

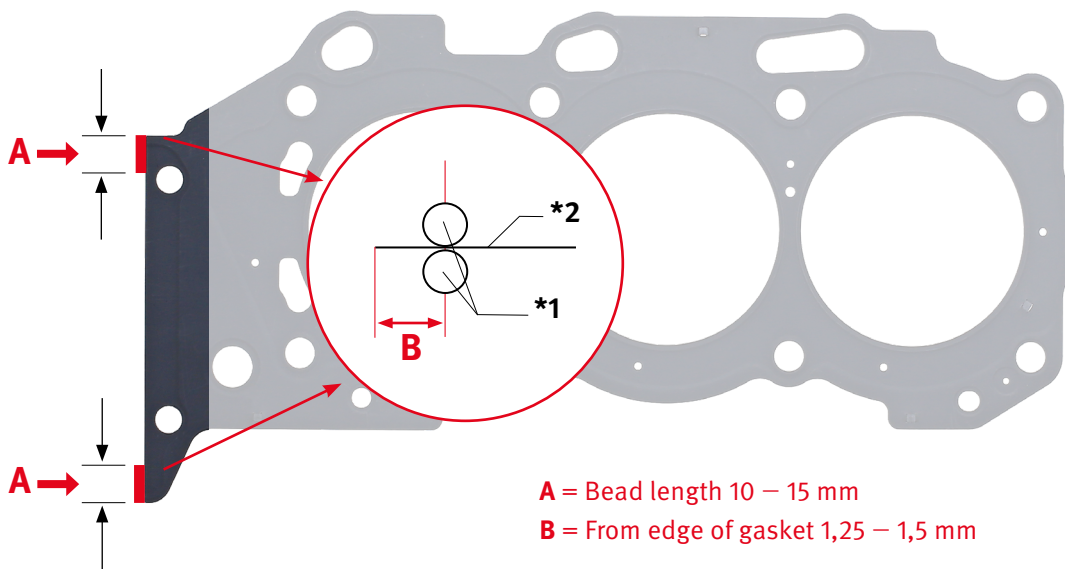
# Installation instruction for the cylinder-head gasket

4.0L Toyota 1GR-FE-Engines from 2003 to 2023

**430.780 | 430.790 | 633.950 | 633.960**

When installing the cylinder head gaskets for the 4 liter V6 engine 1GR-FE from Toyota, make sure to apply sealing compound in certain areas of the gasket to prevent leaks on the front side of the cover gasket due to possible uneven flange surfaces.

Apply **Elring - Das Original Dirko™ sealant** to the areas marked in red on both sides of the gasket.



**A** = Bead length 10 – 15 mm  
**B** = From edge of gasket 1,25 – 1,5 mm

\*1 = Bead diameter 2,5 – 3 mm  
\*2 = Cylinder-head gasket

*Gasket location on right cylinder bank shown. Application on left cylinder bank similar.*

To ensure the sealing effect, install the cylinder-head gasket with the applied sealing compound within 3 minutes and tighten the new cylinder-head bolts within 15 minutes of applying the sealing compound.

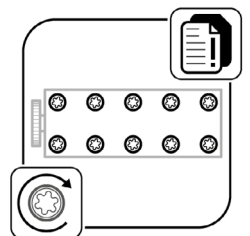
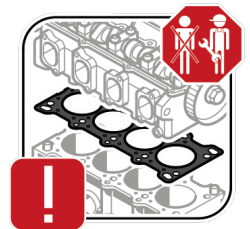
For the installation and tightening sequence, please follow the enclosed tightening instructions in the packaging.



TecDoc



471.501 | 006.553



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**Das Original**