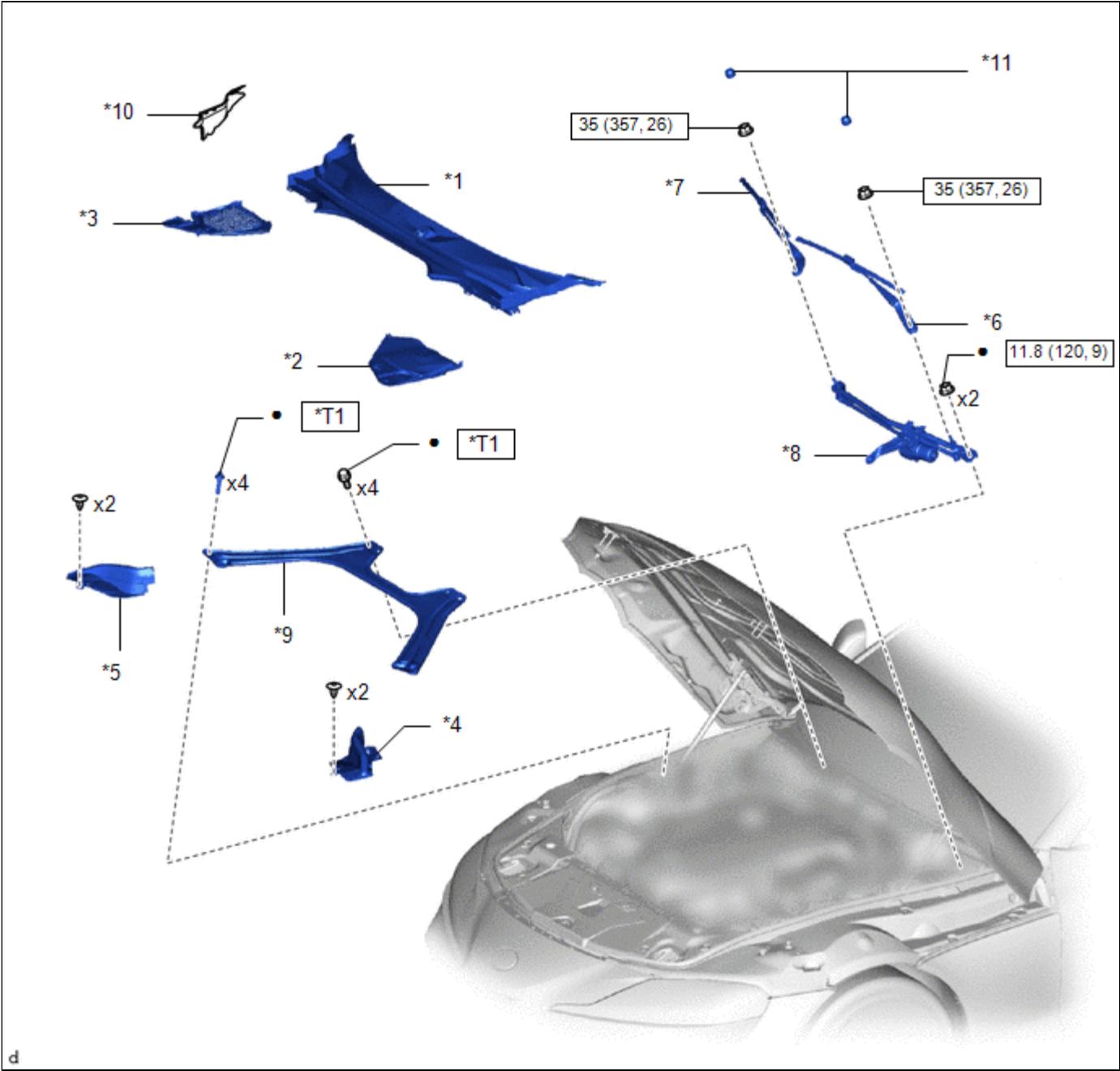


Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCCR
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WIPER / WASHER: FRONT WIPER MOTOR: COMPONENTS; 2020 MY Supra [03/2019 -]		

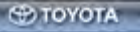
COMPONENTS

ILLUSTRATION



*1	COWL TOP VENTILATOR LOUVER SUB-ASSEMBLY	*2	COWL VENT COVER LH
*3	COWL VENT COVER RH	*4	FRONT FENDER TO COWL SIDE SEAL LH

*5	FRONT FENDER TO COWL SIDE SEAL RH	*6	FRONT WIPER ARM AND BLADE ASSEMBLY LH
*7	FRONT WIPER ARM AND BLADE ASSEMBLY RH	*8	FRONT WIPER MOTOR AND LINK ASSEMBLY
*9	UPPER FRONT SUSPENSION CENTER BRACE	*10	WATER GUARD PLATE RH
*11	FRONT WIPER ARM HEAD CAP	-	-
	N*m (kgf*cm, ft.*lbf): Specified torque	•	Non-reusable part
*T1	1st: 56 N*m (571 kgf*cm, 41 ft.*lbf) 2nd: Turn 90°	-	-



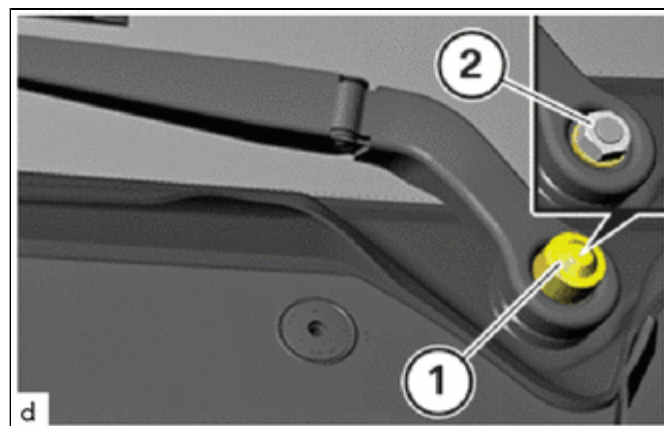
Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCCS
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WIPER / WASHER: FRONT WIPER MOTOR: REMOVAL; 2020 MY Supra [03/2019 -]		

REMOVAL

PROCEDURE

1. REMOVE FRONT WIPER ARM AND BLADE ASSEMBLY LH

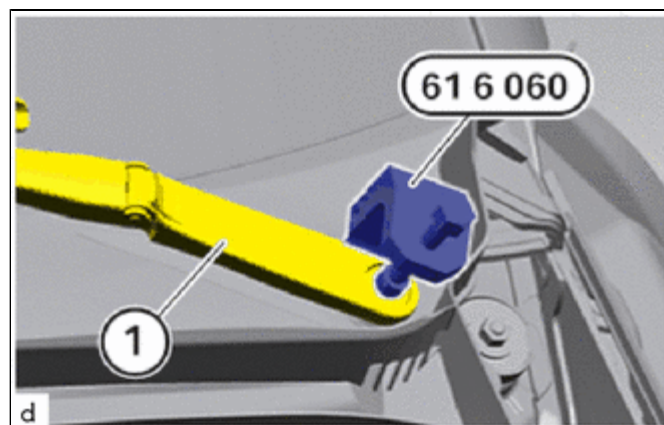
(a) Remove the front wiper arm head cap (1).



(b) Using a socket wrench 16 mm, remove nut (2).

(c) Using special tool 0 493 441 (61 6 060), pull off the front wiper arm and blade assembly LH (1).

SST: 09800-WA020



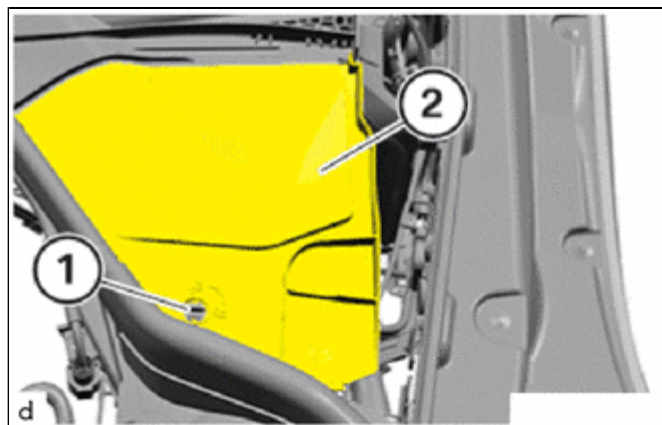
2. REMOVE FRONT WIPER ARM AND BLADE ASSEMBLY RH

HINT:

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

3. REMOVE COWL VENT COVER LH

(a) Disengage the lock (1).

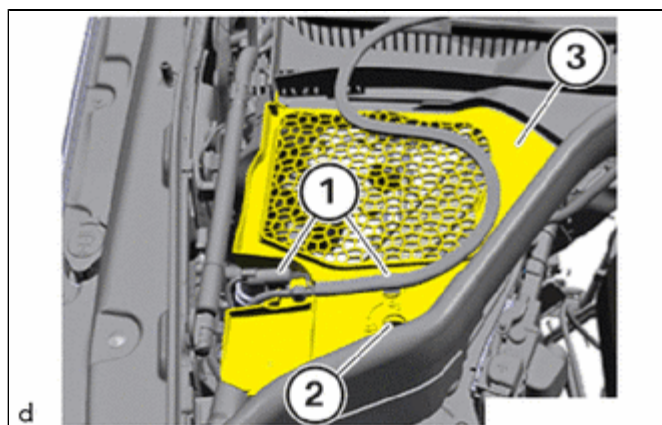


(b) Remove cowl vent cover LH (2).

4. REMOVE COWL VENT COVER RH

(a) for Type A:

(1) Disconnect the connector and washer nozzle and hose assembly (1) from the cowl vent cover RH (3).

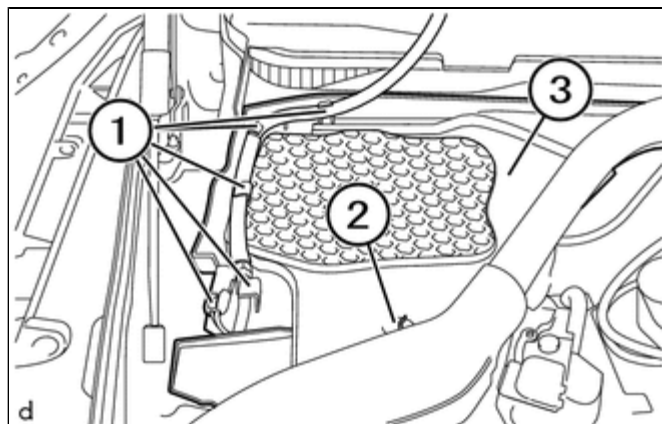


(2) Disengage the lock (2).

(3) Remove the cowl vent cover RH (3).

(b) for Type B:

(1) Disconnect the connector and washer nozzle and hose assembly (1) from the cowl vent cover RH (3).

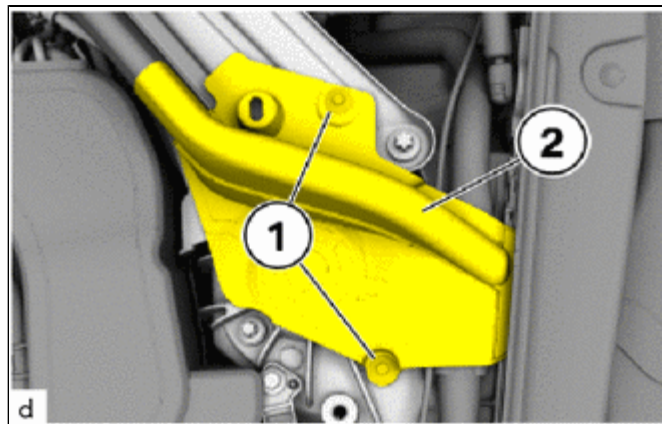


(2) Disengage the lock (2).

(3) Remove the cowl vent cover RH (3).

5. REMOVE FRONT FENDER TO COWL SIDE SEAL LH

(a) Remove the clips (1).



(b) Remove front fender to cowl side seal LH (2).

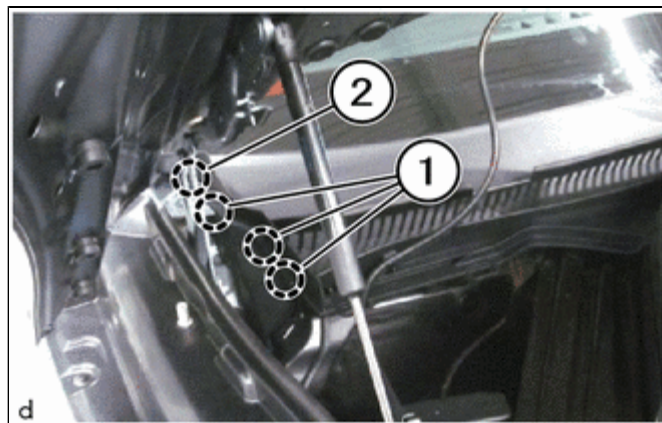
6. REMOVE FRONT FENDER TO COWL SIDE SEAL RH

HINT:

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

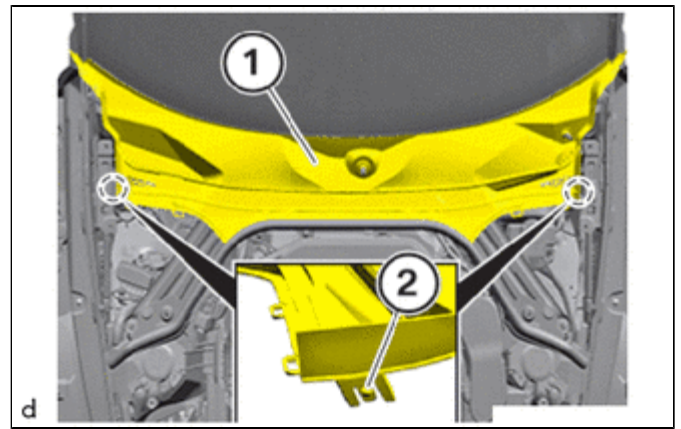
7. REMOVE WATER GUARD PLATE RH

(a) Disengage the claws (1) and guide (2) to remove the water guard plate RH.

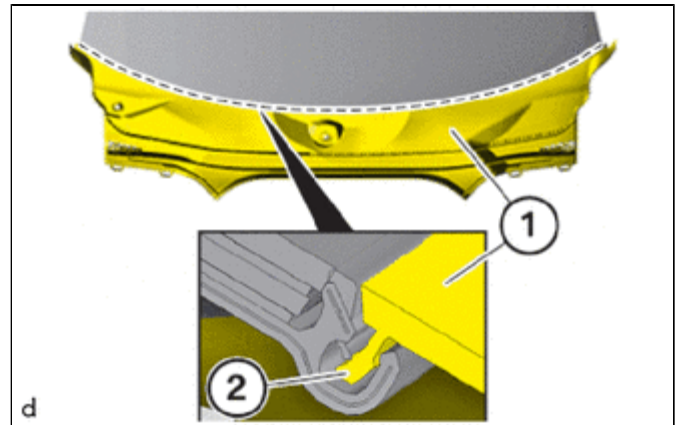


8. REMOVE COWL TOP VENTILATOR LOUVER SUB-ASSEMBLY

(a) Disengage the claws (2) to disconnect the cowl top ventilator louver sub-assembly (1).



(b) Pull the cowl top ventilator louver sub-assembly (1) upward out of the claw (2) beginning on the side.

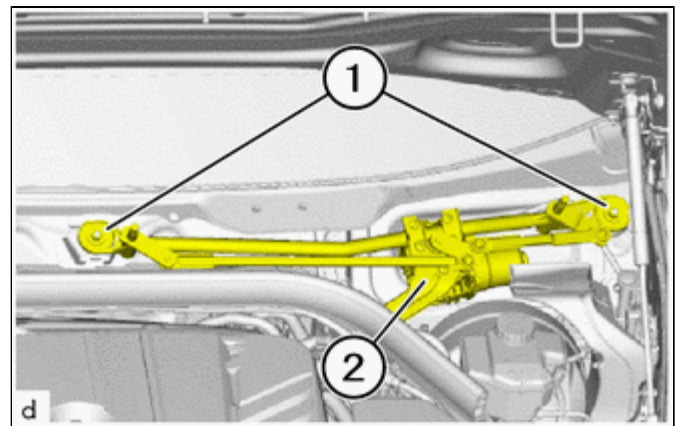


9. REMOVE UPPER FRONT SUSPENSION CENTER BRACE

Click here [INFO](#)

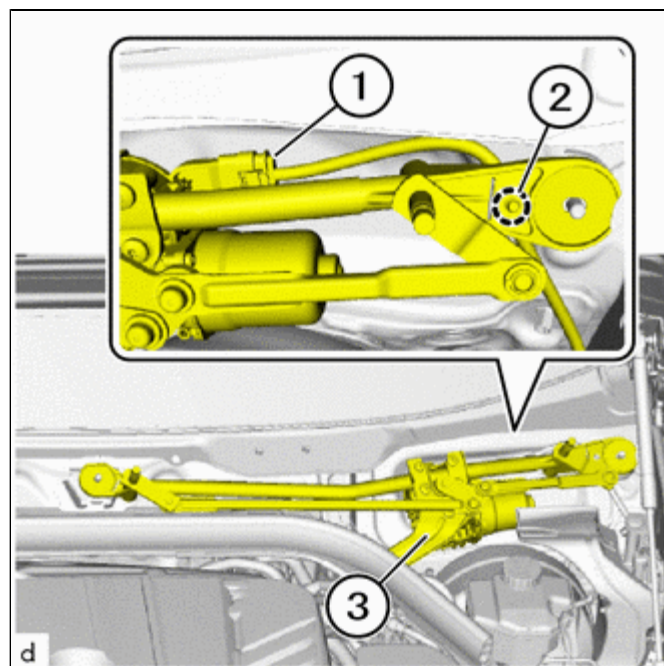
10. REMOVE FRONT WIPER MOTOR AND LINK ASSEMBLY

(a) Remove the nuts (1).



(b) Disengage the guide (2).

(c) Disengage the clamp (2).



(d) Disconnect the connector (1) to remove the front wiper motor and link assembly (3).

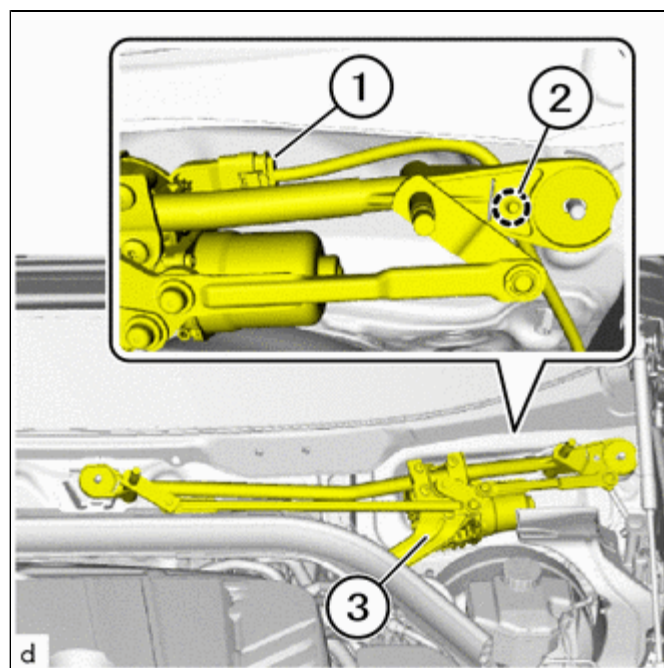
Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCCT
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WIPER / WASHER: FRONT WIPER MOTOR: INSTALLATION; 2020 MY Supra [03/2019 -]		

INSTALLATION

PROCEDURE

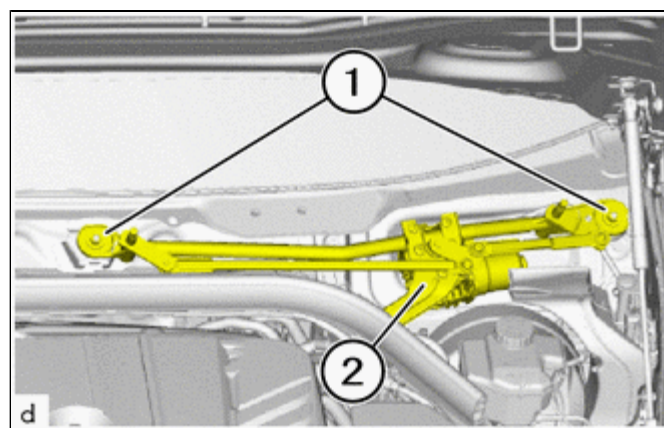
1. INSTALL FRONT WIPER MOTOR AND LINK ASSEMBLY

(a) Connect the connector (1).



(b) Engage the guide (3) and clamp (2).

(c) Install the front wiper motor and link assembly (2).



(d) Install a new nuts (1).

Torque:

11.8 N·m {120 kgf·cm, 9 ft·lbf}

2. INSTALL UPPER FRONT SUSPENSION CENTER BRACE

Click here [INFO](#)

3. INSTALL COWL TOP VENTILATOR LOUVER SUB-ASSEMBLY

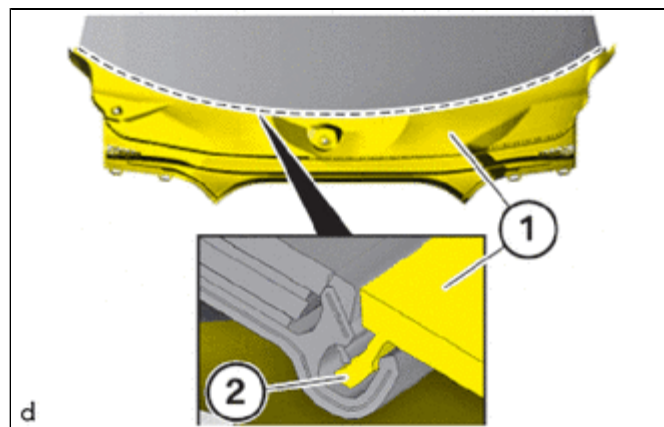
NOTICE:

- Damage caused by water ingress into the vehicle.

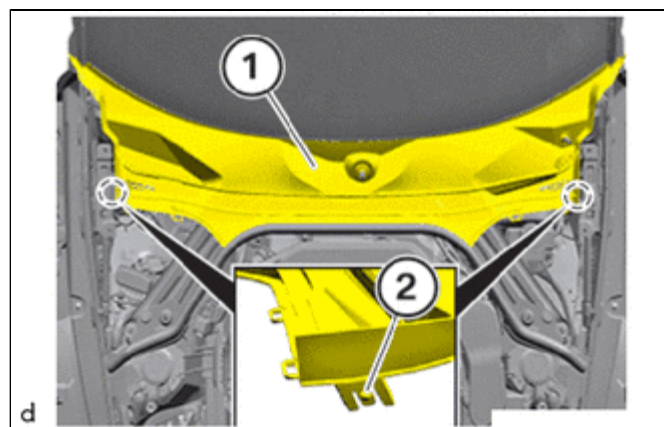
Water ingress into the vehicle may result in damage to components, malfunctions and corrosion.

- Ensure correct installation of the components.
- Only use undamaged components.

- (a) Push the cowl top ventilator louver sub-assembly (1) into the claw (2) beginning on the side.

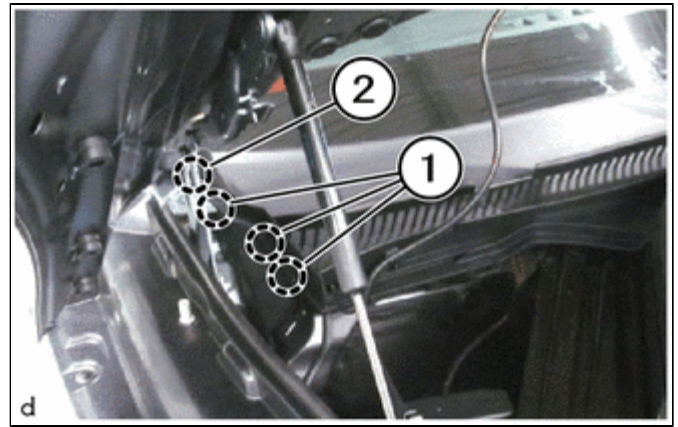


- (b) Engage the cowl top ventilator louver sub-assembly (1) in the claws (2).



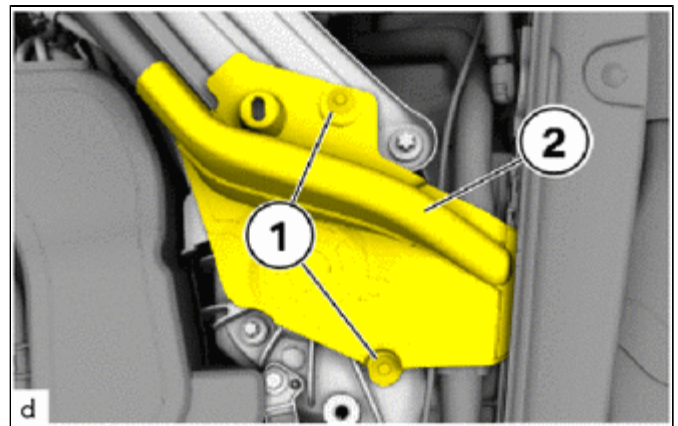
4. INSTALL WATER GUARD PLATE RH

- (a) Engage the guide (2) and claws (1) to install the water guard plate RH.



5. INSTALL FRONT FENDER TO COWL SIDE SEAL LH

(a) Install front fender to cowl side seal LH (2).



(b) Install clips (1).

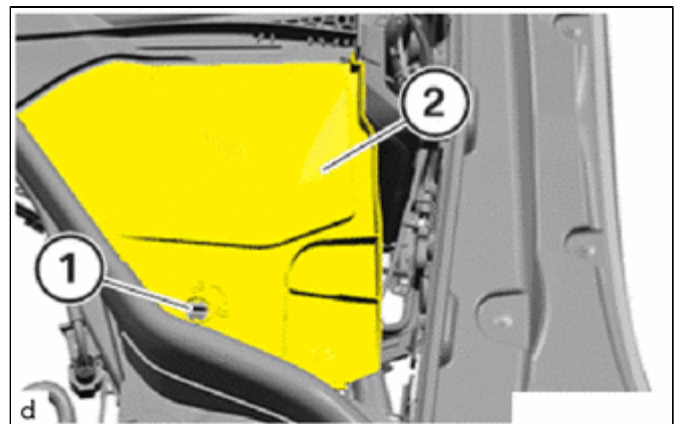
6. INSTALL FRONT FENDER TO COWL SIDE SEAL RH

HINT:

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

7. INSTALL COWL VENT COVER LH

(a) Install the cowl vent cover LH (2).

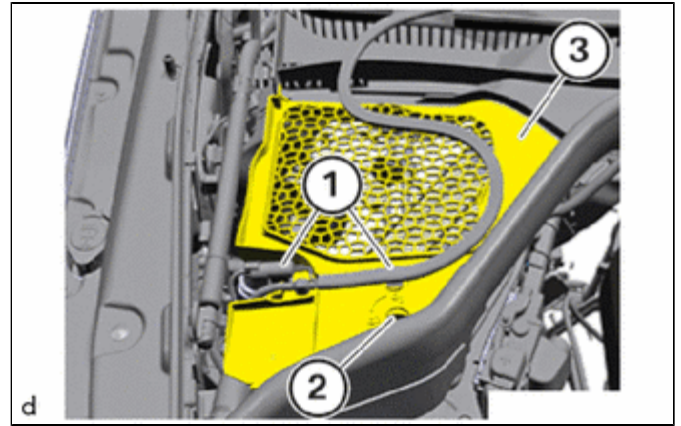


(b) Engage the lock (1).

8. INSTALL COWL VENT COVER RH

(a) for Type A:

(1) Install the cowl vent cover RH (3).

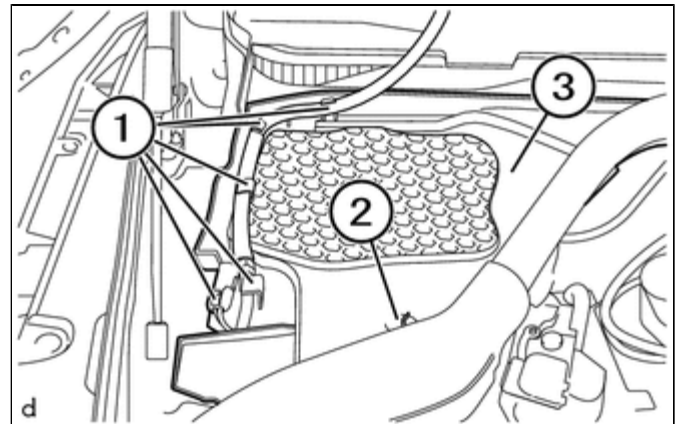


(2) Engage the lock (2).

(3) Connect the connector and the washer nozzle and hose assembly (1) to the cowl vent cover RH (3).

(b) for Type B:

(1) Install the cowl vent cover RH (3).

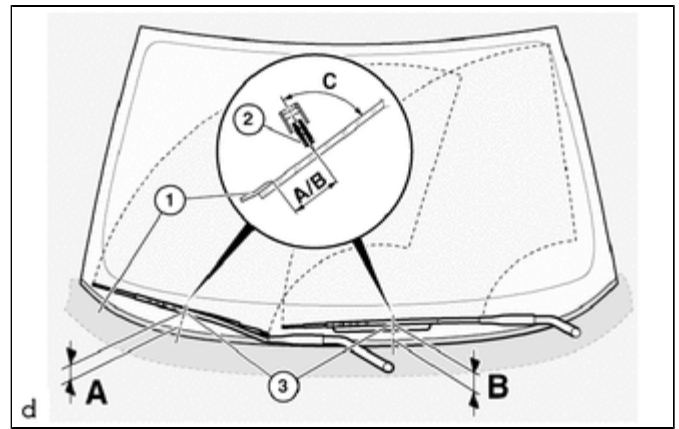


(2) Engage the lock (2).

(3) Connect the connector and the washer nozzle and hose assembly (1) to the cowl vent cover RH (3).

9. INSPECT FRONT WIPER ARM AND BLADE ASSEMBLY

(a) Connect the front wiper arm and blade assembly (3).



(b) Correctly position the front wiper arm and blade assembly (2) in relation to the windshield glass edge (1).

Distance from windshield glass edge to wiper blade:

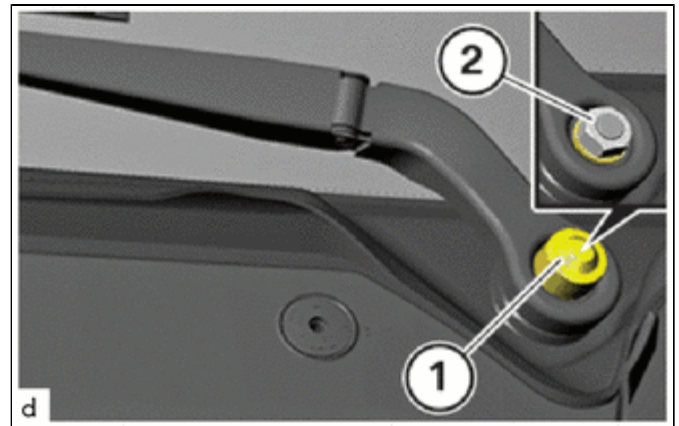
AREA	DIMENSION
A	65.0 mm (2.56 in.)
B	58.0 mm (2.28 in.)

10. INSTALL FRONT WIPER ARM AND BLADE ASSEMBLY LH

(a) Using a socket wrench 16 mm, tighten nut (2).

Torque:

35.0 N·m {357 kgf·cm, 26 ft·lbf}



(b) Install the front wiper arm head cap (1).

11. INSTALL FRONT WIPER ARM AND BLADE ASSEMBLY RH

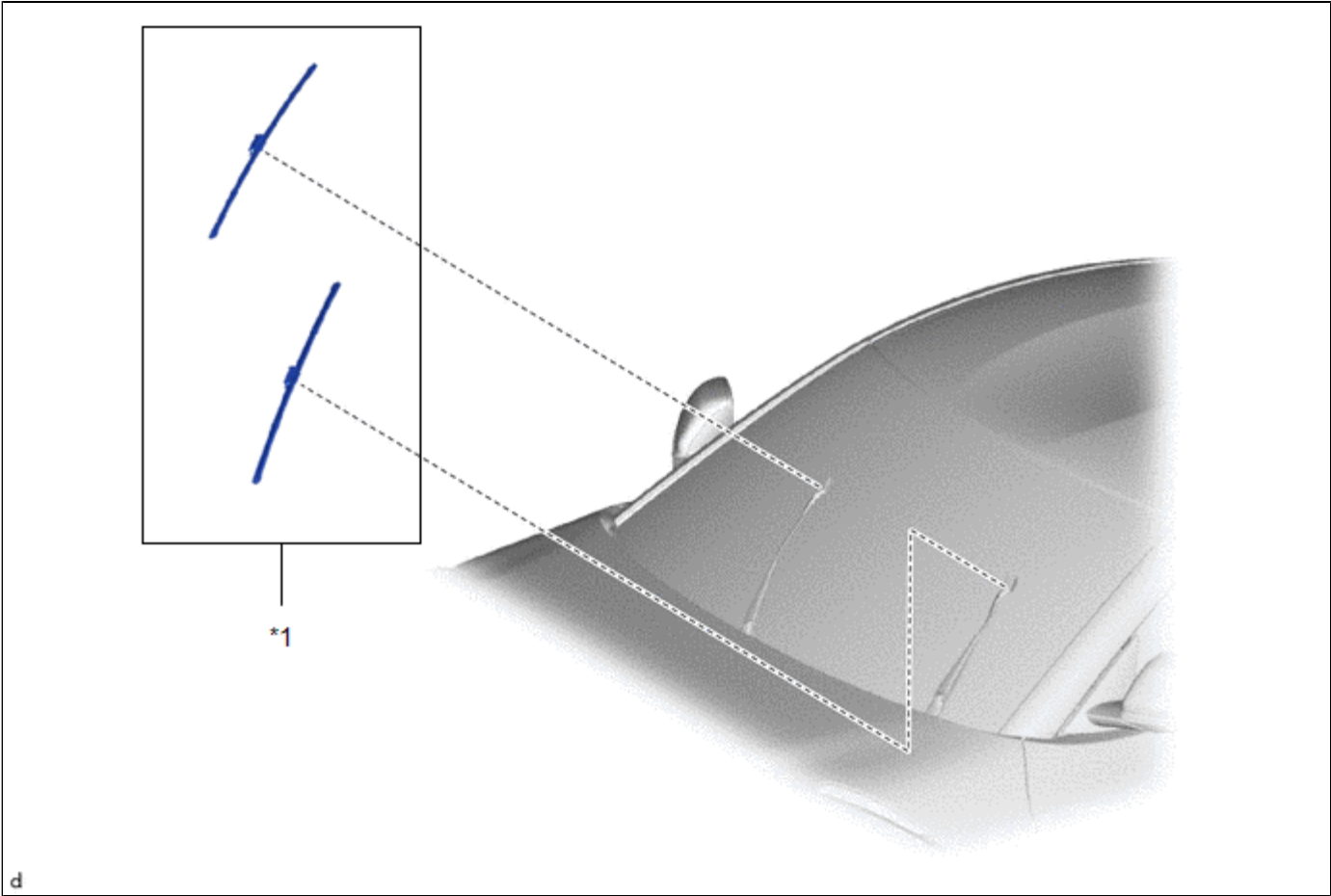
HINT:

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

Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCCU
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WIPER / WASHER: FRONT WIPER RUBBER: COMPONENTS; 2020 MY Supra [03/2019 -]		

COMPONENTS

ILLUSTRATION



*1	FRONT WIPER BLADE	-	-
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Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCCV
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WIPER / WASHER: FRONT WIPER RUBBER: REMOVAL; 2020 MY Supra [03/2019 -]		

REMOVAL

CAUTION / NOTICE / HINT

Click here [INFO](#)



Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCCW
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WIPER / WASHER: FRONT WIPER RUBBER: INSTALLATION; 2020 MY Supra [03/2019 -]		

INSTALLATION

CAUTION / NOTICE / HINT

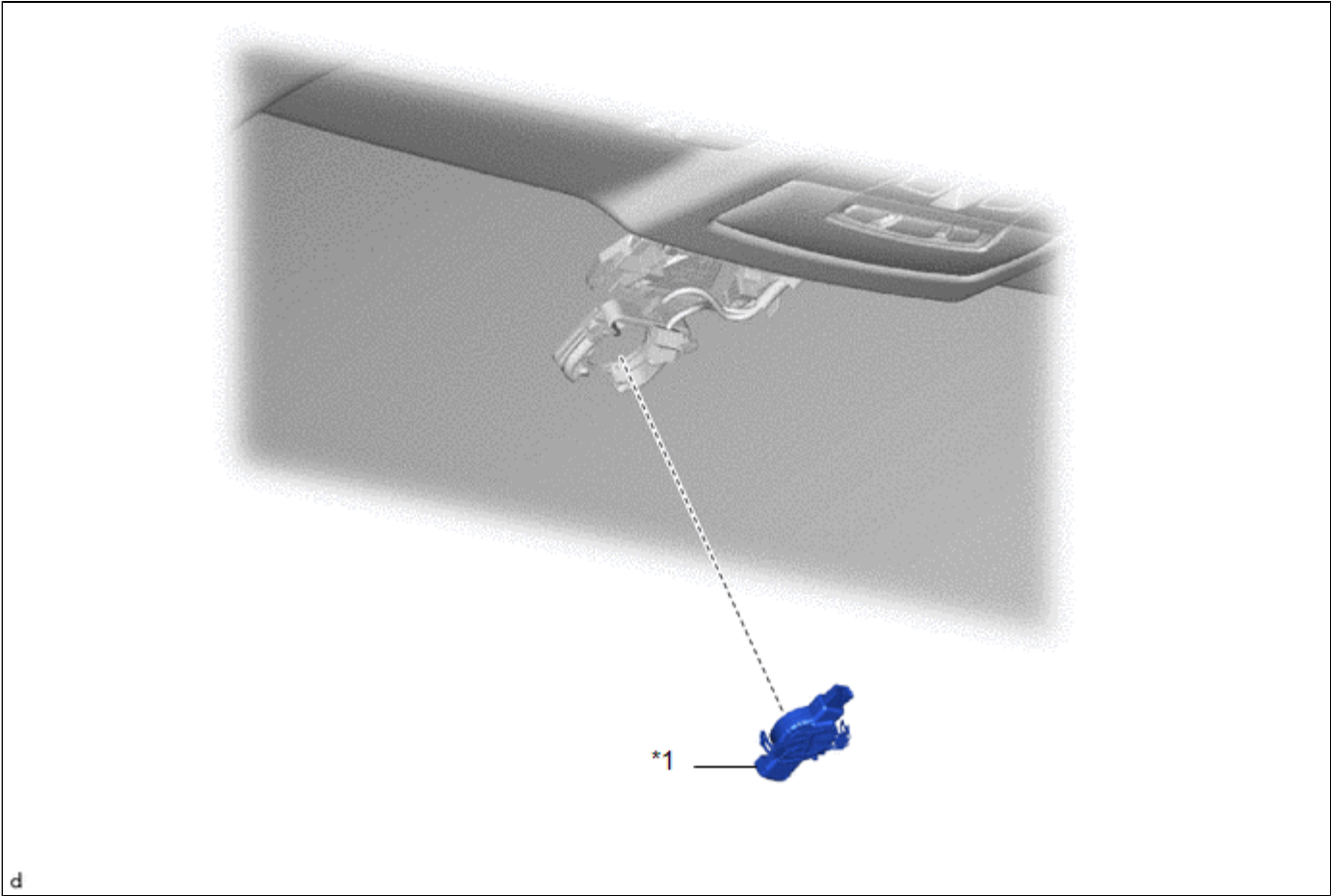
Click here [INFO](#)



Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCD6
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WIPER / WASHER: RAIN SENSOR: COMPONENTS; 2020 MY Supra [03/2019 -]		

COMPONENTS

ILLUSTRATION



*1	RAIN SENSOR	-	-
----	-------------	---	---

Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCD7
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WIPER / WASHER: RAIN SENSOR: REMOVAL; 2020 MY Supra [03/2019 -]		

REMOVAL

PROCEDURE

1. REMOVE INNER REAR VIEW MIRROR ASSEMBLY

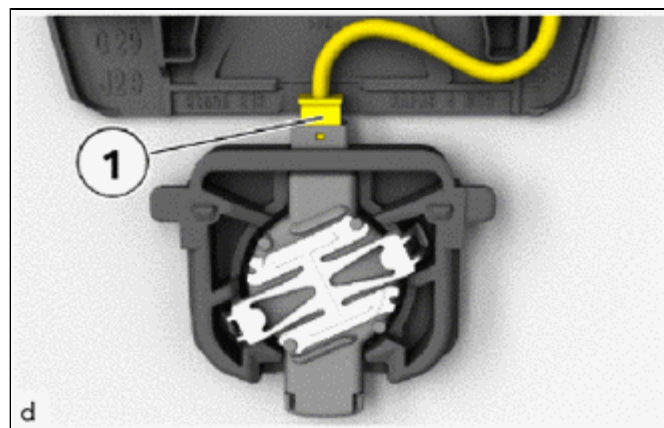
Click here [INFO](#)

2. REMOVE RAIN SENSOR

NOTICE:

When replacing windshield glass: Immediately install the rain sensor on the new windshield glass.

(a) Disconnect the connector (1).



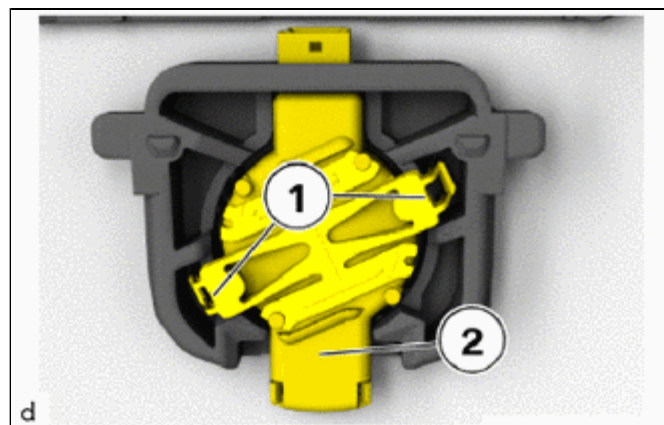
(b) Push in retaining springs (1) on both sides and disengage the lock by means of a screwdriver.

NOTICE:

- Damage to silicone surface.

A damaged silicone surface can lead to malfunctioning of the rain sensor (2).

- Do not touch or damage the silicone-coated surface on the rain sensor (2).



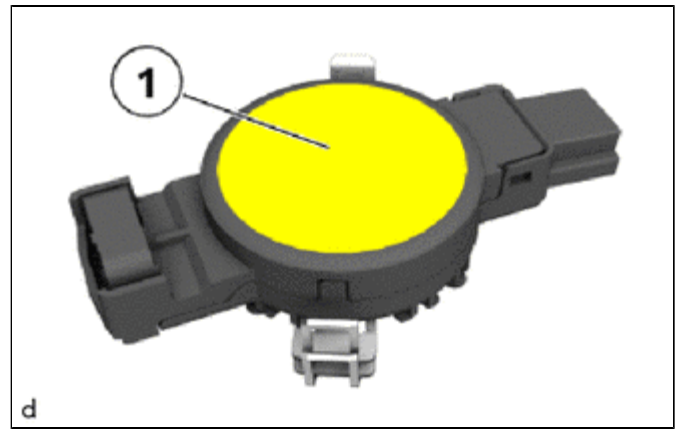
(c) Remove the rain sensor slowly off the windshield glass. At the same time, monitor the release of the silicone area (1) from outside.

NOTICE:

The silicone surface must evenly loosen from the windshield glass, if applicable, lower the pull-off force.

HINT:

After releasing lock, wait approx. 30 minutes. at 20°C (68°F) for silicone surface to relax.



Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCD8
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WIPER / WASHER: RAIN SENSOR: INSTALLATION; 2020 MY Supra [03/2019 -]		

INSTALLATION

PROCEDURE

1. INSTALL RAIN SENSOR

NOTICE:

- Damage to silicone surface.

A damaged silicone surface can lead to malfunctioning of the rain sensor.

- Do not touch or damage the silicone-coated surface on the rain sensor.

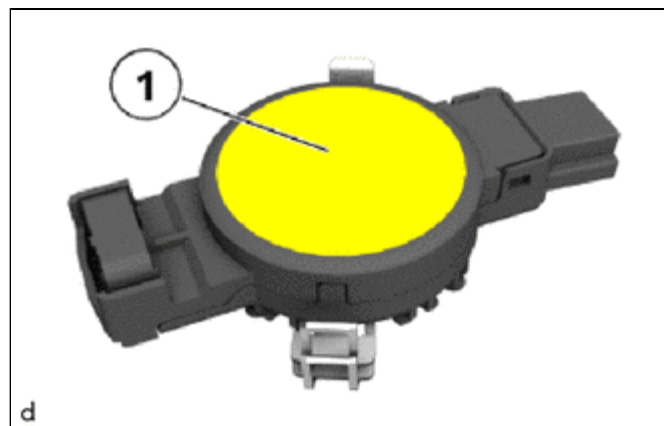
HINT:

After releasing lock, wait approx. 30 minutes. at 20°C (68°F) for silicone surface to relax.

(a) Check silicone surface (1) for damage.

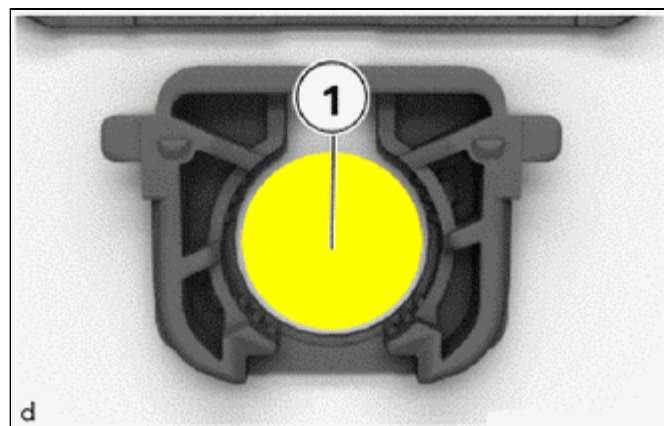
HINT:

- Silicone surface (1) is damaged.
 - Replace rain sensor.



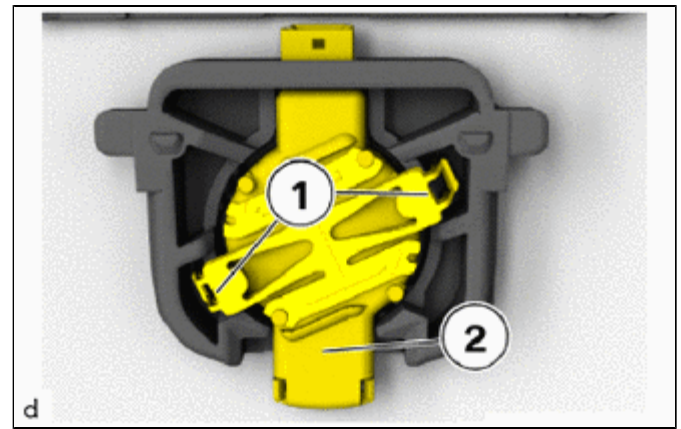
d

(b) Carefully clean windshield glass in the contact area (1) of rain sensor.



d

(c) Install the rain sensor (2) into the holder and press on centered on the retaining springs (1).

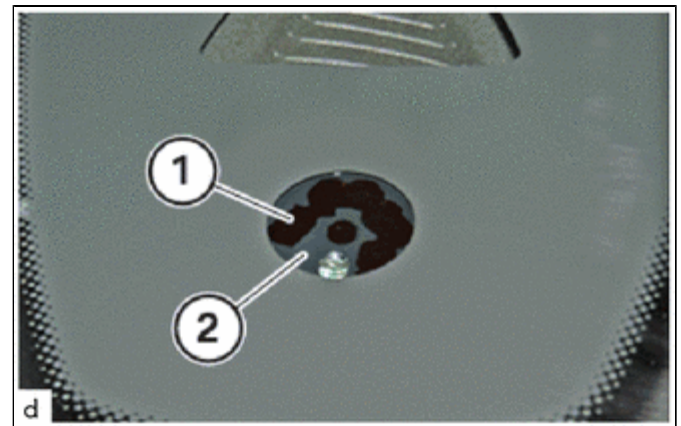


(d) Successively press down the retaining springs (1) on each side to lock it.

(e) Check contact surfaces for air pockets from the outside.

HINT:

- Visible shadows (1) are not air pockets, but the optical element of the rain sensor (2).
- The shadows (1) do not indicate a functional limitation.
- Contact surface has air pockets.
 - Remove the rain sensor and install again.



(f) Connect the connector.

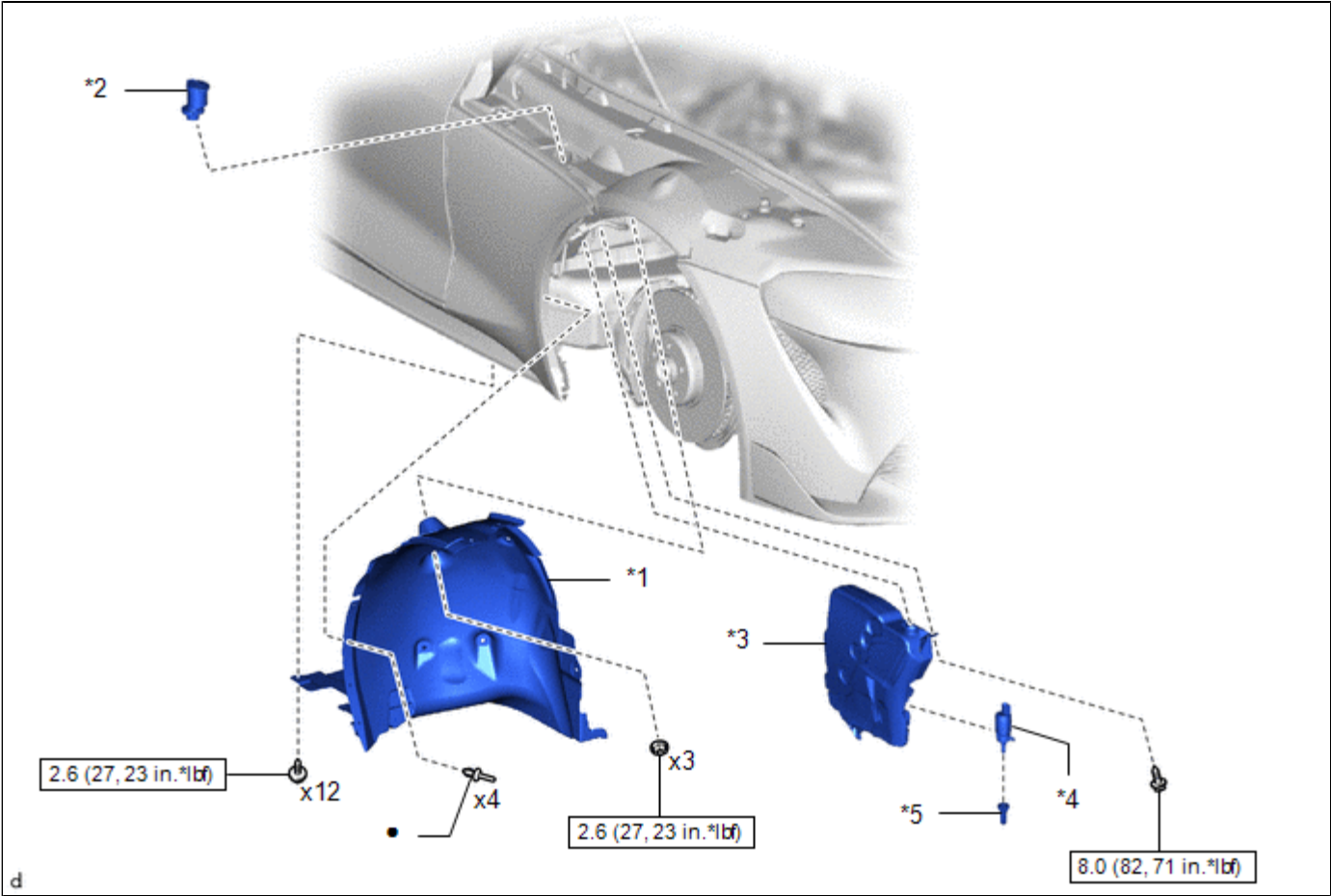
2. INSTALL INNER REAR VIEW MIRROR ASSEMBLY

Click here [INFO](#)

Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCD0
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WIPER / WASHER: WASHER MOTOR: COMPONENTS; 2020 MY Supra [03/2019 -]		

COMPONENTS

ILLUSTRATION



*1	FRONT NO. 2 FENDER LINER RH	*2	WASHER INLET SUB-ASSEMBLY
*3	WINDSHIELD WASHER JAR ASSEMBLY	*4	WINDSHIELD WASHER MOTOR AND PUMP ASSEMBLY
*5	STRAINER WITH SEAL	-	-
	N*m (kgf*cm, ft.*lbf): Specified torque	●	Non-reusable part

Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCD1
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WIPER / WASHER: WASHER MOTOR: REMOVAL; 2020 MY Supra [03/2019 -]		

REMOVAL PROCEDURE

1. REMOVE FRONT WHEEL RH

Click here [INFO](#)

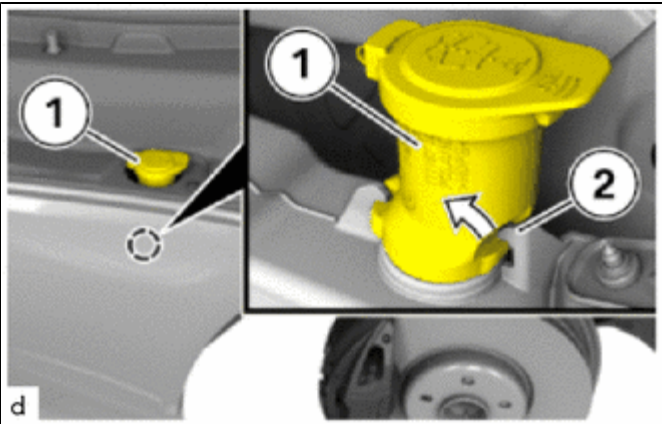
2. REMOVE FRONT NO. 2 FENDER LINER RH

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

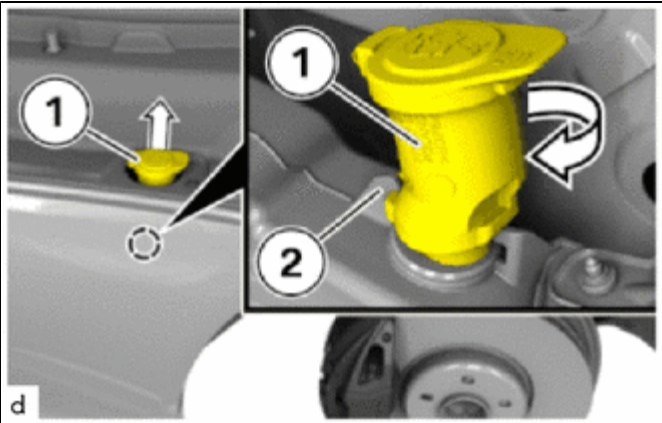
Click here [INFO](#)

3. REMOVE WASHER INLET SUB-ASSEMBLY

(a) Disengage the washer inlet sub-assembly (1) out of the front tabs (2) in the direction of the arrow.

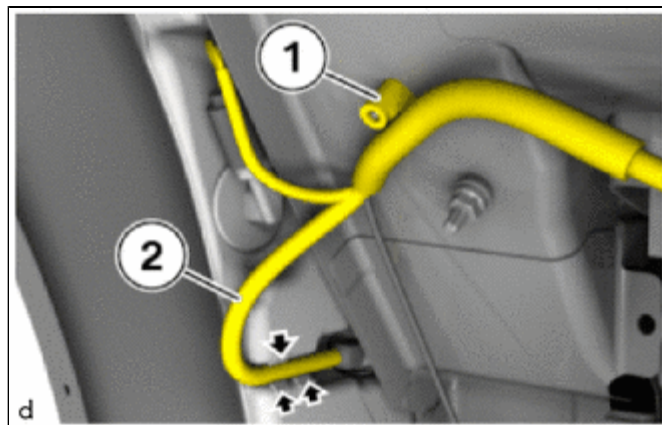


(b) Remove washer inlet sub-assembly (1) in direction of arrow and feed out from rear tabs (2).

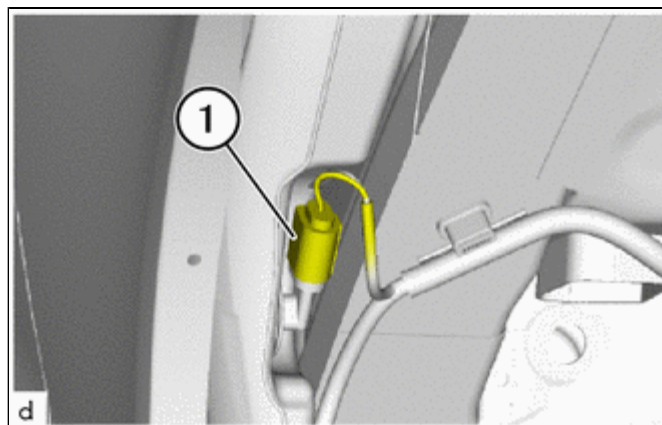


4. REMOVE WINDSHIELD WASHER JAR ASSEMBLY

(a) Disengage the clamp (1).

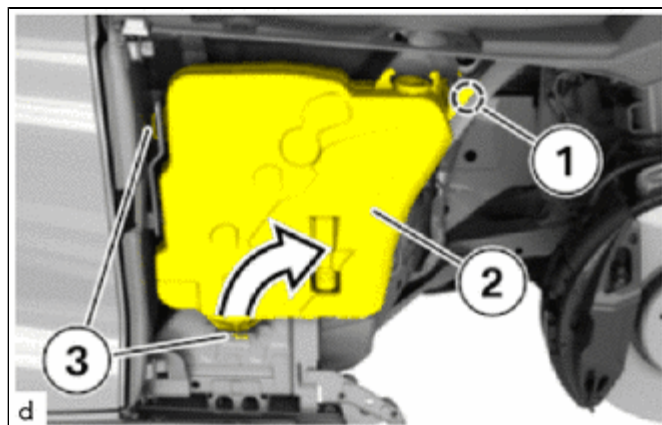


(b) Disengage the washer hose (2) in the marked area (arrows).



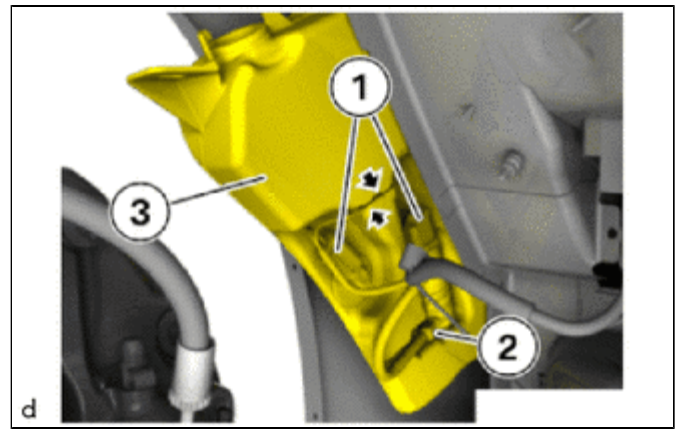
(c) Disconnect the connector (1).

(d) Remove the screw (1).



(e) Tilt the windshield washer jar assembly (2) from the guides (3) in the direction of arrow.

(f) Disengage the wire harness in the marked area (arrows).



(g) Disconnect the connectors (1).

(h) Disconnect the washer hose at the snap fastener (2).

(i) Catch the escaping washer fluid.

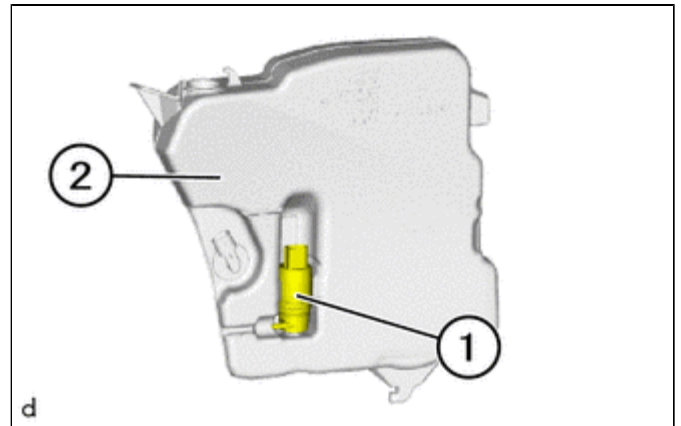
HINT:

Use a container to collect the washer fluid.

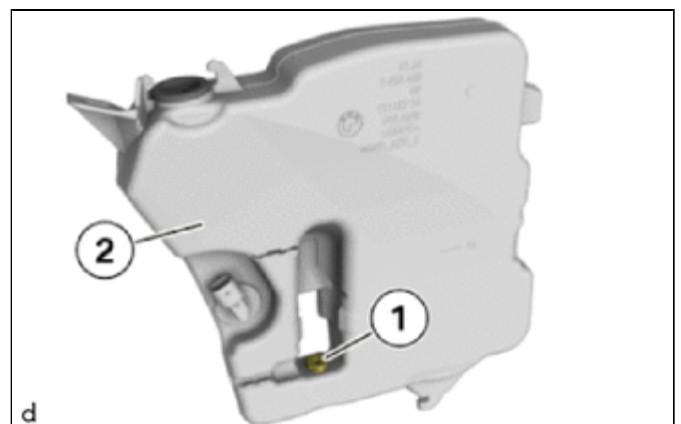
(j) Remove windshield washer jar assembly (3).

5. REMOVE WINDSHIELD WASHER MOTOR AND PUMP ASSEMBLY

(a) Remove the windshield washer motor and pump assembly (1) from the windshield washer jar assembly (2).



(b) Remove strainer with seal (1) in the windshield washer jar assembly (2).





Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCD2
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WIPER / WASHER: WASHER MOTOR: INSTALLATION; 2020 MY Supra [03/2019 -]		

INSTALLATION

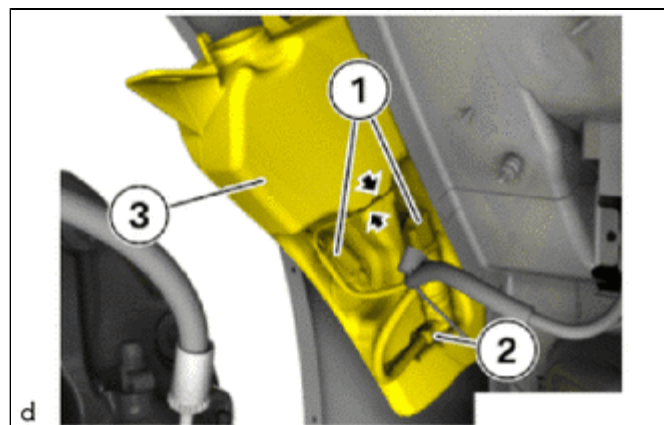
PROCEDURE

1. INSTALL WINDSHIELD WASHER MOTOR AND PUMP ASSEMBLY

- (a) Check the strainer with seal for damage and replace if necessary.
- (b) Install strainer with seal in windshield washer jar assembly.
- (c) Install windshield washer motor and pump assembly in windshield washer jar assembly.

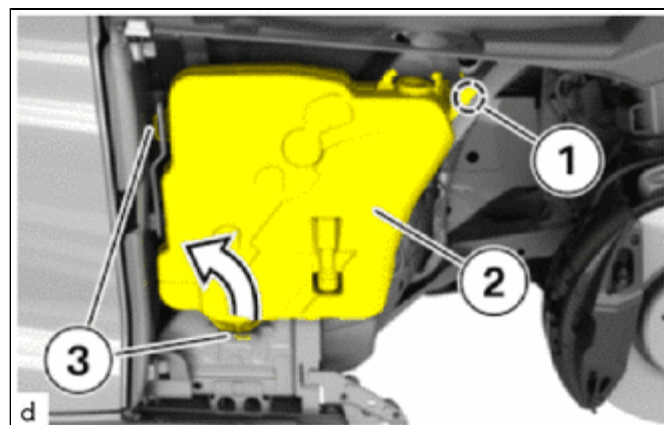
2. INSTALL WINDSHIELD WASHER JAR ASSEMBLY

- (a) Connect the washer hose at the snap fastener (2).



- (b) Connect connectors (1).
- (c) Engage in the line in the marked area (arrows).
- (d) Insert washer windshield washer jar assembly (3).

- (e) Install the windshield washer jar assembly (2) into the guides (3) in the direction of the arrow.

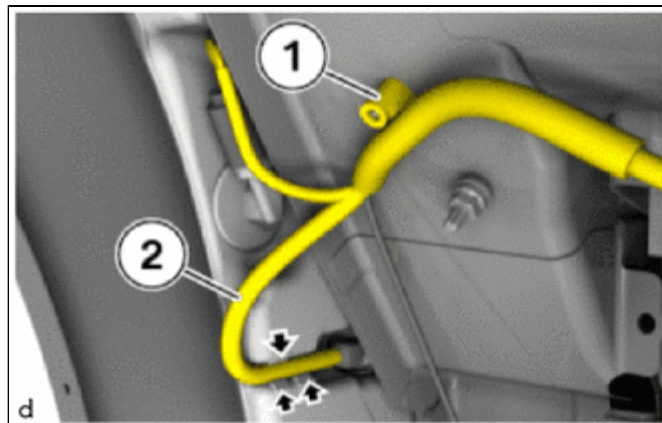


- (f) Install the screw (1).

Torque:

8.0 N·m { 82 kgf·cm, 71 in·lbf }

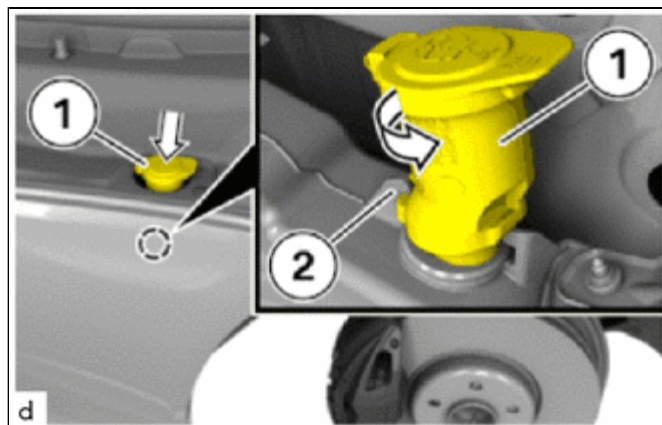
- (g) Engage in the washer hose (2) in the marked area (arrows).



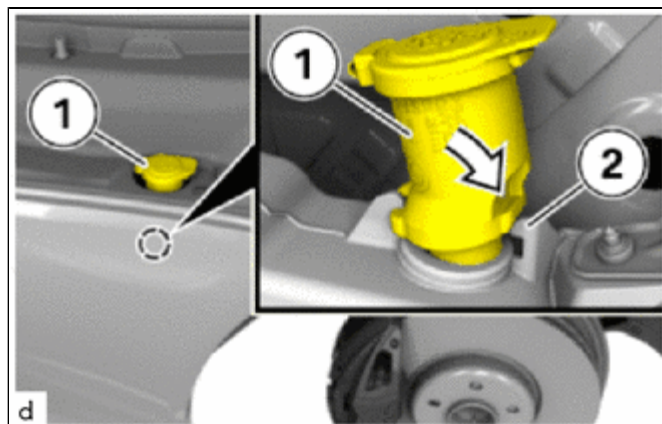
- (h) Engage the clamp (1).

3. INSTALL WASHER INLET SUB-ASSEMBLY

- (a) Engage the washer inlet sub-assembly (1) into the rear tabs (2) downwards in the direction of the arrow.



- (b) Turn the washer inlet sub-assembly (1) in the direction of the arrow towards the initial position.



- (c) Install in the washer inlet sub-assembly (1) to the front tabs (2) the direction of the arrow.

4. INSTALL FRONT NO. 2 FENDER LINER RH

HINT:

Use the same procedure as for the LH side.

[Click here](#) [INFO](#)

5. INSTALL FRONT WHEEL RH

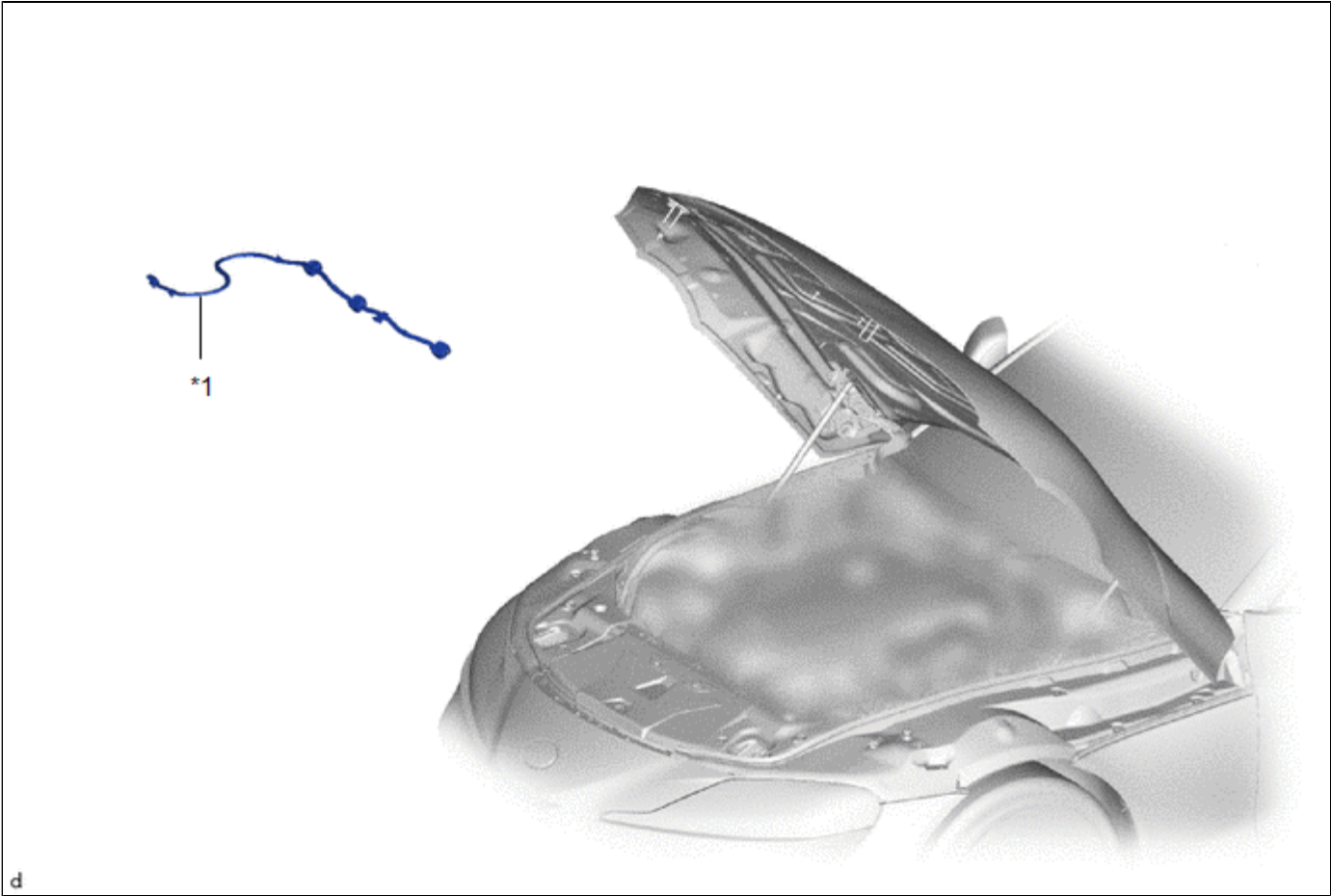
[Click here](#) [INFO](#)



Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCD3
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WIPER / WASHER: WASHER NOZZLE: COMPONENTS; 2020 MY Supra [03/2019 -]		

COMPONENTS

ILLUSTRATION



*1	FRONT WASHER NOZZLE AND HOSE ASSEMBLY	-	-
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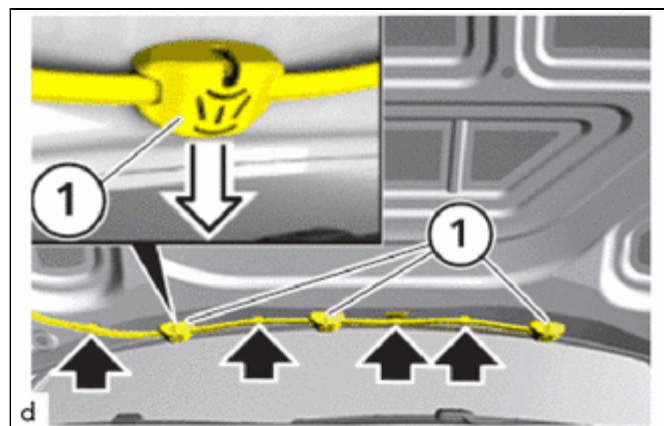
Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCD4
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WIPER / WASHER: WASHER NOZZLE: REMOVAL; 2020 MY Supra [03/2019 -]		

REMOVAL

PROCEDURE

1. REMOVE FRONT WASHER NOZZLE AND HOSE ASSEMBLY

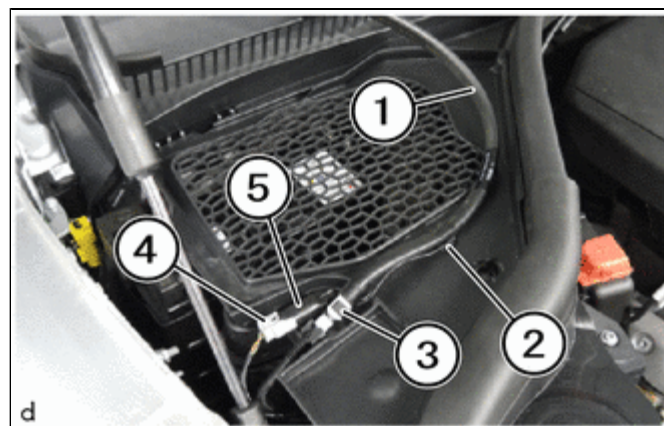
- (a) Disengage the front washer nozzle and hose assembly from all brackets (arrows) at the hood sub-assembly.



- (b) Disengage the front washer nozzle and hose assembly (1) towards the bottom.

- (c) for Type A:

- (1) Disengage the front washer nozzle and hose assembly (1) from the brackets (2).



- (2) Disconnect the front washer nozzle and hose assembly (1) at the snap fastener (3).

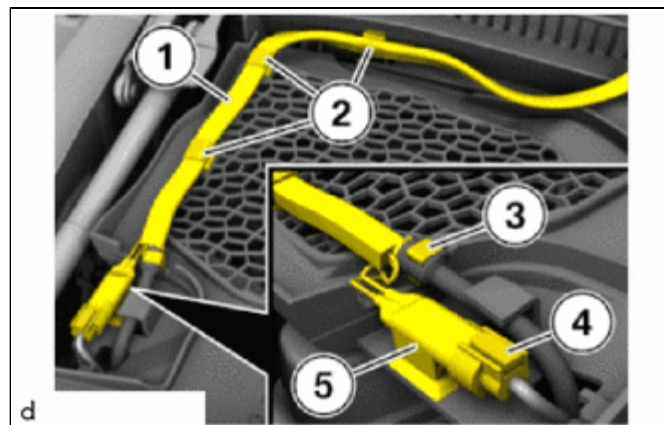
- (3) Disconnect the connector (4).

- (4) Disengage the connector (5) from the bracket.

- (5) Remove the front washer nozzle and hose assembly (1).

- (d) for Type B:

- (1) Disengage the front washer nozzle and hose assembly (1) from the brackets (2).



- (2) Disconnect the front washer nozzle and hose assembly (1) at the snap fastener (3).
- (3) Disconnect the connector (4).
- (4) Disengage the connector (5) from the bracket.
- (5) Remove the front washer nozzle and hose assembly (1).

Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCD5
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WIPER / WASHER: WASHER NOZZLE: INSTALLATION; 2020 MY Supra [03/2019 -]		

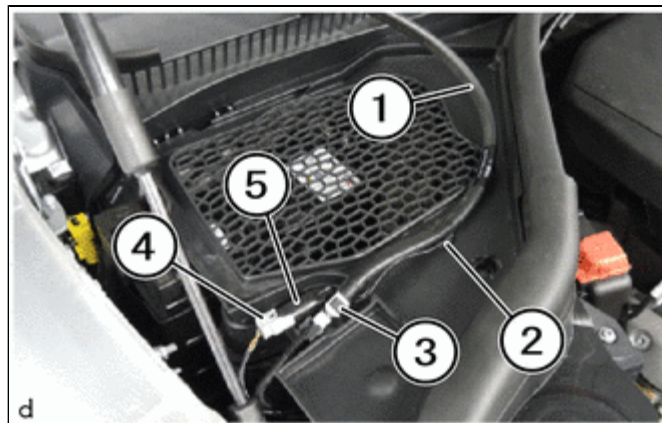
INSTALLATION

PROCEDURE

1. INSTALL FRONT WASHER NOZZLE AND HOSE ASSEMBLY

(a) for Type A:

(1) Engage the connector (5) into the bracket.



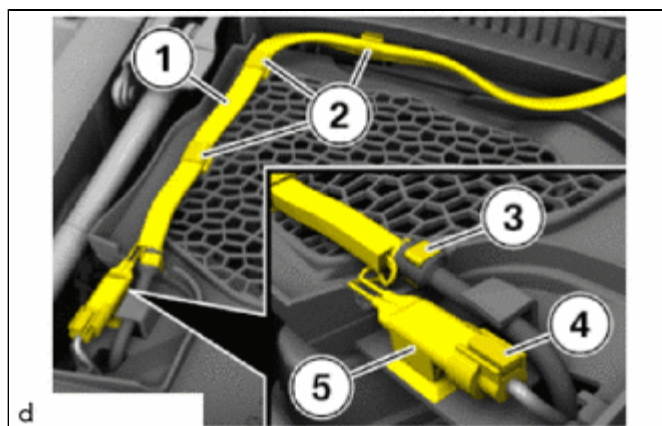
(2) Connect connectors (4).

(3) Connect the front washer nozzle and hose assembly (1) at the snap fastener (3).

(4) Engage the front washer nozzle and hose assembly (1) into the brackets (2).

(b) for Type B:

(1) Engage the connector (5) into the bracket.

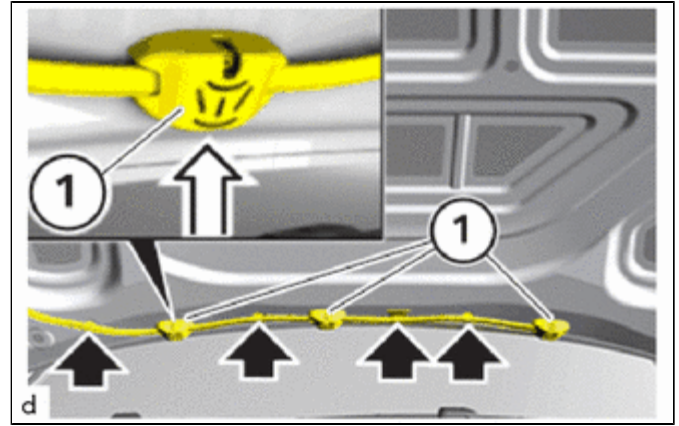


(2) Connect connectors (4).

(3) Connect the front washer nozzle and hose assembly (1) at the snap fastener (3).

(4) Engage the front washer nozzle and hose assembly (1) into the brackets (2).

(c) Engage the front washer nozzle and hose assembly (1) in at the top.



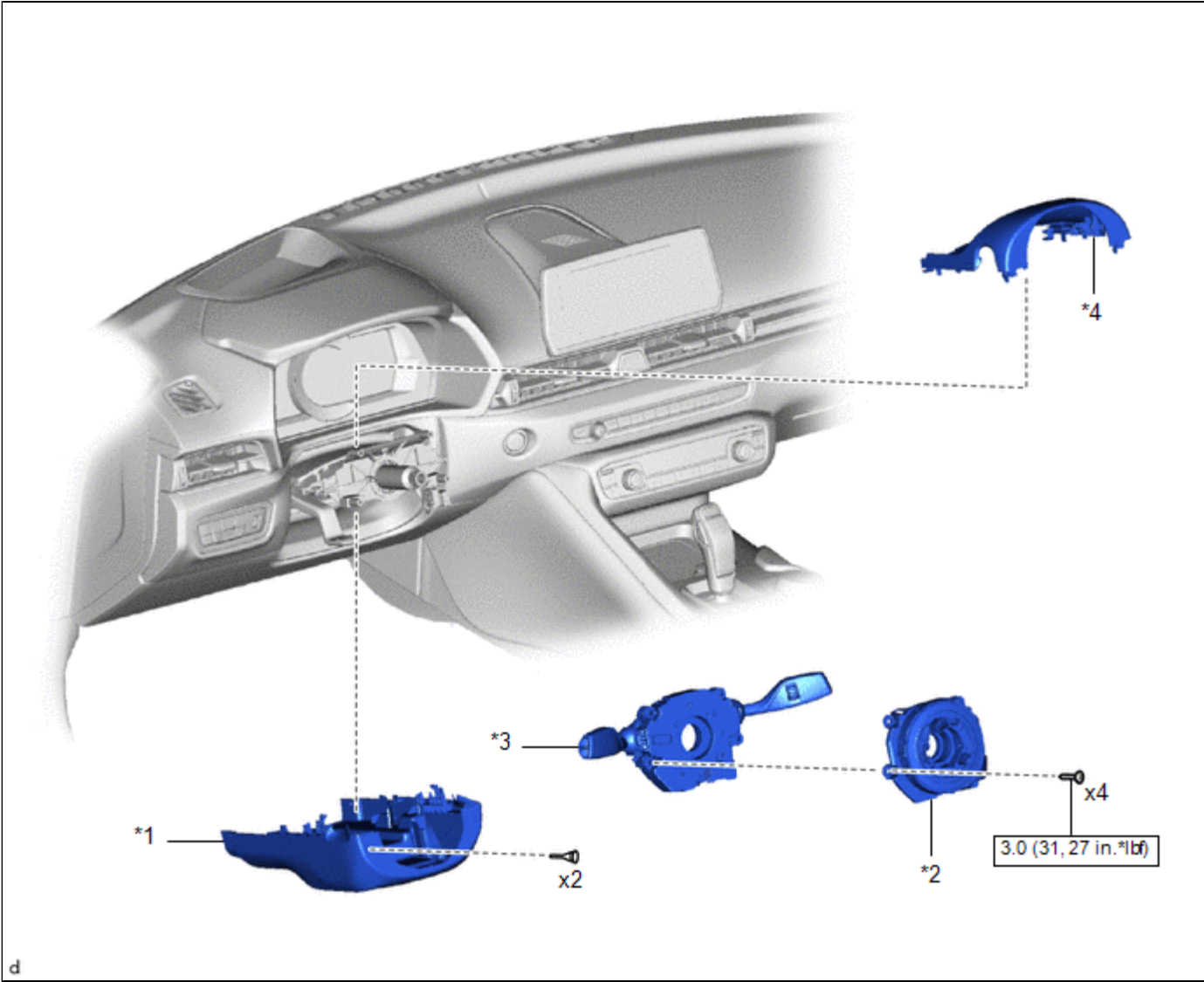
(d) Install the front washer nozzle and hose assembly into the brackets (arrows) on the hood sub-assembly.



Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCCX
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WIPER / WASHER: WIPER SWITCH: COMPONENTS; 2020 MY Supra [03/2019 -]		

COMPONENTS

ILLUSTRATION



*1	LOWER STEERING COLUMN COVER	*2	SPIRAL CABLE SUB-ASSEMBLY
*3	TURN SIGNAL SWITCH ASSEMBLY	*4	UPPER STEERING COLUMN COVER
	N*m (kgf*cm, ft.*lbf): Specified torque	-	-

Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCCY
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WIPER / WASHER: WIPER SWITCH: REMOVAL; 2020 MY Supra [03/2019 -]		

REMOVAL

CAUTION / NOTICE / HINT

CAUTION:

- Airbag unit.

Danger! Life-threatening injuries!



- All work on pyrotechnic parts may be carried out by technically experienced and appropriately trained personnel only.
- Replace any damaged part or ones that have been dropped.
- Before performing any work on the airbag, always disconnect the battery earth lead from the battery.
- Airbag unit may only be set down with the cushion (airbag itself) facing upwards.
- For additional information see: Safety regulations on handling components with gas generators.

Click here

INFO

PROCEDURE

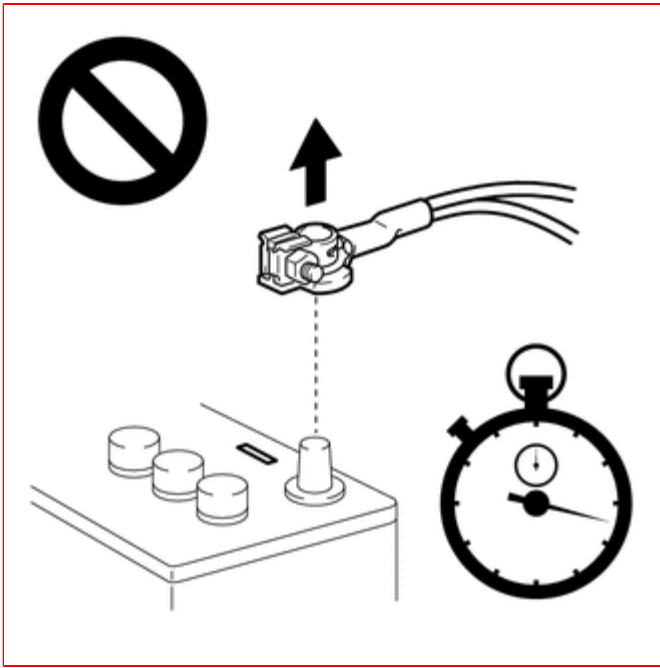
1. DISCONNECT CABLE FROM NEGATIVE BATTERY TERMINAL

Click here

INFO

CAUTION:

- Wait at least 60 seconds after disconnecting the cable from the negative (-) battery terminal to disable the SRS



system.

- If the airbag deploys for any reason, it may cause a serious accident.

2. REMOVE STEERING WHEEL ASSEMBLY

Click here [INFO](#)

3. REMOVE UPPER STEERING COLUMN COVER

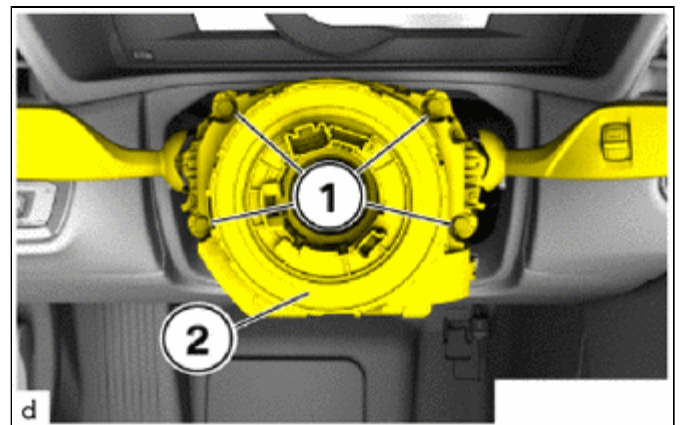
Click here [INFO](#)

4. REMOVE LOWER STEERING COLUMN COVER

Click here [INFO](#)

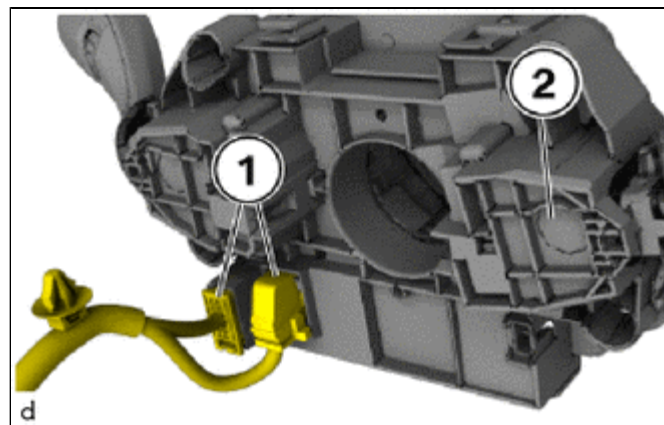
5. REMOVE TURN SIGNAL SWITCH ASSEMBLY

(a) Using a deep socket wrench 7 mm, remove screws (1).



(b) Disconnect the turn signal switch assembly (2).

(c) Disconnect the connectors (1) to remove the turn signal switch assembly (2) with the spiral cable sub-assembly.



6. REMOVE SPIRAL CABLE SUB-ASSEMBLY

Click here [INFO](#)

Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JCCZ
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WIPER / WASHER: WIPER SWITCH: INSTALLATION; 2020 MY Supra [03/2019 -]		

INSTALLATION

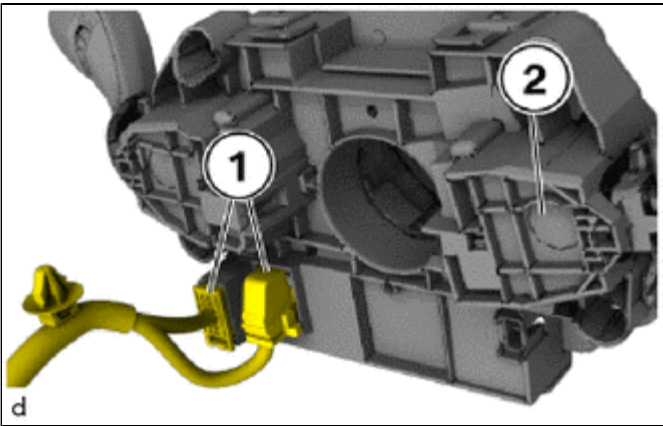
PROCEDURE

1. INSTALL SPIRAL CABLE SUB-ASSEMBLY

Click here [INFO](#)

2. INSTALL TURN SIGNAL SWITCH ASSEMBLY

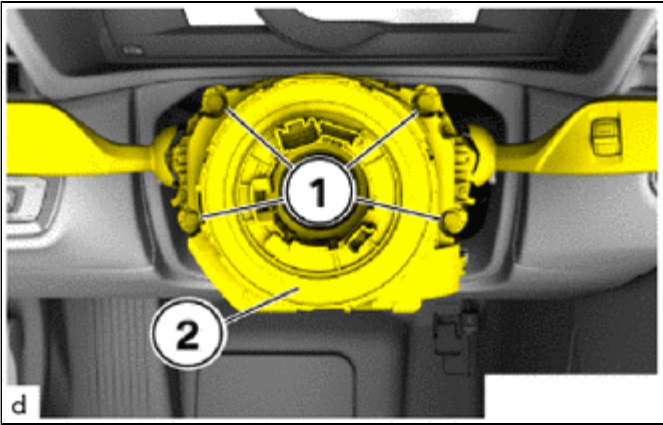
(a) Connect the connectors (1) with the turn signal switch assembly (2).



(b) Connect the turn signal switch assembly (2).

(c) Using a deep socket wrench 7 mm, tighten the screws (1) to install the turn signal switch assembly (2) with the spiral cable sub-assembly.

Torque:
3.0 N·m {31 kgf·cm, 27 in·lbf}



3. INSTALL LOWER STEERING COLUMN COVER

Click here [INFO](#)

4. INSTALL UPPER STEERING COLUMN COVER

Click here [INFO](#)

5. INSTALL STEERING WHEEL ASSEMBLY

Click here [INFO](#)

6. CONNECT CABLE TO NEGATIVE BATTERY TERMINAL

Click here [INFO](#)



Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JC19
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WINDOW / GLASS: QUARTER WINDOW GLASS: REMOVAL; 2020 MY Supra [03/2019 -]		

REMOVAL

CAUTION / NOTICE / HINT

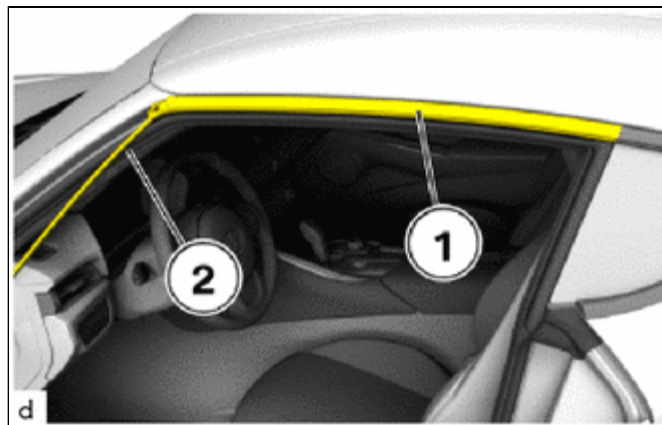
HINT:

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

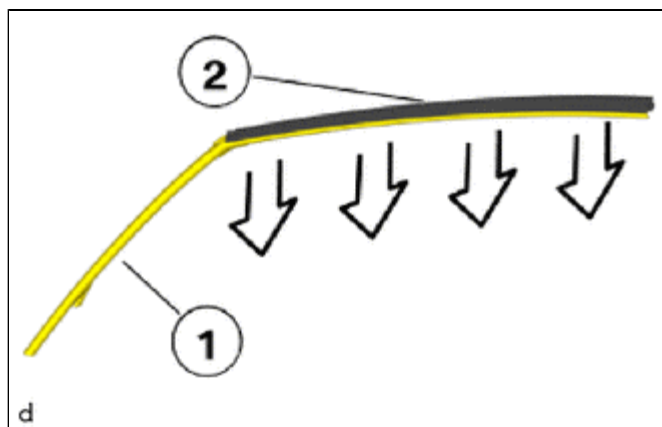
PROCEDURE

1. REMOVE FRONT DOOR WINDOW FRAME FRONT MOULDING

- (a) Remove front roof side rail weatherstrip retainer (1) with the front door window frame front moulding (2).



- (b) Disengage front door window frame front moulding (1) from the front roof side rail weatherstrip retainer (2) in the direction of arrow.



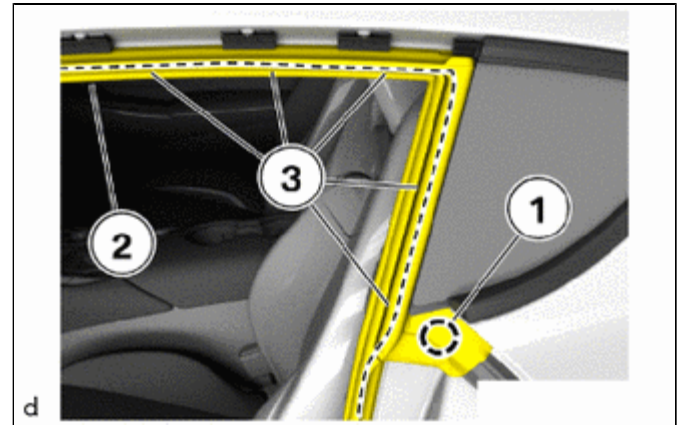
2. REMOVE QUARTER WINDOW ASSEMBLY

NOTICE:

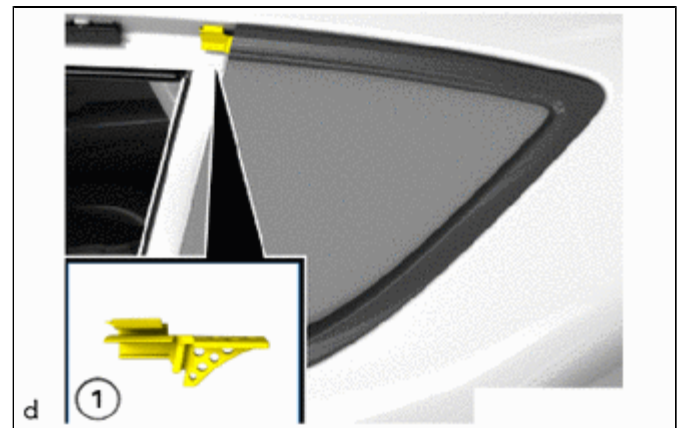
- Paint damage.
- Mechanical action can lead to paint damage.
 - Mask those working areas at risk with protective tape.

- Remove and install heavy or bulky components with the aid of another person/other persons.

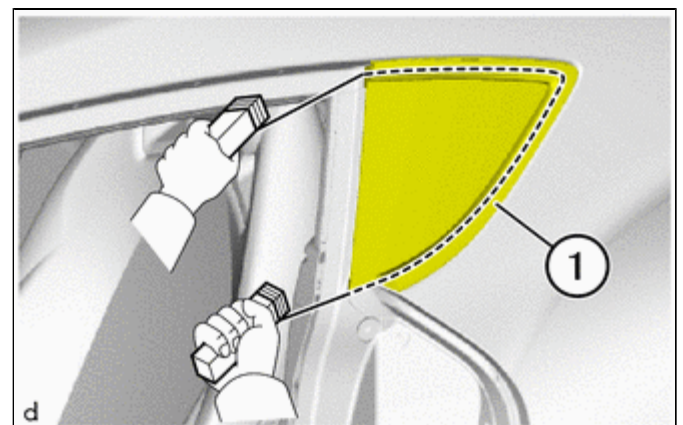
(a) Disengage clip (1) and pull off the edge protection (2) at (3).



(b) Remove clip (1).



(c) Guide the piano wire (1) behind of the quarter window assembly and wrap it completely around the quarter window assembly.



(d) Set the handles (for example, wooden blocks) (2) to the piano wire (1).

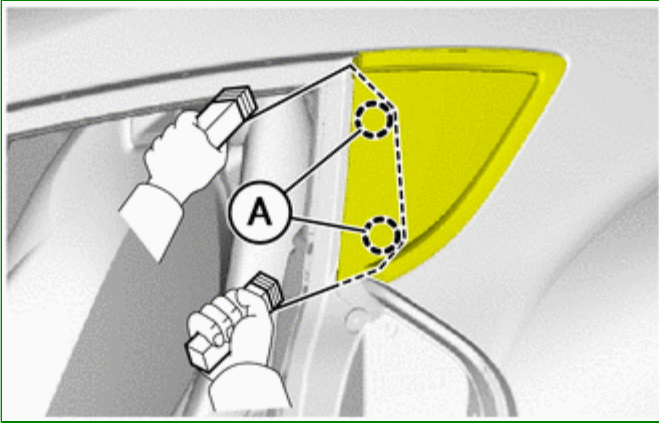
(e) Secure the quarter window assembly on the body with protective tape.

(f) To facilitate cutting through the adhesive bead, heat the piano wire (1) with sawing motions.

(g) Cut through the adhesive bead from back to front.

HINT:

- To facilitate cutting through the adhesive bead, heat the piano wire (1) with sawing motions.
- There are guide pins in area (A) which can be cut through using increased force.



(h) Cut through adhesive bead completely and remove the quarter window assembly.



Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JC1A
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WINDOW / GLASS: QUARTER WINDOW GLASS: INSTALLATION; 2020 MY Supra [03/2019 -]		

INSTALLATION

PROCEDURE

1. INSTALL QUARTER WINDOW ASSEMBLY

HINT:

- The vehicle can be towed away or driven without the quarter window assembly.
- When carrying out removal/installation work and during the hardening time, the vehicle must be standing on its wheels on a level surface.
- The quarter window assembly are bonded to the body. This bonding will increase the torsional rigidity of the vehicle. To obtain perfect bonding, comply with the installation procedure described in the following.

(a) Clean quarter window assembly and body aperture with residual adhesive bead.

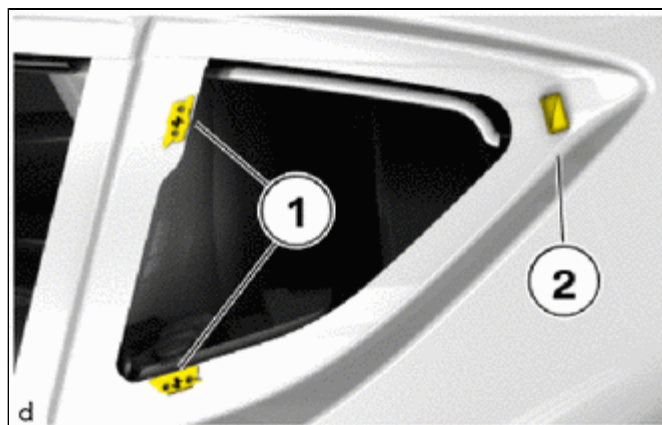
Cleaner:

Cleaner R1, Cleaner R2

HINT:

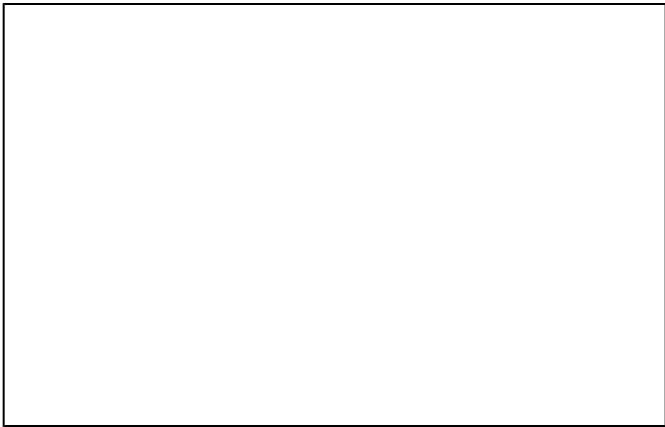
Protect vehicle interior against contamination.

(b) Remove the remaining guide pins (1) and the double-sided tape (2) and clean the bonding surface.



(c) Apply new double-sided tape in the position of the removed double-sided tape (2).

(d) Remove residual adhesive bead (1) on body aperture and on the quarter window assembly shortly before the bonding with scraper.



(e) Position the scraper (2) as shown and remove the residual adhesive bead (1) up to remaining thickness.

Standard Dimension:

AREA	DIMENSION
Remaining thickness of adhesive bead	0.5 mm (0.0197 in.)

(f) Apply glass activator to the quarter window assembly (3) so that a wide line of glass activator is located next to the squeezed adhesive bead.

Glass activator:

Repair Kit, Window Glass, Cold, 1 Hour

NOTICE:

- The glass activator is used for adhesion between glass or ceramic glass and the adhesive. Therefore, a thin, homogeneous and continuous line of glass activator must be applied. If the quarter window assembly is to be reused with a cut-back adhesive bead, glass activator is not needed.
- The glass activator may not be applied in the field of view or the point grid. Fresh glass activator in the field of view must immediately be wiped off because hardened glass activator will leave a haze behind.

Cleaner:
Cleaner R2

HINT:

- Protrusion of glass activator against the compressed adhesive bead: 1.0 to 2.0 mm (0.0394 to 0.0787 in.)
- Allow the glass activator to dry for 2 minutes.

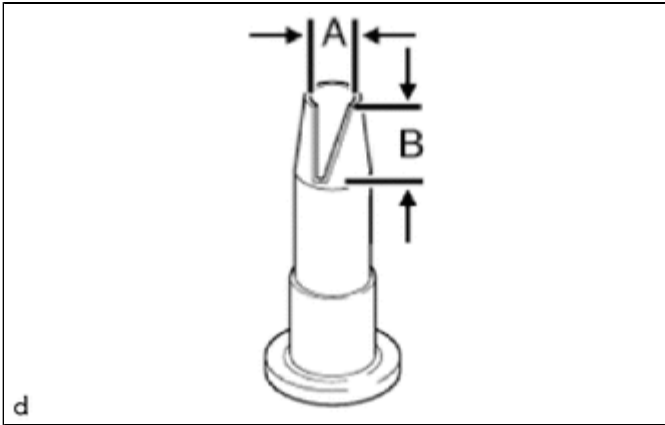
(g) Prepare the glue cartridge with the plastic nozzle.

Standard Nozzle C:

Repair Kit, Window Glass, Cold, 1 Hour

Standard Dimension:

AREA	DIMENSION
A	7.0 to 9.0 mm (0.276 to 0.354 in.)
B	14 to 16 mm (0.551 to 0.630 in.)

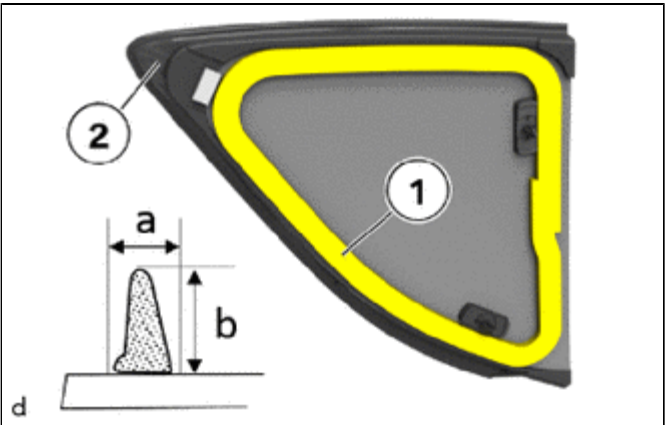


(h) Overview for quarter window assembly bonding.

(i) Follow the adhesive bead (1) around the circumference of the PVC coating (2).

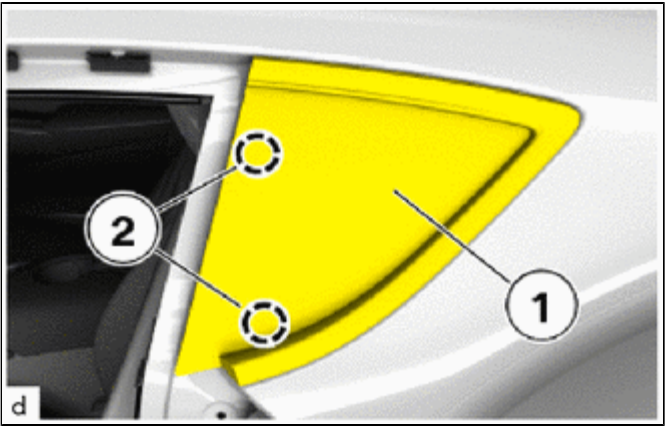
Adhesive:
Repair Kit, Window Glass, Cold, 1 Hour
Adhesive bead:

AREA	DIMENSION
a	7.0 to 9.0 mm (0.276 to 0.354 in.)
b	14 to 16 mm (0.551 to 0.630 in.)



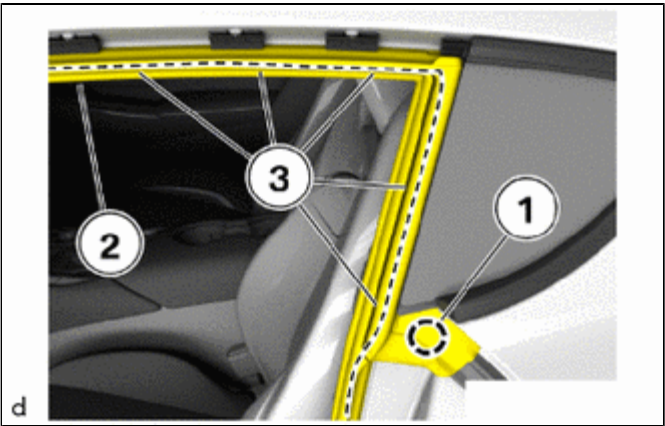
(j) Mount the quarter window assembly (1) on the side panel and thread in using guide pins (2).

HINT:
Secure the quarter window assembly (1) with the protective tape.



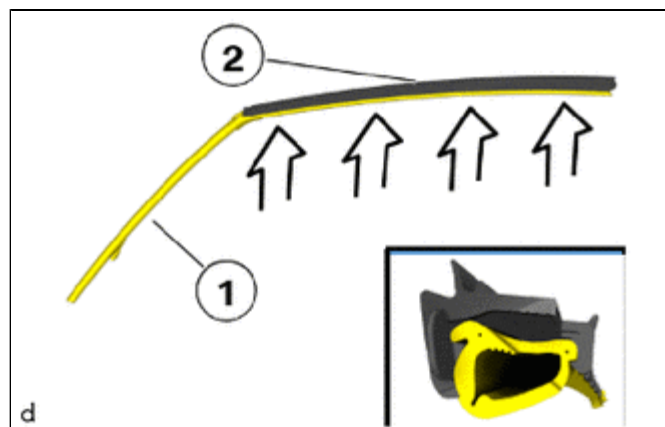
(k) Insert the clip.

(l) Mount edge protection (2) in area (3) and clip in the clip (1).



2. INSTALL FRONT DOOR WINDOW FRAME FRONT MOULDING

(a) Clip front door window frame front moulding (1) into the front roof side rail weatherstrip retainer (2) in the direction of arrow.



(b) Clip in front roof side rail weatherstrip retainer with the front door window frame front moulding.