

Enginetech Inc
For Technical Assistance Call:
1-800-410-3664 ext 340 or ext 237

TECHNICAL BULLETIN		Mfg: TOYOTA
	February 2004 TB 2141	Model: COROLLA
		Liter: 1.8L
		V I N: 1ZZFE
		Year: 98-08

Main Bearing Bolt Torque Specifications For
1998-2003 Toyota 1.8L 1ZZFE & 2ZZGE Engines

The AERA Technical Committee offers the following information regarding main bearing bolt torque specifications for 1998-2003 Toyota 1.8L 1ZZFE & 2ZZGE engines. There has been some confusion as to the correct torque value for this engine. Apparently, depending on the source of information different values have been published. Some previously published information showed plus 90° and plus 90° when the correct information should of listed plus 45° and plus 45°.

The bolts used to secure the main bearing caps may be re-used if thread damage or bolt stretch does not exist. Refer to the illustrations and steps listed below to install the main bearing bolts.

INSTALL 12 POINTED HEAD BEARING CAP SUB-ASSEMBLY BOLTS

1. Apply a light coat of engine oil on the threads and under the bearing cap subassembly bolts.
2. Install and uniformly tighten the 10 bearing cap sub-assembly bolts, in several passes, in the sequence shown below in Figure 1. Torque to 16 ft/lbs (22 Nm).
3. Retighten the bearing cap sub-assembly bolts, in several passes, in the sequence shown. Torque the bolt to 32 ft/lbs (44 Nm). If any of the bearing cap sub-assembly bolts does not meet the torque specification, replace the bearing cap subassembly bolt.
4. Mark the front of the bearing cap and sub-assembly bolts with white paint.
5. Retighten the bearing cap sub-assembly bolts by rotating the bolts in sequence 45° and 45° in the manner shown in Figure 2.
6. Check that the painted mark is now at a 90° angle to the front.

INSTALL HEXAGON HEAD BEARING CAP SUB-ASSEMBLY BOLTS

1. Install and uniformly tighten the 10 bearing cap sub-assembly bolts in several

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passes and torque 14 ft/lbs. (18.5 Nm).

2. Check that the crankshaft rotates smoothly with little effort.

3. 2ZZGE engine: Apply adhesive to 2 or 3 threads, and install the 4 screw plugs.

Adhesive: Part No. 08833-00070, THREE BOND 1324, or equivalent and torque plugs to 32 ft/lbs (43 Nm).

The AERA Technical Committee

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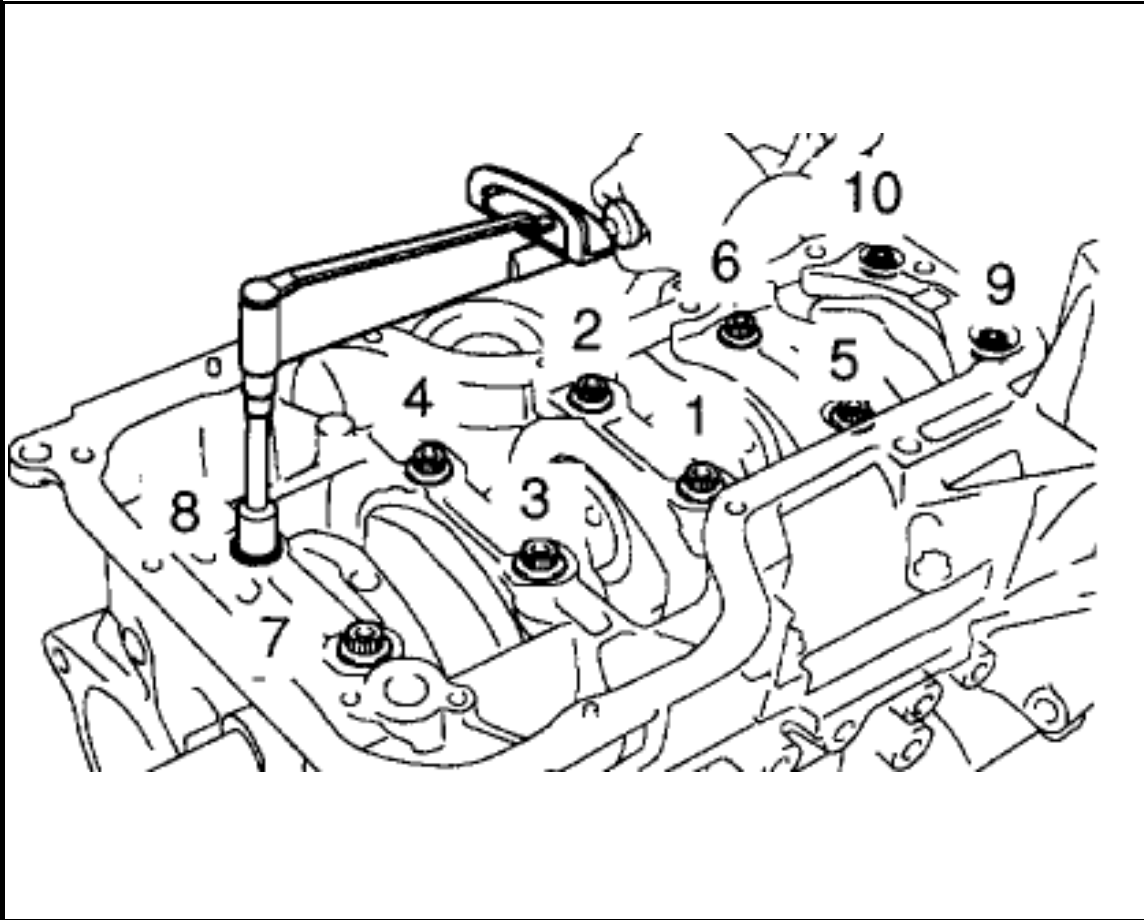
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Bulletin Diagram: FIGURE 1, MAIN BEARING BOLT TORQUE SEQUENCE - CYLINDER BLOCK



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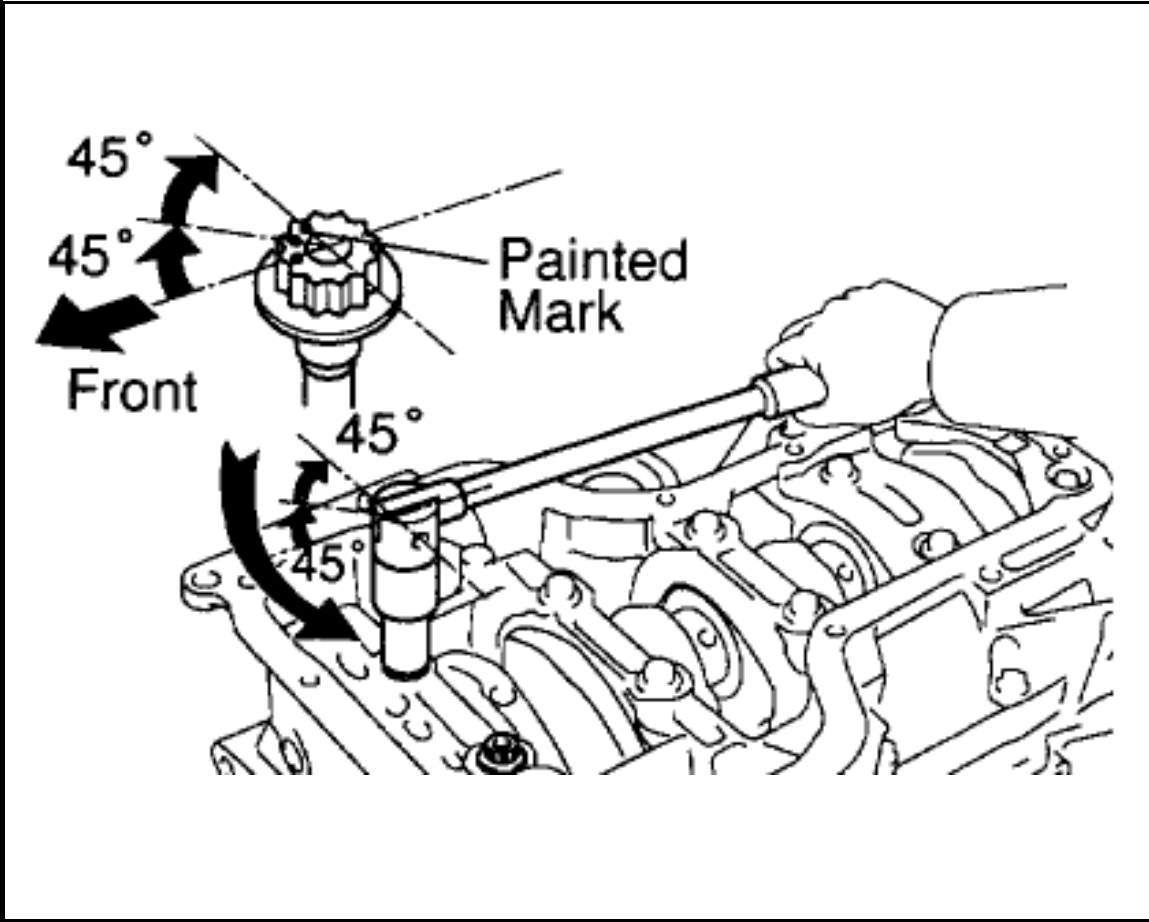
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Bulletin Diagram: FIGURE 2, 45° + 45° BOLT MOVEMENT - CYLINDER BLOCK



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