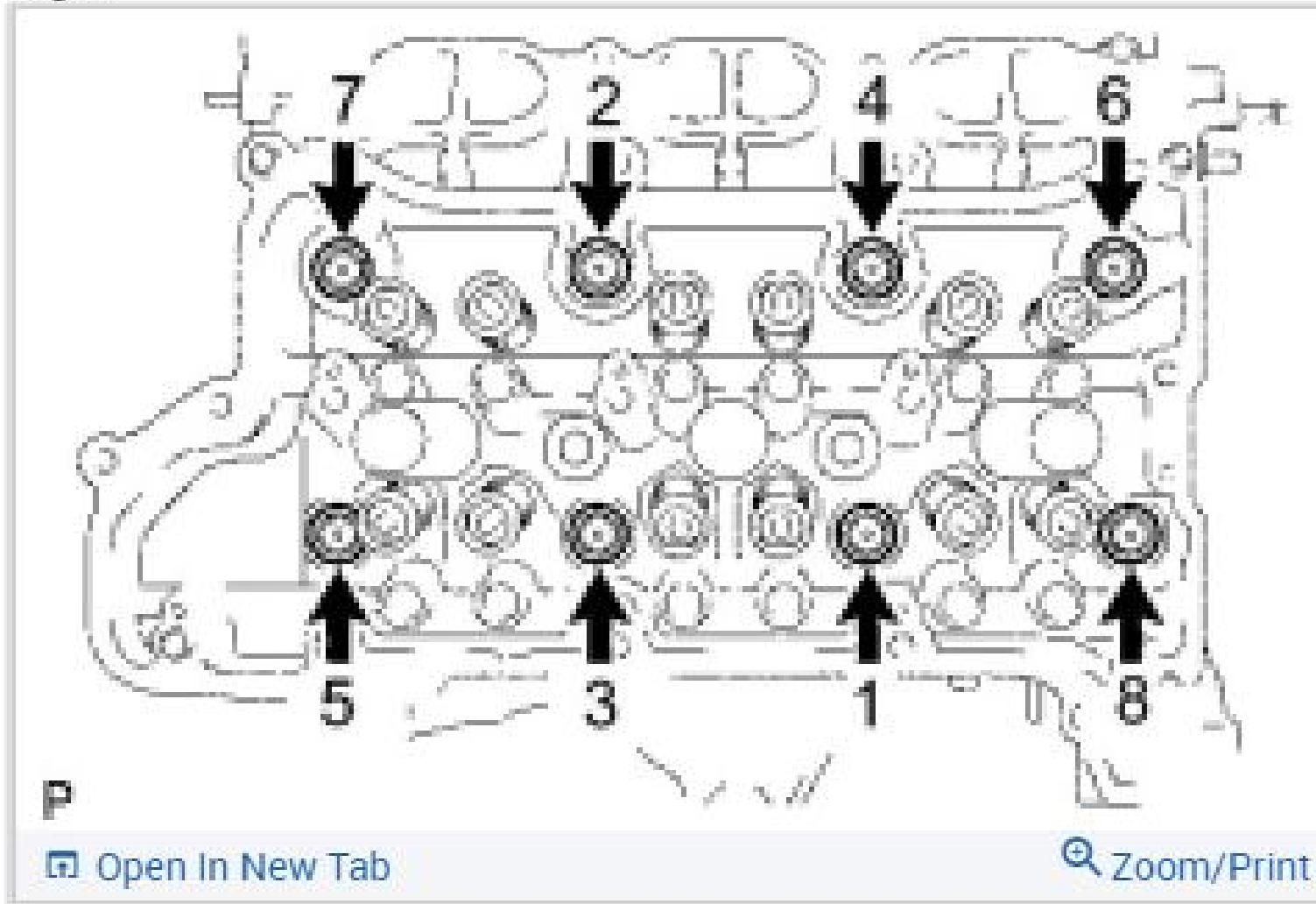


IS250 - V6-2.5L (4GR-FSE)

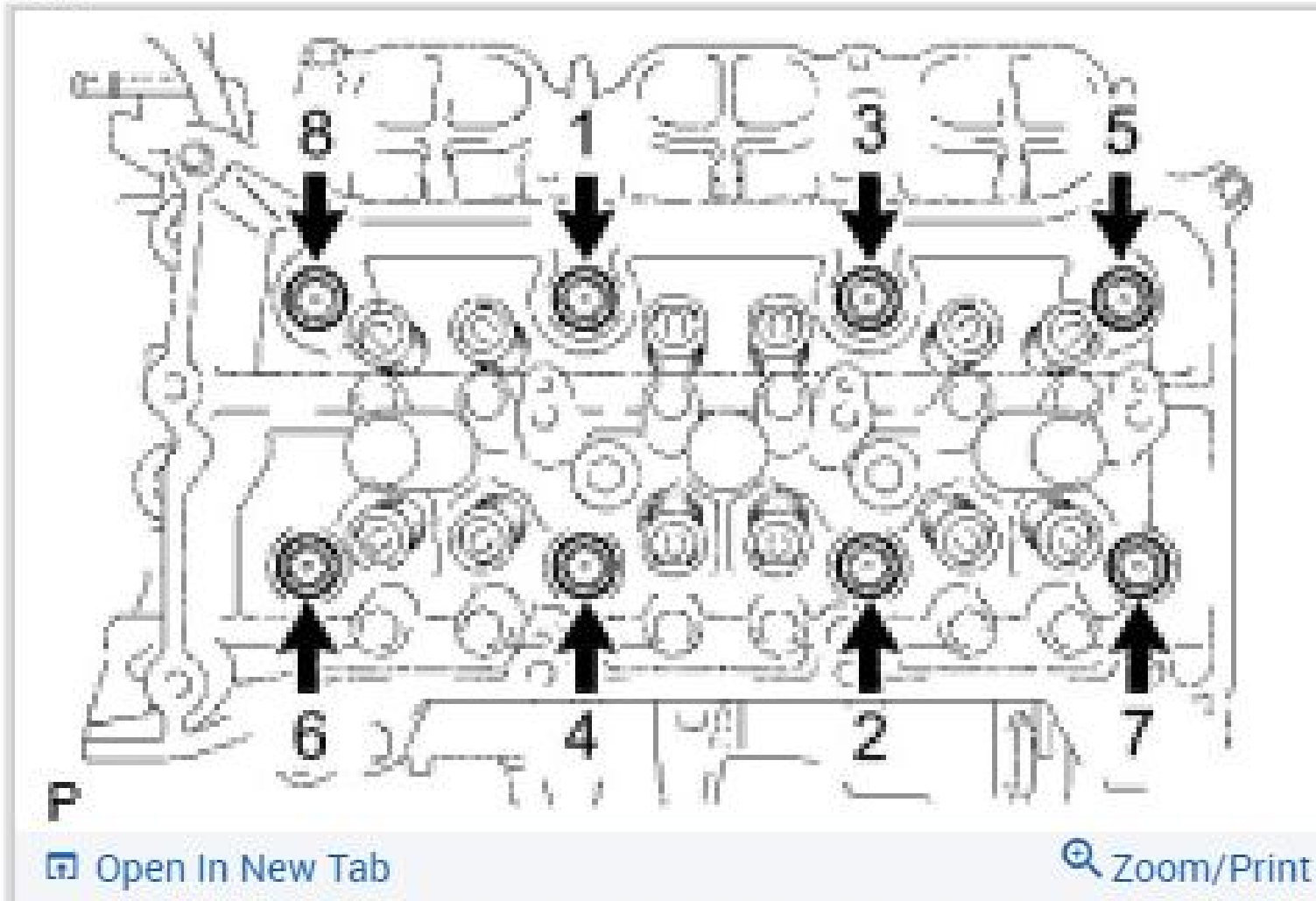
Cylinder Head, RH:

Right



Cylinder Head, LH:

Left



Cylinder head x **Cylinder block** sub-assembly

1st Pass: 36 Nm (367 kgf-cm, 27 ft.lbf)

2nd Pass: Turn 90°

3rd Pass: Turn 90°

Intake Manifold Nuts and Bolts 21 Nm (214 kgf-cm, 15 ft.lbf)

Exhaust manifold sub-assembly x Engine assembly 21 Nm (214 kgf-cm, 15 ft.lbf)

Camshaft bearing cap x Camshaft housing

1st Pass: 10 Nm (102 kgf-cm, 7 ft.lbf)

2nd Pass: 16 Nm (163 kgf-cm, 12 ft.lbf)

Camshaft timing gear assembly x **Camshaft** 100 Nm (1,020 kgf-cm, 74 ft.lbf)