

INSTALLATION

1. ADJUST COMPRESSOR OIL

- (a) When replacing the compressor and magnetic clutch with new ones, after gradually discharging the refrigerant gas from the service valve, drain the following volume of oil from new compressor and magnetic clutch before installation.

Standard:

(Oil capacity inside a new compressor and magnetic clutch: 150 + 15 cc (5.1 + 0.51 fl.oz.)) - (Remaining oil amount in the removed compressor and magnetic clutch) = (Oil amount to be removed when replacing the compressor)

NOTICE:

- When checking the compressor oil level, observe the precautions on the cooler removal/installation.
- If a new compressor and magnetic clutch are installed without removing some oil remaining in the pipes of the vehicle, the oil amount becomes too large. This prevents heat exchange in the refrigerant cycle and causes refrigerant failure.
- If the volume of oil remaining in the removed compressor and magnetic clutch is too small, check for oil leakage.
- Be sure to use RL-897 for compressor oil.

2. INSTALL COMPRESSOR AND MAGNETIC CLUTCH (for 2TR-FE)

- (a) Provisionally tighten the compressor and magnetic clutch with the 4 bolts and harness bracket.

NOTICE:

The harness bracket stopper should be in contact with compressor case.

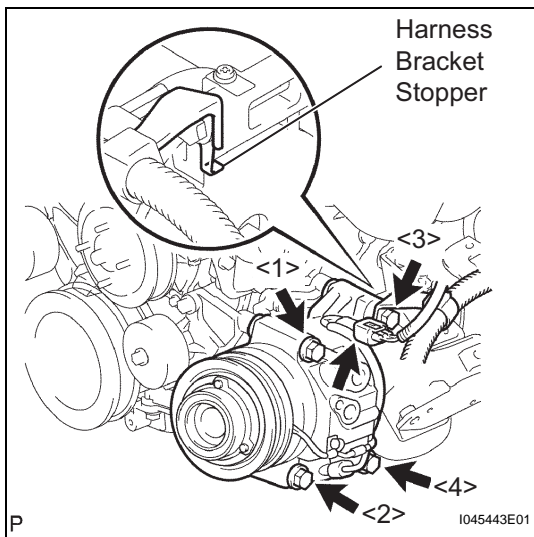
- (b) Tighten the compressor and magnetic clutch with the 4 bolts.

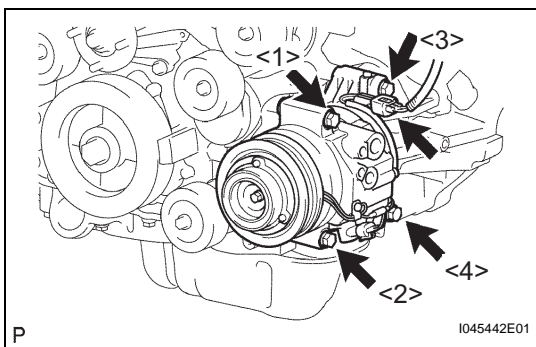
Torque: 21 N*m (214 kgf*cm, 16 ft.*lbf)

NOTICE:

Tighten the bolts in the sequence order shown in the illustration to install the compressor and magnetic clutch.

- (c) Connect the connector.





3. INSTALL COMPRESSOR AND MAGNETIC CLUTCH (for 1GR-FE)

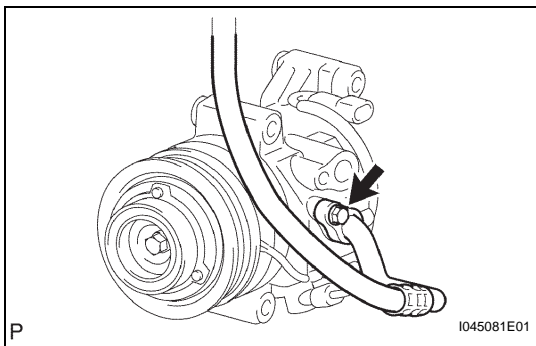
- (a) Provisionally tighten the compressor and magnetic clutch with the 4 bolts.
- (b) Tighten the compressor and magnetic clutch with the 4 bolts.

Torque: 21 N*m (214 kgf*cm, 16 ft.*lbf)

NOTICE:

Tighten the bolts in the sequence order shown in the illustration to install the compressor and magnetic clutch.

- (c) Connect the connector.



4. INSTALL DISCHARGE HOSE SUB-ASSEMBLY

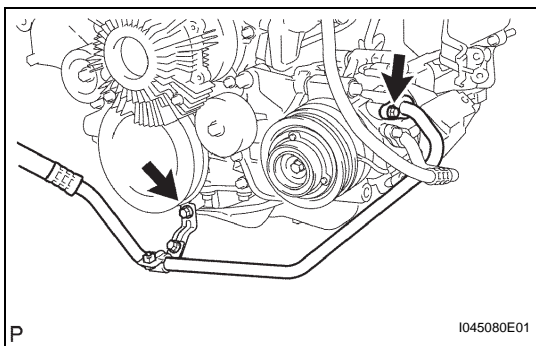
- (a) Remove the attached vinyl tape from the hose.
- (b) Apply sufficient compressor oil to a new seal washer and fitting surface of the compressor and magnetic clutch.

Compressor oil:

RL-897 or equivalent

- (c) Install the seal washer onto the cooler refrigerant discharge hose sub-assembly.
- (d) Install the cooler refrigerant discharge hose sub-assembly onto the compressor and magnetic clutch with the bolt.

Torque: 19 N*m (194 kgf*cm, 14 ft.*lbf)



5. INSTALL SUCTION HOSE SUB-ASSEMBLY (for 2TR-FE)

- (a) Remove the attached vinyl tape from the hose.
- (b) Apply sufficient compressor oil to a new seal washer and fitting surface of the compressor and magnetic clutch.

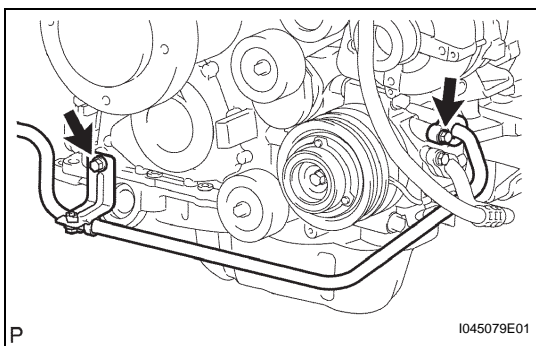
Compressor oil:

RL-897 or equivalent

- (c) Install the seal washer onto the suction hose sub-assembly.
- (d) Install the suction hose sub-assembly onto the compressor and magnetic clutch with the bolt.

Torque: 19 N*m (194 kgf*cm, 14 ft.*lbf)

- (e) Install the suction hose sub-assembly with the bolt.
- Torque: 7.5 N*m (76 kgf*cm, 66 in.*lbf)**



6. INSTALL SUCTION HOSE SUB-ASSEMBLY (for 1GR-FE)

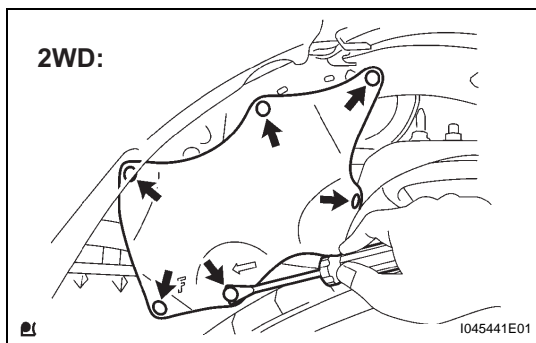
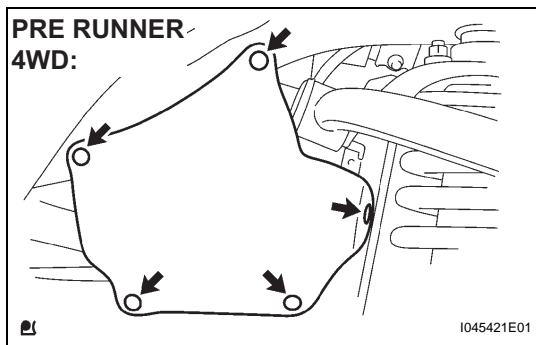
- (a) Remove the attached vinyl tape from the hose.
- (b) Apply sufficient compressor oil to a new seal washer and fitting surface of the compressor and magnetic clutch.

Compressor oil:

RL-897 or equivalent

- (c) Install the seal washer onto the suction hose sub-assembly.
- (d) Install the suction hose sub-assembly onto the compressor and magnetic clutch with the bolt.

Torque: 19 N*m (194 kgf*cm, 14 ft.*lbf)



- (e) Install the suction hose sub-assembly with the bolt.
Torque: 7.5 N*m (76 kgf*cm, 66 in.*lbf)

7. INSTALL FRONT FENDER APRON SEAL UPPER

- (a) Install the front fender apron seal upper with the 5 clips. (4WD, PRE RUNNER)

- (b) Install the front fender apron seal upper with the 6 clips. (2WD)

8. INSTALL GENERATOR ASSEMBLY (for 1GR-FE) (See page [CH-13](#))

9. INSTALL FAN AND GENERATOR V BELT (for 2TR-FE) (See page [EM-6](#))

10. INSPECT FAN AND GENERATOR V BELT (for 2TR-FE) (See page [EM-5](#))

11. INSTALL FAN AND GENERATOR V BELT (for 1GR-FE) (See page [EM-5](#))

12. INSTALL FAN SHROUD (for 1GR-FE) (See page [CO-20](#))

13. INSTALL RADIATOR SUPPORT TO FRAME SEAL LH (for 1GR-FE)

14. INSTALL V-BANK COVER (for 1GR-FE) (See page [EM-166](#))

15. INSTALL NO. 1 ENGINE UNDER COVER SUB-ASSEMBLY (for 2TR-FE) (See page [EM-35](#))

16. INSTALL NO. 1 ENGINE UNDER COVER SUB-ASSEMBLY (for 1GR-FE) (See page [EM-166](#))

17. INSTALL FRONT WHEEL LH

Torque: 113 N*m (1152 kgf*cm, 83 ft.*lbf)

18. CONNECT CABLE TO NEGATIVE BATTERY TERMINAL

Torque: 3.9 N*m (40 kgf*cm, 35 in.*lbf)

19. CHARGE REFRIGERANT (See page [AC-18](#))

20. WARM UP ENGINE (See page [AC-19](#))

21. CHECK FOR REFRIGERANT LEAKAGE (See page [AC-19](#))