



- 4 Install a new O-ring (1).  
Install the side plate. Take care to ensure that the sealant is not scraped off during installation. Torque the bolts (2) to **25 Nm (18 lbf ft)**.

**IMPORTANT!**

Torque the bolts immediately after the components are joined.



- 5 Install the idler gear (1), position the washer (2) and tighten the bolt (3) to **25 Nm (18 lbf ft)**.



- 6 Lift the crankshaft into place.  
Install the main bearing caps. Make sure the bearing shell locking tabs (1) and (2) are aligned as illustrated.  
The main bearing caps are numbered 1–5 (D4) or 1–7 (D6). Number "1" must be installed furthest forwards (close to the circulation pump).

# Toyota D4 Workshop Manual

**Christian G. Meyer**

A red circular graphic with a gradient, appearing as a semi-circle or a partial circle, located to the right of the author's name.

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