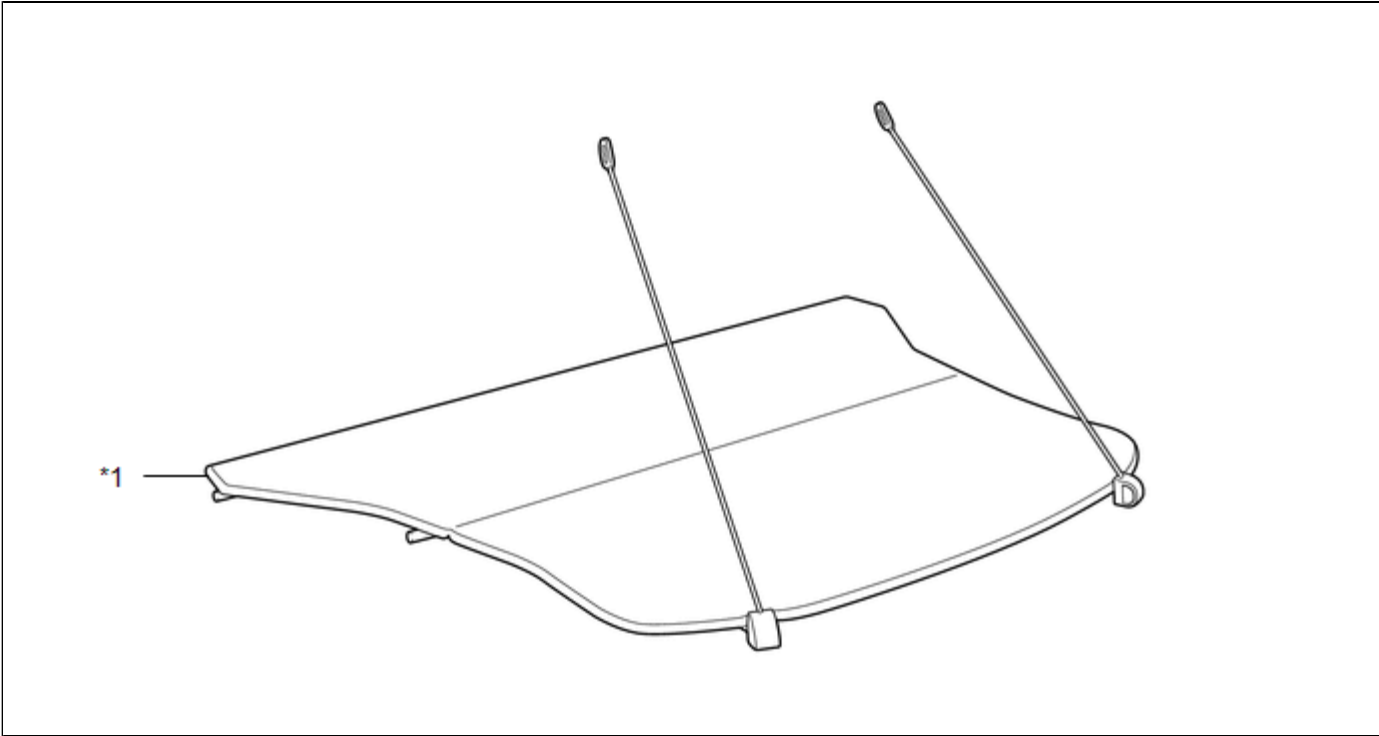


Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JC15
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WINDOW / GLASS: BACK DOOR GLASS: COMPONENTS; 2020 MY Supra [03/2019 -]		

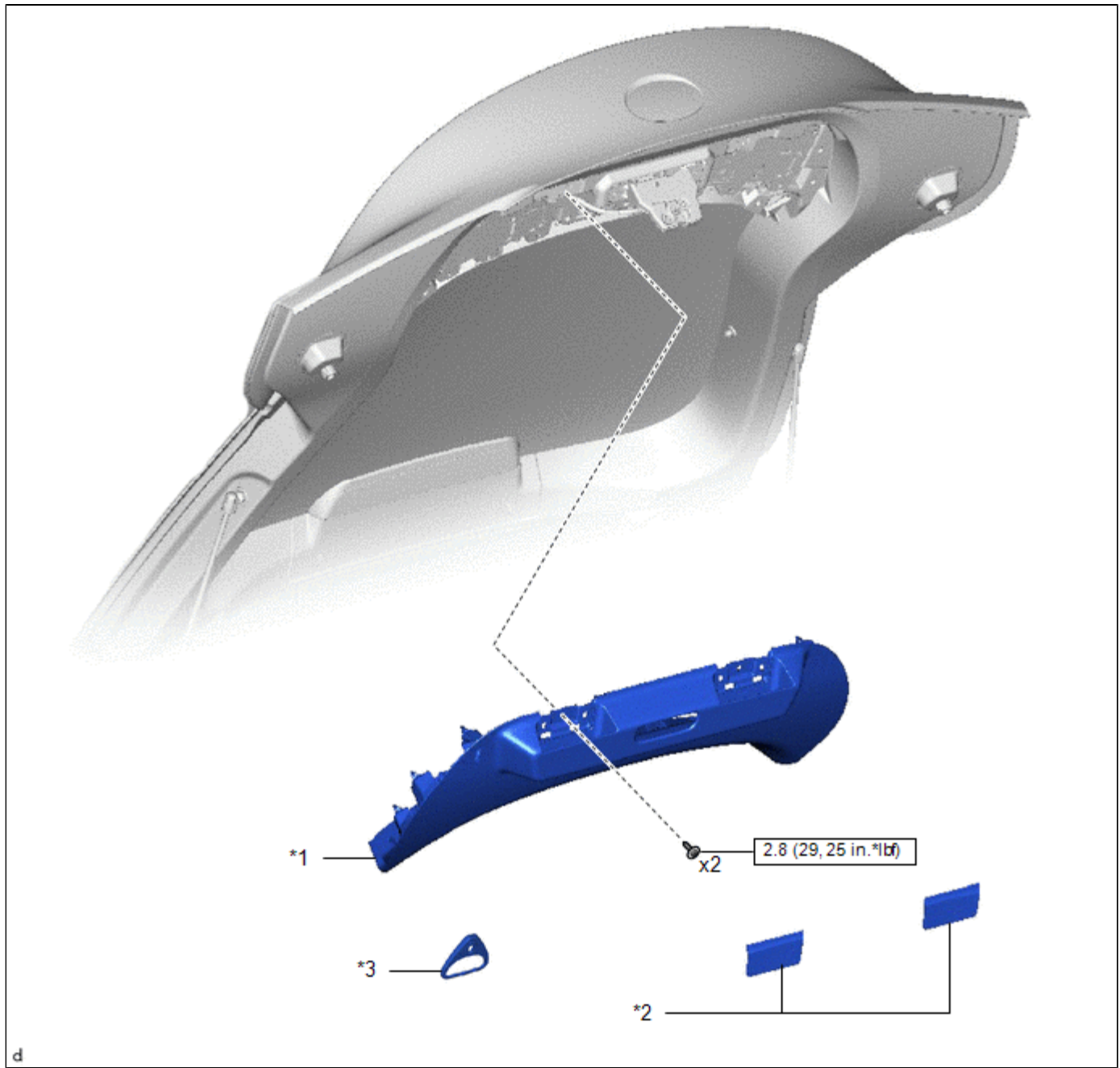
COMPONENTS

ILLUSTRATION



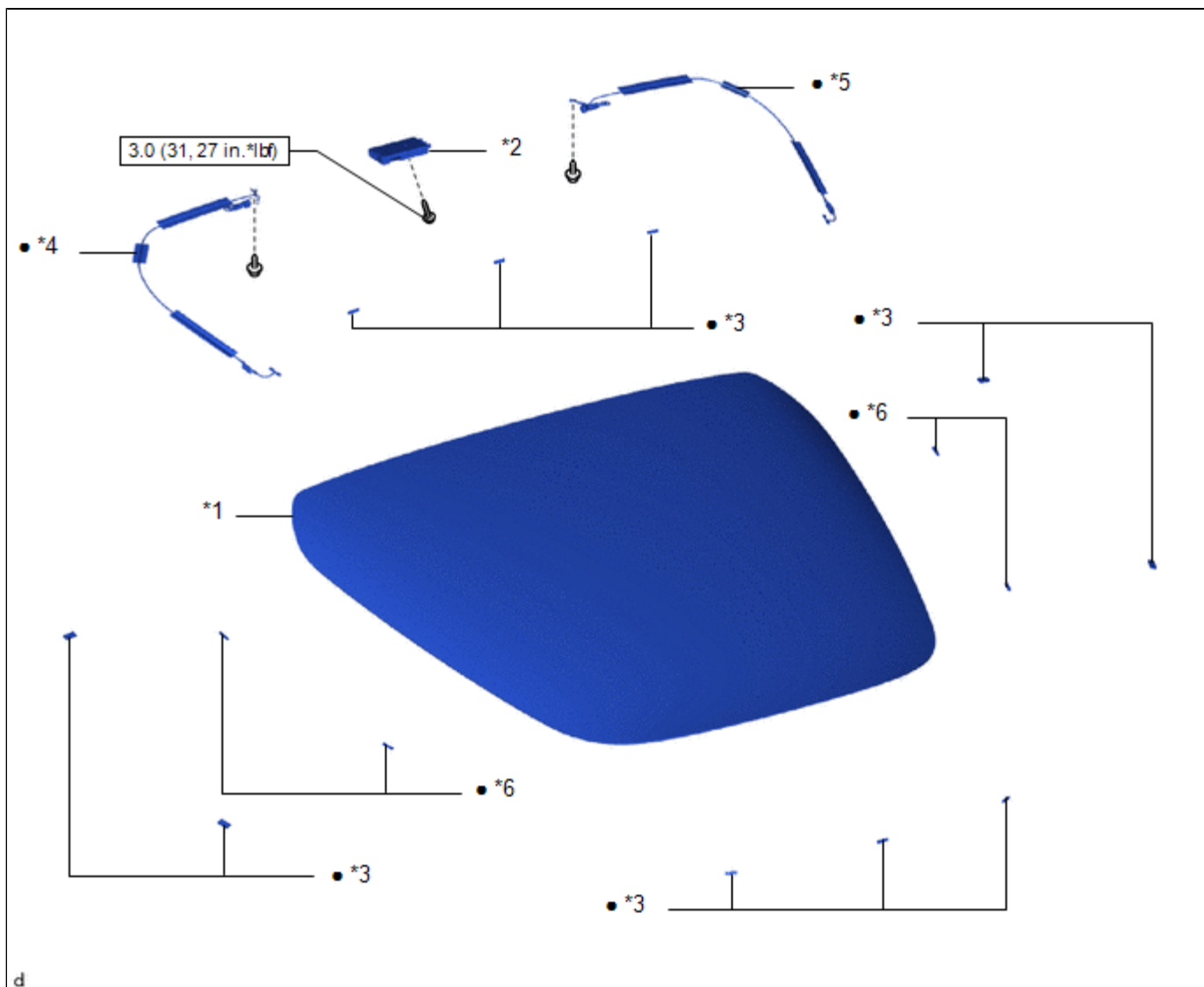
*1	PACKAGE TRAY TRIM PANEL ASSEMBLY	-	-
----	----------------------------------	---	---

ILLUSTRATION



*1	BACK DOOR TRIM BOARD	*2	BACK DOOR TRIM COVER
*3	EMERGENCY RELEASE HANDLE	-	-
	N*m (kgf*cm, ft.*lbf): Specified torque	-	-

ILLUSTRATION



*1	BACK DOOR GLASS	*2	NO. 1 AMPLIFIER ANTENNA ASSEMBLY
*3	NO. 1 WINDSHIELD GLASS SPACER	*4	BACK DOOR GLASS WIRE LH
*5	BACK DOOR GLASS WIRE RH	*6	BACK DOOR GLASS SPACER
	N*m (kgf*cm, ft.*lbf): Specified torque	•	Non-reusable part



Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JC16
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WINDOW / GLASS: BACK DOOR GLASS: REMOVAL; 2020 MY Supra [03/2019 -]		

REMOVAL

PROCEDURE

1. REMOVE PACKAGE TRAY TRIM PANEL ASSEMBLY

Click here [INFO](#)

2. REMOVE BACK DOOR TRIM BOARD

Click here [INFO](#)

3. REMOVE EMERGENCY RELEASE HANDLE

Click here [INFO](#)

4. REMOVE CENTER STOP LIGHT ASSEMBLY

Click here [INFO](#)

5. REMOVE NO. 1 AMPLIFIER ANTENNA ASSEMBLY

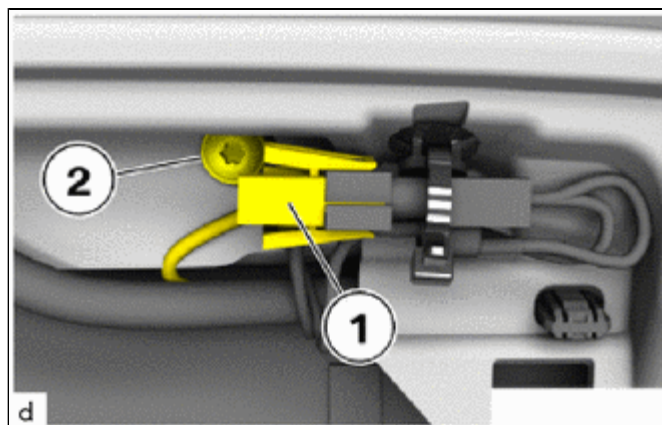
Click here [INFO](#)

6. REMOVE BACK DOOR GLASS

(a) Disconnect the connector (1).

HINT:

Perform the operations on the left and right side.



(b) Remove T25 screw (2).

HINT:

Perform the operations on the left and right side.

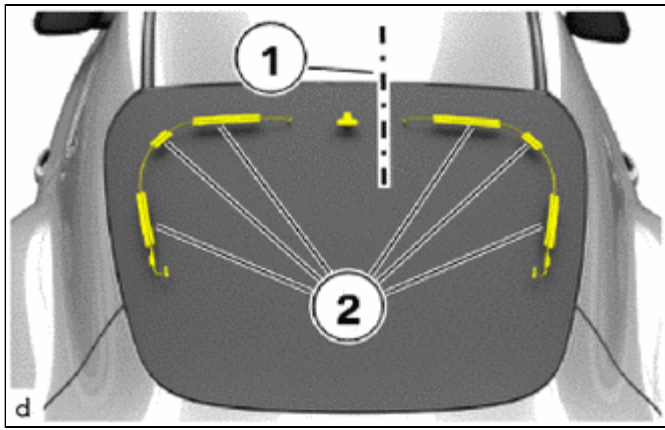
(c) Tape off body in area of passthrough point (1) with protective tape.

(d) Pass a piano wire between the back door panel and back door glass.

NOTICE:

Pay particular attention at the passthrough point (1) as otherwise there is a risk of damage to the wiring harness (2)

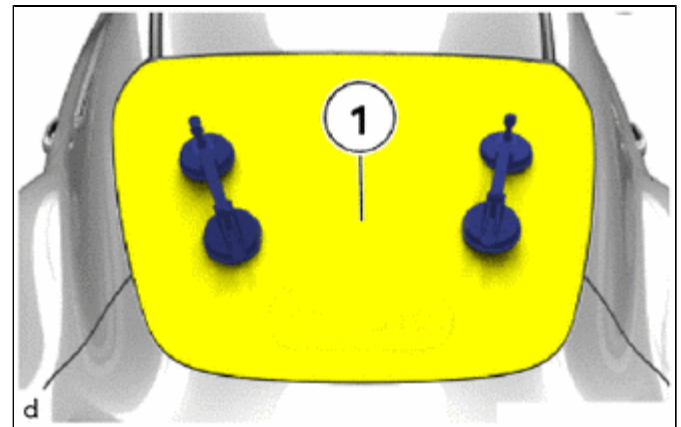
at the passthrough.



(e) Tie both wire ends to wooden blocks or similar objects that can serve as handles.

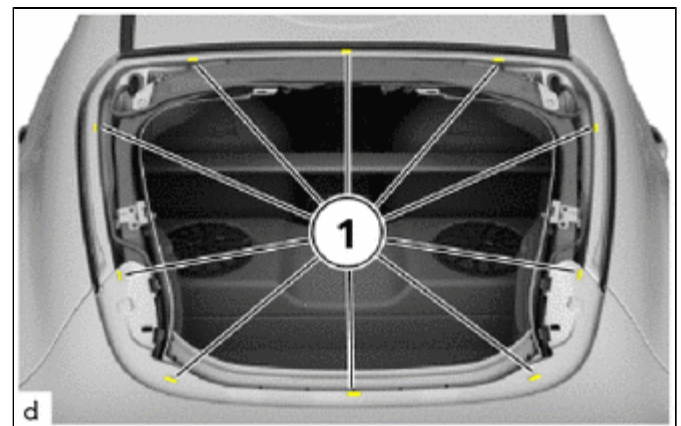
(f) Cut out the back door glass.

(g) Using suction cups, remove back door glass (1).



7. REMOVE NO. 1 WINDSHIELD GLASS SPACER

(a) Remove all No. 1 windshield glass spacers (1).



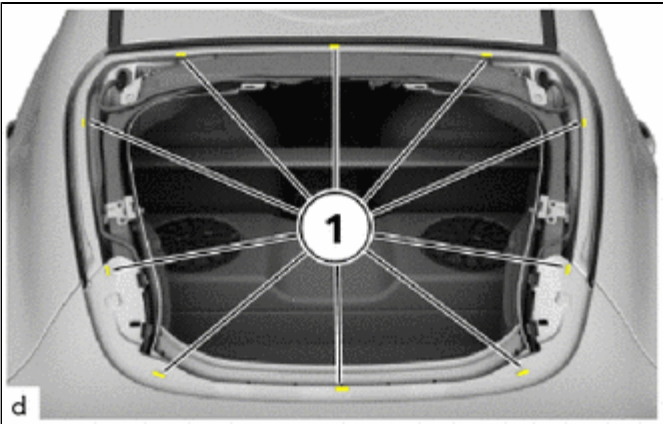
Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JC17
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WINDOW / GLASS: BACK DOOR GLASS: INSTALLATION; 2020 MY Supra [03/2019 -]		

INSTALLATION

PROCEDURE

1. INSTALL NO. 1 WINDSHIELD GLASS SPACER

- (a) Install all new No. 1 windshield glass spacers (1) centrally on the marks.



2. INSTALL BACK DOOR GLASS

HINT:

- The vehicle can be towed away or driven without the back door glass.
- When carrying out removal/installation work and during the hardening time, the vehicle must be standing on its wheels on a level surface.
- The back door glass 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 back door glass and body aperture with residual adhesive bead.

Cleaner:
Cleaner R1, Cleaner R2

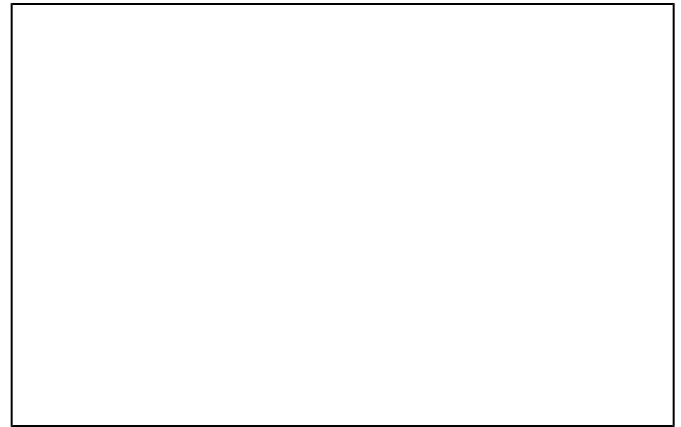
HINT:

Protect vehicle interior against contamination.

- (b) Install the 2 protective tapes (1) to the roof.

Standard Dimension:

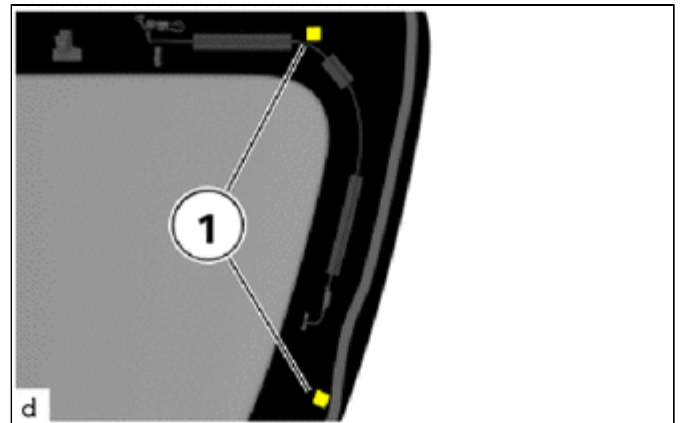
AREA	DIMENSION
A	250 mm (9.84 in.)



(c) Replace the back door glass spacers (1) on the back door glass and the body.

HINT:

Perform the operations on the left and right side.



(d) Glue on the back door glass spacers (1) where marked.

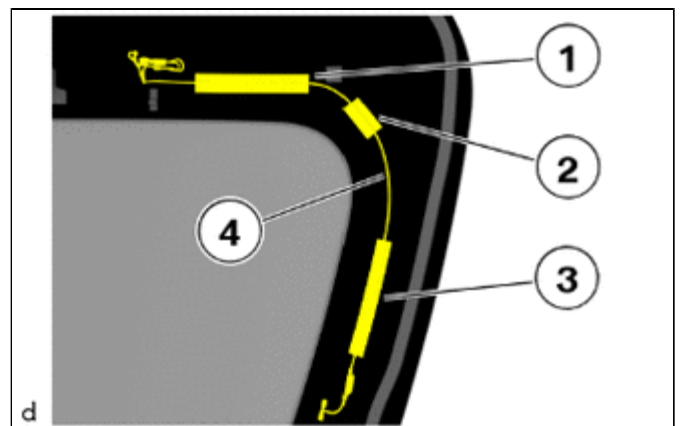
HINT:

Perform the operations on the left and right side.

(e) Check tapes (1) to (3) on the back door glass wire (4) for correct position and replace where required.

HINT:

Perform the operations on the left and right side.



(f) Provide two glue cartridges.

Adhesive:

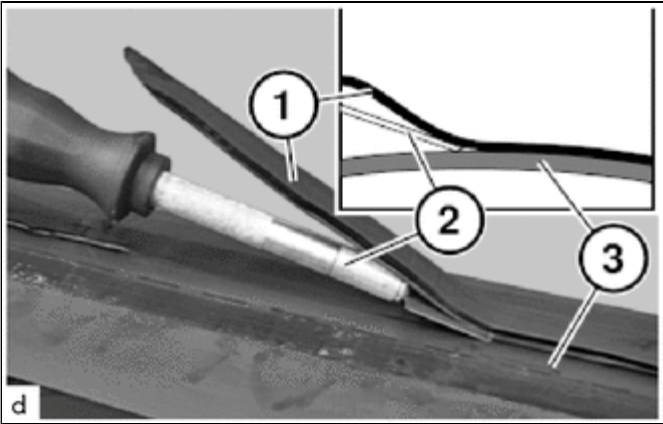
Repair Kit, Window Glass, Cold, 1 Hour

(g) When reusing the back door glass:

- (1) 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.)



(h) Apply glass activator to the back door glass (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 back door glass 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.

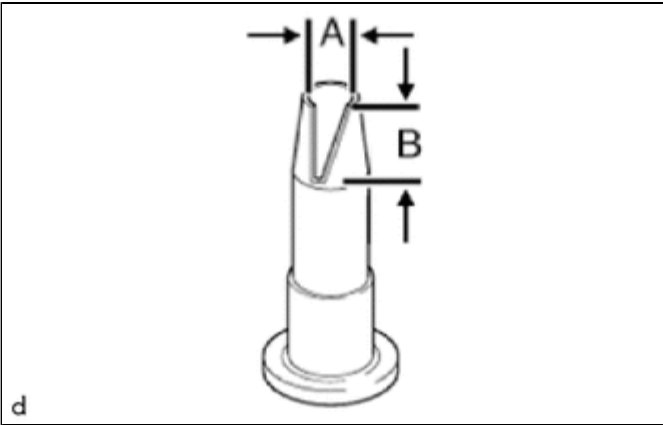
(i) Prepare the glue cartridge with the standard nozzle C.

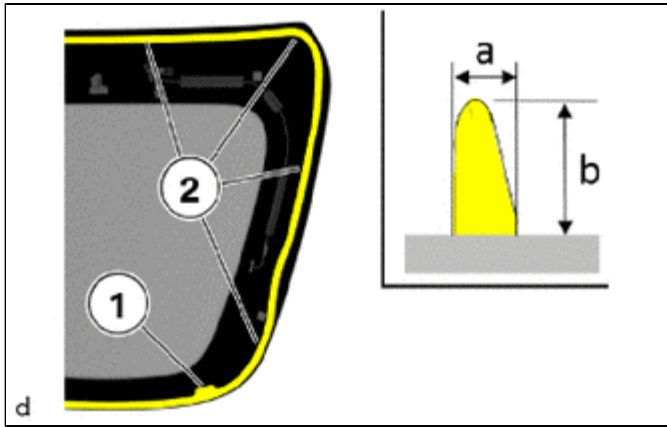
Standard Nozzle C:

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	11 to 13 mm (0.433 to 0.512 in.)





(j) Apply bead joint in area (1).

(k) Apply adhesive bead within the mark (2) on the back door glass.

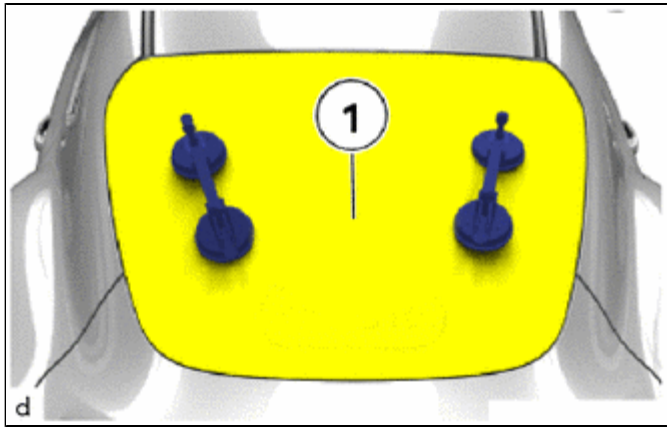
Adhesive bead:

AREA	DIMENSION
a	7.0 to 9.0 mm (0.276 to 0.354 in.)
b	11 to 13 mm (0.433 to 0.512 in.)

(l) Using suction cups, fit back door glass (1) carefully.

HINT:

At the same time, guide the back door glass parallel to the C-pillar, fit at the top and align on the side edges as well as the upper and lower edge.



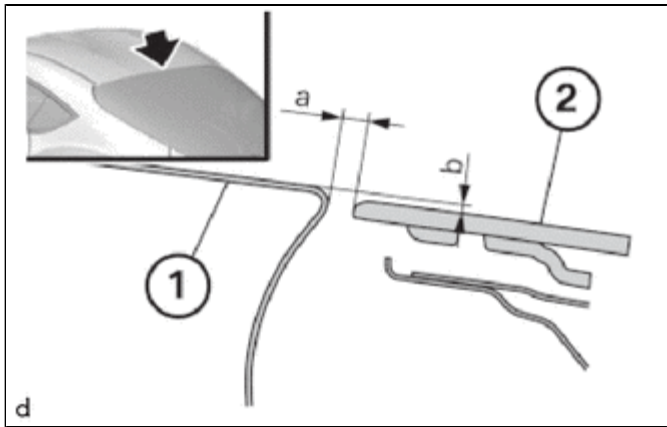
(m) Using the special tools 0 496 076 (00 9 470) and 0 495 259 (51 0 010), measuring gap dimension back door glass to roof outer skin.

SST: 09800-WA340

SST: 09800-WA350

Standard Clearance:

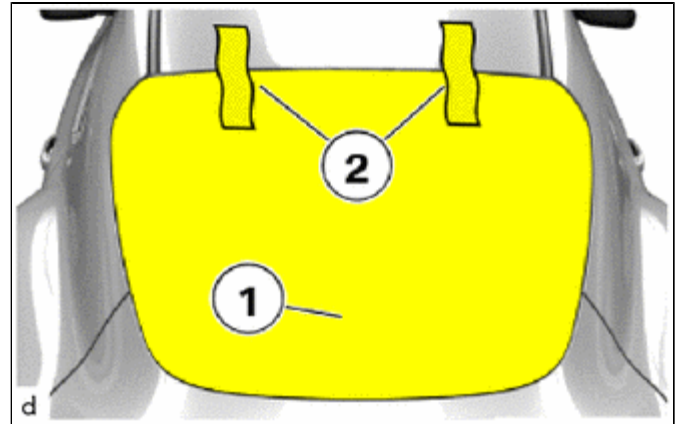
AREA	DIMENSION
a	5.8 to 9.1 mm (0.228 to 0.358 in.)
b	0.6 to 4.2 mm (0.0236 to 0.165 in.)



(1)	Roof outer skin
-----	-----------------

(n) Press the back door glass on evenly all the way around and engage at the back door glass spacer.

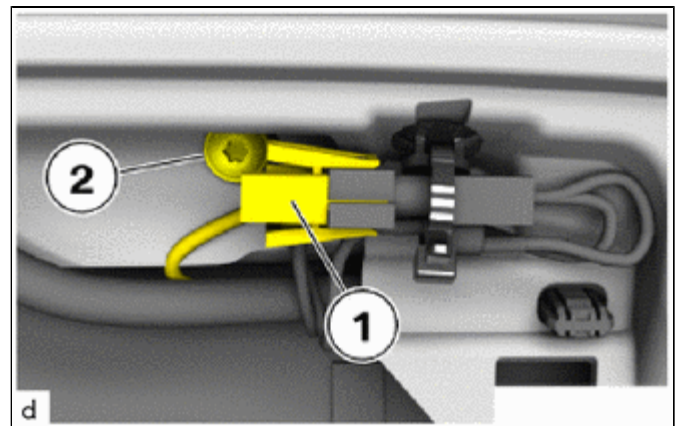
(o) Secure back door glass (1) with protective tapes (2) on the roof.



(p) Pull the cable shoe of the grounding cable onto the screw (2).

HINT:

Perform the operations on the left and right side.



(q) Tighten down T25 screw (2).

HINT:

Perform the operations on the left and right side.

(r) Connect the connector (1).

HINT:

Perform the operations on the left and right side.

3. INSTALL NO. 1 AMPLIFIER ANTENNA ASSEMBLY

Click here [INFO](#)

4. INSTALL CENTER STOP LIGHT ASSEMBLY

Click here [INFO](#)

5. INSTALL BACK DOOR TRIM BOARD

Click here

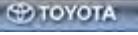
[INFO](#)

6. INSTALL EMERGENCY RELEASE HANDLE

Click here [INFO](#)

7. INSTALL PACKAGE TRAY TRIM PANEL ASSEMBLY

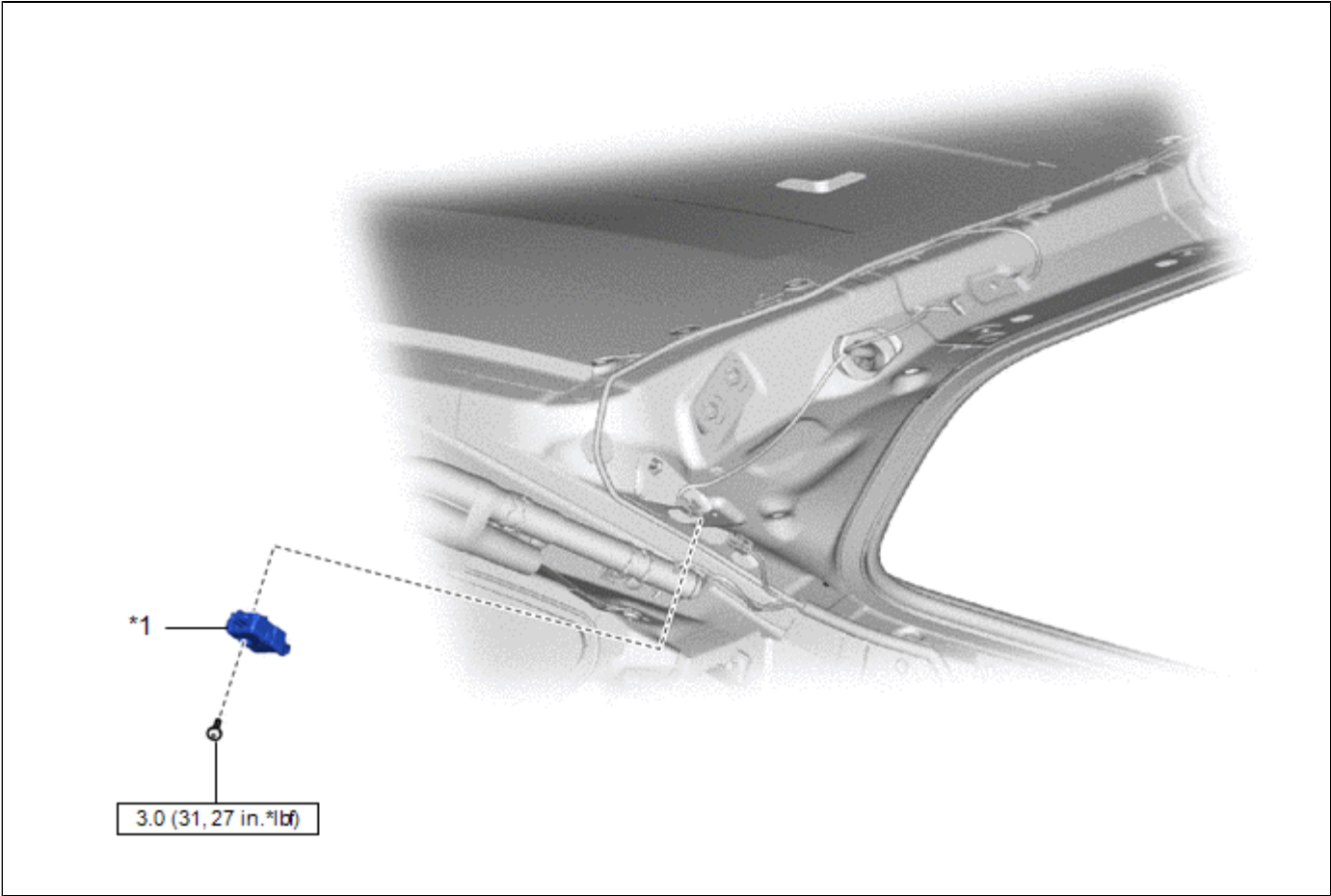
Click here [INFO](#)



Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JC1B
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WINDOW / GLASS: DEFOGGER RELAY: COMPONENTS; 2020 MY Supra [03/2019 -]		

COMPONENTS

ILLUSTRATION



*1	TRAP CIRCUIT	-	-
	N*m (kgf*cm, ft.*lbf): Specified torque	-	-

Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JC1C
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WINDOW / GLASS: DEFOGGER RELAY: REMOVAL; 2020 MY Supra [03/2019 -]		

REMOVAL

CAUTION / NOTICE / HINT

CAUTION:

- Working on 12 V vehicle electrical system.

Risk of short circuits! Risk of fire!

- Detach battery earth lead from battery.

- 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.
- For additional information see: Safety regulations on handling components with gas generators.

Click here [INFO](#)

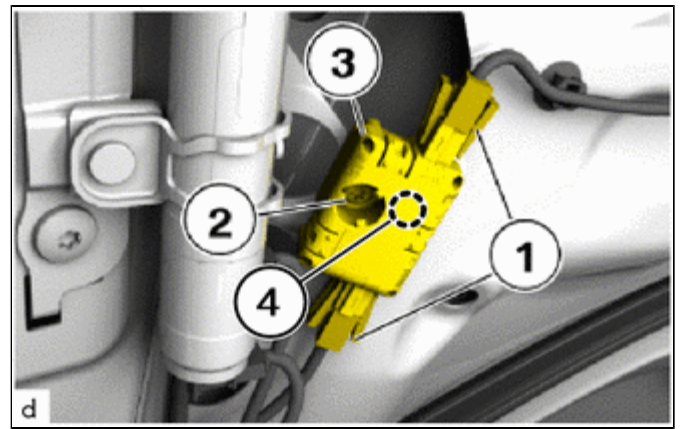
PROCEDURE

1. REMOVE ROOF HEADLINING ASSEMBLY

Click here [INFO](#)

2. REMOVE TRAP CIRCUIT

- (a) Disconnect the connectors (1).



(b) Remove T25 bolt (2).

(c) Disengage the guide (4) to remove the trap circuit (3).

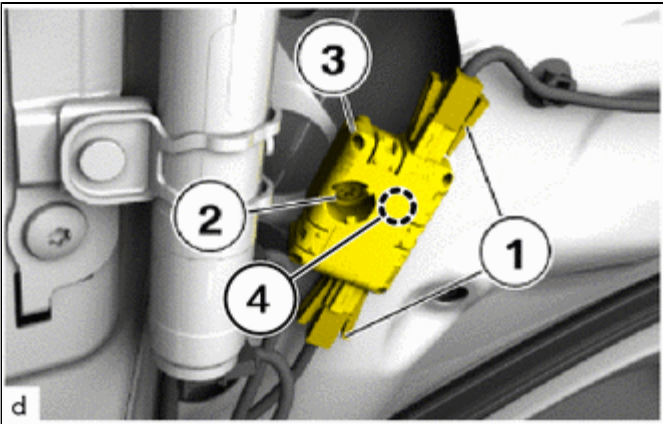
Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JC1D
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WINDOW / GLASS: DEFOGGER RELAY: INSTALLATION; 2020 MY Supra [03/2019 -]		

INSTALLATION

PROCEDURE

1. INSTALL TRAP CIRCUIT

(a) Engage the guide (4).



(b) Install the trap circuit (3) with the T25 bolt (2).

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

(c) Connect the connectors (1).

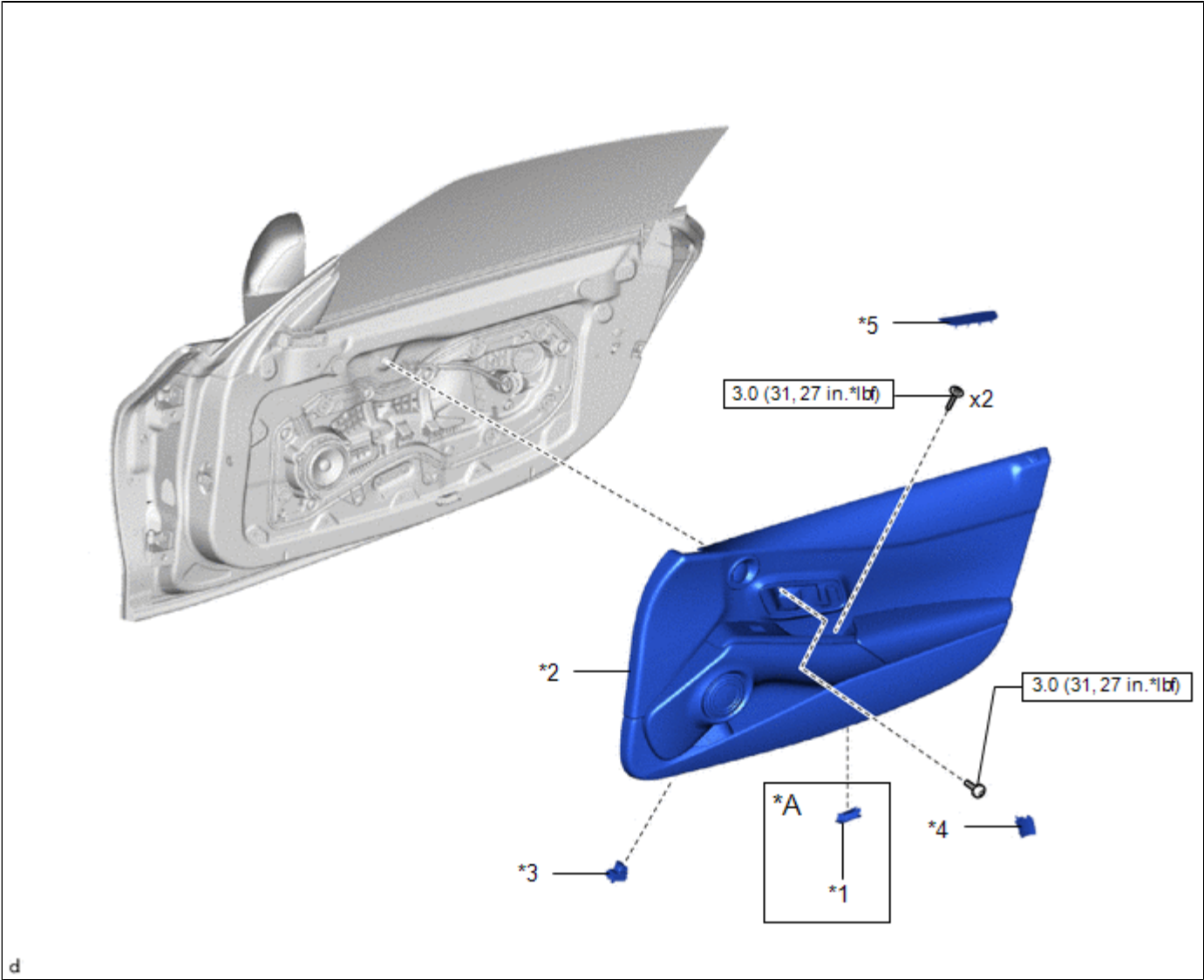
2. INSTALL ROOF HEADLINING ASSEMBLY

Click here [INFO](#)

Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JC0W
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WINDOW / GLASS: FRONT PASSENGER SIDE POWER WINDOW SWITCH: COMPONENTS; 2020 MY Supra [03/2019 -]		

COMPONENTS

ILLUSTRATION



*A	w/ Courtesy Light	-	-
*1	COURTESY LIGHT ASSEMBLY	*2	FRONT DOOR TRIM BOARD SUB-ASSEMBLY RH
*3	POWER WINDOW REGULATOR SWITCH ASSEMBLY	*4	NO. 2 DOOR INSIDE HANDLE BEZEL RH
*5	DOOR TRIM COVER RH	-	-
N*m (kgf*cm, ft.*lbf): Specified			

	torque	-	-
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Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JC0X
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WINDOW / GLASS: FRONT PASSENGER SIDE POWER WINDOW SWITCH: REMOVAL; 2020 MY Supra [03/2019 -]		

REMOVAL

PROCEDURE

1. REMOVE COURTESY LIGHT ASSEMBLY (w / Courtesy Light)

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

Click here [INFO](#)

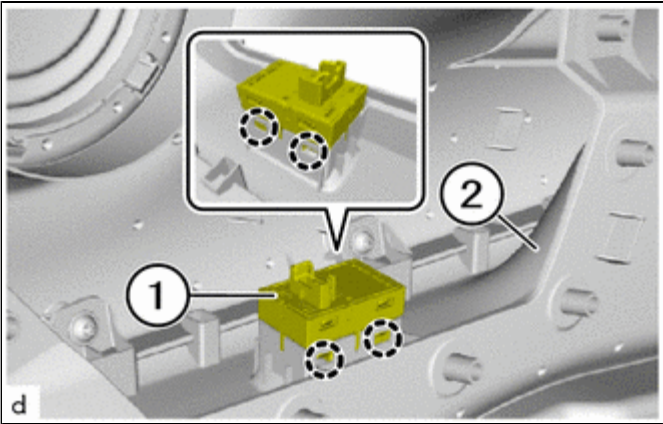
2. REMOVE FRONT DOOR TRIM BOARD SUB-ASSEMBLY RH

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

Click here [INFO](#)

3. REMOVE POWER WINDOW REGULATOR SWITCH ASSEMBLY

(a) Disengage the claws in the marked area.



(b) Remove power window regulator switch assembly (1) from the front door trim board sub-assembly RH (2).

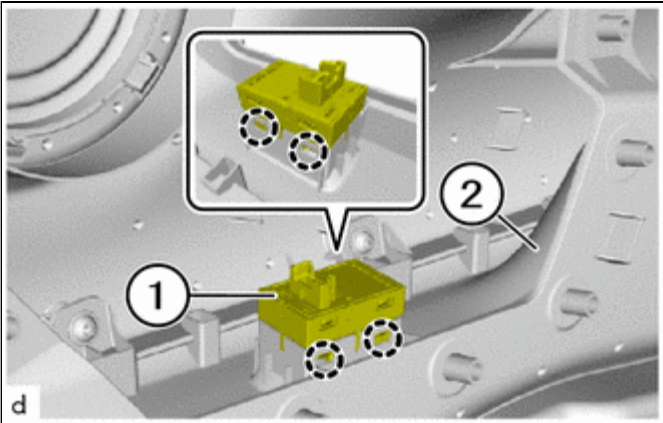
Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JC0Y
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WINDOW / GLASS: FRONT PASSENGER SIDE POWER WINDOW SWITCH: INSTALLATION; 2020 MY Supra [03/2019 -]		

INSTALLATION

PROCEDURE

1. INSTALL POWER WINDOW REGULATOR SWITCH ASSEMBLY

- (a) Install power window regulator switch assembly (1) on front door trim board sub-assembly RH (2) and clip it in on both sides of the marked area.



2. INSTALL FRONT DOOR TRIM BOARD SUB-ASSEMBLY RH

HINT:

Use the same procedure as for the LH side.

Click here [INFO](#)

3. INSTALL COURTESY LIGHT ASSEMBLY (w / Courtesy Light)

HINT:

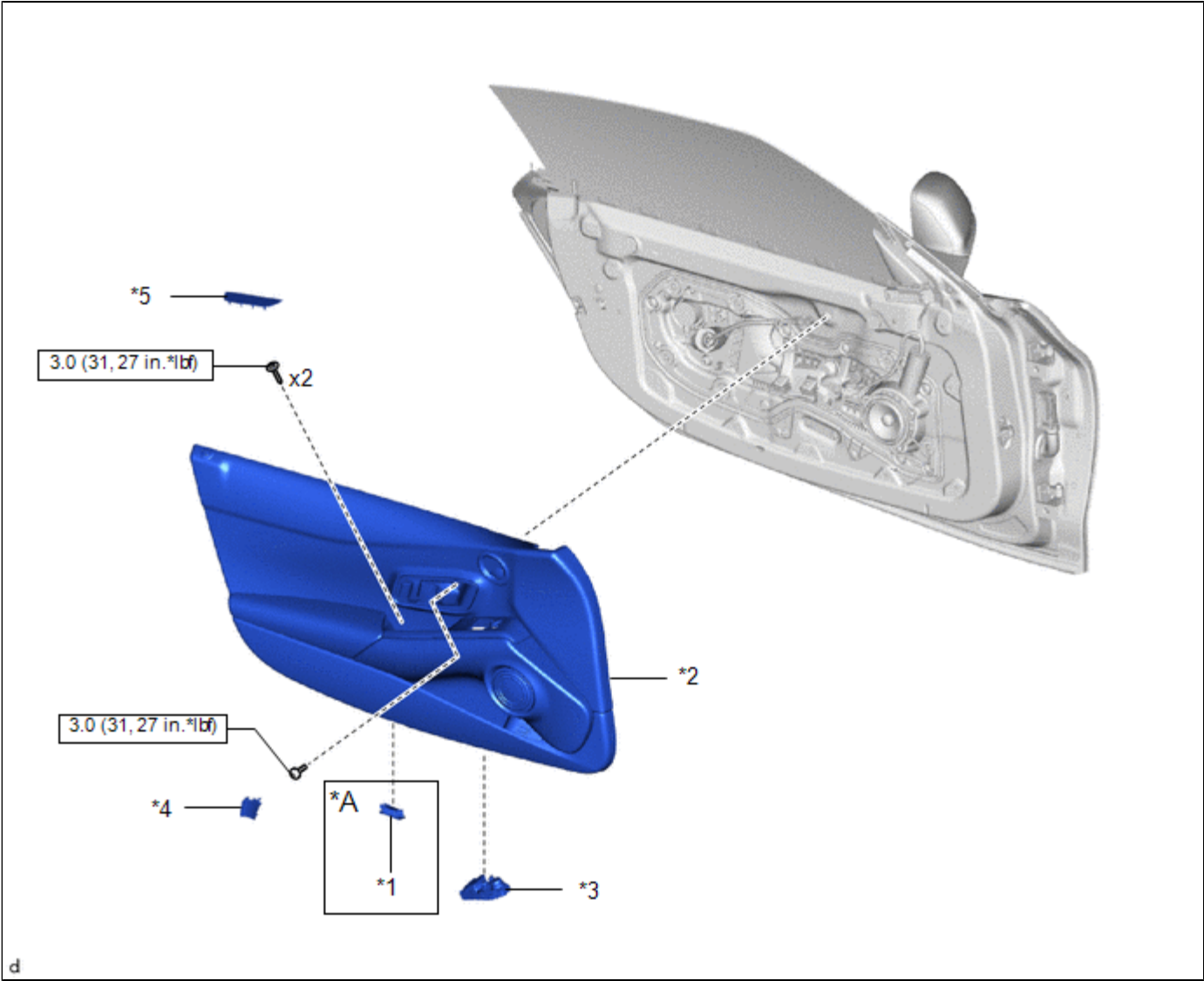
Use the same procedure as for the LH side.

Click here [INFO](#)

Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JC0T
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WINDOW / GLASS: POWER WINDOW MASTER SWITCH: COMPONENTS; 2020 MY Supra [03/2019 -]		

COMPONENTS

ILLUSTRATION



*A	w/ Courtesy Light	-	-
*1	COURTESY LIGHT ASSEMBLY	*2	FRONT DOOR TRIM BOARD SUB-ASSEMBLY LH
*3	POWER WINDOW REGULATOR MASTER SWITCH ASSEMBLY	*4	NO. 2 DOOR INSIDE HANDLE BEZEL LH
*5	DOOR TRIM COVER LH	-	-
	N*m (kgf*cm, ft.*lbf): Specified torque	-	-

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Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JC0U
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WINDOW / GLASS: POWER WINDOW MASTER SWITCH: REMOVAL; 2020 MY Supra [03/2019 -]		

REMOVAL

PROCEDURE

1. REMOVE COURTESY LIGHT ASSEMBLY (w / Courtesy Light)

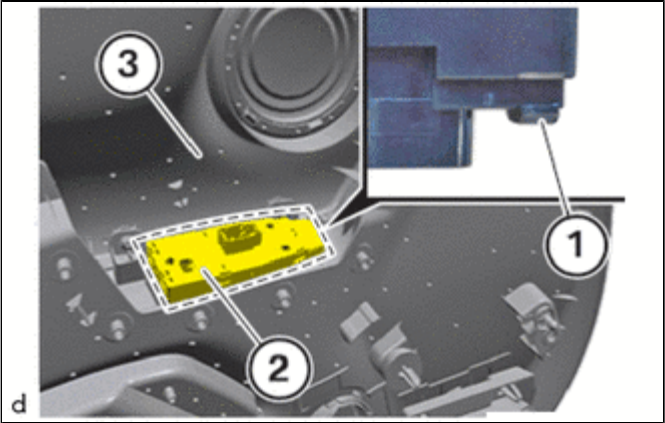
Click here [INFO](#)

2. REMOVE FRONT DOOR TRIM BOARD SUB-ASSEMBLY LH

Click here [INFO](#)

3. REMOVE POWER WINDOW REGULATOR MASTER SWITCH ASSEMBLY

(a) Disengage claws (1) in the marked area.



(b) Remove power window regulator master switch assembly (2) from front door trim board sub-assembly LH (3).

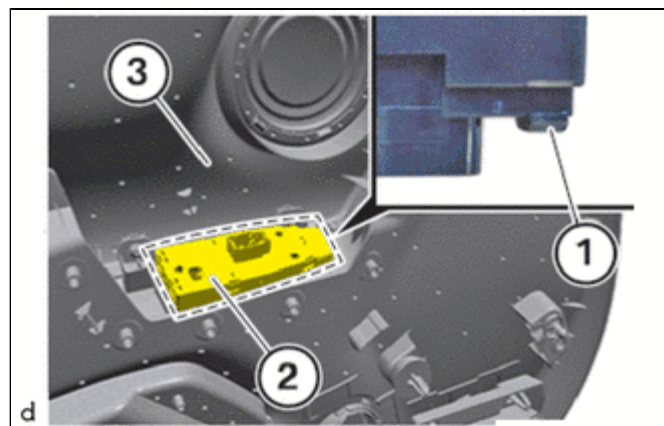
Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JC0V
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WINDOW / GLASS: POWER WINDOW MASTER SWITCH: INSTALLATION; 2020 MY Supra [03/2019 -]		

INSTALLATION

PROCEDURE

1. INSTALL POWER WINDOW REGULATOR MASTER SWITCH ASSEMBLY

- (a) Position power window regulator master switch assembly (2) on the front door trim board sub-assembly LH (3) and engage in the claws (1).



2. INSTALL FRONT DOOR TRIM BOARD SUB-ASSEMBLY LH

Click here [INFO](#)

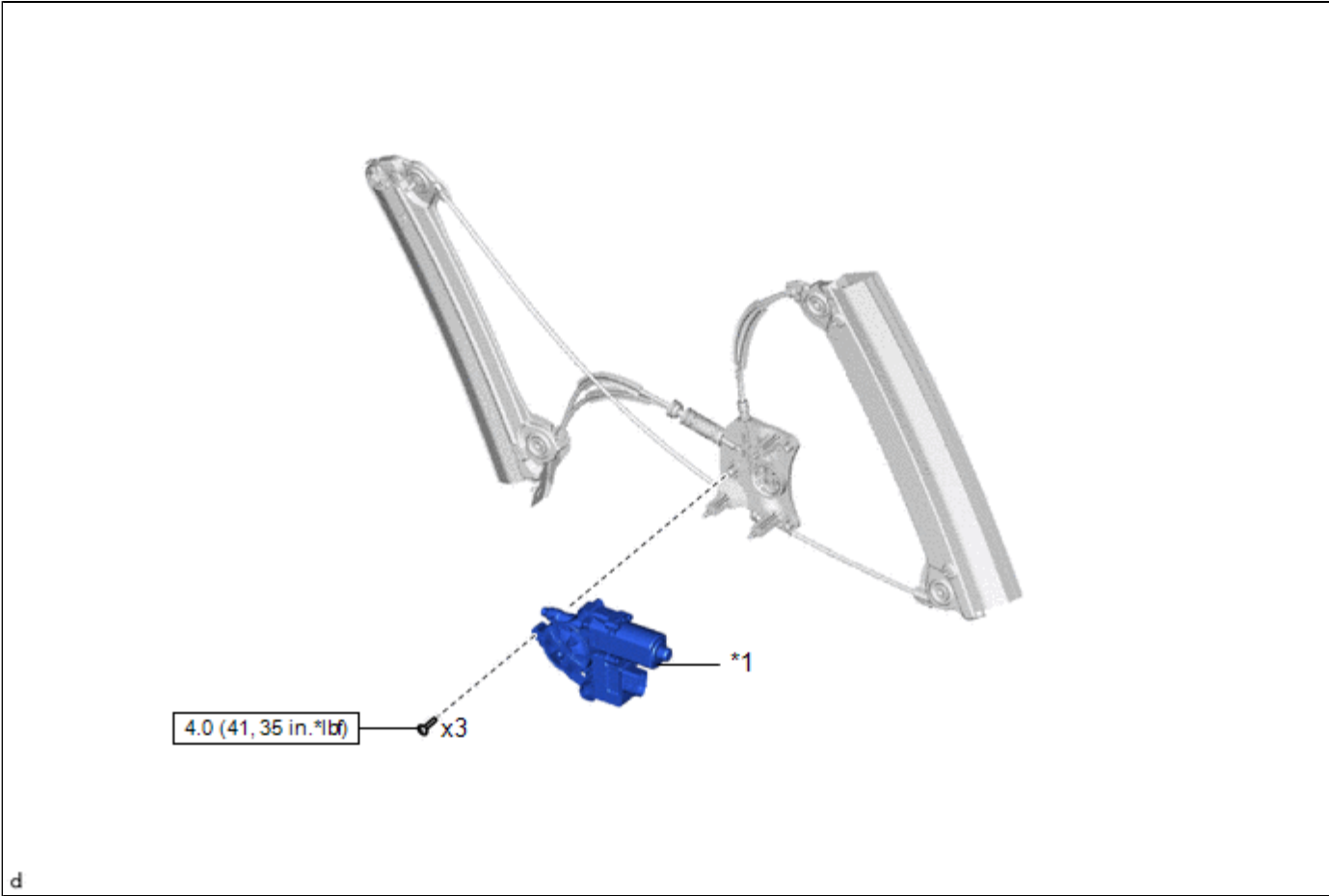
3. INSTALL COURTESY LIGHT ASSEMBLY (w / Courtesy Light)

Click here [INFO](#)

Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JC0Z
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WINDOW / GLASS: POWER WINDOW REGULATOR MOTOR: COMPONENTS; 2020 MY Supra [03/2019 -]		

COMPONENTS

ILLUSTRATION



*1	POWER WINDOW REGULATOR MOTOR ASSEMBLY	-	-
	N*m (kgf*cm, ft.*lbf): Specified torque	-	-

Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JC10
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WINDOW / GLASS: POWER WINDOW REGULATOR MOTOR: 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.

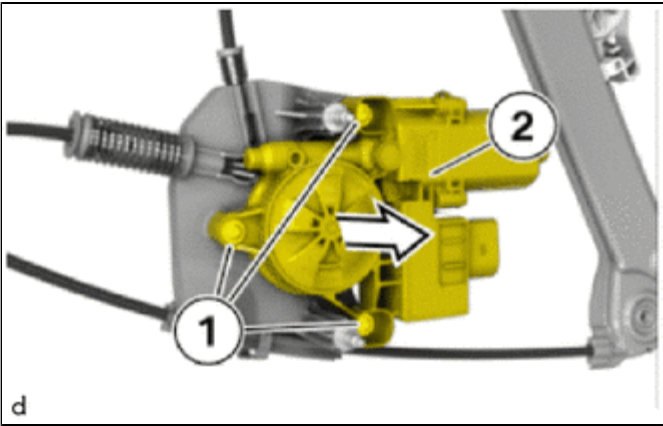
PROCEDURE

1. REMOVE FRONT DOOR WINDOW REGULATOR ASSEMBLY

Click here [INFO](#)

2. REMOVE POWER WINDOW REGULATOR MOTOR ASSEMBLY

(a) Remove the T25 screws (1).



(b) Remove the power window regulator motor assembly (2) from the front door window regulator assembly in direction of arrow.

Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JC11
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WINDOW / GLASS: POWER WINDOW REGULATOR MOTOR: INSTALLATION; 2020 MY Supra [03/2019 -]		

INSTALLATION

CAUTION / NOTICE / HINT

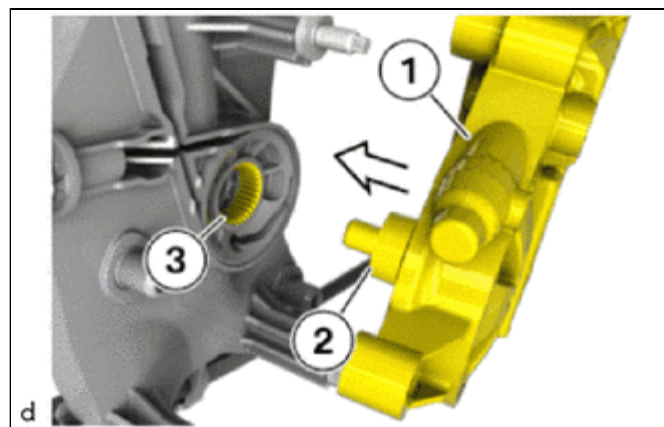
HINT:

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

PROCEDURE

1. INSTALL POWER WINDOW REGULATOR MOTOR ASSEMBLY

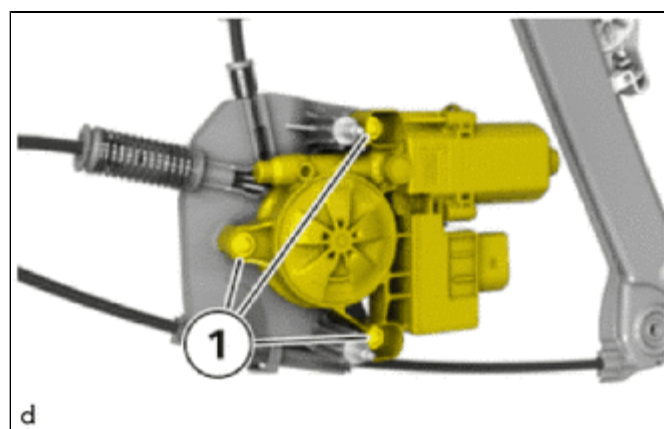
- (a) Install the power window regulator motor assembly for the front door window regulator assembly (1) in direction of arrow so that its shaft (2) is fitted de-energized in the gearing (3) of the front door window regulator assembly.



- (b) Install the T25 screws (1).

Torque:

4.0 N·m {41 kgf·cm, 35 in·lbf}



2. INSTALL FRONT DOOR WINDOW REGULATOR ASSEMBLY

Click here [INFO](#)

3. INITIALIZE POWER WINDOW CONTROL SYSTEM

NOTICE:

- When a power window regulator motor assembly replaced, the power window control system must be initialized. Functions such as the auto up and down function, jam protection function and window open warning function will not operate if initialization is not performed.
- When performing initialization, use the power window switch of each door to initialize each power window.
- Make sure to park the vehicle and all doors closed before performing initialization.

(a) Operating procedure for initialization (manual):

- (1) Move front door glass sub-assembly into lower end position.
- (2) Press and hold switch in "Open one-touch function" position (second switch position) for a timespan between 15 and 25 seconds.
- (3) Move front door glass sub-assembly to upper end position.
- (4) Switch position "Close one-touch function" (2nd switch position) hold down the switch position during the entire process.

(b) Connect the diagnosis system to the vehicle and enter the following menus:

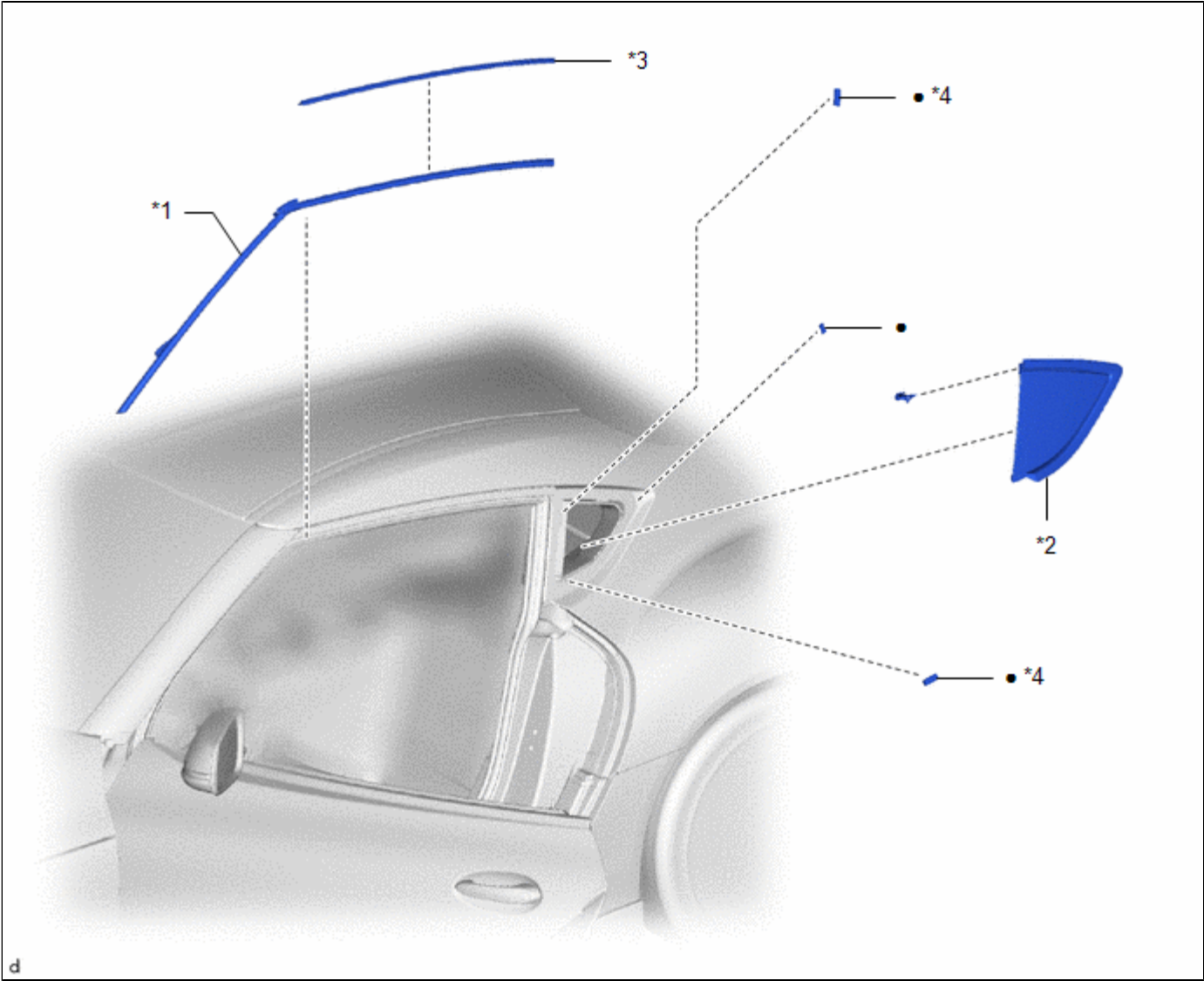
Vehicle management / Service functions / Body / Locking and security functions / Power window regulator / Initialize power window drive



Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JC18
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WINDOW / GLASS: QUARTER WINDOW GLASS: COMPONENTS; 2020 MY Supra [03/2019 -]		

COMPONENTS

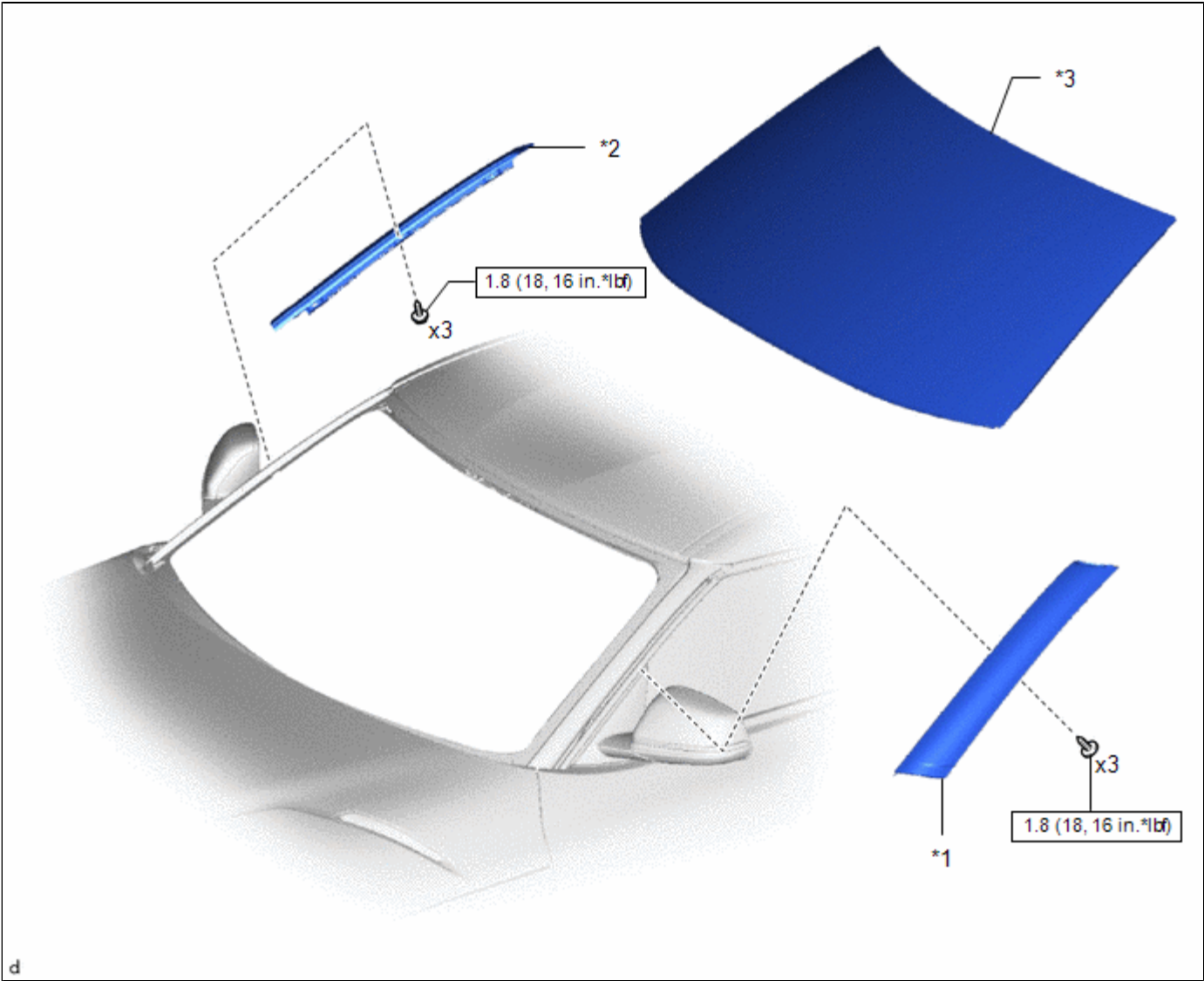
ILLUSTRATION



*1	FRONT DOOR WINDOW FRAME FRONT MOULDING	*2	QUARTER WINDOW ASSEMBLY
*3	FRONT ROOF SIDE RAIL WEATHERSTRIP RETAINER	*4	GUIDE PIN
•	Non-reusable part	-	-

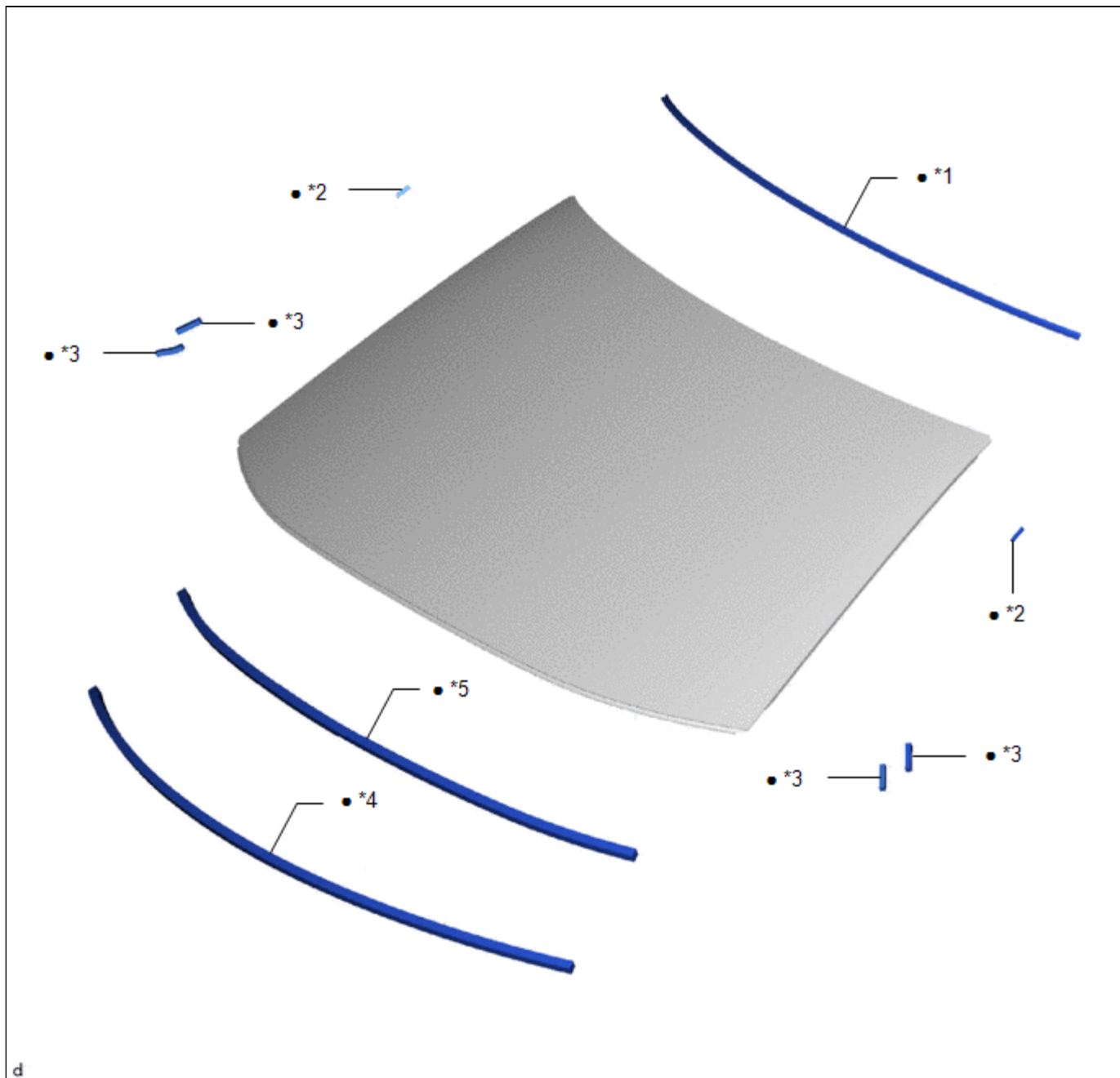
	N*m (kgf*cm, ft.*lbf): Specified torque	-	-
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ILLUSTRATION



*1	ROOF DRIP SIDE FINISH MOULDING LH	*2	ROOF DRIP SIDE FINISH MOULDING RH
*3	WINDSHIELD GLASS	-	-
	N*m (kgf*cm, ft.*lbf): Specified torque	-	-

ILLUSTRATION



*1	WINDSHIELD OUTSIDE MOULDING	*2	NO. 1 WINDSHIELD GLASS SPACER
*3	CUSHION	*4	NO. 1 INSTRUMENT PANEL CUSHION
*5	NO. 2 INSTRUMENT PANEL CUSHION	-	-
●	Non-reusable part	-	-

Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JC13
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WINDOW / GLASS: WINDSHIELD GLASS: REMOVAL; 2020 MY Supra [03/2019 -]		

REMOVAL

CAUTION / NOTICE / HINT

NOTICE:

- Scratches.

Tools and sharp-edged components can cause scratches.

- Protect working area.
- Handle tools and components carefully.

PROCEDURE

1. REMOVE INNER REAR VIEW MIRROR STAY HOLDER COVER

Click here [INFO](#)

2. REMOVE INNER REAR VIEW MIRROR ASSEMBLY

Click here [INFO](#)

3. REMOVE RAIN SENSOR

Click here [INFO](#)

4. REMOVE FORWARD RECOGNITION CAMERA (w / Toyota Supra Safety)

Click here [INFO](#)

5. REMOVE FRONT PILLAR GARNISH LH

Click here [INFO](#)

6. REMOVE FRONT PILLAR GARNISH RH

HINT:

Use the same procedure as for the LH side.

7. REMOVE COWL TOP VENTILATOR LOUVER SUB-ASSEMBLY

Click here [INFO](#)

8. REMOVE ROOF DRIP SIDE FINISH MOULDING LH

Click here [INFO](#)

9. REMOVE ROOF DRIP SIDE FINISH MOULDING RH

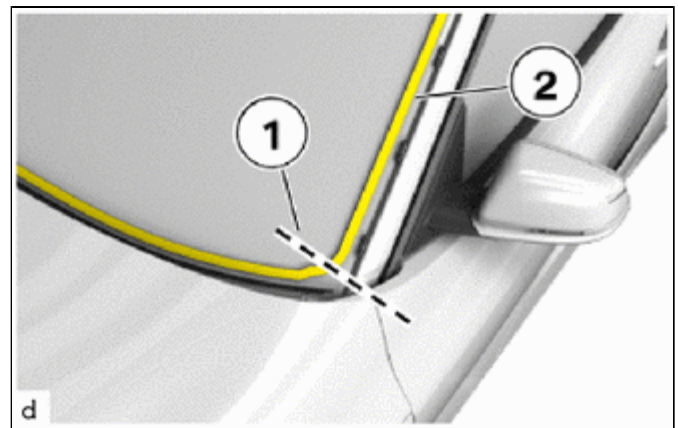
HINT:

Use the same procedure as for the LH side.

10. REMOVE WINDSHIELD GLASS

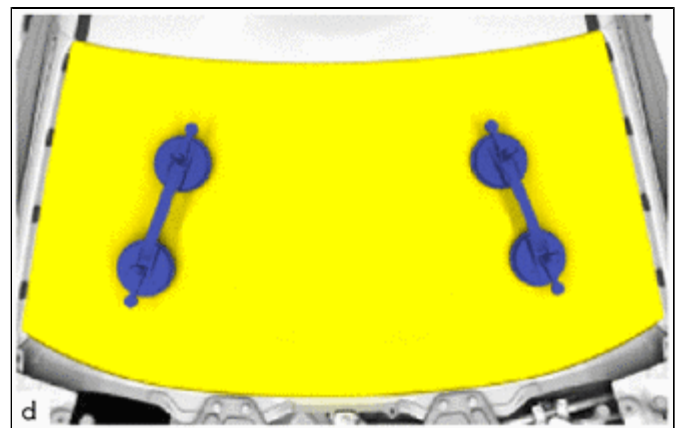
- (a) Tape off body in area of piercing point with protective tape.

(b) Push the thread along the line (1) through the adhesive bead (2) from the inside.



(c) Cut out the windshield glass with a piano wire.

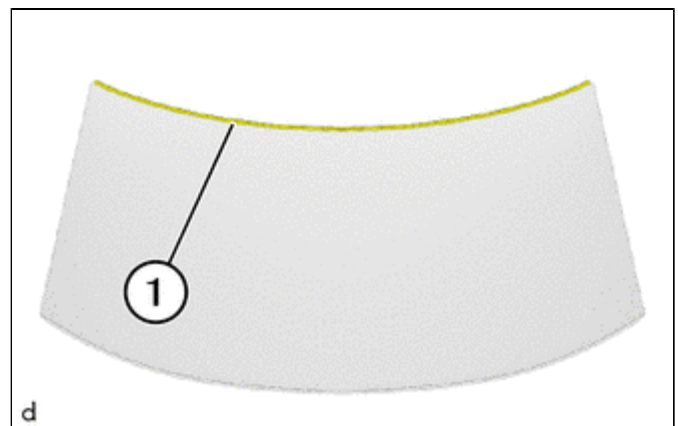
(d) Using suction cups, remove windshield glass.



11. REMOVE WINDSHIELD OUTSIDE MOULDING

(a) When reusing the windshield glass:

(1) Remove the windshield outside moulding (1).



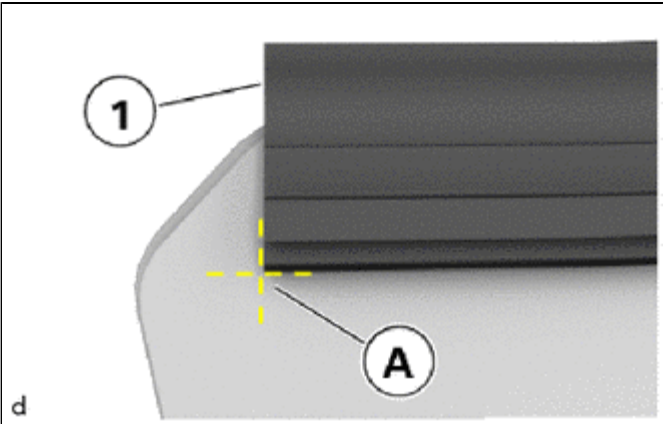
Last Modified: 09-05-2019	6.9:8.0.49	Doc ID: RM100000001JC14
Model Year Start: 2020	Model: Supra	Prod Date Range: [03/2019 -]
Title: WINDOW / GLASS: WINDSHIELD GLASS: INSTALLATION; 2020 MY Supra [03/2019 -]		

INSTALLATION

PROCEDURE

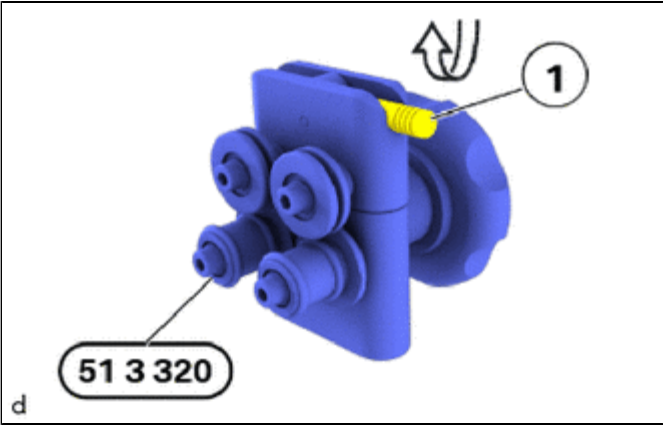
1. INSTALL WINDSHIELD OUTSIDE MOULDING

(a) Observe marks (A) for a new windshield outside moulding (1).

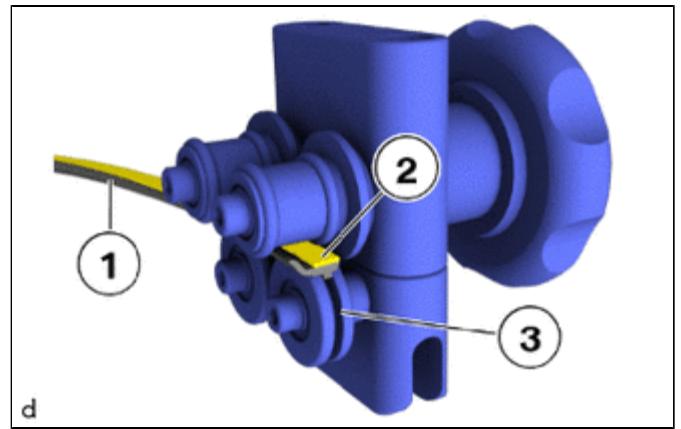


(b) Reposition lever (1) in direction of arrow and open it using the special tool 0 496 529 (51 3 320).

SST: 09800-WA170

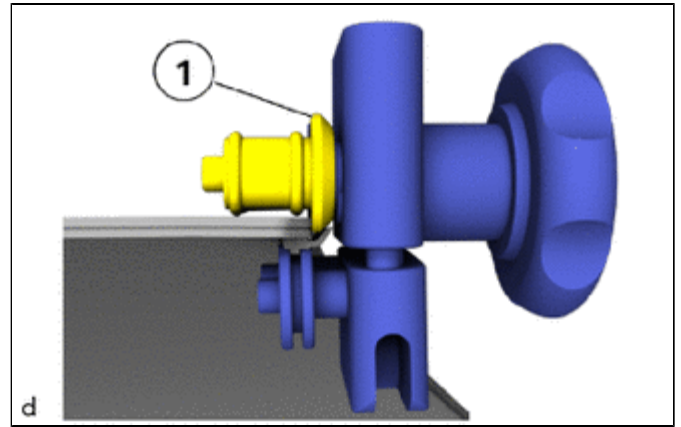


(c) Pull off protective film (2) in stages from double-sided tape.



(d) Insert the windshield outside moulding (1) into the special tool 0 496 529 (51 3 320) (3).

SST: 09800-WA170

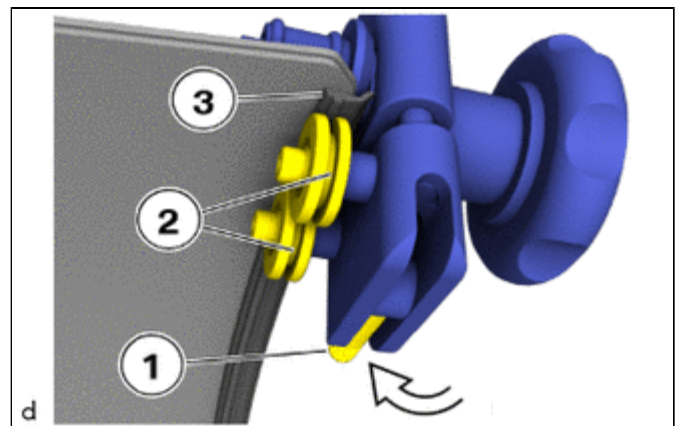


(e) Place the special tool 0 496 529 (51 3 320) with the pressure rollers (1) up against the windshield glass edge.

SST: 09800-WA170

(f) Align the cover on the outer edge of the windshield glass.

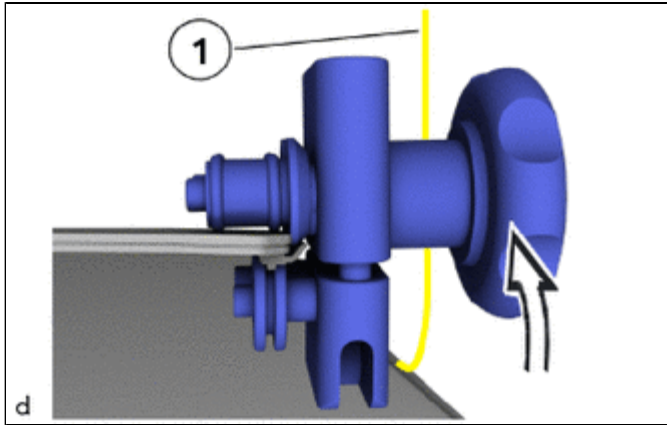
(g) Fit the cover and visually check for perfect fit.



(h) Reposition the lever (1) in the direction of arrow and close the special tool 0 496 529 (51 3 320).

SST: 09800-WA170

(i) Ensure the windshield outside moulding (3) fits correctly into the guide pulleys (2).



- (j) Continue to pull off protective film (1) in stages from double-sided tape.

- (k) Pull the special tool 0 496 529 (51 3 320) in the direction of arrow with the handwheel over the entire upper edge of the windshield glass.

SST: 09800-WA170

- (l) Install the windshield outside moulding.

2. INSTALL WINDSHIELD GLASS

HINT:

- The vehicle can be towed away or driven without the windshield glass.
- When carrying out removal/installation work and during the hardening time, the vehicle must be standing on its wheels on a level surface.
- The windshield glass 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 windshield glass and body aperture with residual adhesive bead.

Cleaner:

Cleaner R1, Cleaner R2

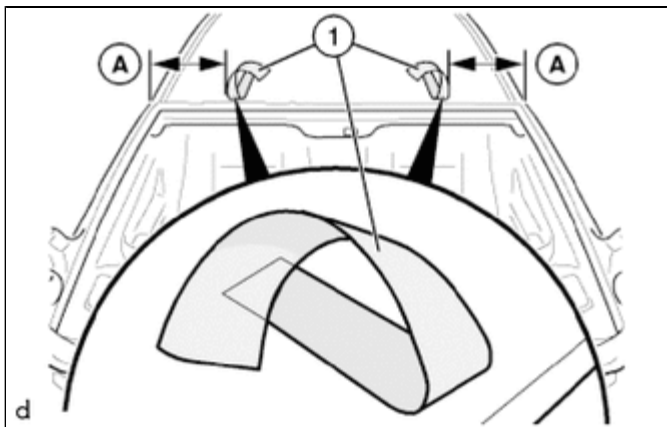
HINT:

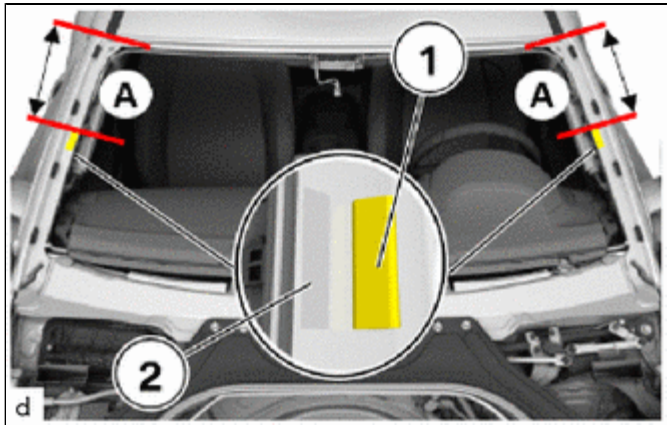
Protect vehicle interior against contamination.

- (b) Install the 2 protective tapes (1) to the roof.

Standard Dimension:

AREA	DIMENSION
A	250 mm (9.84 in.)





(c) Completely remove the No. 1 windshield glass spacer (1).

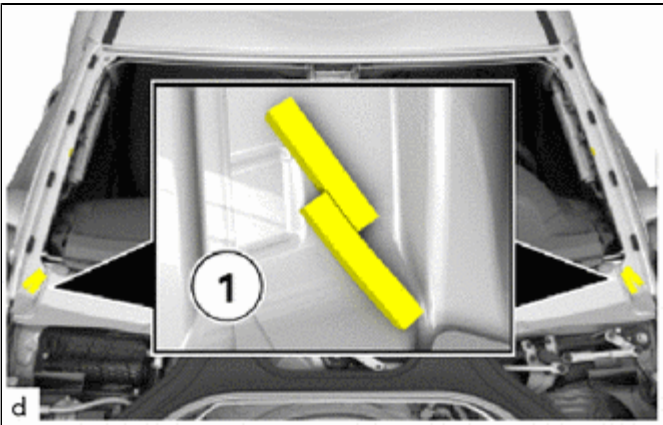
(d) Replace the No. 1 windshield glass spacer (1).

(e) Bond the new No. 1 windshield glass spacer (1) in the center on the marks (2) embossed on the body.

Dimensions of the No. 1 windshield glass spacer and positioning:

AREA	DIMENSION
Length	20 mm (0.787 in.)
Width	5.0 mm (0.197 in.)
Height	5.0 mm (0.197 in.)
A	300 mm (11.8 in.)

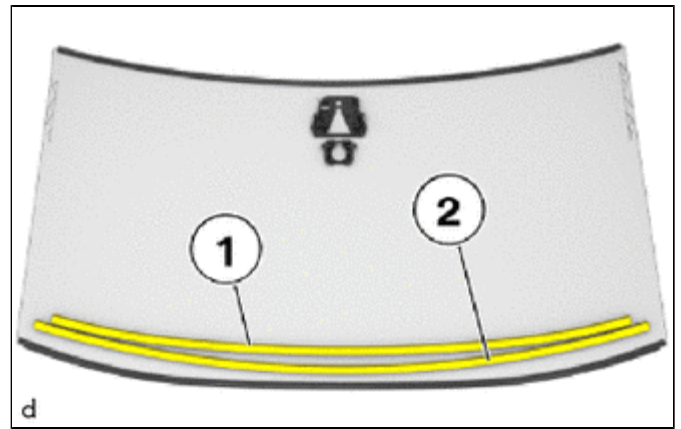
(f) Check both cushions (1) for damage and replace if necessary.



(g) Check No. 1 instrument panel cushion (2) and No. 2 instrument panel cushion (1) for the cowl panel for damage.

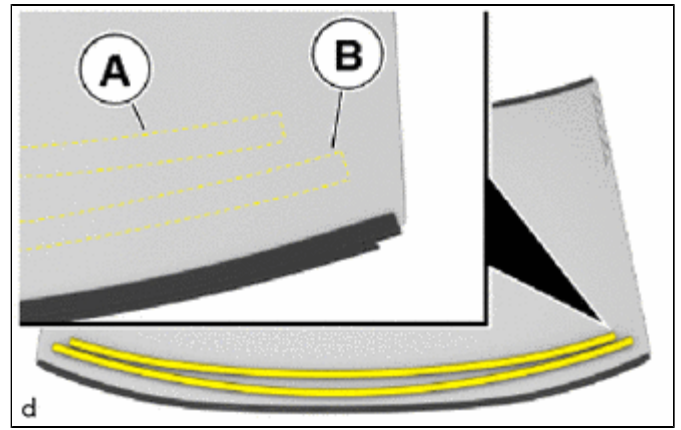
HINT:

- No. 1 instrument panel cushion (2) or No. 2 instrument panel cushion (1) for the cowl panel is damaged.
 - Replace No. 1 instrument panel cushion (2) or No. 2 instrument panel cushion (1) for the cowl panel.



(h) When reusing the No. 1 instrument panel cushion and No. 2 instrument panel cushion:

- (1) Observe marks (A) and (B) for the No. 1 instrument panel cushion and No. 2 instrument panel cushion on the windshield glass.

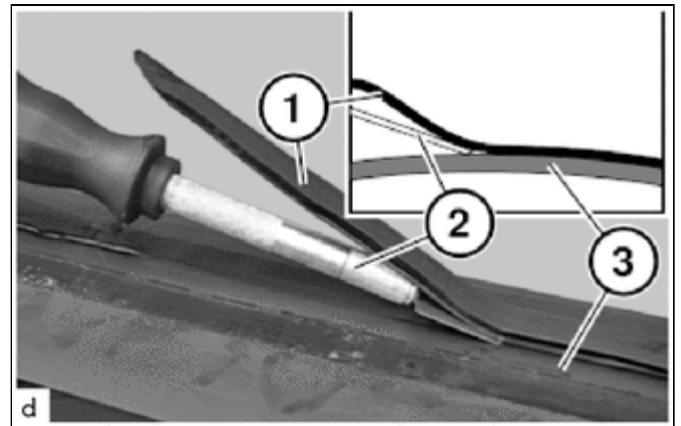


(i) When reusing the windshield glass:

- (1) 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.)



(j) Apply glass activator to the windshield glass (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 windshield glass 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

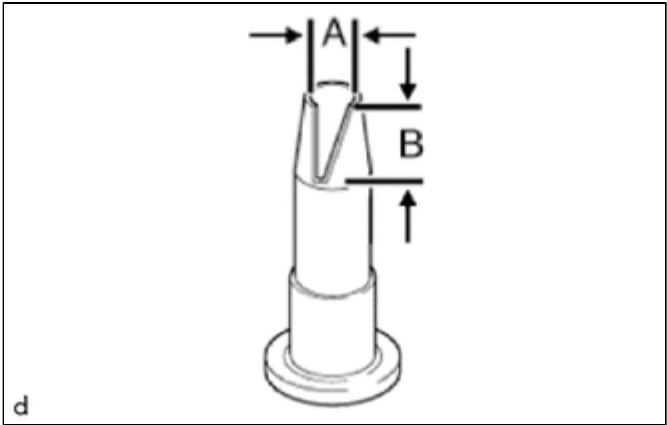
HINT:

- 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.

(k) Prepare the glue cartridge with the standard nozzle C.

Standard Nozzle C:
Repair Kit, Window Glass, Cold, 1 Hour
Standard Dimension:

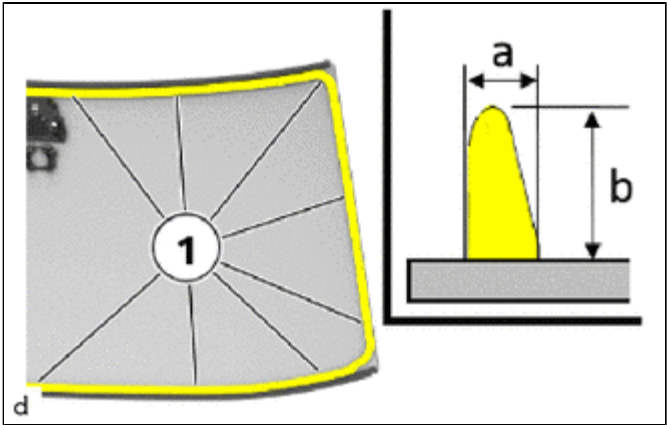
AREA	DIMENSION
A	7.0 to 9.0 mm (0.276 to 0.354 in.)
B	11 to 13 mm (0.433 to 0.512 in.)



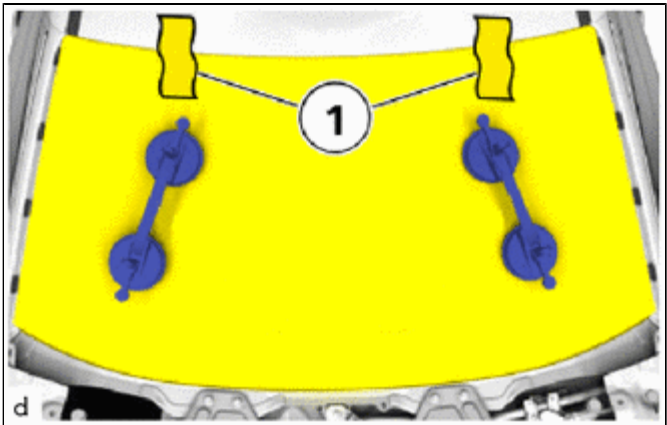
(l) Apply adhesive bead within the marks (1) on the windshield glass.

Adhesive:
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	11 to 13 mm (0.433 to 0.512 in.)



(m) Using suction cups, carefully insert the windshield glass between the bonnet and the cowl panel.



- (n) Position the windshield glass at the top.
- (o) Evenly align the windshield glass on the left and right.
- (p) Insert and press on the windshield glass at the bottom.
- (q) Press the windshield glass towards the top until the windshield outside moulding of the windshield glass is evenly in contact with the roof.
- (r) Secure the windshield glass in this installation position using the two protective tapes (1).

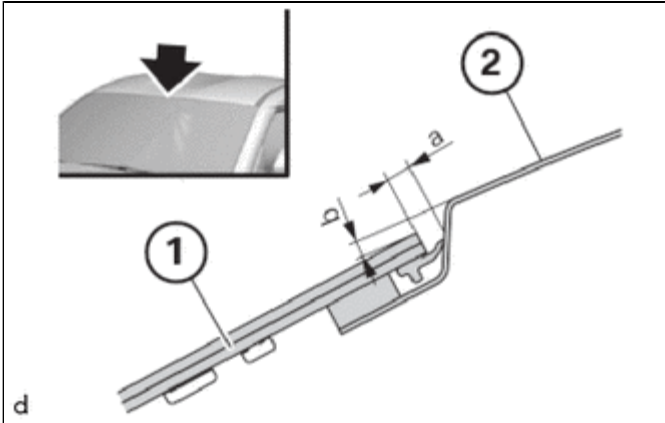
(s) Using the special tools 0 496 076 (00 9 470) and 0 495 259 (51 0 010), measuring gap dimension windshield glass to roof outer skin.

SST: 09800-WA340

SST: 09800-WA350

Standard Dimension:

AREA	DIMENSION
a	2.6 to 5.0 mm (0.102 to 0.197 in.)
b	1.1 to 3.7 mm (0.0433 to 0.146 in.)



(1)	Windshield Glass
(2)	Roof Outer Skin

3. INSTALL ROOF DRIP SIDE FINISH MOULDING LH

Click here [INFO](#)

4. INSTALL ROOF DRIP SIDE FINISH MOULDING RH

HINT:

Use the same procedure as for the LH side.

5. INSTALL COWL TOP VENTILATOR LOUVER SUB-ASSEMBLY

Click here [INFO](#)

6. CHECK WIPER AND WASHER SYSTEM

- (a) Check the wiper range for streaks.
 - (1) Streaks in the wiper range.
 - (2) Replace the windshield wiper blade assembly.
- (b) Check the washer fluid contacts the windshield glass.
 - (1) The washer fluid contacts does not exit or exits unevenly.
 - (2) If applicable, replace the front washer nozzle and hose assembly.

7. INSTALL FRONT PILLAR GARNISH LH

Click here [INFO](#)

8. INSTALL FRONT PILLAR GARNISH RH

HINT:

Use the same procedure as for the LH side.

9. INSTALL FORWARD RECOGNITION CAMERA (w/ Toyota Supra Safety)

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10. INSTALL RAIN SENSOR

Click here [INFO](#)

11. INSTALL INNER REAR VIEW MIRROR ASSEMBLY

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12. INSTALL INNER REAR VIEW MIRROR STAY HOLDER COVER

Click here [INFO](#)

