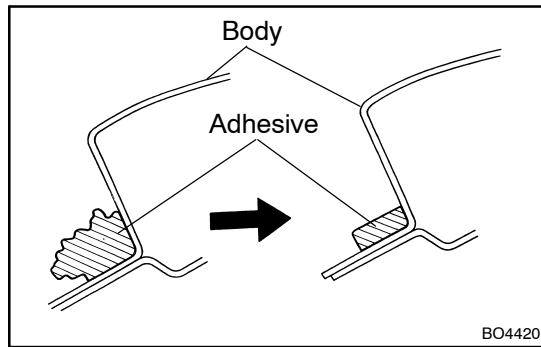




INSTALLATION

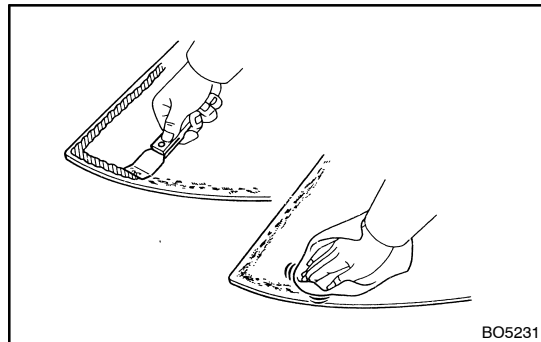
1. CLEAN AND SHAPE CONTACT SURFACE OF BODY

- (a) Using a knife, cut away any rough areas on the body.

HINT:

Leave as much of the adhesive on the body as possible.

- (b) Clean the cutting surface of the adhesive with a piece of shop rag soaked with cleanser.

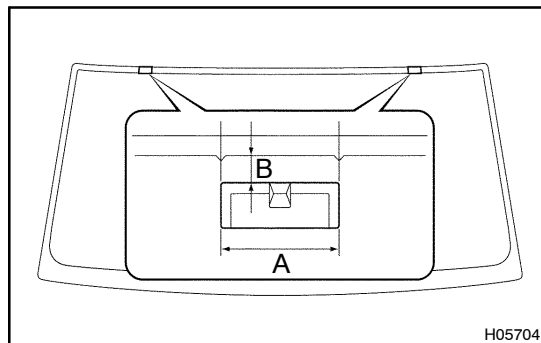


2. CLEAN REMOVED GLASS

- (a) Remove the damaged stoppers and dams.
 (b) Using a scraper, remove the adhesive sticking to the glass.
 (c) Clean the glass with cleaner.

NOTICE:

- Do not touch the glass surface after cleaning it.
- Be careful not to damage the glass.

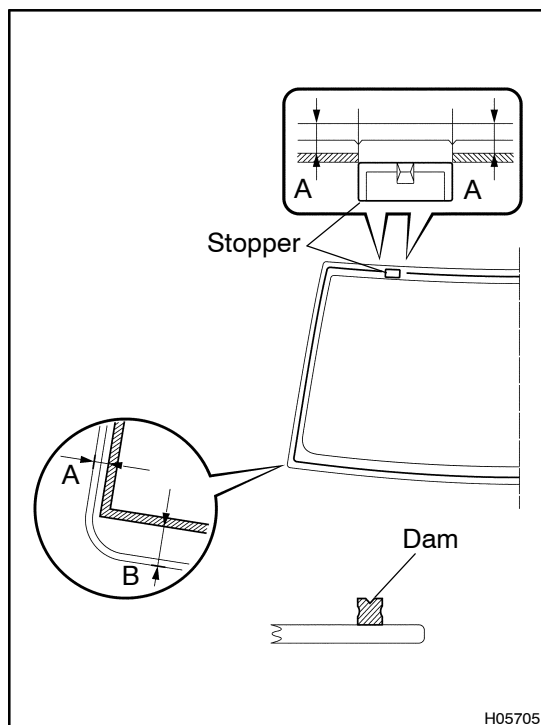


3. INSTALL NEW STOPPERS

Install new stoppers onto the glass.

A: 9 mm (0.35 in.)

B: 25 mm (0.98 in.)



4. INSTALL NEW DAMS

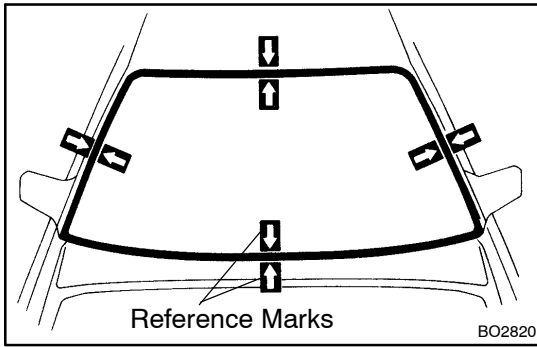
Install new dams with adhesive tape as shown in the illustration.

NOTICE:

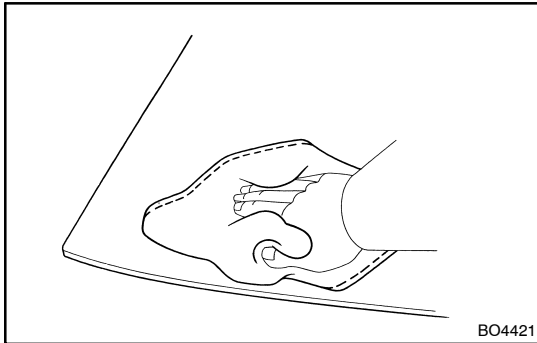
Do not touch the glass surface after cleaning it.

A: 7 mm (0.28 in.)

B: 20 mm (0.79 in.)

**5. POSITION GLASS**

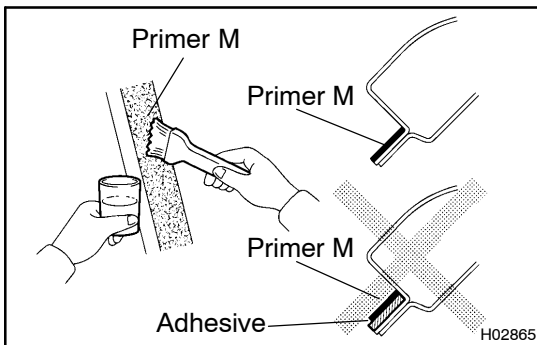
- Place the glass in the correct position.
- Check that all contacting parts of the glass rim is perfectly even but does not contact with the 2 stoppers.
- Place reference marks between the glass and the body.
- Remove the glass.

**6. CLEAN CONTACT SURFACE OF GLASS**

Using cleanser, clean the contact surface which is black-colored area around the entire glass rim.

NOTICE:

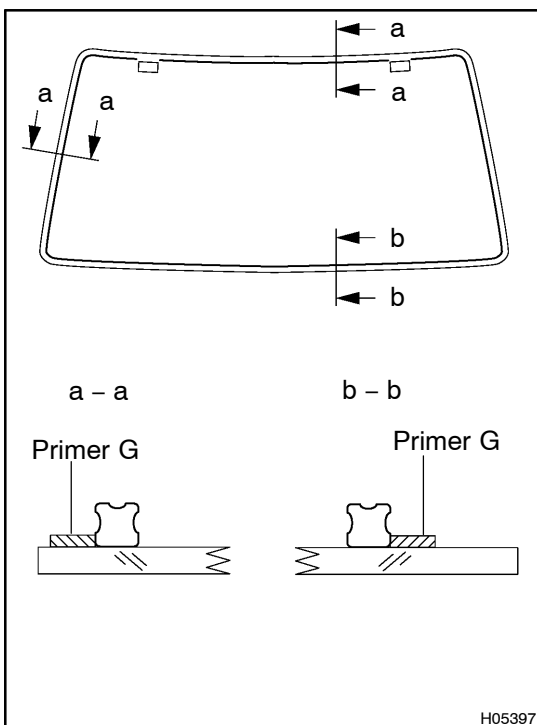
Do not touch the glass surface after cleaning it.

**7. COAT CONTACT SURFACE OF BODY WITH PRIMER "M"**

Using a brush, coat Primer M to the exposed part of body on the vehicle side.

NOTICE:

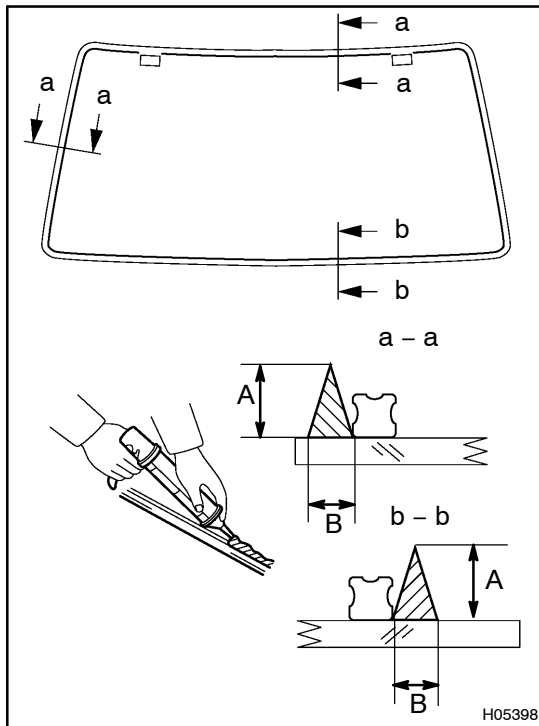
- Let the primer coating dry for 3 minutes or more.
- Do not coat Primer M to the adhesive.
- Do not keep the remaining Primer M for later use.

**8. COAT CONTACT SURFACE OF GLASS WITH PRIMER "G"**

- Using a brush or sponge, coat the edge of the glass and the contact surface with Primer G.
- If the primer is accidentally coated to the area not specified, wipe it off with a clean shop rag before the primer dries.

NOTICE:

- Let the primer coating dry for 3 minutes or more.
- Do not keep the remaining Primer G for later use.



9. APPLY ADHESIVE

- (a) Cut off the tip of the cartridge nozzle.
Part No. 08850-00801 or equivalent.

HINT:

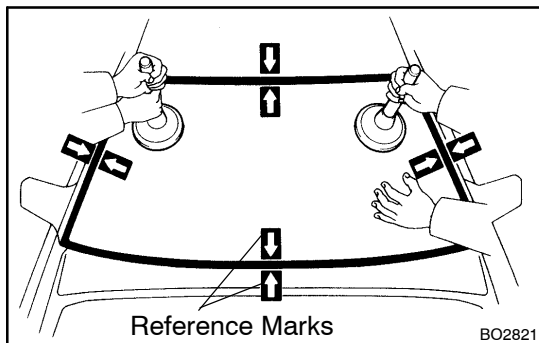
After cutting off the tip, use all adhesive within the time described in the table below.

Temperature	Tackfree time
35 °C (95 °F)	15 minutes
20 °C (68 °F)	100 minutes
5 °C (41 °F)	8 hours

- (b) Load the cartridge into the sealer gun.
 (c) Coat the glass with adhesive as shown.

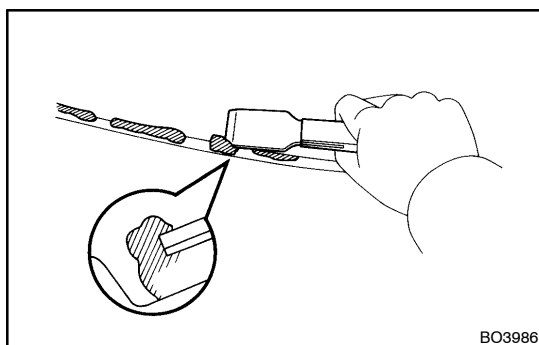
A: 12.0 mm (0.472 in.)

B: 8.0 mm (0.315 in.)

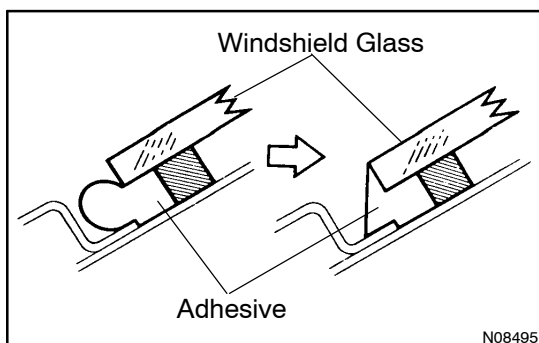


10. INSTALL WINDSHIELD GLASS

- (a) Position the glass so that the reference marks are lined up and press in gently along the rim.
 (b) Using a spatula, apply adhesive on the glass rim.



- (c) Use a scraper to remove any excess or protruding adhesive.



HINT:

Make sure that the dam is attached to the body panel, as shown in the illustration.

- (d) Hold the windshield glass in place securely with a protective tape or equivalent until the adhesive hardens.

NOTICE:

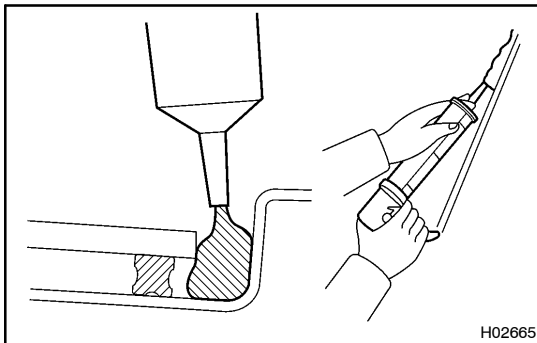
Take care not to drive the vehicle with in the time described in the table below.

Temperature	Minimum time prior to driving the vehicle
35 °C (95 °F)	1.5 hours
20 °C (68 °F)	5 hours
5 °C (41 °F)	24 hours

11. INSPECT FOR LEAK AND REPAIR

- Conduct a leak test after the hardening time elapsed.
- Seal any leak with sealant.

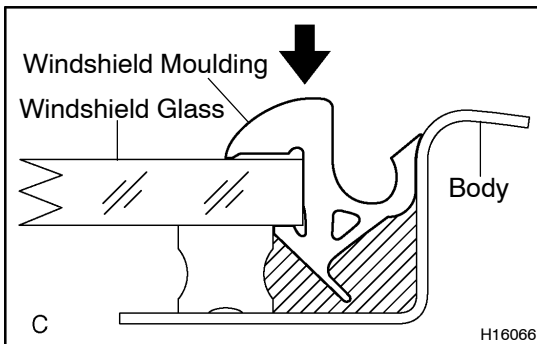
Part No. 08833-00030 or equivalent.



12. APPLY ADHESIVE TO MOULDING INSTALLATION AREA

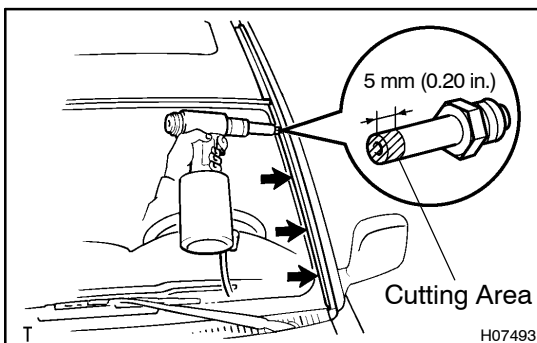
Apply adhesive to the moulding installation area between the glass and the body.

Part No. 08833-00030 or equivalent.



13. INSTALL UPPER OUTSIDE MOULDING

Place a new moulding onto the body and tap it by hand.

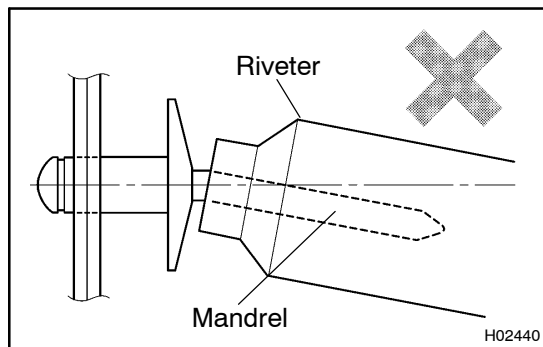


14. INSTALL OUTSIDE NO. 2 MOULDING

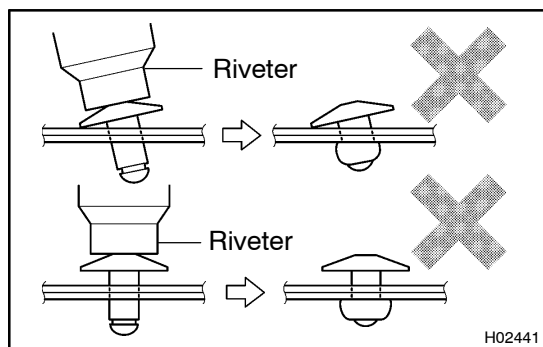
- Using an air riveter with nose piece No. 4, install 4 new rivets and the outside No. 2 moulding.

HINT:

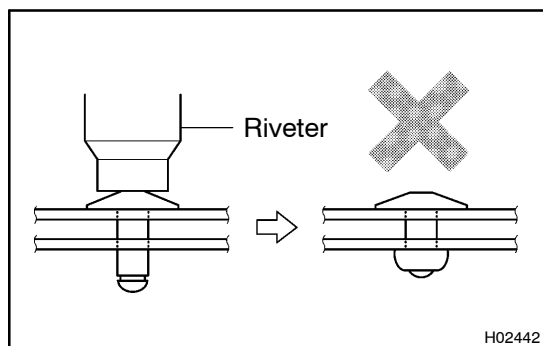
Before using the air riveter with nose piece No. 4, cut 5 mm (0.20 in.) at the edge of nose piece No. 4.

**NOTICE:**

- Do not prize a riveter. It could damage the riveter and cause loose fitting and mandrel bend.



- Do not tilt the riveter when fasten the rivet to the material to avoid loose fitting.
- Do not allow gap spacing between the rivet head and the material.



- Do not allow gap spacing between the materials.
- (b) Use the same manner described above to the other side.

15. INSTALL COWL TOP VENTILATOR LOUVERS

- (a) Install the cowl top ventilator louver LH.
 (b) Install the cowl top ventilator louver RH.

16. INSTALL HOOD TO COWL TOP SEAL**17. INSTALL WIPER ARMS**

- (a) Operate the wiper motor once and turn the wiper switch OFF.
 (b) Install the wiper arms and tighten the nuts by hand.
 (c) Adjust the installation positions of the wiper arms to the positions as shown in the illustration.

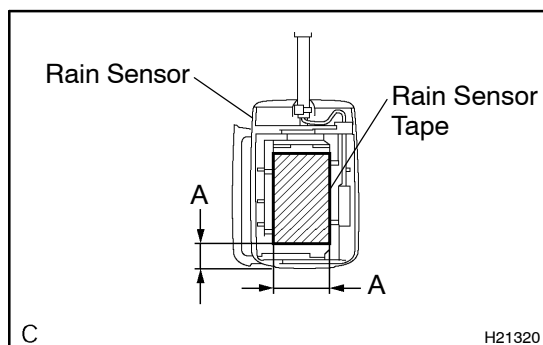
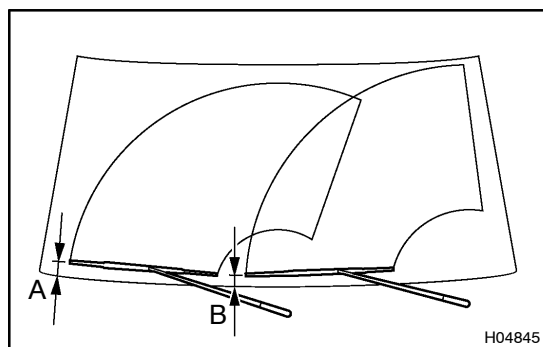
A: Approx. 30 mm (1.18 in.)

B: Approx. 21 mm (0.83 in.)

- (d) Torque the nuts.

Torque: 20 N·m (204 kgf·cm, 15 ft·lbf)

- (e) Install the 2 wiper arm head caps.

**18. INSTALL RAIN SENSOR**

- (a) If reusing the rain sensor:
 Install the new rain sensor tape.
 (1) Remove the used rain sensor tape from the windshield glass or rain sensor.
 (2) Stick new rain sensor tape on the lens surface 75 of the rain sensor indicated by the hatched line.

A: 10 mm (0.39 in.)

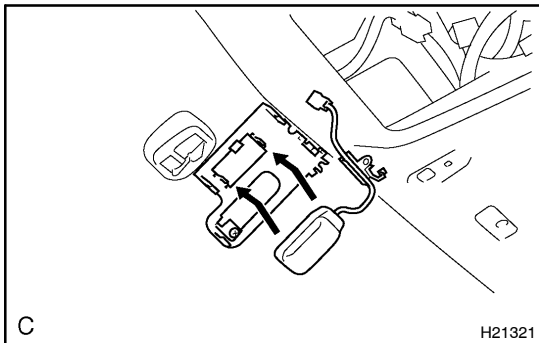
NOTICE:

- **Make sure that no dust nor fingerprint is not on the sheet surface.**
- **Stick the sheet so as not come out from the placing face.**

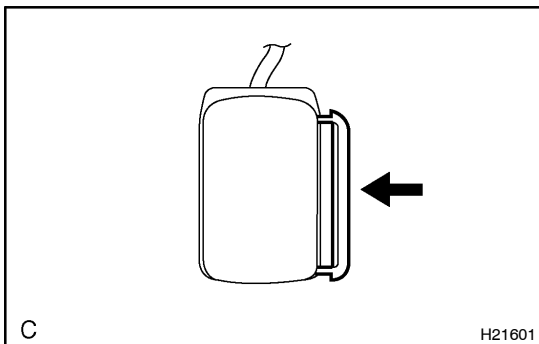
(b) Install the rain sensor.

NOTICE:

- **If reusing the windshield:**
Check that the no rain sensor tape remains on the windshield after removing the rain sensor. In case the tape remains, remove completely.
- **Clean the glass surface with a cloth, etc.**



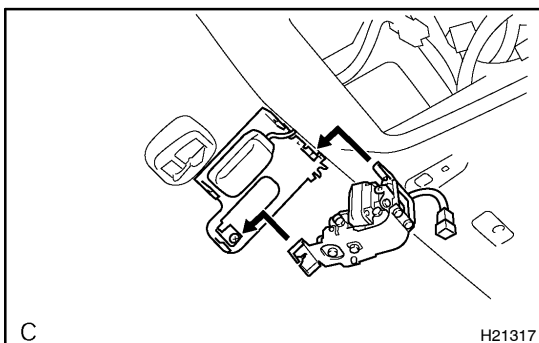
- (1) Peel the separation paper of the rain sensor tape.
- (2) Connect the connector and the rain sensor with screw.



- (3) Push the stopper.

HINT:

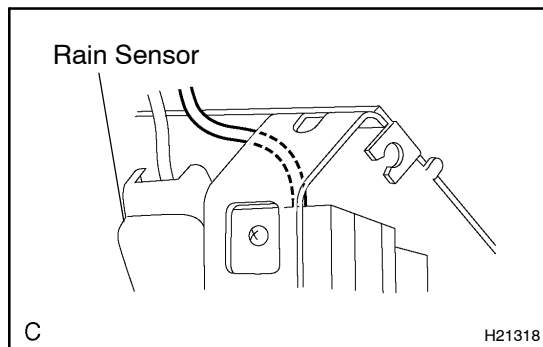
Install the rain sensor harness as it go through a hollow on the roof headlining.



19. w/ Night View:

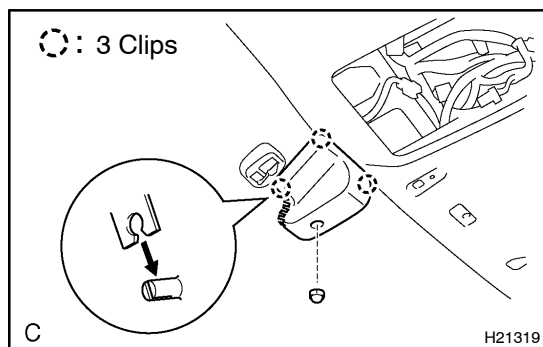
INSTALL NIGHT VIEW CAMERA

- (a) Install the night view camera by sliding it downward along the front glass, and then tighten the screw.

**NOTICE:**

Install the night view camera assembly as shown on the illustration.

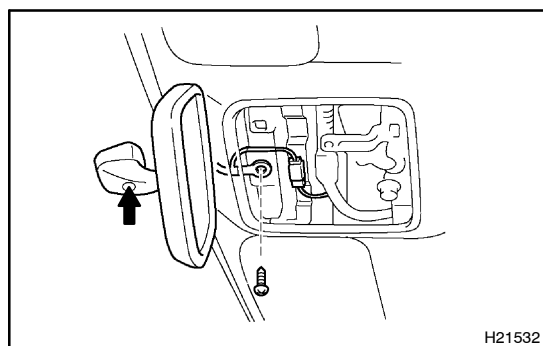
- (b) Connect the connector.
- (c) The adjustment of night view camera,
(See page [BE-97](#)).



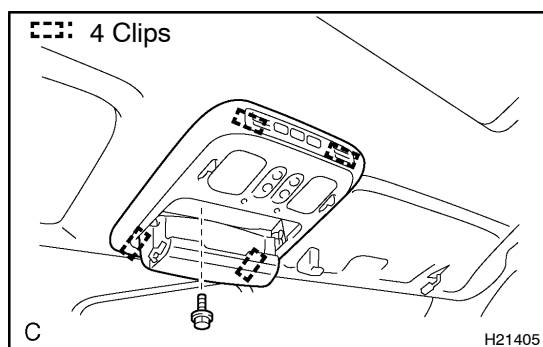
- (d) Install the night view cover and the nut.

NOTICE:

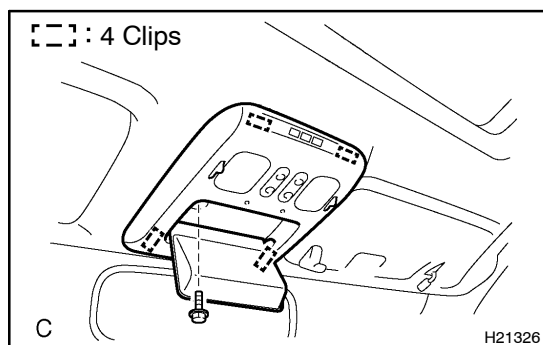
Do not pinch the night view harness and the rain sensor harness in the night view cover. Let them through a hole on the side of the night view cover.

**20. INSTALL INNER REAR VIEW MIRROR**

- (a) Install the inner rear view mirror with the 2 screw.
- (b) Connect the connector.

21. INSTALL FRONT PART OF ROOF HEADLINING**22. INSTALL OVERHEAD CONSOLE BOX**

- (a) Connect the connector and the overhead console box.
- (b) Install the overhead console box with the bolt.

**23. w/ LEXUS Link System:****INSTALL OVERHEAD CONSOLE BOX**

- (a) Connect the connector and the overhead console box.
- (b) Install the overhead console box with bolt.

24. INSTALL HOLDERS

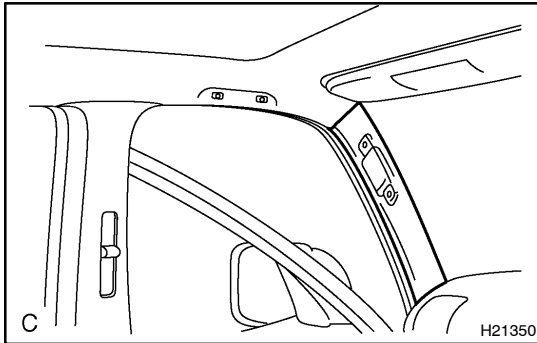
Install the 2 holders with the 2 screws.

25. INSTALL DOUBLE VISORS

Install the 2 double visors with the 4 screws.

26. INSTALL SUN VISORS

- (a) Install the 2 sun visors with the 4 screws, then connect the connectors.
- (b) Install the 2 caps.

27. INSTALL FRONT DOOR OPENING TRIMS**28. INSTALL FRONT PILLAR GARNISH**

- (a) Install the front pillar garnish.
- (b) Use the same manner described above to the other side.

29. INSTALL ASSIST GRIPS

- (a) Install the 2 assist grips with the 4 screws, then install the 4 assist grip plugs.
- (b) Use the same manner described above to the other side.