

TOYOTA

SERVICE BULLETIN

TOYOTA MOTOR SALES, U.S.A., INC.

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PLASTIC REGION CONNECTING ROD BOLT TIGHTENING PROCEDURE

When tightening connecting rods on 2VZ-FE, 3VZ-E, or 5S-FE engines special attention needs to be paid to final tightening (final 90° rotation) of the nut.

The bolt has a tendency to rotate slightly inside the rod when performing the final tightening. If not compensated for, this results in a lower final torque than specified. To achieve the correct torque use the following procedure. This procedure will ensure that a full 90° of nut rotation relative to the bolt is achieved during the final tightening:

- 1) Perform the initial torque as specified in the appropriate repair manual.
- 2) Place two marks ('B' and 'C' in figure 1 below) on the end of the connecting rod bolt 90° apart. Place a third mark ('A' in figure 1 below) on the nut in line with mark "B" on the rod bolt.
- 3) Tighten the nut until mark "A" (on the nut) lines up with mark "C" (on the bolt).

