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TECHNICAL REPORT

Suggestions for the assembly
of the rear main seal in Toyota
engines 1KD-FTV



INTRODUCTION

1KD-FTV Toyota engines **use a rear main seal** assembled on a seal frame, which be be later fixed on the front side of the block with screws. **AJUSA offers seal reference number 15054500** ready for replacement.

ASSEMBLY SUGGESTIONS

There two methods to assembly this seal:

1 Seal assembly without removing the metal housing of the cylinder block:

- 1 Remove seal and clean housing**, avoiding hitting or scratching the machined surfaces you are going to seal.
- 2 Lube the seal lip** with grease or oil. This is good for all seals except for PTFE seals.
- 3 With the help of a tooling as in the picture, tighten the seal until its surface is totally level with the edge of the metal housing.**

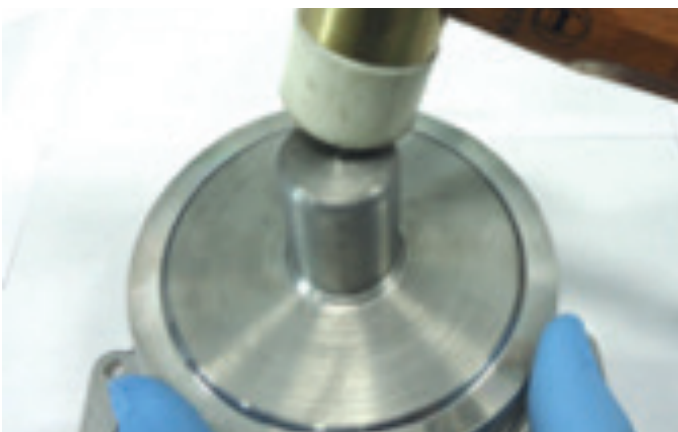
Watch out that the seal lip is in correct position with no damage and with the spring; it is important to **remind that in this process there is no sight of the inside part of the seal.**



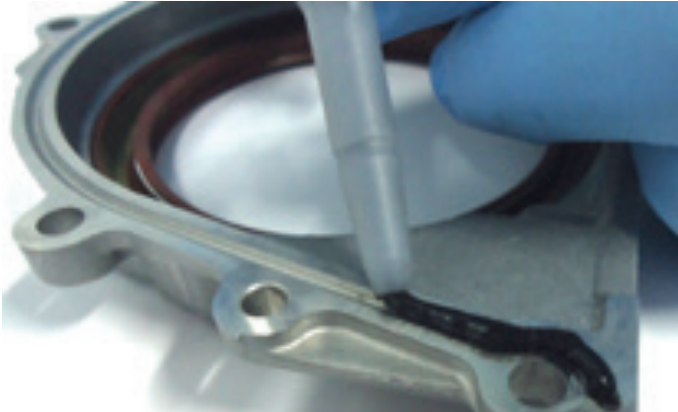
2 Seal assembly removing the metal housing of the cylinder block:

1 Remove the seal clean housing avoiding hitting or scratching the machined surfaces you are going to seal.

2 Assemble seal in its metal housing, **using the former tooling to get the seal surface** totally level with the edge of the metal housing.



- 3** Apply gasket maker (Ajusil) with a uniform 2 mm cord along all the housing groove.



- 4** Lube the seal lip with grease or oil.
- 5** Before the gasket maker (Ajusil) begins to reticulate, **we must assemble the housing with the seal in the cylinder block** (do not hit the kit) taking care of the seal lip and spring.
- 6** Apply 8 Nm to all bolts in cross order.