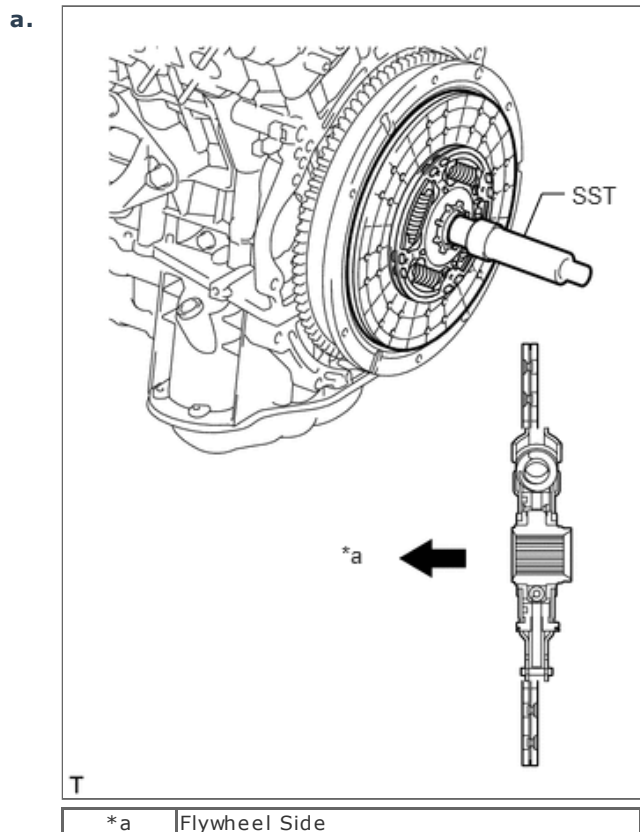


CLUTCH CLUTCH UNIT(for 1GR-FE) INSTALLATION

PROCEDURE

1.INSTALL CLUTCH DISC ASSEMBLY

31250



Insert SST into the clutch disc assembly, then insert the clutch disc assembly into the flywheel sub-assembly.

SST

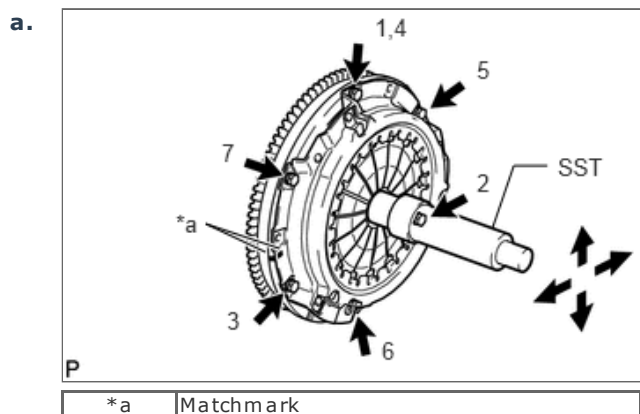
09301-00110

NOTICE:

Take care not to insert the clutch disc assembly in the wrong direction.

2.INSTALL CLUTCH COVER ASSEMBLY

31210



Align the matchmarks on the clutch cover assembly with the one on the flywheel sub-assembly.

- b. Following the order shown in the illustration, tighten the 6 bolts, starting with the bolt located near the knock pin at the top.

SST
09301-00110

Torque:
19.1 N*m (195 kgf*cm, 14 ft.*lbf)

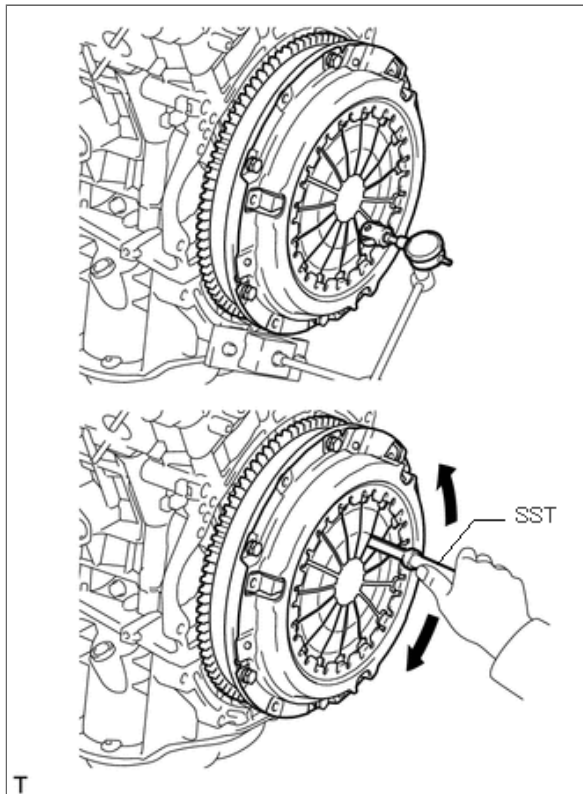
HINT:

- Following the order in the illustration, tighten the bolts evenly one at a time.
- Move SST up and down, right and left lightly after checking that the clutch disc assembly is in the center, and tighten the bolts.

3.INSPECT AND ADJUST CLUTCH COVER ASSEMBLY

31210

a.



Using a dial indicator with a roller instrument, check the diaphragm spring tip alignment.

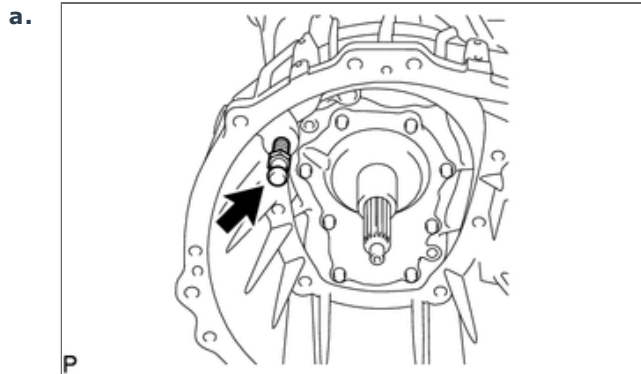
SST
09333-00013

Maximum non-alignment:
0.5 mm (0.0197 in.)

If the alignment is more than the maximum, using SST, adjust the diaphragm spring tip alignment.

4.INSTALL RELEASE FORK SUPPORT

31236B



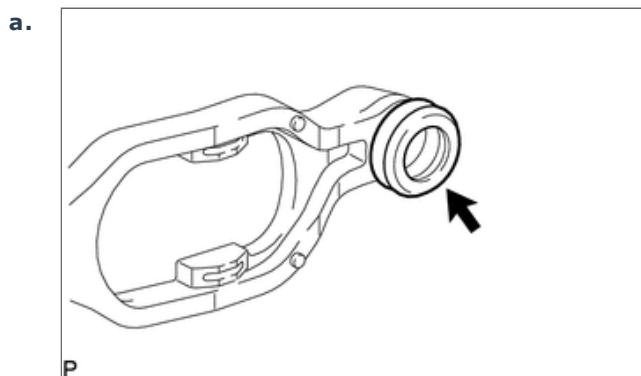
Install the release fork support to the manual transmission assembly.

Torque:

47.1 N*m (480 kgf*cm, 35 ft.*lbf)

5.INSTALL CLUTCH RELEASE FORK SUPPORT BOOT

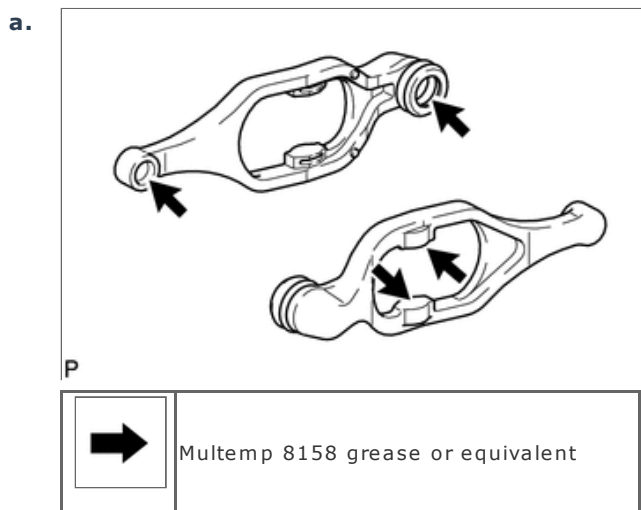
31237



Install the clutch release fork support boot to the clutch release fork sub-assembly.

6.INSTALL CLUTCH RELEASE FORK SUB-ASSEMBLY

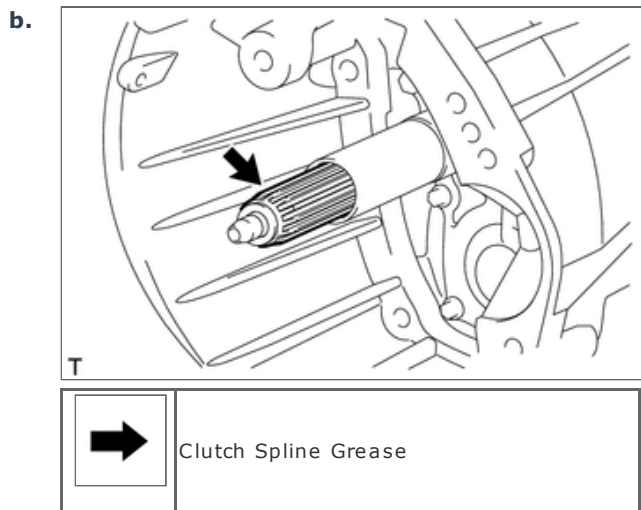
31204



Apply release hub grease to the clutch release fork sub-assembly, clutch release bearing assembly, push rod contact point and pivot points shown in the illustration.

Grease:

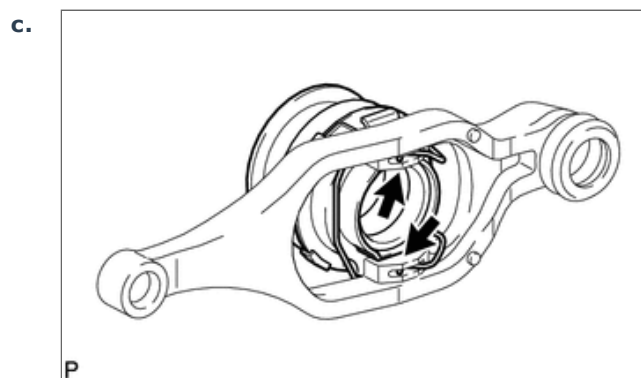
Multemp 8158 grease or equivalent



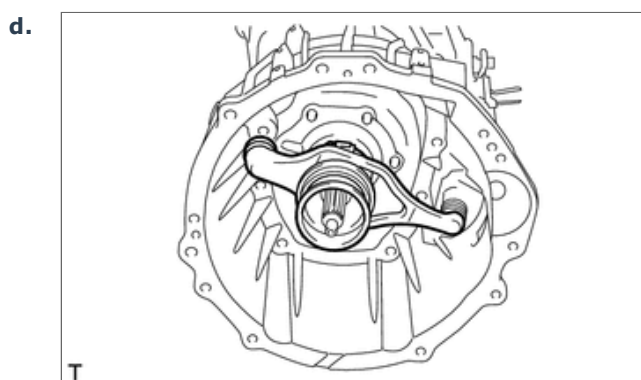
Apply clutch spline grease to the input shaft spline.

Grease:

Toyota Genuine Clutch Spline Grease or equivalent



Install the clutch release bearing assembly to the clutch release fork sub-assembly with the release bearing hub clip.



Install the clutch release fork sub-assembly with the clutch release bearing assembly to the manual transmission assembly.

NOTICE:

After installation, move the fork back and forth to check that the release bearing slides smoothly.

7.INSTALL MANUAL TRANSMISSION ASSEMBLY

[Click here](#)Drivetrain>H150F MANUAL TRANSMISSION / TRANSAXLE>MANUAL TRANSMISSION ASSEMBLY(for 1GR-FE)>INSTALLATION