

# Installation Instructions

## Exhaust Block-Off Plates Toyota 4.0L (1GR-FE) Engines

### Tools Needed:

10 mm wrench, ratchet with 10 mm standard and or deep-well socket, large flat head screwdriver or other pry tool, PB Blaster or equivalent

### Installation:

The exhaust block-off plates are **only** to be installed along with the SAS (AIP) Bypass Module. They install at the connection between air tubes from the secondary air system's exhaust valves and the air tubes to each of the exhaust manifolds. The exhaust valves on the 1GR-FE 4.0L V6 engine are either both located on the passenger side of the engine as shown in Figure-1 or with one valve on each side of the engine as shown in Figure-2.

- 1) With the engine cold locate the Secondary Air System Exhaust Valves on your engine as shown in Figure-1 or Figure-2.
- 2) Loosen or remove the bolts holding each of the hard tubes to the exhaust valves. If the bolts will not come loose apply some penetrating fluid (PB Blaster) to the nuts and let soak before trying again.
- 3) Insert the plates between the tube flange and the valve so metal gasket is between the tube and the block off plate. It may be necessary to use a pry tool to open the flange enough to slip the block off plate in.
- 4) Make sure the plate is inserted all of the way so it stops against the bolts.
- 5) If the bolts were removed, reinstall them and tighten the connection back down.
- 6) Crank the engine and check for exhaust leaks. Retighten if needed.

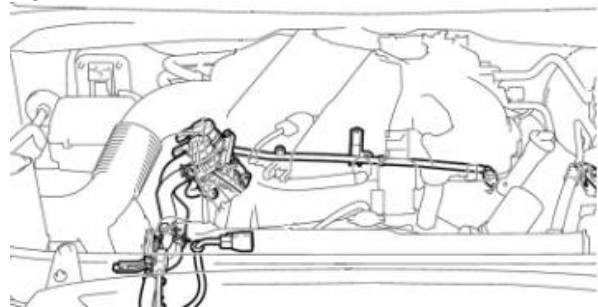


Figure 1 – 4.0L Exhaust Valve Locations 1



Figure 2 – 4.0L Exhaust Valve Locations 2

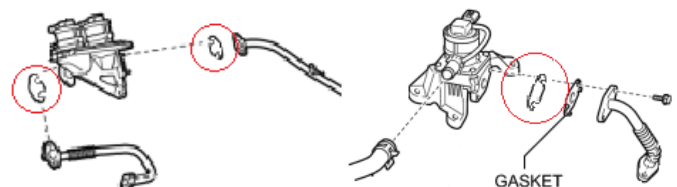


Figure 3 – 4.0L Exhaust Block Off Plate Configurations