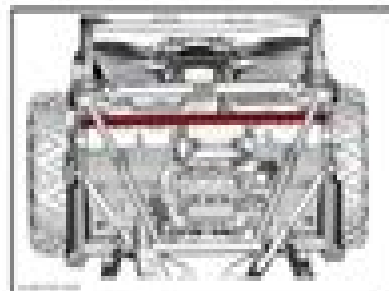


16. Remove seat belt tie bar. Drill rivets to re-move.



Lifting the Engine

1. Install 2 straps as shown.



2. Remove the front engine support bolts.



3. Lift engine with the rear support bolt still in place, to lift the engine and gearbox assembly.



NOTE: Make sure engine does not tilt side-to-side, restrain straps as necessary.

4. Remove rear support bolt and lift engine from vehicle.

INSTALLING THE ENGINE

The installation is the reverse of the removal procedure. However, pay attention to the following:

Prior to install engine, inspect condition of engine mounts.

Fasteners Torque	
Engine mount screw nuts	30 Nm (22 ft-lb) 30 Nm (22 ft-lb)

NOTE: Do not install plastic parts and seals prior to FINAL ASSEMBLY.

Final Assembly Procedure

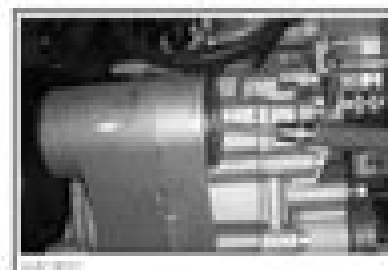
1. Fill engine with the recommended oil and quantity. Refer to **CHANGING THE ENGINE OIL** in the **PERIODIC MAINTENANCE PROCEDURES** subsection.
2. Fill and bleed cooling system. Refer to **REPLACING THE ENGINE COOLANT** in the **PERIODIC MAINTENANCE PROCEDURES** subsection.
3. Check for any leaks.
4. Reinstall all remaining parts.
5. Test drive vehicle to confirm proper operation.

ENGINE MOUNTS

NOTE: Use the same procedure for the front and rear engine mounts.

Removing the Engine Mount

Insert a punch into engine mount bushing and push the opposite engine mount out.



Installing the Engine Mount

The installation is the reverse of the removal procedure.

20corolla Xrs Repair Manual

Ensheng Dong



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