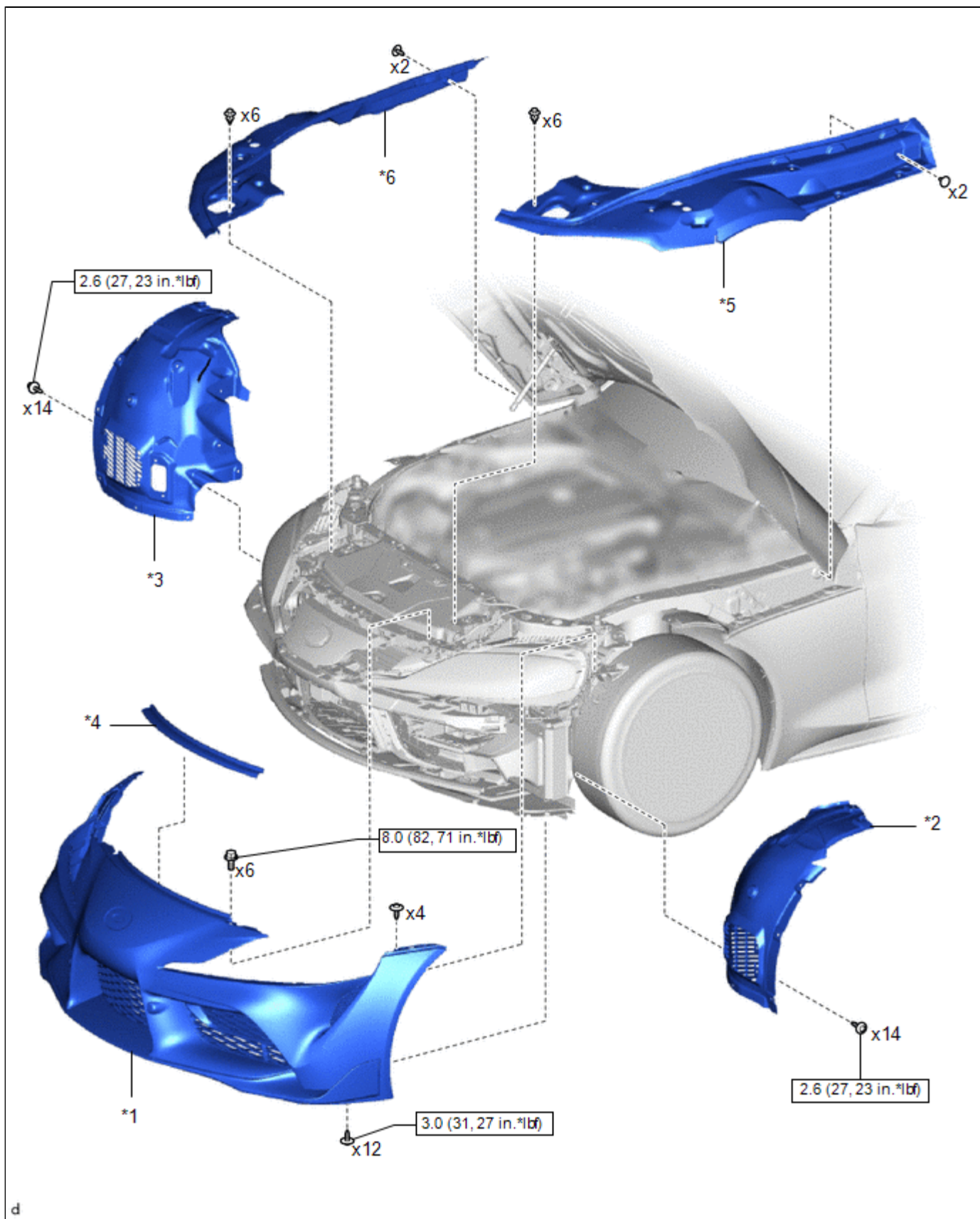


Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCMJ
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: FRONT BUMPER: COMPONENTS; 2020 MY Supra [03/2019 -]		

COMPONENTS

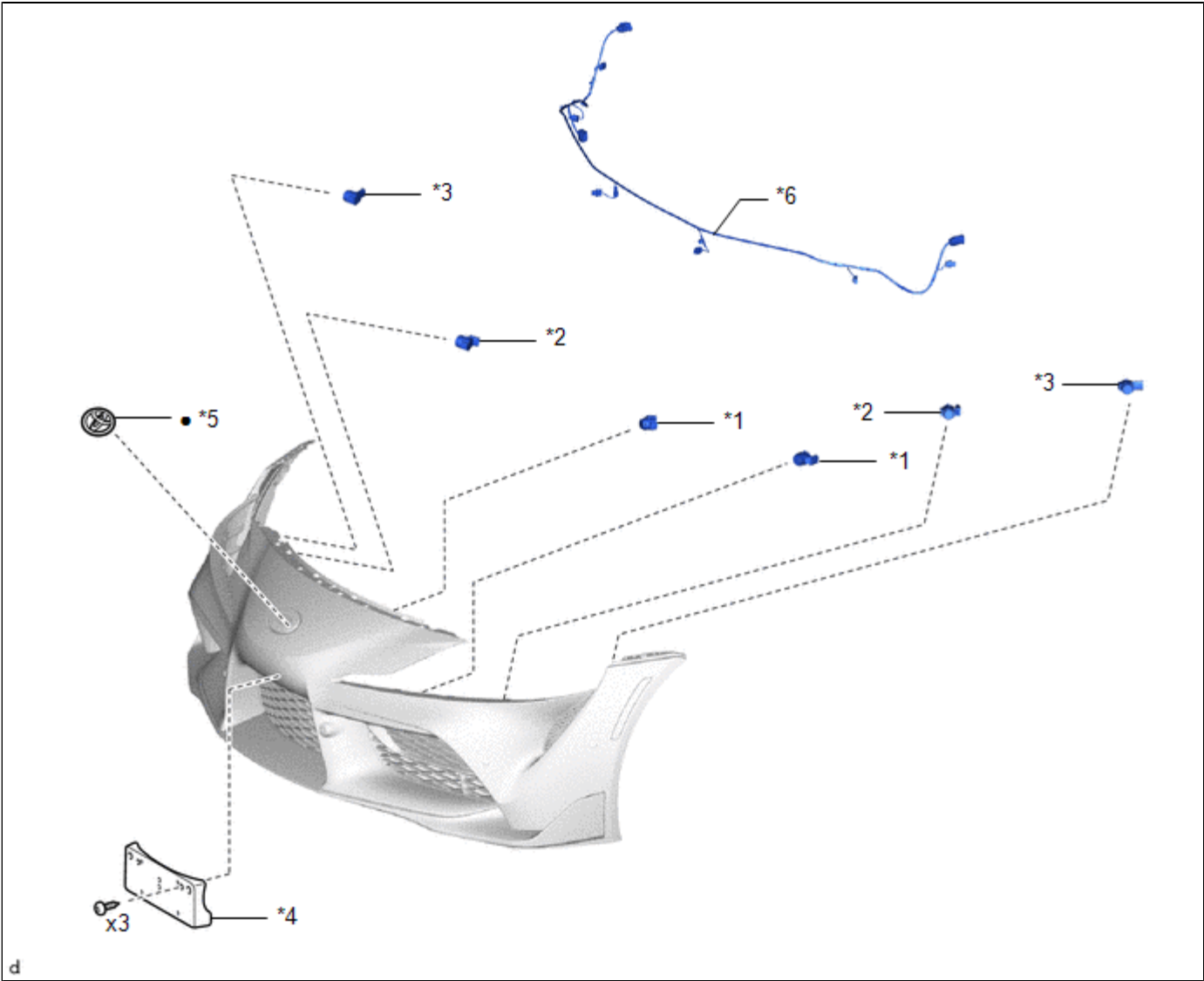
ILLUSTRATION



*1	FRONT BUMPER ASSEMBLY	*2	FRONT FENDER LINER LH
*3	FRONT FENDER LINER RH	*4	HOOD TO RADIATOR SUPPORT SEAL
*5	FRONT FENDER UPPER PROTECTOR LH	*6	FRONT FENDER UPPER PROTECTOR RH

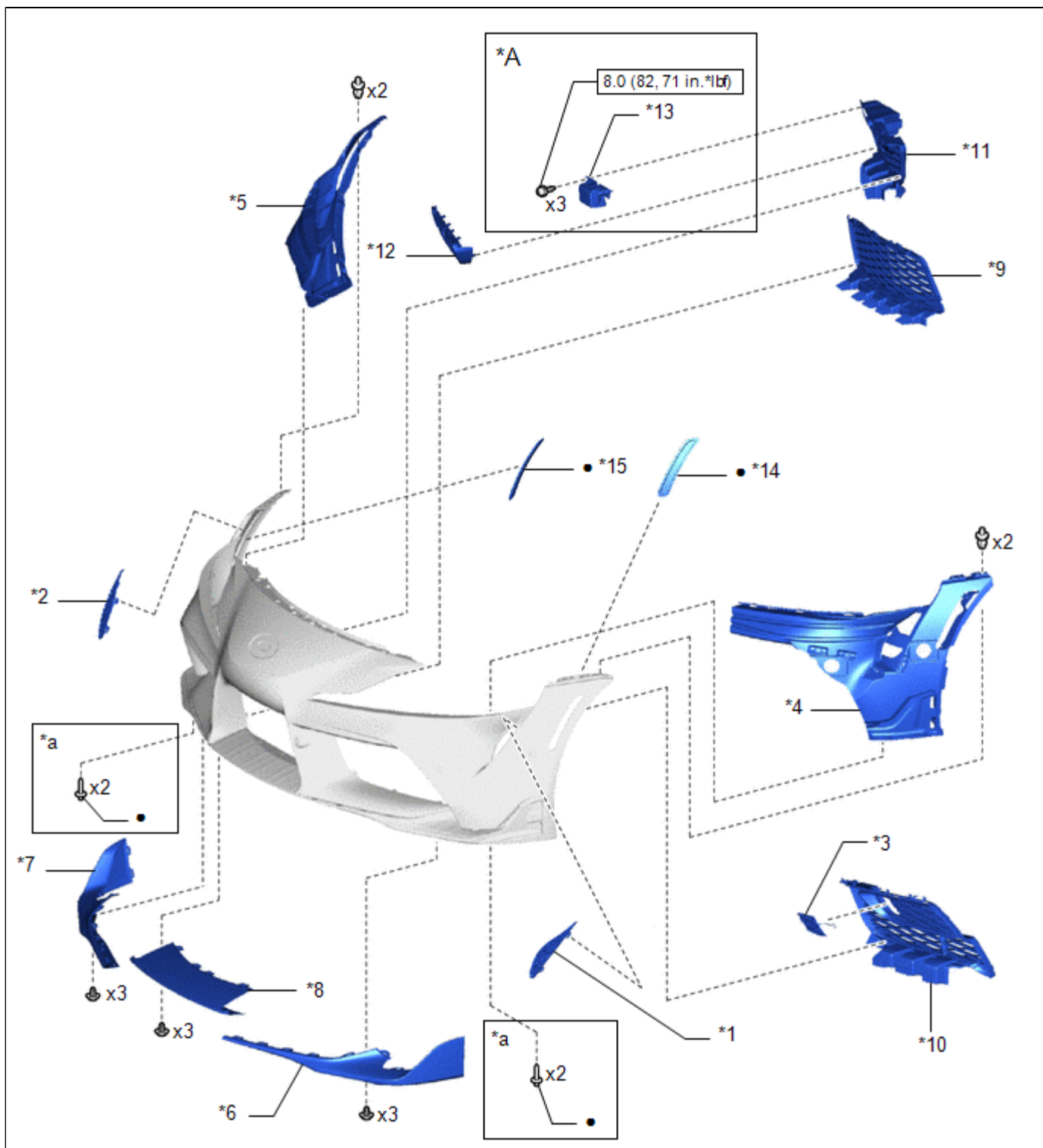
	N*m (kgf*cm, ft.*lbf): Specified torque	-	-
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ILLUSTRATION



*1	FRONT CENTER ULTRASONIC SENSOR	*2	FRONT CORNER ULTRASONIC SENSOR
*3	FRONT SIDE ULTRASONIC SENSOR	*4	FRONT BUMPER EXTENSION MOUNTING BRACKET
*5	FRONT BUMPER EMBLEM SUB-ASSEMBLY	*6	NO. 4 ENGINE ROOM WIRE
●	Non-reusable part	-	-

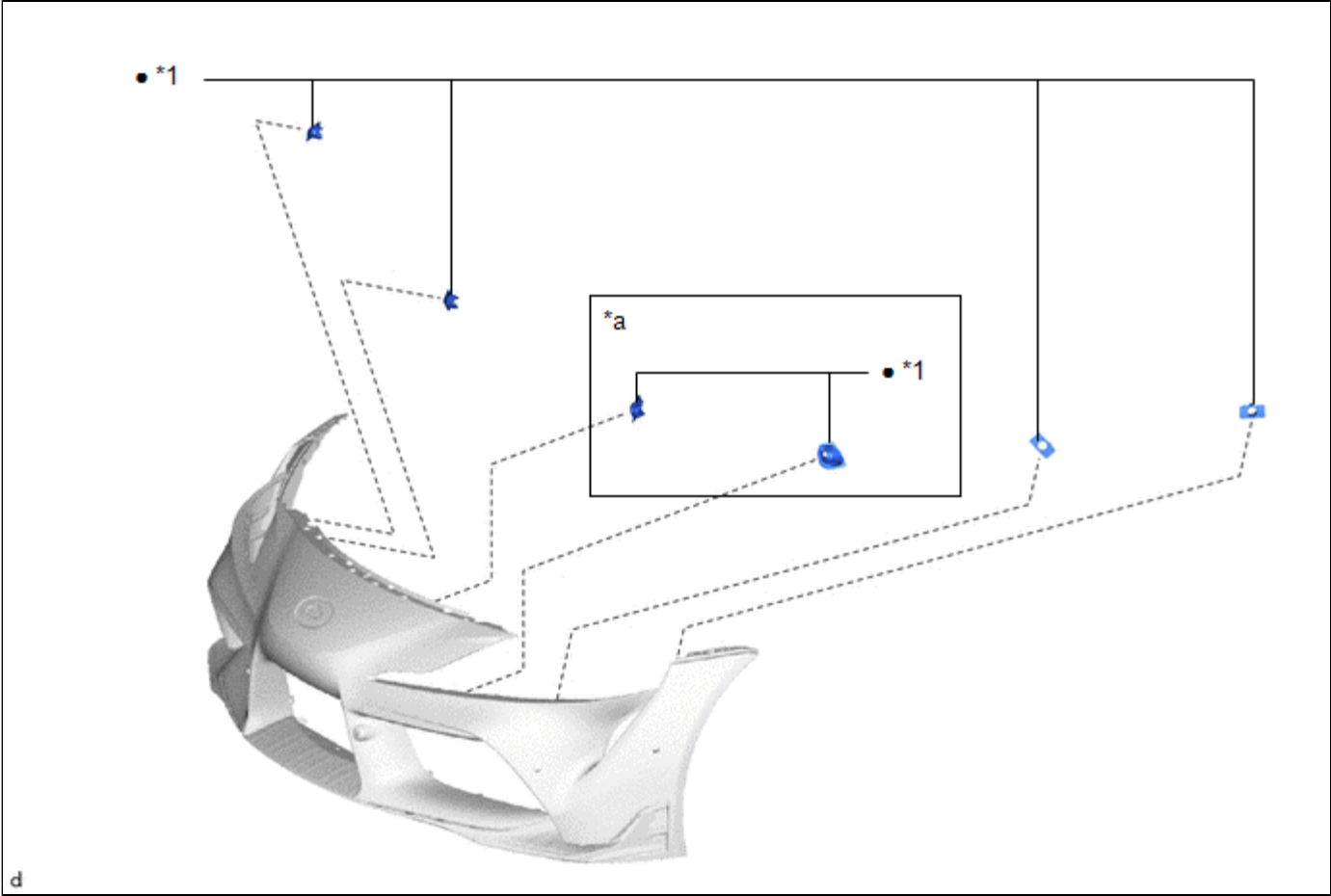
ILLUSTRATION



*A	w/ Toyota Supra Safety	-	-
*1	COOL AIR INTAKE GRILLE LH	*2	COOL AIR INTAKE GRILLE RH
*3	FRONT BUMPER HOLE COVER	*4	FRONT BUMPER SIDE RETAINER LH
*5	FRONT BUMPER SIDE RETAINER RH	*6	FRONT SIDE SPOILER LH
*7	FRONT SIDE SPOILER RH	*8	FRONT SPOILER SUB-ASSEMBLY

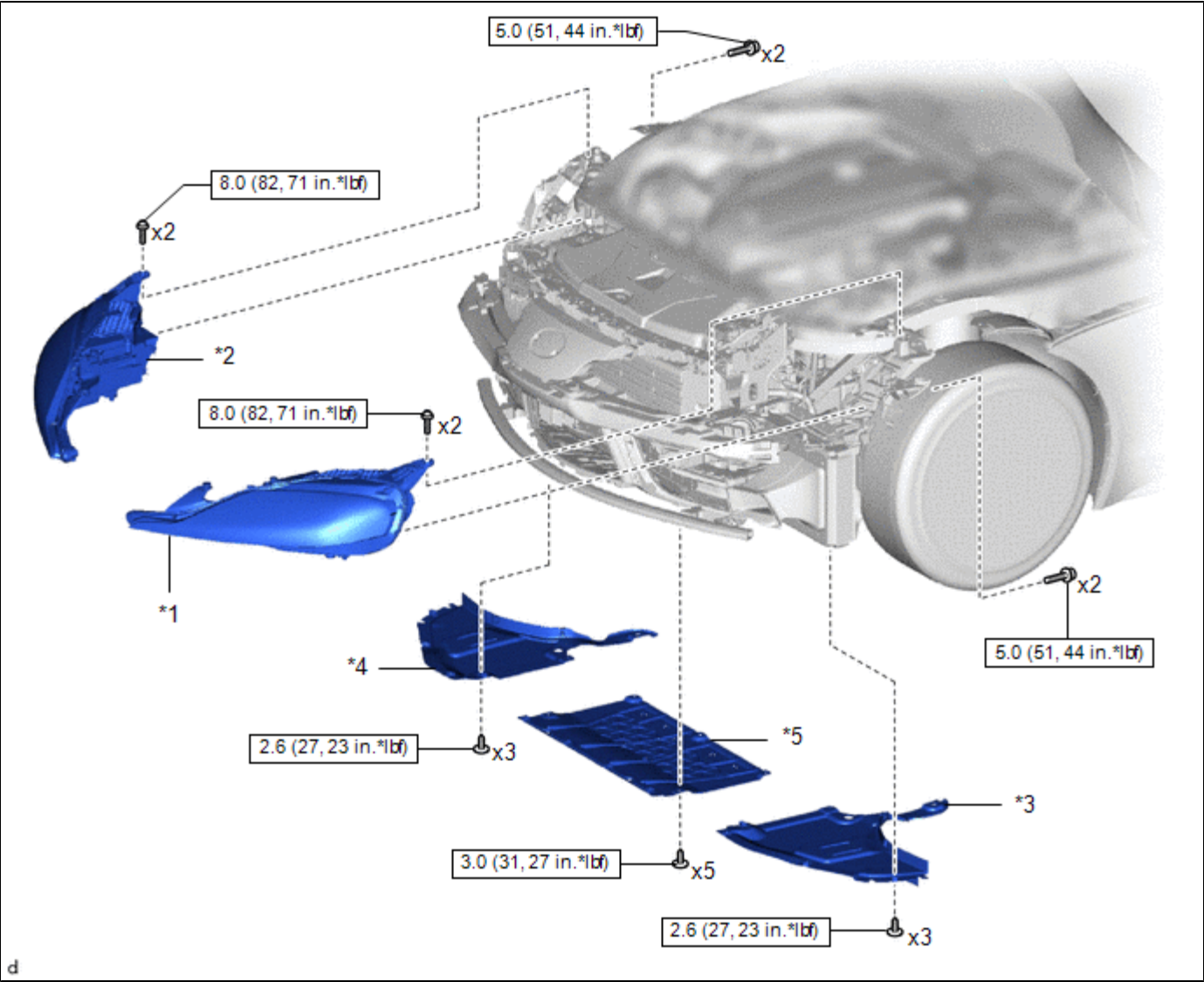
*9	LOWER NO. 1 RADIATOR GRILLE	*10	LOWER RADIATOR GRILLE LH
*11	LOWER RADIATOR GRILLE RH	*12	LOWER SIDE RADIATOR GRILLE RH
*13	MILLIMETER WAVE RADAR SENSOR	*14	REFLEX REFLECTOR ASSEMBLY LH
*15	REFLEX REFLECTOR ASSEMBLY RH	-	-
*a	Front Bumper Side Retainer for Repair	-	-
	N*m (kgf*cm, ft.*lbf): Specified torque	●	Non-reusable part

ILLUSTRATION



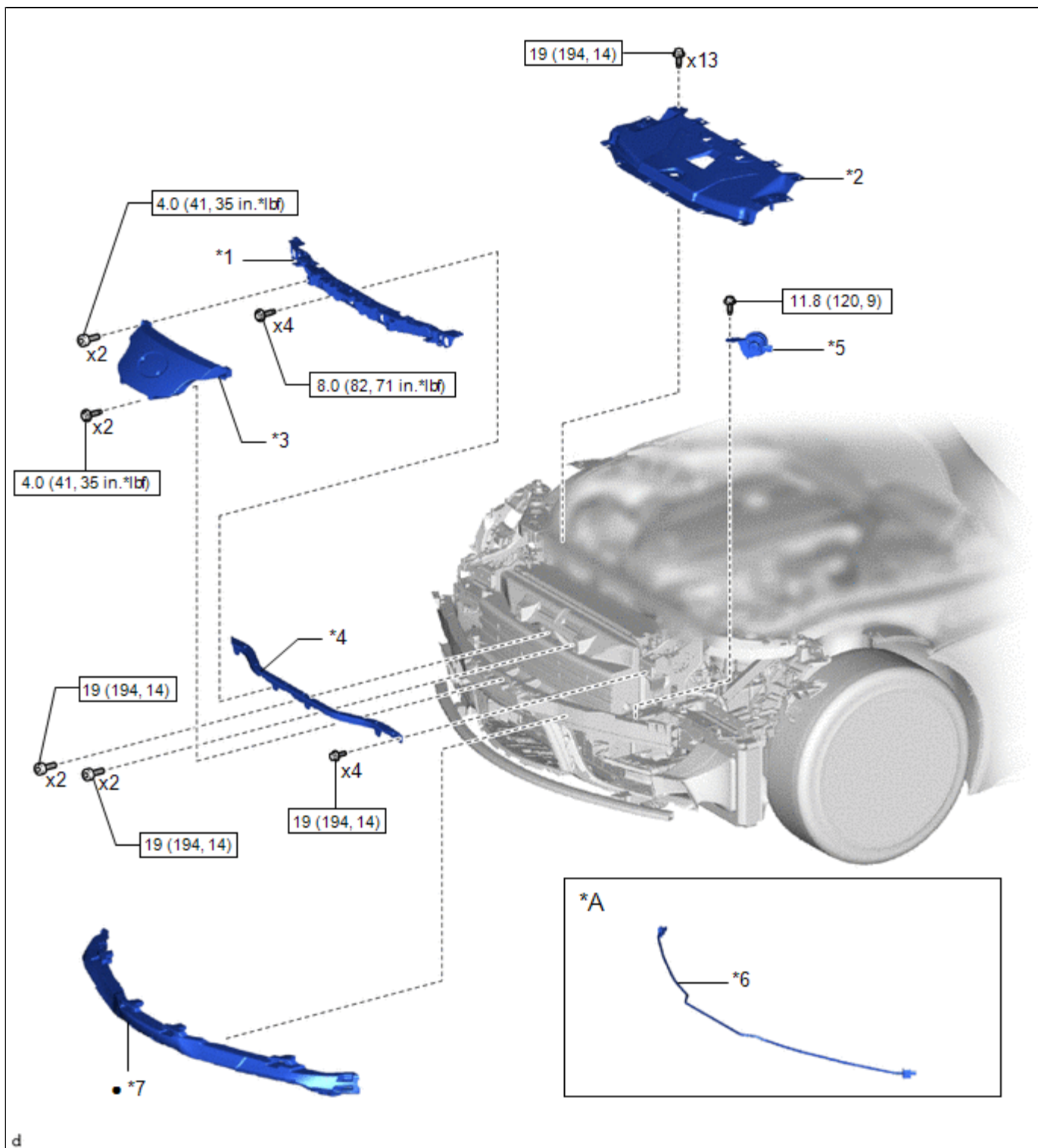
*1	NO. 1 ULTRASONIC SENSOR RETAINER	-	-
*a	The No. 1 ultrasonic sensor retainer of the front center ultrasonic sensor is welded to the front bumper assembly and cannot be removed.	-	-
●	Non-reusable part	-	-

ILLUSTRATION



*1	HEADLIGHT ASSEMBLY LH	*2	HEADLIGHT ASSEMBLY RH
*3	FRONT FENDER FRONT SPLASH SHIELD LH	*4	FRONT FENDER FRONT SPLASH SHIELD RH
*5	NO. 1 ENGINE UNDER COVER ASSEMBLY	-	-
	N*m (kgf*cm, ft.*lbf): Specified torque	-	-

ILLUSTRATION

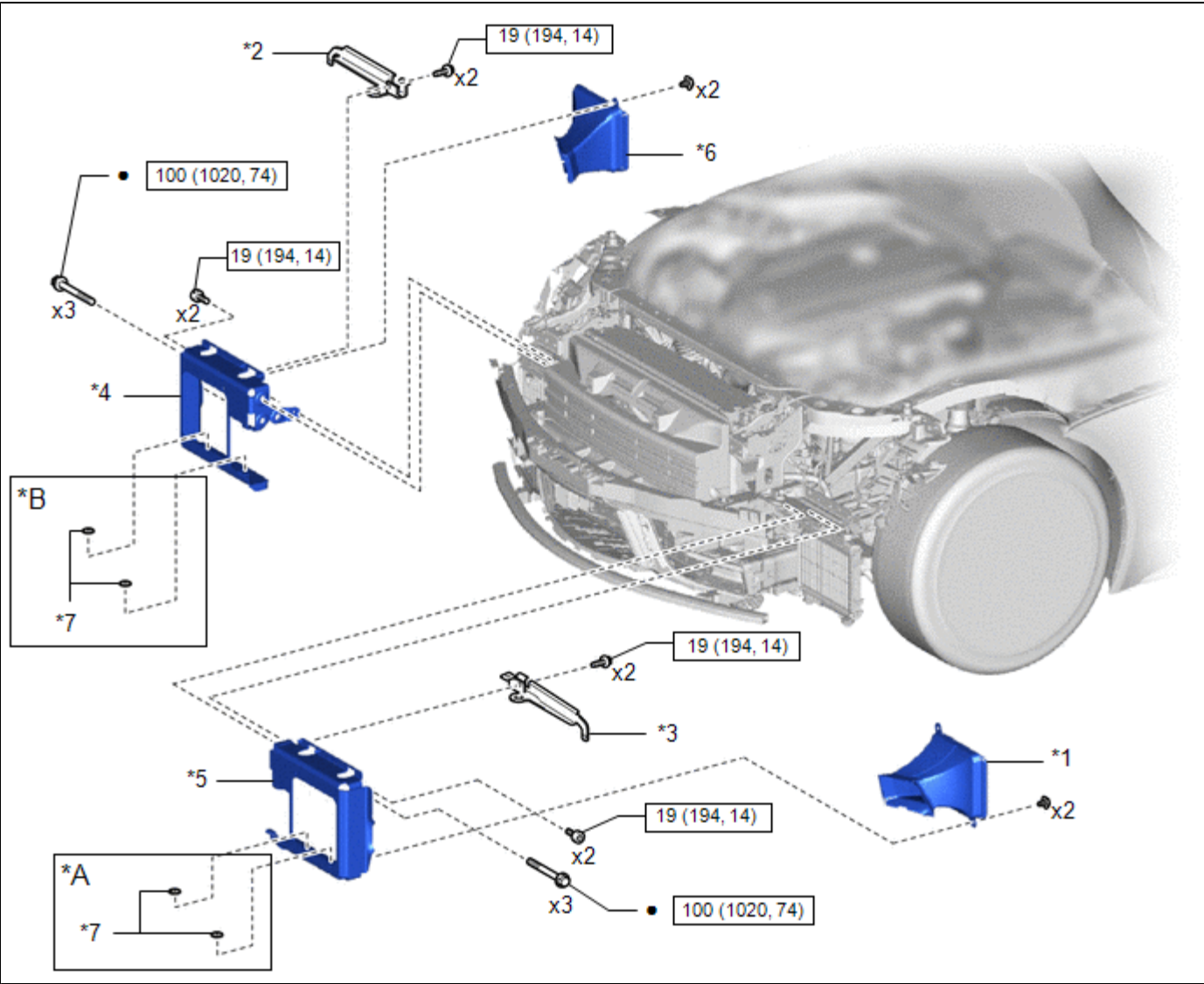


d

*A	w/ Pedestrian Detection Chamber Assembly	-	-
*1	FRONT BUMPER UPPER RETAINER	*2	RADIATOR UPPER AIR DEFLECTOR
*3	FRONT BUMPER INNER SUPPORT	*4	FRONT CROSSMEMBER
*5	HIGH PITCHED HORN ASSEMBLY	*6	PEDESTRIAN DETECTION CHAMBER ASSY
*7	FRONT BUMPER ENERGY ABSORBER	-	-
	N*m (kgf*cm, ft.*lbf): Specified torque	•	Non-reusable part

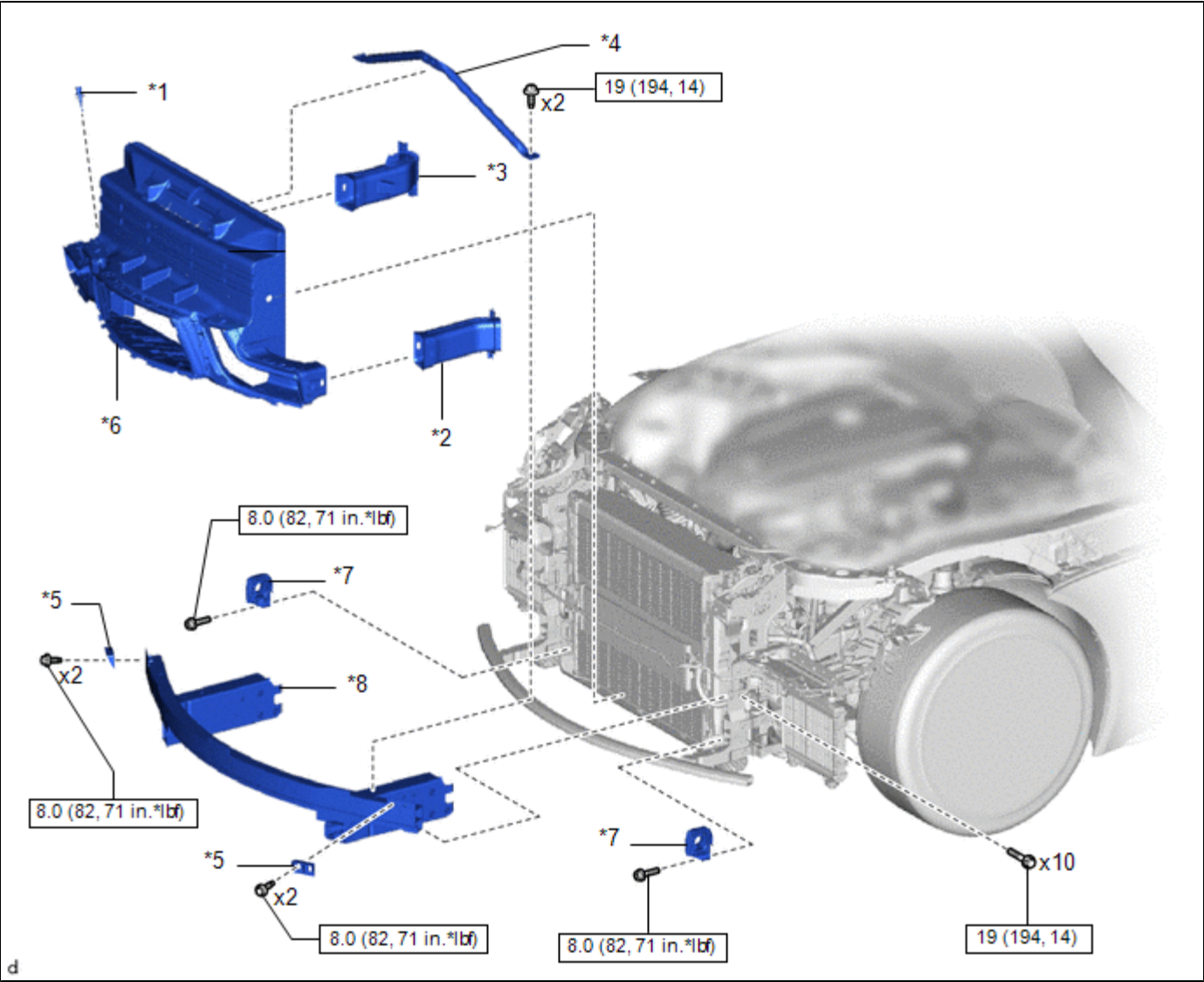
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ILLUSTRATION



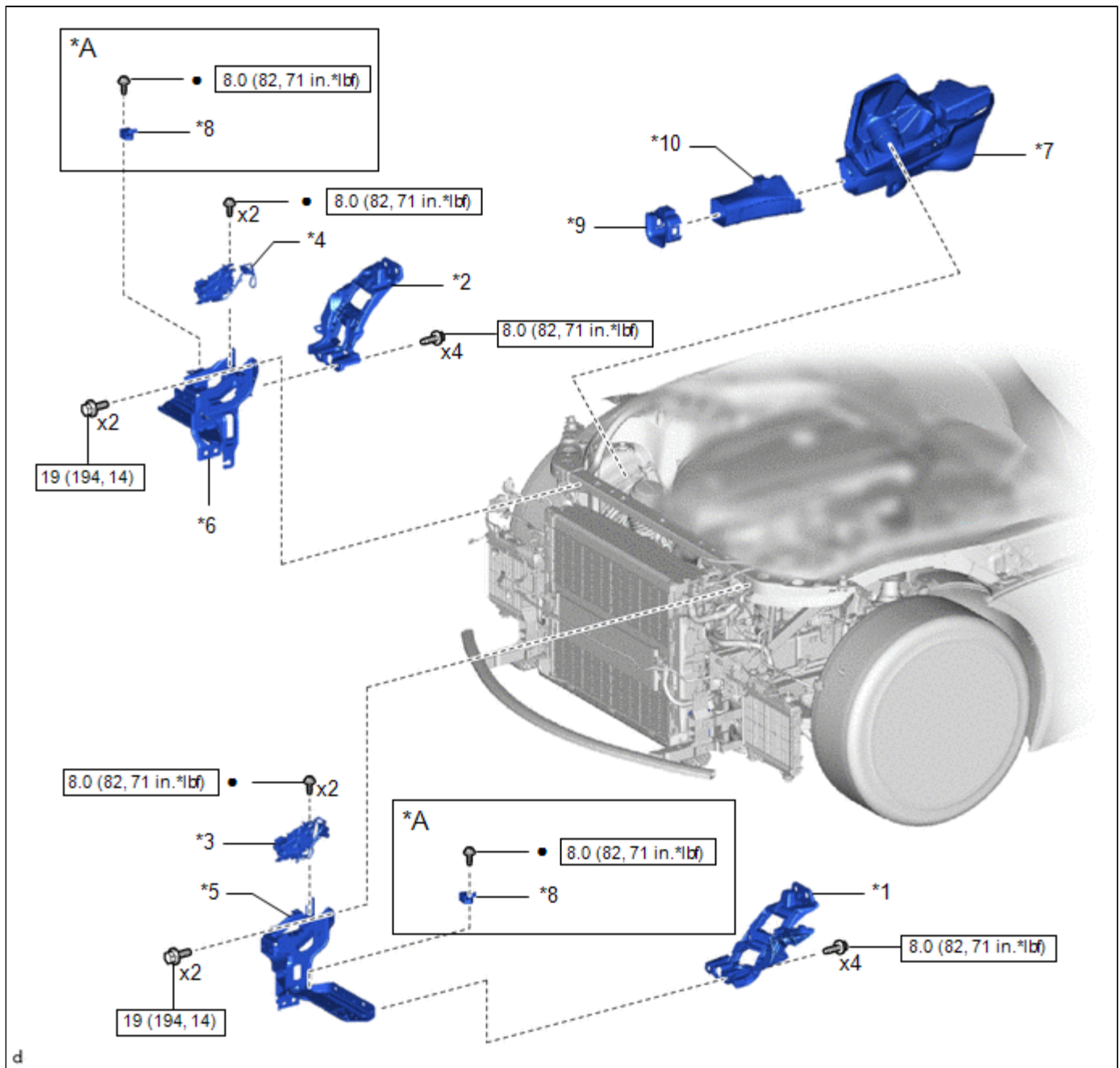
*A	for LH SIDE	*B	for RH SIDE
*1	SUB RADIATOR AIR DUCT LH	*2	FRONT BUMPER REINFORCEMENT SUPPORT RH
*3	FRONT BUMPER REINFORCEMENT SUPPORT LH	*4	FRONT BUMPER REINFORCEMENT SUB-ASSEMBLY RH
*5	FRONT BUMPER REINFORCEMENT SUB-ASSEMBLY LH	*6	SUB RADIATOR AIR DUCT RH
*7	SUB RADIATOR SUPPORT	-	-
	N*m (kgf*cm, ft.*lbf): Specified torque	•	Non-reusable part

ILLUSTRATION



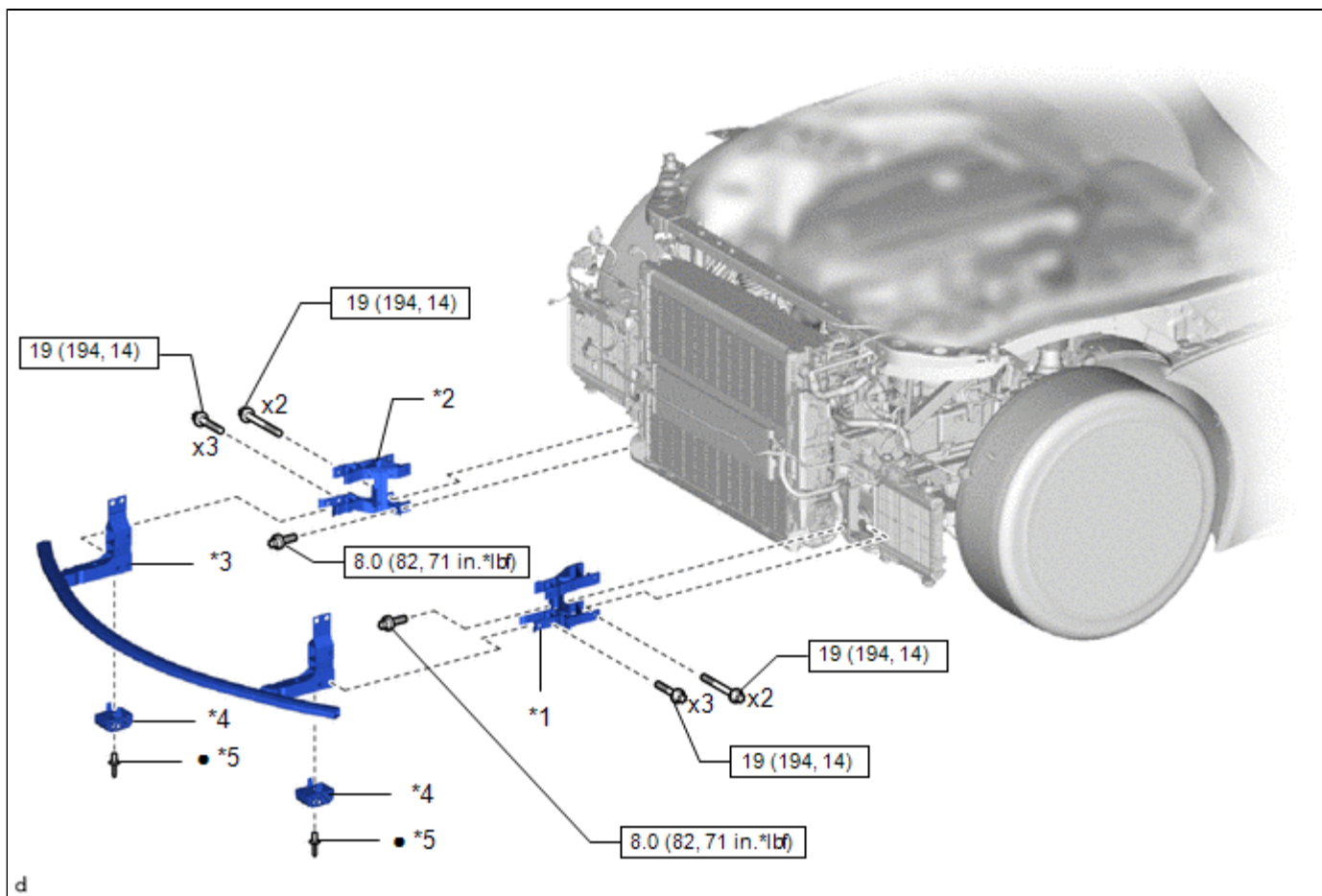
*1	TEMPERATURE SENSOR ASSEMBLY	*2	AIR INTAKE DUCT LH
*3	AIR INTAKE DUCT RH	*4	RADIATOR BRACE ROD SUB-ASSEMBLY
*5	FRONT BUMPER SIDE SUPPORT	*6	NO. 1 COOL AIR INTAKE DUCT
*7	BOTTOM COOLER MODULE MOUNT	*8	FRONT BUMPER REINFORCEMENT
	N*m (kgf*cm, ft.*lbf): Specified torque	-	-

ILLUSTRATION



*A	w/ Airbag Sensor	-	-
*1	FRONT BUMPER RETAINER LH	*2	FRONT BUMPER RETAINER RH
*3	ENGINE HOOD COURTESY SWITCH (HOOD LOCK ASSEMBLY)	*4	HOOD LOCK ASSEMBLY
*5	RADIATOR SUPPORT LH	*6	RADIATOR SUPPORT RH
*7	AIR CLEANER ASSEMBLY	*8	AIRBAG SENSOR
*9	NO. 1 AIR INLET DUCT	*10	INLET NO. 2 AIR DUCT
	N*m (kgf*cm, ft.*lbf): Specified torque	•	Non-reusable part

ILLUSTRATION



*1	FRONT BUMPER LOWER SIDE SUPPORT LH	*2	FRONT BUMPER LOWER SIDE SUPPORT RH
*3	LOWER FRONT BUMPER REINFORCEMENT	*4	IMPACT ABSORBER
*5	RIVET	-	-
	N*m (kgf*cm, ft.*lbf): Specified torque	•	Non-reusable part

Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCMK
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: FRONT BUMPER: REMOVAL; 2020 MY Supra [03/2019 -]		

REMOVAL

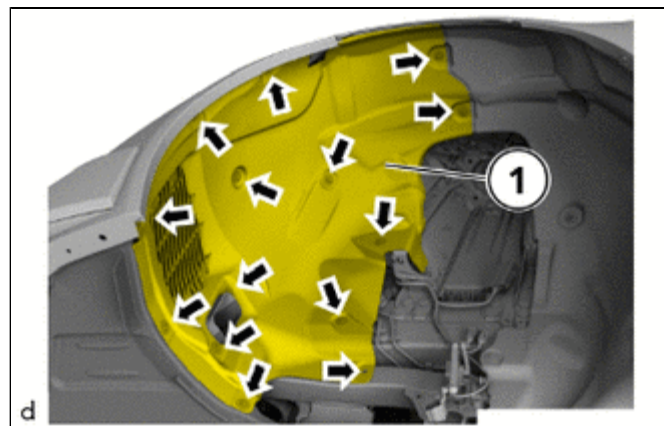
PROCEDURE

1. DISCONNECT CABLE FROM NEGATIVE BATTERY TERMINAL

Click here [INFO](#)

2. REMOVE FRONT FENDER LINER LH

(a) Remove the screws (arrows) and front fender liner LH (1).



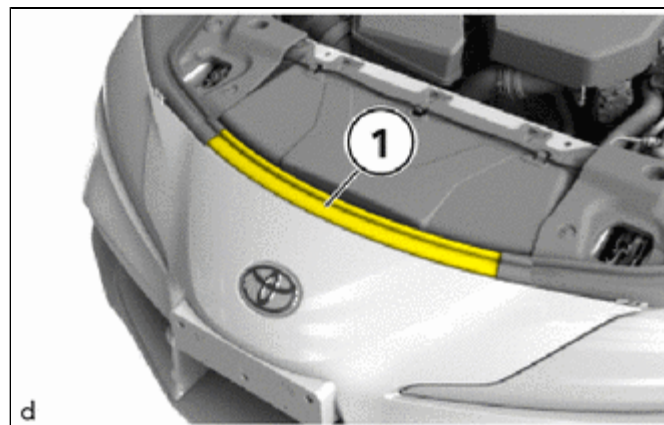
3. REMOVE FRONT FENDER LINER RH

HINT:

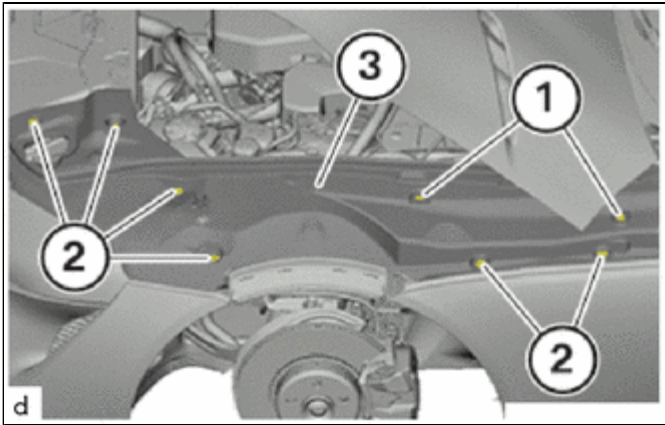
Use the same procedure as for the LH side.

4. REMOVE HOOD TO RADIATOR SUPPORT SEAL

(a) Remove the hood to radiator support seal (1).



5. REMOVE FRONT FENDER UPPER PROTECTOR LH



(a) Remove the clips (1) and clips (2).

(b) Remove the front fender upper protector LH (3).

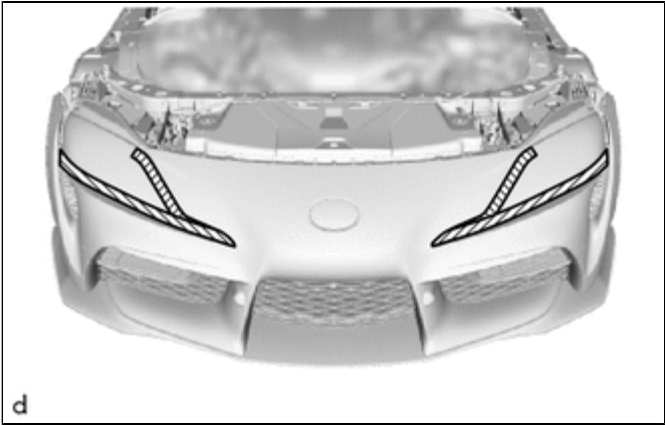
6. REMOVE FRONT FENDER UPPER PROTECTOR RH

HINT:

Use the same procedure as for the LH side.

7. REMOVE FRONT BUMPER ASSEMBLY

(a) Apply protective tape as shown in the illustration.

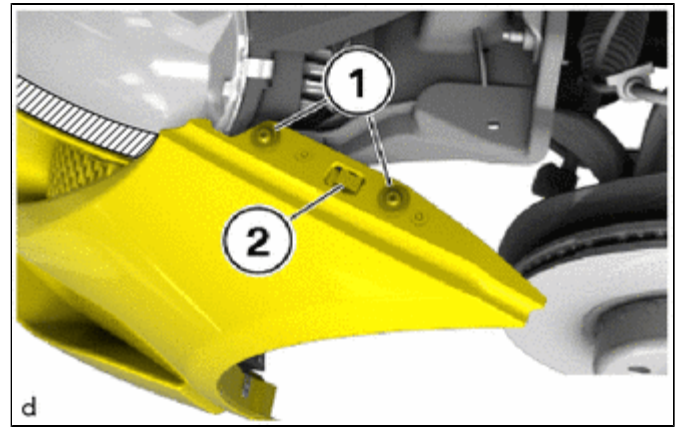


	Protective Tape
--	-----------------

(b) Remove the T20 screws (1).

HINT:

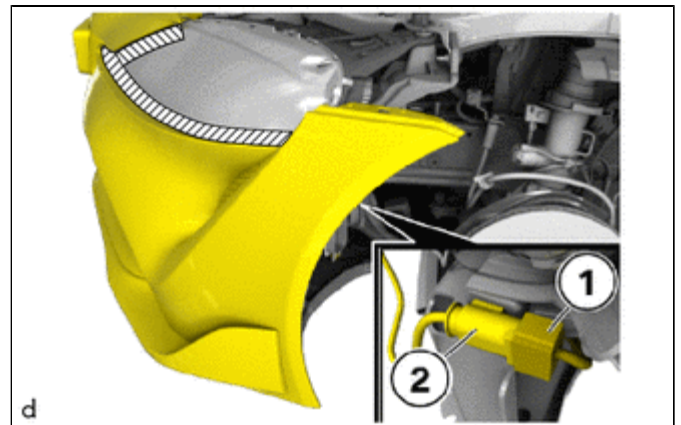
Perform the operations on the left and right side.



(c) Disengage front bumper assembly from the clamp (2).

HINT:

Perform the operations on the left and right side.



(d) Disconnect the connector (1).

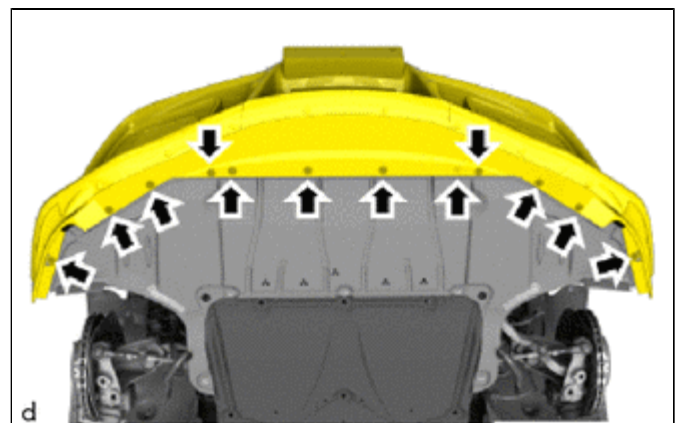
HINT:

Perform the operations on the left and right side.

(e) Disengage the clamp (2).

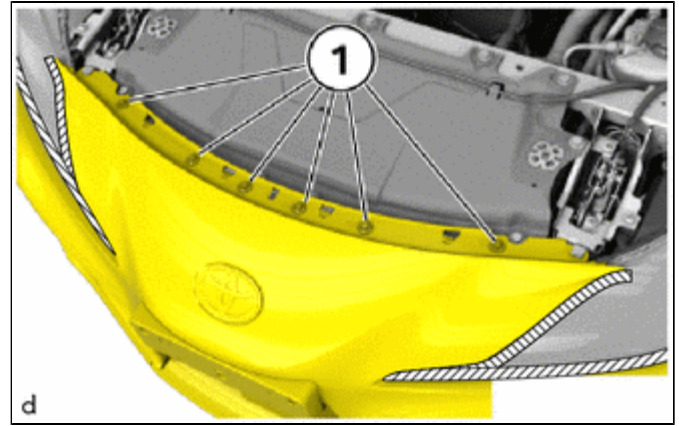
HINT:

Perform the operations on the left and right side.

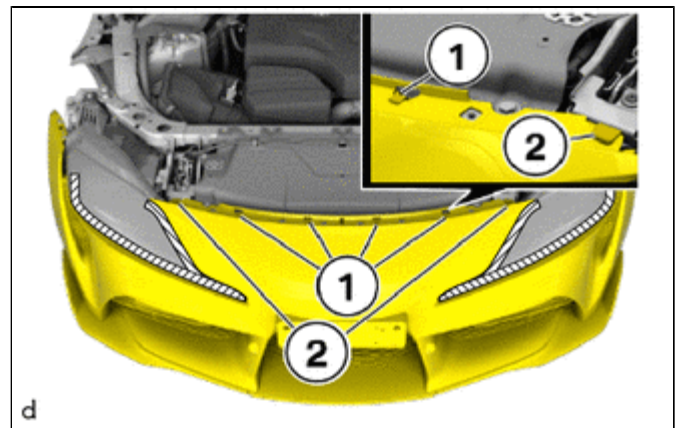


(f) Remove the screws (arrows) on the front bumper assembly.

(g) Remove the bolts (1).



(h) Disengage the clamps (1).



(i) Disengage the guides (2) to remove the front bumper assembly.



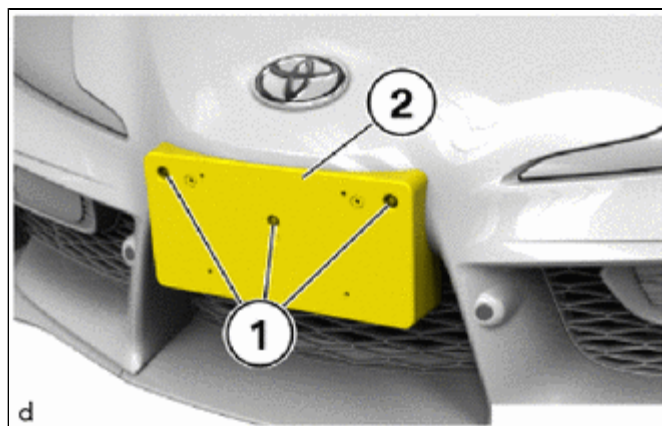
Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCML
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: FRONT BUMPER: DISASSEMBLY; 2020 MY Supra [03/2019 -]		

DISASSEMBLY

PROCEDURE

1. REMOVE FRONT BUMPER EXTENSION MOUNTING BRACKET

- (a) Remove the screws (1) and front bumper extension mounting bracket (2).



2. REMOVE FRONT BUMPER EMBLEM SUB-ASSEMBLY

Click here [INFO](#)

3. REMOVE FRONT CORNER ULTRASONIC SENSOR

Click here [INFO](#)

4. REMOVE FRONT CENTER ULTRASONIC SENSOR

HINT:

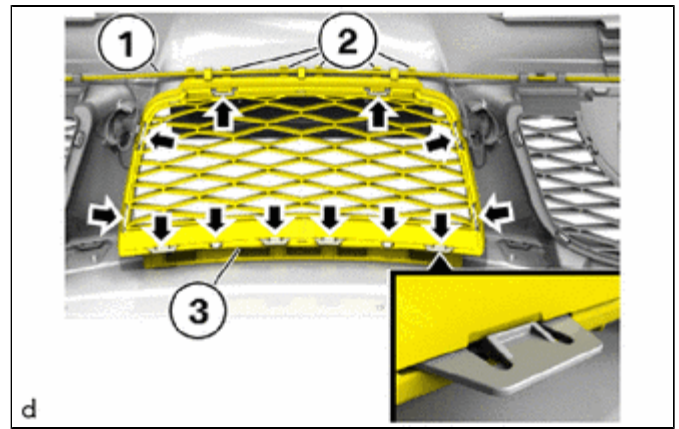
Use the same procedure as for the front corner ultrasonic sensor.

5. REMOVE FRONT SIDE ULTRASONIC SENSOR

Click here [INFO](#)

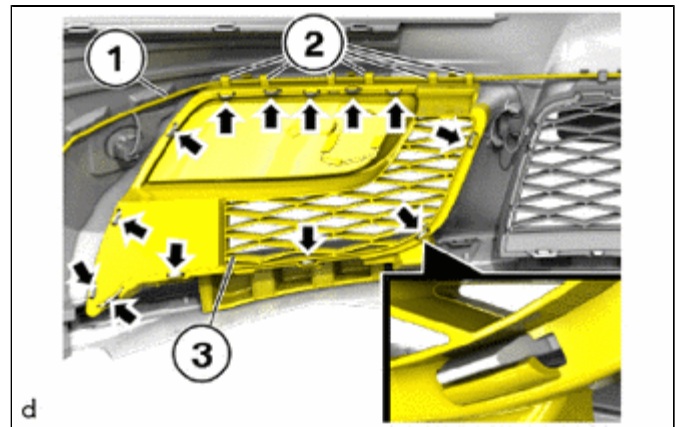
6. REMOVE LOWER NO. 1 RADIATOR GRILLE

- (a) Disconnect the No. 4 engine room wire (1) from the guides (2) on the lower No. 1 radiator grille (3).



(b) Disengage the claws to remove the lower No. 1 radiator grille (3).

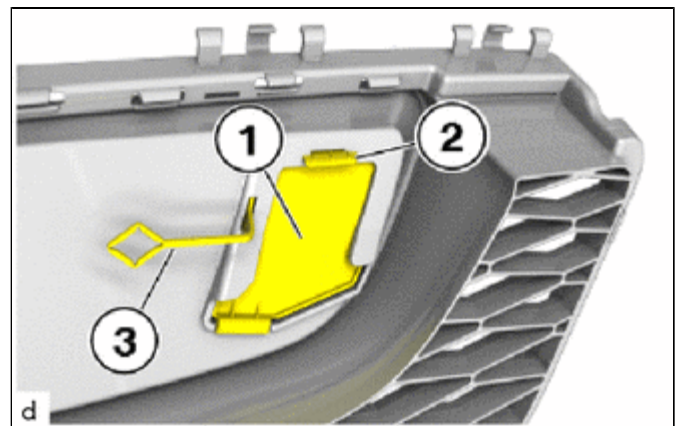
7. REMOVE LOWER RADIATOR GRILLE LH



(a) Disconnect the No. 4 engine room wire (1) from the guides (2) on the lower radiator grille LH (3).

(b) Disengage the claws to remove the lower radiator grille LH (3).

8. REMOVE FRONT BUMPER HOLE COVER



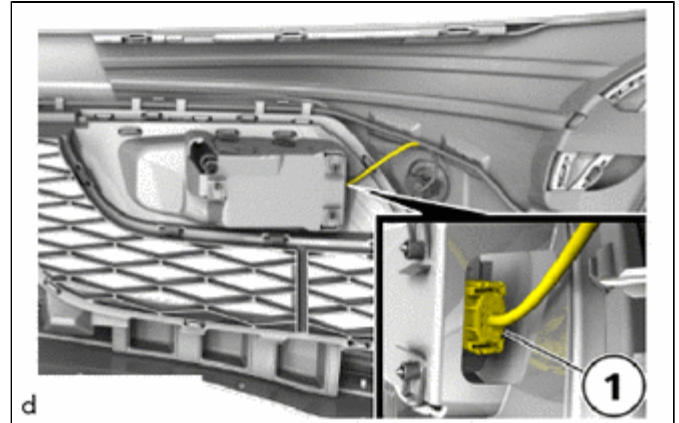
(a) Disengage the claw (2).

(b) Disengage the hook (3) to remove the front bumper hole cover (1).

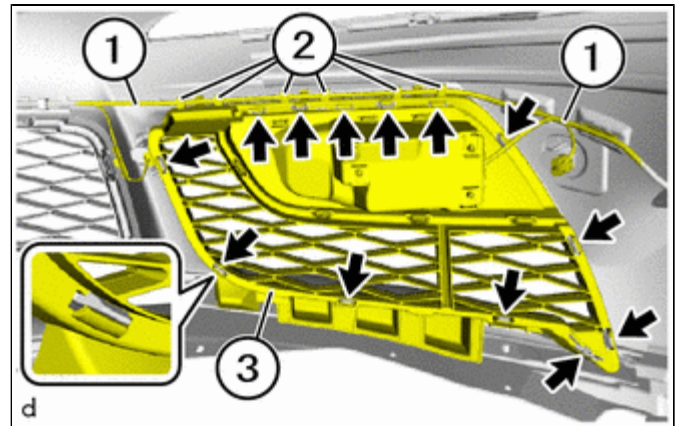
9. REMOVE LOWER RADIATOR GRILLE RH

(a) w/ Toyota Supra Safety:

(1) Disconnect the connector (1).



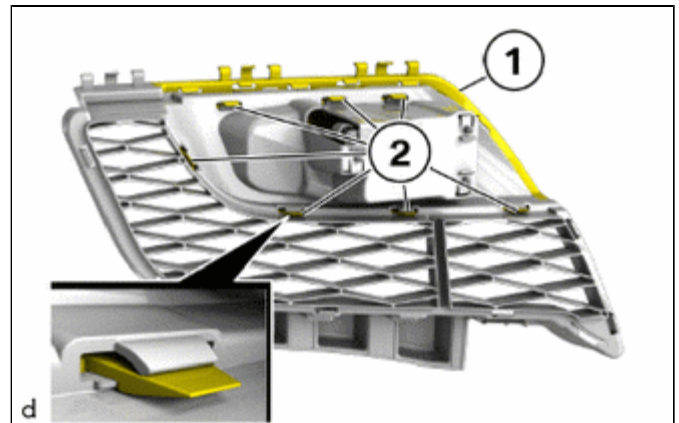
(b) Disconnect No. 4 engine room wire (1) from the guides (2) on the lower radiator grille RH (3).



(c) Disengage the claws to remove the lower radiator grille RH (3).

10. REMOVE LOWER SIDE RADIATOR GRILLE RH

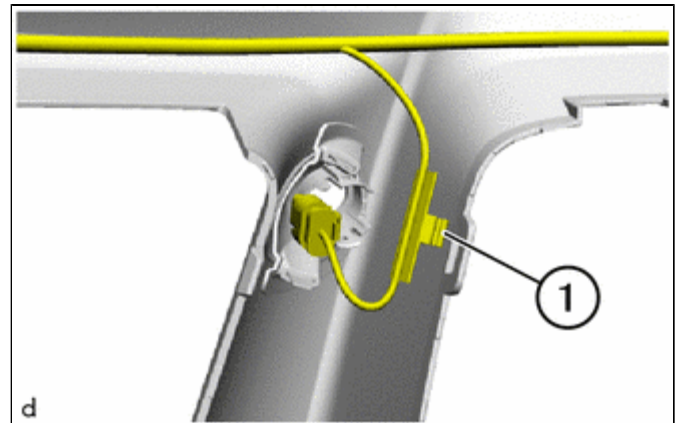
(a) Disengage the claws (2) to remove the lower side radiator grille RH (1).



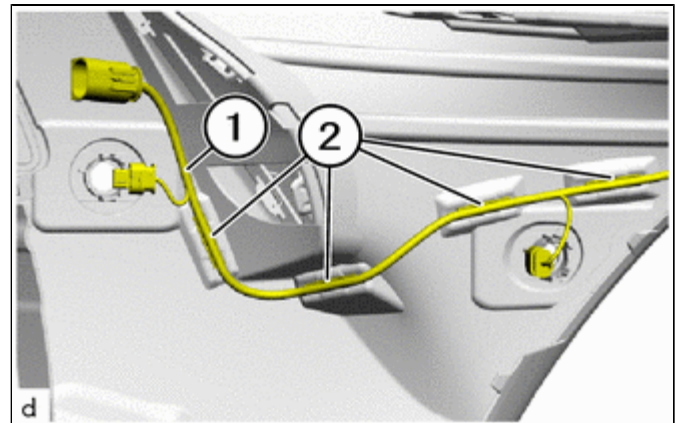
11. REMOVE MILLIMETER WAVE RADAR SENSOR (w / Toyota Supra Safety)

12. REMOVE FRONT BUMPER SIDE RETAINER LH

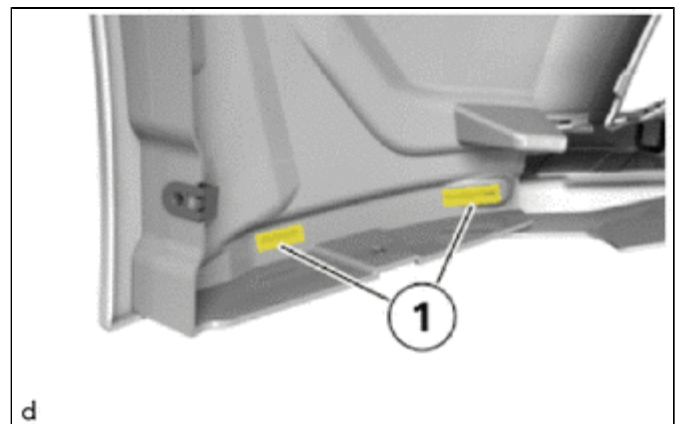
(a) Disengage the clamp (1).



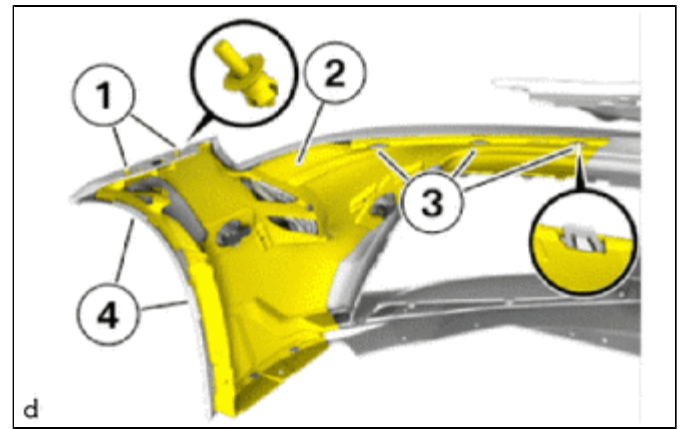
(b) Disengage the clamps (2) to disconnect the No. 4 engine room wire (1).



(c) Disengage the welded connections (1).



(d) Remove the clips (1).



(e) Disengage the claws (3).

(f) Feed out and remove the front bumper side retainer LH (2) towards the inside on the guides (4).

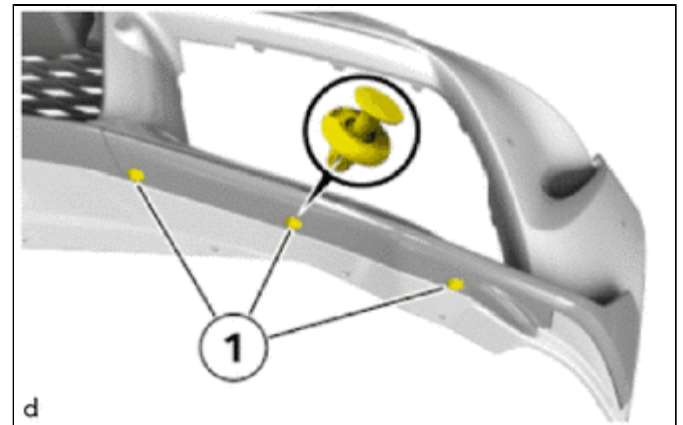
13. REMOVE FRONT BUMPER SIDE RETAINER RH

HINT:

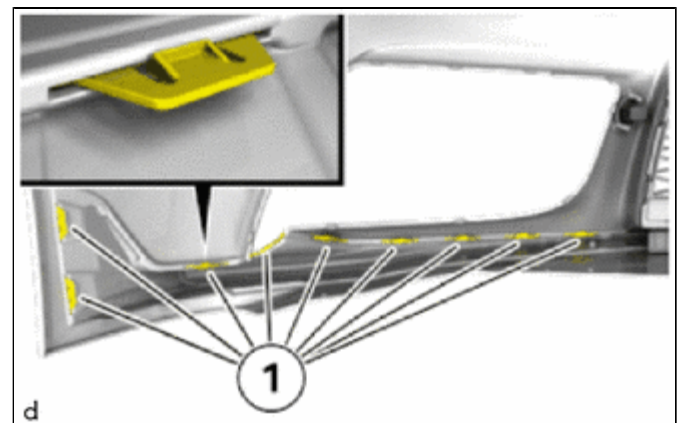
Use the same procedure as for the LH side.

14. REMOVE FRONT SIDE SPOILER LH

(a) Remove the clips.



(b) Disengage the claws (1) to remove the front side spoiler LH.



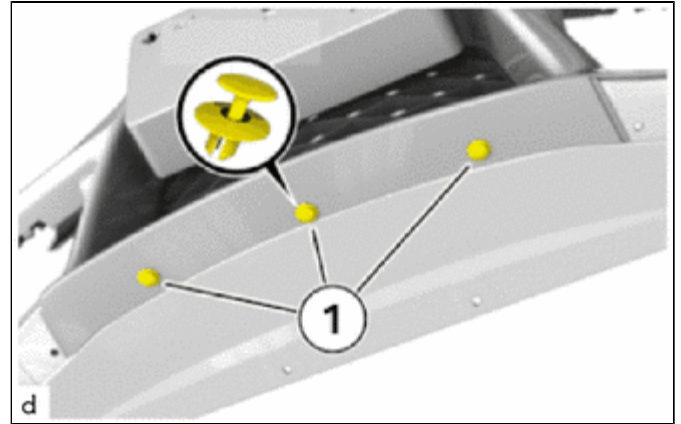
15. REMOVE FRONT SIDE SPOILER RH

HINT:

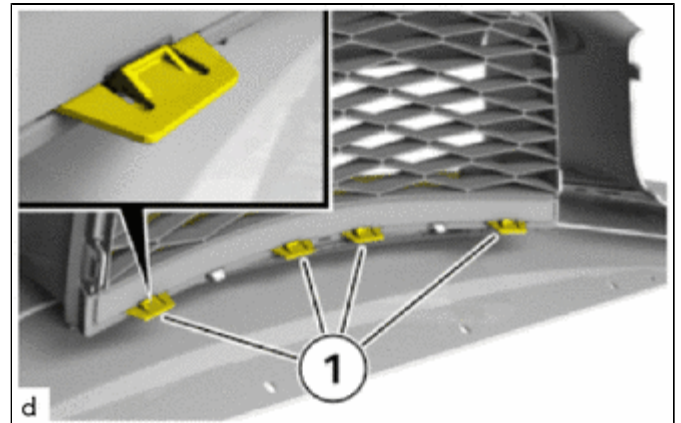
Use the same procedure as for the LH side.

16. REMOVE FRONT SPOILER SUB-ASSEMBLY

(a) Remove the clips (1).

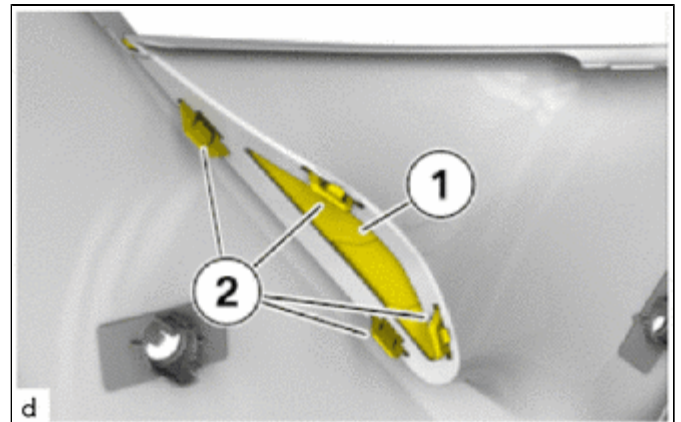


(b) Disengage the claws (1) to remove the front spoiler sub-assembly.



17. REMOVE COOL AIR INTAKE GRILLE LH

(a) Disengage the claws (2) to remove the cool air intake grille LH (1).



18. REMOVE COOL AIR INTAKE GRILLE RH

HINT:

Use the same procedure as for the LH side.

19. REMOVE REFLEX REFLECTOR ASSEMBLY LH

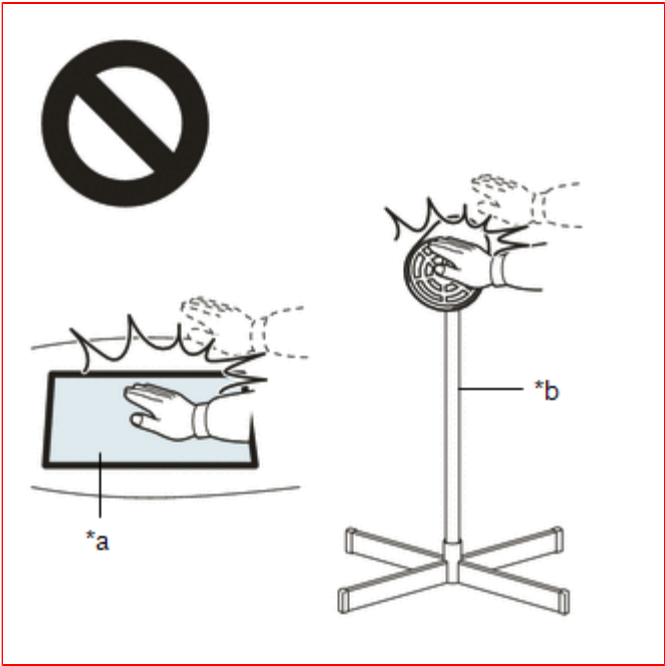
HINT:

When removing the reflex reflector assembly LH, heat the reflex reflector assembly LH using a heat light.

Standard:

ITEM	TEMPERATURE
Reflex Reflector Assembly LH	40 to 50 °C (104 to 122 °F)

CAUTION:



- Touching heated parts for a long time may result in burns.

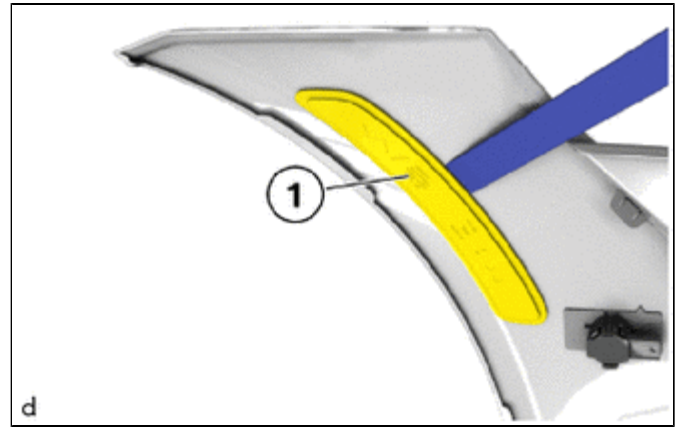
*a	Heated Part
*b	Heat Light

- Do not touch the heat light and heated parts, touching the heat light may result in burns.

NOTICE:

Do not heat the reflex reflector assembly LH excessively.

(a) Using a moulding remover A, remove the reflex reflector assembly LH (1).



20. REMOVE REFLEX REFLECTOR ASSEMBLY RH

HINT:

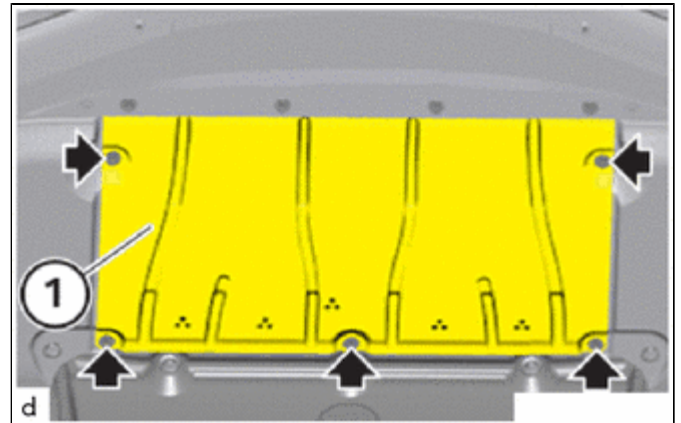
Use the same procedure as for the LH side.

21. REMOVE NO. 1 ULTRASONIC SENSOR RETAINER

Click here [INFO](#)

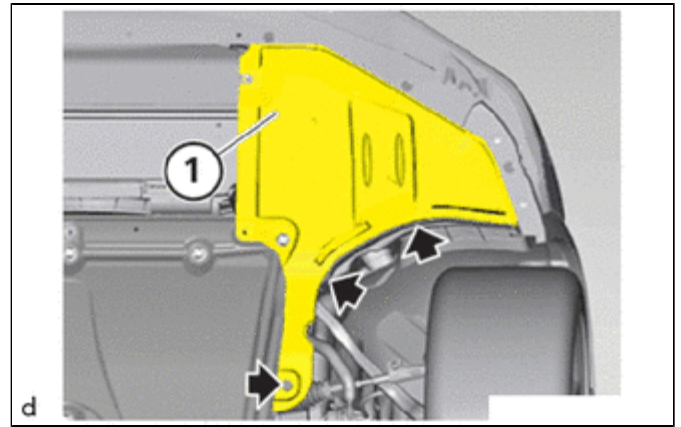
22. REMOVE NO. 1 ENGINE UNDER COVER ASSEMBLY

- (a) Remove the screws (arrows) and No. 1 engine under cover assembly (1).



23. REMOVE FRONT FENDER FRONT SPLASH SHIELD LH

- (a) Remove the screws (arrows) and front fender front splash shield LH (1).



24. REMOVE FRONT FENDER FRONT SPLASH SHIELD RH

HINT:

Use the same procedure as for the LH side.

25. REMOVE HEADLIGHT ASSEMBLY LH

Click here [INFO](#)

26. REMOVE HEADLIGHT ASSEMBLY RH

HINT:

Use the same procedure as for the LH side.

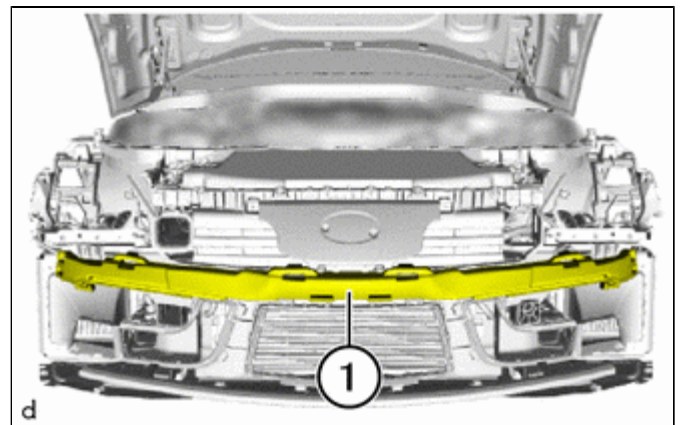
27. REMOVE HIGH PITCHED HORN ASSEMBLY

Click here [INFO](#)

28. REMOVE FRONT BUMPER ENERGY ABSORBER

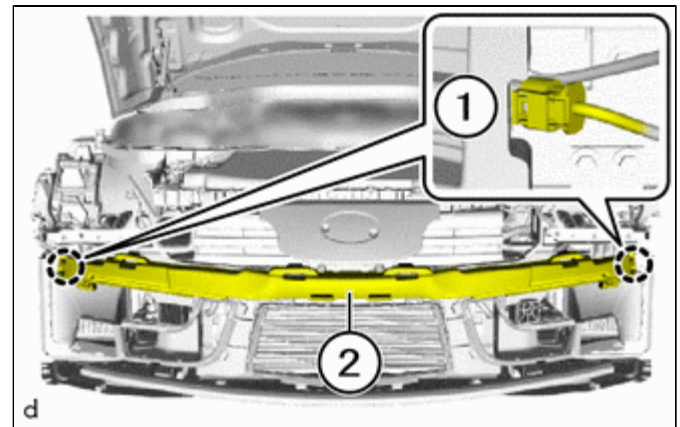
(a) w/o Pedestrian detection chamber assembly:

(1) Remove the front bumper energy absorber (1).



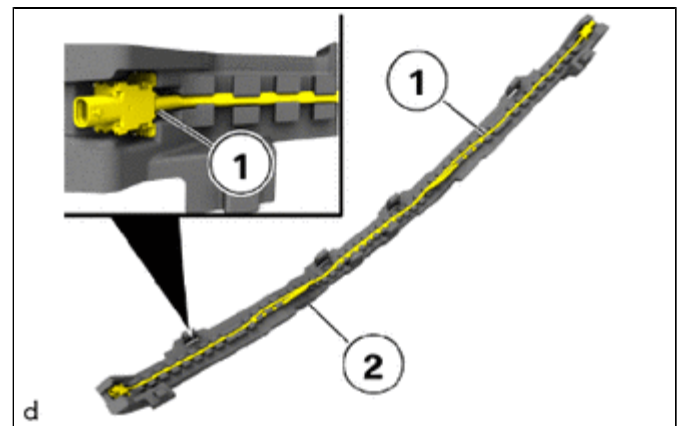
(b) w/ Pedestrian detection chamber assembly:

(1) Disconnect the connectors (1).



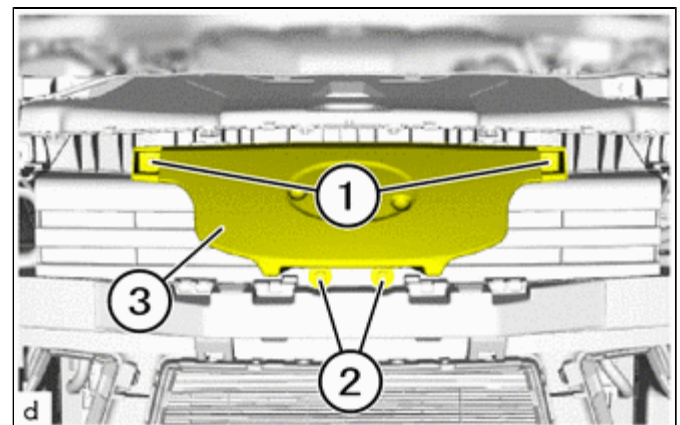
(2) Remove the front bumper energy absorber with pedestrian detection chamber assembly (2).

(3) Remove the pedestrian detection chamber assembly (1) from front bumper energy absorber (2).



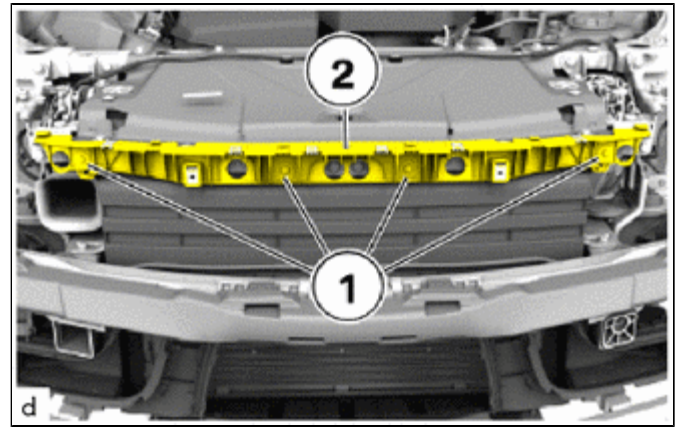
29. REMOVE FRONT BUMPER INNER SUPPORT

(a) Remove the T30 bolts (1), bolts (2) and front bumper inner support (3).



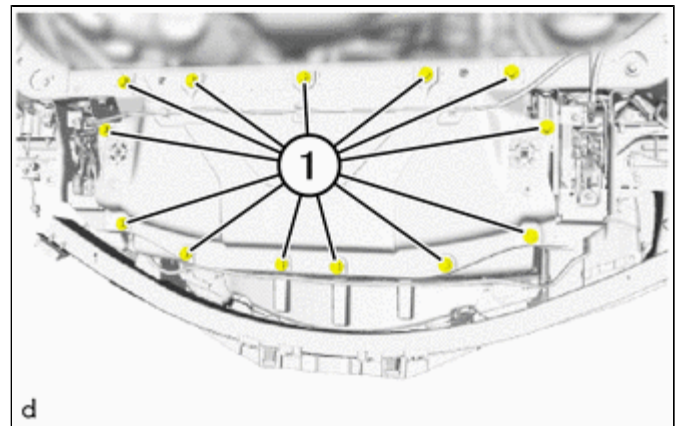
30. REMOVE FRONT BUMPER UPPER RETAINER

(a) Remove the bolts (1) and front bumper upper retainer (2).

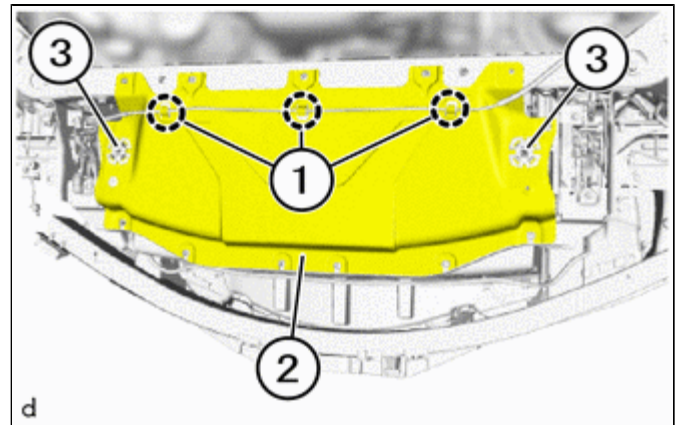


31. REMOVE RADIATOR UPPER AIR DEFLECTOR

(a) Remove the bolts (1).



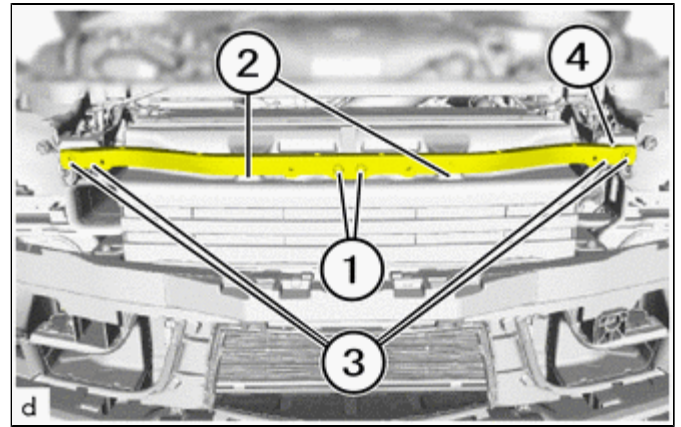
(b) Disconnect the hood lock control cable assembly from the guides(1).



(c) Disengage guides (3) to remove the radiator upper air deflector (2).

32. REMOVE FRONT CROSSMEMBER

(a) Remove the T50 bolts (1) and T30 bolts (2).



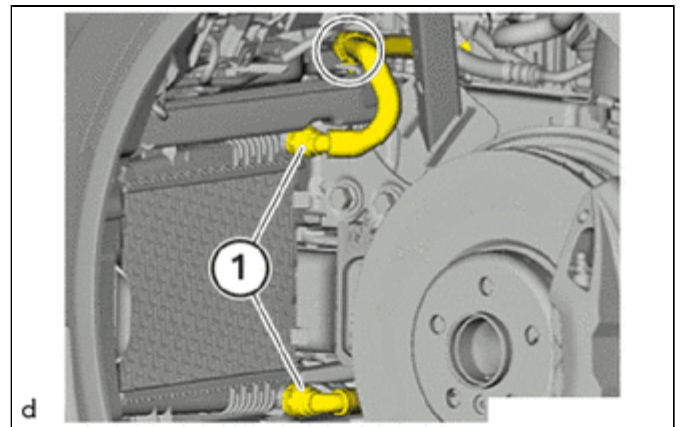
(b) Remove the bolts (3) and front crossmember (4).

33. REMOVE SUB RADIATOR SUPPORT (for LH Side)

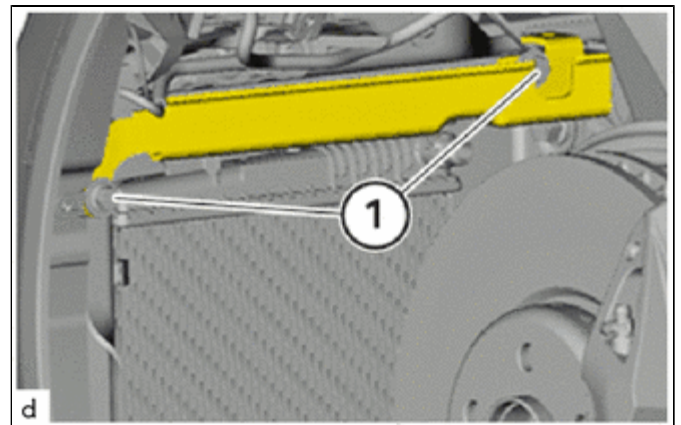
(a) Disengage the clip in the marked area.

NOTICE:

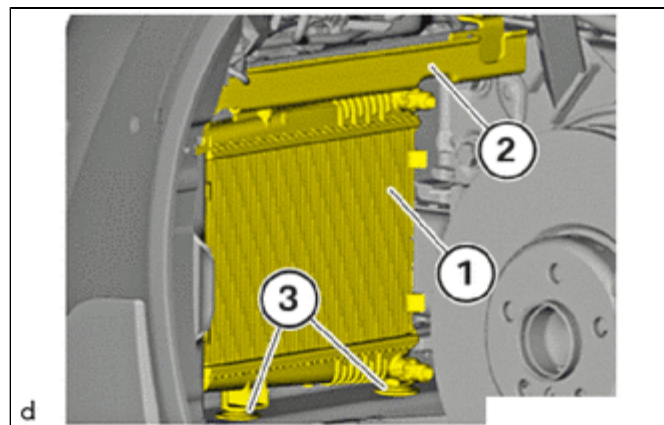
Do not disengage the No.3 radiator hose (1) and radiator hose sub-assembly (1).



(b) Remove the T45 bolts (1).



(c) Remove the front bumper reinforcement support LH (2) to separate the sub radiator (1).

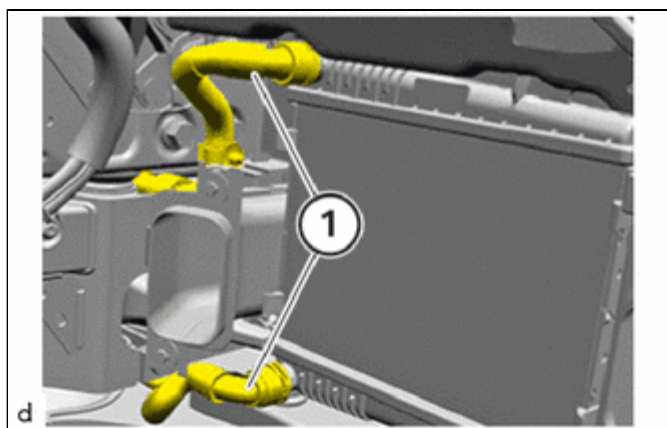


(d) Carefully remove the sub radiator support (3) from the body.

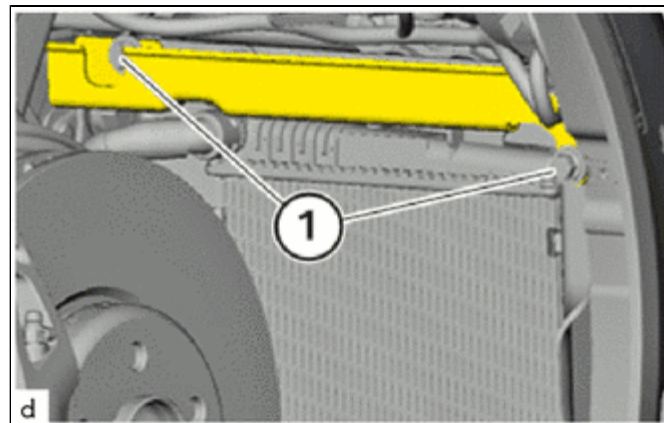
34. REMOVE SUB RADIATOR SUPPORT (for RH Side)

NOTICE:

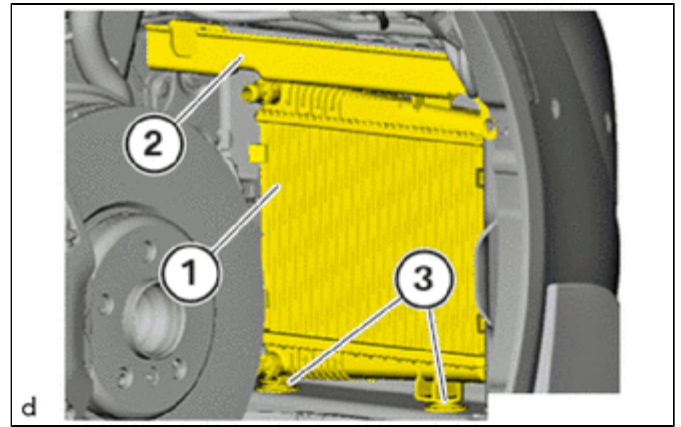
Do not disengage the No.1 radiator hose (1) and radiator hose sub-assembly (1).



(a) Remove the T45 bolts (1).



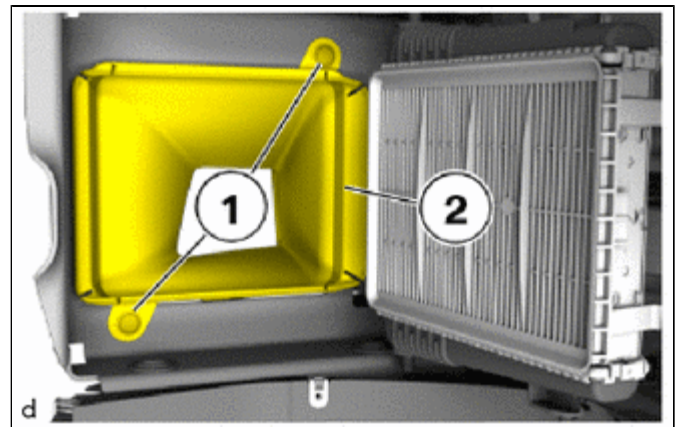
(b) Remove the front bumper reinforcement support RH (2) to separate the sub radiator (1).



(c) Carefully remove the sub radiator support (3) from the body.

35. REMOVE SUB RADIATOR AIR DUCT LH

(a) Remove the clips (1) and sub radiator air duct LH (2).



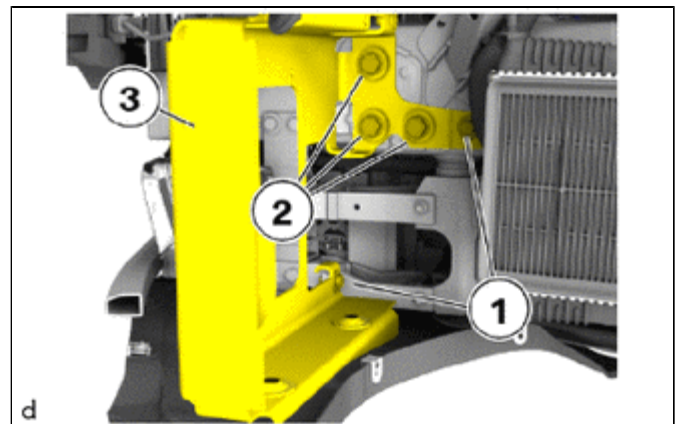
36. REMOVE SUB RADIATOR AIR DUCT RH

HINT:

Use the same procedure as for the LH side.

37. REMOVE FRONT BUMPER REINFORCEMENT SUB-ASSEMBLY LH

(a) Remove the T45 bolts (1).



- (b) Using a deep socket wrench 18 mm, remove the 18 mm bolts (2) and front bumper reinforcement sub-assembly LH (3).

38. REMOVE FRONT BUMPER REINFORCEMENT SUB-ASSEMBLY RH

HINT:

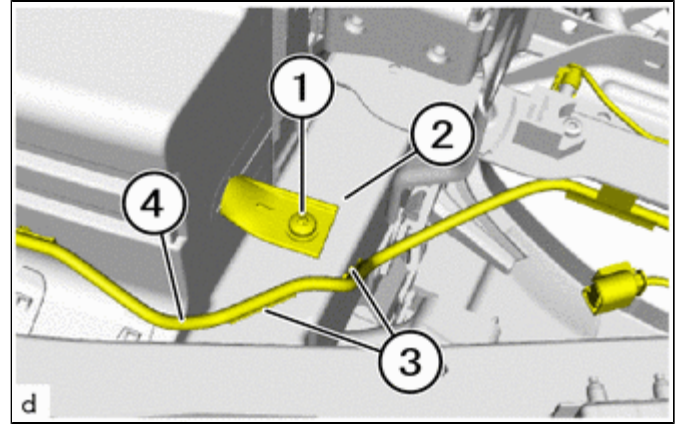
Use the same procedure as for the LH side.

39. REMOVE FRONT BUMPER REINFORCEMENT

- (a) Remove the T30 bolt (1) to disengage the radiator brace rod sub-assembly (2).

HINT:

Perform the operations on the left and right side.

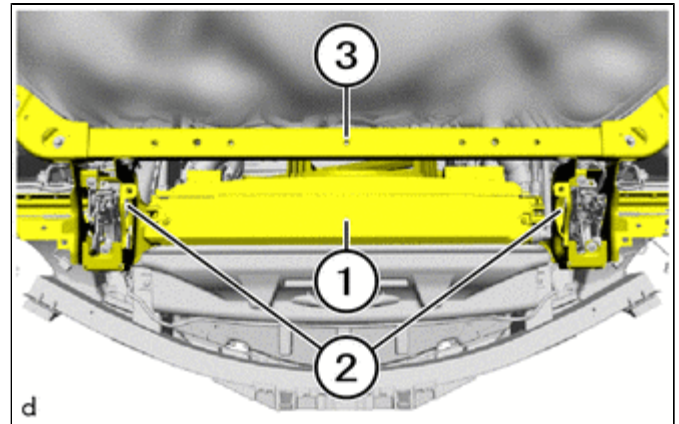


- (b) Disengage the clamps (3) to disconnect the No. 4 engine room wire (4).

HINT:

Perform the operations on the left and right side.

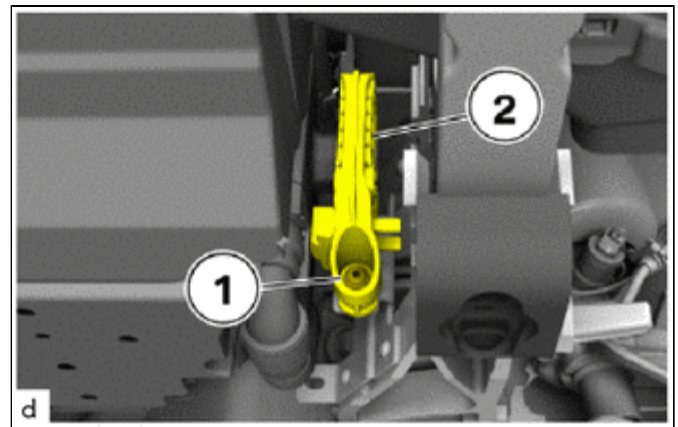
- (c) Secure radiator assembly (1) on the radiator support (2) and the upper radiator support sub-assembly (3) with suitable auxiliary materials.



- (d) Remove the T30 bolt (1) and bottom cooler module mount (2).

HINT:

Perform the operations on the left and right side.

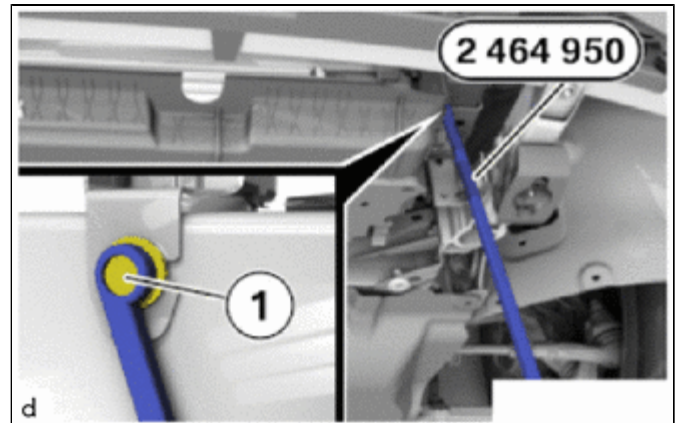


(e) Loosen bolt (1) with the special tool 2 464 950 a few revolutions.

SST: 09800-WA310

HINT:

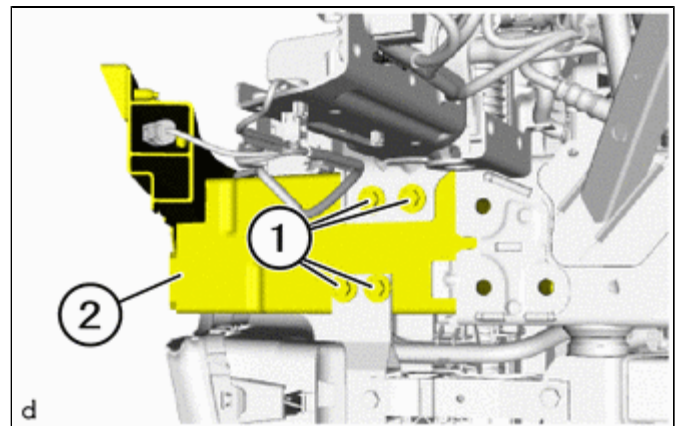
- Guide through the special tool from below, between the radiator assembly (1) and the support for the front bumper.
- Perform the operations on the left and right side.



(f) Remove the bolts (1).

HINT:

Perform the operations on the left and right side.



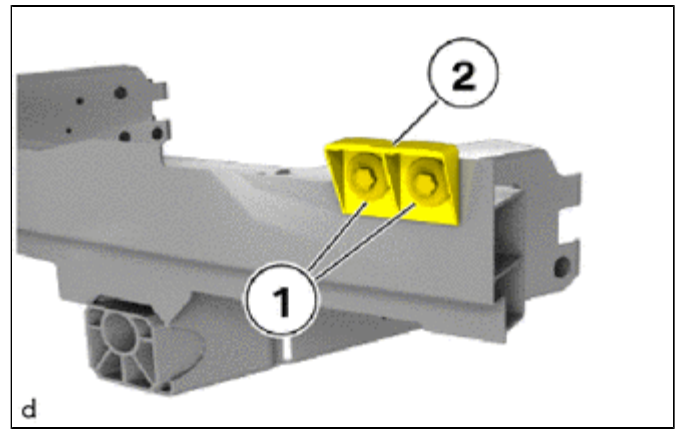
(g) Remove the front bumper reinforcement (2) toward the front.

40. REMOVE FRONT BUMPER SIDE SUPPORT

HINT:

Description is for left component only. Procedure on the right side is identical.

- (a) Remove the T30 bolts (1) and front bumper side support (2).



41. REMOVE AIR INTAKE DUCT LH

Click here [INFO](#)

42. REMOVE AIR INTAKE DUCT RH

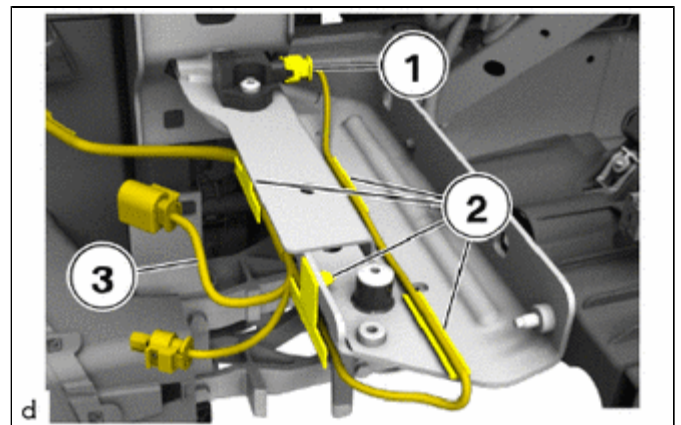
Click here [INFO](#)

43. REMOVE TEMPERATURE SENSOR ASSEMBLY

Click here [INFO](#)

44. REMOVE NO. 1 COOL AIR INTAKE DUCT

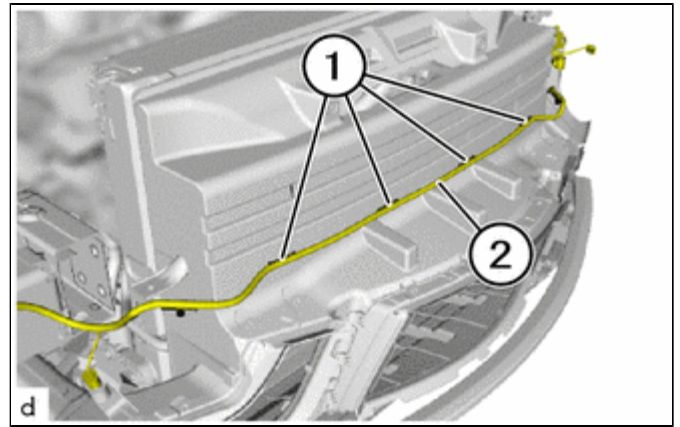
- (a) w/ Airbag Sensor:



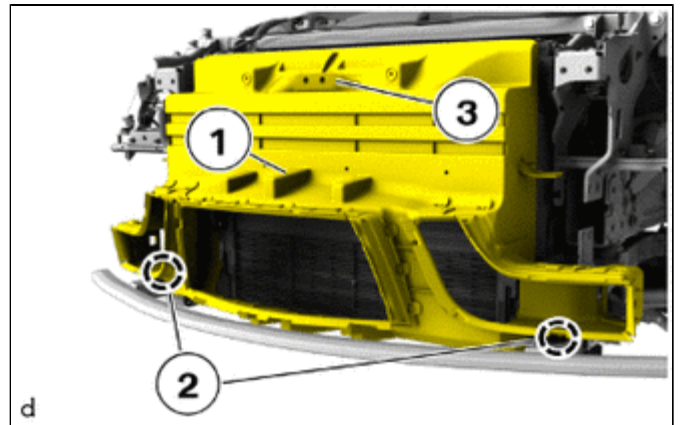
- (1) Disconnect the connector (1).

- (b) Disengage the clamps (2) to disconnect the No. 4 engine room wire (3).

- (c) Disengage the clamps (1) to disconnect the No. 4 engine room wire (2).

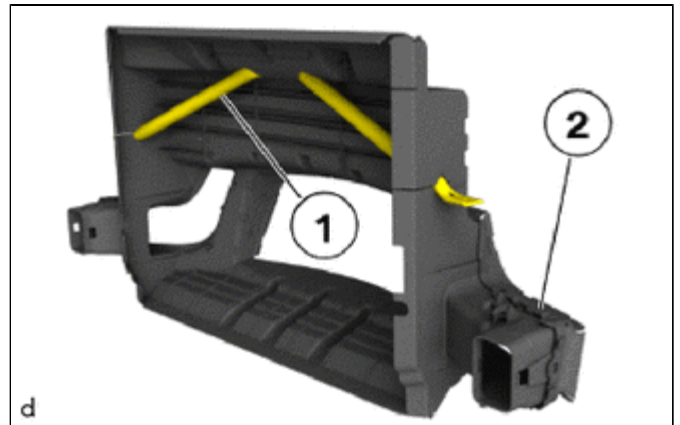


(d) Disengage the guides (2) to remove the No. 1 cool air intake duct (1).



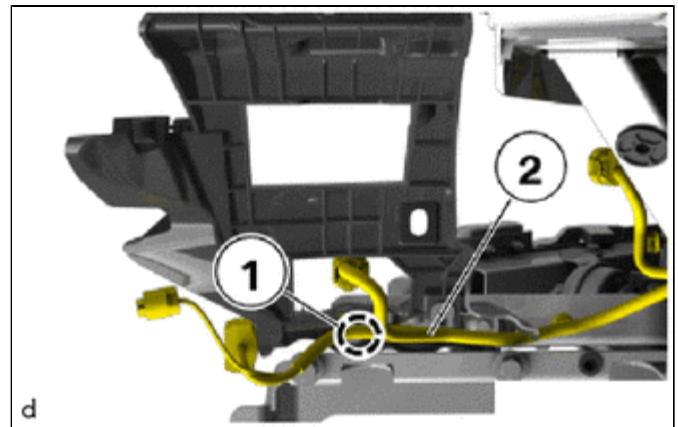
45. REMOVE RADIATOR BRACE ROD SUB-ASSEMBLY

(a) Remove the radiator brace rod sub-assembly (1) out of the No. 1 cool air intake duct (2).

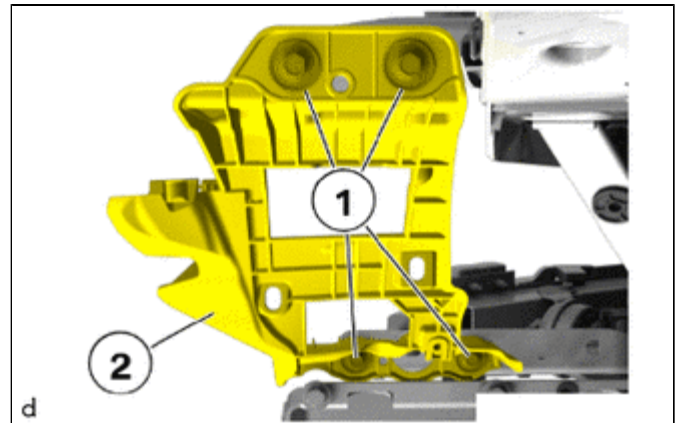


46. REMOVE FRONT BUMPER RETAINER LH

(a) Disengage the clamp (1) to disconnect the No. 4 engine room wire (2).



(b) Remove the bolts (1) and front bumper retainer LH (2).



47. REMOVE FRONT BUMPER RETAINER RH

HINT:

Use the same procedure as for the LH side.

48. REMOVE ENGINE HOOD COURTESY SWITCH (HOOD LOCK ASSEMBLY)

Click here [INFO](#)

49. REMOVE HOOD LOCK ASSEMBLY

Click here [INFO](#)

50. REMOVE AIR CLEANER ASSEMBLY

Click here [INFO](#)

51. REMOVE INLET NO. 2 AIR DUCT

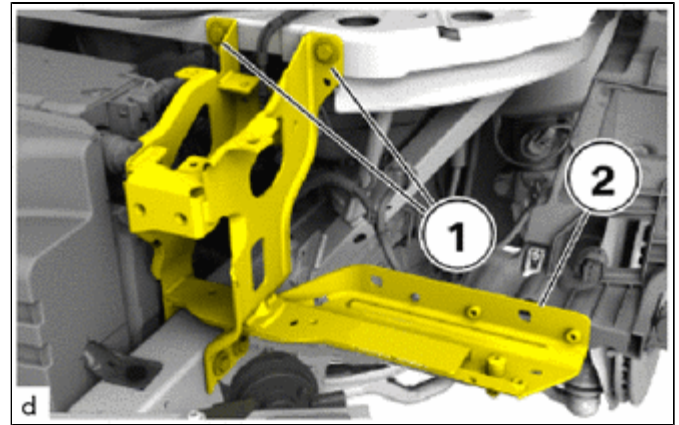
Click here [INFO](#)

52. REMOVE AIRBAG SENSOR (w/ Airbag Sensor)

Click here [INFO](#)

53. REMOVE RADIATOR SUPPORT LH

(a) Remove the bolts (1) and radiator support LH (2).



54. REMOVE RADIATOR SUPPORT RH

HINT:

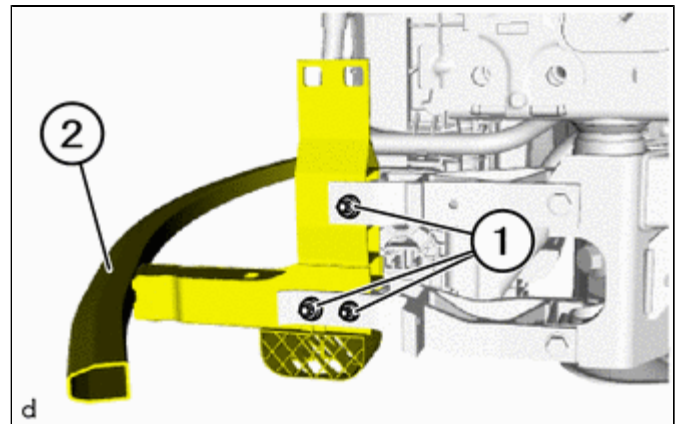
Use the same procedure as for the LH side.

55. REMOVE LOWER FRONT BUMPER REINFORCEMENT

(a) Remove the E10 bolts (1).

HINT:

Perform the operations on the left and right side.

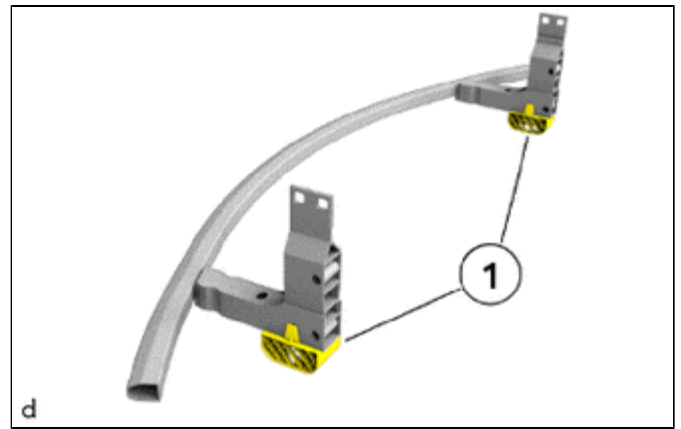


(b) Remove the lower front bumper reinforcement (2) to the bottom.

56. REMOVE IMPACT ABSORBER

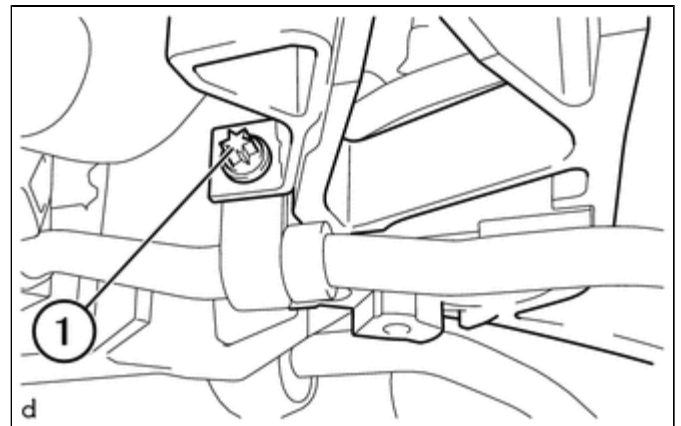
(a) Drill out the blind rivet.

(b) Remove both impact absorbers (1).

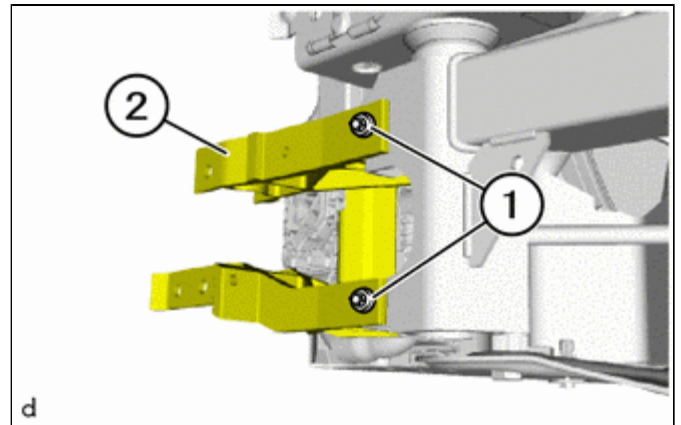


57. REMOVE FRONT BUMPER LOWER SIDE SUPPORT LH

(a) Remove the E8 bolt (1).



(b) Remove the E10 bolts (1) and front bumper lower side support LH (2).



58. REMOVE FRONT BUMPER LOWER SIDE SUPPORT RH

HINT:

Use the same procedure as for the LH side.



Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCMM
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: FRONT BUMPER: REASSEMBLY; 2020 MY Supra [03/2019 -]		

REASSEMBLY

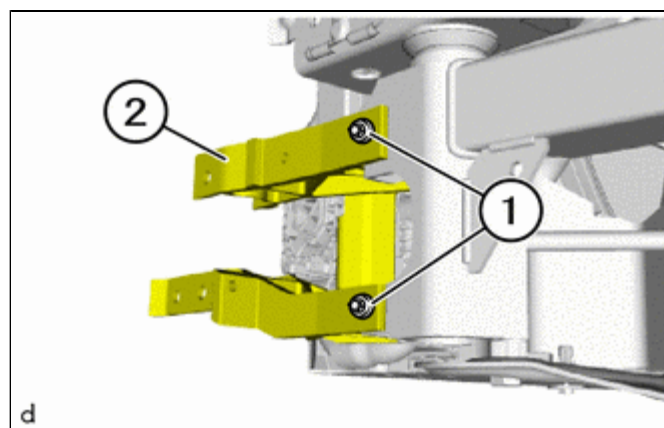
PROCEDURE

1. INSTALL FRONT BUMPER LOWER SIDE SUPPORT LH

- (a) Install the front bumper lower side support LH (2) with E10 bolts (1).

Torque:

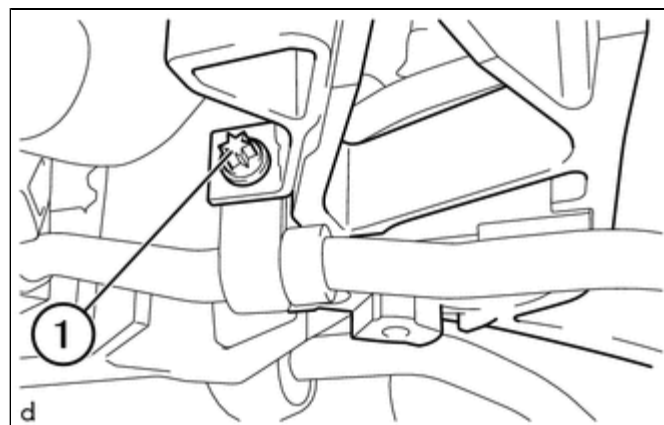
19 N·m {194 kgf·cm, 14 ft·lbf}



- (b) Install the E8 bolt (1).

Torque:

8.0 N·m {82 kgf·cm, 71 in·lbf}



2. INSTALL FRONT BUMPER LOWER SIDE SUPPORT RH

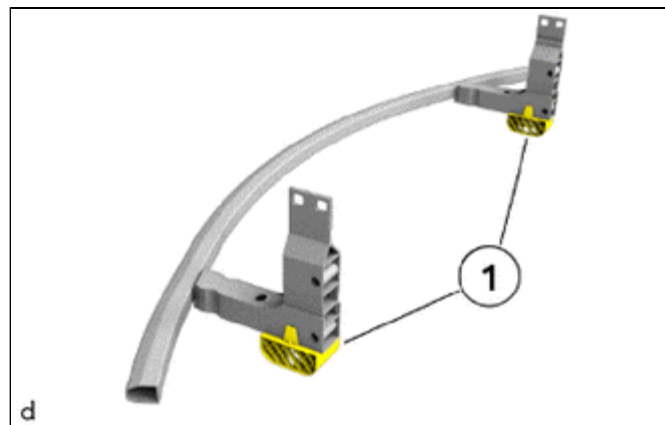
HINT:

Use the same procedure as for the LH side.

3. INSTALL IMPACT ABSORBER

- (a) Replace the blind rivet.

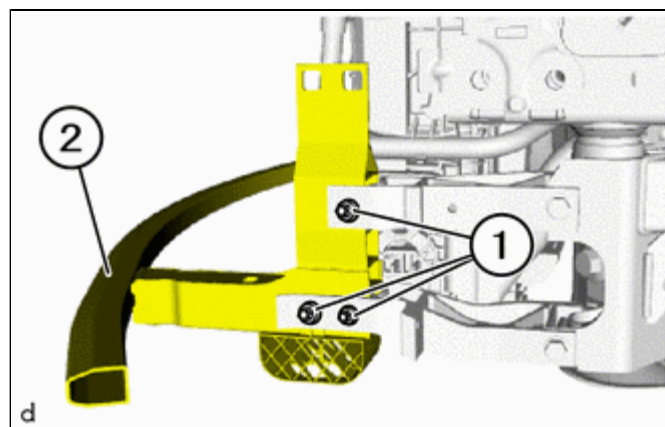
(b) Set the impact absorbers (1).



(c) Mount blind rivets.

4. INSTALL LOWER FRONT BUMPER REINFORCEMENT

(a) Install the lower front bumper reinforcement (2).



(b) Install the E10 bolts (1).

Torque:

19 N·m {194 kgf·cm, 14 ft·lbf}

HINT:

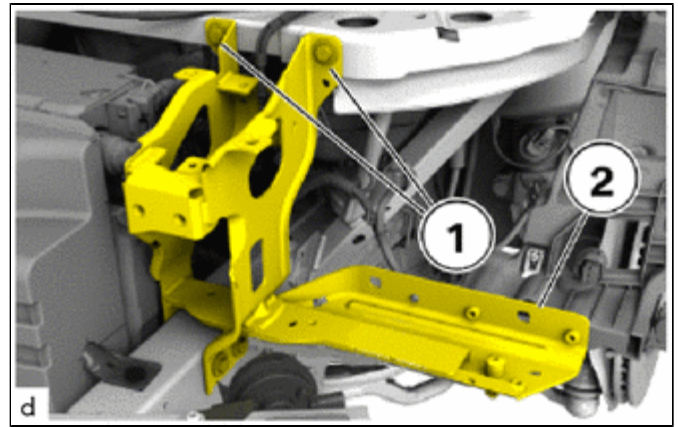
Perform the operations on the left and right side.

5. INSTALL RADIATOR SUPPORT LH

(a) Install the radiator support LH (2) with bolts (1).

Torque:

19 N·m {194 kgf·cm, 14 ft·lbf}



6. INSTALL RADIATOR SUPPORT RH

HINT:

Use the same procedure as for the LH side.

7. INSTALL AIRBAG SENSOR (w/ Airbag Sensor)

Click here [INFO](#)

8. INSTALL INLET NO. 2 AIR DUCT

Click here [INFO](#)

9. INSTALL AIR CLEANER ASSEMBLY

Click here [INFO](#)

10. INSTALL ENGINE HOOD COURTESY SWITCH (HOOD LOCK ASSEMBLY)

Click here [INFO](#)

11. INSTALL HOOD LOCK ASSEMBLY

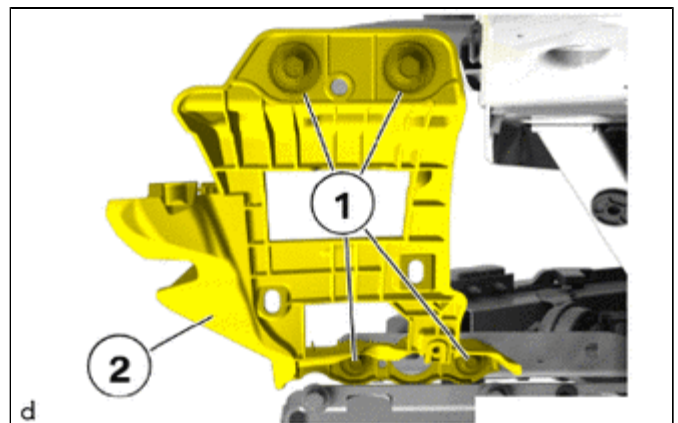
Click here [INFO](#)

12. INSTALL FRONT BUMPER RETAINER LH

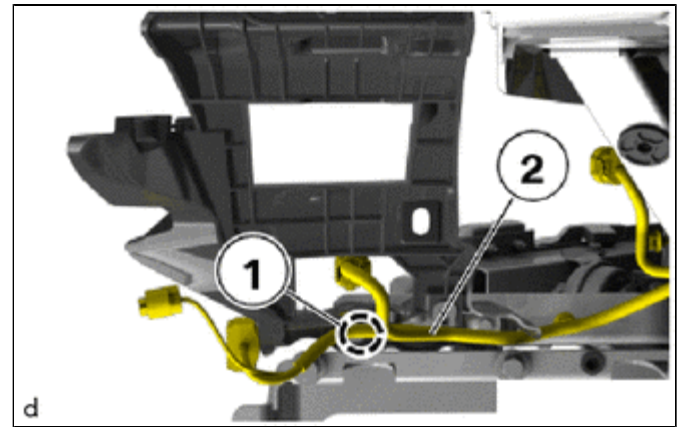
(a) Install the front bumper retainer LH (2) with bolts (1).

Torque:

8.0 N·m {82 kgf·cm, 71 in·lbf}



- (b) Engage the clamp (1) to connect the No. 4 engine room wire (2).



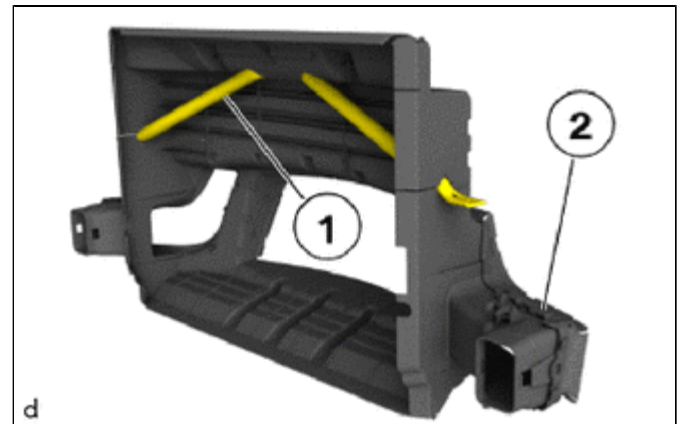
13. INSTALL FRONT BUMPER RETAINER RH

HINT:

Use the same procedure as for the LH side.

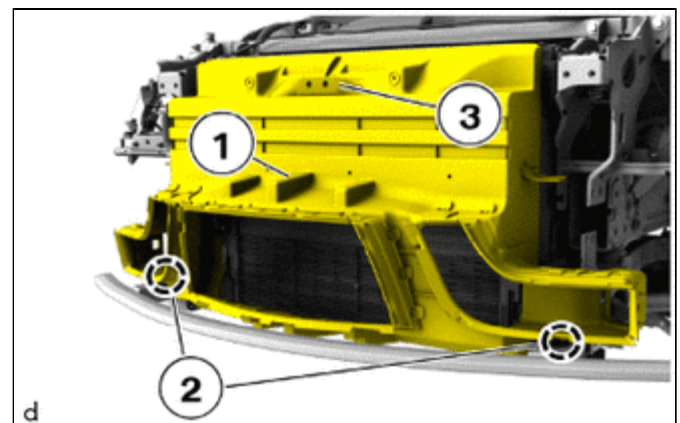
14. INSTALL RADIATOR BRACE ROD SUB-ASSEMBLY

- (a) Install the radiator brace rod sub-assembly (1) into the No. 1 cool air intake duct (2).

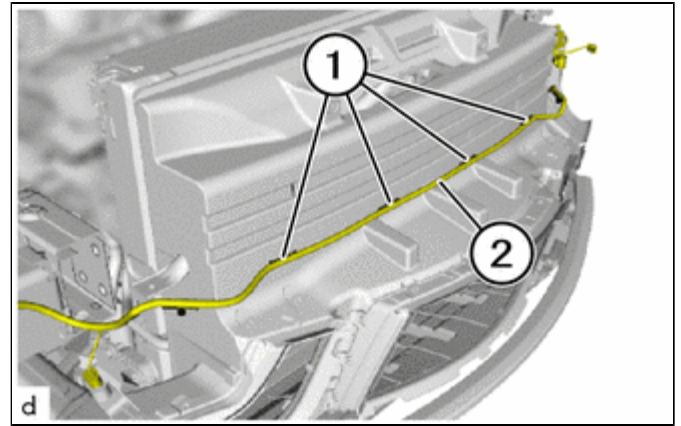


15. INSTALL NO. 1 COOL AIR INTAKE DUCT

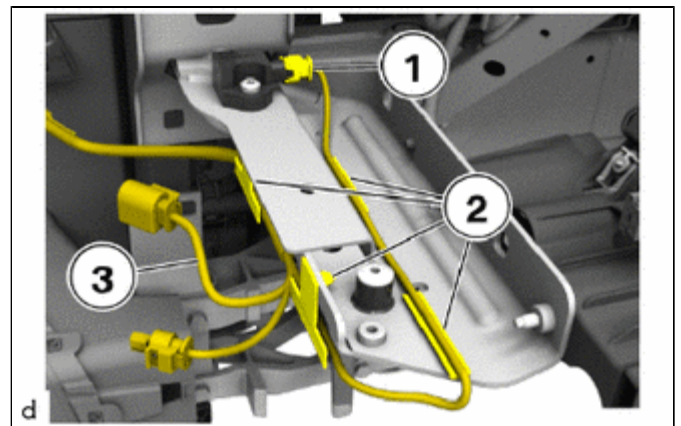
- (a) Install the No. 1 cool air intake duct (1) together with the radiator brace rod sub-assembly (3) into the guides (2) and position.



(b) Engage the clamps (1) to connect the No. 4 engine room wire (2).



(c) Engage the clamps (2) to connect the No. 4 engine room wire (3).



(d) w/ Airbag Sensor:

(1) Connect the connector (1).

16. INSTALL TEMPERATURE SENSOR ASSEMBLY

Click here [INFO](#)

17. INSTALL AIR INTAKE DUCT LH

Click here [INFO](#)

18. INSTALL AIR INTAKE DUCT RH

Click here [INFO](#)

19. INSTALL FRONT BUMPER SIDE SUPPORT

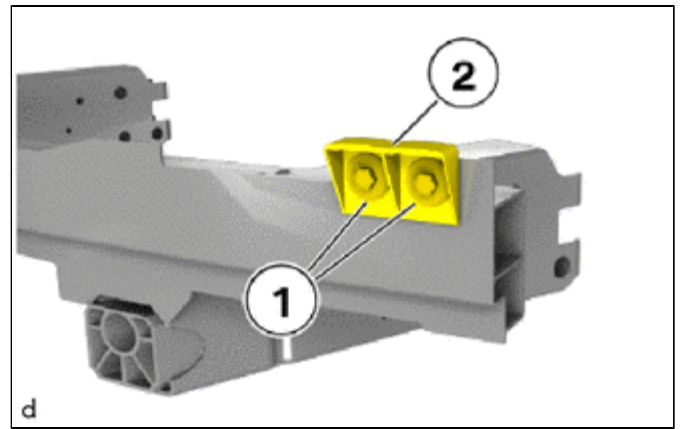
HINT:

Description is for left component only. Procedure on the right side is identical.

- (a) Install the front bumper side support (2) with the T30 bolts (1).

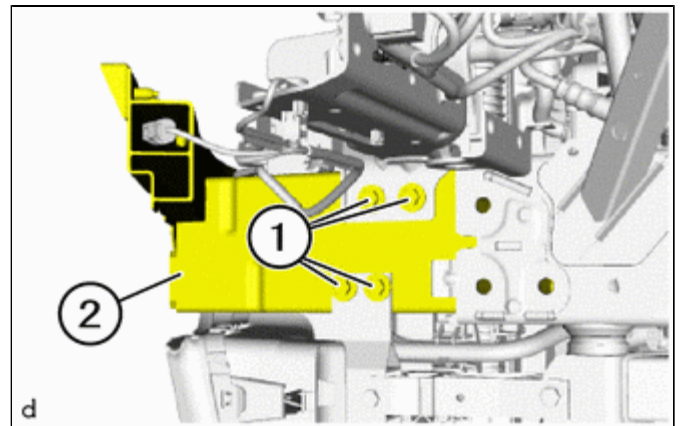
Torque:

8.0 N·m {82 kgf·cm, 71 in·lbf}



20. INSTALL FRONT BUMPER REINFORCEMENT

- (a) Install the front bumper reinforcement (2).



- (b) Install the bolts (1).

Torque:

19 N·m {194 kgf·cm, 14 ft·lbf}

HINT:

Perform the operations on the left and right side.

- (c) Tighten the bolt (1) with special tool 2 464 950 and SST, a torque wrench.

SST: 09800-WA310

SST: 09900-WA280

Torque:

Specified tightening torque :

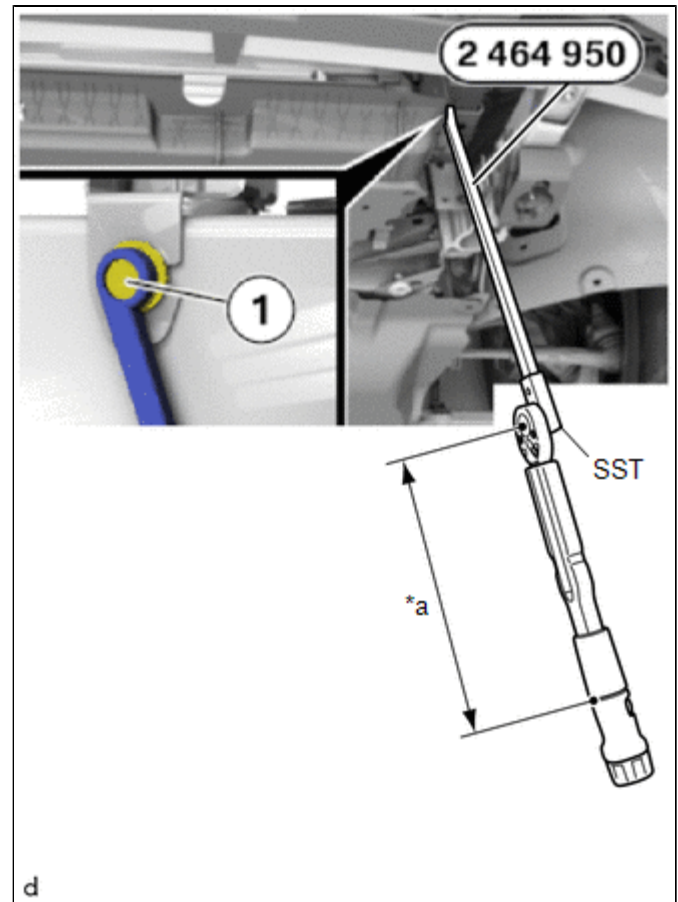
19 N·m {194 kgf·cm, 14 ft·lbf}

HINT:

- Calculate the torque wrench reading when changing the fulcrum length of the torque wrench.

Click here [INFO](#)

- Perform the operations on the left and right side.



*a	Torque Wrench Fulcrum Length
----	------------------------------

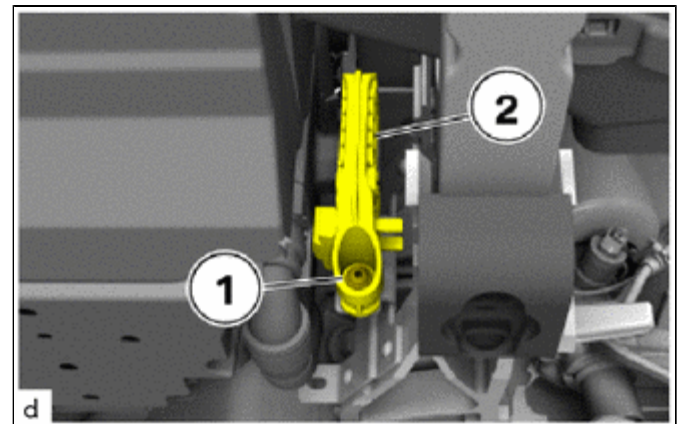
(d) Install the bottom cooler module mount (2) with T30 bolt (1).

Torque:

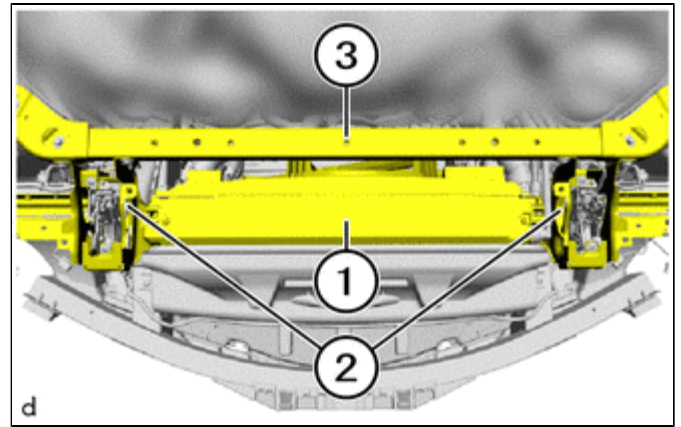
8.0 N·m {82 kgf·cm, 71 in·lbf}

HINT:

Perform the operations on the left and right side.



(e) Remove suitable auxiliary materials to disengage the radiator assembly (1) from the upper radiator support sub-assembly (3) and radiator support (2).



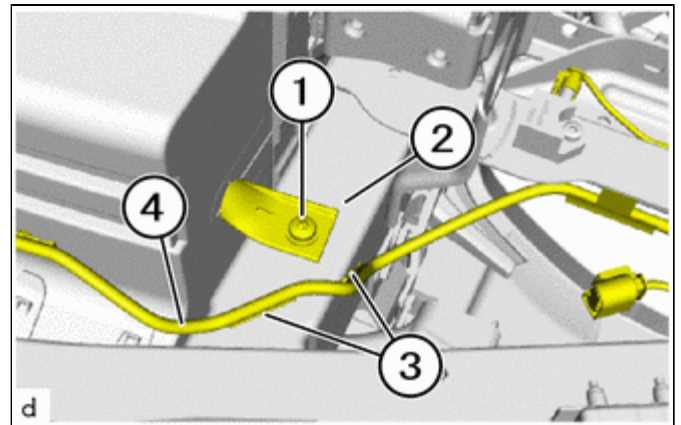
(f) Install the radiator brace rod sub-assembly (2) with T50 bolt (1).

Torque:

19 N·m {194 kgf·cm, 14 ft·lbf}

HINT:

Perform the operations on the left and right side.



(g) Engage the clamps (3) to connect the No. 4 engine room wire (4).

HINT:

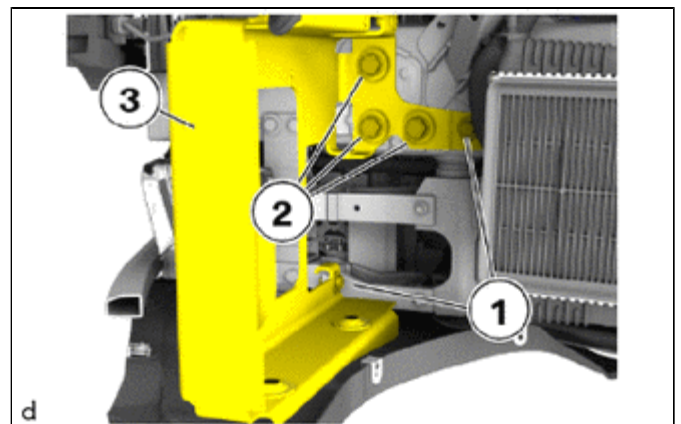
Perform the operations on the left and right side.

21. INSTALL FRONT BUMPER REINFORCEMENT SUB-ASSEMBLY LH

(a) Install the front bumper reinforcement sub-assembly (3) with the T45 bolt (1).

Torque:

19 N·m {194 kgf·cm, 14 ft·lbf}



(b) Using a deep socket wrench 18 mm, install the replace 18 mm bolts (2).

Torque:

100 N·m {1020 kgf·cm, 74 ft·lbf}

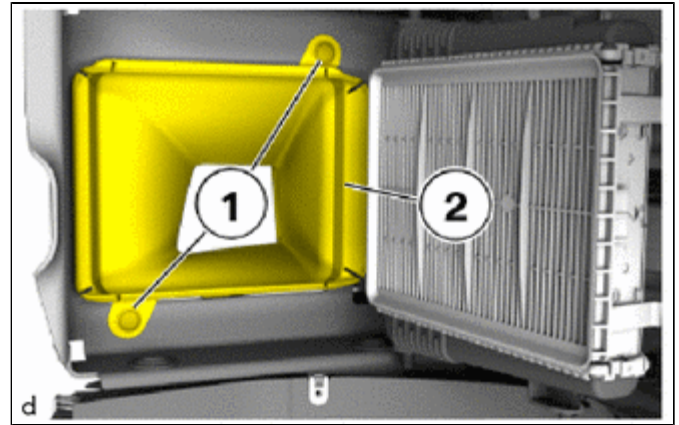
22. INSTALL FRONT BUMPER REINFORCEMENT SUB-ASSEMBLY RH

HINT:

Use the same procedure as for the LH side.

23. INSTALL SUB RADIATOR AIR DUCT LH

(a) Install the sub radiator air duct LH (2) with clips (1).



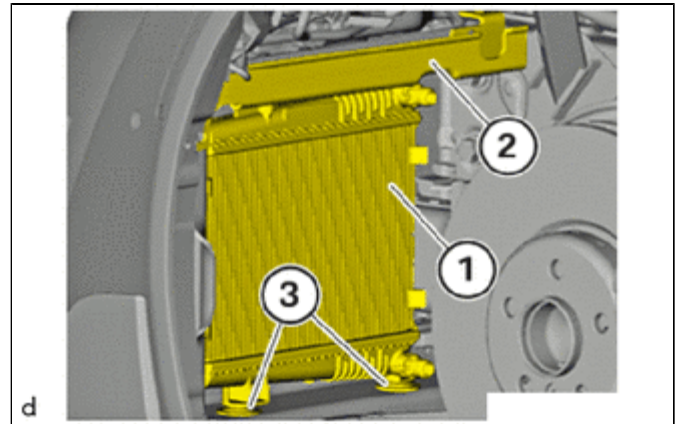
24. INSTALL SUB RADIATOR AIR DUCT RH

HINT:

Use the same procedure as for the LH side.

25. INSTALL SUB RADIATOR SUPPORT (for LH Side)

(a) Install the sub radiator support (3).

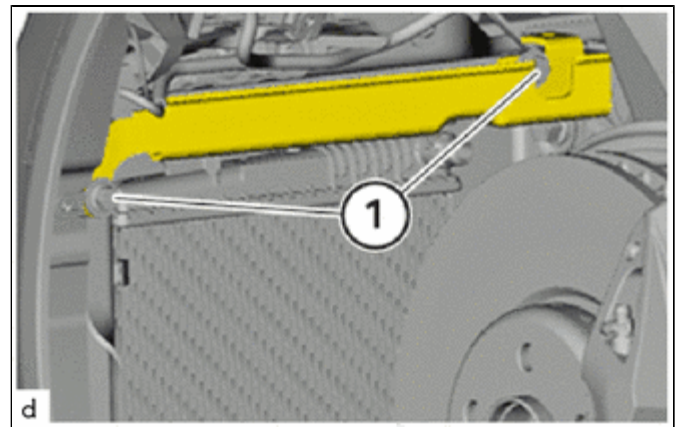


(b) Connect the sub radiator LH (1) to install the front bumper reinforcement support LH (2).

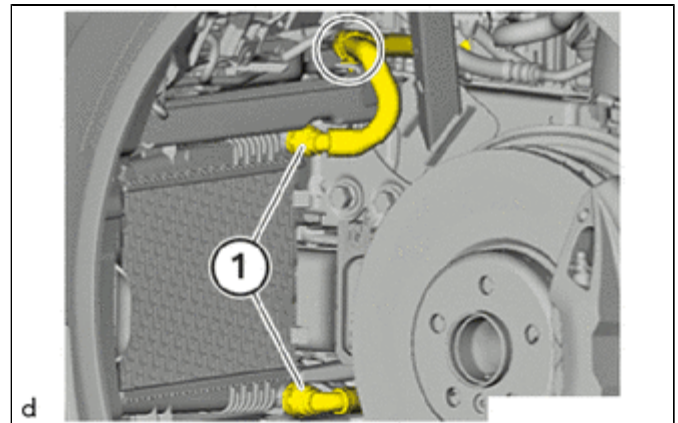
(c) Install the T45 bolts (1).

Torque:

19 N·m {194 kgf·cm, 14 ft·lbf}

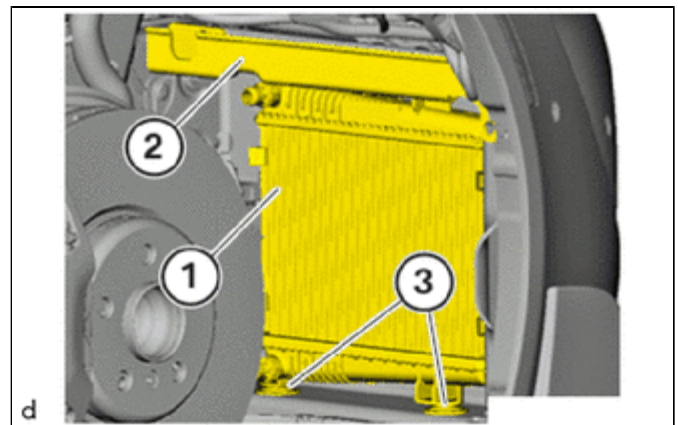


(d) Engage the clip in the marked area.



26. INSTALL SUB RADIATOR SUPPORT (for RH Side)

(a) Install the sub radiator support (3).

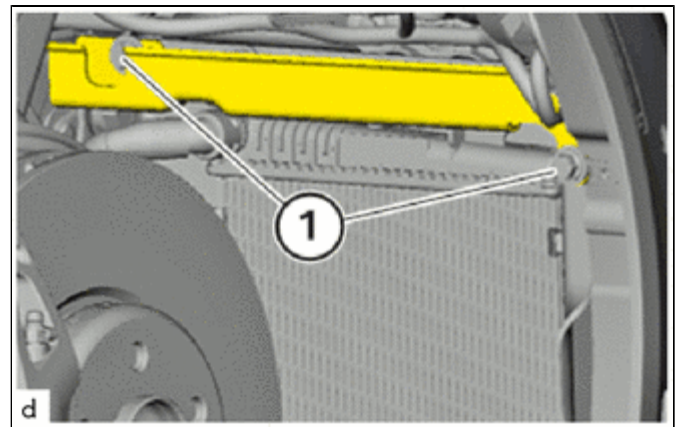


(b) Connect the sub radiator RH (1) to install the front bumper reinforcement support RH (2).

(c) Install the T45 bolts (1).

Torque:

19 N·m {194 kgf·cm, 14 ft·lbf}

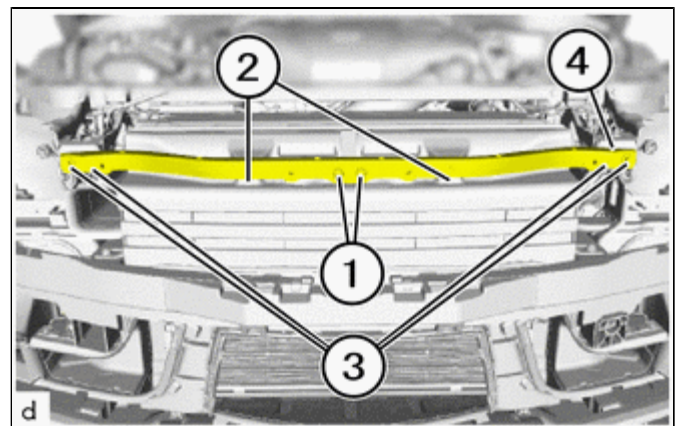


27. INSTALL FRONT CROSSMEMBER

(a) Install the front crossmember (4) with bolts (3).

Torque:

19 N·m {194 kgf·cm, 14 ft·lbf}



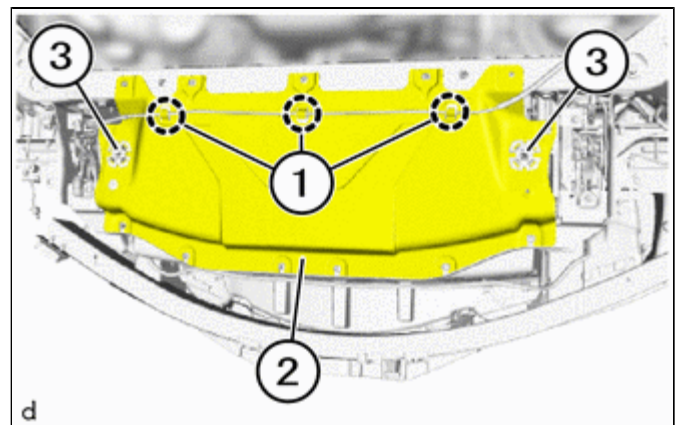
(b) Install the T50 bolts (1) and T30 bolts (2).

Torque:

19 N·m {194 kgf·cm, 14 ft·lbf}

28. INSTALL RADIATOR UPPER AIR DEFLECTOR

(a) Engage the guides (3) to install the radiator upper air deflector (2).

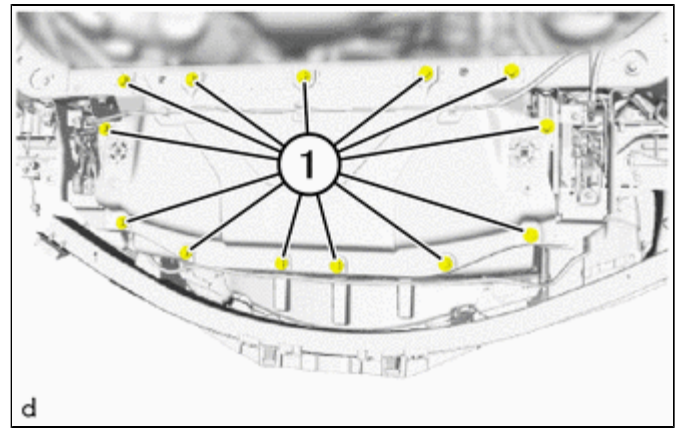


(b) Connect the hood lock control cable assembly on the guides(1).

(c) Install the bolts (1).

Torque:

19 N·m {194 kgf·cm, 14 ft·lbf}



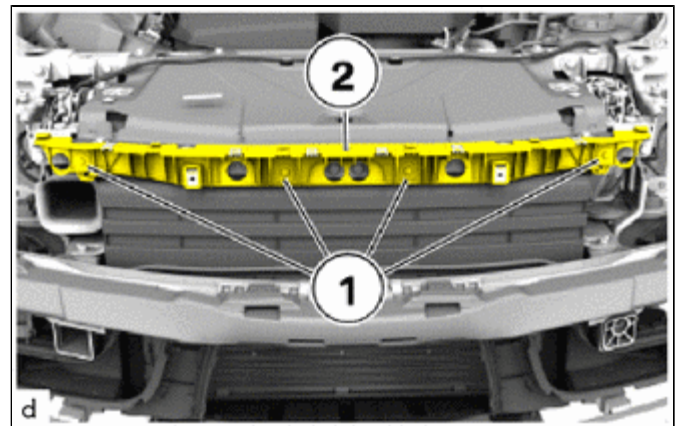
29. INSTALL FRONT BUMPER UPPER RETAINER

(a) Install the front bumper upper retainer (2) with bolts (1).

Torque:

:

8.0 N·m {82 kgf·cm, 71 in·lbf}

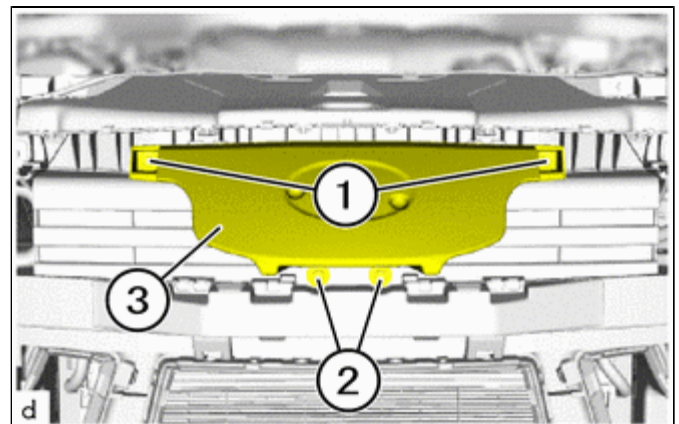


30. INSTALL FRONT BUMPER INNER SUPPORT

(a) Install the front bumper inner support (3) with T30 bolts (1) and bolts (2).

Torque:

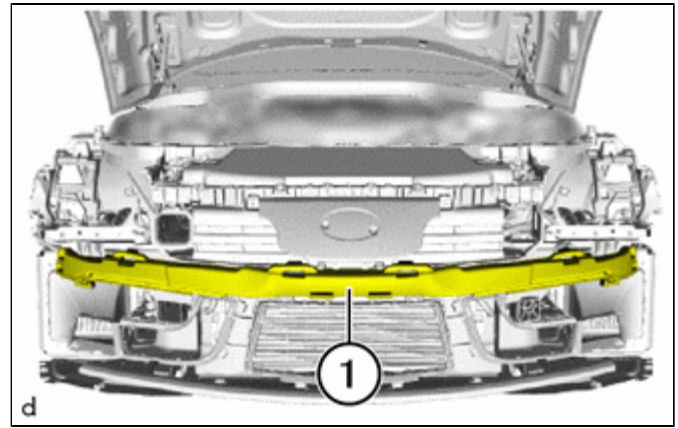
4.0 N·m {41 kgf·cm, 35 in·lbf}



31. INSTALL FRONT BUMPER ENERGY ABSORBER

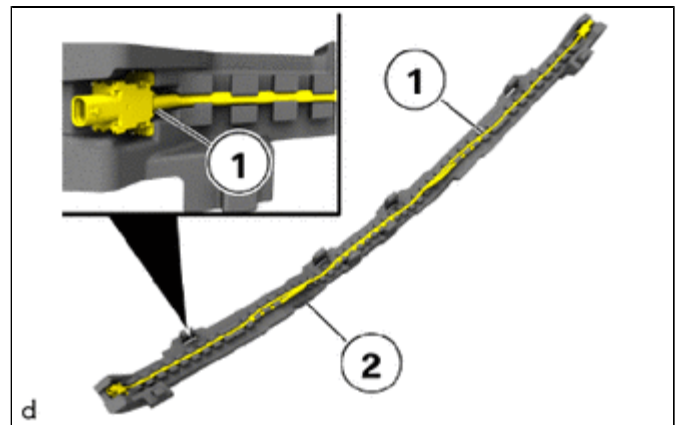
(a) w/o Pedestrian detection chamber assembly:

(1) Replace the front bumper energy absorber(1).



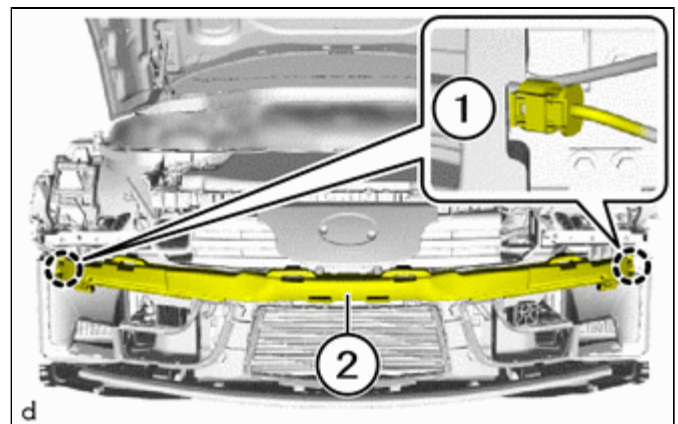
(2) Install the front bumper energy absorber (1).
(b) w/ Pedestrian detection chamber assembly:

(1) Replace the front bumper energy absorber (1).



(2) Carefully install the pedestrian detection chamber assembly (1) into the front bumper energy absorber (2).

(3) Install the front bumper energy absorber with
pedestrian detection chamber assembly (2).



(4) Connect the connectors (1).

32. INSTALL HIGH PITCHED HORN ASSEMBLY

Click here [INFO](#)

33. INSTALL HEADLIGHT ASSEMBLY LH

Click here [INFO](#)

34. INSTALL HEADLIGHT ASSEMBLY RH

HINT:

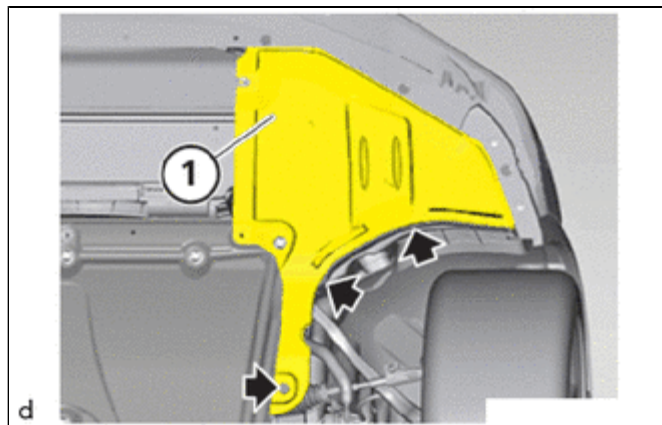
Use the same procedure as for the LH side.

35. INSTALL FRONT FENDER FRONT SPLASH SHIELD LH

- (a) Install the front fender front splash shield LH (1) with screws (arrows).

Torque:

2.6 N·m {27 kgf·cm, 23 in·lbf}



36. INSTALL FRONT FENDER FRONT SPLASH SHIELD RH

HINT:

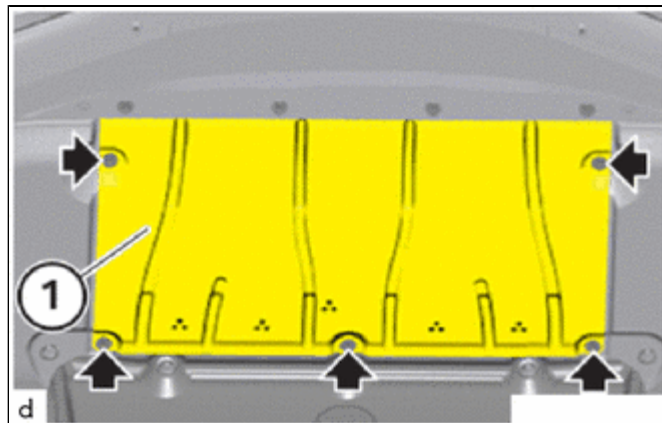
Use the same procedure as for the LH side.

37. INSTALL NO. 1 ENGINE UNDER COVER ASSEMBLY

- (a) Install the No. 1 engine under cover assembly (1) with screws (arrows).

Torque:

3.0 N·m {31 kgf·cm, 27 in·lbf}

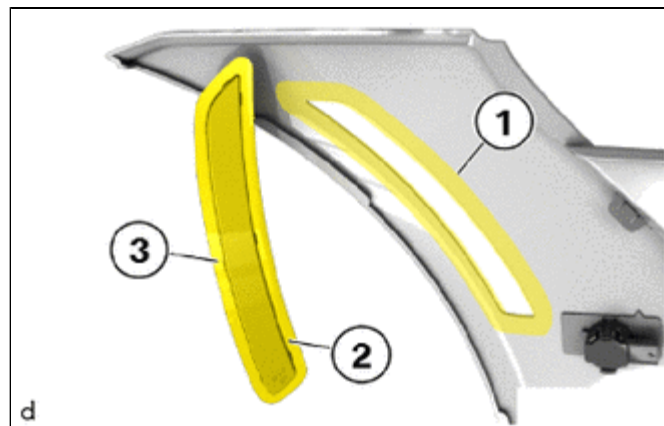


38. INSTALL NO. 1 ULTRASONIC SENSOR RETAINER

Click here [INFO](#)

39. INSTALL REFLEX REFLECTOR ASSEMBLY LH

(a) Replace the reflex reflector assembly LH (3).



(b) Remove adhesive residue on the bumper panel and clean the adhesive area (1) with cleaner.

Cleaner:

Cleaner R2

(c) Peel off the liner (2) from the adhesive tape.

(d) Install the reflex reflector assembly LH (3) in the designated area and press it on tightly.

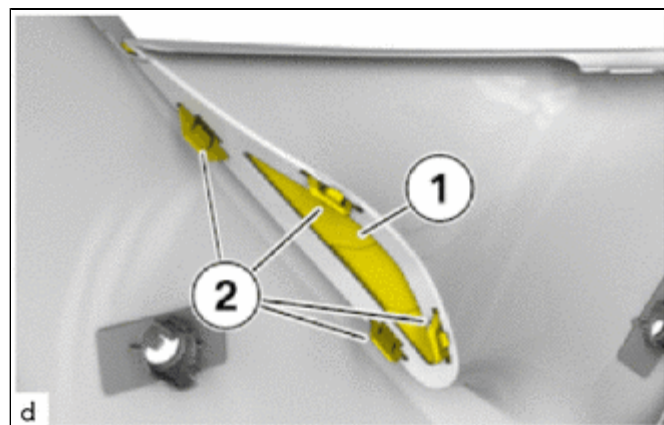
40. INSTALL REFLEX REFLECTOR ASSEMBLY RH

HINT:

Use the same procedure as for the LH side.

41. INSTALL COOL AIR INTAKE GRILLE LH

(a) Engage the claws (2) to install the cool air intake grille LH (1).



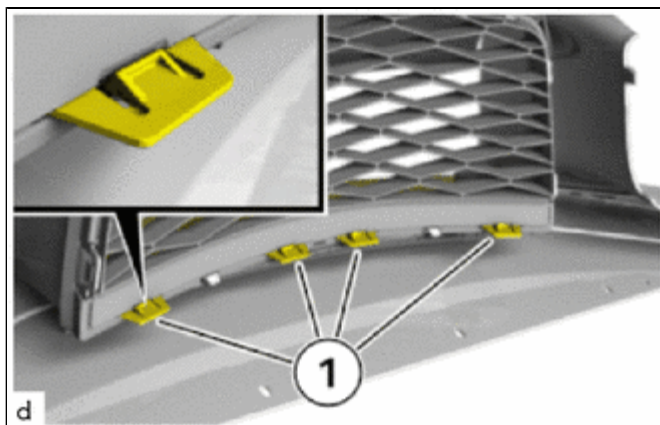
42. INSTALL COOL AIR INTAKE GRILLE RH

HINT:

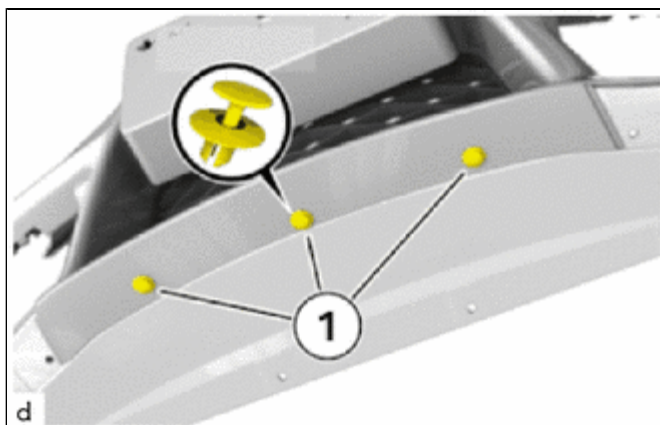
Use the same procedure as for the LH side.

43. INSTALL FRONT SPOILER SUB-ASSEMBLY

(a) Engage the claws (1) to install the front spoiler sub-assembly.

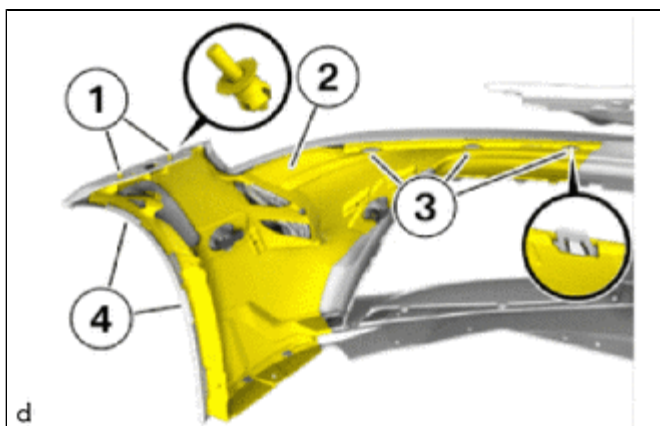


(b) Install the clips (1).



44. INSTALL FRONT BUMPER SIDE RETAINER LH

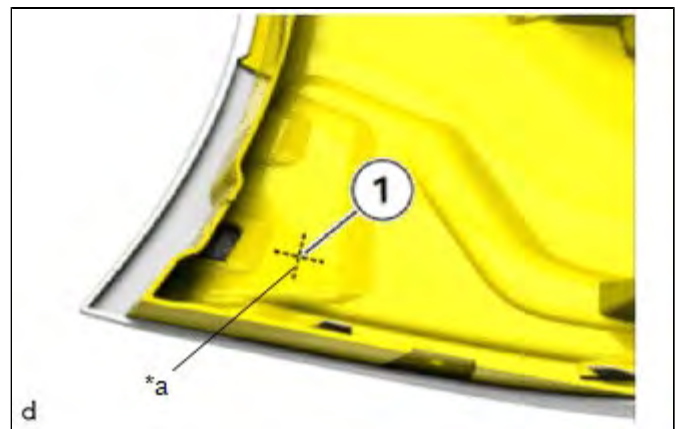
(a) Engage the guides (4) to install the front bumper side retainer LH (2).



(b) Engage the claws (3).

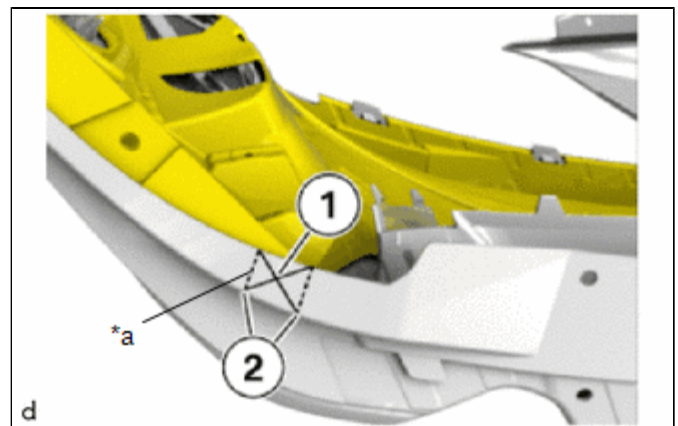
(c) Install the clips (1).

(d) In central point (1) of the crack lines, drill a 6.0 mm (0.236 in.) bore hole for plastic rivet.



*a	Scribed Line
----	--------------

(e) Determine the central point (1) between the crack lines (2).

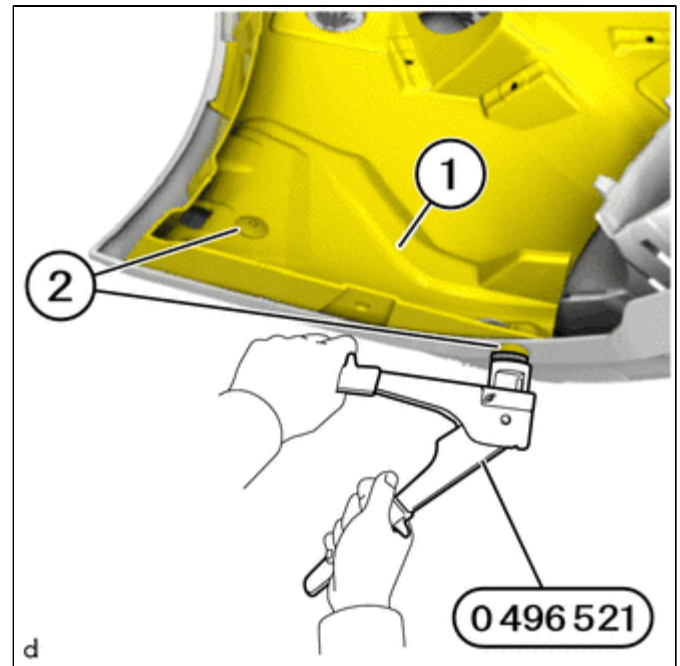


*a	Scribed Line
----	--------------

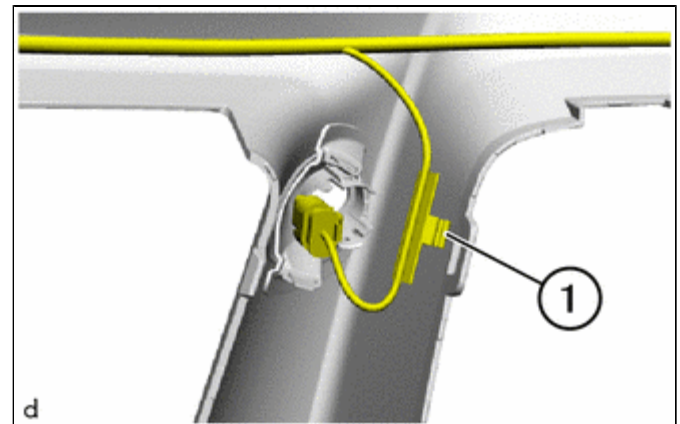
(f) In the area (1) drill out a 6.0 mm (0.236 in.) bore hole for plastic rivet.

(g) Using a special tool 0 496 521 (00 2 230), install the front bumper side retainer LH (1) with plastic rivets (2).

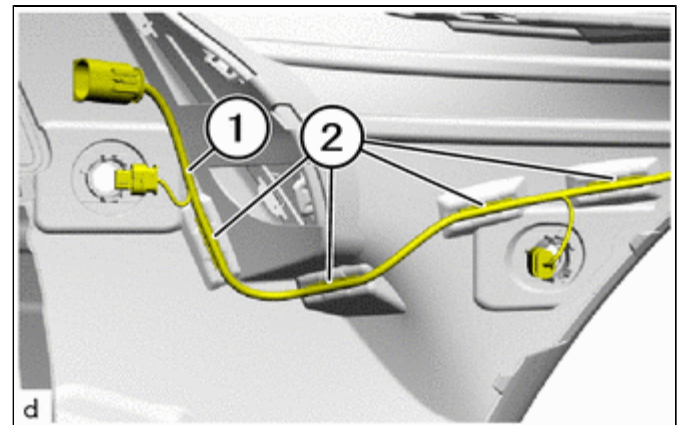
SST: 09900-WA100



(h) Engage the clamp (1).



(i) Engage the clamps (2) to connect the No. 4 engine room wire (1).



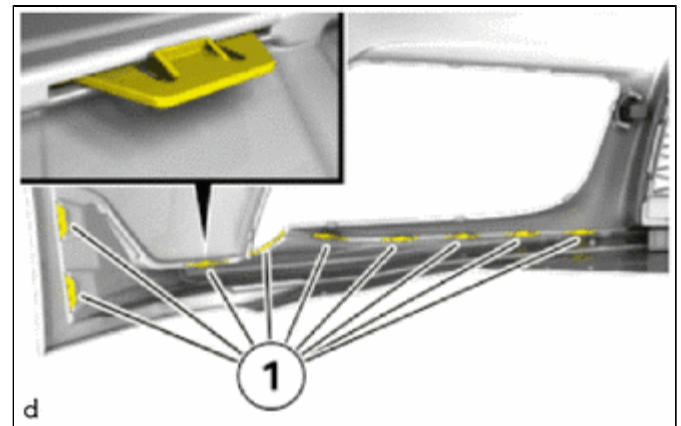
45. INSTALL FRONT BUMPER SIDE RETAINER RH

HINT:

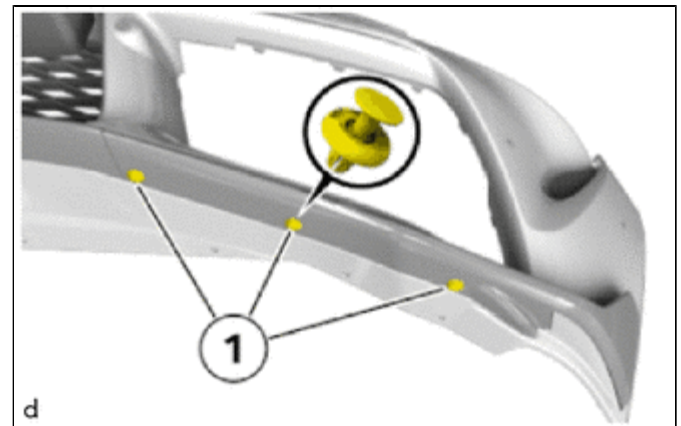
Use the same procedure as for the LH side.

46. INSTALL FRONT SIDE SPOILER LH

(a) Engage the claws (1) to install the front side spoiler LH.



(b) Install the clips (1).



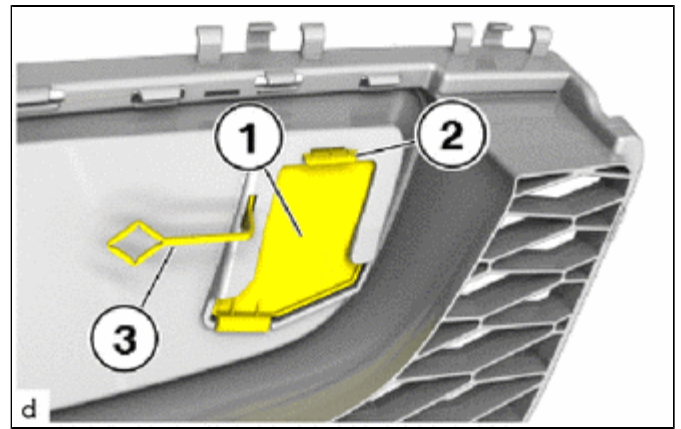
47. INSTALL FRONT SIDE SPOILER RH

HINT:

Use the same procedure as for the LH side.

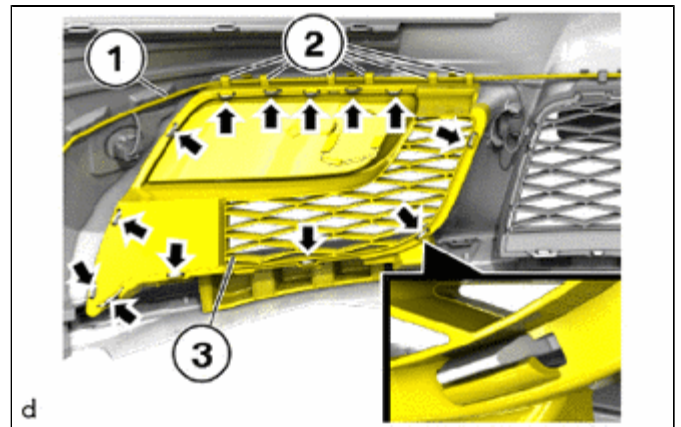
48. INSTALL FRONT BUMPER HOLE COVER

(a) Engage the hook (3).



(b) Engage the claw (2) to install the front bumper hole cover (1).

49. INSTALL LOWER RADIATOR GRILLE LH



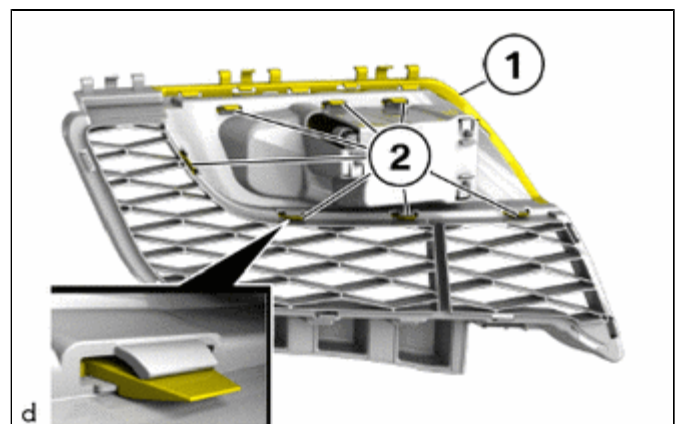
(a) Engage the claws (arrows) to install the lower radiator grille LH (3).

(b) Engage the No. 4 engine room wire (1) to the holder (2) on the lower radiator grille LH (3).

50. INSTALL MILLIMETER WAVE RADAR SENSOR (w/ Toyota Supra Safety)

Click here [INFO](#)

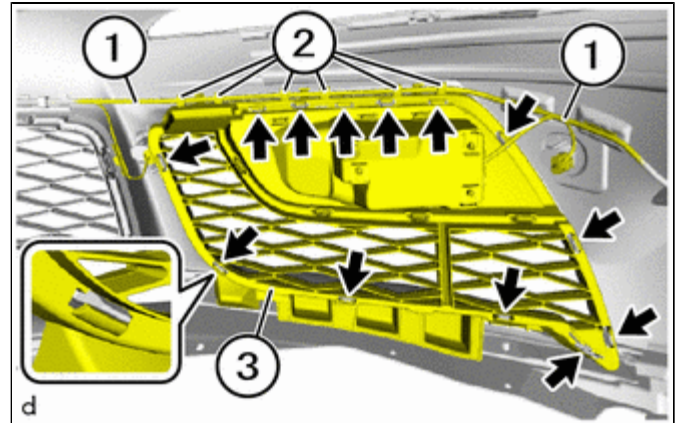
51. INSTALL LOWER SIDE RADIATOR GRILLE RH



(a) Engage the claws (2) to install the lower side radiator grille RH (1).

52. INSTALL LOWER RADIATOR GRILLE RH

- (a) Engage the claws (arrows) to install the lower radiator grille RH (3).



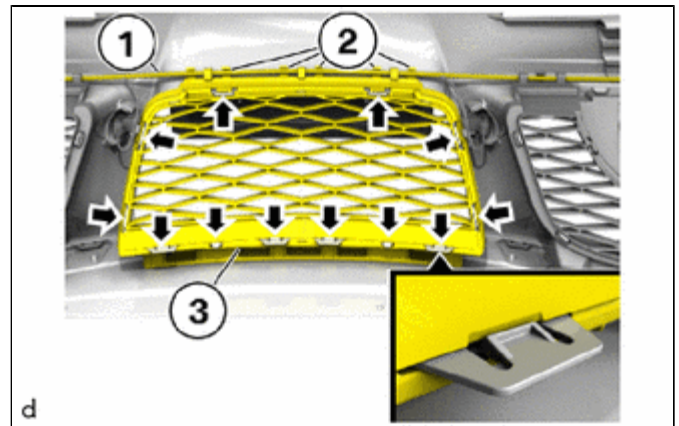
- (b) Connect the No. 4 engine room wire (1) to the holders (2) on the lower radiator grille RH (3).

- (c) w/ Toyota Supra Safety:

- (1) Connect the connector.

53. INSTALL LOWER NO. 1 RADIATOR GRILLE

- (a) Engage the claws (arrows) to install the lower No. 1 radiator grille (3).



- (b) Connect the No. 4 engine room wire (1) to the holders (2) on the lower No. 1 radiator grille (3).

54. INSTALL FRONT SIDE ULTRASONIC SENSOR

Click here [INFO](#)

55. INSTALL FRONT CORNER ULTRASONIC SENSOR

Click here [INFO](#)

56. INSTALL FRONT CENTER ULTRASONIC SENSOR

HINT:

Use the same procedure as for the front corner ultrasonic sensor.

57. INSTALL FRONT BUMPER EMBLEM SUB-ASSEMBLY

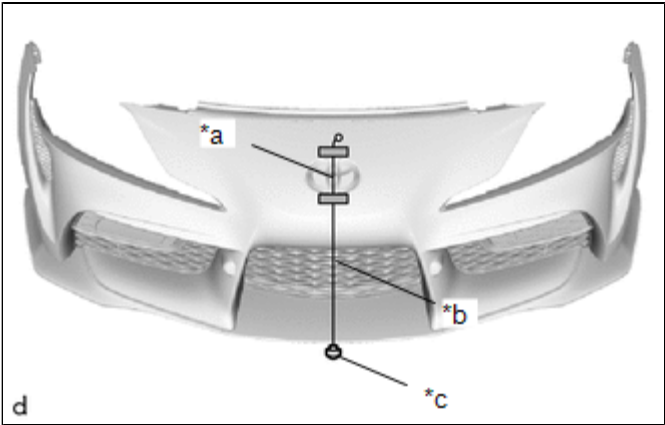
Click here [INFO](#)

58. INSTALL FRONT BUMPER EXTENSION MOUNTING BRACKET

NOTICE:

- Malfunction of the ultrasonic sensor.
- Incorrect assembly of the license plate leads to a malfunction of the ultrasonic sensor.
- Fix license plate and front bumper extension mounting bracket only according to the dimensions specified in the repair instructions.
 - Only use front bumper extension mounting bracket that have been approved for the vehicle type.
 - The license plate carrier must not be installed on the front bumper.

(a) Hang the weight from the center of the front bumper emblem sub-assembly as shown in the illustration.

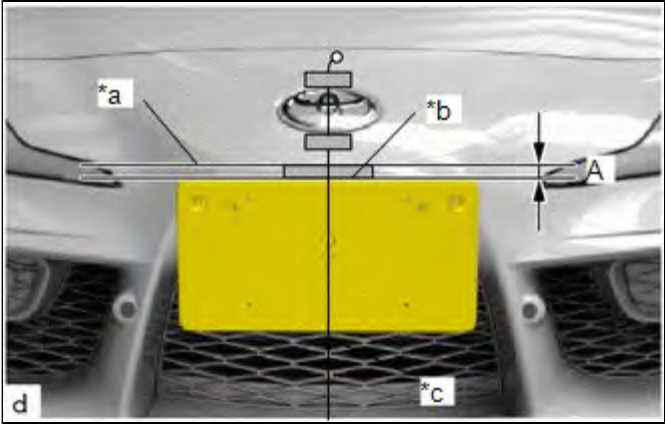


*a	Center of The Front Bumper Emblem Sub-assembly
*b	String
*c	Weight
	Tape

HINT:

Lightly flick the string with your fingers several times to confirm that the string is perpendicular to the ground.

(b) Set the front bumper extension mounting bracket on the front bumper assembly as shown in the illustration.



*a	Bumper Panel Edge
*b	Lower Edge of The Tape And Upper Edge of The Front Bumper Extension Mounting Bracket
*c	String
	Tape

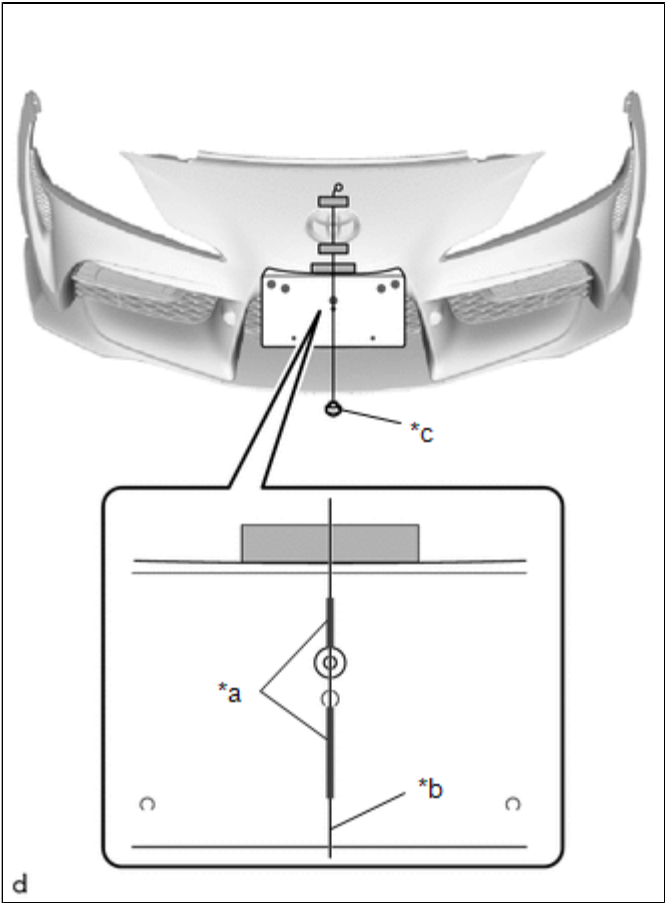
Standard:

AREA	SPECIFIED CONDITION
A	15 mm (0.591 in.)

HINT:

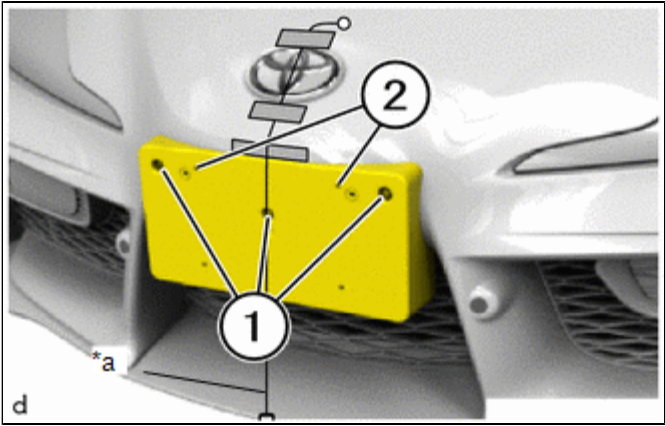
Match the lower edge of the tape with the upper edge of the front bumper extension mounting bracket.

- (c) Make sure that the center line of the bumper extension mounting bracket and the center of the front bumper emblem sub-assembly match.



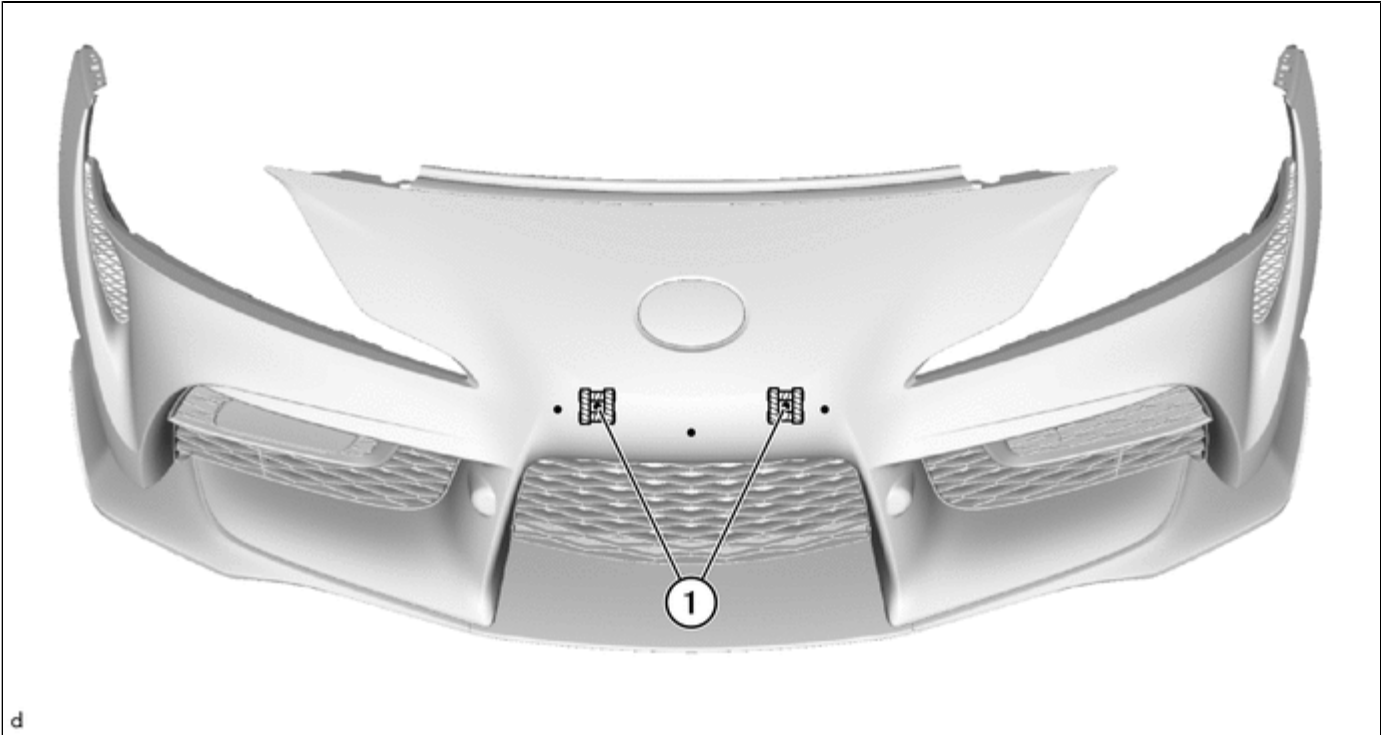
*a	Center Line
*b	String
*c	Weight
	Tape

(d) Front license plate mounting bolt length 10 mm (0.394 in.) or more:



*a	String
	Tape

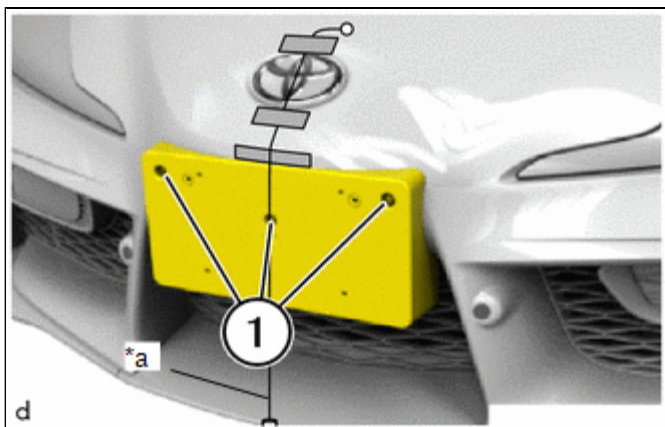
- (1) Mark the front bumper assembly from the mounting holes position (1) of the front bumper extension mounting bracket and the mounting bolt holes position (2) of the license plate.
- (2) Apply protective tape as shown in the illustration and drill a 8.0 mm (0.315 in.) hole in the mounting bolt holes position (1) of the number plate.



	Protective Tape	-	-
---	-----------------	---	---

- (3) Remove the protective tape.

(e) Align the mark and install screws (1) the front bumper extension mounting bracket without pre-drilling.



*a	String
	Tape

(f) Remove the tape, string and weight.

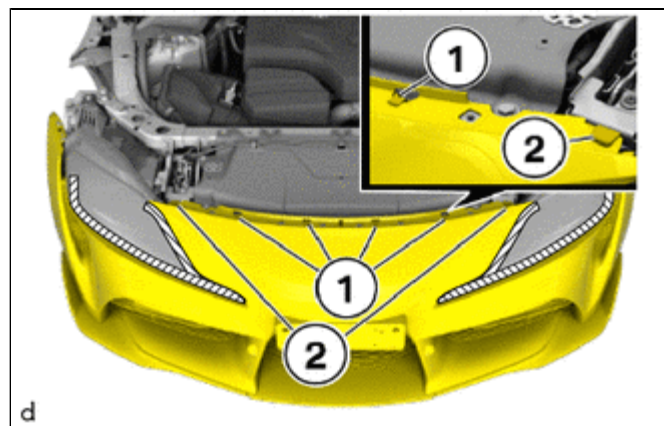
Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCMN
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: FRONT BUMPER: INSTALLATION; 2020 MY Supra [03/2019 -]		

INSTALLATION

PROCEDURE

1. INSTALL FRONT BUMPER ASSEMBLY

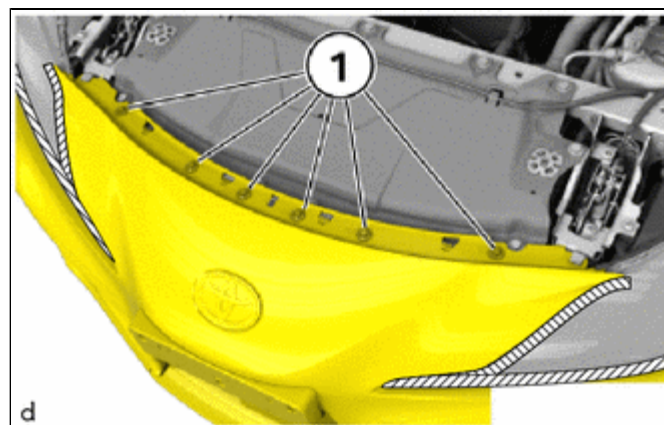
- (a) Engage the guides (2) and clamps (1) to install the front bumper assembly.



- (b) Install the bolts (1).

Torque:

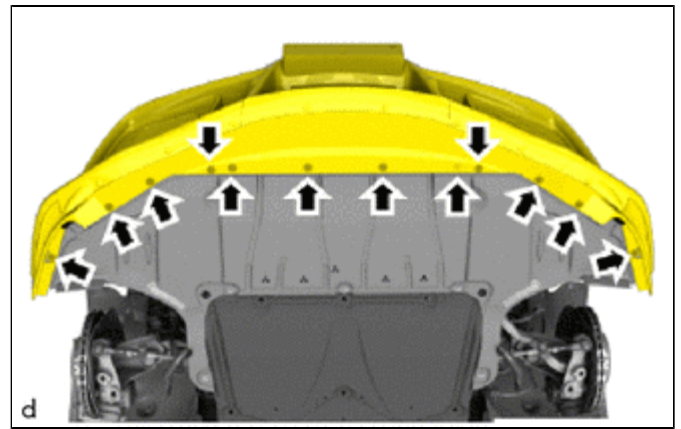
8.0 N·m {82 kgf·cm, 71 in·lbf}



- (c) Install the screws (arrowed).

Torque:

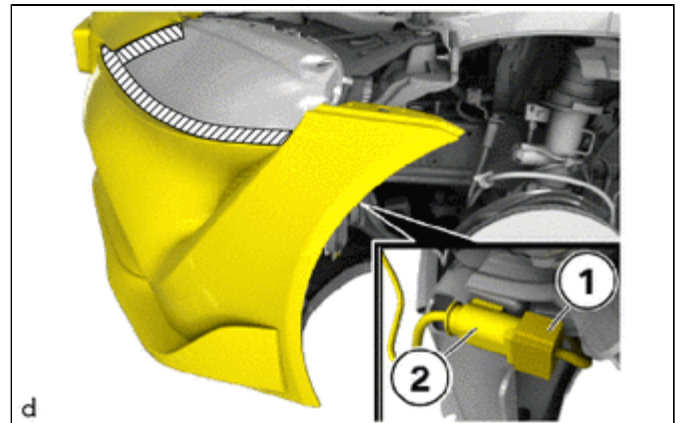
3.0 N·m {31 kgf·cm, 27 in·lbf}



(d) Engage the clamp (2).

HINT:

Perform the operations on the left and right side.



(e) Connect the connector (1).

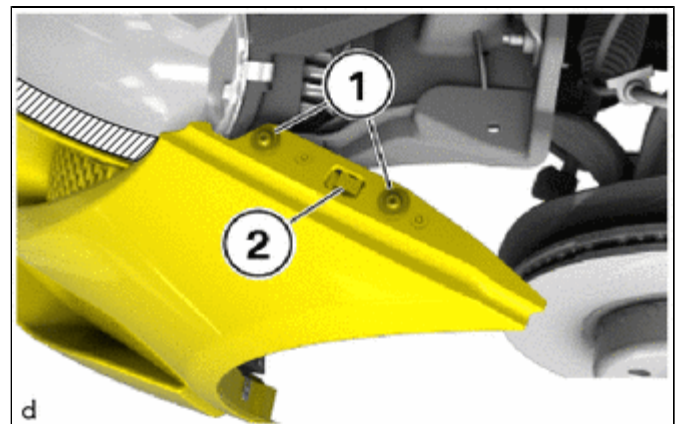
HINT:

Perform the operations on the left and right side.

(f) Engage the clamp (2).

HINT:

Perform the operations on the left and right side.



(g) Install the T20 screws (1).

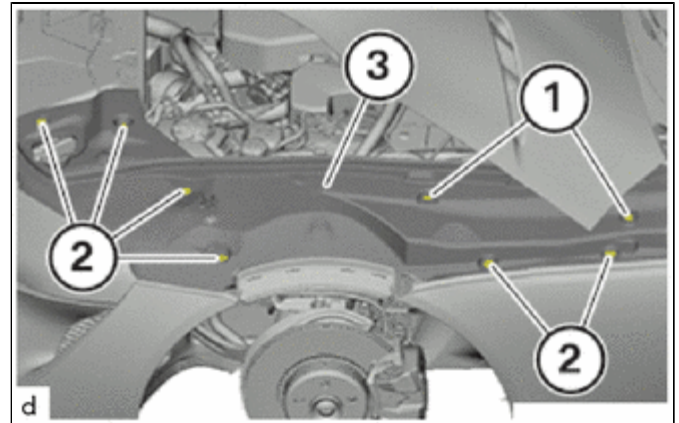
HINT:

Perform the operations on the left and right side.

(h) Remove the protective tape.

2. INSTALL FRONT FENDER UPPER PROTECTOR LH

(a) Install the front fender upper protector LH (3).



(b) Install the clips (1) and clips (2).

3. INSTALL FRONT FENDER UPPER PROTECTOR RH

HINT:

Use the same procedure as for the LH side.

4. INSTALL HOOD TO RADIATOR SUPPORT SEAL

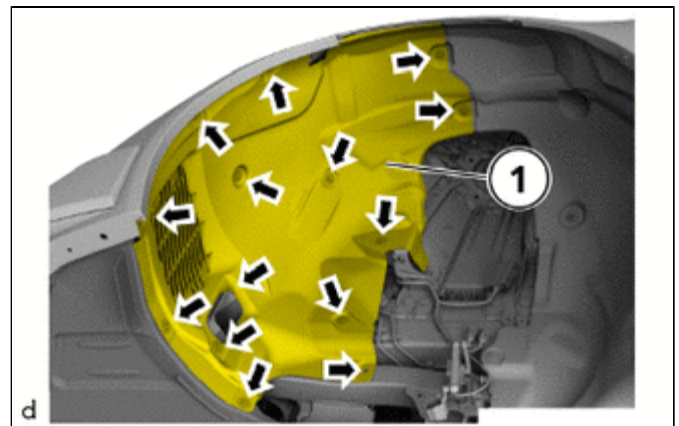
(a) Install the hood to radiator support seal.

5. INSTALL FRONT FENDER LINER LH

(a) Install the front fender liner LH (1) with screws (arrows).

Torque:

2.6 N·m {27 kgf·cm, 23 in·lbf}



6. INSTALL FRONT FENDER LINER RH

HINT:

Use the same procedure as for the LH side.

7. CONNECT CABLE TO NEGATIVE BATTERY TERMINAL

Click here [INFO](#)

8. ADJUST HEADLIGHT AIMING

Click here [INFO](#)

9. ADJUST MILLIMETER WAVE RADAR SENSOR (w / Toyota Supra Safety)

- Before starting adjustment:

Click here [INFO](#)

- Adjustment:

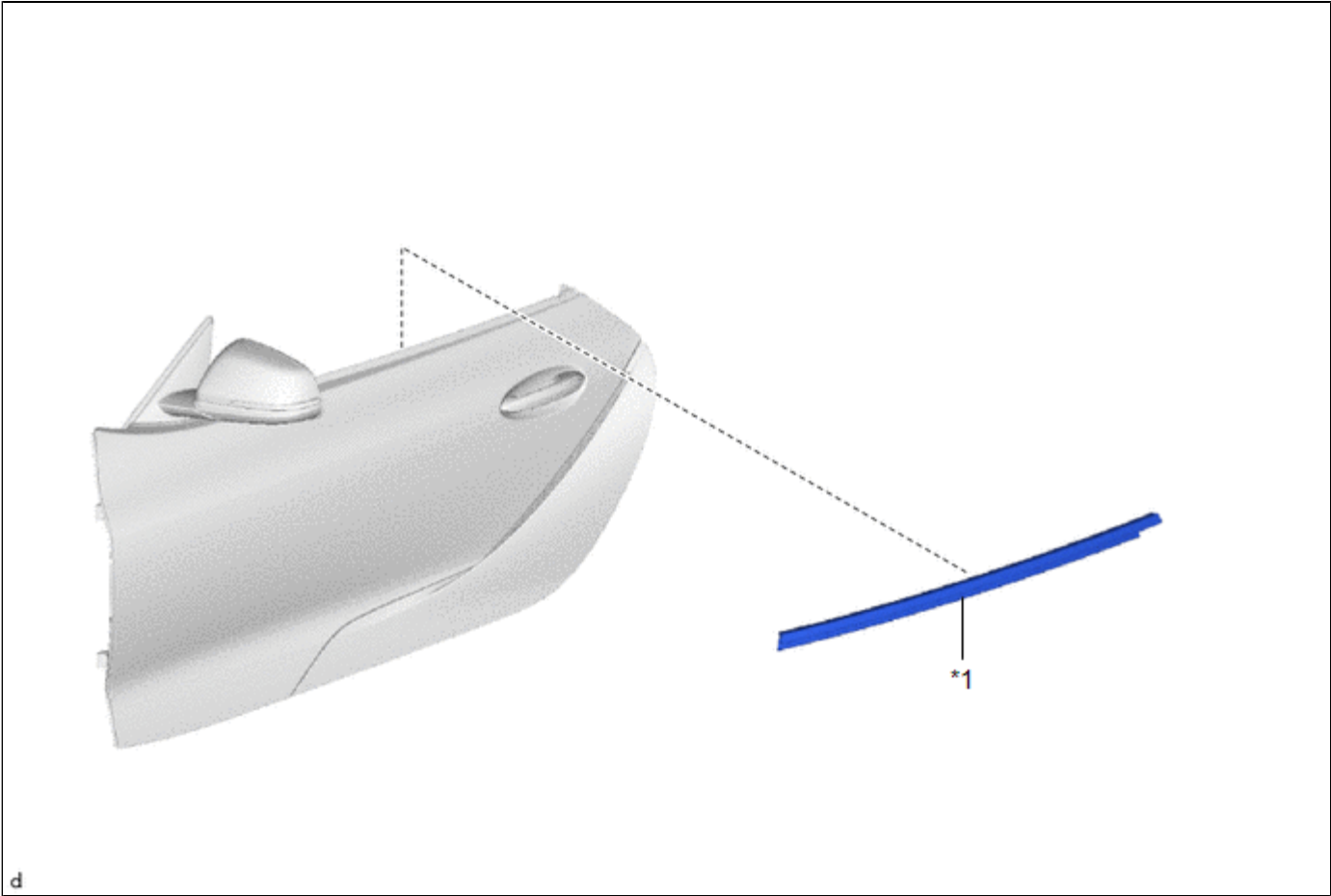
Click here [INFO](#)



Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCMW
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: FRONT DOOR BELT MOULDING: COMPONENTS; 2020 MY Supra [03/2019 -]		

COMPONENTS

ILLUSTRATION



*1	FRONT DOOR BELT MOULDING ASSEMBLY	-	-
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Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCMX
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: FRONT DOOR BELT MOULDING: REMOVAL; 2020 MY Supra [03/2019 -]		

REMOVAL

CAUTION / NOTICE / HINT

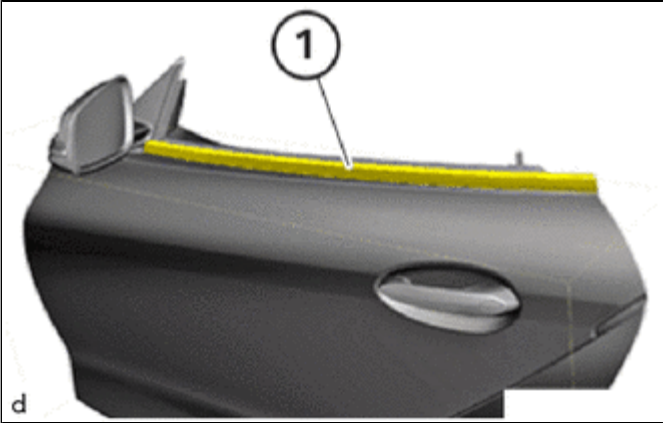
HINT:

- Use the same procedure for both the LH and RH sides.
- The procedure described below is for the LH side.

PROCEDURE

1. REMOVE FRONT DOOR BELT MOULDING ASSEMBLY

(a) Remove the front door belt moulding assembly (1).



Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCMY
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: FRONT DOOR BELT MOULDING: INSTALLATION; 2020 MY Supra [03/2019 -]		

INSTALLATION

CAUTION / NOTICE / HINT

HINT:

- Use the same procedure for both the LH and RH sides.
- The procedure described below is for the LH side.

PROCEDURE

1. INSTALL FRONT DOOR BELT MOULDING ASSEMBLY

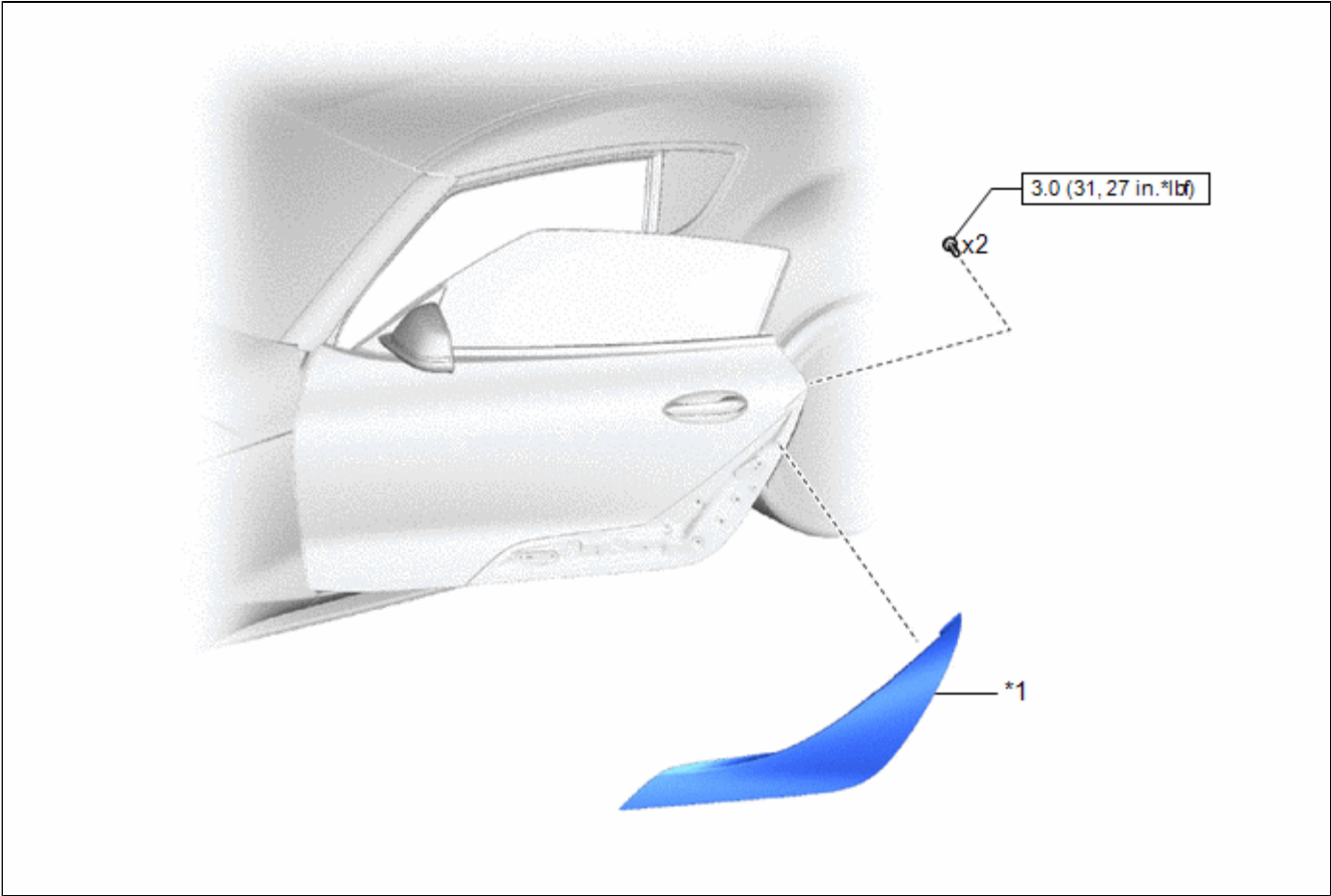
- Coat the front door belt moulding assembly with a suitable lubricant prior to installation.
- Install the front door belt moulding assembly.



Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCND
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: FRONT DOOR OUTSIDE MOULDING: COMPONENTS; 2020 MY Supra [03/2019 -]		

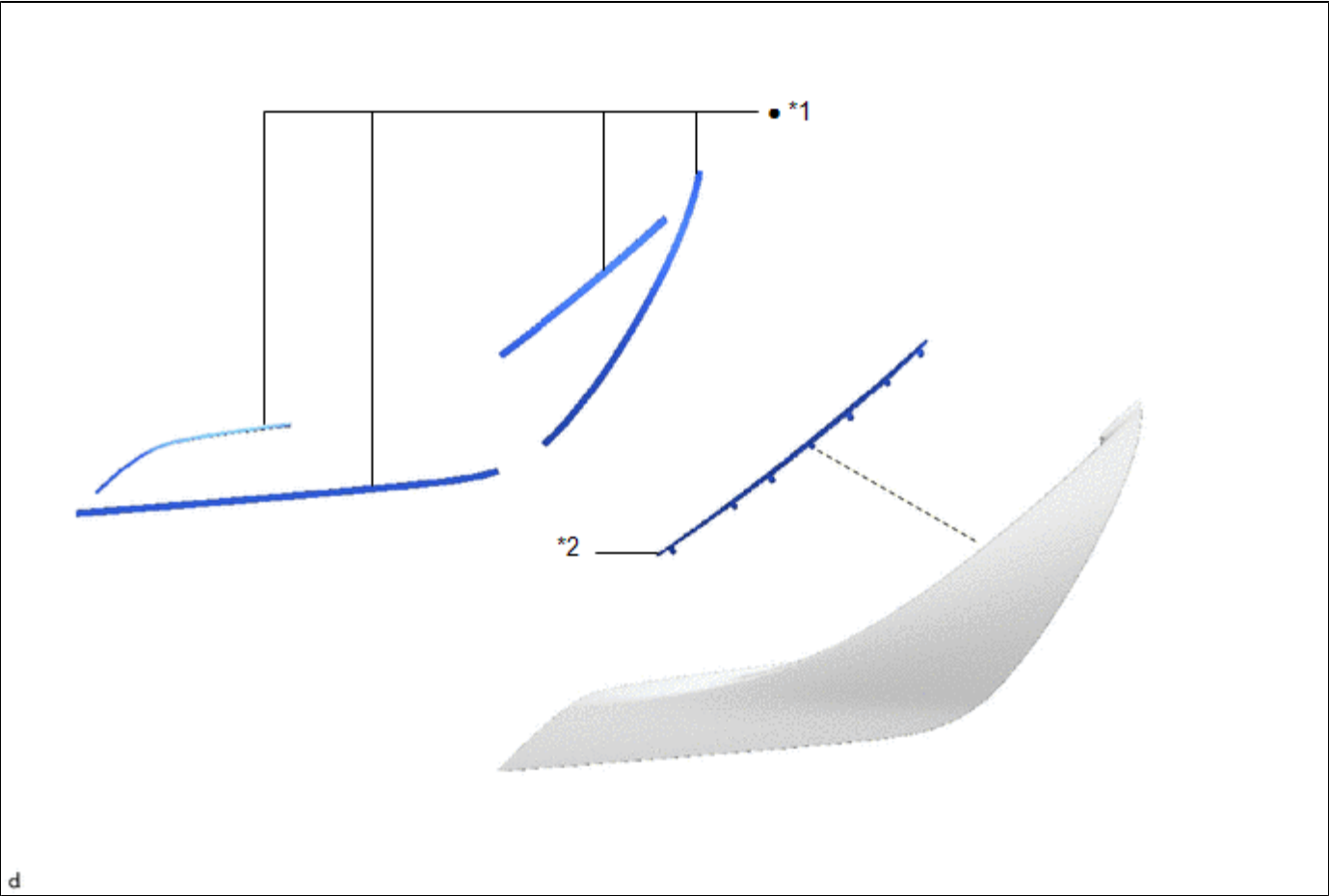
COMPONENTS

ILLUSTRATION

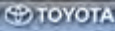


*1	FRONT DOOR OUTSIDE MOULDING SUB-ASSEMBLY	-	-
	N*m (kgf*cm, ft.*lbf): Specified torque	-	-

ILLUSTRATION



*1	BODY OUTSIDE MOULDING PAD	*2	FRONT DOOR REAR OUTSIDE MOULDING
●	Non-reusable part	-	-



Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCNE
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: FRONT DOOR OUTSIDE MOULDING: REMOVAL; 2020 MY Supra [03/2019 -]		

REMOVAL

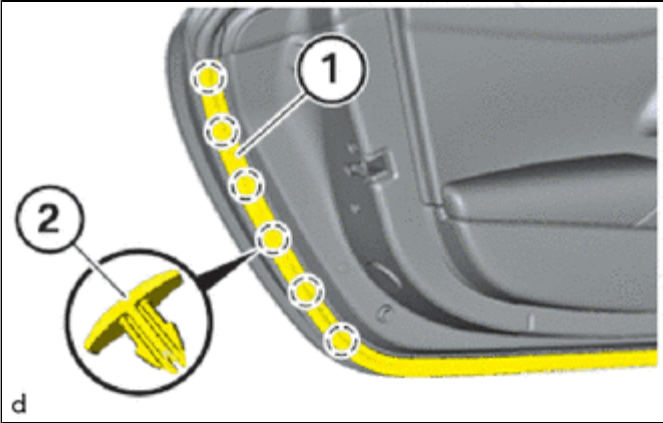
CAUTION / NOTICE / HINT

- HINT:**
- Use the same procedure for both the LH and RH sides.
 - The procedure described below is for the LH side.

PROCEDURE

1. SEPARATE FRONT DOOR WEATHERSTRIP

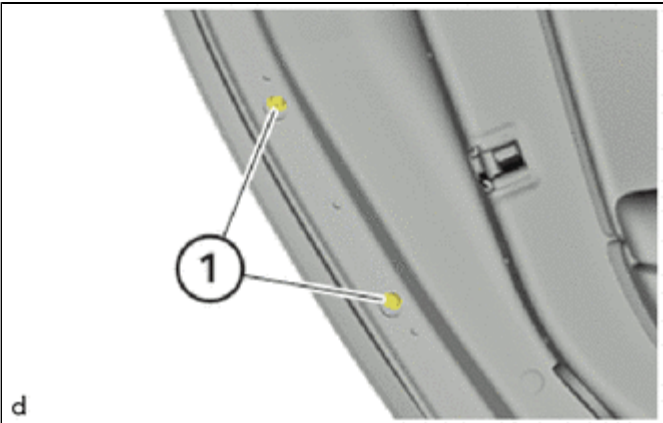
- (a) Disengage the clips (2) to separate the front door weatherstrip (1).



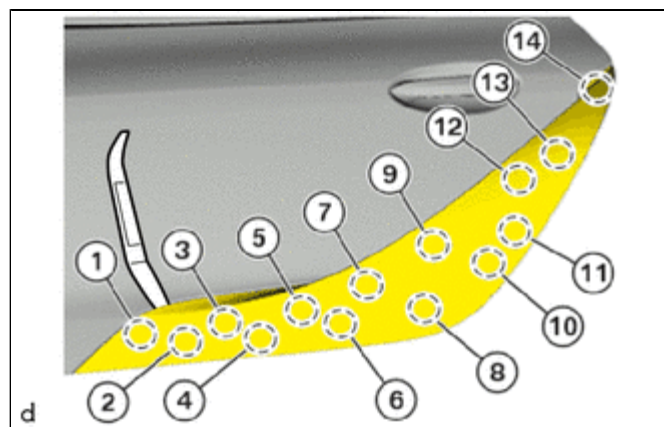
- (b) Let front door weatherstrip (1) hang down.

2. REMOVE FRONT DOOR OUTSIDE MOULDING SUB-ASSEMBLY

- (a) Remove the screws (1).



(b) Using a moulding remover A, disengage the clips in the order as shown the illustration, and remove the front door outside moulding sub-assembly.



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Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: FRONT DOOR OUTSIDE MOULDING: DISASSEMBLY; 2020 MY Supra [03/2019 -]		

DISASSEMBLY

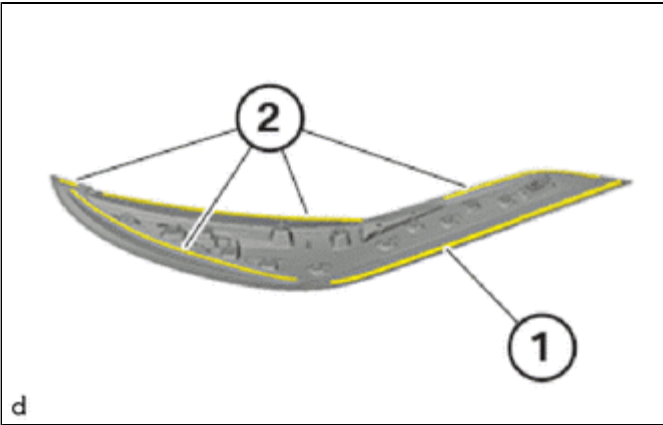
CAUTION / NOTICE / HINT

- HINT:**
- Use the same procedure for both the LH and RH sides.
 - The procedure described below is for the LH side.

PROCEDURE

1. REMOVE BODY OUTSIDE MOULDING PAD

(a) Remove the body outside moulding pad (1) and (2).

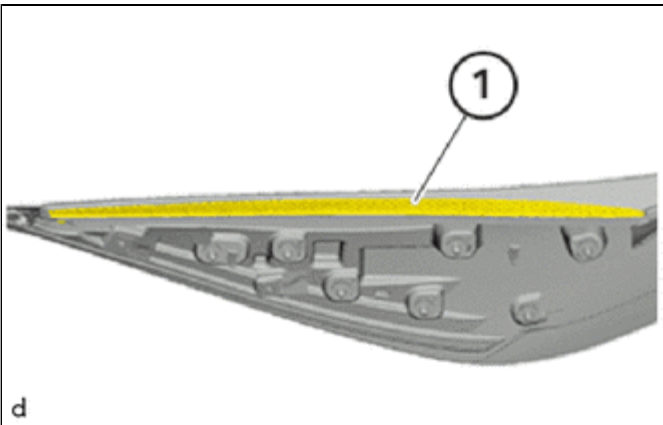


(b) Clean the adhesive area with cleaner.

- Cleaner:
- Cleaner R2

2. REMOVE FRONT DOOR REAR OUTSIDE MOULDING

(a) Remove the front door rear outside moulding (1).





Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCNG
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: FRONT DOOR OUTSIDE MOULDING: REASSEMBLY; 2020 MY Supra [03/2019 -]		

REASSEMBLY

CAUTION / NOTICE / HINT

HINT:

- Use the same procedure for both the LH and RH sides.
- The procedure described below is for the LH side.

PROCEDURE

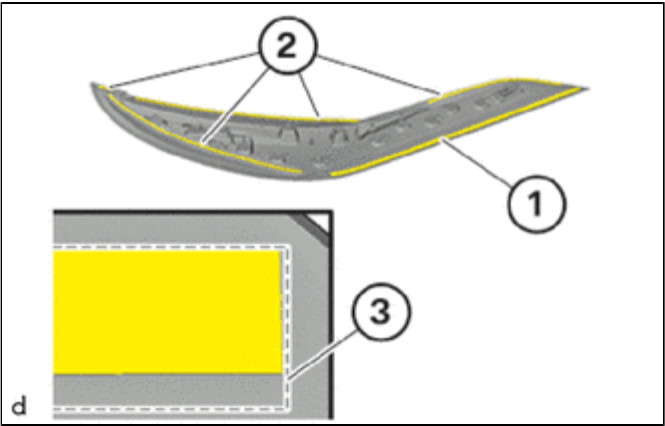
1. INSTALL FRONT DOOR REAR OUTSIDE MOULDING

- (a) Install the front door rear outside moulding.

2. INSTALL BODY OUTSIDE MOULDING PAD

- (a) Replace the body outside moulding pad.

- (b) Cut and shorten body outside moulding pad (1) and (2) according to the marks.



- (c) Install the body outside moulding pad (1) and (2) along the marker line (3) that lies near the component center.

Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCNH
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: FRONT DOOR OUTSIDE MOULDING: INSTALLATION; 2020 MY Supra [03/2019 -]		

INSTALLATION

CAUTION / NOTICE / HINT

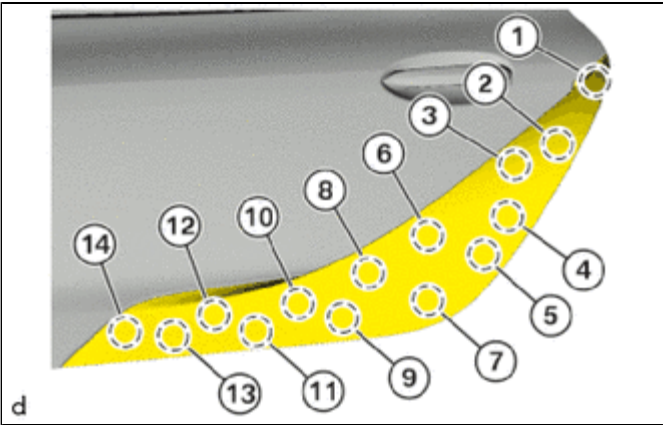
HINT:

- Use the same procedure for both the LH and RH sides.
- The procedure described below is for the LH side.

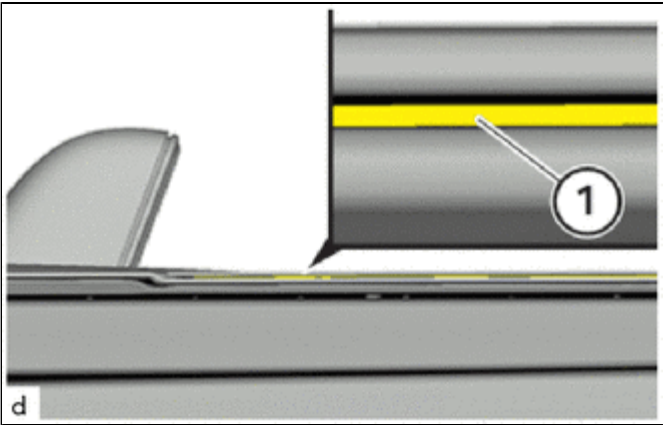
PROCEDURE

1. INSTALL FRONT DOOR OUTSIDE MOULDING SUB-ASSEMBLY

(a) Peel off the liner from adhesive tape.



(b) Engage the clips in the order as shown the illustration, and install the front door outside moulding sub-assembly.

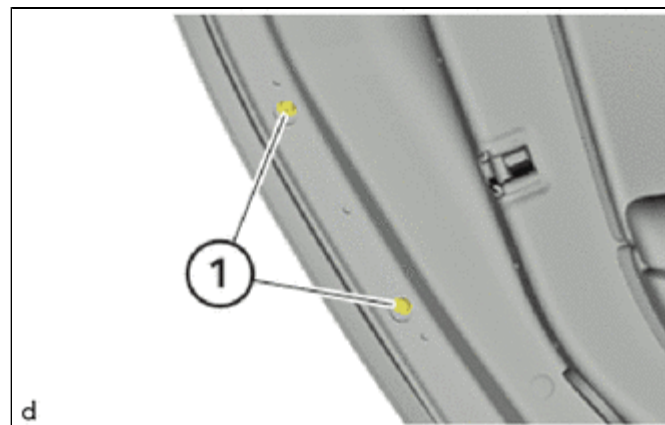


(c) Press on adhesive strip (1) tightly by hand in sections.

(d) Install the screws (1).

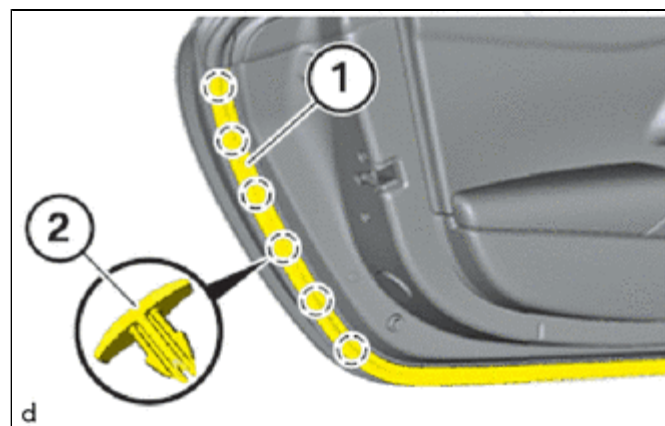
Torque:

3.0 N·m {31 kgf·cm, 27 in·lbf}



2. INSTALL FRONT DOOR WEATHERSTRIP

(a) Engage the clips to install the front door weatherstrip (1).

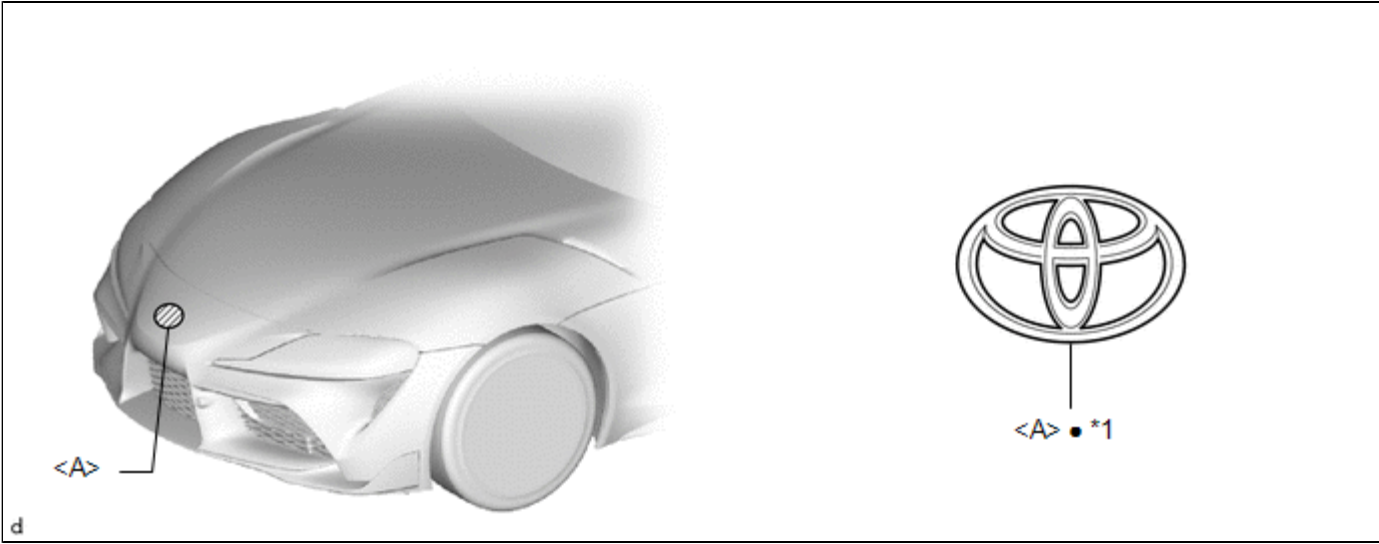


TOYOTA

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Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: NAME PLATE: COMPONENTS; 2020 MY Supra [03/2019 -]		

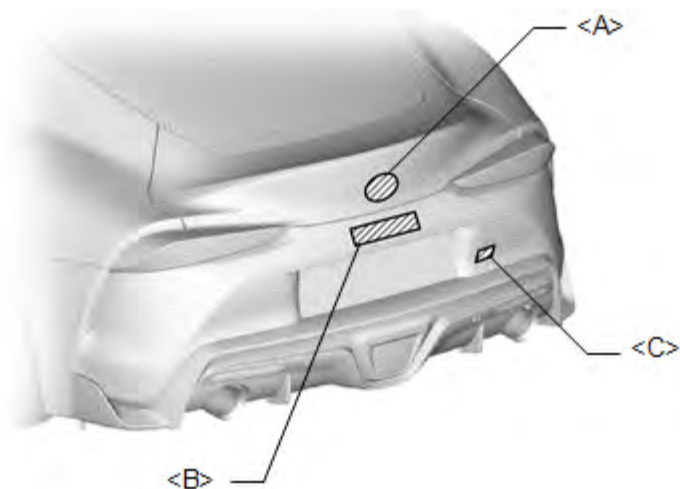
COMPONENTS

ILLUSTRATION



*1	FRONT BUMPER EMBLEM SUB-ASSEMBLY	-	-
•	Non-reusable part	-	-

ILLUSTRATION



d

*1	NO. 1 BACK DOOR EMBLEM	*2	SYMBOL EMBLEM
*3	NAME PLATE	-	-
•	Non-reusable part	-	-



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Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: NAME PLATE: REMOVAL; 2020 MY Supra [03/2019 -]		

REMOVAL

CAUTION / NOTICE / HINT

NOTICE:

- Tools and sharp-edged components can cause scratches.
 - Protect working area.
 - Handle tools and components carefully.

PROCEDURE

1. REMOVE FRONT BUMPER EMBLEM SUB-ASSEMBLY

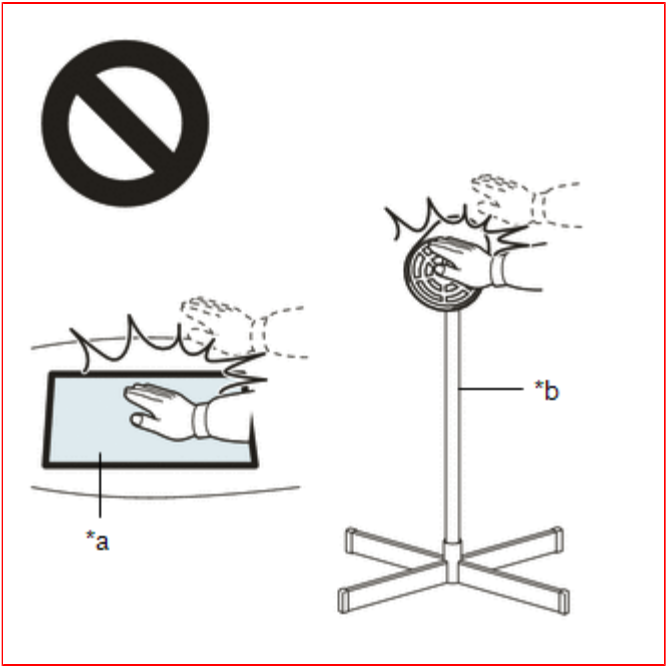
HINT:

When removing the front bumper emblem sub-assembly, heat the front bumper emblem sub-assembly using a heat light.

Standard:

ITEM	TEMPERATURE
Front Bumper Emblem Sub-assembly	40 to 50°C (104 to 122°F)

CAUTION:



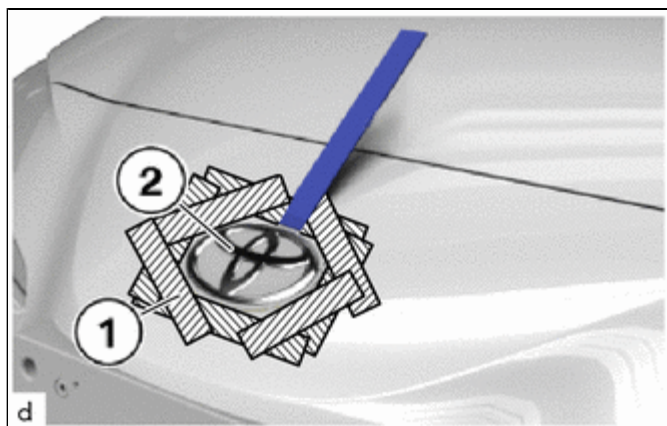
- Touching heated parts for a long time may result in burns.

*a	Heated Part
*b	Heat Light
- Do not touch the heat light and heated parts, touching the heat light may result in burns.

NOTICE:

Do not heat the front bumper emblem sub-assembly excessively.

(a) Tape off working area (1) around front bumper emblem sub-assembly (2) with protective tape.



Protective Tape

(b) Using a moulding remover A, remove the front bumper emblem sub-assembly (2).

(c) Remove the protective tape.

2. REMOVE NO. 1 BACK DOOR EMBLEM

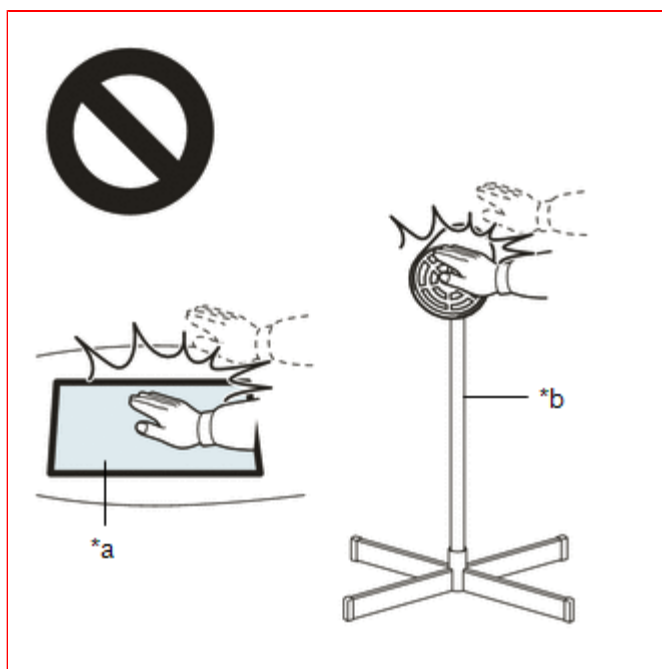
HINT:

When removing the No. 1 back door emblem, heat the No. 1 back door emblem using a heat light.

Standard:

ITEM	TEMPERATURE
No. 1 Back Door Emblem	40 to 50°C (104 to 122°F)

CAUTION:



- Touching heated parts for a long time may result in burns.

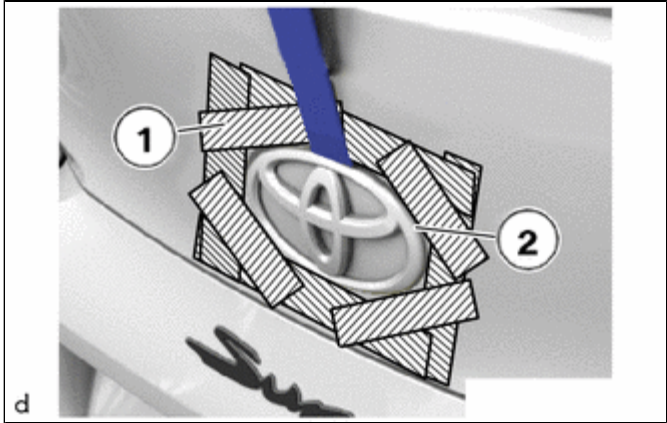
*a	Heated Part
*b	Heat Light

- Do not touch the heat light and heated parts, touching the heat light may result in burns.

NOTICE:

Do not heat the No. 1 back door emblem excessively.

(a) Tape off working area (1) around No. 1 back door emblem (2) with protective tape.



	Protective Tape
--	-----------------

- (b) Using a moulding remover A, remove the No. 1 back door emblem (2).
- (c) Remove the protective tape.

3. REMOVE NAME PLATE

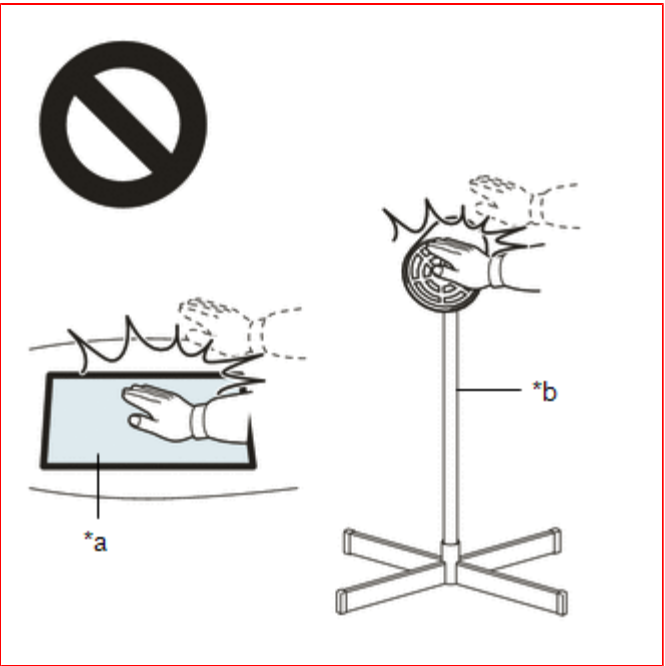
HINT:

When removing the name plate, heat the name plate using a heat light.

Standard:

ITEM	TEMPERATURE
Name Plate	40 to 50°C (104 to 122°F)

CAUTION:



- Touching heated parts for a long time may result in burns.

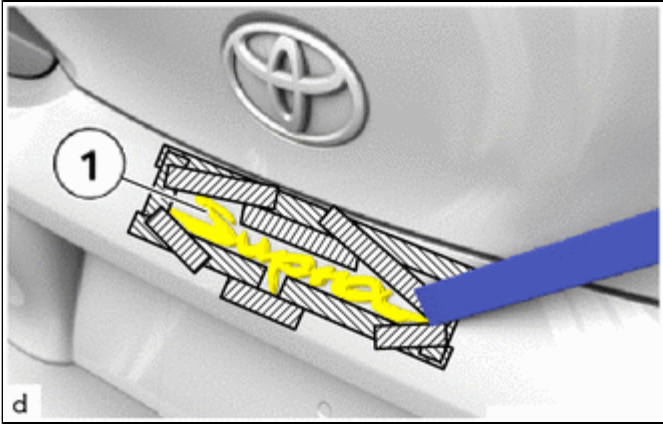
*a	Heated Part
*b	Heat Light

- Do not touch the heat light and heated parts, touching the heat light may result in burns.

NOTICE:

Do not heat the name plate excessively.

(a) Tape off the working area around the name plate (1) with protective tape.



	Protective Tape
--	-----------------

(b) Using a moulding remover A, remove the name plate (1).

(c) Remove the protective tape.

4. REMOVE SYMBOL EMBLEM

HINT:

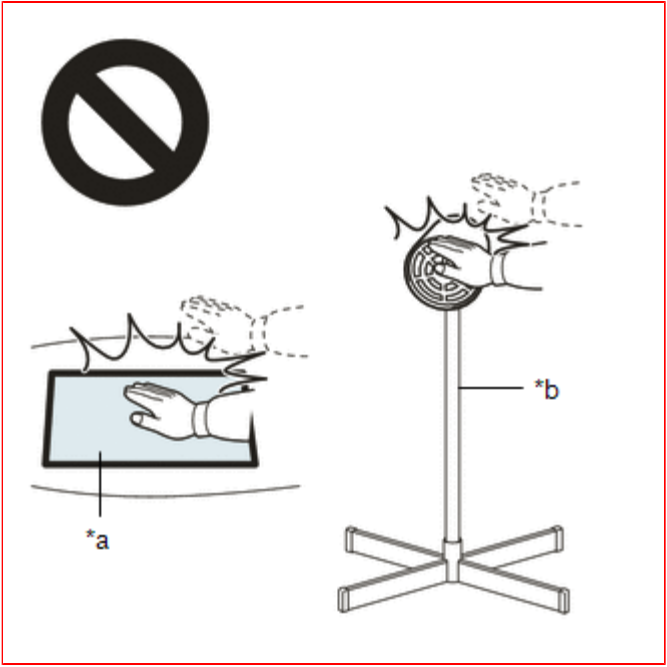
When removing the symbol emblem, heat the symbol emblem using a heat light.

Standard:

ITEM	TEMPERATURE
------	-------------

Symbol Emblem	40 to 50°C (104 to 122°F)
---------------	---------------------------

CAUTION:

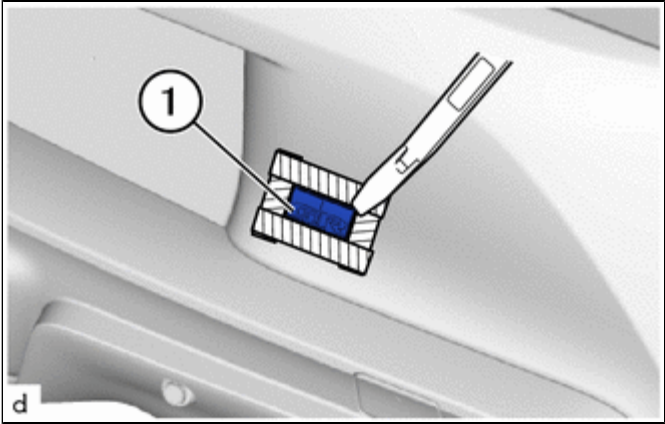


- Touching heated parts for a long time may result in burns.
- | | |
|----|-------------|
| *a | Heated Part |
| *b | Heat Light |
- Do not touch the heat light and heated parts, touching the heat light may result in burns.

NOTICE:

Do not heat the symbol emblem excessively.

(a) Tape off the working area around the symbol emblem (1) with protective tape.



	Protective Tape
--	-----------------

- (b) Using a moulding remover A, remove the symbol emblem (1).
- (c) Remove the protective tape.

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Title: EXTERIOR PANELS / TRIM: NAME PLATE: INSTALLATION; 2020 MY Supra [03/2019 -]		

INSTALLATION

PROCEDURE

1. INSTALL SYMBOL EMBLEM

(a) Remove the adhesive residue on the rear bumper assembly and clean the adhesive area with cleaner.

Cleaner:
Cleaner R2

(b) Install the replace symbol emblem.

(1) Remove the peeling paper from the face of the symbol emblem.

HINT:

After removing the peeling paper, keep the exposed adhesive free from foreign matter.

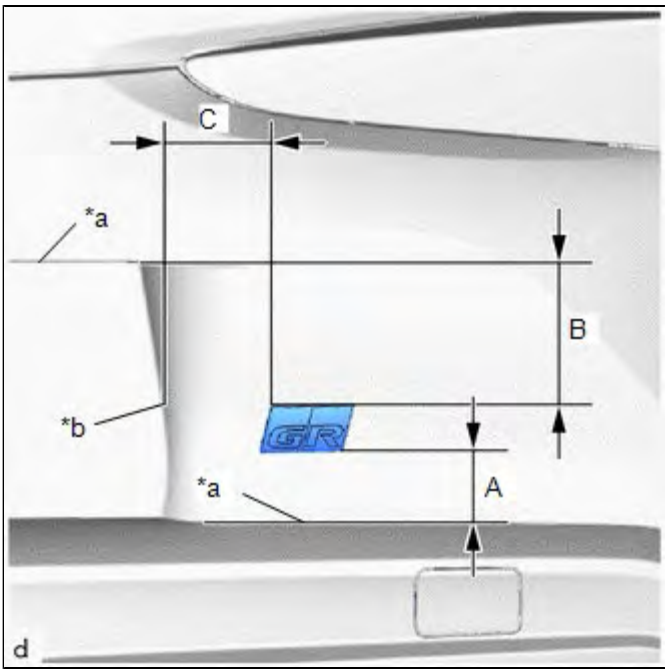
(2) Install the symbol emblem in the position shown in the illustration.

HINT:

Press the symbol emblem firmly to install it.

Standard:

AREA	SPECIFIED CONDITION
A	40.9 mm (1.61 in.)
B	91.6 mm (3.61 in.)
C	84.6 mm (3.33 in.)



*a	Rear Bumper Assembly Edge
*b	Rear Bumper Assembly End of R

2. INSTALL NAME PLATE

(a) Remove the adhesive residue on the rear bumper assembly and clean the adhesive area with the cleaner.

Cleaner:
Cleaner R2

(b) Install the replace name plate.

(1) Remove the peeling paper from the face of the name plate.

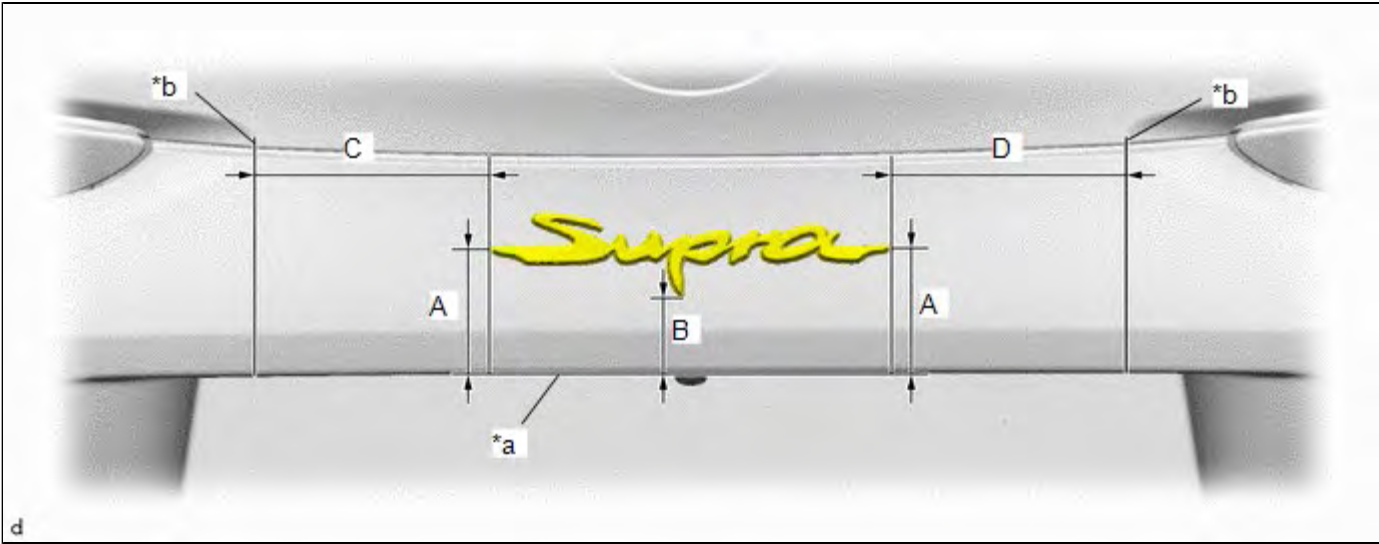
HINT:

After removing the peeling paper, keep the exposed adhesive free from foreign matter.

(2) Install the name plate in the position shown in the illustration.

HINT:

Press the name plate firmly to install it.



*a	Rear Bumper Assembly Edge	*b	Rear Bumper Assembly End of R
----	---------------------------	----	-------------------------------

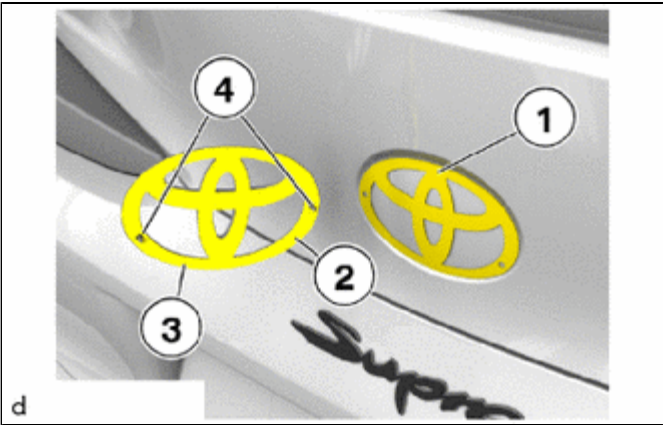
Standard:

AREA	SPECIFIED CONDITION
A	65 mm (2.56 in.)
B	40 mm (1.57 in.)
C	131 mm (5.16 in.)
D	138 mm (5.43 in.)

3. INSTALL NO. 1 BACK DOOR EMBLEM

(a) Remove adhesive residue on the tailgate and clean the adhesive area (1) with cleaner.

Cleaner:
Cleaner R2



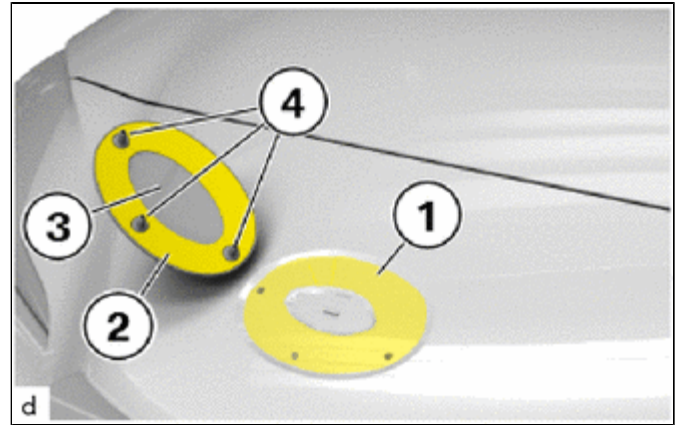
(b) Peel off the liner from the adhesive tape (2).
(c) Install a new No. 1 back door emblem (3) using the guides (4) and press it on tightly.

4. INSTALL FRONT BUMPER EMBLEM SUB-ASSEMBLY

- (a) Remove glue residue from the bumper panel and clean the adhesive area (1) with cleaner.

Cleaner:

Cleaner R2



- (b) Peel off the liner from the adhesive tape (2).

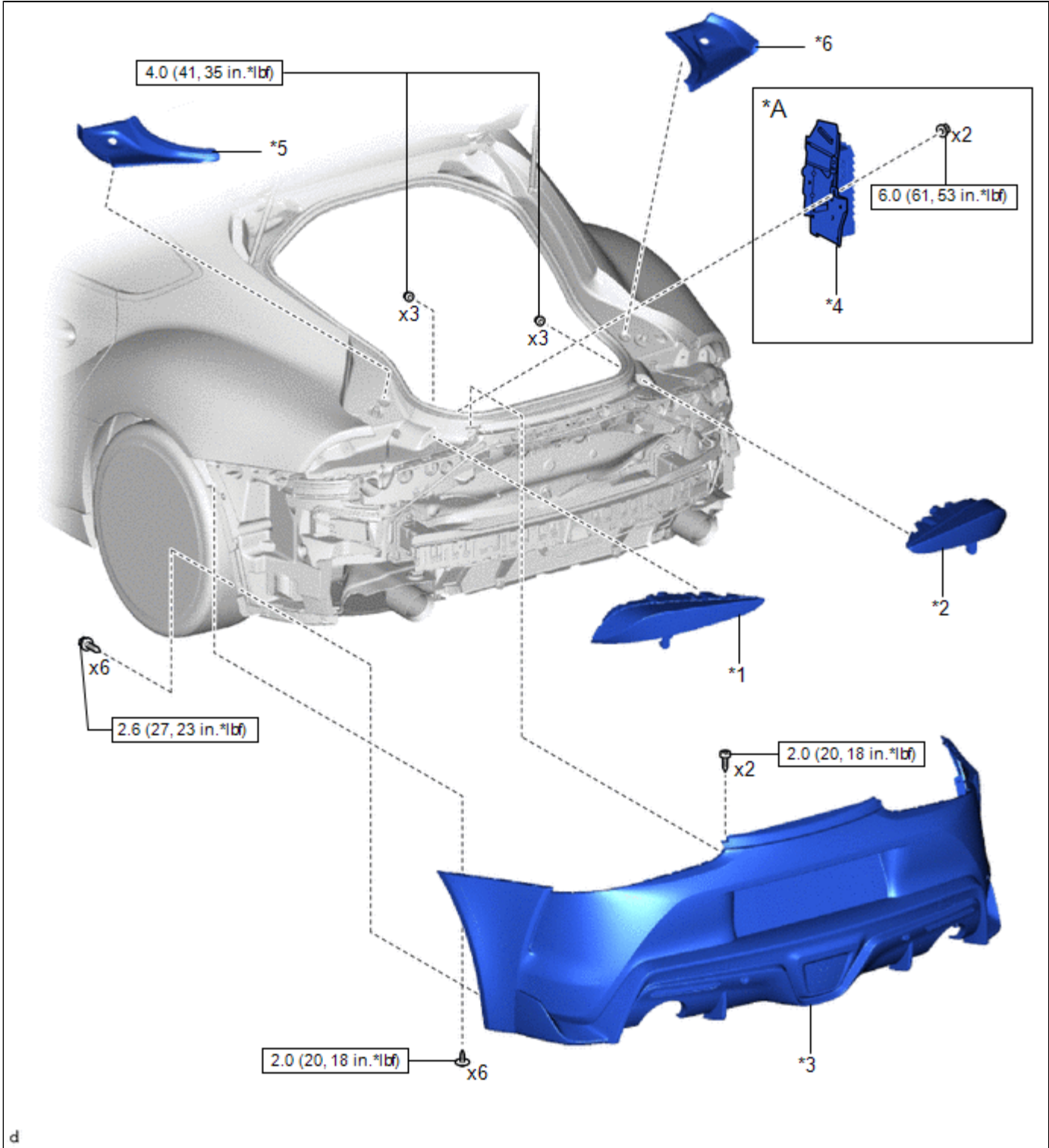
- (c) Install a new front bumper emblem sub-assembly (3) using the guides (4) and press it on tightly.



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Title: EXTERIOR PANELS / TRIM: REAR BUMPER: COMPONENTS; 2020 MY Supra [03/2019 -]		

COMPONENTS

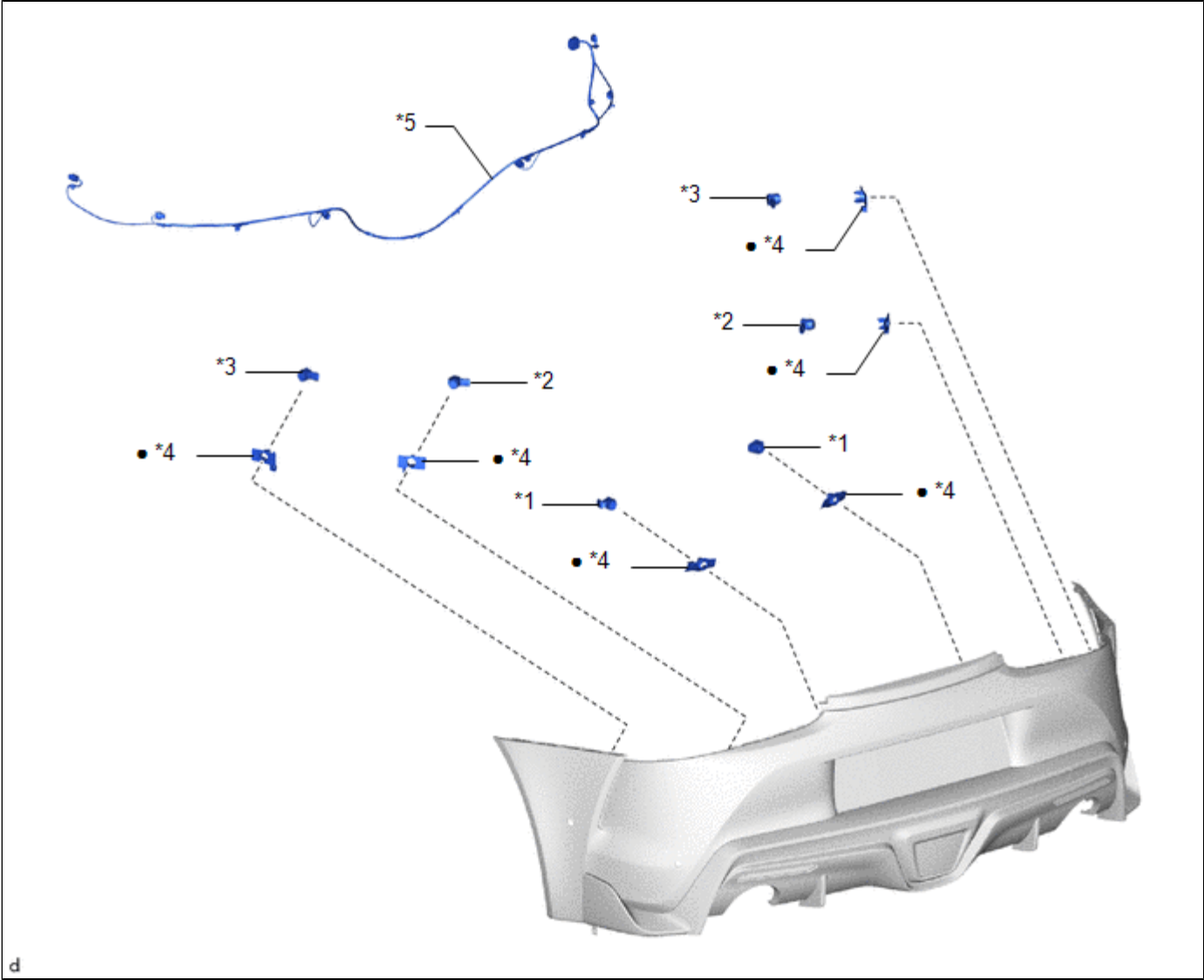
ILLUSTRATION



*A	w/ Stereo Component Amplifier	-	-
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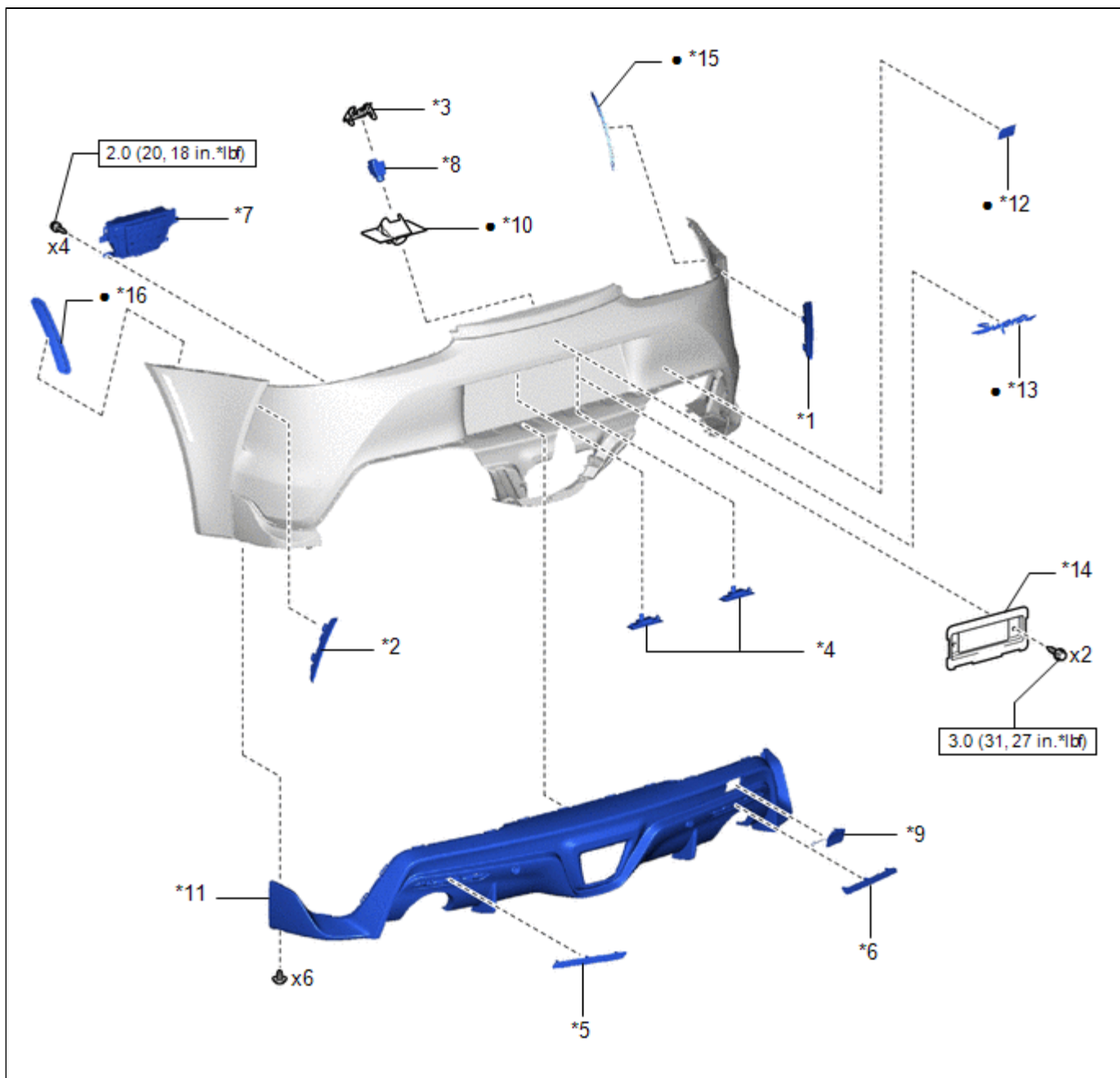
*1	REAR COMBINATION LIGHT ASSEMBLY LH	*2	REAR COMBINATION LIGHT ASSEMBLY RH
*3	REAR BUMPER ASSEMBLY	*4	STEREO COMPONENT AMPLIFIER ASSEMBLY WITH BRACKET
*5	BACK DOOR SIDE GARNISH LH	*6	BACK DOOR SIDE GARNISH RH
	N*m (kgf*cm, ft.*lbf): Specified torque	-	-

ILLUSTRATION



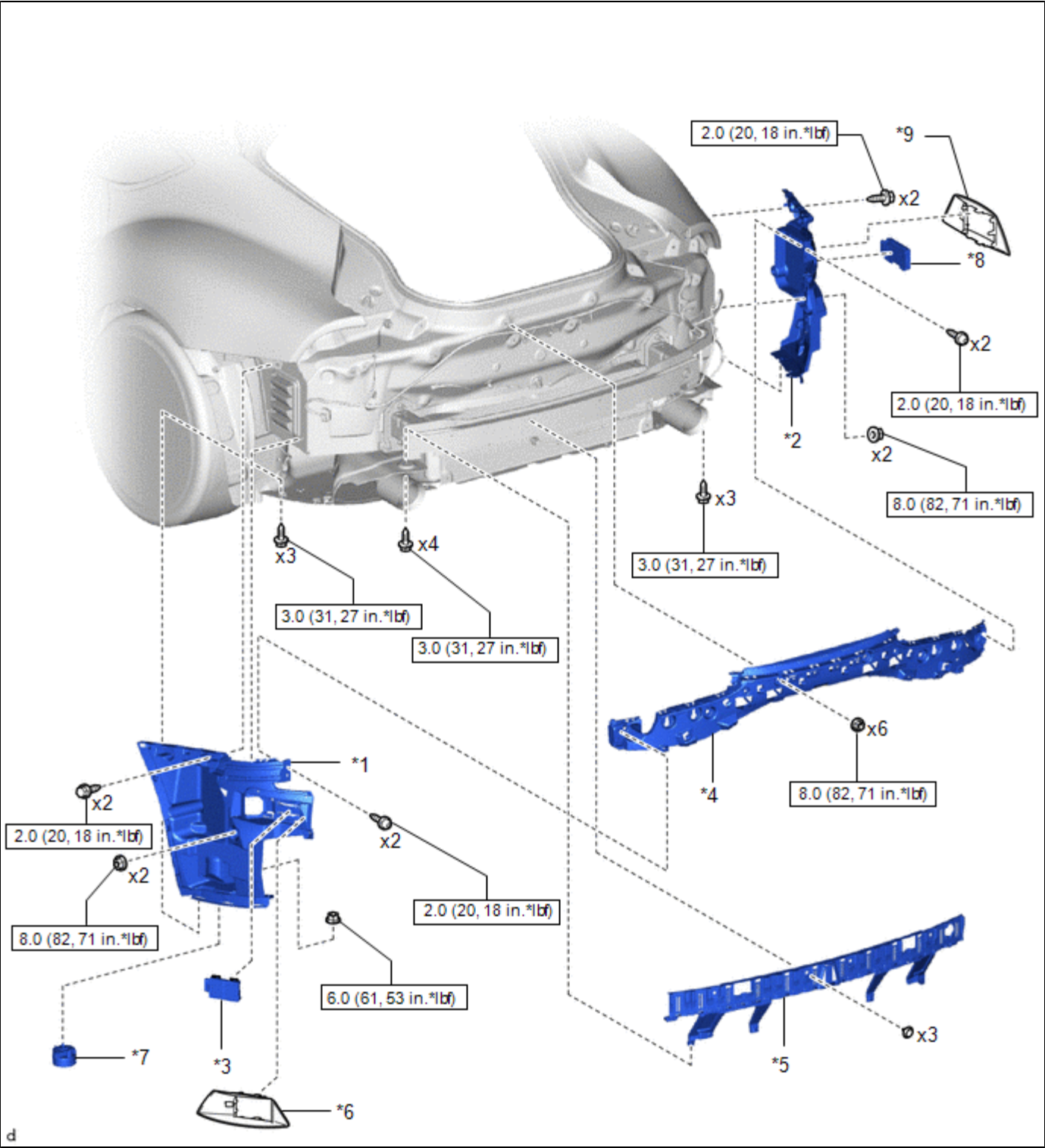
*1	REAR CENTER ULTRASONIC SENSOR	*2	REAR CORNER ULTRASONIC SENSOR
*3	REAR SIDE ULTRASONIC SENSOR	*4	NO. 2 ULTRASONIC SENSOR RETAINER
*5	WIRING HARNESS	-	-
●	Non-reusable part	-	-

ILLUSTRATION



*1	AIR INLET TRIM STRIP RH	*2	AIR INLET TRIM STRIP LH
*3	HOLDER	*4	LICENSE PLATE LIGHT ASSEMBLY
*5	REFLEX REFLECTOR ASSEMBLY LH	*6	REFLEX REFLECTOR ASSEMBLY RH
*7	BACK-UP LIGHT ASSEMBLY	*8	TELEVISION CAMERA ASSEMBLY
*9	REAR BUMPER PLATE RH	*10	BRACKET FOR REAR VIEW CAMERA
*11	REAR BUMPER COVER LOWER SECTION	*12	SYMBOL EMBLEM
*13	NAME PLATE	*14	REAR REGISTRATION PLATE
*15	REFLECTOR RH	*16	REFLECTOR LH
	N*m (kgf*cm, ft.*lbf): Specified torque	•	Non-reusable part

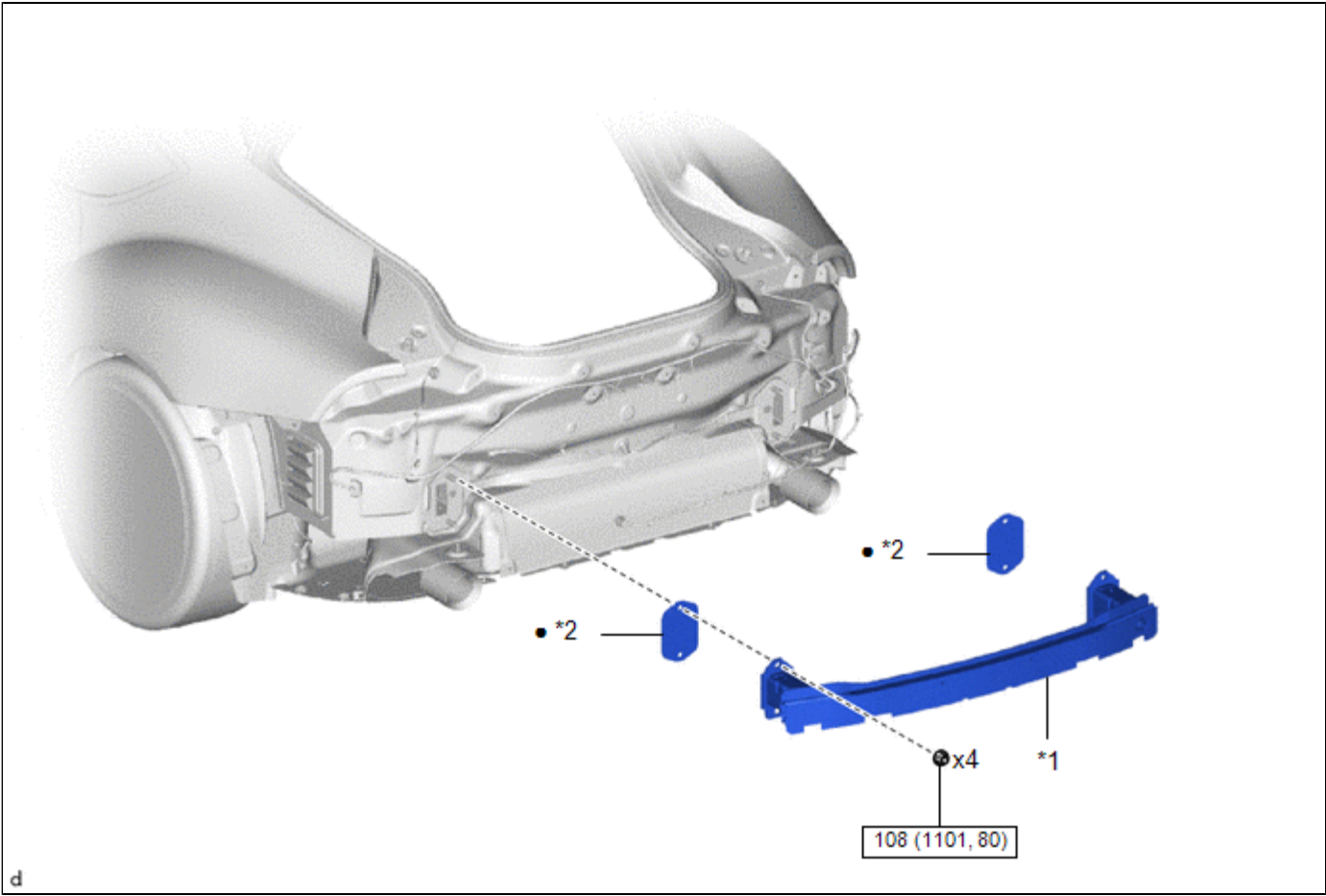
ILLUSTRATION



*1	REAR BUMPER SIDE SUPPORT SUB-ASSEMBLY LH	*2	REAR BUMPER SIDE SUPPORT SUB-ASSEMBLY RH
*3	BLIND SPOT MONITOR SENSOR LH	*4	NO. 1 REAR BUMPER SUPPORT
*5	REAR BUMPER ENERGY ABSORBER	*6	ABSORBER FUNNEL LH
*7	THEFT WARNING SIREN ASSEMBLY	*8	BLIND SPOT MONITOR SENSOR RH
*9	ABSORBER FUNNEL RH	-	-

	N*m (kgf*cm, ft.*lbf): Specified torque	-	-
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ILLUSTRATION



*1	REAR BUMPER REINFORCEMENT SUB-ASSEMBLY	*2	SEAL
	N*m (kgf*cm, ft.*lbf): Specified torque	•	Non-reusable part

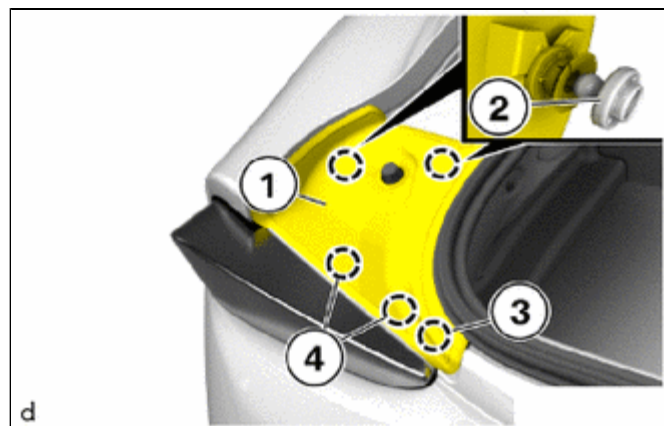
Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCMP
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Title: EXTERIOR PANELS / TRIM: REAR BUMPER: REMOVAL; 2020 MY Supra [03/2019 -]		

REMOVAL

PROCEDURE

1. REMOVE BACK DOOR SIDE GARNISH LH

(a) Disengage the pins (2) and claw (3).



(b) Disengage the guides to remove the back door side garnish LH (1).

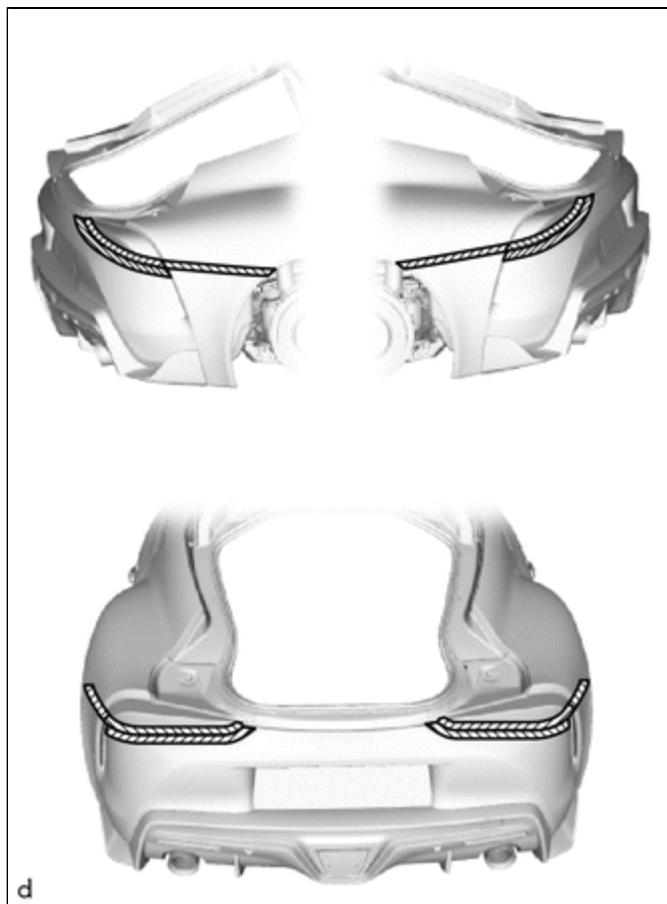
2. REMOVE BACK DOOR SIDE GARNISH RH

HINT:

Use the same procedure as for the LH side.

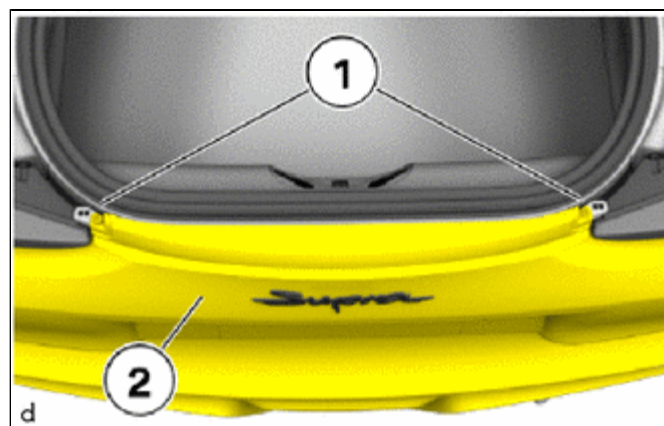
3. REMOVE REAR BUMPER ASSEMBLY

(a) Apply protective tape as shown in the illustration.



	Protective Tape
--	-----------------

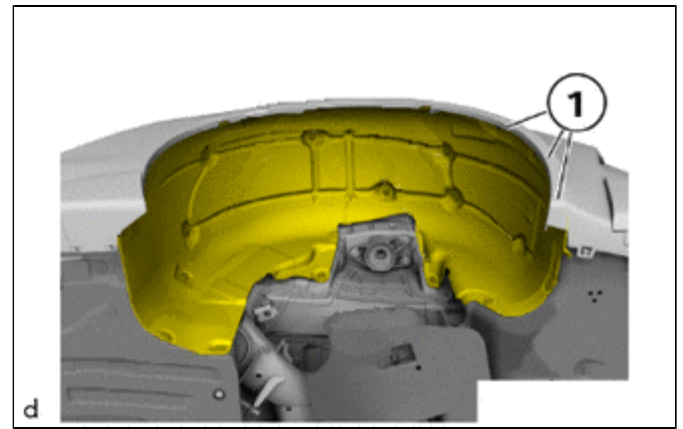
(b) Remove the T20 screws (1) on the rear bumper assembly (2).



(c) Remove the screws (1).

HINT:

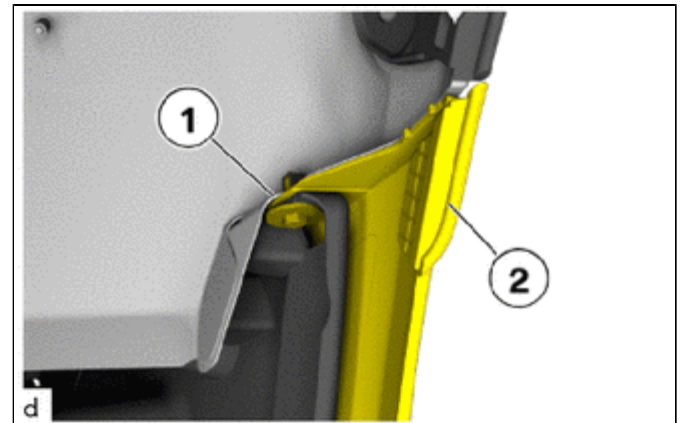
Perform the operations on the left and right side.



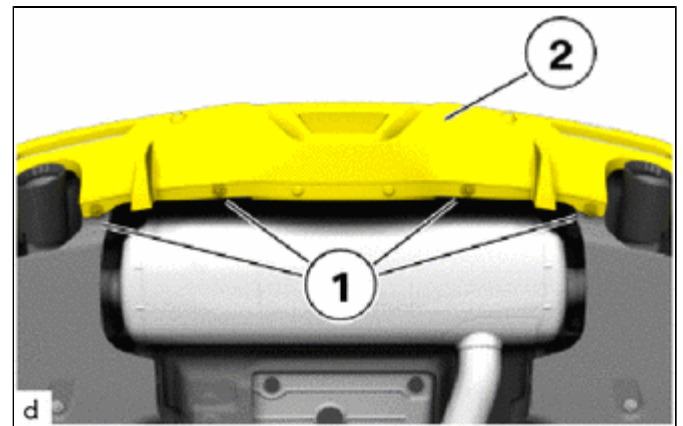
(d) Remove the screw (1) on the rear bumper assembly (2).

HINT:

Perform the operations on the left and right side.



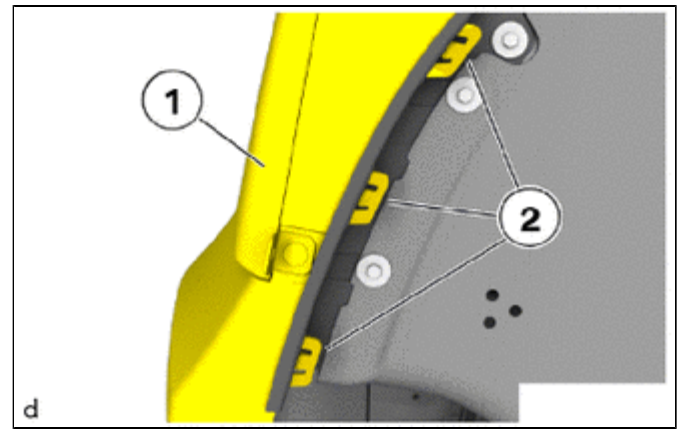
(e) Remove the screws (1) on the rear bumper assembly (2).



(f) Disengage the claws (2) on the rear bumper assembly (1).

HINT:

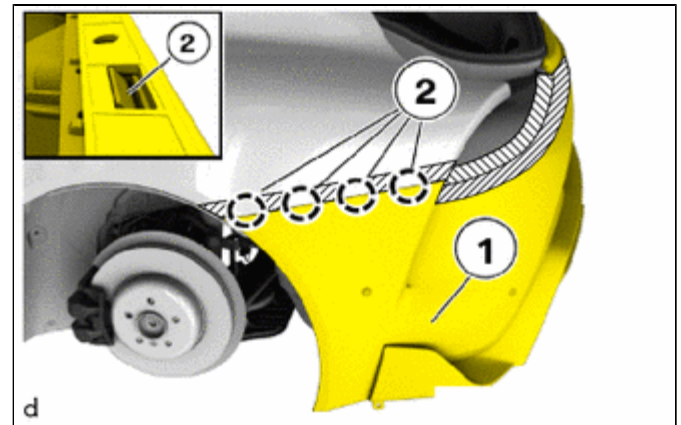
Perform the operations on the left and right side.



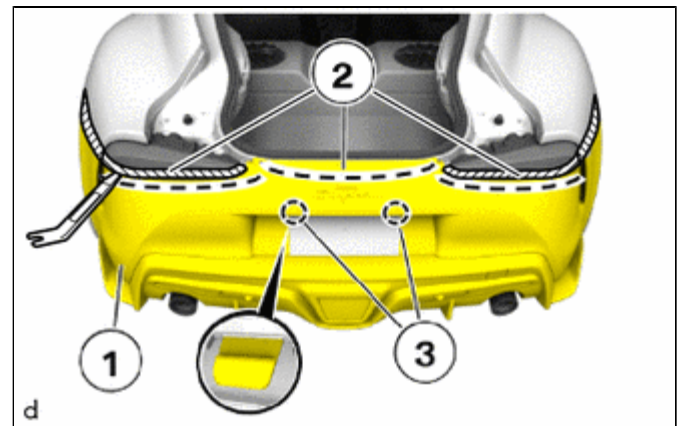
(g) Disengage the claws (2) on the rear bumper assembly (1).

HINT:

Perform the operations on the left and right side.



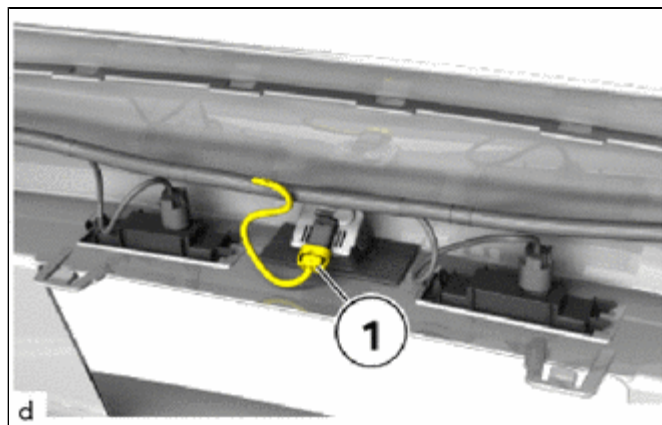
(h) Using a moulding remover E, disengage the claws (2).



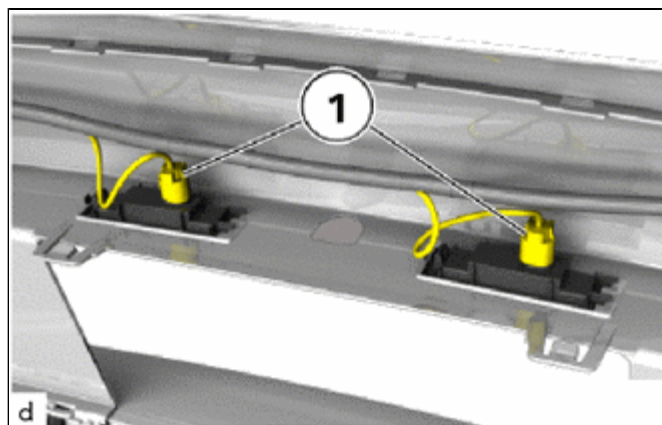
(i) Disengage the claws (3).

(j) Disconnect the rear bumper assembly (1).

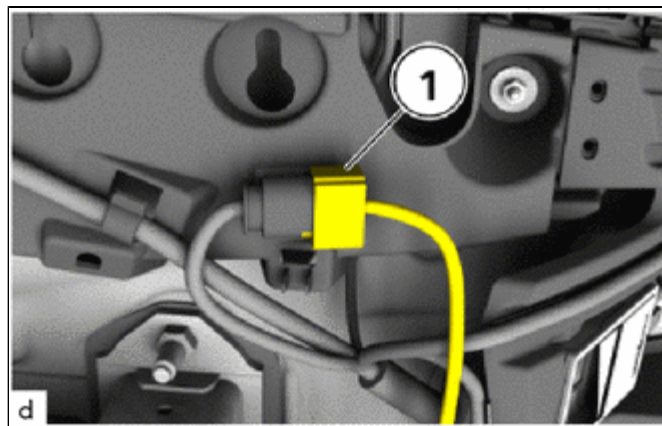
(k) Disconnect the connector (1).



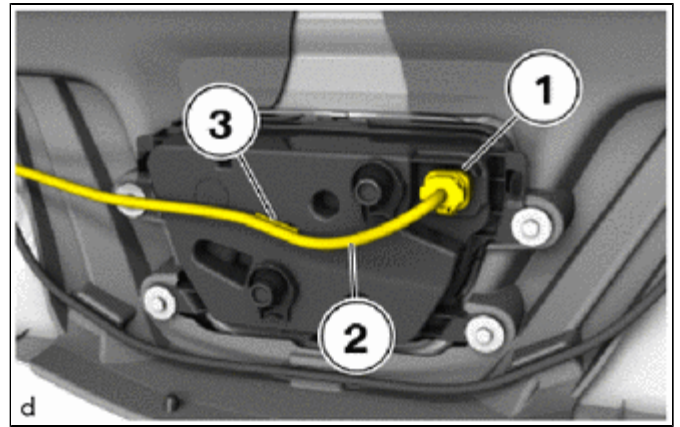
(l) Disconnect the connectors (1).



(m) Disconnect the connector (1).



(n) Disconnect the connector (1).



(o) Disengage the clamp (3) to disconnect the wiring harness (2).

(p) Remove rear bumper assembly.

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DISASSEMBLY

PROCEDURE

1. REMOVE DECK TRIM SIDE BOARD AND DECK SIDE TRIM COVER RH

Click here [INFO](#)

2. REMOVE STEREO COMPONENT AMPLIFIER ASSEMBLY WITH BRACKET (w/ Stereo Component Amplifier)

Click here [INFO](#)

3. REMOVE REAR COMBINATION LIGHT ASSEMBLY LH

Click here [INFO](#)

4. REMOVE REAR COMBINATION LIGHT ASSEMBLY RH

HINT:

Use the same procedure as for the LH side.

5. REMOVE REAR SIDE ULTRASONIC SENSOR

Click here [INFO](#)

6. REMOVE REAR CORNER ULTRASONIC SENSOR

HINT:

Use the same procedure as for the rear side ultrasonic sensor.

7. REMOVE REAR CENTER ULTRASONIC SENSOR

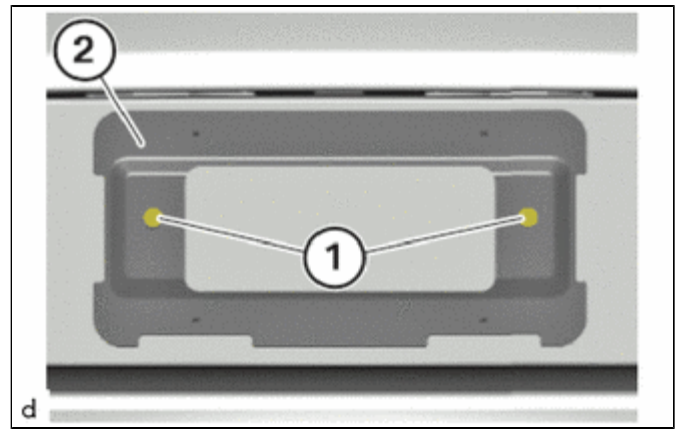
Click here [INFO](#)

8. REMOVE NO. 2 ULTRASONIC SENSOR RETAINER

Click here [INFO](#)

9. REMOVE REAR REGISTRATION PLATE

(a) Remove the screws (1).



(b) Remove rear registration plate (2).

10. REMOVE BACK-UP LIGHT ASSEMBLY

Click here [INFO](#)

11. REMOVE TELEVISION CAMERA ASSEMBLY

Click here [INFO](#)

12. REMOVE BRACKET FOR REAR VIEW CAMERA

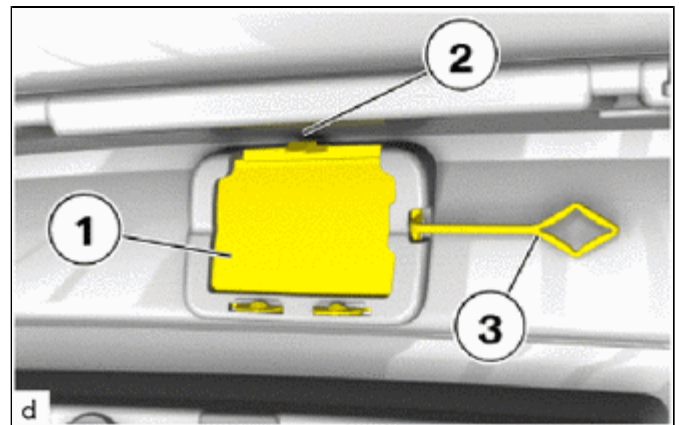
Click here [INFO](#)

13. REMOVE LICENSE PLATE LIGHT ASSEMBLY

Click here [INFO](#)

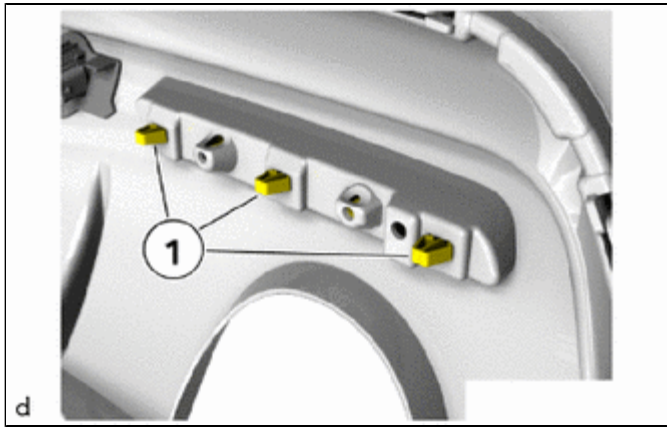
14. REMOVE REAR BUMPER PLATE RH

(a) Disengage the claw (2).



(b) Disengage the hook (3) to remove the rear bumper plate RH (1).

15. REMOVE REFLEX REFLECTOR ASSEMBLY LH



(a) Disengage claws (1) to remove the reflex reflector assembly LH.

16. REMOVE REFLEX REFLECTOR ASSEMBLY RH

HINT:
Use the same procedure as for the LH side.

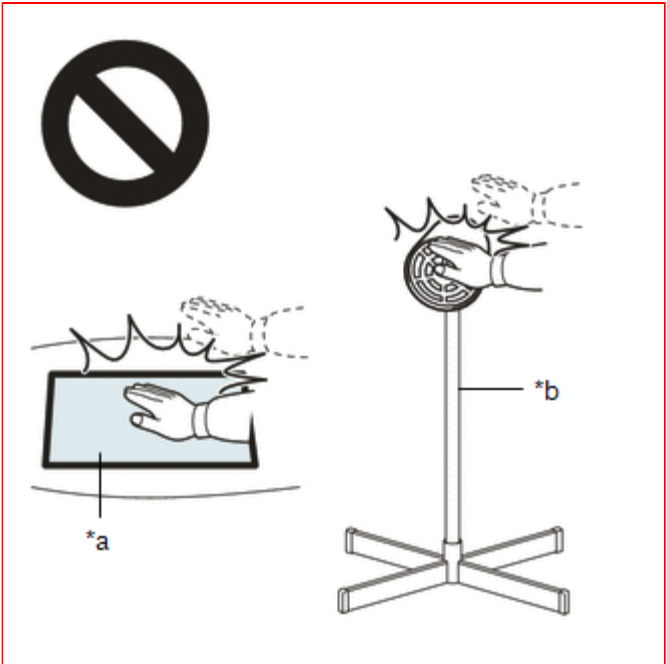
17. REMOVE REFLECTOR LH

HINT:
When removing the reflector LH, heat the reflector LH using a heat light.

Standard:

ITEM	TEMPERATURE
Reflector LH	40 to 50 °C (104 to 122 °F)

CAUTION:



- Touching heated parts for a long time may result in burns.

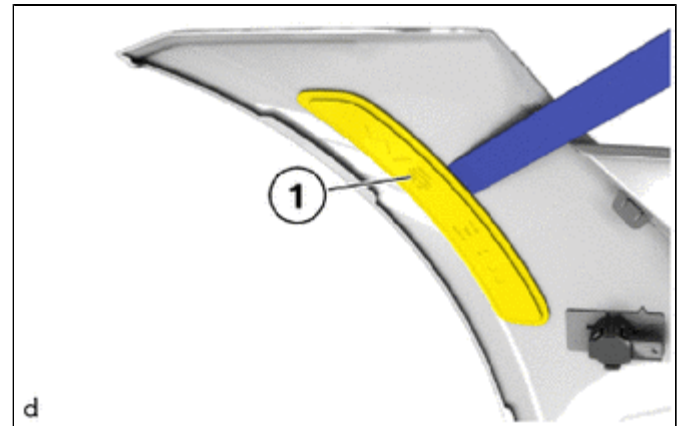
*a	Heated Part
*b	Heat Light

- Do not touch the heat light and heated parts, touching the heat light may result in burns.

NOTICE:

Do not heat the reflector LH excessively.

(a) Using a moulding remover A, remove the reflector LH (1).



18. REMOVE REFLECTOR RH

HINT:

Use the same procedure as for the LH side.

19. REMOVE NAME PLATE

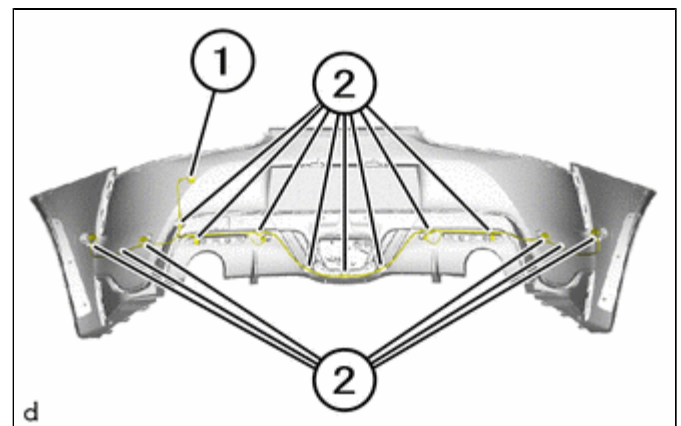
Click here [INFO](#)

20. REMOVE SYMBOL EMBLEM

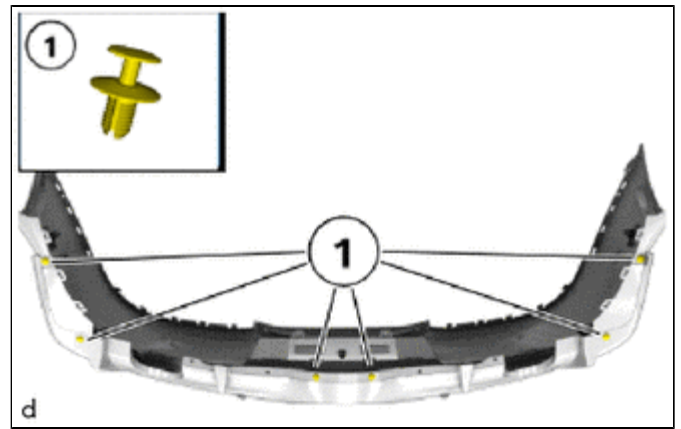
Click here [INFO](#)

21. REMOVE REAR BUMPER COVER LOWER SECTION

(a) Disengage the clamps to remove the wiring harness (1).



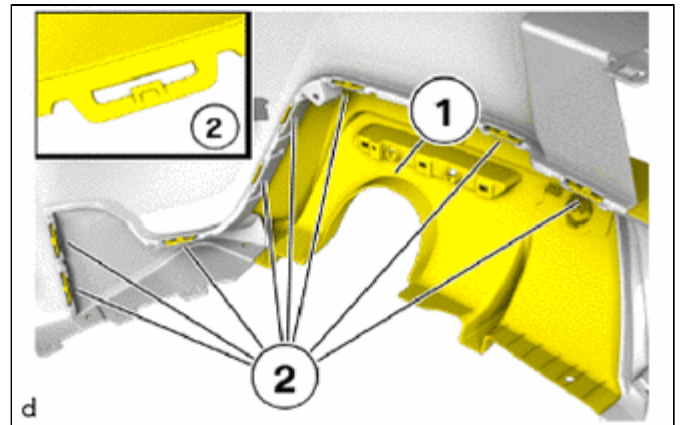
(b) Remove the clips (1).



(c) Disengage the claws (2).

HINT:

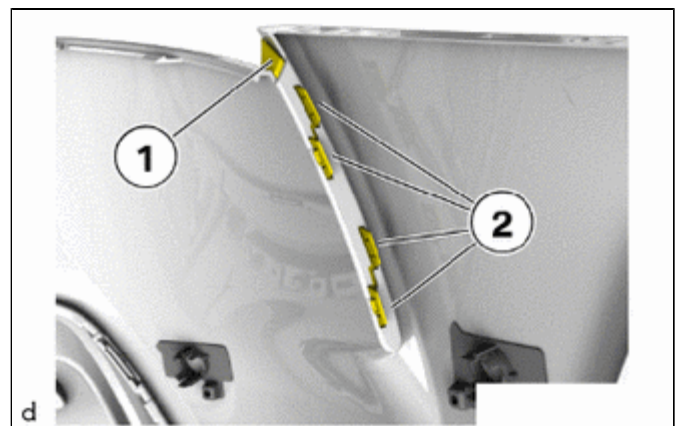
Perform the operations on the left and right side.



(d) Remove the rear bumper cover lower section (1).

22. REMOVE AIR INLET TRIM STRIP LH

(a) Disengage the claws (2) to remove the air inlet trim strip LH (1).



23. REMOVE AIR INLET TRIM STRIP RH

HINT:

Use the same procedure as for the LH side.

24. REMOVE ABSORBER FUNNEL LH

Click here [INFO](#)

25. REMOVE ABSORBER FUNNEL RH

HINT:

Use the same procedure as for the LH side.

26. REMOVE BLIND SPOT MONITOR SENSOR LH

Click here [INFO](#)

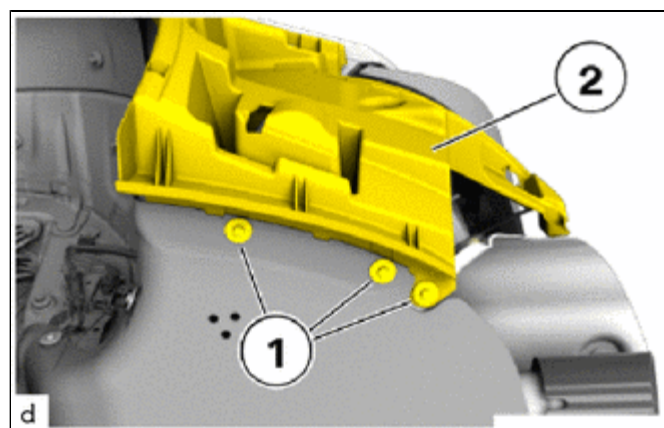
27. REMOVE BLIND SPOT MONITOR SENSOR RH

HINT:

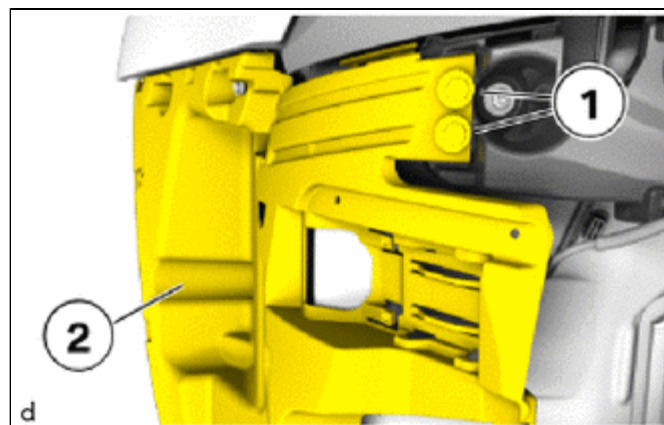
Use the same procedure as for the LH side.

28. REMOVE REAR BUMPER SIDE SUPPORT SUB-ASSEMBLY LH

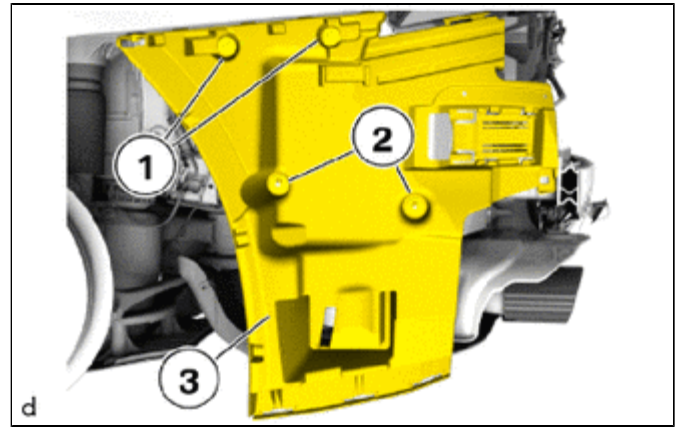
- (a) Remove the screws (1) on the rear bumper side support sub-assembly LH (2).



- (b) Remove the T20 screws (1) on the rear bumper side support sub-assembly LH (2).

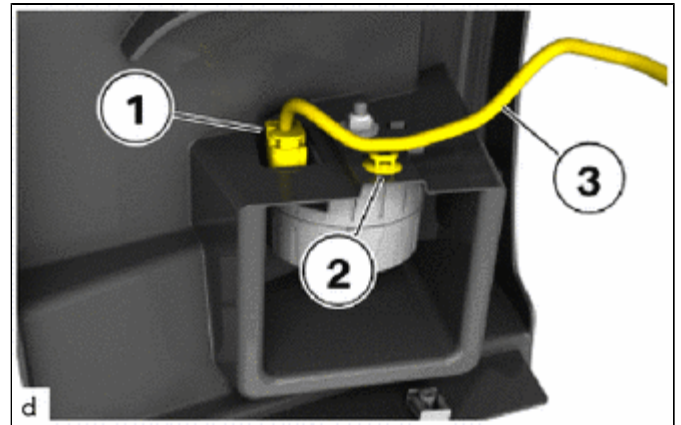


(c) Remove the screws (1).



(d) Remove the nuts (2).

(e) Remove the rear bumper side support sub-assembly LH (3).



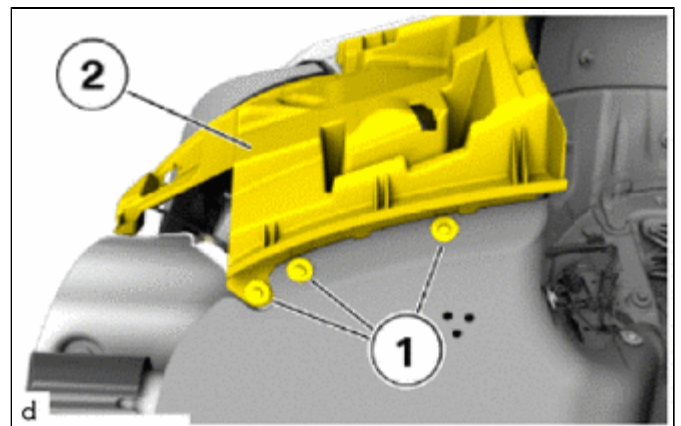
(g) Disconnect the connector (1) and wiring harness (3) to remove the rear bumper side support sub-assembly LH.

29. REMOVE THEFT WARNING SIREN ASSEMBLY

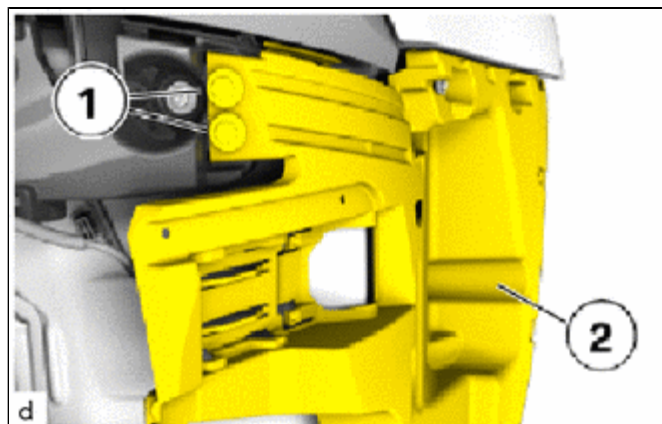
Click here [INFO](#)

30. REMOVE REAR BUMPER SIDE SUPPORT SUB-ASSEMBLY RH

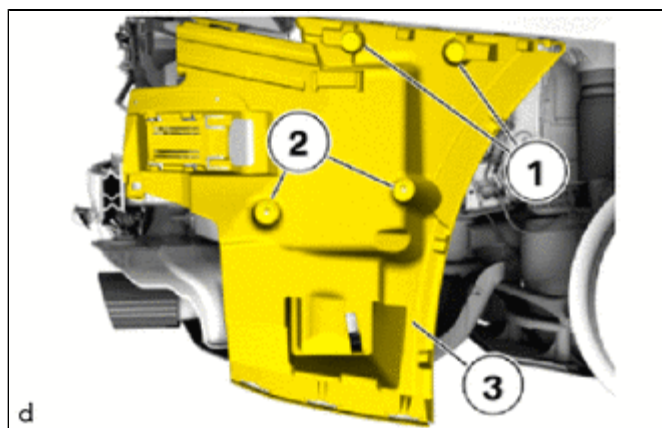
(a) Remove the screws (1) on the rear bumper side support sub-assembly RH (2).



- (b) Remove the T20 screws (1) on the rear bumper side support sub-assembly RH (2).



- (c) Remove the screws (1).

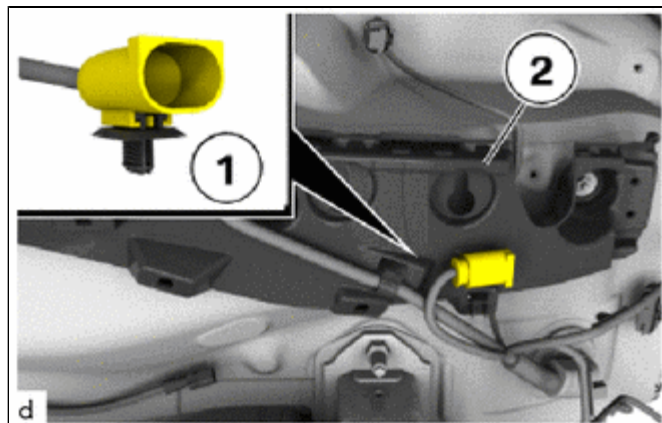


- (d) Remove the nuts (2).

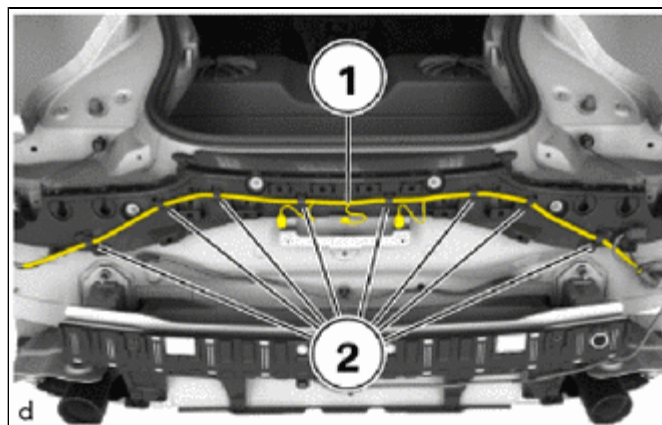
- (e) Remove the rear bumper side support sub-assembly RH (3).

31. REMOVE NO. 1 REAR BUMPER SUPPORT

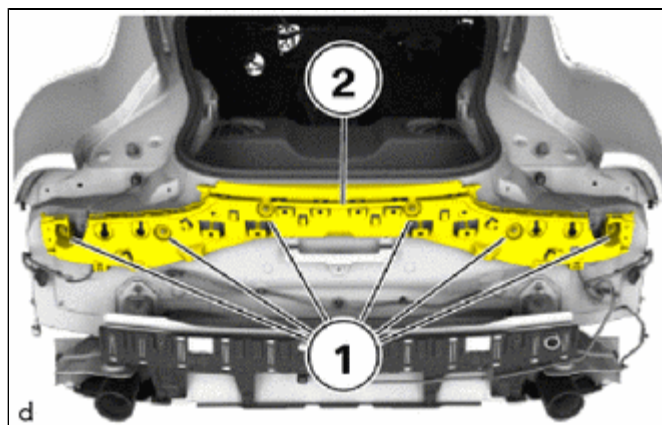
- (a) Disengage the clamp (1) to the guide for the No. 1 rear bumper support (2).



(b) Disconnect the wiring harness (1) from the holders (2).

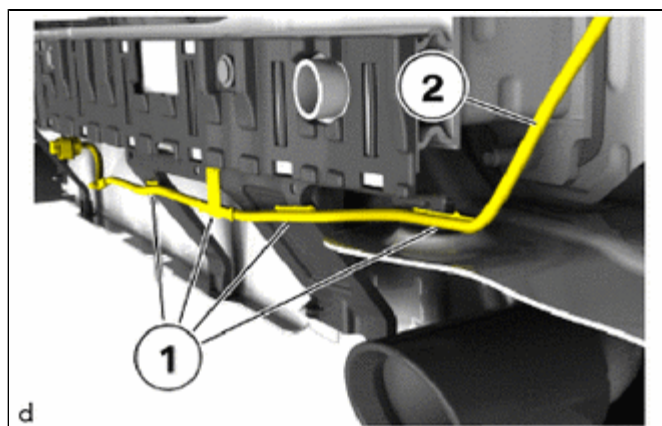


(c) Remove the nuts (1) and guide for the No. 1 rear bumper support (2).

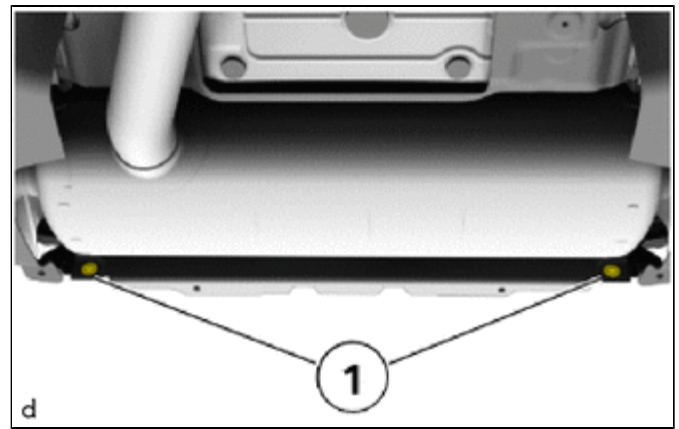


32. REMOVE REAR BUMPER ENERGY ABSORBER

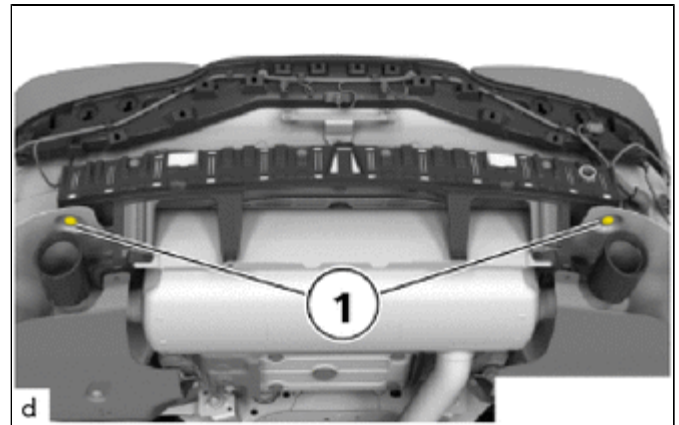
(a) Disengage the clamps (1) to disconnect the wiring harness (2).



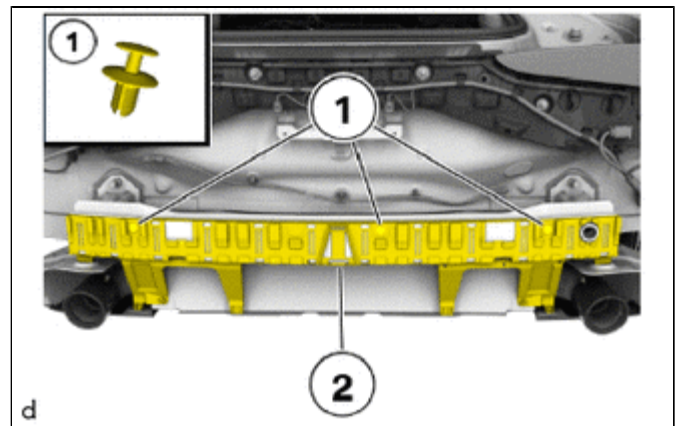
(b) Remove the screws (1).



(c) Remove the screws (1).

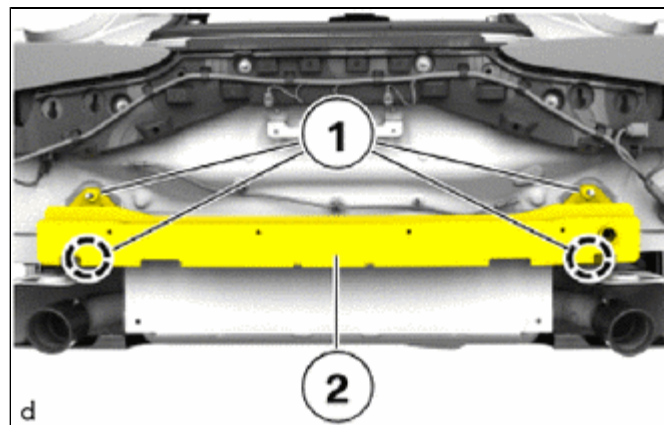


(d) Remove the clips (1) and rear bumper energy absorber (2).



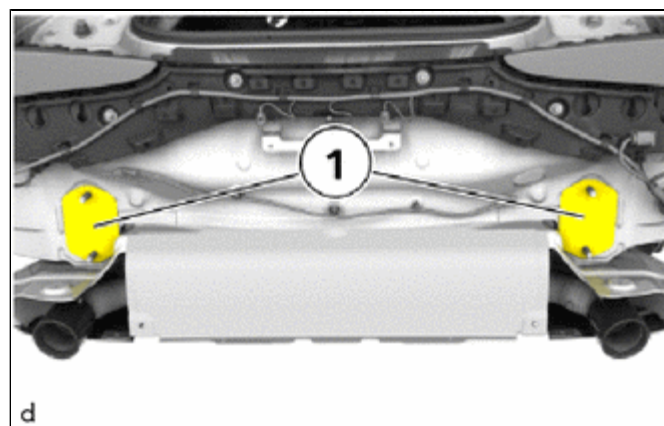
33. REMOVE REAR BUMPER REINFORCEMENT SUB-ASSEMBLY

(a) Using a deep socket wrench 18 mm, remove the 18 mm nuts (1).



(b) Remove the rear bumper reinforcement sub-assembly (2).

(c) Remove the seals (1).



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Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: REAR BUMPER: REASSEMBLY; 2020 MY Supra [03/2019 -]		

REASSEMBLY

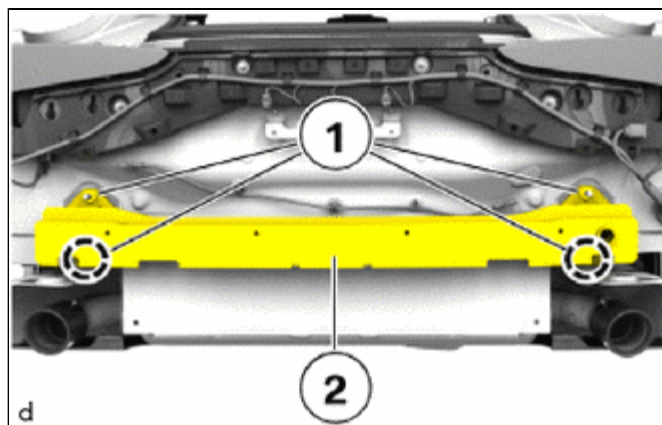
PROCEDURE

1. INSTALL REAR BUMPER REINFORCEMENT SUB-ASSEMBLY

(a) Install the replace seals (1).



(b) Set the rear bumper reinforcement sub-assembly (2).



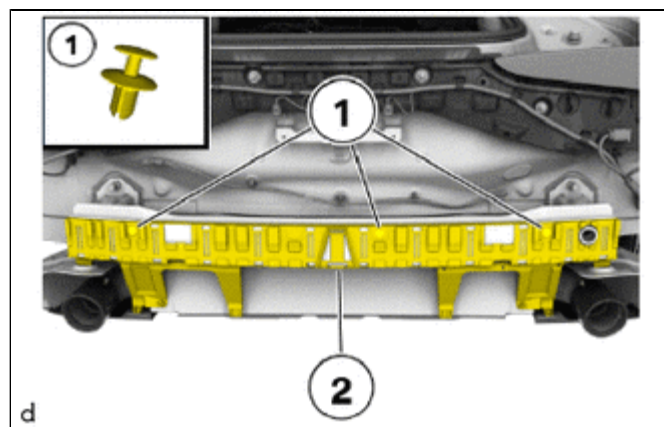
(c) Using a deep socket wrench 18 mm, install the 18 mm nuts (1).

Torque:

108 N·m {1101 kgf·cm, 80 ft·lbf}

2. INSTALL BUMPER ENERGY ABSORBER

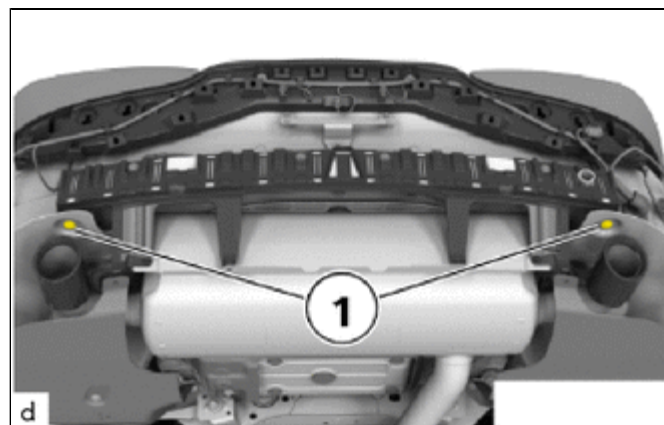
(a) Install the rear bumper energy absorber (2) with clips (1).



(b) Install the screws (1).

Torque:

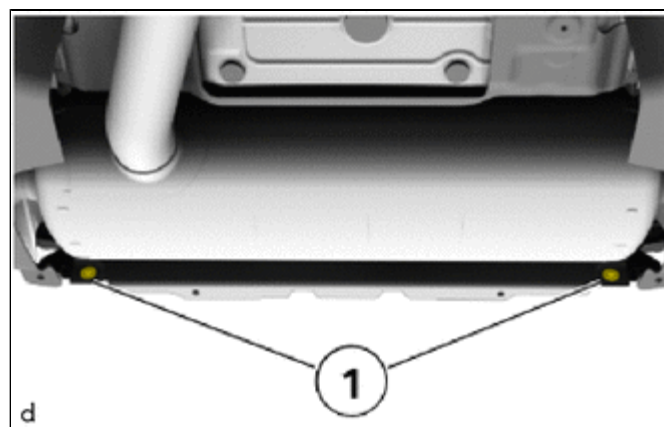
3.0 N·m {31 kgf·cm, 27 in·lbf}



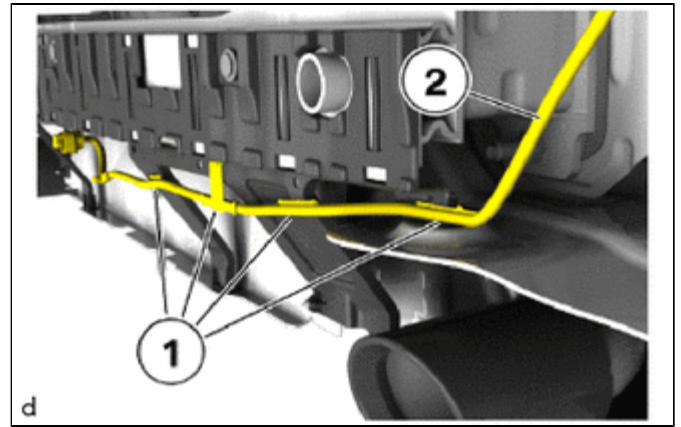
(c) Install the screws (1).

Torque:

3.0 N·m {31 kgf·cm, 27 in·lbf}



(d) Engage the clamps (1) to connect the wiring harness (2).

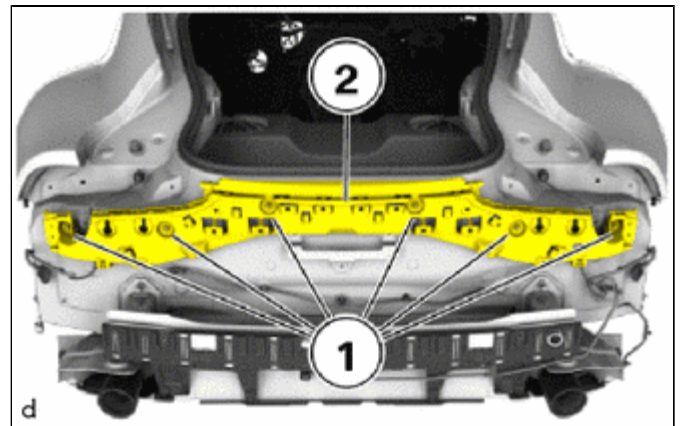


3. INSTALL NO. 1 REAR BUMPER SUPPORT

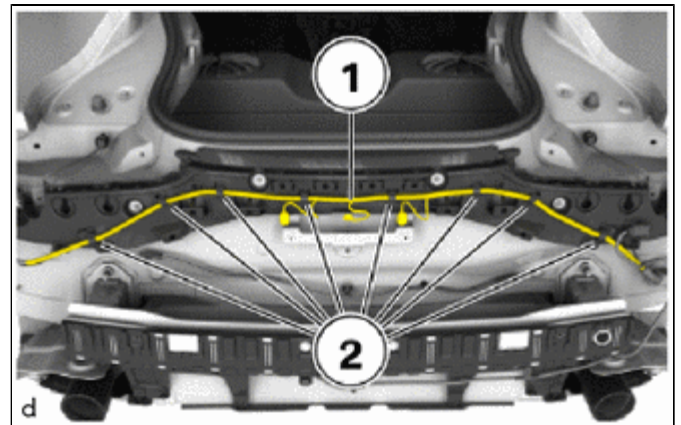
(a) Install the No. 1 rear bumper support (2) with nuts (1).

Torque:

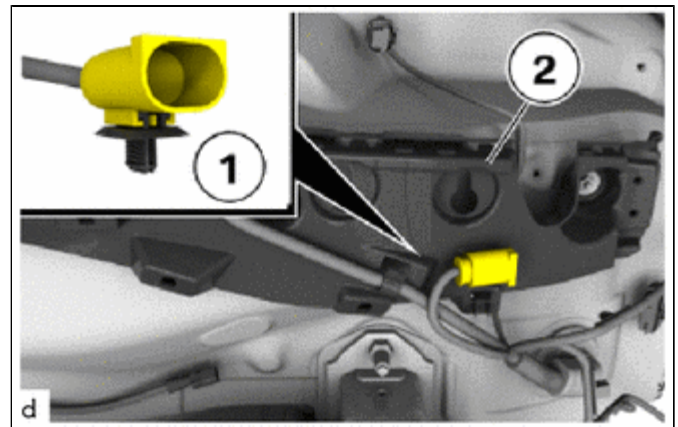
8.0 N·m {82 kgf·cm, 71 in·lbf}



(b) Connect the wiring harness (1) to the holders (2).



- (c) Engage the connector (1) to the No. 1 rear bumper support (2).

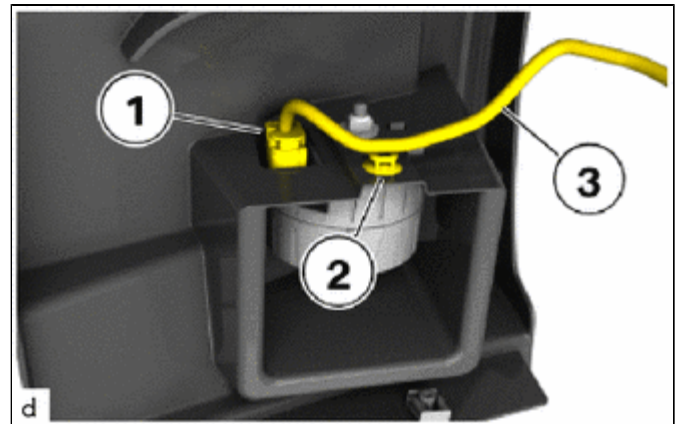


4. INSTALL THEFT WARNING SIREN ASSEMBLY

Click here [INFO](#)

5. INSTALL REAR BUMPER SIDE SUPPORT SUB-ASSEMBLY LH

- (a) Connect the connector (1) and wiring harness (3).

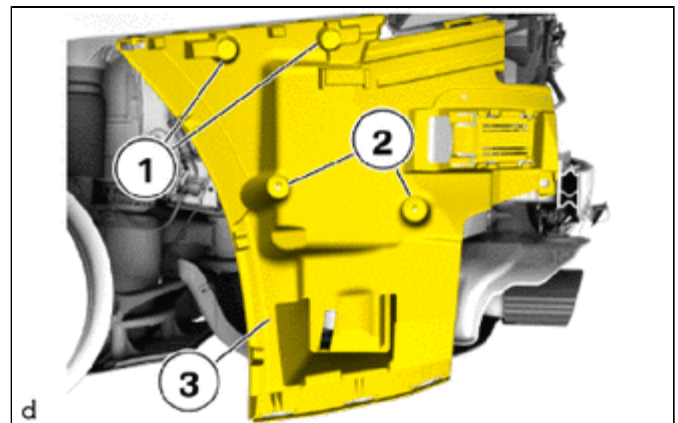


- (b) Engage the clamp (2).

- (c) Install the rear bumper side support sub-assembly LH (3) with nuts (2).

Torque:

8.0 N·m {82 kgf·cm, 71 in·lbf}



- (d) Install the screws (1).

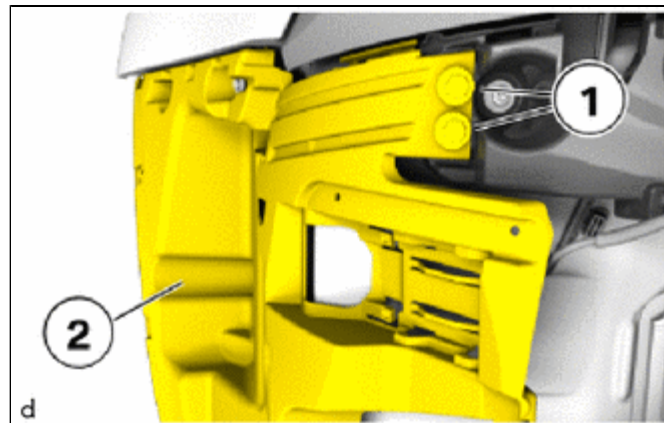
Torque:

2.0 N·m {20 kgf·cm, 18 in·lbf}

- (e) Install the T20 screws (1) on the rear bumper side support sub-assembly LH (2).

Torque:

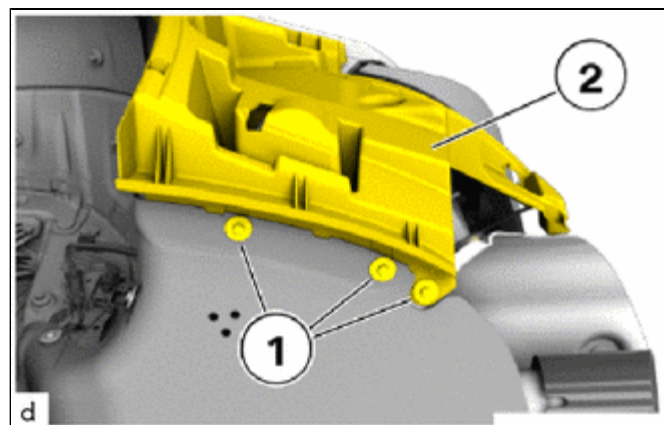
2.0 N·m {20 kgf·cm, 18 in·lbf}



- (f) Install the screws (1) on the rear bumper side support sub-assembly LH (2).

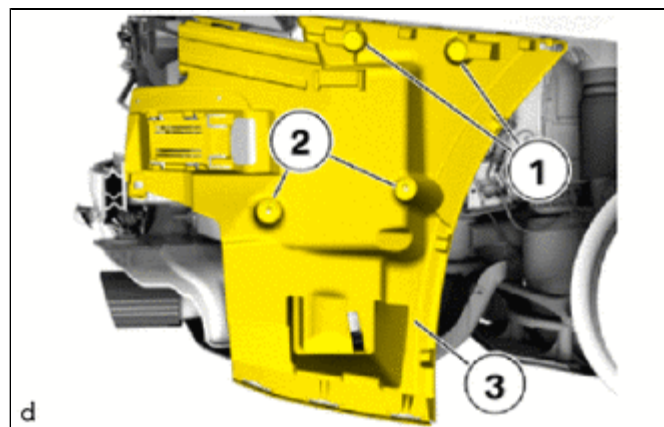
Torque:

3.0 N·m {31 kgf·cm, 27 in·lbf}



6. INSTALL REAR BUMPER SIDE SUPPORT SUB-ASSEMBLY RH

- (a) Set the rear bumper side support sub-assembly RH (3).



- (b) Install the nuts (2).

Torque:

8.0 N·m {82 kgf·cm, 71 in·lbf}

(c) Install the screws (1).

Torque:

2.0 N·m {20 kgf·cm, 18 in·lbf}

(d) Install the T20 screws (1) on the rear bumper side support sub-assembly RH (2).

Torque:

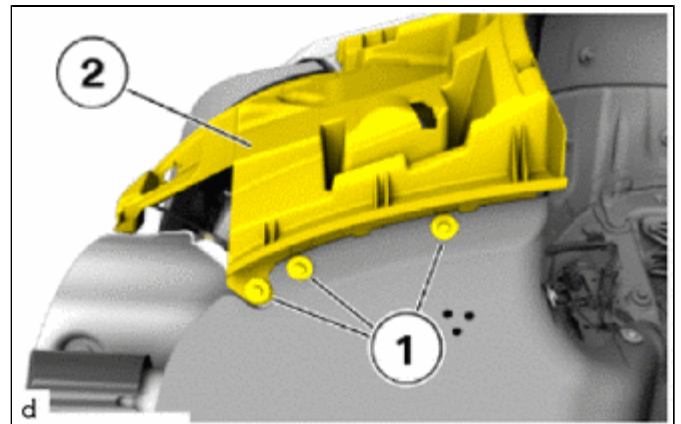
2.0 N·m {20 kgf·cm, 18 in·lbf}



(e) Install the screws (1) on the rear bumper side support sub-assembly RH (2).

Torque:

3.0 N·m {31 kgf·cm, 27 in·lbf}



7. INSTALL BLIND SPOT MONITOR SENSOR LH

Click here [INFO](#)

8. INSTALL BLIND SPOT MONITOR SENSOR RH

HINT:

Use the same procedure as for the LH side.

9. INSTALL ABSORBER FUNNEL LH

Click here [INFO](#)

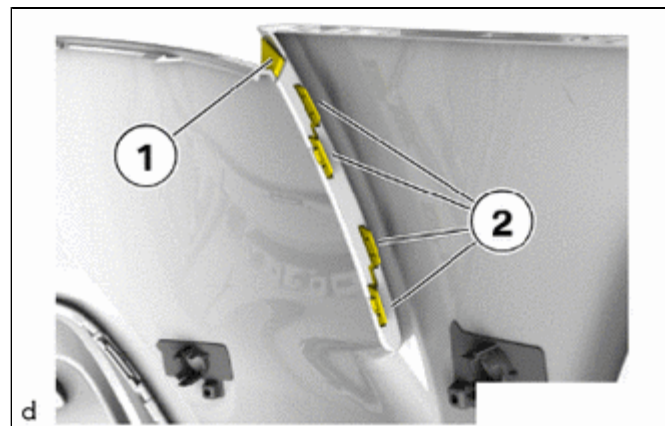
10. INSTALL ABSORBER FUNNEL RH

HINT:

Use the same procedure as for the LH side.

11. INSTALL AIR INLET TRIM STRIP LH

- (a) Install the air inlet trim strip LH (1) and engage the claws (2).



12. INSTALL AIR INLET TRIM STRIP RH

HINT:

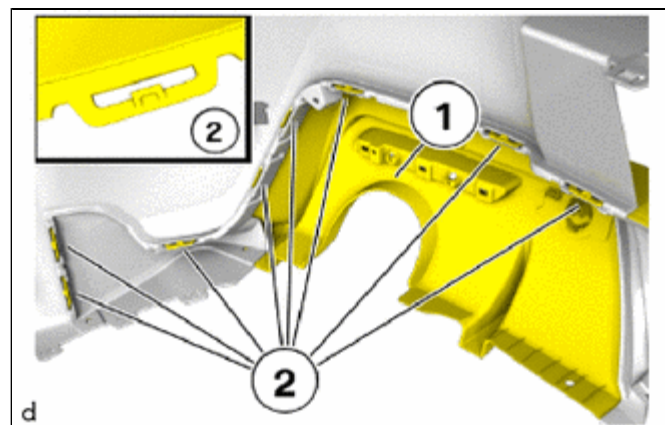
Use the same procedure as for the LH side.

13. INSTALL REAR BUMPER COVER LOWER SECTION

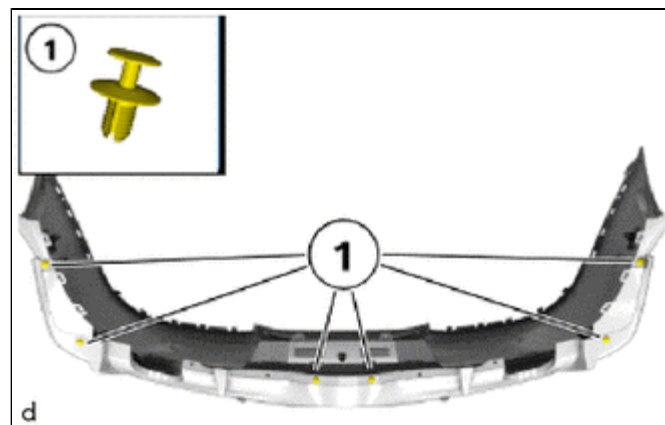
- (a) Engage the claws (2) to install the rear bumper cover lower section (1).

HINT:

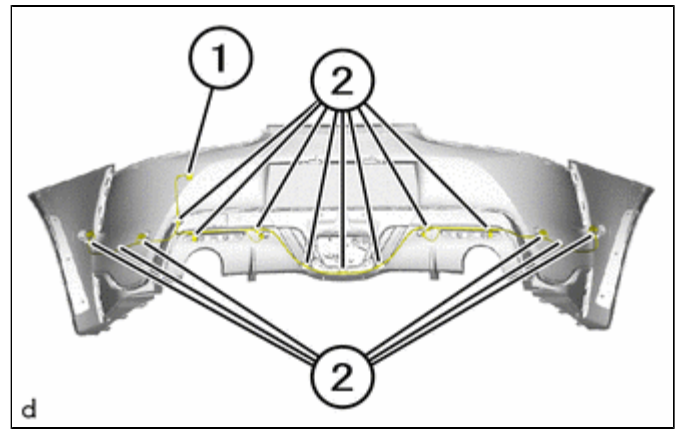
Perform the operations on the left and right side.



- (b) Install the clips (1).



(c) Engage the clamps (2) to install the wiring harness (1).



14. INSTALL SYMBOL EMBLEM

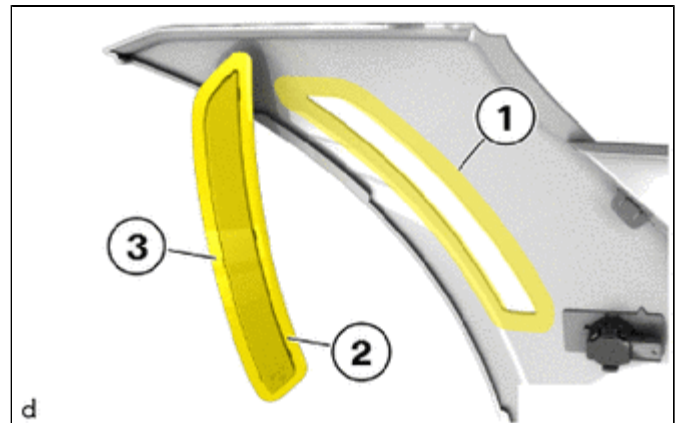
Click here [INFO](#)

15. INSTALL NAME PLATE

Click here [INFO](#)

16. INSTALL REFLECTOR LH

(a) Replace the reflector (3).



(b) Remove glue residue from the bumper panel and clean the adhesive area (1) with cleaner.

Cleaner:

Cleaner R2

(c) Peel off the liner (2) from the adhesive tape.

(d) Install the reflector (3) in the designated area and securely press.

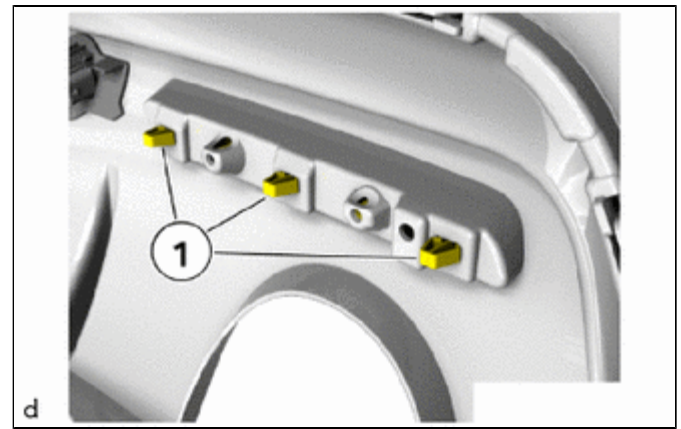
17. INSTALL REFLECTOR RH

HINT:

Use the same procedure as for the LH side.

18. INSTALL REFLEX REFLECTOR ASSEMBLY LH

- (a) Engage the claws (1) to install the reflex reflector assembly LH.



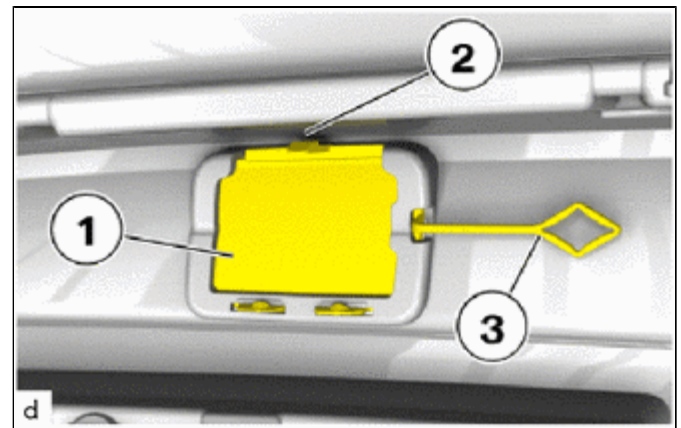
19. INSTALL REFLEX REFLECTOR ASSEMBLY RH

HINT:

Use the same procedure as for the LH side.

20. INSTALL REAR BUMPER PLATE RH

- (a) Engage the hook (3).



- (b) Engage the claw to install the rear bumper plate RH (1).

21. INSTALL LICENSE PLATE LIGHT ASSEMBLY

Click here [INFO](#)

22. INSTALL BRACKET FOR REAR VIEW CAMERA

Click here [INFO](#)

23. INSTALL TELEVISION CAMERA ASSEMBLY

Click here [INFO](#)

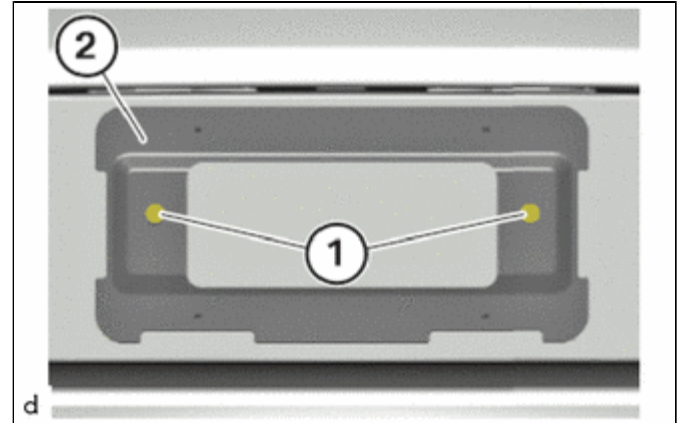
24. INSTALL BACK-UP LIGHT ASSEMBLY

Click here [INFO](#)

25. INSTALL REAR REGISTRATION PLATE

HINT:

The bolting points of the rear registration plate are marked by stampings on the rear bumper assembly.



(a) Set the rear registration plate (2).

(b) Install the screws (1) without pre-drilling and tighten.

Torque:

3.0 N·m {31 kgf·cm, 27 in·lbf}

26. INSTALL NO. 2 ULTRASONIC SENSOR RETAINER

Click here [INFO](#)

27. INSTALL REAR CENTER ULTRASONIC SENSOR

Click here [INFO](#)

28. INSTALL REAR SIDE ULTRASONIC SENSOR

Click here [INFO](#)

29. INSTALL REAR CORNER ULTRASONIC SENSOR

HINT:

Use the same procedure as for the rear side ultrasonic sensor.

30. INSTALL REAR COMBINATION LIGHT ASSEMBLY LH

Click here [INFO](#)

31. INSTALL REAR COMBINATION LIGHT ASSEMBLY RH

HINT:

Use the same procedure as for the LH side.

32. INSTALL STEREO COMPONENT AMPLIFIER ASSEMBLY WITH BRACKET (w/ Stereo Component Amplifier)

Click here [INFO](#)

33. INSTALL DECK TRIM SIDE BOARD AND DECK SIDE TRIM COVER RH

Click here [INFO](#)

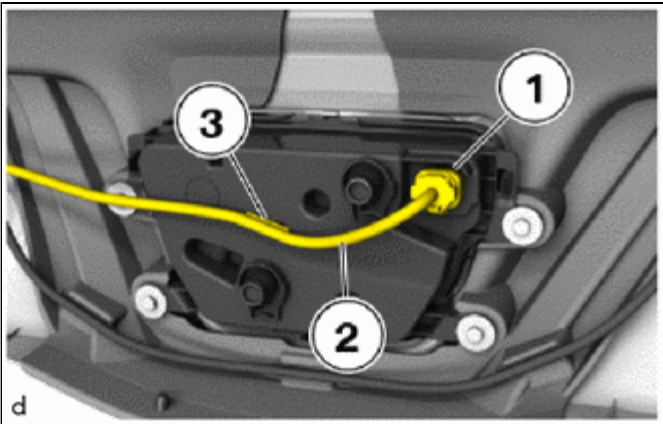
Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCMS
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: REAR BUMPER: INSTALLATION; 2020 MY Supra [03/2019 -]		

INSTALLATION

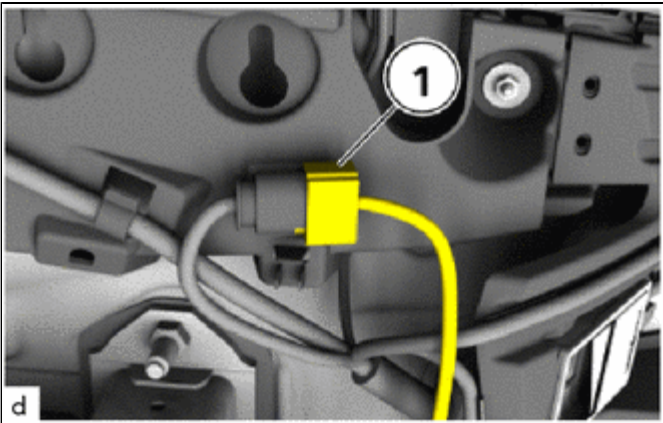
PROCEDURE

1. INSTALL REAR BUMPER ASSEMBLY

(a) Connect the connector (1).

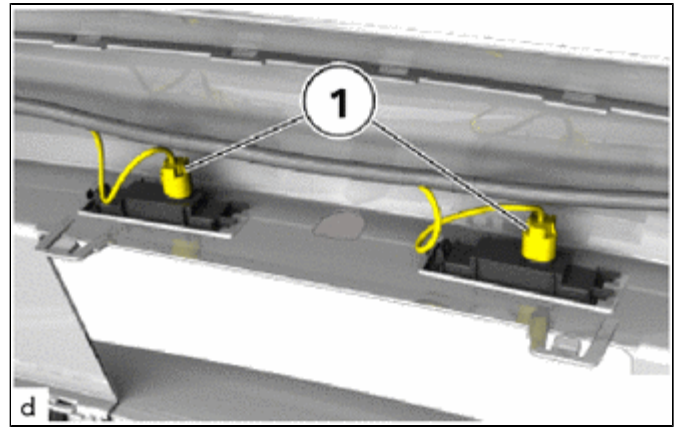


(b) Engage the wiring harness (2) with the clamp (3).

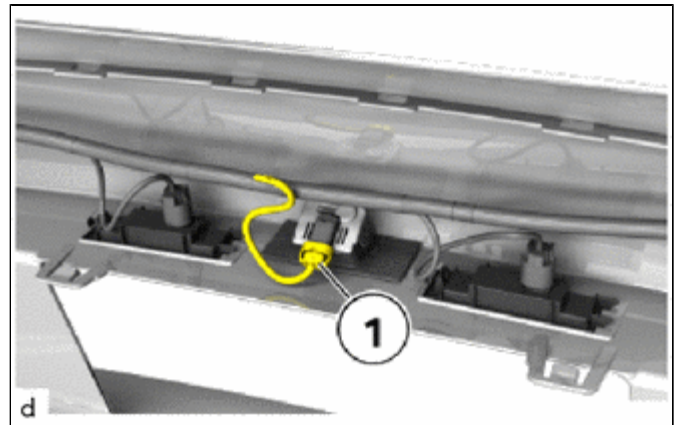


(c) Connect the connector (1).

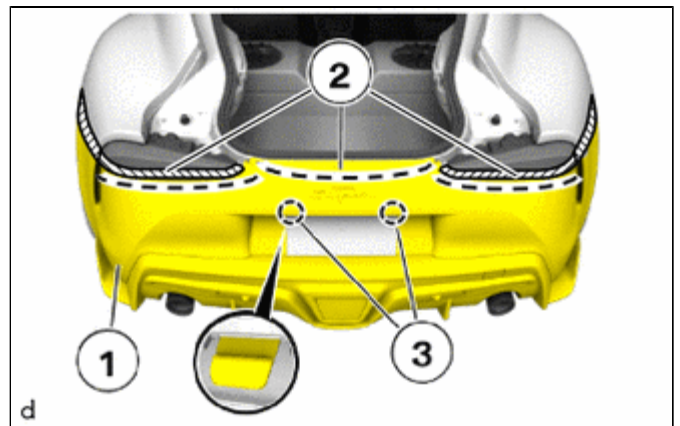
(d) Connect the connectors (1).



(e) Connect the connector (1).



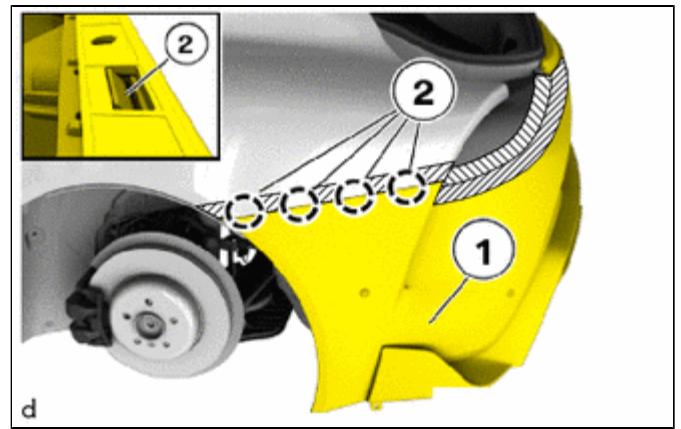
(f) Install the rear bumper assembly (1) and engage the claws (2) and claws (3).



(g) Engage the rear bumper assembly (1) into the claws (2) at side.

HINT:

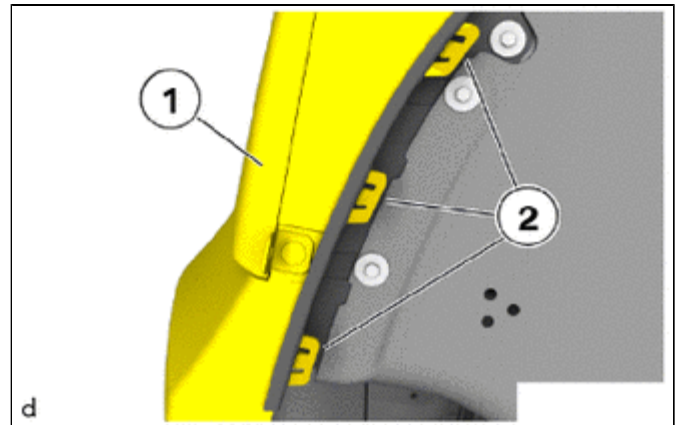
Perform the operations on the left and right side.



(h) Engage the rear bumper assembly (1) into the claws (2) at side.

HINT:

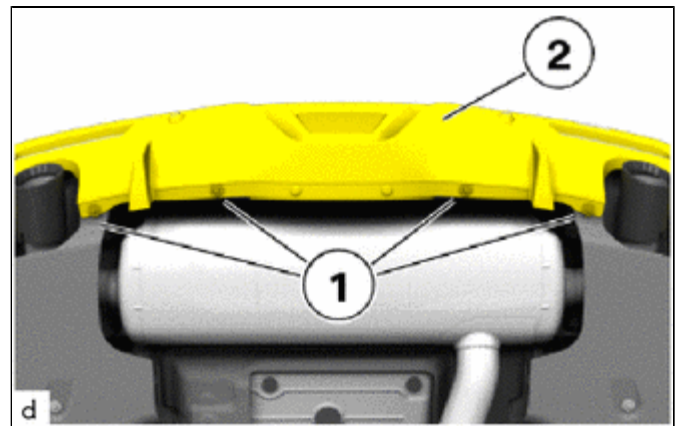
Perform the operations on the left and right side.



(i) Install the screws (1) on the rear bumper assembly (2).

Torque:

2.0 N·m {20 kgf·cm, 18 in·lbf}



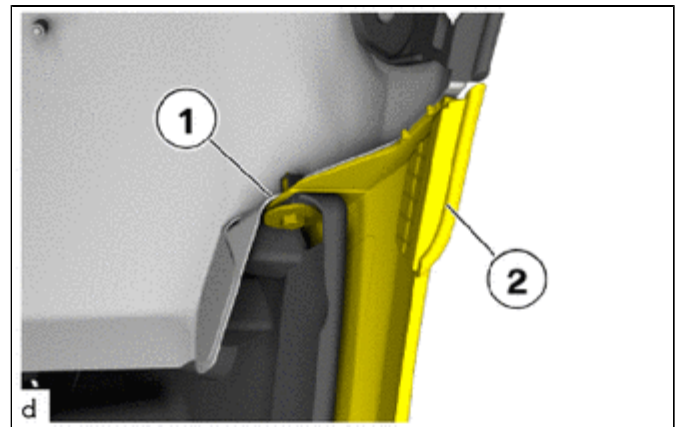
(j) Install the screw (1) on the rear bumper assembly (2).

Torque:

2.0 N·m {20 kgf·cm, 18 in·lbf}

HINT:

Perform the operations on the left and right side.



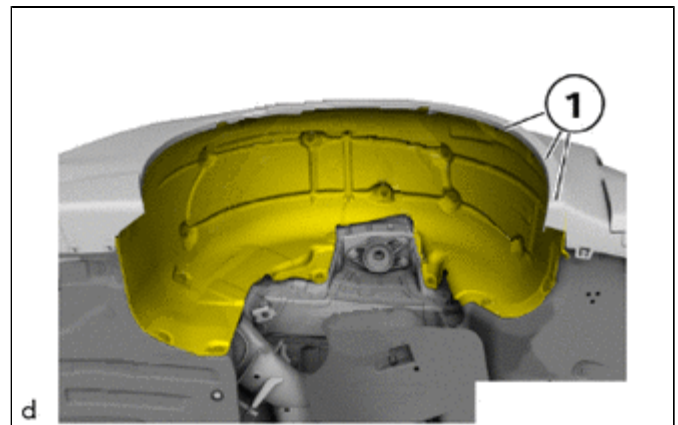
(k) Install the screws (1).

Torque:

2.6 N·m {27 kgf·cm, 23 in·lbf}

HINT:

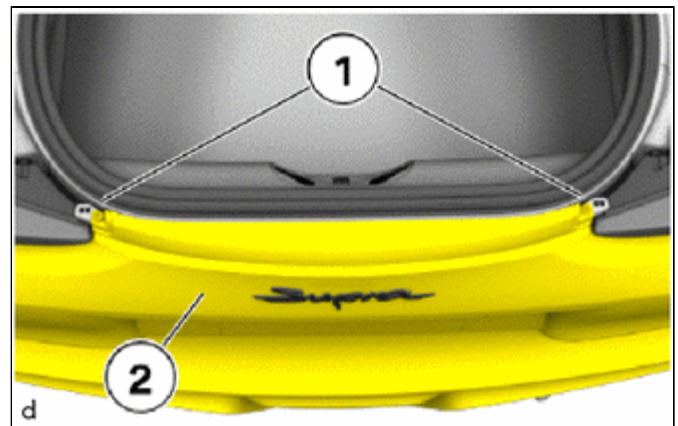
Perform the operations on the left and right side.



(l) Install the T20 screws (1) on the rear bumper assembly (2).

Torque:

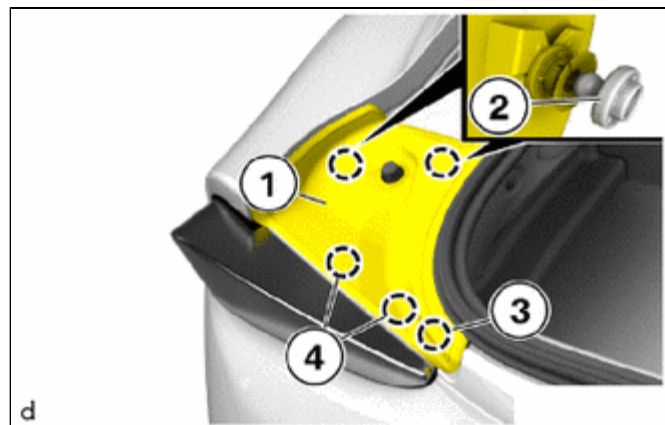
2.0 N·m {20 kgf·cm, 18 in·lbf}



(m) Remove the protective tape.

2. INSTALL BACK DOOR SIDE GARNISH LH

(a) Engage the guides (4) to install the back door side garnish LH (1).



(b) Engage the pins (2) and claw (3).

3. INSTALL BACK DOOR SIDE GARNISH RH

HINT:

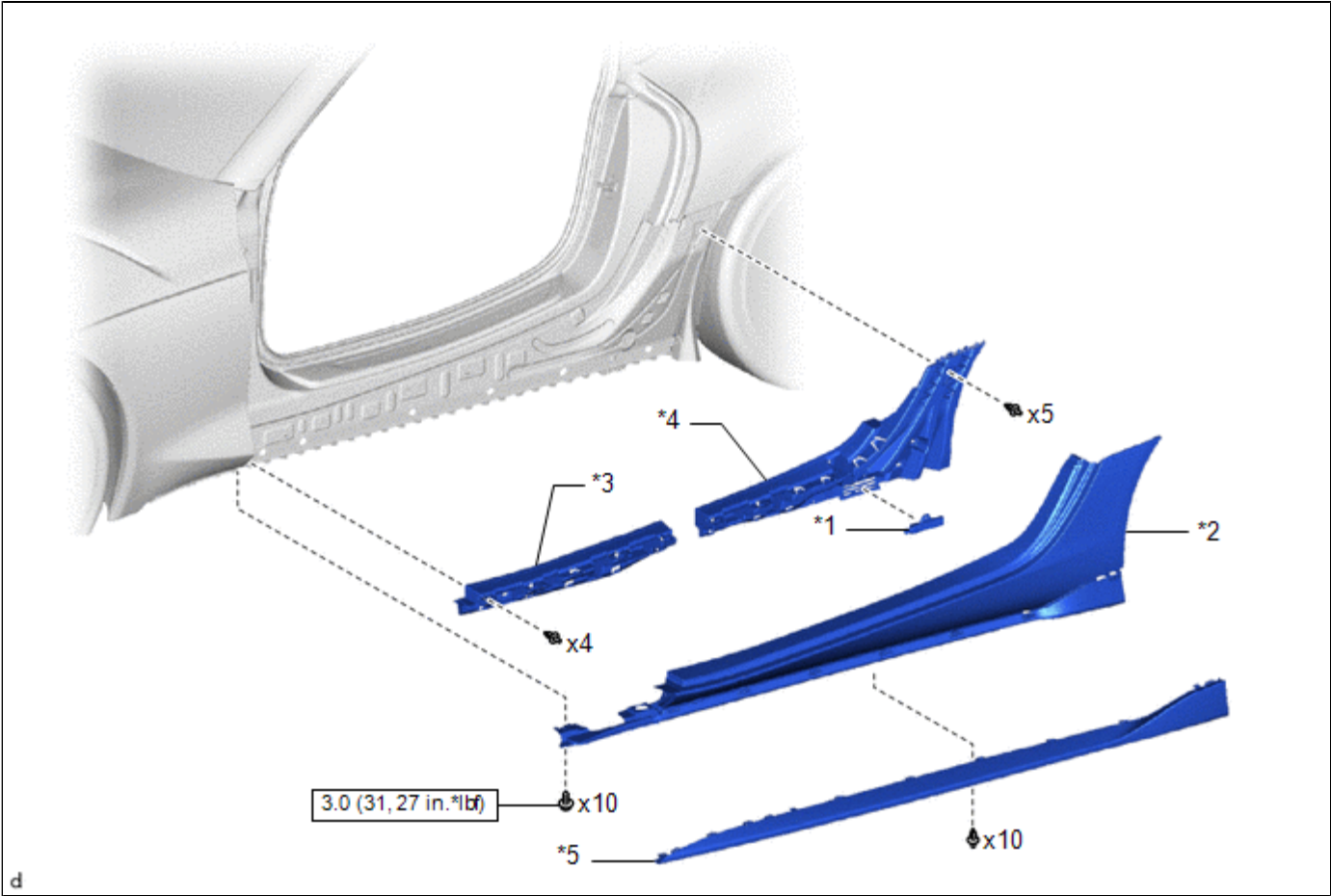
Use the same procedure as for the LH side.



Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCMZ
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: ROCKER PANEL MOULDING: COMPONENTS; 2020 MY Supra [03/2019 -]		

COMPONENTS

ILLUSTRATION



*1	ELECTRICAL KEY ANTENNA	*2	NO. 1 SIDE PANEL MOULDING
*3	NO. 2 BODY OUTSIDE MOULDING PAD	*4	NO. 4 BODY OUTSIDE MOULDING PAD
*5	ROCKER PANEL MOULDING	-	-
	N*m (kgf*cm, ft.*lbf): Specified torque	-	-

Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCN0
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: ROCKER PANEL MOULDING: REMOVAL; 2020 MY Supra [03/2019 -]		

REMOVAL

CAUTION / NOTICE / HINT

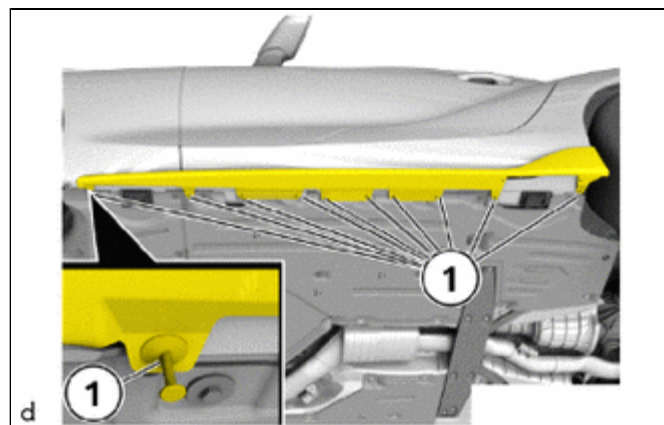
HINT:

- Use the same procedure for both the LH and RH sides.
- The procedure described below is for the LH side.

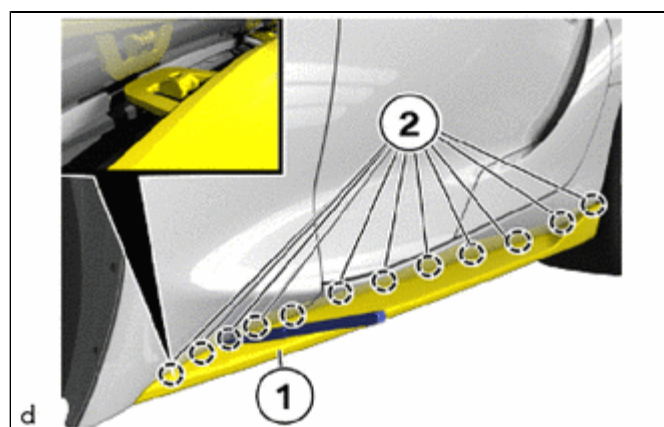
PROCEDURE

1. REMOVE ROCKER PANEL MOULDING

(a) Remove the clips (1).

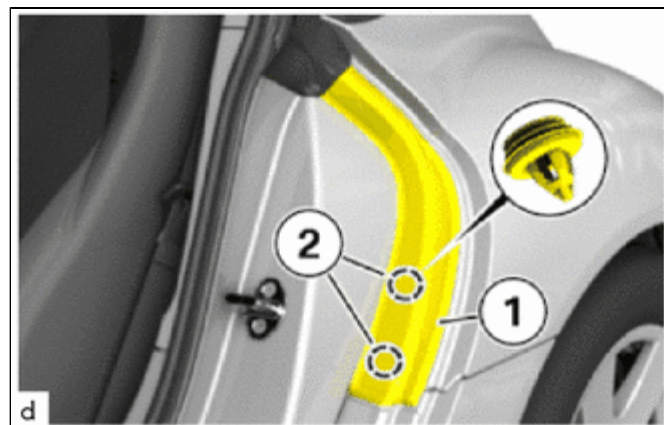


(b) Using a moulding remover A, disengage the claws (2) to remove the rocker panel moulding (1).

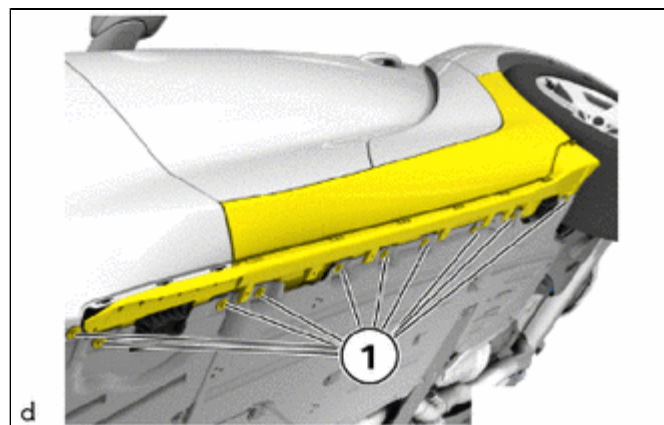


2. REMOVE NO. 1 SIDE PANEL MOULDING

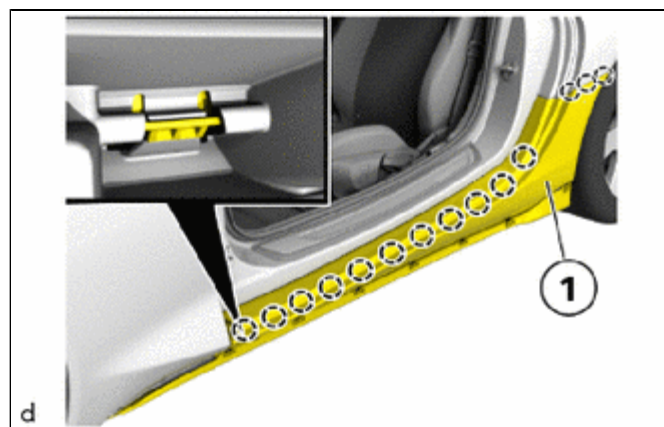
(a) Disengage the clips (2) to disconnect the front door inner trim cover (1).



(b) Remove the screws (1).



(c) Disengage the claws to remove the No. 1 side panel moulding (1).



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Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: ROCKER PANEL MOULDING: DISASSEMBLY; 2020 MY Supra [03/2019 -]		

DISASSEMBLY

CAUTION / NOTICE / HINT

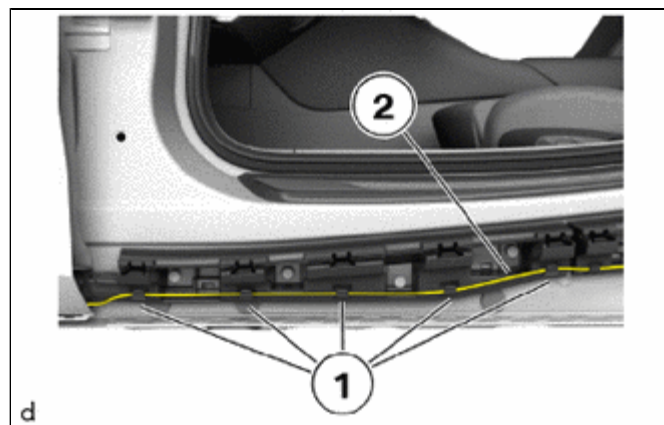
HINT:

- Use the same procedure for both the LH and RH sides.
- The procedure described below is for the LH side.

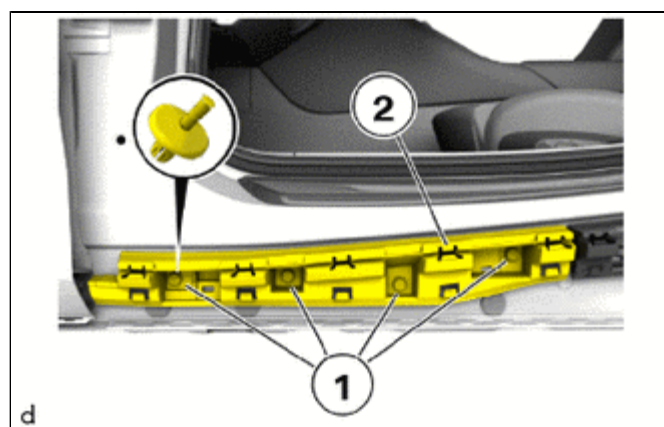
PROCEDURE

1. REMOVE NO. 2 BODY OUTSIDE MOULDING PAD

(a) Disconnect the floor wire (2) from holders (1).



(b) Remove the clips (1) and No. 2 body outside moulding pad (2).

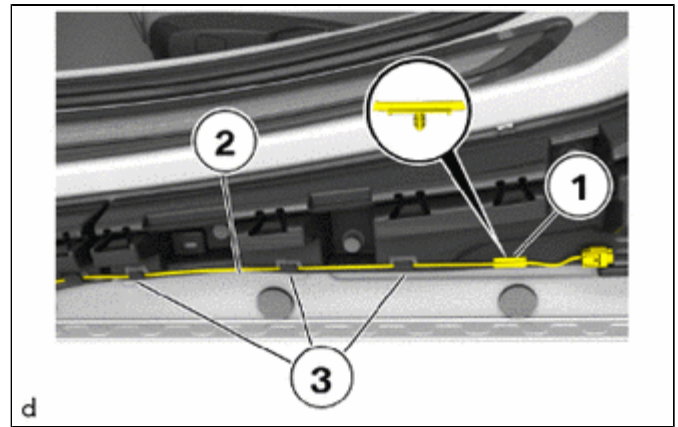


2. REMOVE ELECTRICAL KEY ANTENNA

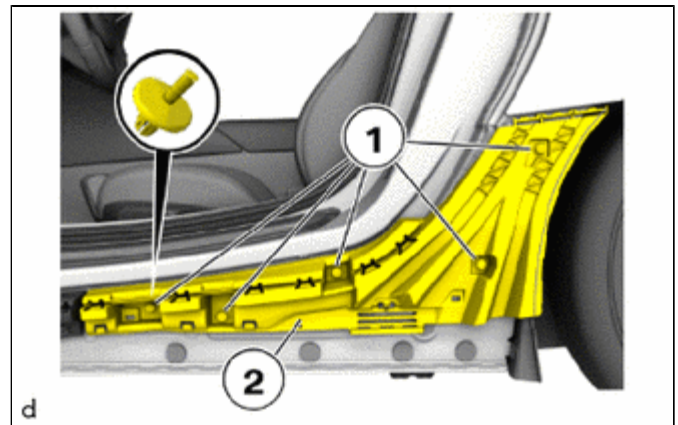
Click here [INFO](#)

3. REMOVE NO. 4 BODY OUTSIDE MOULDING PAD

(a) Disengage the clamp (1).



(b) Disconnect the floor wire (2) from holders (3).



(c) Remove the clips (1) and No. 4 body outside moulding pad (2).

Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCN2
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: ROCKER PANEL MOULDING: REASSEMBLY; 2020 MY Supra [03/2019 -]		

REASSEMBLY

CAUTION / NOTICE / HINT

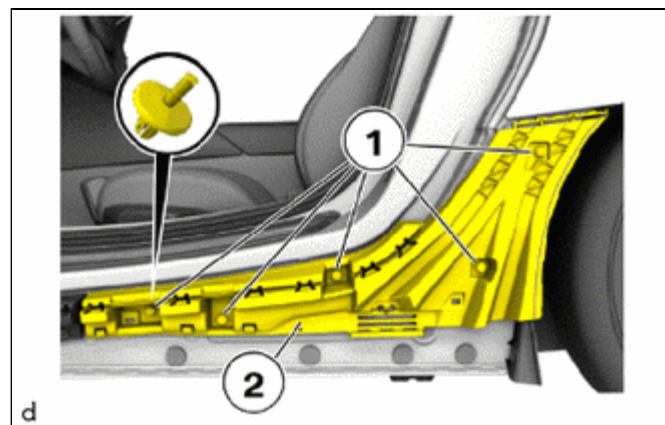
HINT:

- Use the same procedure for both the LH and RH sides.
- The procedure described below is for the LH side.

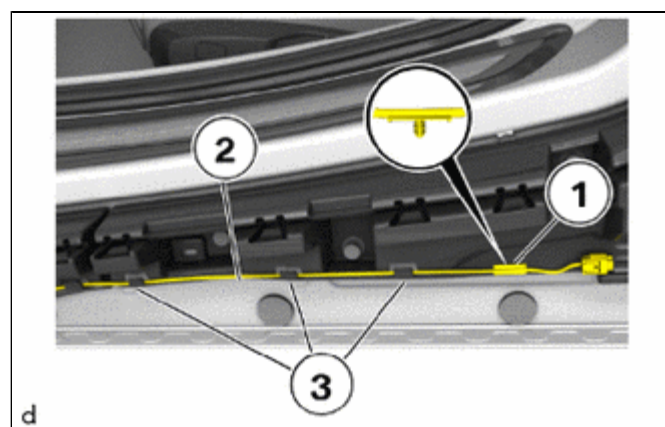
PROCEDURE

1. INSTALL NO. 4 BODY OUTSIDE MOULDING PAD

- (a) Install the No. 4 body outside moulding pad (2) with the clips (1).



- (b) Connect the wiring harness (2) to the holders (3).



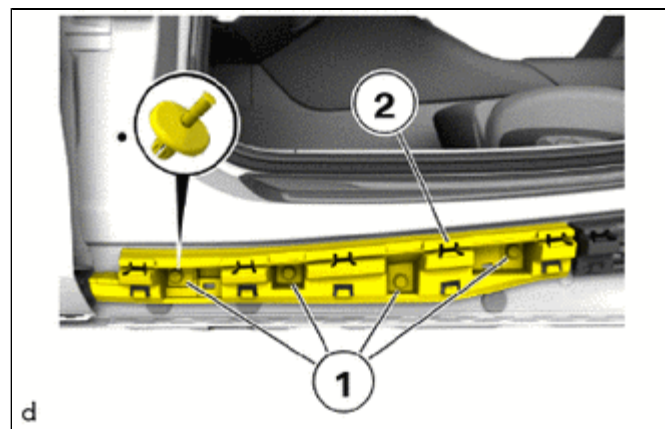
- (c) Engage the clamp (1).

2. INSTALL ELECTRICAL KEY ANTENNA

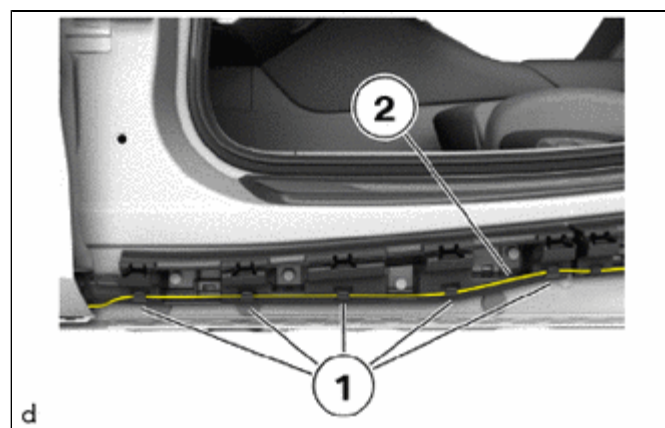
Click here [INFO](#)

3. INSTALL NO. 2 BODY OUTSIDE MOULDING PAD

(a) Install the No. 2 body outside moulding pad (2) with the clips (1).



(b) Connect the wiring harness (2) to the holders (1).



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Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: ROCKER PANEL MOULDING: INSTALLATION; 2020 MY Supra [03/2019 -]		

INSTALLATION

CAUTION / NOTICE / HINT

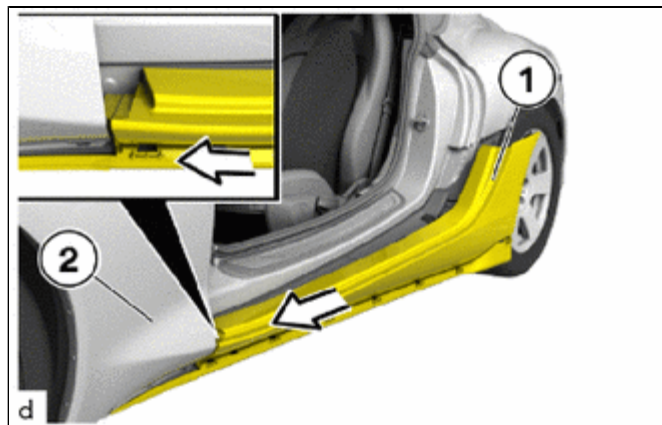
HINT:

- Use the same procedure for both the LH and RH sides.
- The procedure described below is for the LH side.

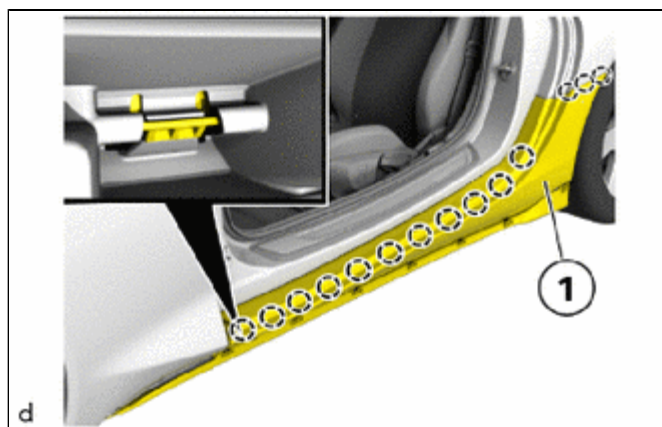
PROCEDURE

1. INSTALL NO. 1 SIDE PANEL MOULDING

- (a) Install the No. 1 side panel moulding (1) under the front side panel (2) in the direction of the arrow.



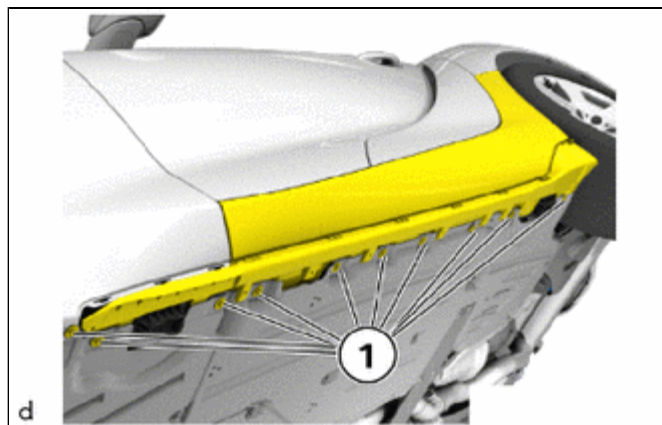
- (b) Engage the No. 1 side panel moulding (1) and the claws.



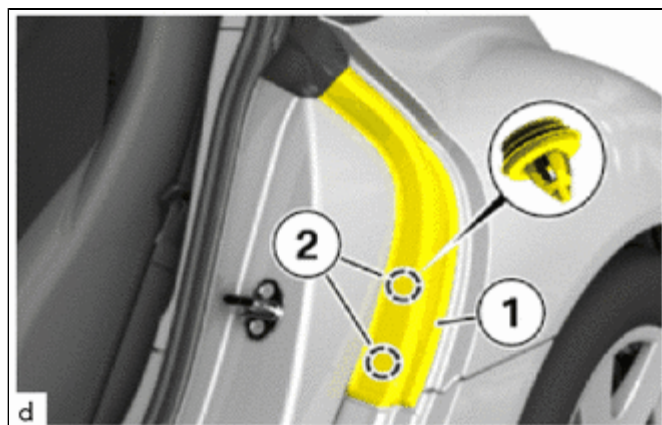
(c) Install the screws (1).

Torque:

3.0 N·m {31 kgf·cm, 27 in·lbf}

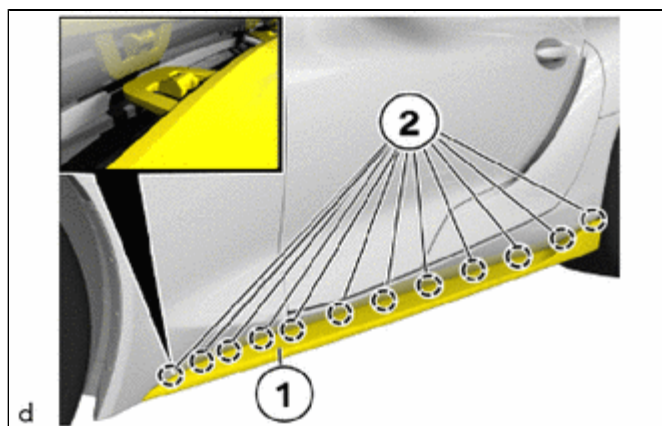


(d) Engage the clips (2) to connect the front door inner trim cover (1).

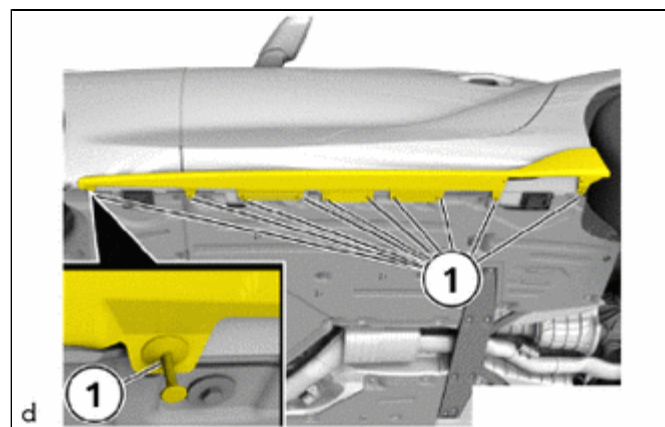


2. INSTALL ROCKER PANEL MOULDING

(a) Engage the claws (2) to install the rocker panel moulding (1).



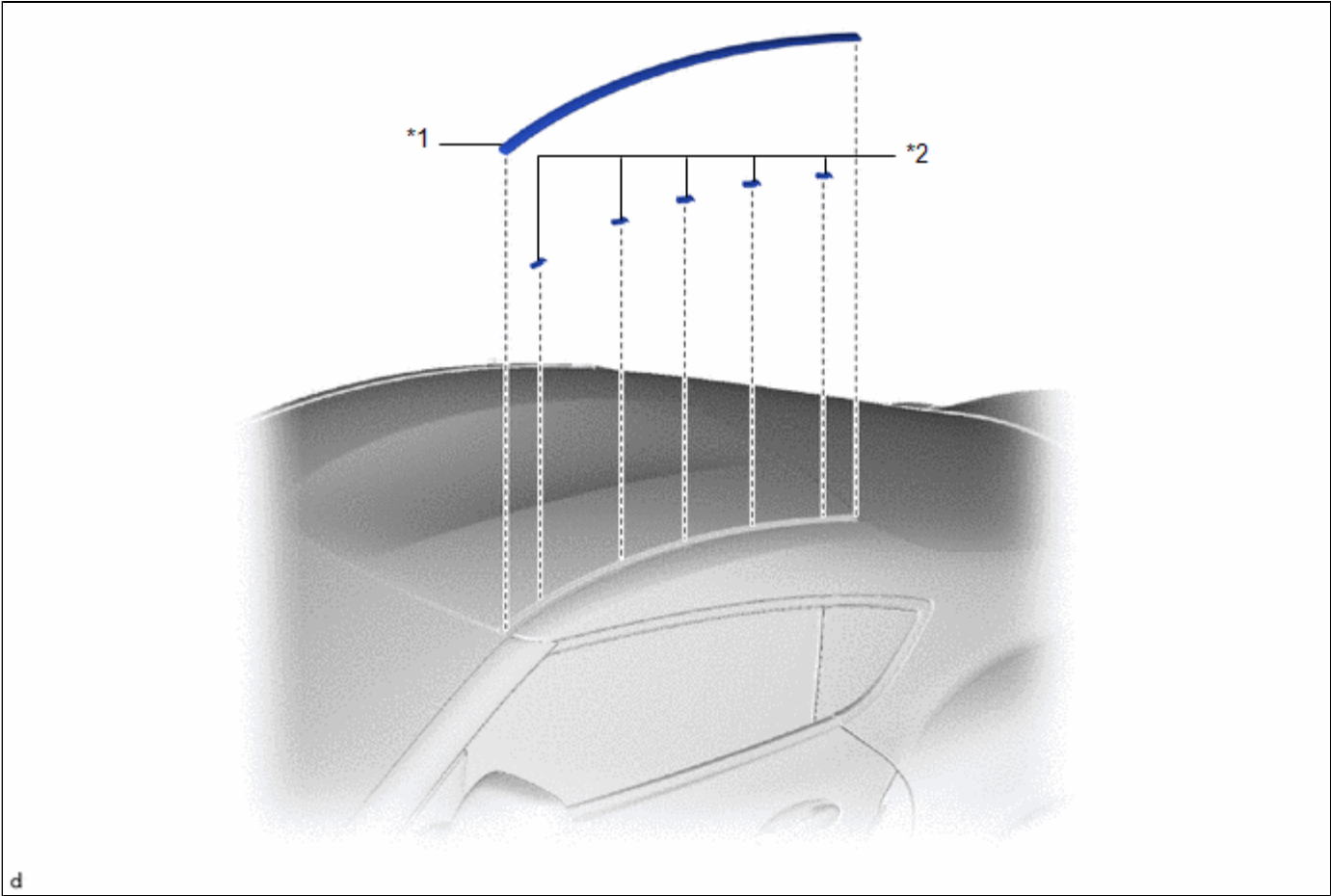
(b) Install the clips (1).



Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCNA
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: ROOF DRIP SIDE FINISH MOULDING: COMPONENTS; 2020 MY Supra [03/2019 -]		

COMPONENTS

ILLUSTRATION



*1	ROOF DRIP SIDE FINISH MOULDING	*2	NO. 1 ROOF DRIP SIDE FINISH MOULDING CLIP
----	--------------------------------	----	---

Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCNB
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: ROOF DRIP SIDE FINISH MOULDING: REMOVAL; 2020 MY Supra [03/2019 -]		

REMOVAL

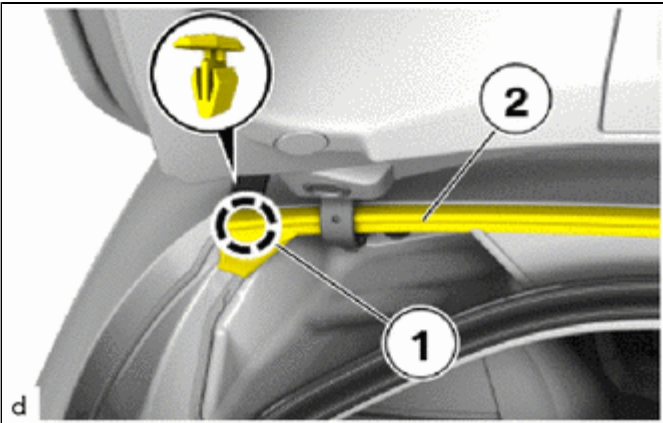
CAUTION / NOTICE / HINT

- HINT:**
- Use the same procedure for both the LH and RH sides.
 - The procedure described below is for the LH side.

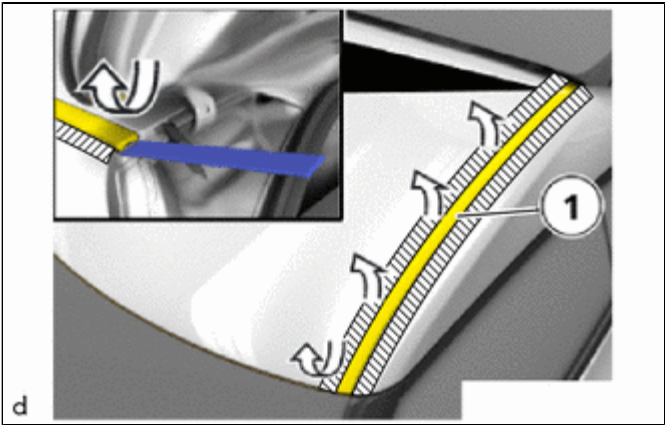
PROCEDURE

1. REMOVE ROOF DRIP SIDE FINISH MOULDING

(a) Disengage the clip (1) to disconnect the back door seal (2).



(b) Apply protective tape as shown in the illustration.



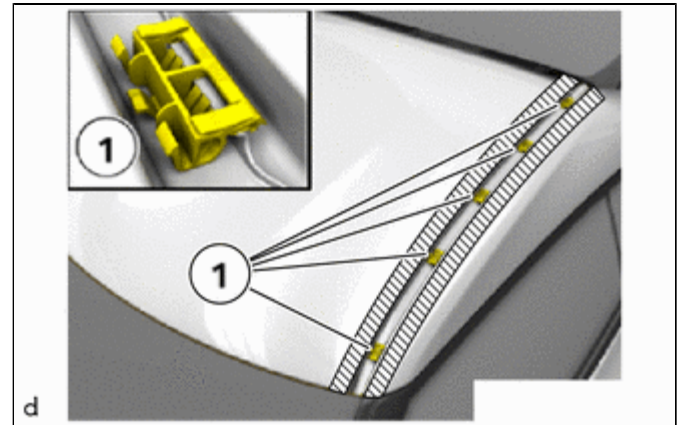
	Protective Tape
--	-----------------

(c) Using a moulding remover A, disengage the claws to remove the roof drip side finish moulding (1).

NOTICE:

- Tools and sharp-edged components can cause scratches.
 - Protect working area.
 - Handle tools and components carefully.

(d) Remove the No. 1 roof drip side finish moulding clip (1).



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Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: ROOF DRIP SIDE FINISH MOULDING: INSTALLATION; 2020 MY Supra [03/2019 -]		

INSTALLATION

CAUTION / NOTICE / HINT

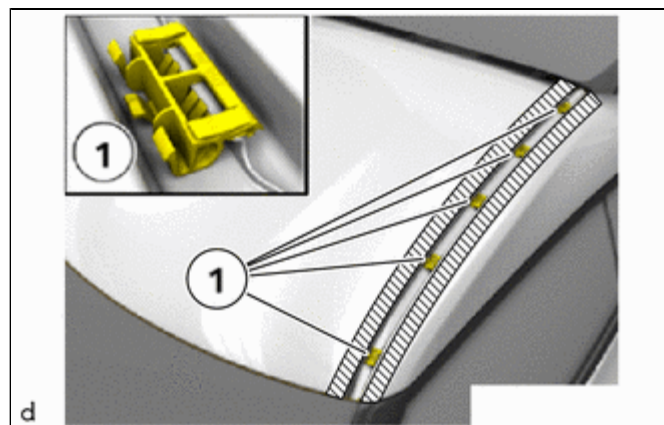
HINT:

- Use the same procedure for both the LH and RH sides.
- The procedure described below is for the LH side.

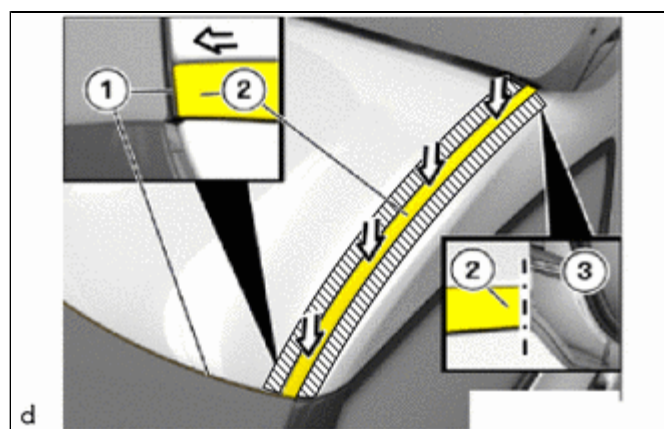
PROCEDURE

1. INSTALL ROOF DRIP SIDE FINISH MOULDING

(a) Install the No. 1 roof drip side finish moulding clip.



(b) Install the roof drip side finish moulding (2) in such a way that it makes contact with windshield outside moulding (1).

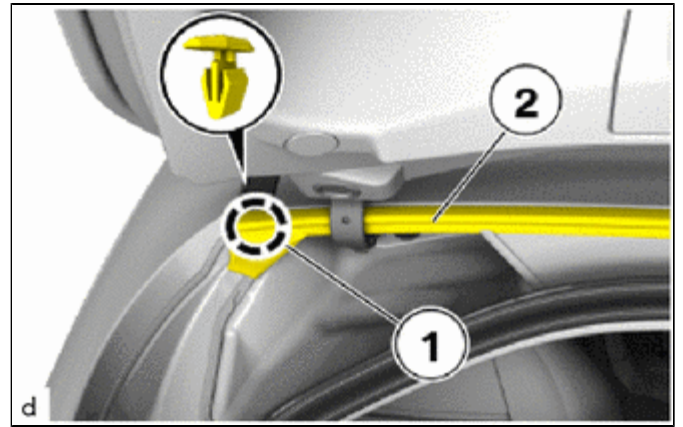


(c) Install the roof drip side finish moulding (2) in such a way that it lies flush against edge (3).

(d) Install the roof drip side finish moulding fully into roof frame (2).

(e) Remove the protective tape.

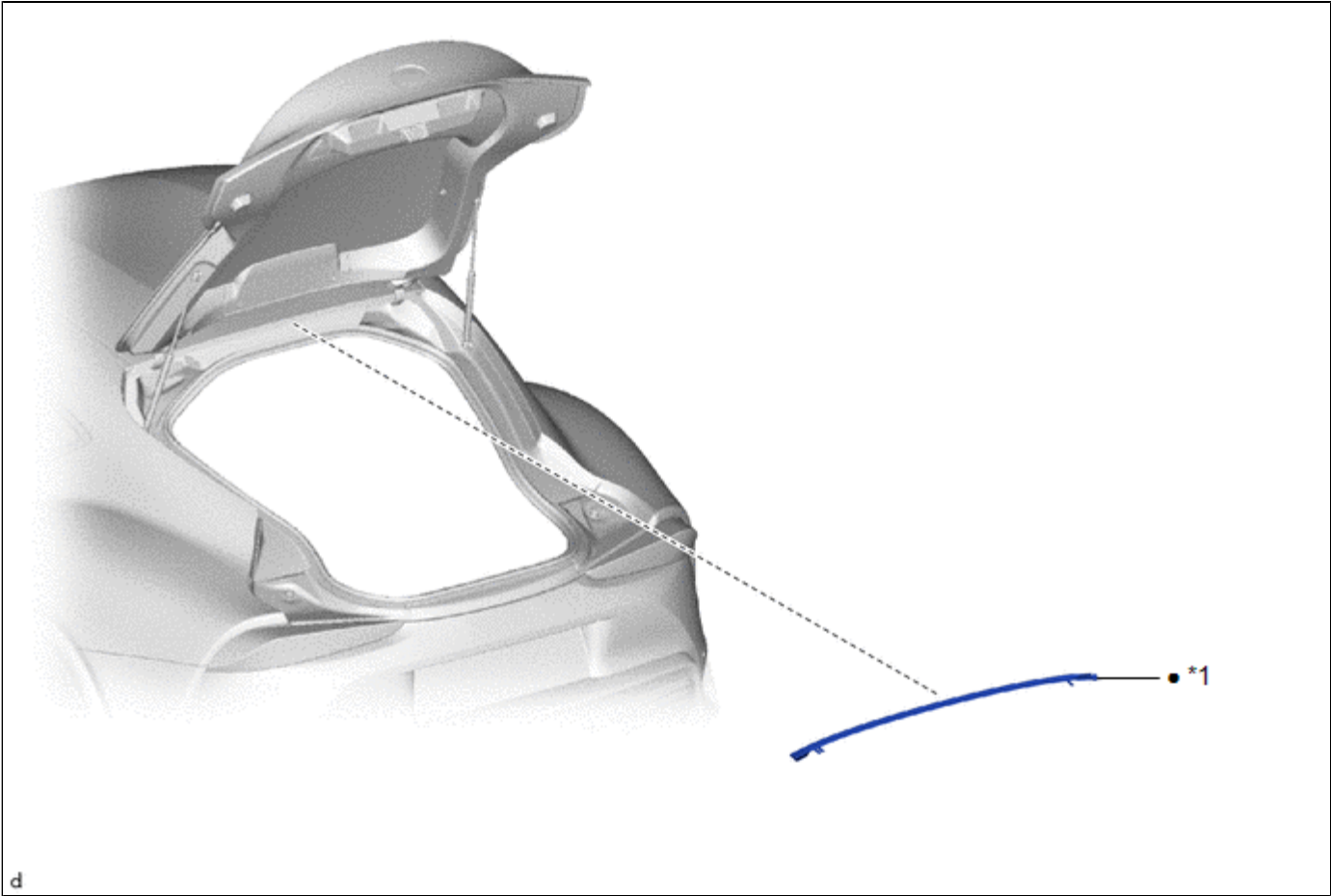
(f) Engage the clip (1) to connect the back door seal (2).



Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCNI
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: TAIL GATE PROTECTOR: COMPONENTS; 2020 MY Supra [03/2019 -]		

COMPONENTS

ILLUSTRATION



*1	BACK DOOR SEAL	-	-
●	Non-reusable part	-	-

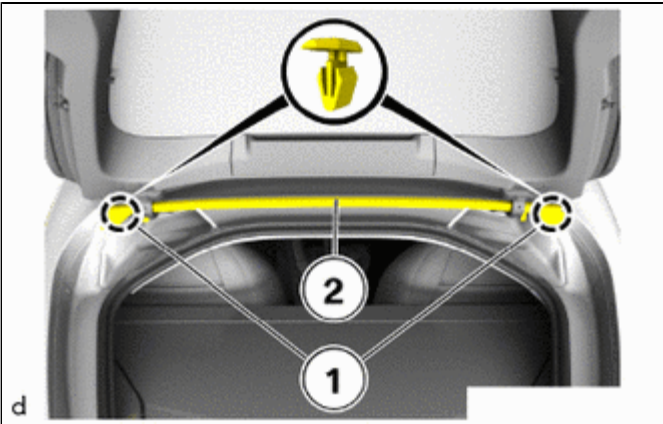
Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCNJ
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: TAIL GATE PROTECTOR: REMOVAL; 2020 MY Supra [03/2019 -]		

REMOVAL

PROCEDURE

1. REMOVE BACK DOOR SEAL

(a) Disengage the clips (1).



(b) Remove the back door seal (2).

Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCNK
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: TAIL GATE PROTECTOR: INSTALLATION; 2020 MY Supra [03/2019 -]		

INSTALLATION

PROCEDURE

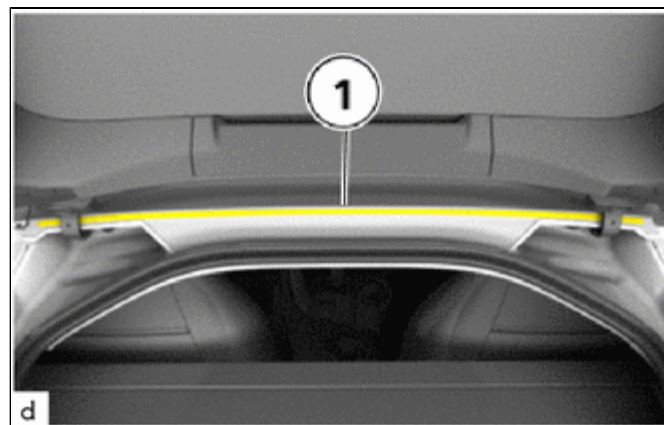
1. INSTALL BACK DOOR SEAL

(a) Remove adhesive residue on the roof frame.

(b) Clean the adhesive area (1) with cleaner.

Cleaner:

Cleaner R2

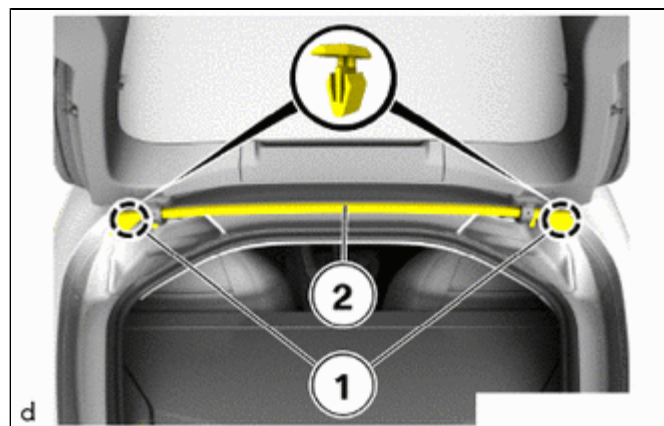


(c) Peel off the liner from adhesive tape.

(d) Engage the clips (1) to install a new back door seal (2).

HINT:

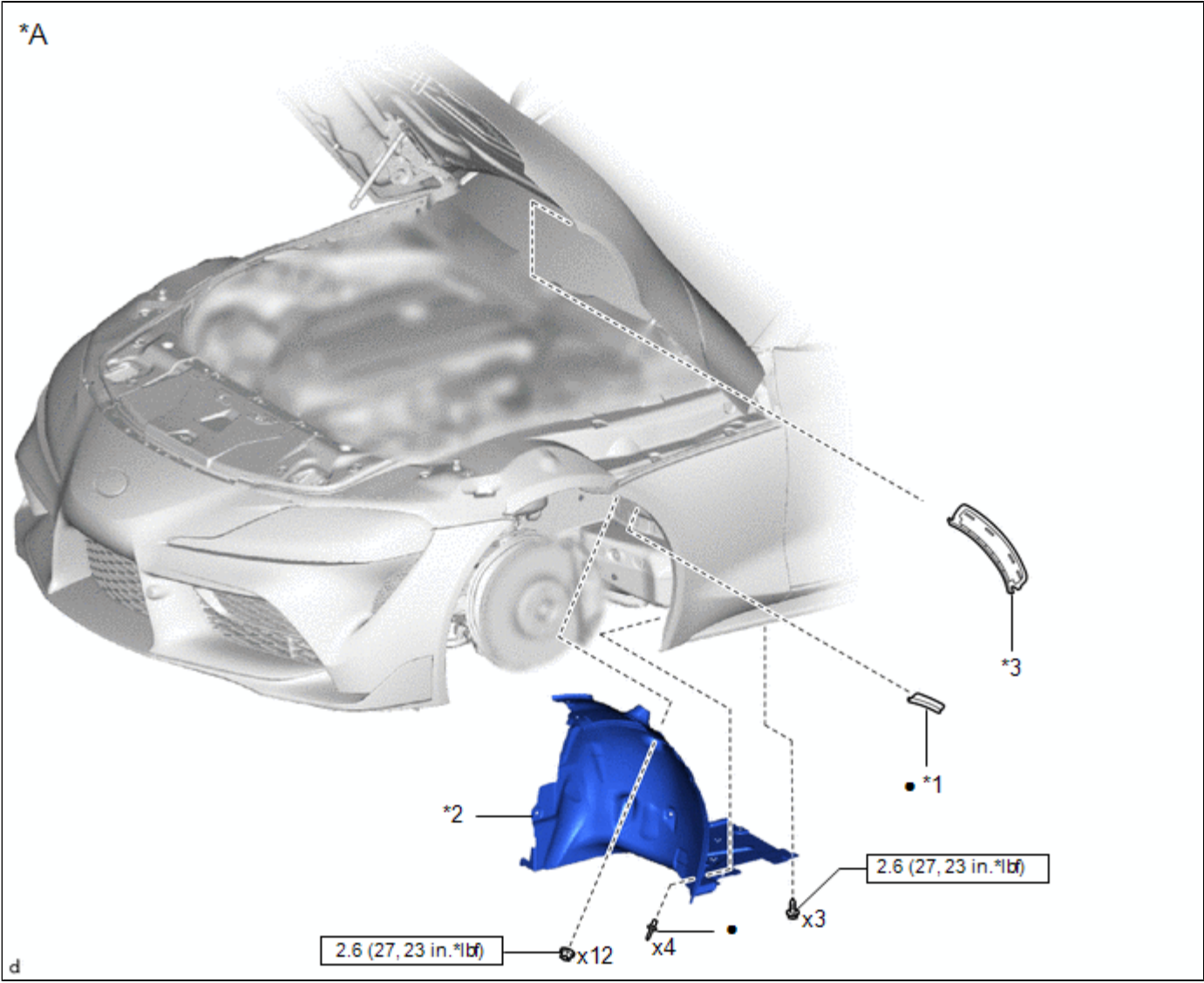
Press the back door seal firmly to install it.



Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCN7
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: WHEEL OPENING MOULDING: COMPONENTS; 2020 MY Supra [03/2019 -]		

COMPONENTS

ILLUSTRATION



*A	for Front Side	-	-
*1	FENDER PANEL MUDGUARD SUB-ASSEMBLY	*2	FRONT NO. 2 FENDER LINER
*3	HOOD MOULDING	-	-
	N*m (kgf*cm, ft.*lbf): Specified torque	●	Non-reusable part

 TOYOTA

Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCN8
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: WHEEL OPENING MOULDING: REMOVAL; 2020 MY Supra [03/2019 -]		

REMOVAL

CAUTION / NOTICE / HINT

HINT:

- Use the same procedure for both the LH and RH sides.
- The procedure described below is for the LH side.

PROCEDURE

1. REMOVE FRONT WHEEL LH (for Front Side)

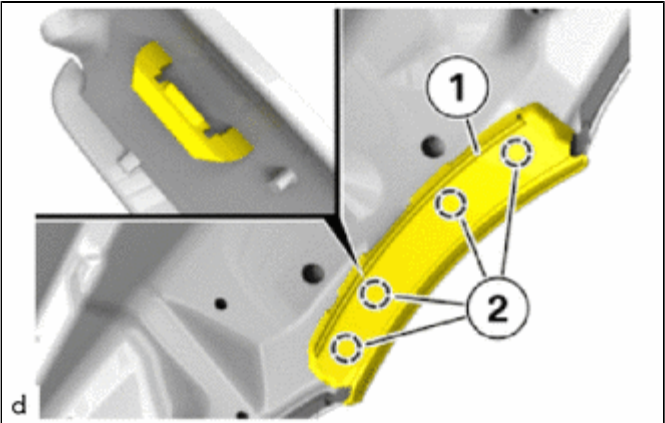
Click here [INFO](#)

2. REMOVE FRONT NO. 2 FENDER LINER (for Front Side)

Click here [INFO](#)

3. REMOVE HOOD MOULDING (for Front Side)

(a) Disengage the claws (2) to remove the hood moulding (1).



4. REMOVE FENDER PANEL MUDGUARD SUB-ASSEMBLY (for Front Side)

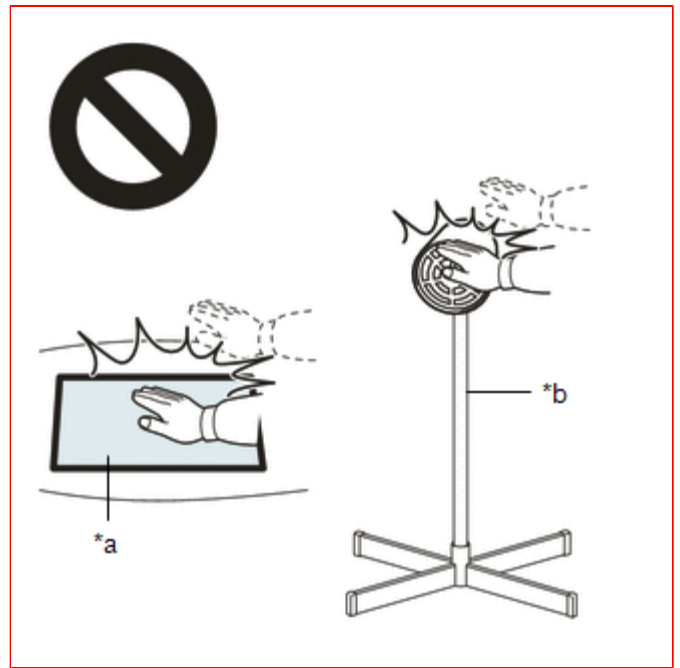
HINT:

When removing the fender panel mudguard sub-assembly, heat the fender panel mudguard sub-assembly using a heat light.

Standard:

ITEM	TEMPERATURE
Fender Panel Mudguard Sub-assembly	40 to 50°C (104 to 122°F)

CAUTION:



- Touching heated parts for a long time may result in burns.

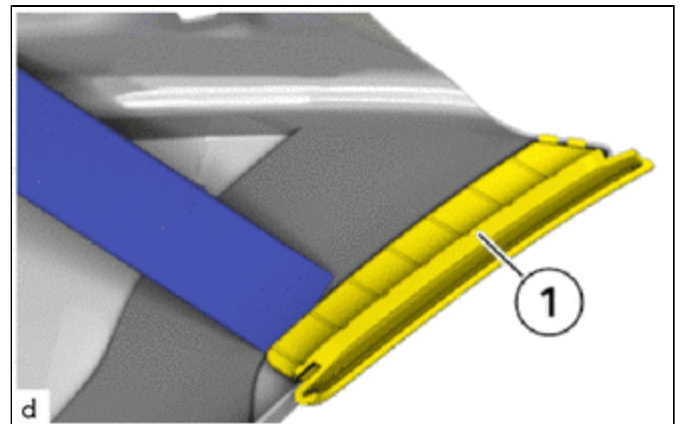
*a	Heated Part
*b	Heat Light

- Do not touch the heat light and heated parts, touching the heat light may result in burns.

NOTICE:

Do not heat the fender panel mudguard sub-assembly excessively.

- (a) Using a moulding remover A, remove the fender panel mudguard sub-assembly (1).

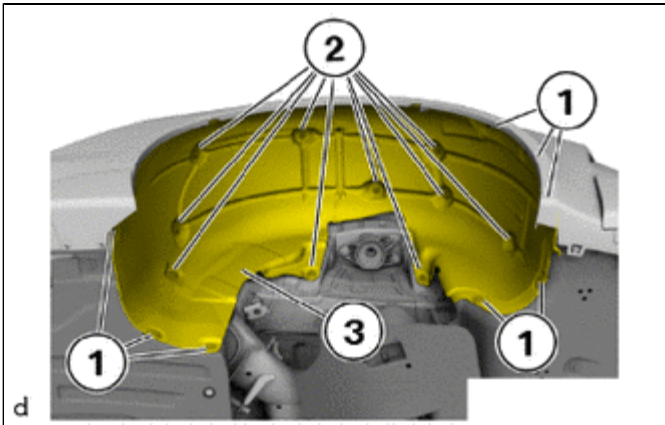


5. REMOVE REAR WHEEL LH (for Rear Side)

Click here [INFO](#)

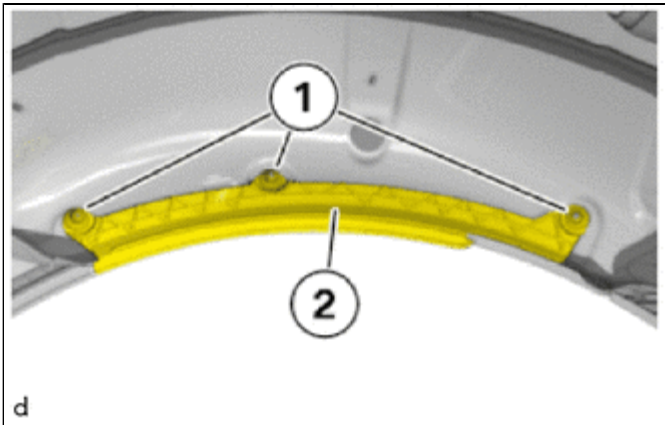
6. REMOVE REAR WHEEL HOUSE LINER (for Rear Side)

- (a) Remove the screws (1).



(b) Remove the nuts (2) and rear wheel house liner (3).

7. REMOVE QUARTER OUTSIDE MOULDING (for Rear Side)



(a) Remove the nuts (1) and quarter outside moulding (2).

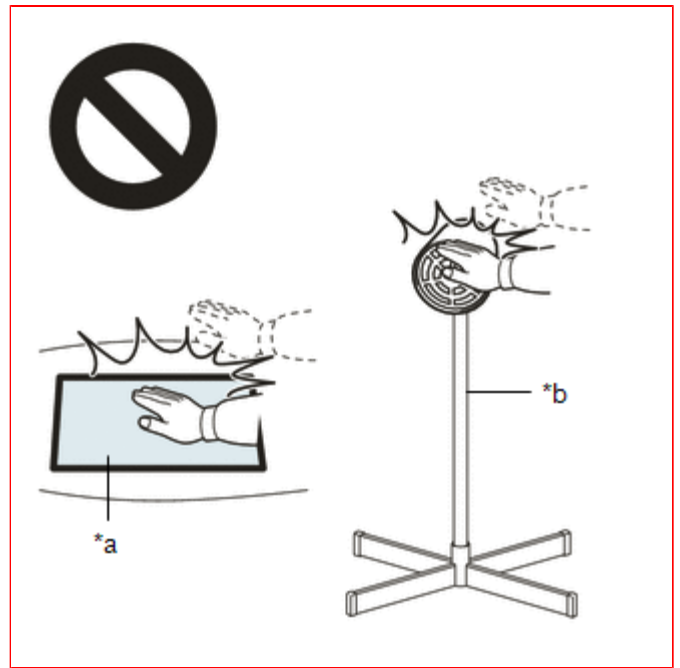
8. REMOVE NO. 1 QUARTER OUTSIDE MOULDING (for Rear Side)

HINT:
When removing the No. 1 quarter outside moulding, heat the No. 1 quarter outside moulding using a heat light.

Standard:

ITEM	TEMPERATURE
No. 1 Quarter Outside Moulding	40 to 50°C (104 to 122°F)

CAUTION:



- Touching heated parts for a long time may result in burns.

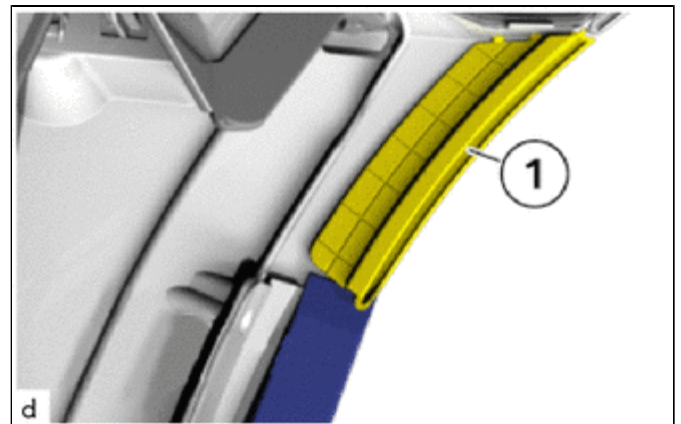
*a	Heated Part
*b	Heat Light

- Do not touch the heat light and heated parts, touching the heat light may result in burns.

NOTICE:

Do not heat the No. 1 quarter outside moulding excessively.

- (a) Using a moulding remover A, remove the No. 1 quarter outside moulding (1).



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Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: WHEEL OPENING MOULDING: INSTALLATION; 2020 MY Supra [03/2019 -]		

INSTALLATION

CAUTION / NOTICE / HINT

HINT:

- Use the same procedure for both the LH and RH sides.
- The procedure described below is for the LH side.

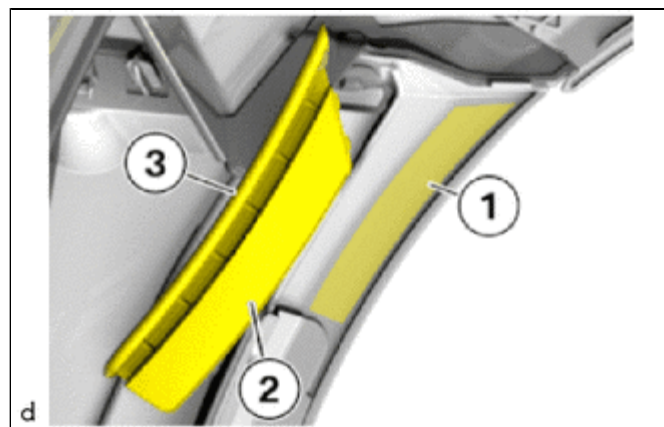
PROCEDURE

1. INSTALL NO. 1 QUARTER OUTSIDE MOULDING (for Rear Side)

- (a) Remove adhesive residue from the rear bumper cover and clean the adhesive area (1) with cleaner.

Cleaner:

Cleaner R2



- (b) Peel off the liner from adhesive tape (2).

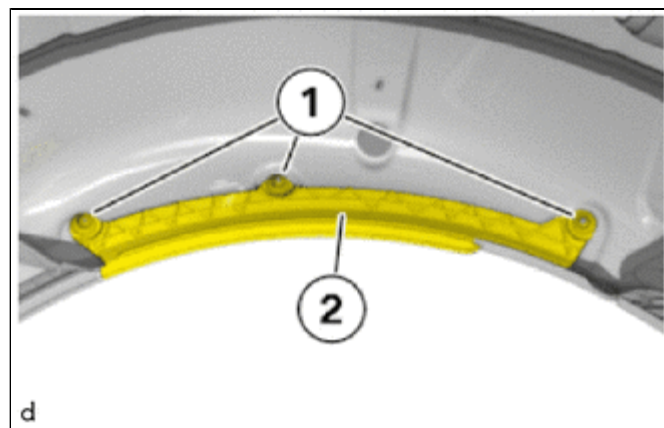
- (c) Install the No. 1 quarter outside moulding (3) and press firmly.

2. INSTALL QUARTER OUTSIDE MOULDING (for Rear Side)

- (a) Install the quarter outside moulding (2) with the nuts (1).

Torque:

3.0 N·m {31 kgf·cm, 27 in·lbf}

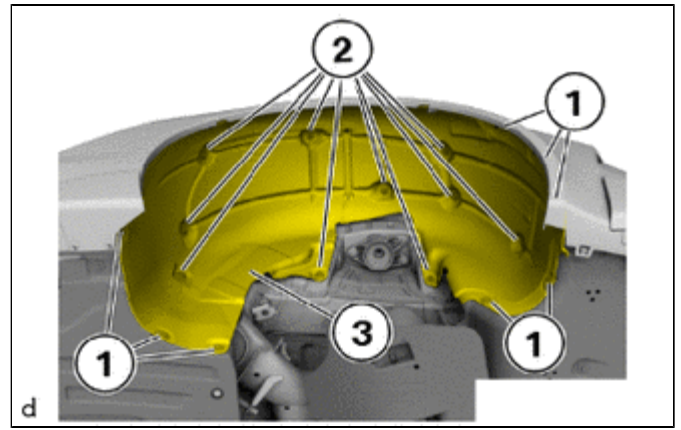


3. INSTALL REAR WHEEL HOUSE LINER (for Rear Side)

(a) Install the rear wheel house liner (3) with the nuts (2).

Torque:

2.6 N·m {27 kgf·cm, 23 in·lbf}



(b) Install the screws (1).

Torque:

2.6 N·m {27 kgf·cm, 23 in·lbf}

4. INSTALL REAR WHEEL LH (for Rear Side)

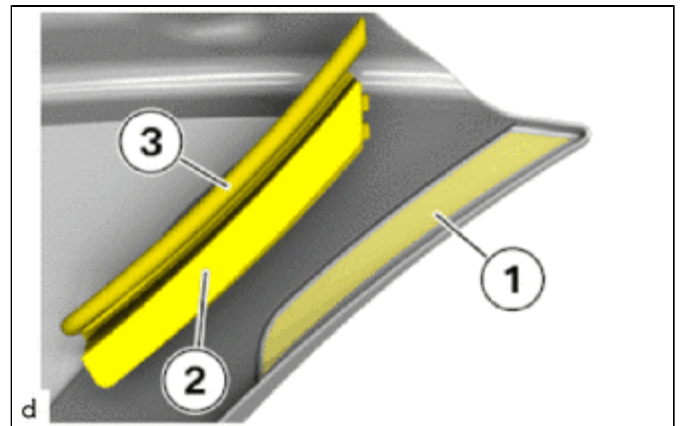
Click here [INFO](#)

5. INSTALL FENDER PANEL MUDGUARD SUB-ASSEMBLY (for Front Side)

(a) Remove adhesive residue on the front side panel and clean the adhesive area (1) with cleaner.

Cleaner:

Cleaner R2

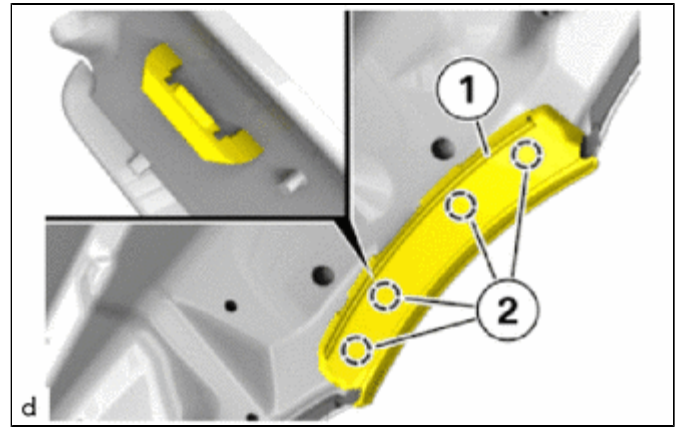


(b) Peel off the liner from adhesive tape (2).

(c) Install the fender panel mudguard sub-assembly (3) and press tightly.

6. INSTALL HOOD MOULDING (for Front Side)

(a) Engage the claws (2) to install the hood moulding (1).



7. INSTALL FRONT NO. 2 FENDER LINER (for Front Side)

Click here [INFO](#)

8. INSTALL FRONT WHEEL LH (for Front Side)

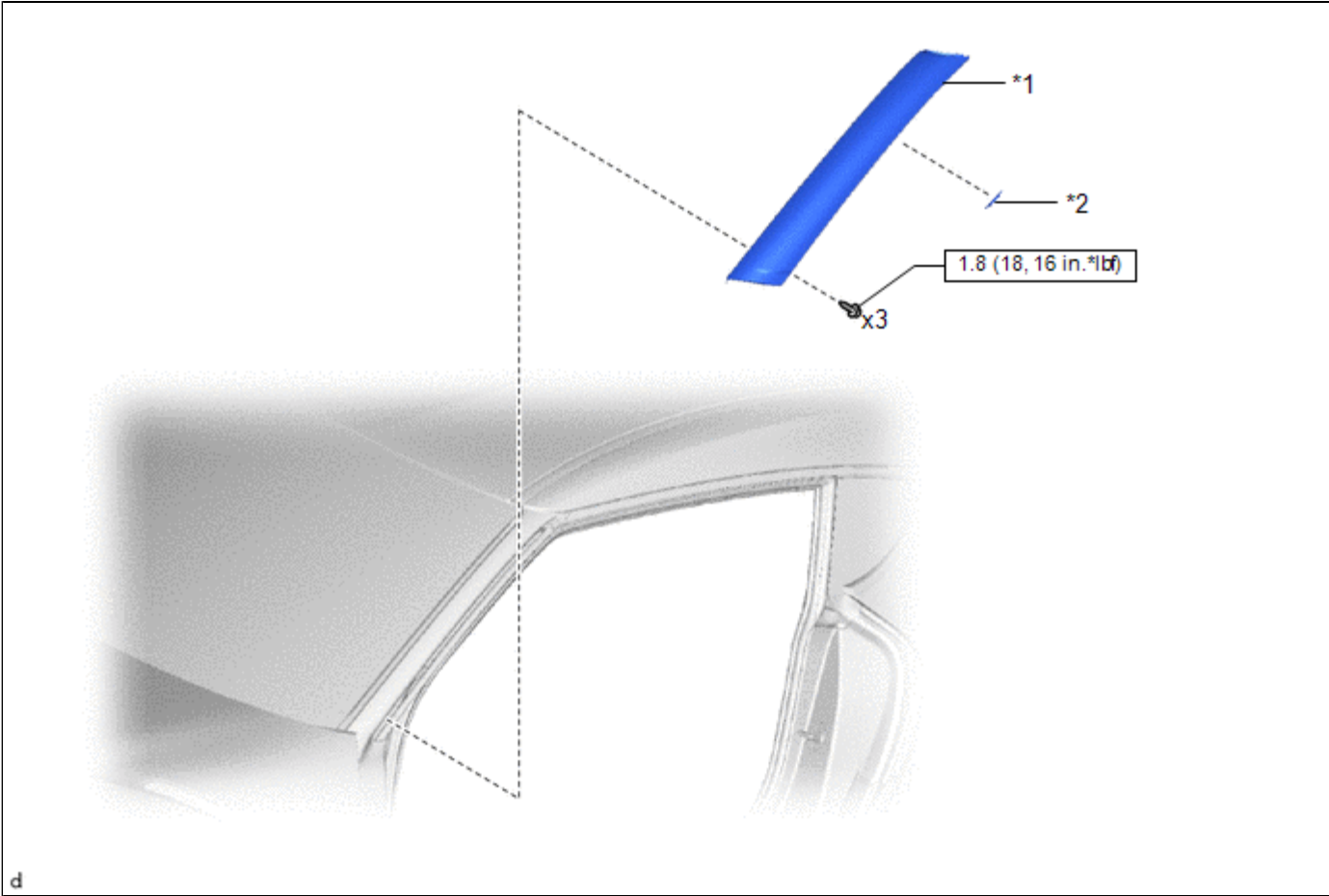
Click here [INFO](#)



Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCN4
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: WINDSHIELD OUTSIDE MOULDING: COMPONENTS; 2020 MY Supra [03/2019 -]		

COMPONENTS

ILLUSTRATION



*1	ROOF DRIP SIDE FINISH MOULDING	*2	ROOF DRIP SIDE FINISH MOULDING CLIP
	N*m (kgf*cm, ft.*lbf): Specified torque	-	-

Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCN5
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: WINDSHIELD OUTSIDE MOULDING: REMOVAL; 2020 MY Supra [03/2019 -]		

REMOVAL

CAUTION / NOTICE / HINT

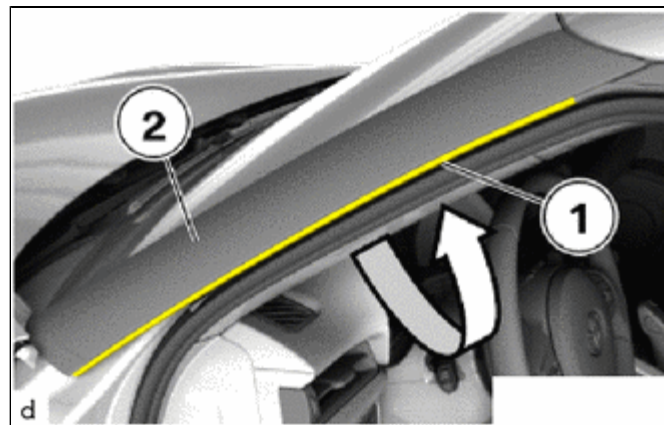
HINT:

- Use the same procedure for both the LH and RH sides.
- The procedure described below is for the LH side.

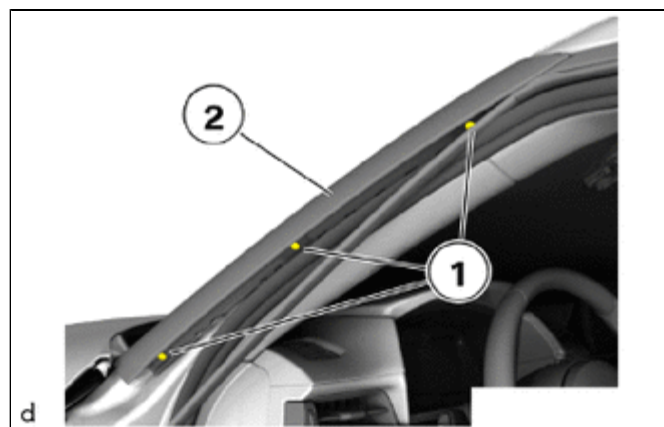
PROCEDURE

1. REMOVE ROOF DRIP SIDE FINISH MOULDING

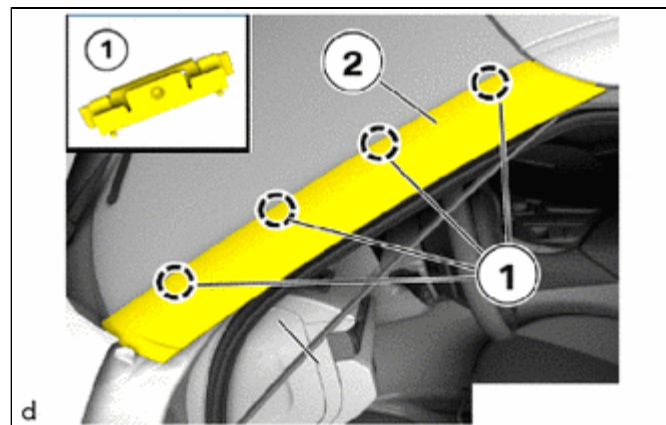
- (a) Disconnect the front door window frame front moulding (1) in the direction of arrow on the roof drip side finish moulding (2).



- (b) Remove the T20 screws (1) on the roof drip side finish moulding (2).



(c) Disengage the claws (1) to remove the roof drip side finish moulding (2).



(d) Remove the roof drip side finish moulding clips (1).

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Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: EXTERIOR PANELS / TRIM: WINDSHIELD OUTSIDE MOULDING: INSTALLATION; 2020 MY Supra [03/2019 -]		

INSTALLATION

CAUTION / NOTICE / HINT

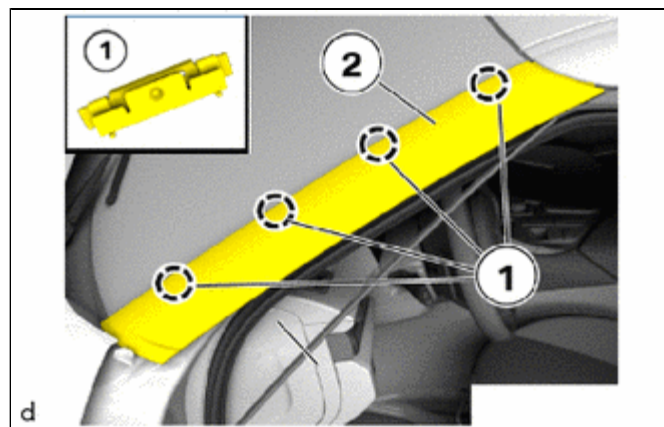
HINT:

- Use the same procedure for both the LH and RH sides.
- The procedure described below is for the LH side.

PROCEDURE

1. INSTALL ROOF DRIP SIDE FINISH MOULDING

(a) Install the roof drip side finish moulding clips (1).

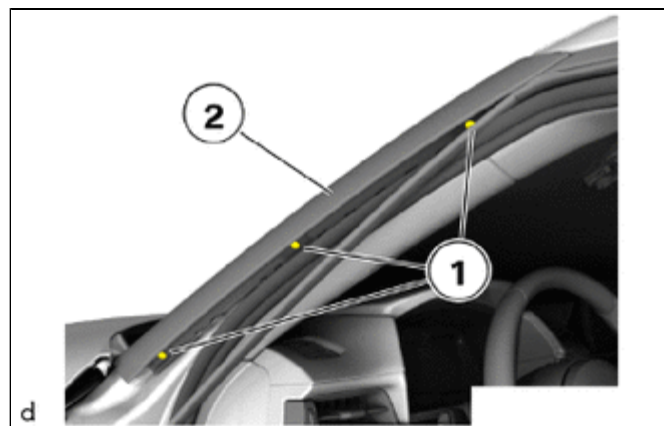


(b) Engage the claws (1) to install the roof drip side finish moulding (2).

(c) Install the T20 screws (1) on the roof drip side finish moulding (2).

Torque:

1.8 N·m {18 kgf·cm, 16 in·lbf}



(d) Connect the front door window frame front moulding.