



- 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

**IM Harris**



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## **Table of Contents Toyota D4 Workshop Manual**

1. Understanding the eBook Toyota D4 Workshop Manual
  - The Rise of Digital Reading Toyota D4 Workshop Manual
  - Advantages of eBooks Over Traditional Books
2. Identifying Toyota D4 Workshop Manual
  - Exploring Different Genres
  - Considering Fiction vs. Non-Fiction
  - Determining Your Reading Goals
3. Choosing the Right eBook Platform
  - Popular eBook Platforms
  - Features to Look for in an Toyota D4 Workshop Manual
  - User-Friendly Interface
4. Exploring eBook Recommendations from Toyota D4 Workshop Manual
  - Personalized Recommendations
  - Toyota D4 Workshop Manual User Reviews and Ratings
  - Toyota D4 Workshop Manual and Bestseller Lists
5. Accessing Toyota D4 Workshop Manual Free and Paid eBooks
  - Toyota D4 Workshop Manual Public Domain eBooks
  - Toyota D4 Workshop Manual eBook Subscription Services
  - Toyota D4 Workshop Manual Budget-Friendly Options

6. Navigating Toyota D4 Workshop Manual eBook Formats
  - ePub, PDF, MOBI, and More
  - Toyota D4 Workshop Manual Compatibility with Devices
  - Toyota D4 Workshop Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
  - Adjustable Fonts and Text Sizes of Toyota D4 Workshop Manual
  - Highlighting and Note-Taking Toyota D4 Workshop Manual
  - Interactive Elements Toyota D4 Workshop Manual
8. Staying Engaged with Toyota D4 Workshop Manual
  - Joining Online Reading Communities
  - Participating in Virtual Book Clubs
  - Following Authors and Publishers Toyota D4 Workshop Manual
9. Balancing eBooks and Physical Books Toyota D4 Workshop Manual
  - Benefits of a Digital Library
  - Creating a Diverse Reading Collection Toyota D4 Workshop Manual
10. Overcoming Reading Challenges
  - Dealing with Digital Eye Strain
  - Minimizing Distractions
  - Managing Screen Time
11. Cultivating a Reading Routine Toyota D4 Workshop Manual
  - Setting Reading Goals Toyota D4 Workshop Manual
  - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Toyota D4 Workshop Manual
  - Fact-Checking eBook Content of Toyota D4 Workshop Manual
  - Distinguishing Credible Sources
13. Promoting Lifelong Learning
  - Utilizing eBooks for Skill Development
  - Exploring Educational eBooks
14. Embracing eBook Trends
  - Integration of Multimedia Elements

- Interactive and Gamified eBooks

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