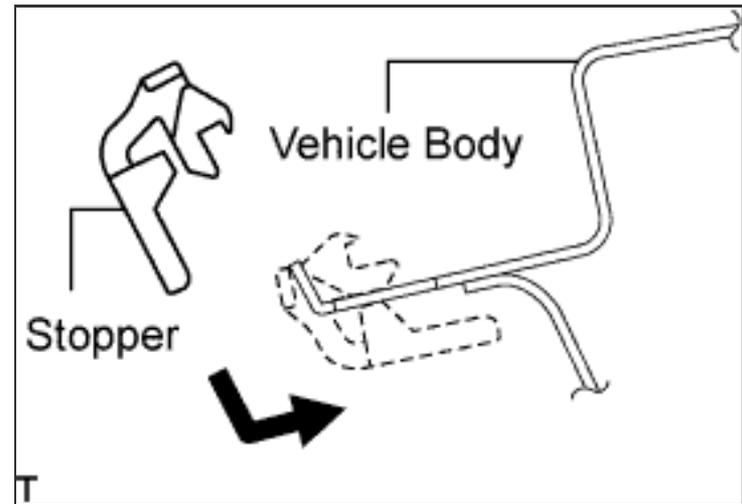


for Preparation [Click here](#)

## 1. INSTALL WINDSHIELD GLASS STOPPER

- a. Install 2 new stoppers to the vehicle body as shown in the illustration.



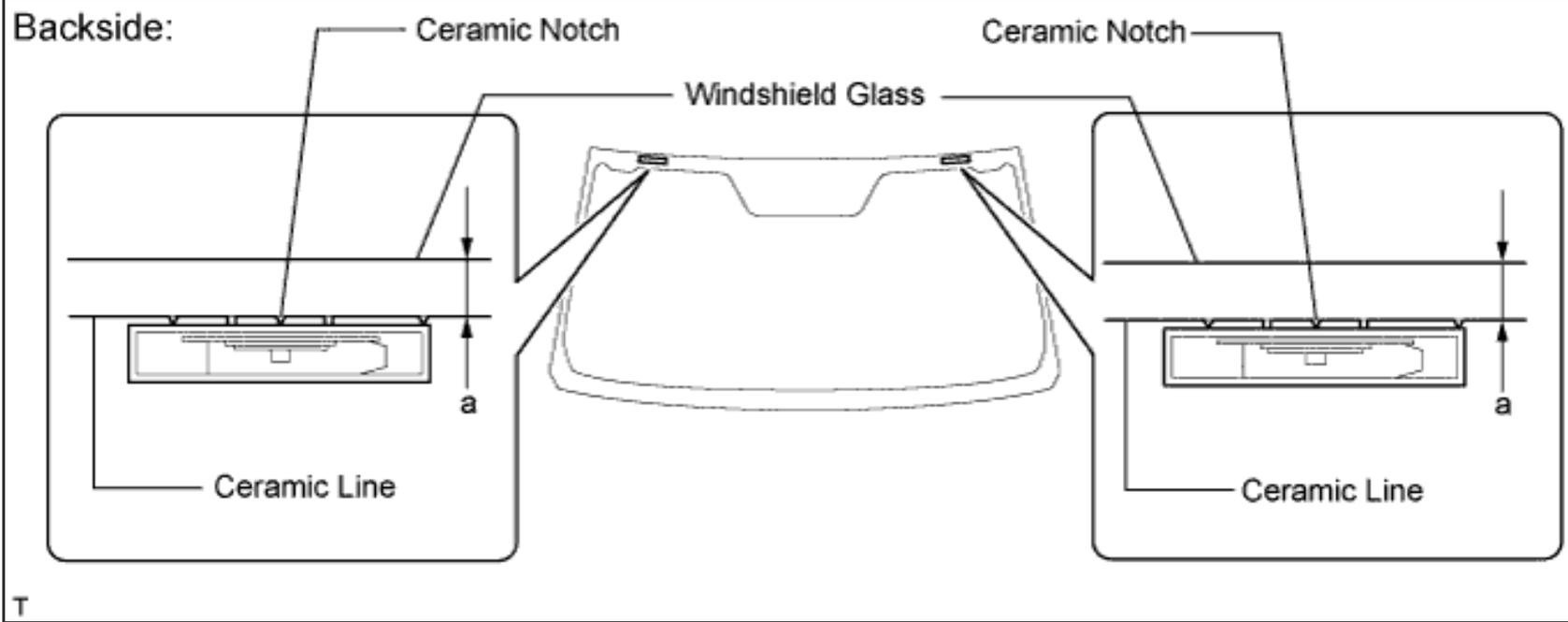
## 2. INSTALL NO. 2 WINDSHIELD GLASS STOPPER

- a. Apply Primer G to the glass where the stopper will be installed.

### NOTICE:

- Allow the primer to dry for 3 minutes or more.
- Throw away any leftover primer.
- Do not apply too much primer.

- b. Install 2 new stoppers onto the glass as shown in the illustration.



**Standard:**

Area	Specified Condition
a	13.2 mm (0.520 in.)

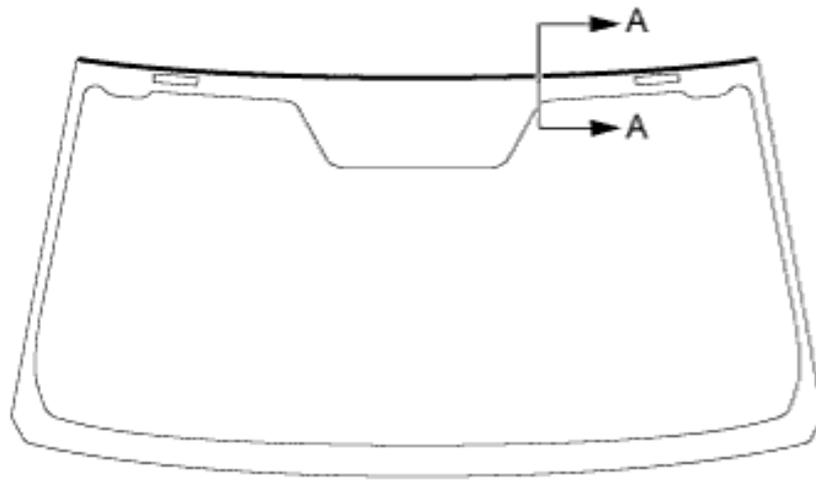
**3. INSTALL WINDSHIELD OUTSIDE MOULDING**

- a. Using a brush or sponge, coat the contact surface of the glass and moulding with Primer G as shown in the illustration.

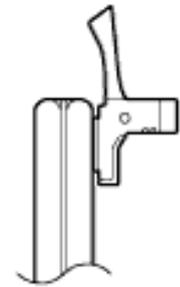
**NOTICE:**

- Allow the primer coating to dry for 3 minutes or more.
- Do not coat the adhesive with Primer G.
- Throw away any leftover primer.

Backside:



A - A



**NOTICE:**

Do not drive the vehicle for the amount of time written in the table below.

**Usage Time Frame:**

Temperature	Usage Time Frame
35°C (95°F)	15 minutes
20°C (68°F)	1 hour 40 minutes
5°C (41°F)	8 hours

- b. Remove the peeling paper from the windshield outside moulding. Install the moulding as shown in the illustration.

**4. INSTALL WINDSHIELD GLASS ADHESIVE DAM**

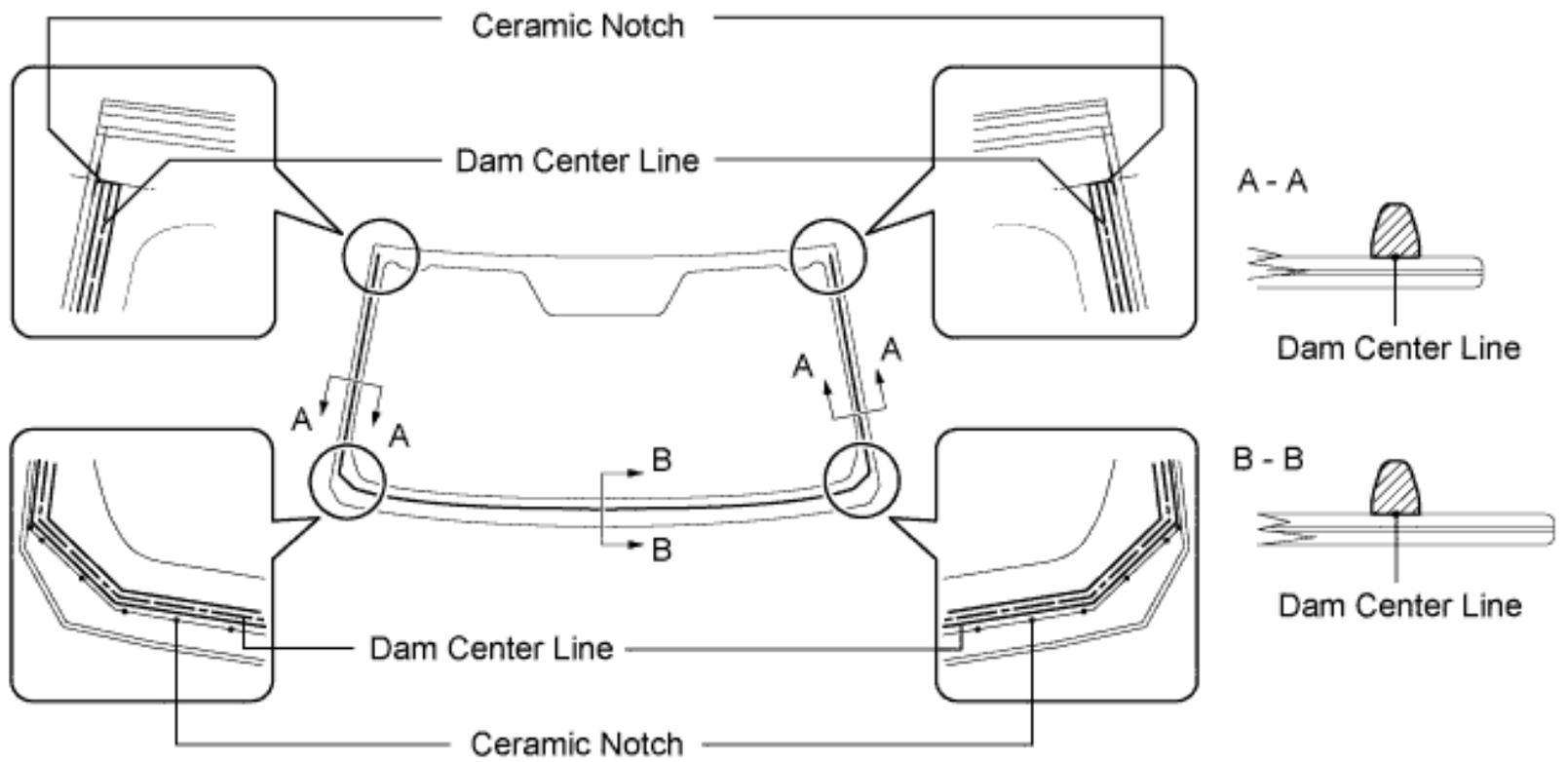
- a. Apply Primer G to the glass where the glass adhesive dam will be installed.

**NOTICE:**

- **Allow the primer to dry for 3 minutes or more.**
- **Throw away any leftover primer.**
- **Do not apply too much primer.**

- b. Remove the peeling paper from the adhesive part of the dam. Install the dam (adhesive side) to the glass (Primer G area), but exclude the area above the notches on the upper part of the glass.

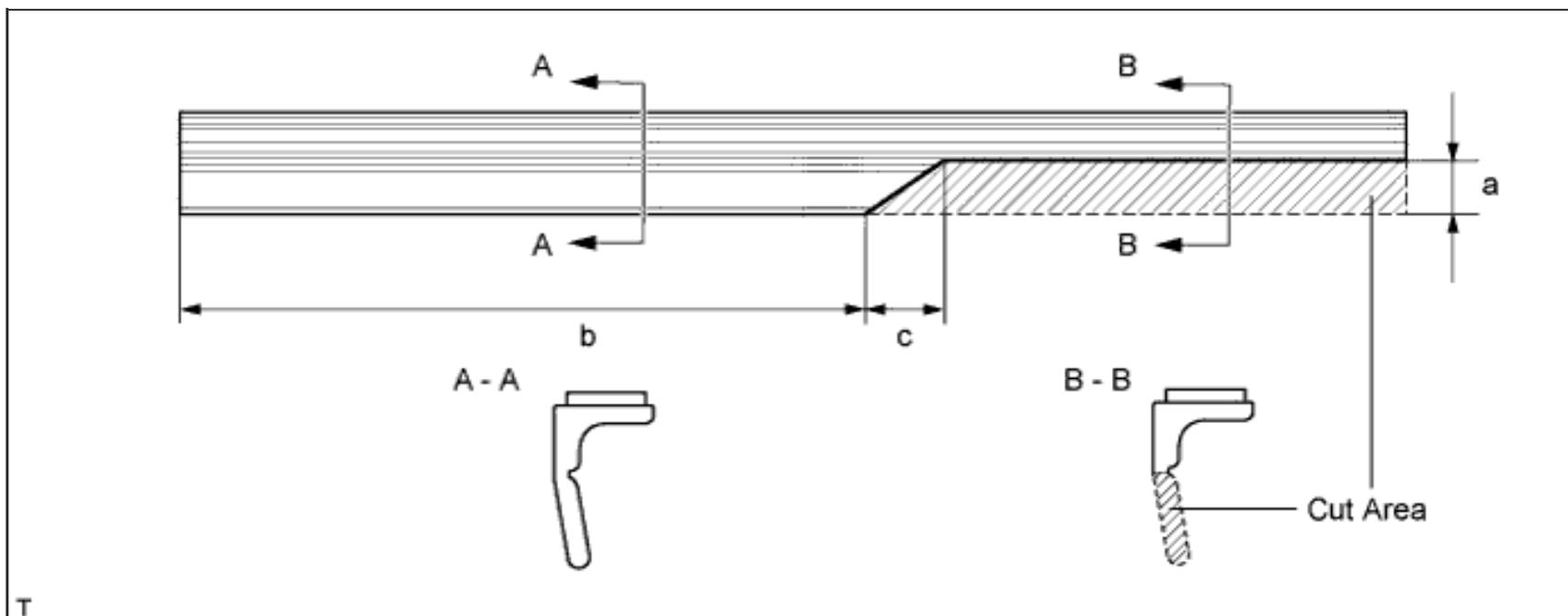
Backside:



T

## 5. INSTALL FRONT INNER WINDOW MOULDING COVER LH

- a. Using a knife, cut off the cover as shown in the illustration.



T

### Standard:

Area	Specified Condition

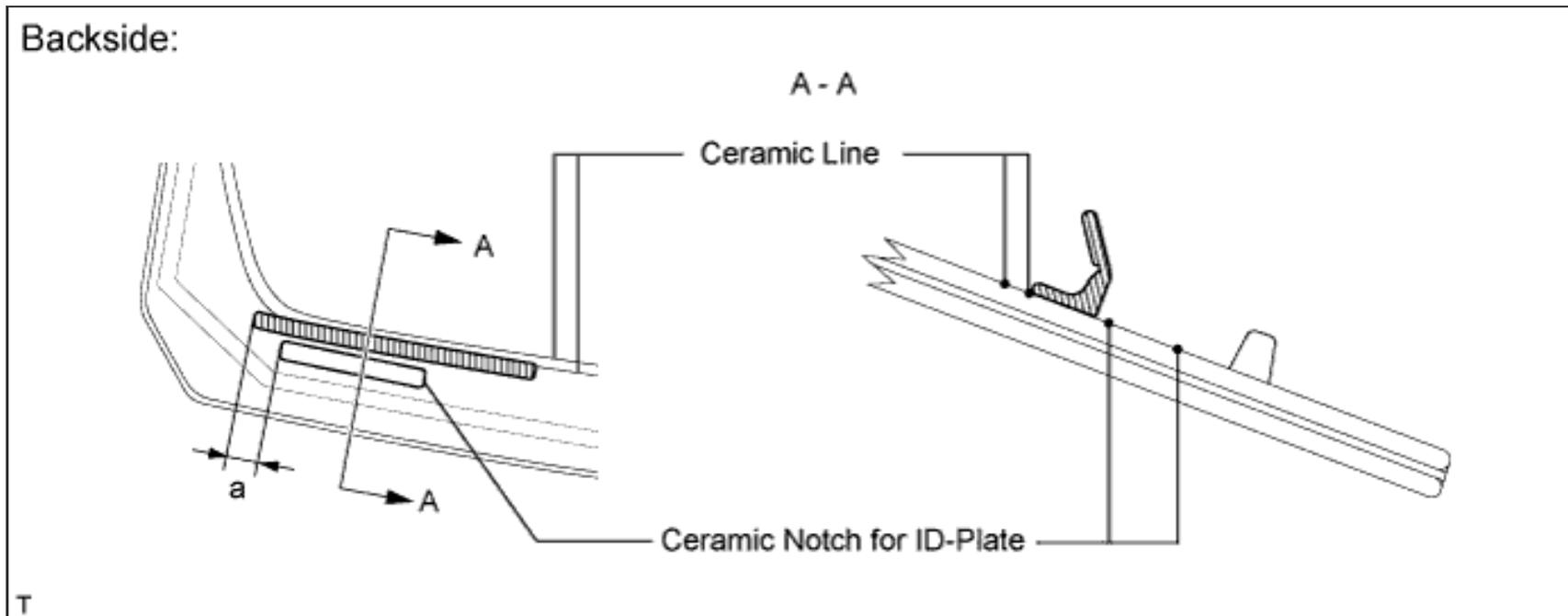
a	6.9 mm (0.272 in.)
b	96.5 mm (3.79 in.)
c	10.0 mm (0.394 in.)

b. Apply Primer G to the glass where the inner window moulding cover will be installed.

**NOTICE:**

- Allow the primer to dry for 3 minutes or more.
- Throw away any leftover primer.
- Do not apply too much primer.

c. Remove the peeling paper from the inner window moulding cover. Install the cover to the glass, as shown in the illustration.



**Standard:**

Area	Specified Condition
a	14.0 mm (0.551 in.)

**6. INSTALL WINDSHIELD GLASS**

a. Position the glass.

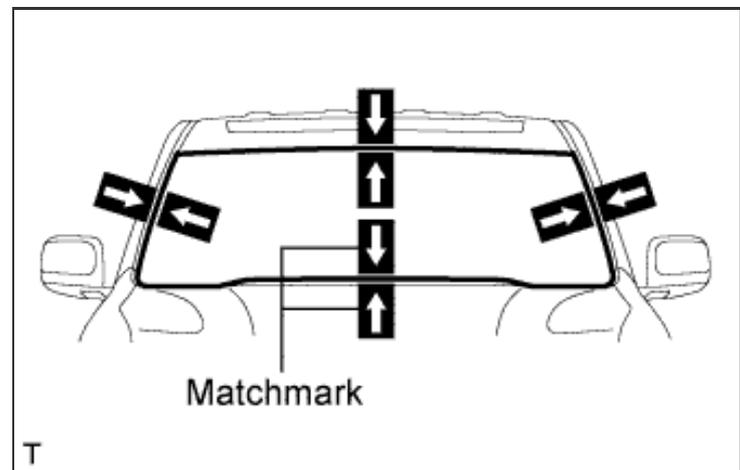
i. Using suction cups, place the glass in the

correct position.

- ii. Check that the entire contact surface of the glass rim is perfectly even.
- iii. Place matchmarks on the glass and vehicle body on the locations indicated in the illustration.

**HINT:**

- **Placing matchmarks is only necessary when installing new glass. If it is the reused glass, matchmarks should already be present.**
- **When reusing the glass, check and correct the matchmark positions.**



**NOTICE:**

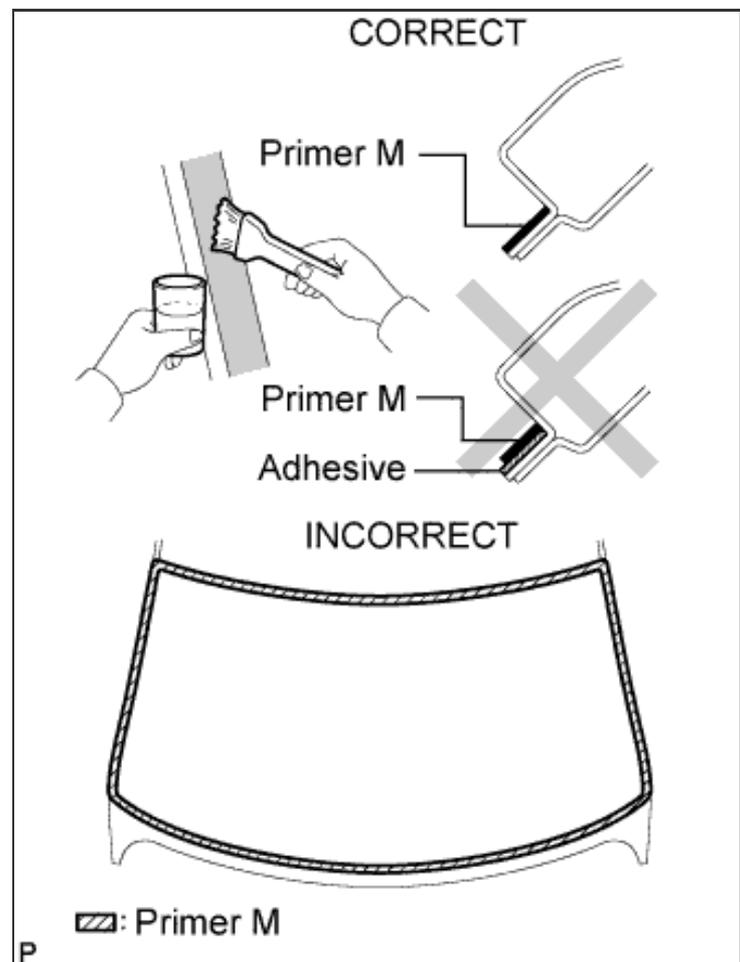
Check that the stoppers are attached to the vehicle body correctly.

- iv. Using suction cups, remove the glass.

- b. Using a brush, apply Primer M to the exposed part of the vehicle body.

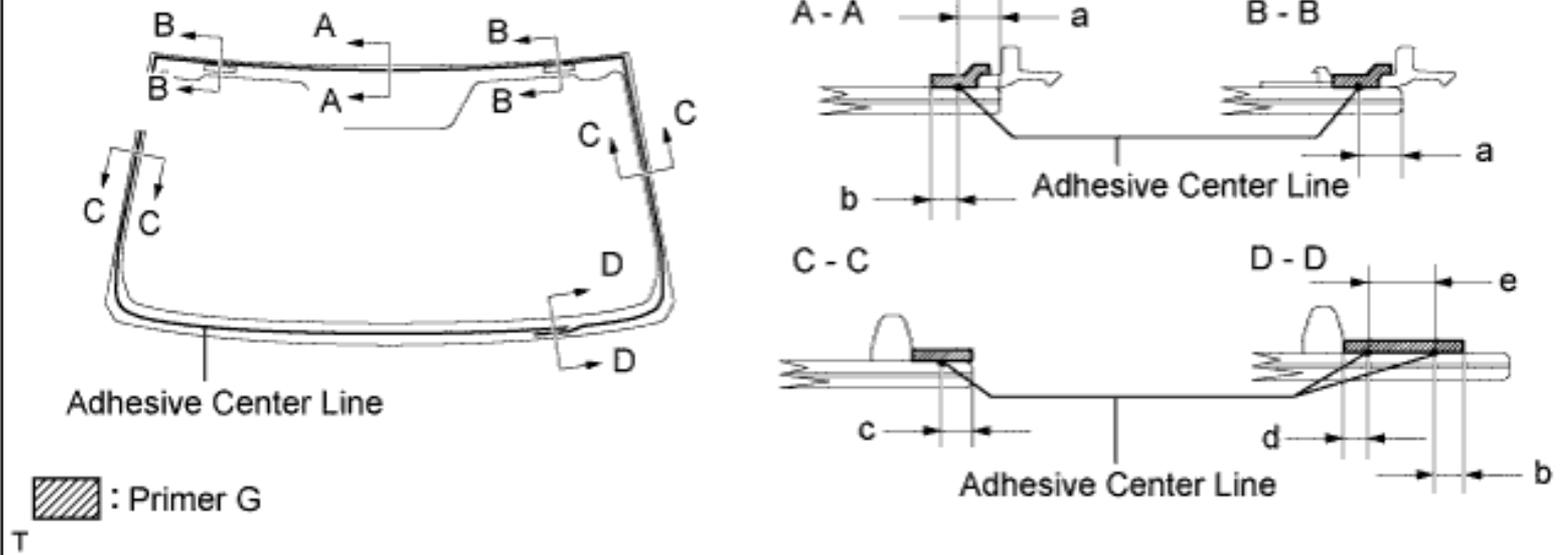
**NOTICE:**

- **Allow the primer to dry for 3 minutes or more.**
- **Do not apply primer to the adhesive.**
- **Throw away any leftover primer.**
- **Do not apply too much primer.**



- c. Using a brush or sponge, apply Primer G to the contact surface of the glass.

Backside:



**Standard:**

Area	Specified Condition
a	9.0 mm (0.354 in.)
b	7.0 mm (0.276 in.)
c	3.0 mm (0.118 in.)
d	4.0 mm (0.157 in.)
e	8.0 mm (0.315 in.)

**HINT:**

If the primer is applied to an area that is not specified, apply non-residue solvent to a clean cloth and wipe off the excess primer before it dries.

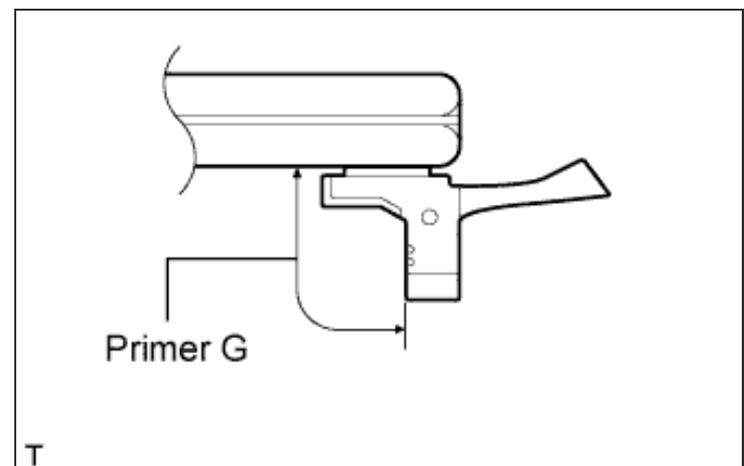
**NOTICE:**

- Allow the primer to dry for 3 minutes or more.
- Throw away any leftover primer.
- Do not apply too much primer.

d. Using a brush or sponge, coat the windshield outside moulding with Primer G as shown in the illustration.

**NOTICE:**

- Allow the primer to dry for 3 minutes or more.
- Throw away any leftover primer.
- Do not apply too much primer.



e. Apply adhesive to the glass.

**Adhesive:****Toyota Genuine Windshield Glass Adhesive or equivalent**

- i. Cut off the tip of the cartridge nozzle as shown in the illustration.

**HINT:**

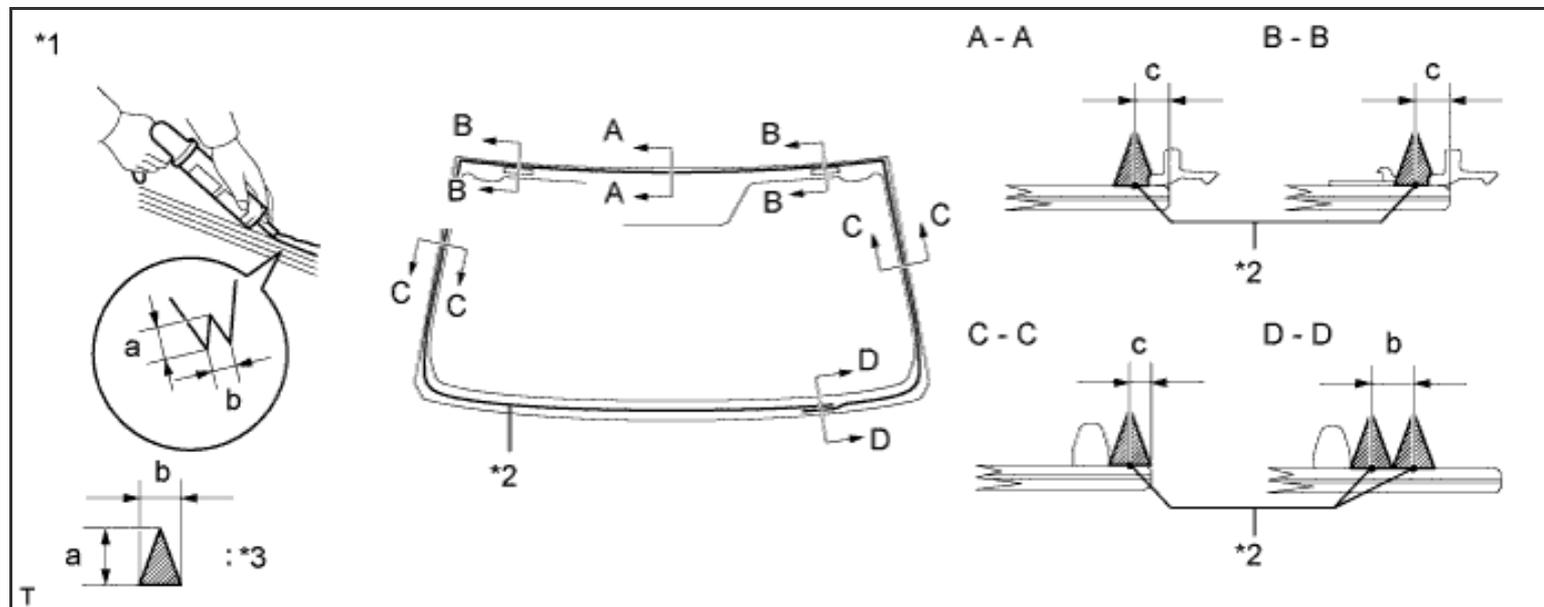
After cutting off the tip, use all adhesive within the time written in the table below.

**Usage Time Frame:**

Temperature	Usage Time Frame
35°C (95°F)	15 minutes
20°C (68°F)	1 hour 40 minutes
5°C (41°F)	8 hours

- ii. Load the sealer gun with the cartridge.

- iii. Apply adhesive to the glass as shown in the illustration.

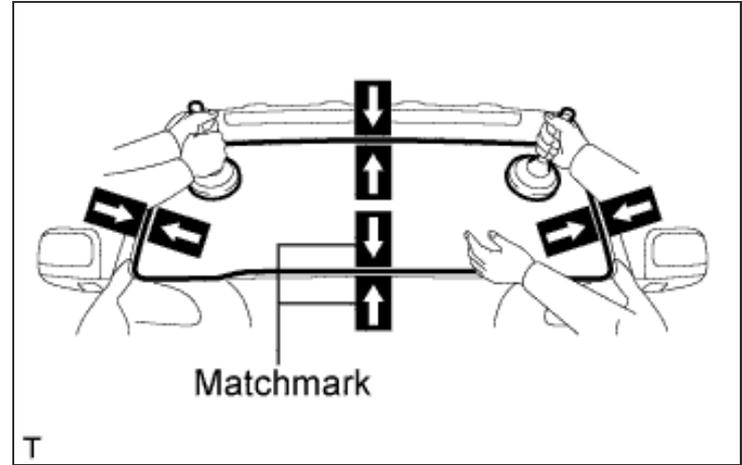
**Standard:**

Area	Specified Condition
a	12.0 mm (0.472 in.)
b	8.0 mm (0.315 in.)
c	9.0 mm (0.354 in.)

d	3.0 mm (0.118 in.)
---	--------------------

f. Install the glass to the vehicle body.

- i. Using suction cups, position the glass so that the matchmarks are aligned. Press it in gently along the rim.
- ii. Lightly press the outer surface of the glass to ensure that it is securely fit to the vehicle body.



**NOTICE:**

- Check that the stoppers are attached to the vehicle body correctly.
- Check that the vehicle body and glass have a small gap between them.

- iii. Hold the glass in place securely with protective tape or equivalent until the adhesive hardens.

**NOTICE:**

Do not drive the vehicle for the amount of time written in the table below.

**Minimum Time:**

Temperature	Minimum Time Prior to Driving Vehicle
35°C (95°F)	1 hour 30 minutes
20°C (68°F)	5 hours
5°C (41°F)	24 hours

- g. w/ Windshield Deicer System:  
Connect the windshield deicer connector.

**7. CHECK FOR LEAK AND REPAIR**

- a. Conduct a leak test after the adhesive has completely hardened.
- b. Seal any leaks with auto glass sealer.

**8. INSTALL ROOF HEADLINING**

- a. w / Sliding Roof:

- i. Return the roof headlining to its original position. Refer to the following procedures ([Click here](#)).

**b.** w /o Sliding Roof:

- i. Return the roof headlining to its original position. Refer to the following procedures ([Click here](#)).

## 9. INSTALL RAIN SENSOR TAPE (w/ Rain Sensor)

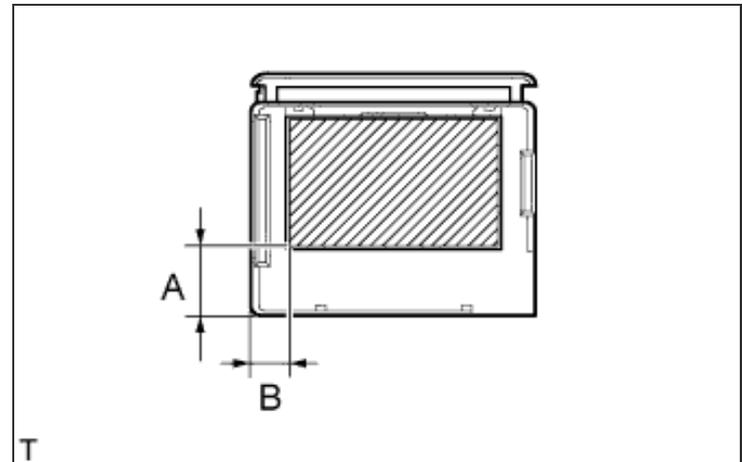
### HINT:

Only perform this procedure when replacing the rain sensor tape.

- a. Apply new rain sensor tape to the rain sensor surface, indicated by the hatched area.

### NOTICE:

- **Keep the exposed adhesive on the tape free from dust and fingerprints.**
- **Apply the tape exactly according to the specifications below.**
- **When installing a new rain sensor, peel the release paper off from the silicon sheet first.**
- **Be careful not to leave any air bubbles in the rain sensor tape when installing it.**



### Specification:

Area	Measurement
A	15 mm (0.591 in.)
B	8 mm (0.315 in.)

## 10. INSTALL RAIN SENSOR (w/ Rain Sensor)

### NOTICE:

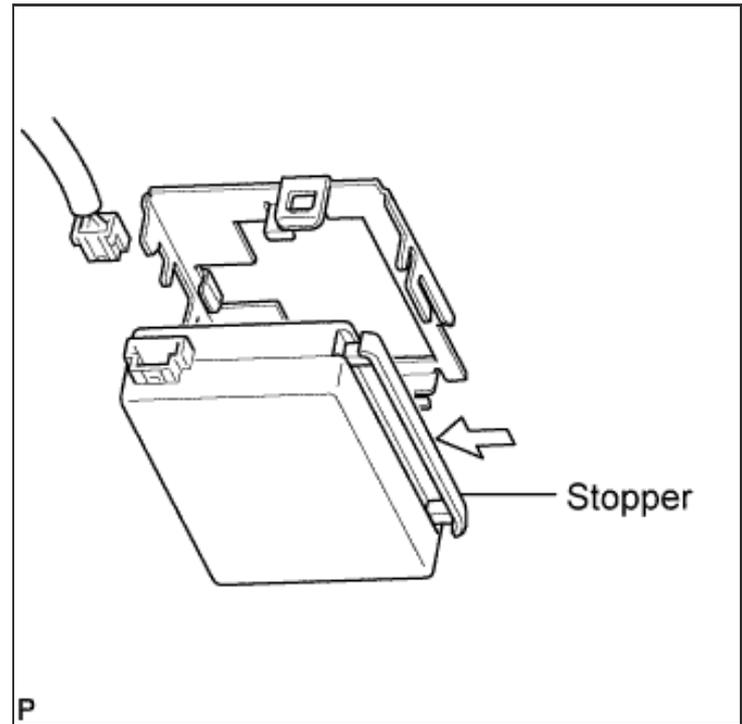
- **Make sure the adhesive between the bracket and windshield glass is normal.**
- **If there is any residue left from the rain sensor tape on the windshield, remove it.**
- **Clean the glass surface with cloth or similar material.**
- **Make sure there are no air bubbles between the rain sensor and windshield.**

- a. Securely attach the rain sensor to the bracket.
- b. Push in the stopper.

**NOTICE:**

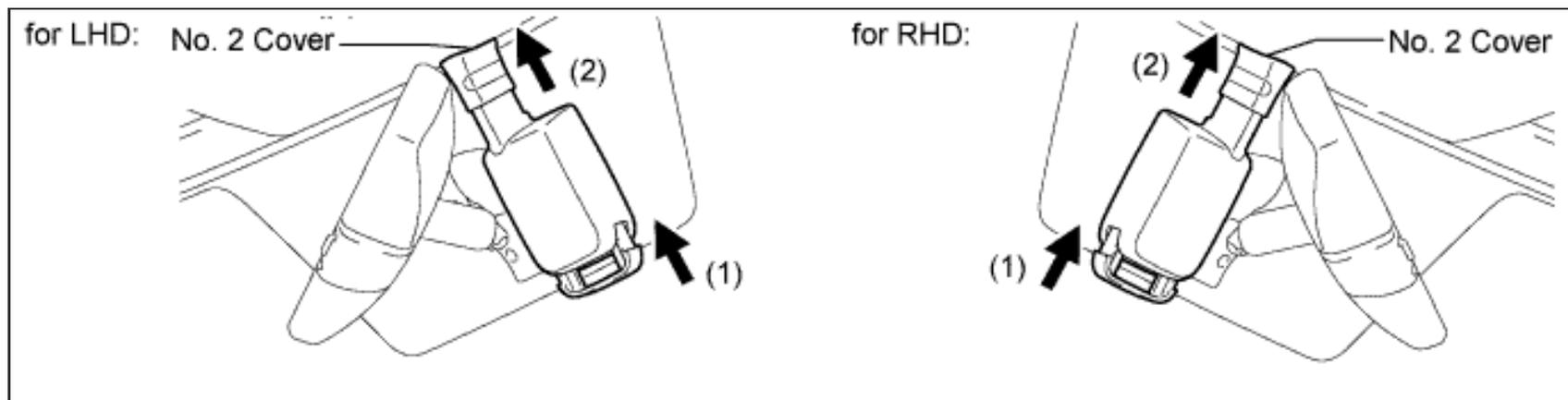
The stopper can be used a maximum of 5 times.

- c. Connect the connector.



## 11. INSTALL RAIN SENSOR COVER (w/ Rain Sensor)

- a. Push in the stopper in the direction of the arrow labeled (1) to install the rain sensor cover.



- b. Slide the No. 2 cover in the direction of the arrow labeled (2) to fix it in place.

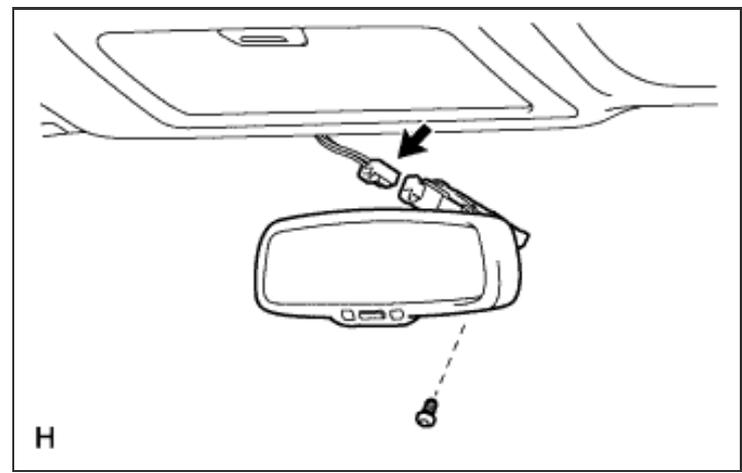
## 12. INSTALL INNER REAR VIEW MIRROR ASSEMBLY (w/ EC Mirror)

- a. Using a T20 "TORX" socket wrench, install the inner rear view mirror with the screw.

**Torque:**

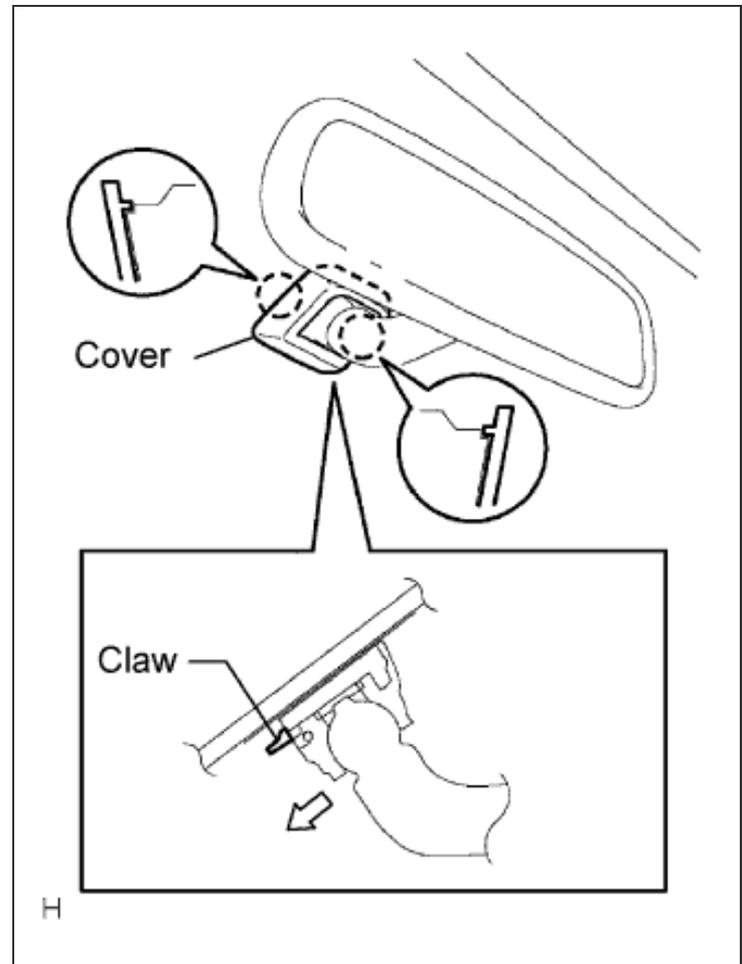
**1.5 N\*m { 15 kgf\*cm , 13 in.\*lbf }**

- b.** Connect the connector.



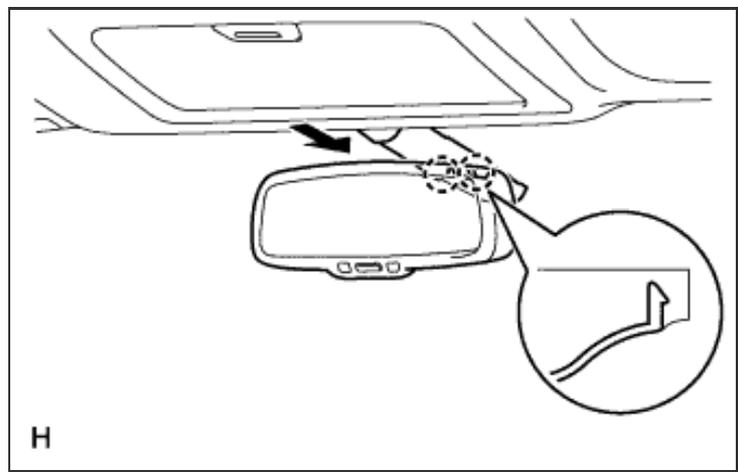
### 13. INSTALL INNER REAR VIEW MIRROR ASSEMBLY (w/o EC Mirror)

- a.** Install the mirror in the direction of the white arrow.
- b.** Install the cover with the 2 claws.



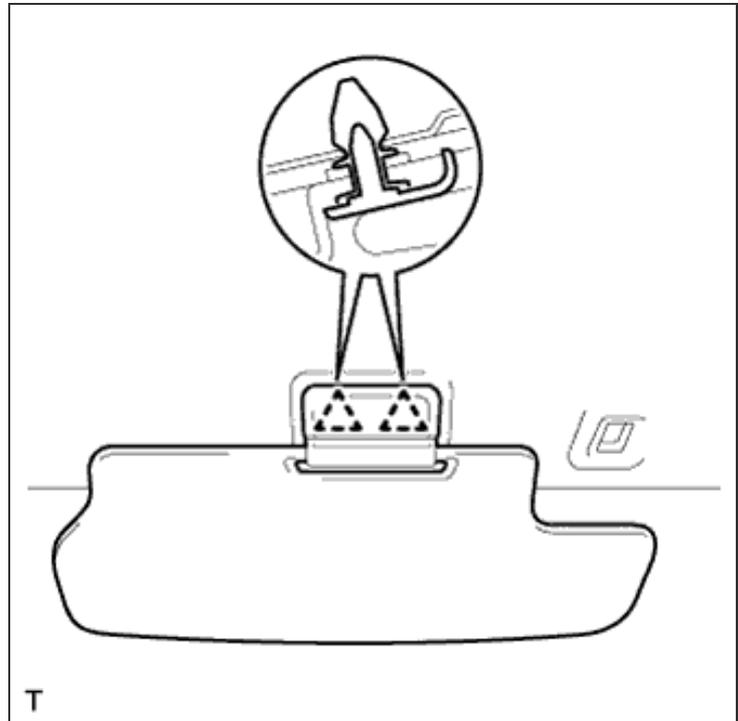
### 14. INSTALL INNER REAR VIEW MIRROR STAY HOLDER COVER (w/ EC Mirror)

- a.** Detach the 2 claws and remove the cover as shown in the illustration.



## 15. INSTALL CENTER VISOR ASSEMBLY LH

- a. Attach the 2 clips to install the center visor.



## 16. INSTALL CENTER VISOR ASSEMBLY RH

### HINT:

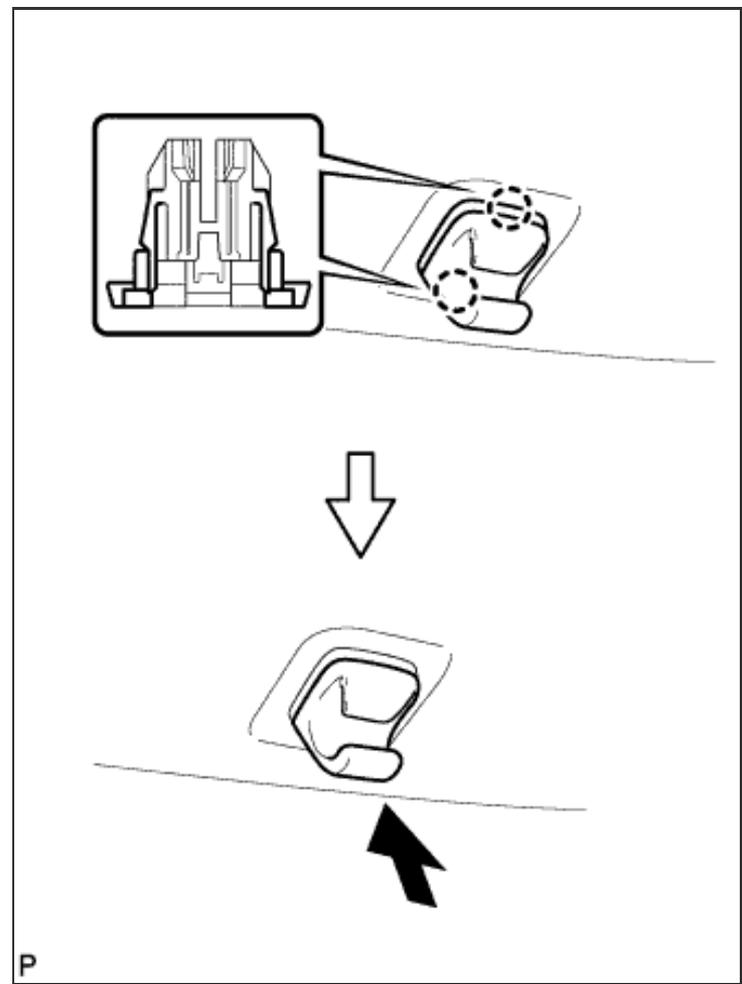
Use the same procedures described for the LH side.

## 17. INSTALL VISOR HOLDER

### HINT:

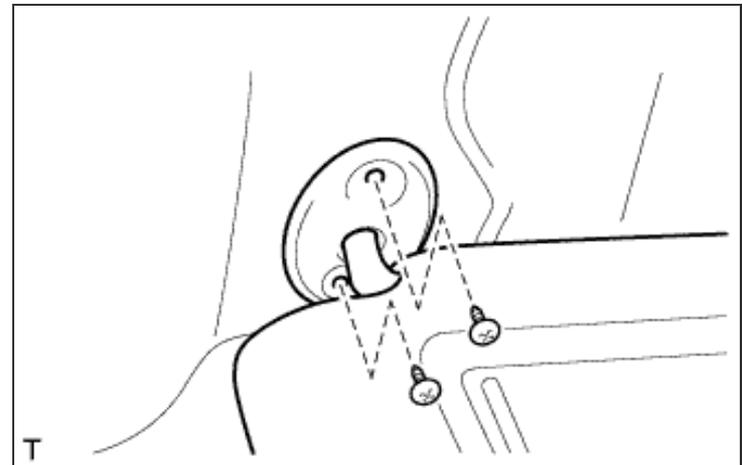
Use the same procedures to install the visor holder on the other side.

- a. Attach the 2 claws.
- b. Push the visor holder in to install it.



## 18. INSTALL VISOR ASSEMBLY LH

- a. Install the visor with the 2 screws.



## 19. INSTALL VISOR ASSEMBLY RH

### HINT:

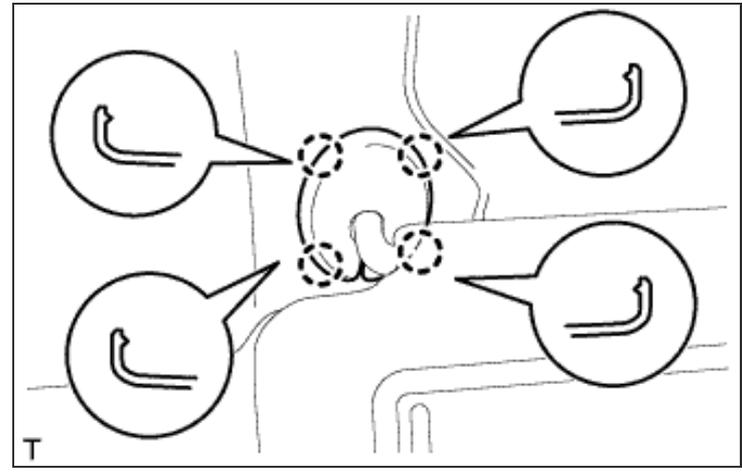
Use the same procedures described for the LH side.

## 20. INSTALL VISOR BRACKET COVER

**HINT:**

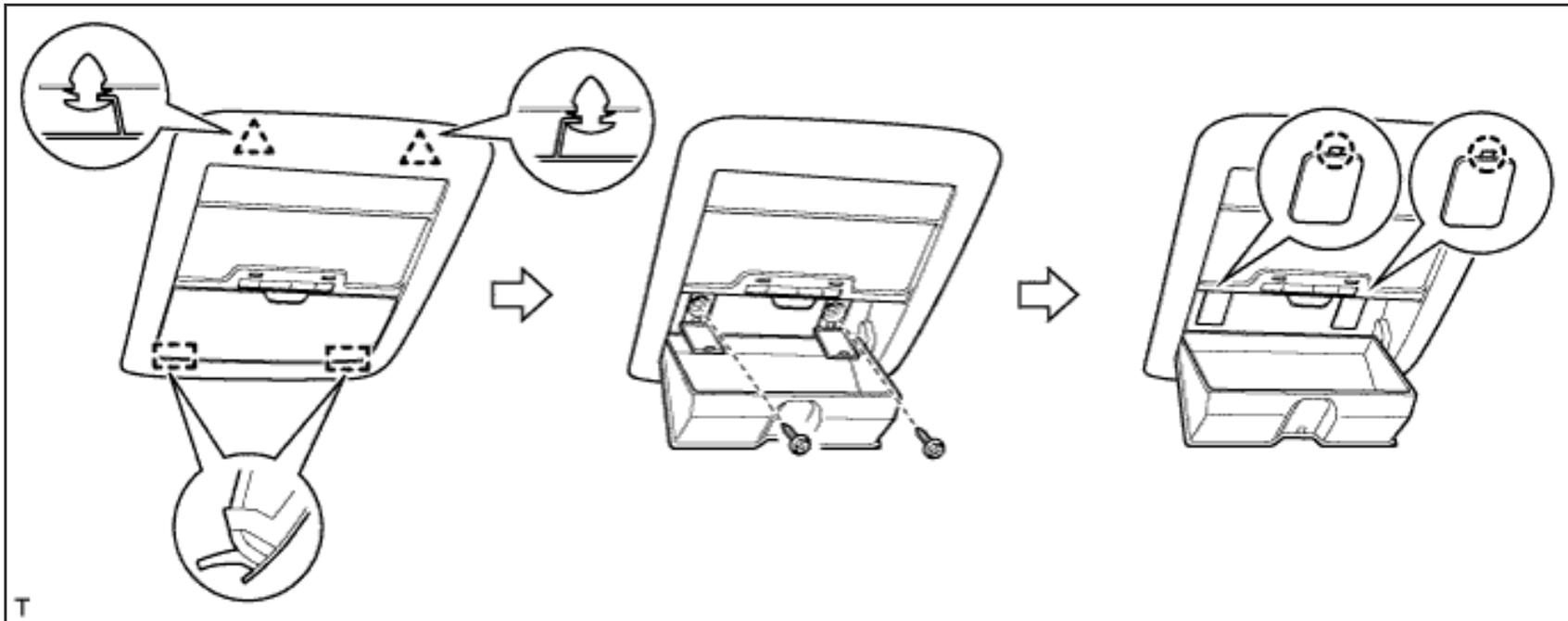
Use the same procedure to install the visor bracket cover on the other side.

- a. Attach the 4 claws to install the visor bracket cover.



**21. INSTALL MAP LIGHT ASSEMBLY**

- a. Connect the connector.
- b. Attach the 2 clips and 2 guides to install the map light.
- c. Install the 2 screws.
- d. Attach the 2 claws to close the 2 covers.

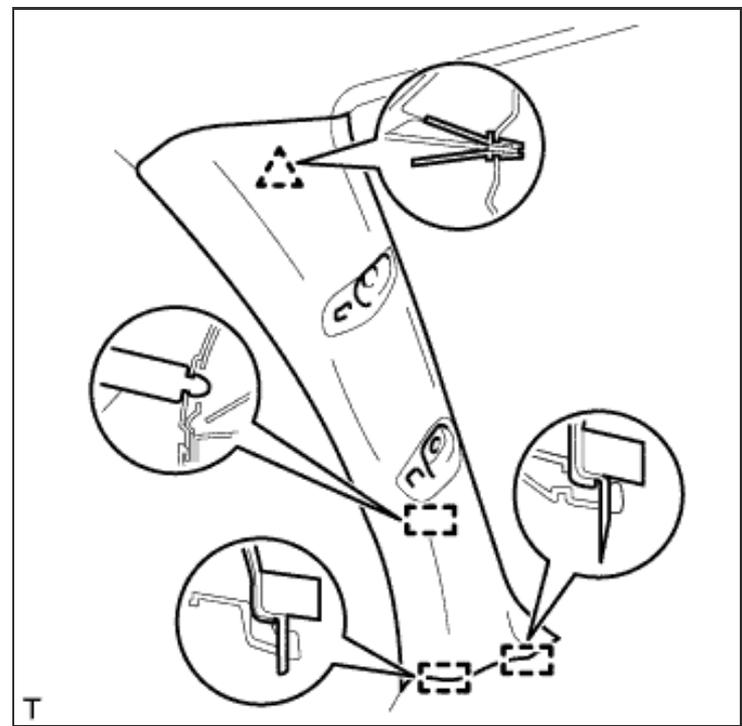


**22. INSTALL FRONT PILLAR GARNISH LH**

- a. for 9, 14 Speakers:

Connect the speaker connector.

- b.** Attach the clip and 3 guides to install the front pillar garnish.



### 23. INSTALL FRONT PILLAR GARNISH RH

#### HINT:

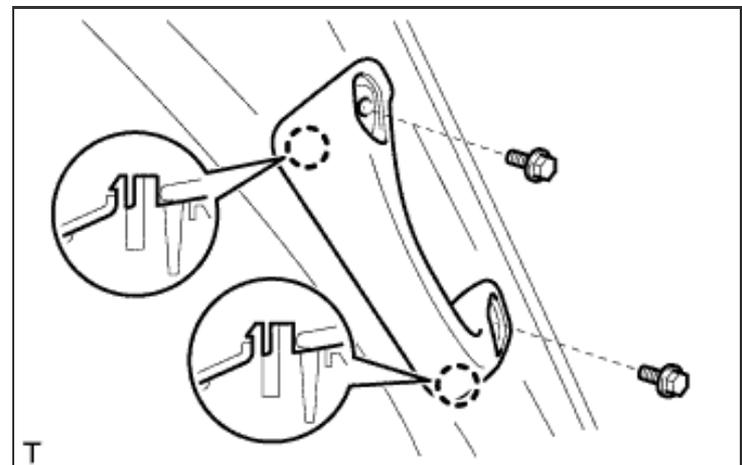
Use the same procedures described for the LH side.

### 24. INSTALL FRONT ASSIST GRIP SUB-ASSEMBLY

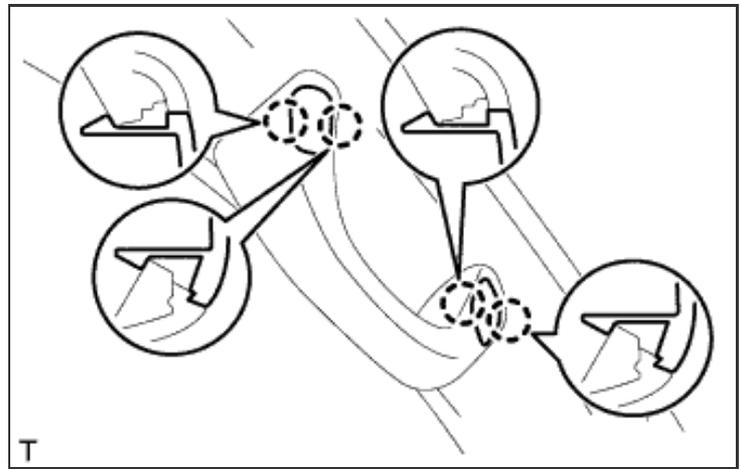
#### HINT:

Use the same procedure to install the front assist grip on the other side.

- a.** Attach the 2 claws to install the front assist grip.
- b.** Install the 2 bolts.



- c.** Attach the 4 claws to install the 2 assist grip plugs.



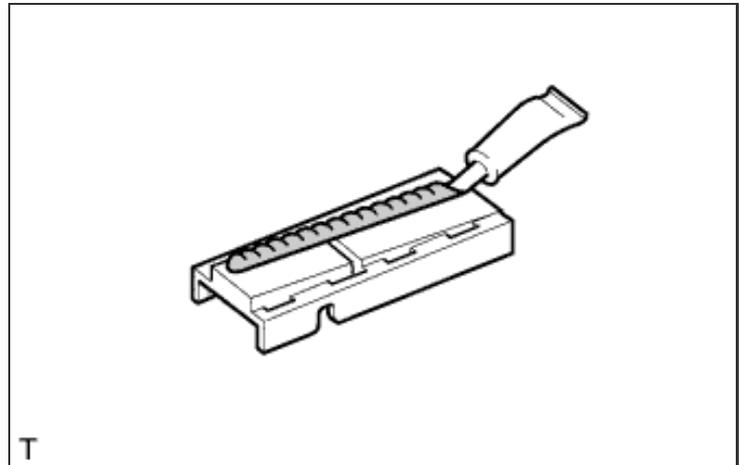
## 25. INSTALL ROOF DRIP SIDE FINISH MOULDING CLIP

### HINT:

Perform the following procedures if replacing any roof drip side finish moulding clip.

### NOTICE:

Remove the double-sided tape where the clips will be installed on the body and clean the body with a non-residue type solvent.



- a. Apply a 2 to 3 mm (0.0787 to 0.118 in.) bead of adhesive (3M DP-105 or equivalent) to a new roof drip side finish moulding clip.

### HINT:

Adhesive strength (tensile strength): 13.7 MPa (140 kgf/cm<sup>2</sup>, 1991 psi) or more when the temperature is 23°C (73°F).

- b. Apply primer to the body where the roof drip side finish moulding clip will be installed.

### NOTICE:

Do not let the primer dry.

- c. Install the clips to the positions on the roof panel shown in the illustration. Determine the locations and firmly press and install the roof drip side finish moulding clip after lightly applying adhesive (3M DP-105 or equivalent).

### Standard:

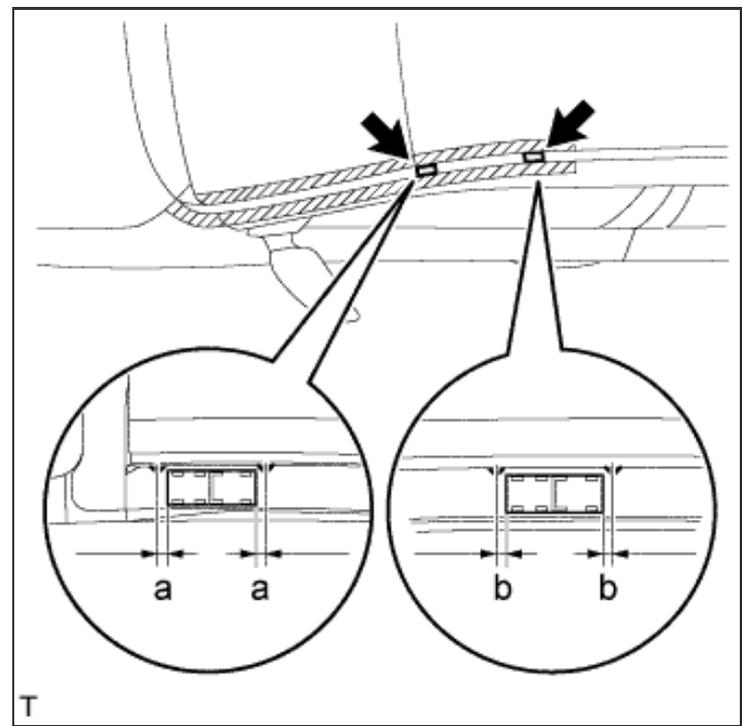
Area	Specified Condition

a	-0.5 to 9.5 mm (0.0197 to 0.374 in.)
b	-0.3 to 3.0 mm (-0.118 to 0.118 in.)

- d. Install the windshield outside moulding when 40 minutes or more have elapsed after pressing and installing the roof drip side finish moulding clip.

**HINT:**

- **Initial hardening time: 40 minutes**
- **Complete hardening time: 48 hours**



**26. INSTALL NO. 3 WINDSHIELD OUTSIDE MouldING CLIP**

**HINT:**

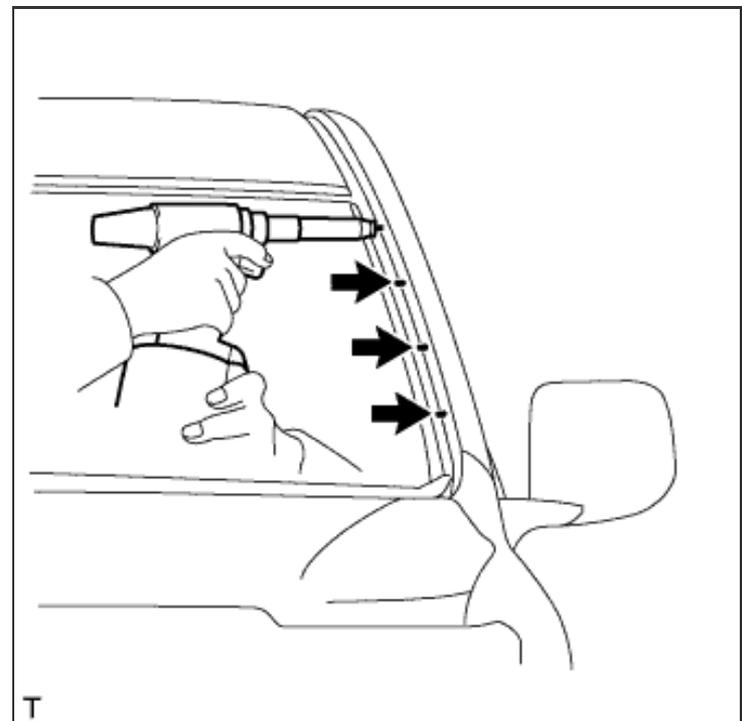
Perform the following procedures if replacing any No. 3 windshield outside moulding clip(s).

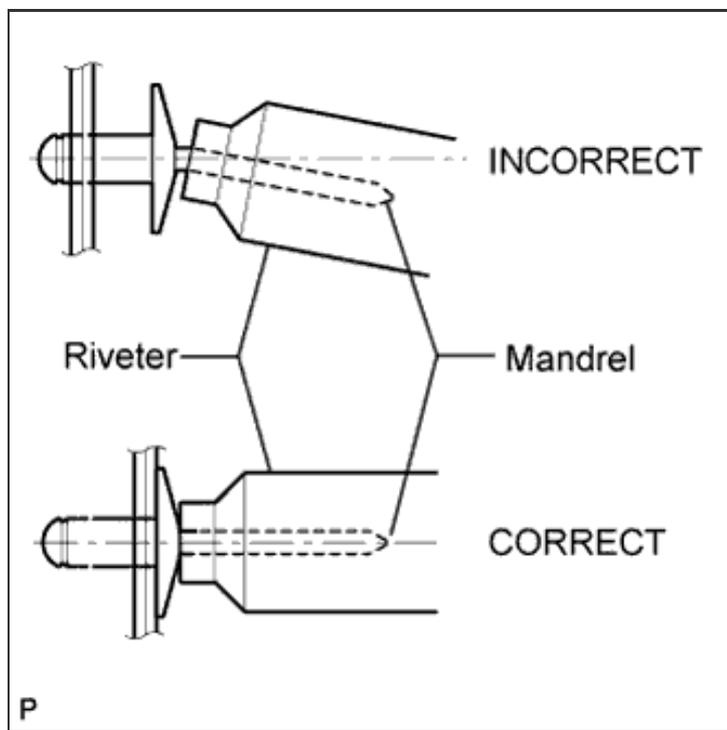
- Install a nose piece to an air riveter or hand riveter.
- Insert the mandrel part of a new No. 3 windshield outside moulding clip into the nose piece.
- Using the riveter, install the No. 3 windshield outside moulding clip(s) shown in the illustration.

**HINT:**

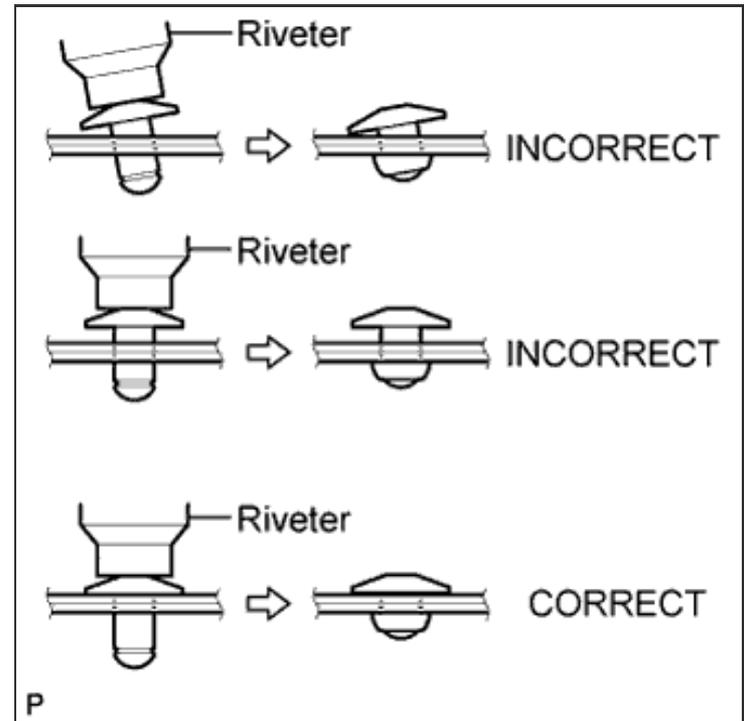
If the rivet cannot be cut, pull it once and cut it.

**NOTICE:**

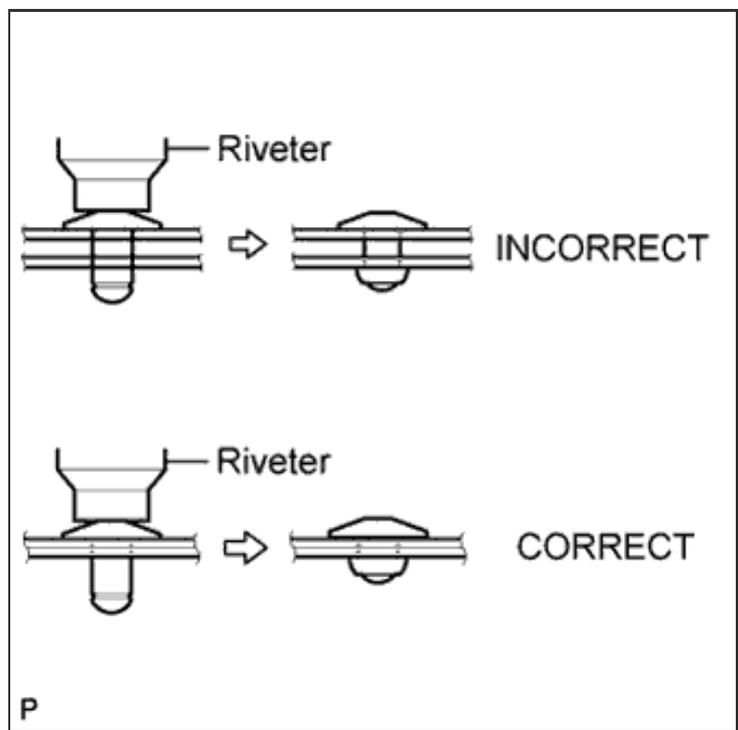




- **Do not pry the rivet with the riveter, as this will cause damage to the riveter and mandrel.**
- **Confirm that the riveter are seated properly against the moulding.**
- **Do not tilt the riveter when installing the rivet to the moulding.**
- **Do not leave any space between the rivet head and moulding.**



- **Do not leave any space between the moulding and body. Firmly hold together the 2 items while installing the rivet.**

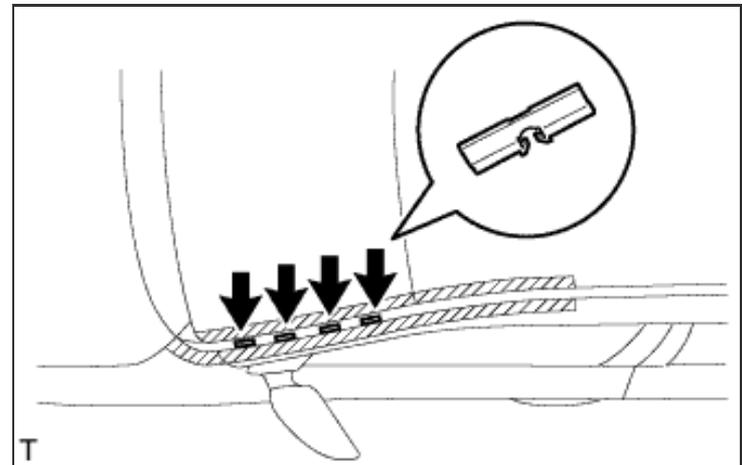


## 27. INSTALL NO. 4 WINDSHIELD MOULDING PAD

- a. Install the 4 No. 4 moulding pads.

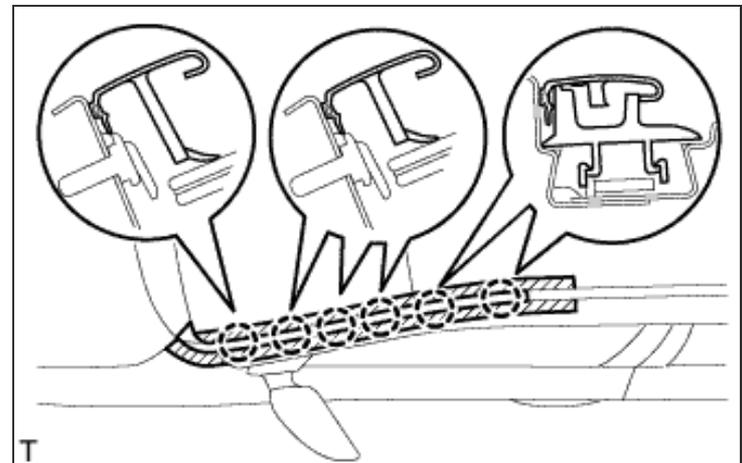
### HINT:

Use the same procedure to install the 4 windshield moulding pads on the other side.



## 28. INSTALL WINDSHIELD OUTSIDE MOULDING LH

- a. Attach the 6 clips to install the moulding.
- b. Remove the protective tape from the edges of the moulding.



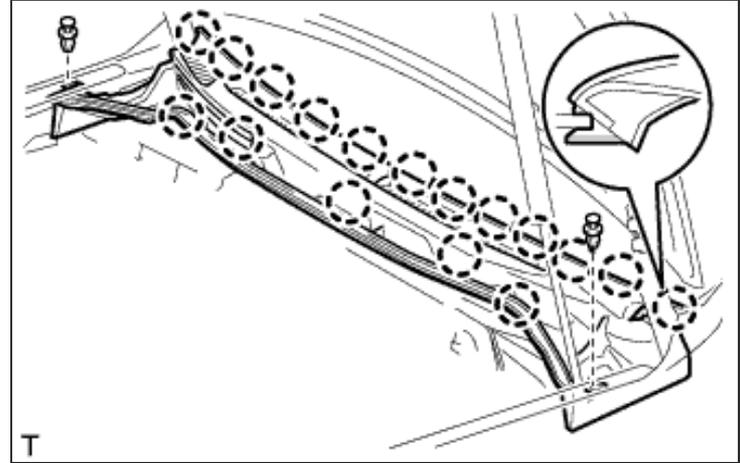
## 29. INSTALL WINDSHIELD OUTSIDE MOULDING RH

**HINT:**

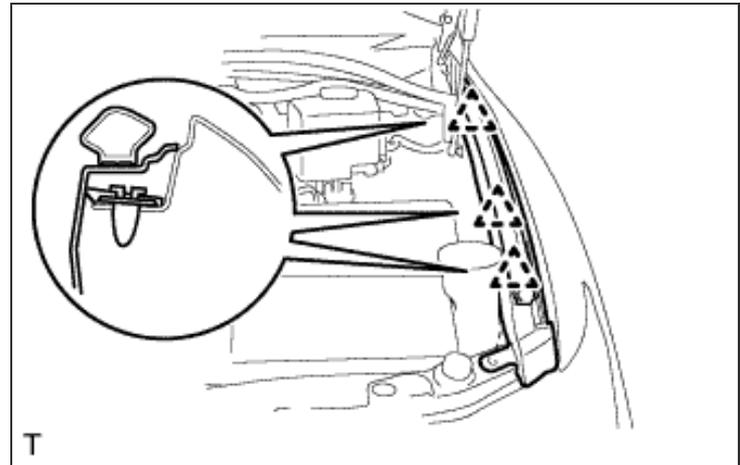
Use the same procedures described for the LH side.

**30. INSTALL COWL TOP VENTILATOR LOUVER SUB-ASSEMBLY**

- a. Push the ventilator louver in the direction indicated by the arrow in the illustration to attach the 17 claws and 2 clips and install the ventilator louver.

**31. INSTALL FRONT FENDER MAIN SEAL LH**

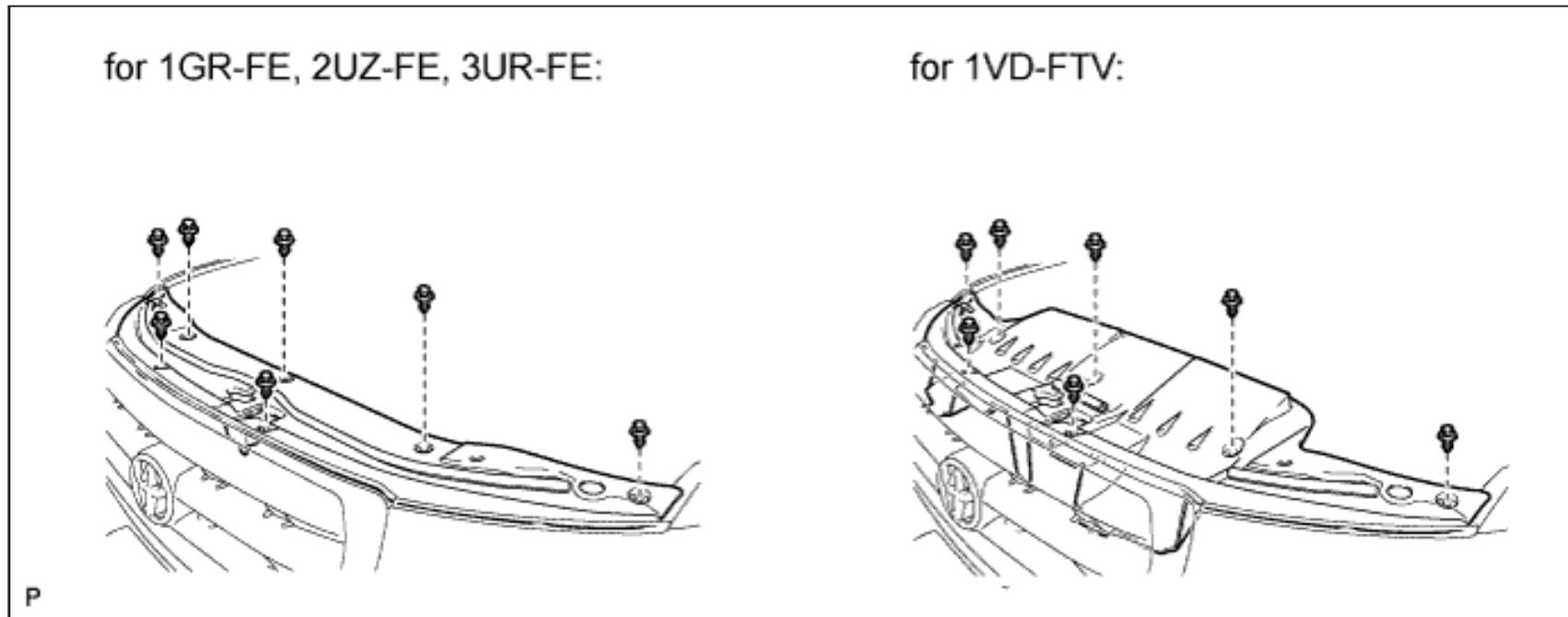
- a. Attach the 3 clips to install the fender main seal.

**32. INSTALL FRONT FENDER MAIN SEAL RH****HINT:**

Use the same procedures described for the LH side.

**33. INSTALL UPPER RADIATOR SUPPORT SEAL**

- a. Install the radiator support seal with the 7 clips.



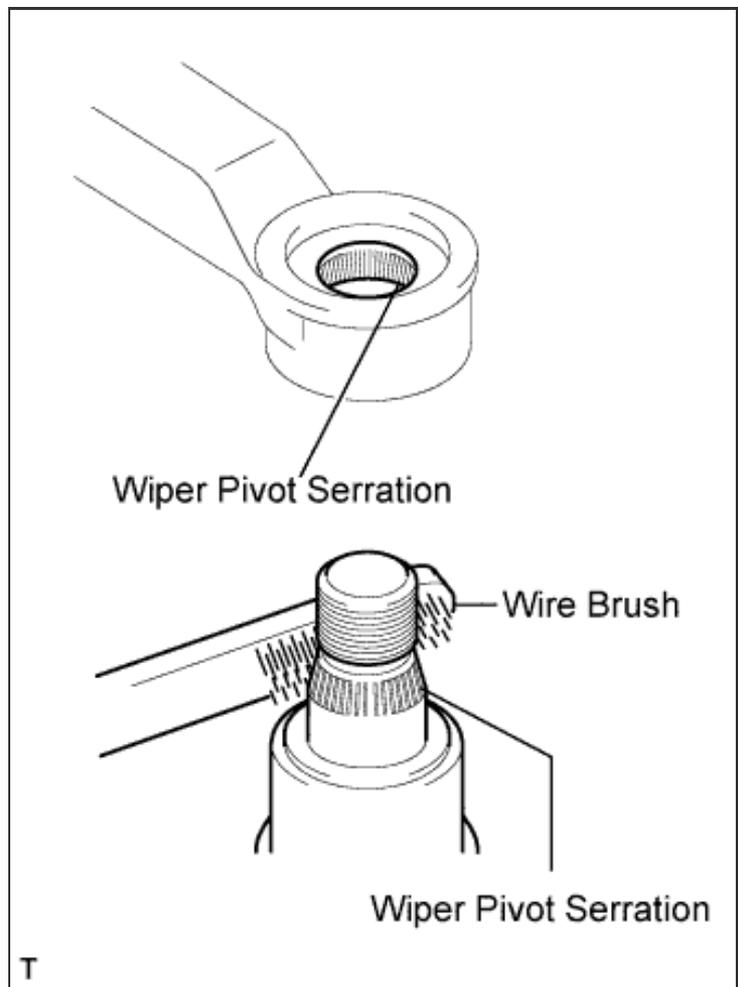
### 34. CONNECT CABLE TO NEGATIVE BATTERY TERMINAL

#### NOTICE:

When disconnecting the cable, some systems need to be initialized after the cable is reconnected ([Click here](#)).

### 35. INSTALL FRONT WIPER ARM LH

- a. Stop the wiper motor at the automatic stop position.
- b. Clean the wiper pivot serration with a wire brush.



- c. Install the wiper arm and blade with the nut. Make sure that the wiper arm and blade comes to the position shown in the illustration.

**Standard Measurement:**

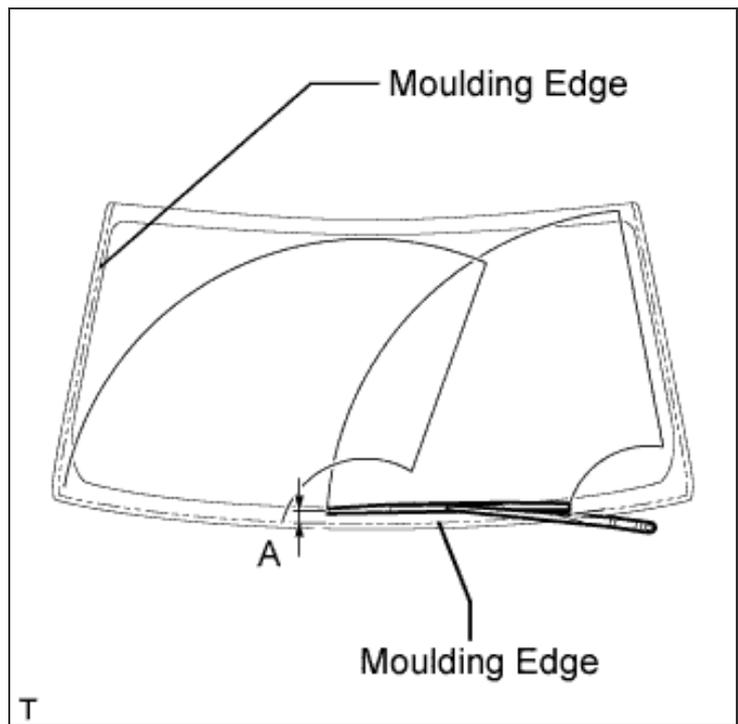
Position	Specified Condition
A	16.8 to 36.8 mm (0.661 to 1.45 in.)

**Torque:**

**25 N\*m { 255 kgf\*cm , 18 ft.\*lbf }**

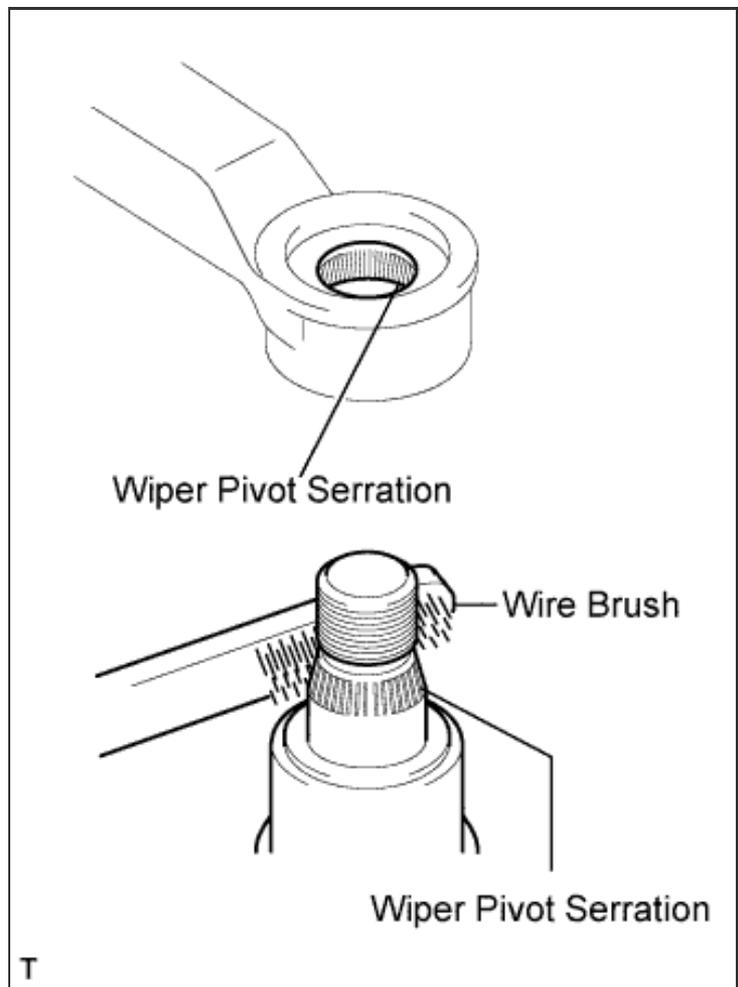
**HINT:**

Hold down the wiper arm hinge with your hand while tightening the nut.



**36. INSTALL FRONT WIPER ARM RH**

- a. Stop the wiper motor at the automatic stop position.
- b. Clean the wiper pivot serration with a wire brush.



- c. Install the wiper arm and blade with the nut. Make sure that the wiper arm and blade comes to the position shown in the illustration.

**Standard Measurement:**

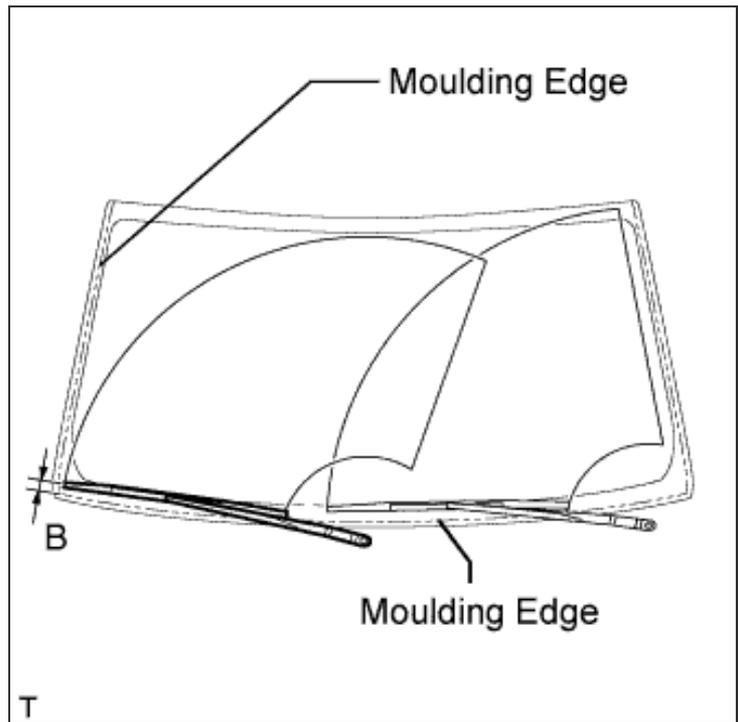
Position	Specified Condition
B	20.0 to 40.0 mm (0.787 to 1.57 in.)

**Torque:**

**25 N\*m { 255 kgf\*cm , 18 ft.\*lbf }**

**HINT:**

Hold down the wiper arm hinge with your hand while tightening the nut.



- d. Operate the front wipers while spraying washer fluid on the windshield glass. Make sure that the front wipers function properly and there is no interference with the vehicle body.

