TOYOTA SERVICE BULLETIN

Group: 08 No.: 04 Date: Mar, 15

LandCruiser 200

Corrections to Repair Manual RM19U1E

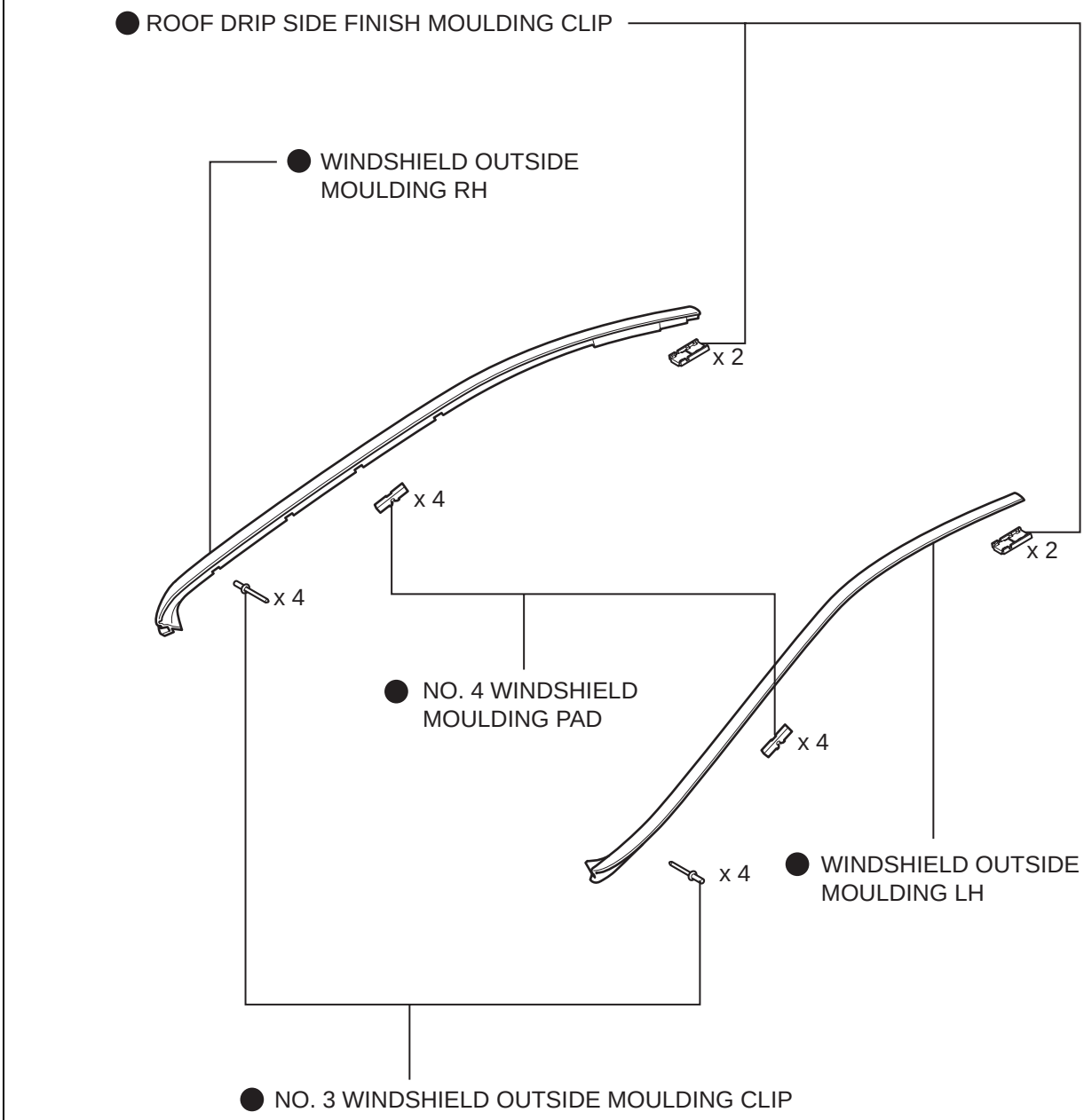
Please ensure these pages are distributed to all relevant staff for their information; and a copy made available for future reference, with the above repair manual.

Section	Title	Paragraph
WINDOW / GLASS	WINDSHIELD GLASS	COMPONENTS
		REMOVAL (2011/09-2012/01)
		REMOVAL (2012/01-)
		INSTALLATION (2011/09-2012/01)
		INSTALLATION (2012/01-)

The revised pages listed above are attached.
(The corrected parts are indicated by arrows.)

This Bulletin does not cause the Flat Rate Manual to be changed.

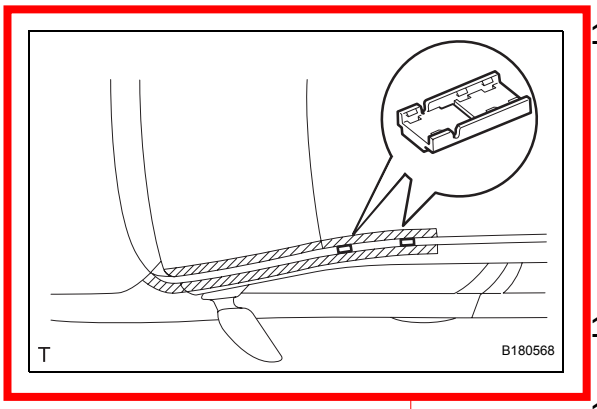
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[Corrected]

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(d) Using a vacuum cleaner, remove the No. 3 windshield outside moulding clip fragments and shavings from the drilled areas.
HINT:
Use the same procedure to remove the clip(s) on the other side.



[Deleted]

12. **REMOVE ROOF DRIP SIDE FINISH MOULDING CLIP**
HINT:
Perform the following procedures if replacing any roof drip side finish moulding clip.
(a) Remove the roof drip side finish moulding clips.
HINT:
Use the same procedure to remove the clip on the other side.

13. **REMOVE FRONT ASSIST GRIP SUB-ASSEMBLY (See page)**

14. **REMOVE FRONT PILLAR GARNISH LH (See page)**

15. **REMOVE FRONT PILLAR GARNISH RH (See page)**

16. **REMOVE MAP LIGHT ASSEMBLY (See page)**

17. **REMOVE VISOR BRACKET COVER (See page)**

18. **REMOVE VISOR ASSEMBLY LH (See page)**

19. **REMOVE VISOR ASSEMBLY RH (See page)**

20. **REMOVE VISOR HOLDER (See page)**

21. **REMOVE CENTER VISOR ASSEMBLY LH (w/ Sub Visor) (See page)**

22. **REMOVE CENTER VISOR ASSEMBLY RH (w/ Sub Visor) (See page)**

23. **REMOVE INNER REAR VIEW MIRROR STAY HOLDER COVER (w/ EC Mirror) (See page)**

24. **REMOVE INNER REAR VIEW MIRROR ASSEMBLY (w/ EC Mirror) (See page)**

25. **REMOVE INNER REAR VIEW MIRROR ASSEMBLY (w/o EC Mirror) (See page)**

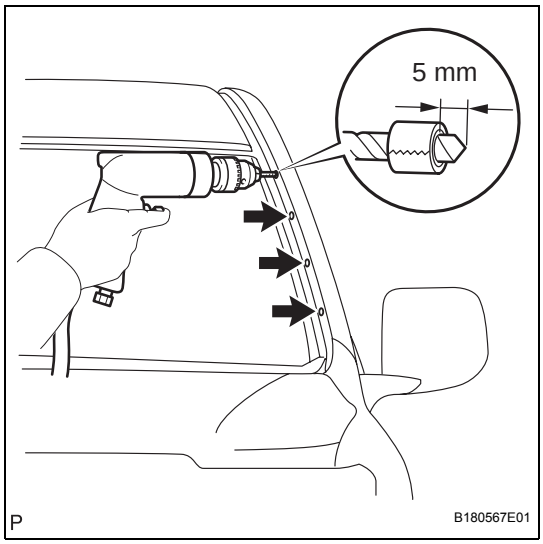
26. **REMOVE RAIN SENSOR COVER (w/ Rain Sensor) (See page)**

27. **REMOVE RAIN SENSOR (w/ Rain Sensor) (See page)**

28. **REMOVE ROOF HEADLINING**
(a) w/ Sliding Roof:
(1) Partially remove the roof headlining.
HINT:
It is not necessary to completely remove the roof headlining. Slightly lower the front section of the roof headlining so that the windshield glass can be removed in a later step.
Refer to the following procedures (See page ○○-○○).

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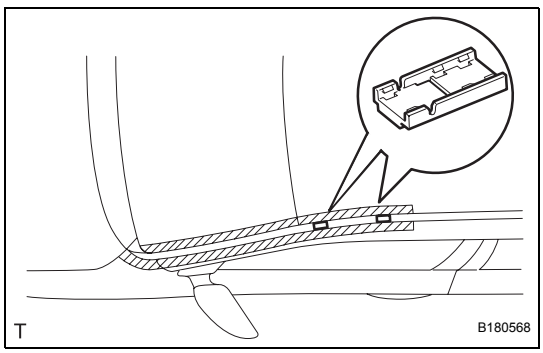
(b) Wind tape around the drill bit approximately 5 mm (0.197 in.) from the tip of the drill.
HINT:
Tape the 4 mm (0.157 in.) drill bit to prevent the drill bit from going too deep.



(c) Lightly press the drill against the No. 3 windshield outside moulding clip(s), drill off the flanges of the No. 3 windshield outside moulding clip(s), and remove the No. 3 windshield outside moulding clip(s).
NOTICE:
- **Pressing the drill too firmly will cause the No. 3 windshield outside moulding clip to turn and result in the No. 3 windshield outside moulding clip not being drilled through.**
- **Do not pry the No. 3 windshield outside moulding clips with the drill, because this may cause damage to the installation holes of the No. 3 windshield outside moulding clips or the drill bit.**

NOTICE:
Be careful of the drilled No. 3 windshield outside moulding clips as they may become hot.

(d) Using a vacuum cleaner, remove the No. 3 windshield outside moulding clip fragments and shavings from the drilled areas.
HINT:
Use the same procedure to remove the clip(s) on the other side.

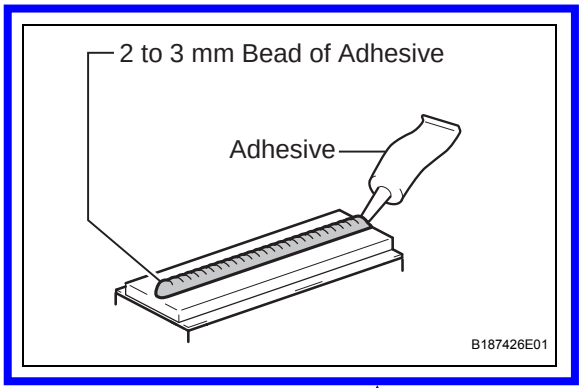


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13. **REMOVE ROOF DRIP SIDE FINISH MOULDING CLIP**
HINT:
Perform the following procedures if replacing any roof drip side finish moulding clip.
(a) Remove the roof drip side finish moulding clips.
HINT:
Use the same procedure to remove the clip on the other side.

14. **REMOVE FRONT ASSIST GRIP SUB-ASSEMBLY (See page)**
15. **REMOVE FRONT PILLAR GARNISH LH (See page)**
16. **REMOVE FRONT PILLAR GARNISH RH (See page)**
17. **REMOVE MAP LIGHT ASSEMBLY (See page)**
18. **REMOVE VISOR BRACKET COVER (See page)**
19. **REMOVE VISOR ASSEMBLY LH (See page)**
20. **REMOVE VISOR ASSEMBLY RH (See page)**
21. **REMOVE VISOR HOLDER (See page)**
22. **REMOVE CENTER VISOR ASSEMBLY LH (w/ Sub Visor) (See page)**

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[Corrected]

25. INSTALL ROOF DRIP SIDE FINISH MOULDING CLIP

HINT:

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

NOTICE:

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

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

HINT:

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

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

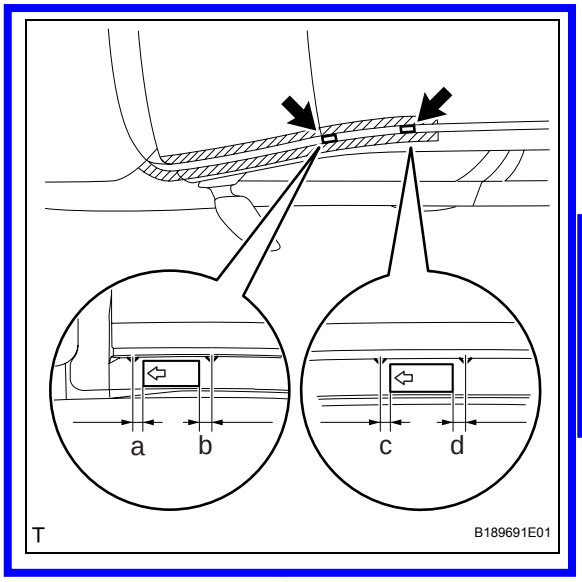
NOTICE:

Do not let the primer dry.

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

Standard

Area	Specified Condition
a	2.5 to 12.5 mm (0.0984 to 0.492 in.)
b	6.5 to 16.5 mm (0.256 to 0.650 in.)
c	0 to 6.0 mm (0 to 0.236 in.)
d	4.0 to 10.0 mm (0.157 to 0.394 in.)



[Corrected]

[Corrected]

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

HINT:

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

26. INSTALL NO. 3 WINDSHIELD OUTSIDE MOULDING CLIP

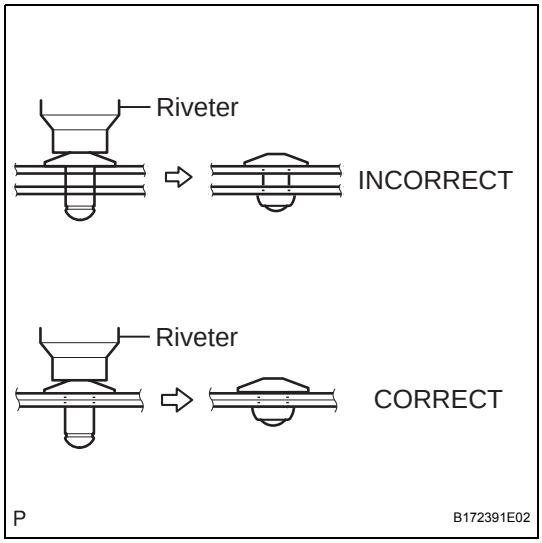
HINT:

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

(a) Install a nose piece to an air riveter or hand riveter.

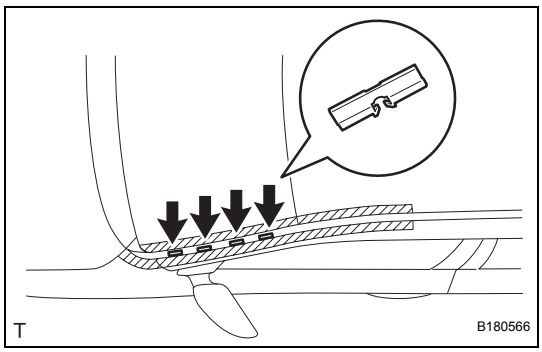
(b) Insert the mandrel part of a new No. 3 windshield outside moulding clip into the nose piece.

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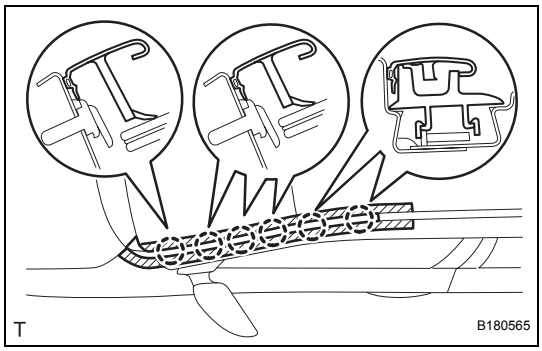
- **Do not leave any space between the moulding and body. Firmly hold together the 2 items while installing the rivet.**

WS



27. INSTALL NO. 4 WINDSHIELD MOULDING PAD

(a) Install the 4 new No. 4 moulding pads. [Added]
HINT:
Use the same procedure to install the 4 windshield moulding pads on the other side.



28. INSTALL WINDSHIELD OUTSIDE MOULDING LH

(a) Attach the 6 clips to install the new moulding.
(b) Remove the protective tape from the edges of the moulding. [Added]

29. INSTALL WINDSHIELD OUTSIDE MOULDING RH

HINT:
Use the same procedures described for the LH side.

30. INSTALL COWL TOP VENTILATOR LOUVER SUB-ASSEMBLY (See page)

31. INSTALL FRONT FENDER MAIN SEAL LH (See page)

32. INSTALL FRONT FENDER MAIN SEAL RH (See page)

33. INSTALL UPPER RADIATOR SUPPORT SEAL (See page)

34. CONNECT CABLE TO NEGATIVE BATTERY TERMINAL
NOTICE:
When disconnecting the cable, some systems need to be initialized after the cable is reconnected (See page ○○-○○).

35. INSTALL FRONT WIPER ARM LH (See page)

36. INSTALL FRONT WIPER ARM RH (See page)

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16. **INSTALL CENTER VISOR ASSEMBLY RH (See page)**
17. **INSTALL VISOR HOLDER (See page)**
18. **INSTALL VISOR ASSEMBLY LH (See page)**
19. **INSTALL VISOR ASSEMBLY RH (See page)**
20. **INSTALL VISOR BRACKET COVER (See page)**
21. **INSTALL MAP LIGHT ASSEMBLY (See page)**
22. **INSTALL FRONT PILLAR GARNISH LH (See page)**
23. **INSTALL FRONT PILLAR GARNISH RH (See page)**
24. **INSTALL FRONT ASSIST GRIP SUB-ASSEMBLY (See page)**
25. **INSTALL ROOF DRIP SIDE FINISH MOULDING CLIP**

HINT:

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

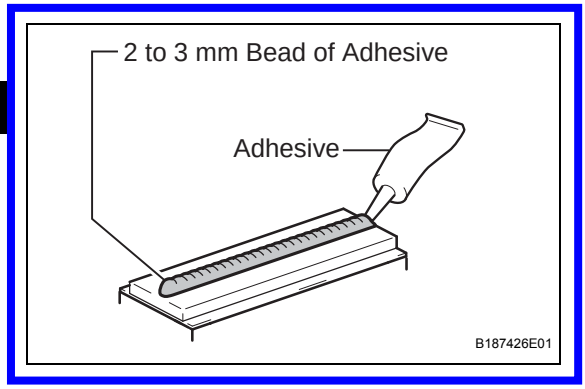
NOTICE:

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

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

HINT:

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



[Corrected]

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

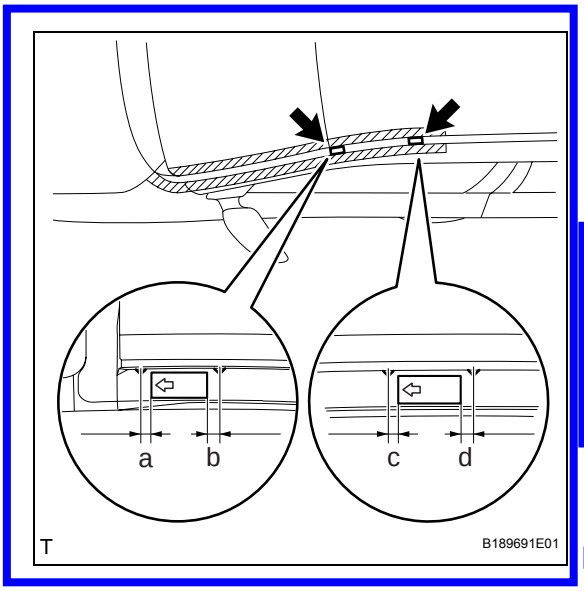
NOTICE:

Do not let the primer dry.

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

Standard

Area	Specified Condition
a	2.5 to 12.5 mm (0.0984 to 0.492 in.)
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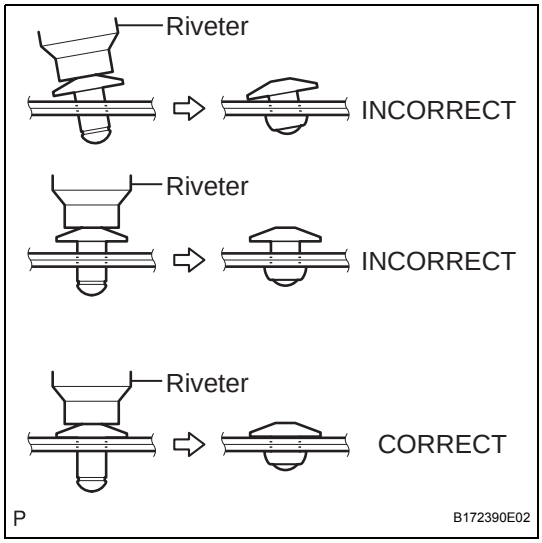
(d) Install the windshield outside moulding when 40 minutes or more have elapsed after pressing and installing the roof drip side finish moulding clip.

[Corrected]

HINT:

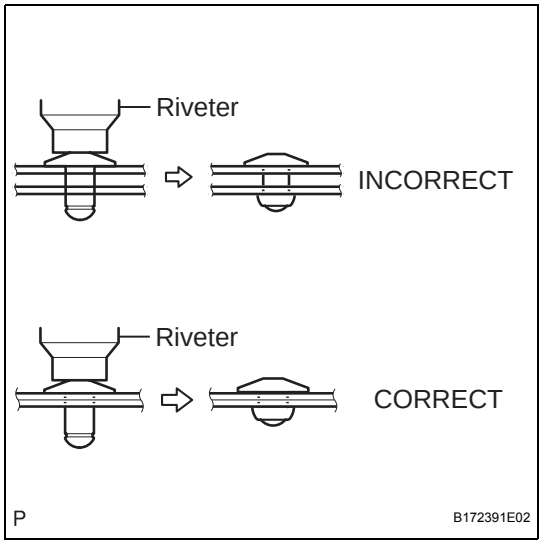
- Initial hardening time: 40 minutes
- Complete hardening time: 48 hours

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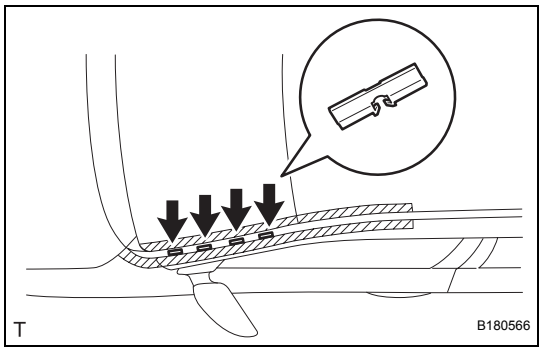


- **Confirm that the riveter are seated properly against the moulding.**
- **Do not tilt the riveter when installing the rivet to the moulding.**
- **Do not leave any space between the rivet head and moulding.**

WS

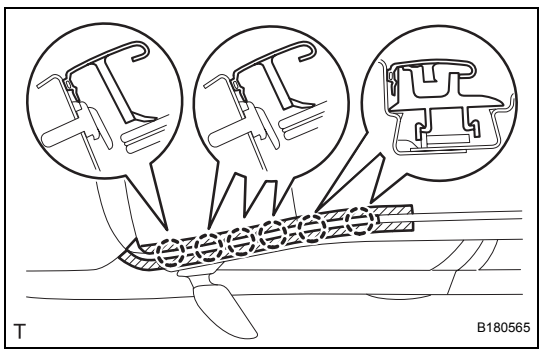


- **Do not leave any space between the moulding and body. Firmly hold together the 2 items while installing the rivet.**



27. INSTALL NO. 4 WINDSHIELD MOULDING PAD

(a) Install the 4 new No. 4 moulding pads. [Added]
HINT:
Use the same procedure to install the 4 windshield moulding pads on the other side.



28. INSTALL WINDSHIELD OUTSIDE MOULDING LH

(a) Attach the 6 clips to install the new moulding.
(b) Remove the protective tape from the edges of the moulding. [Added]

29. INSTALL WINDSHIELD OUTSIDE MOULDING RH

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

30. INSTALL COWL TOP VENTILATOR LOUVER SUB-ASSEMBLY (See page)

31. INSTALL FRONT FENDER MAIN SEAL LH (See page)

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