TOYOTA SERVICE BULLETIN

Group: 01 No.: 02 Date: Mar, 18

Model: Kluger

Subject: Corrections to Repair Manual RM06K6E

Please ensure these pages are distributed to all relevant staff for their information; and a copy made available for future reference, with the above repair manual.

Section	Title	Paragraph
2GR-FE ENGINE MECHANICAL	CYLINDER HEAD	COMPONENTS
		REASSEMBLY

The revised pages listed above are attached.

(The corrected parts are indicated by arrows.)

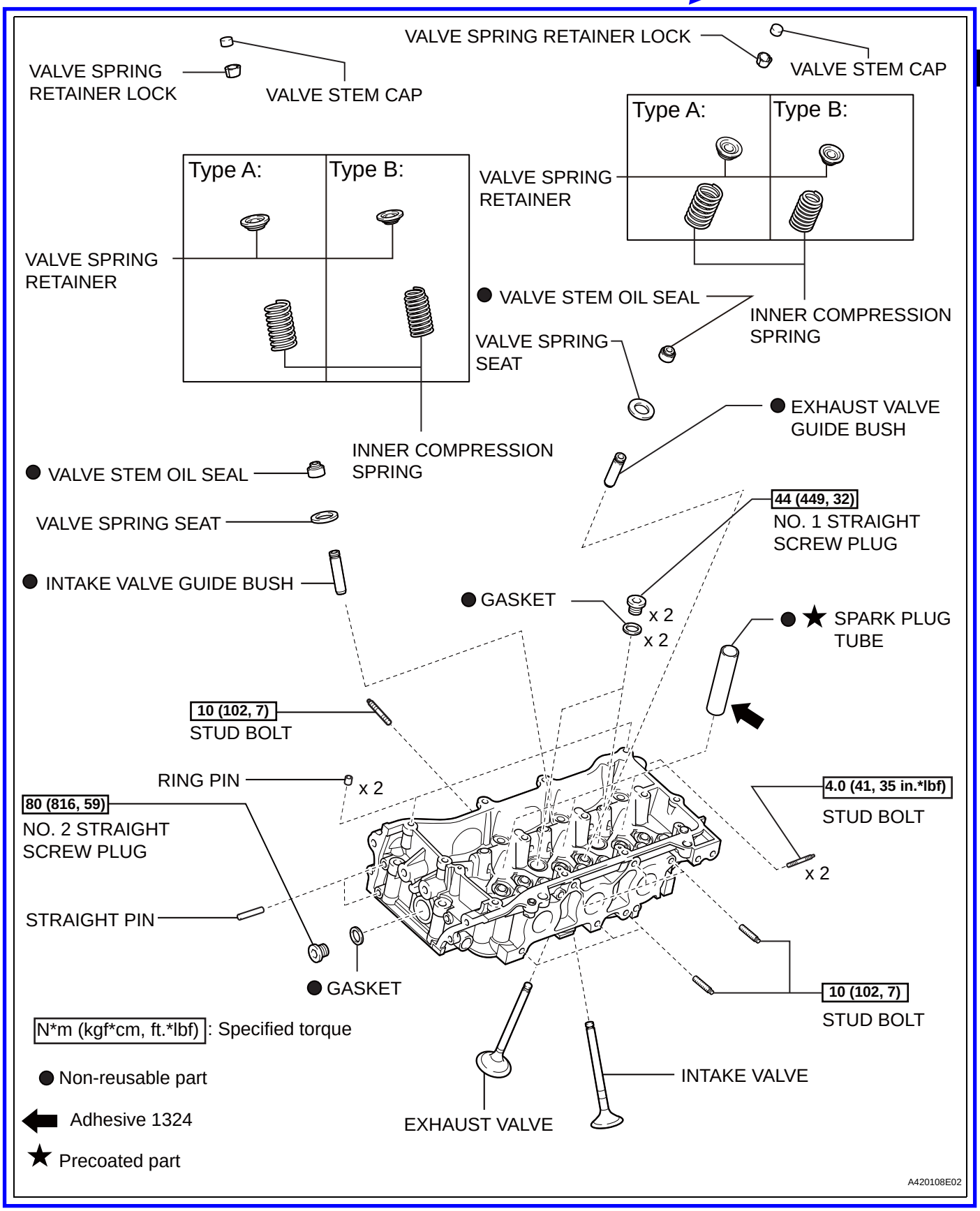
This bulletin does not cause the Flat Rate Manual to be changed

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CYLINDER HEAD

COMPONENTS

[Corrected]



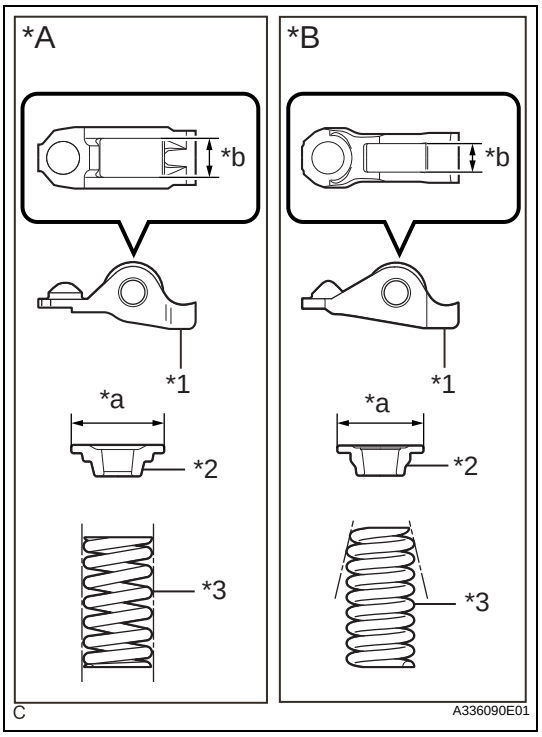
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Text in Illustration

*A	Type A	*B	Type B
*C	Cylinder Head RH	*D	Cylinder Head LH
*a	Identification Mark	-	-

EM

Type	Identification Mark	Inner Compression Spring Shape
A	1 Hole	Straight
B	2 Holes	Taper



- There are 2 types of No. 1 valve rocker arm sub-assemblies, inner compression springs and valve spring retainers. The 2 types are not interchangeable.

Text in Illustration

*A	Type A
*B	Type B
*1	No. 1 Valve Rocker Arm Sub-assembly
*2	Valve Spring Retainer
*3	Inner Compression Spring
*a	Valve Spring Retainer Diameter
*b	No. 1 Valve Rocker Arm Sub-assembly Roller Width

Type	No. 1 Valve Rocker Arm Sub-assembly Roller Width	Valve Spring Retainer Diameter	Inner Compression Spring Shape
A	10.7 mm (0.421 in.)	23.4 mm (0.921 in.)	Straight
B	8.0 mm (0.315 in.)	18.9 mm (0.744 in.)	Taper

1. INSTALL SPARK PLUG TUBE

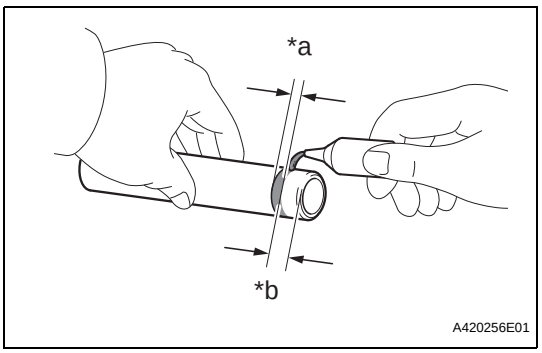
HINT:

When using a new cylinder head LH, the spark plug tubes must be replaced.

(a) Apply adhesive to a new spark plug tube as shown in the illustration.

Text in Illustration

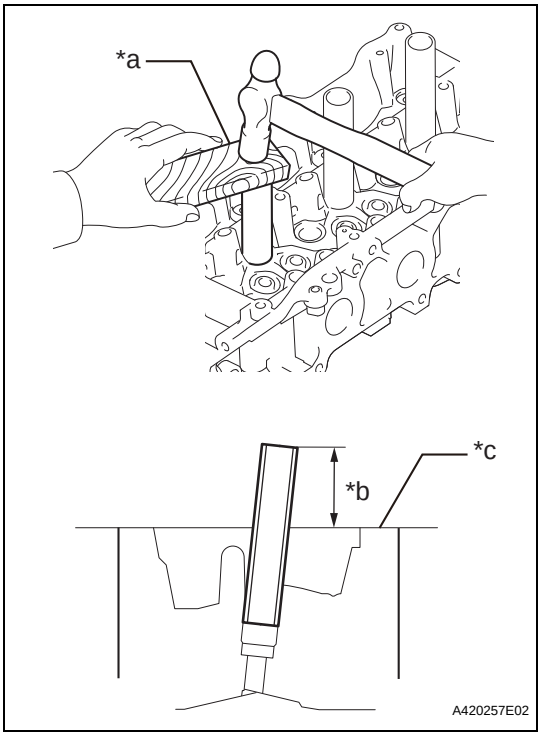
*a	Application Width
*b	9.0 to 15.0 mm (0.354 to 0.591 in.)



Adhesive:
Toyota Genuine Adhesive 1324, Three Bond 1324 or equivalent
Standard Application Width:
1.0 to 3.0 mm (0.0394 to 0.118 in.)
NOTICE:
Install the spark plug tube within 3 minutes of applying adhesive.

[Added]

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(b) Using a hammer and wooden block, install the 3 spark plug tubes to the specified protrusion height.

Text in Illustration

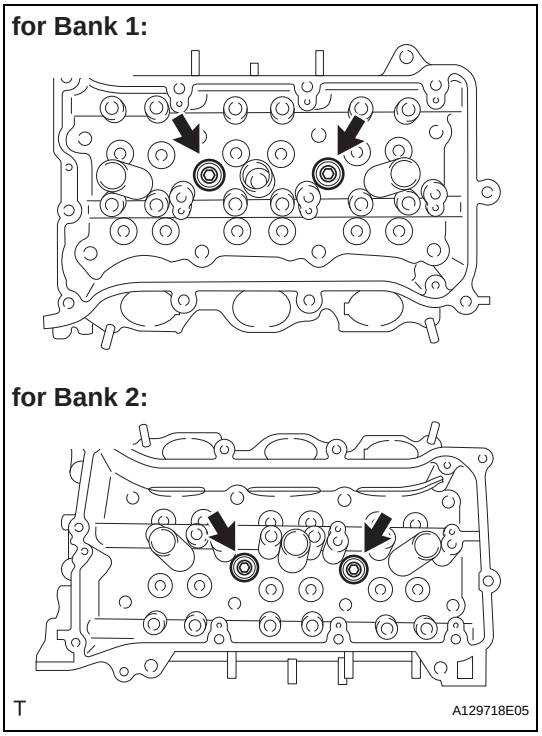
*a	Wooden Block
*b	Protrusion Height
*c	Cylinder Head LH Top Surface

Standard Protrusion Height:
72.9 mm (2.87 in.)

NOTICE:

- **Do not tap in the spark plug tube more than specified.**
- **Do not start the engine for at least 1 hour after installation.**
- **Be careful not to deform the spark plug tubes.**
- **Be careful not to let adhesive drip into the cylinder head LH.**

EM



2. INSTALL NO. 1 STRAIGHT SCREW PLUG

(a) Using a 10 mm hexagon wrench, install 4 new gaskets and the 4 No. 1 straight screw plugs.
Torque: 44 N*m (449 kgf*cm, 32 ft.*lbf)

[Added]

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