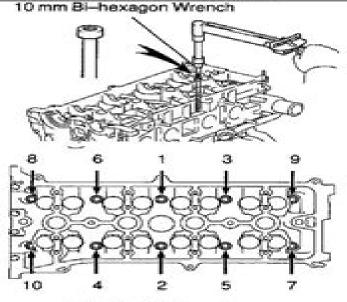


Install and uniformly tighten the 20 bearing cap bolts in several passes, in the sequence shown. Torque:

29.5 Nm (300 kgf cm, 22 ft. lbs.) for No. 1 and No. 2

9 Nm (90 kef-cm, 80 inch lbr.) for others



Cylinder Head Belt Torque Sequence

Orlinder Head

Step 2

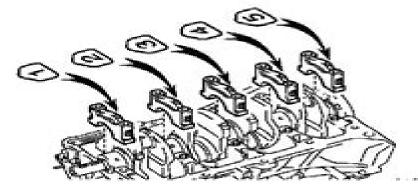
Maximum Warpage 0.08 mm (0.0031 in.)

Cylinder Head Torque
Step 1 79 Nm (58 ft.lb.)

If any cylinder head bolt is broken or deformed, replace it. Apply a light coat of engine oil on the threads and under the heads of the cylinder head bolts.

90 degrees

If any one of the cylinder head bolts does not meet the torque specification, replace the cylinder head bolt.



Main Bearing Cap Bolt Torque Sequence

- Apply a light coat of engine oil on the threads and under the main bearing cap bolts.
- Install and uniformly tighten the 10 main bearing cap bolts in several passes, in the sequence shown.
 Torque: 20 Nm (205 kgf-cm, 15 ft. lbs.)
- 3 Retigiten the 10 main bearing cap bolts in several passes, in the sequence shown. Torque: 40 Nm. (410 kgf-cm., 30 ft. lbs.) If any one of the main bearing cap bolts does not meet the torque specification, replace the main bearing cap bolt.
- 4 Mark the frost of the main bearing cap bolt with paint.
- Retighten the main bearing cap bolts by 90° in the numerical order shown.
- 6 Check that the pointed mark is now at a 90° angle to the front.
- c. Check that the crank shaft turns smoothly.

How To Torque 92 Camry Cylinder Head

R Sandford

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