

## INSTALLATION

### 1. CLEAN AND SHAPE CONTACT SURFACE OF BODY

- Remove the damaged windshield glass seals.
- Using a knife, cut away any rough areas on the body.

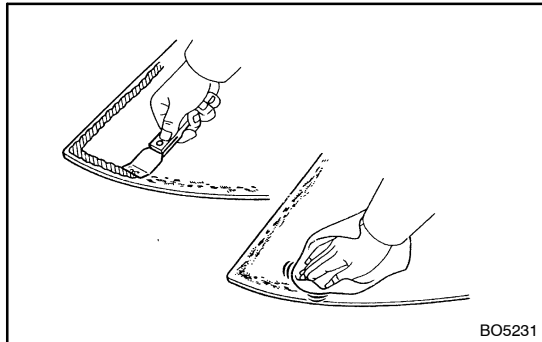
#### HINT:

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

- Clean the cutting surface of the adhesive with a piece of shop rag saturated in cleaner.

#### HINT:

Even if all the adhesive has been removed, clean the body.



### 2. CLEAN REMOVED GLASS

- Remove the damaged stoppers, retainers and dams.
- Using a scraper, remove the old adhesive sticking to the glass.

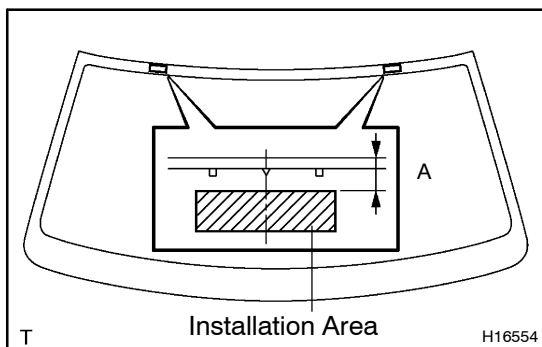
#### NOTICE:

**Be careful not to damage the glass.**

- Clean the glass with cleaner.

#### NOTICE:

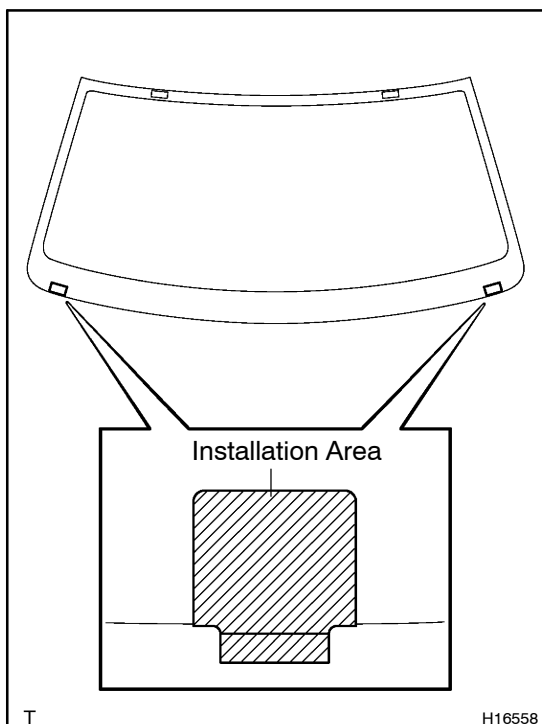
**Do not touch the glass after cleaning it.**



### 3. INSTALL NEW STOPPERS

- Clean the installation area.
- Attach new stoppers to the glass with the ceramic notch on the glass aligned with the new stoppers as shown in the illustration.

**A: 7.6 mm (0.299 in.)**



### 4. INSTALL NEW RETAINERS

- Clean the installation area.
- Attach new retainers to the glass with the ceramic notch on the glass aligned with the new retainers as shown in the illustration.

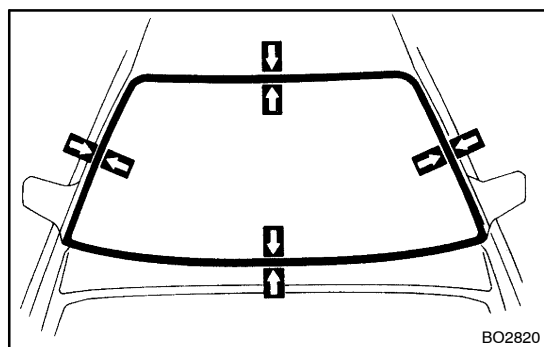
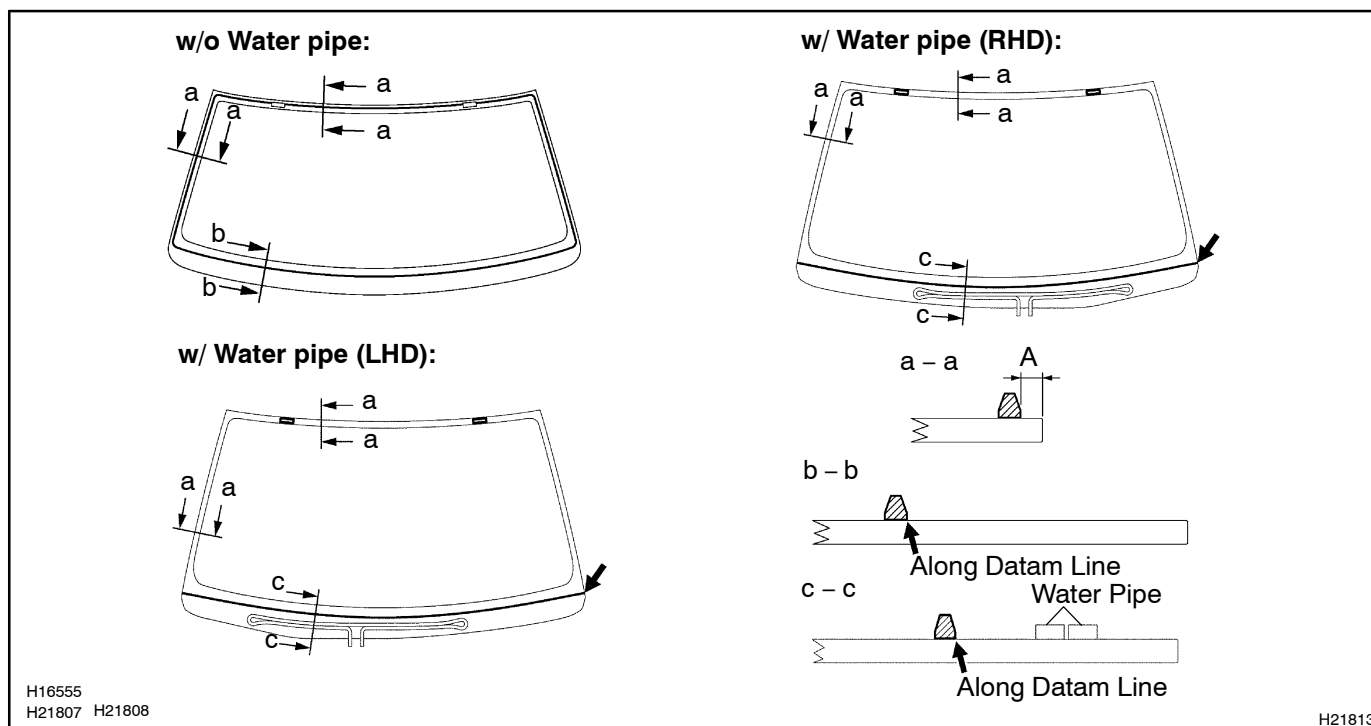
**5. INSTALL NEW DAMS**

Install new dams with double-stick tape as shown in the illustration.

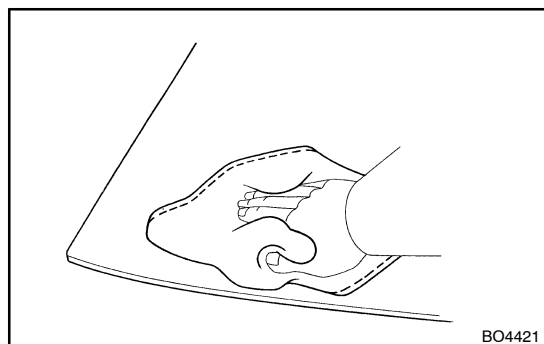
**A: 6 mm (0.24 in.)**

**NOTICE:**

**Do not touch the glass face after cleaning it.**

**6. POSITION GLASS**

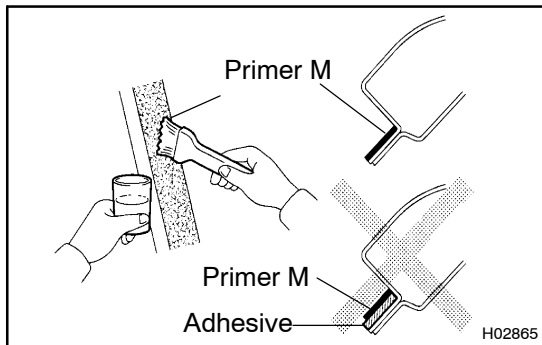
- Place the glass in the correct position.
- Check that all contacting parts of the glass rim are perfectly even.
- Place reference marks between the glass and body.
- Remove the glass.

**7. CLEAN CONTACT SURFACE OF GLASS**

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

**NOTICE:**

**Do not touch the glass face after cleaning it.**



## 8. 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:

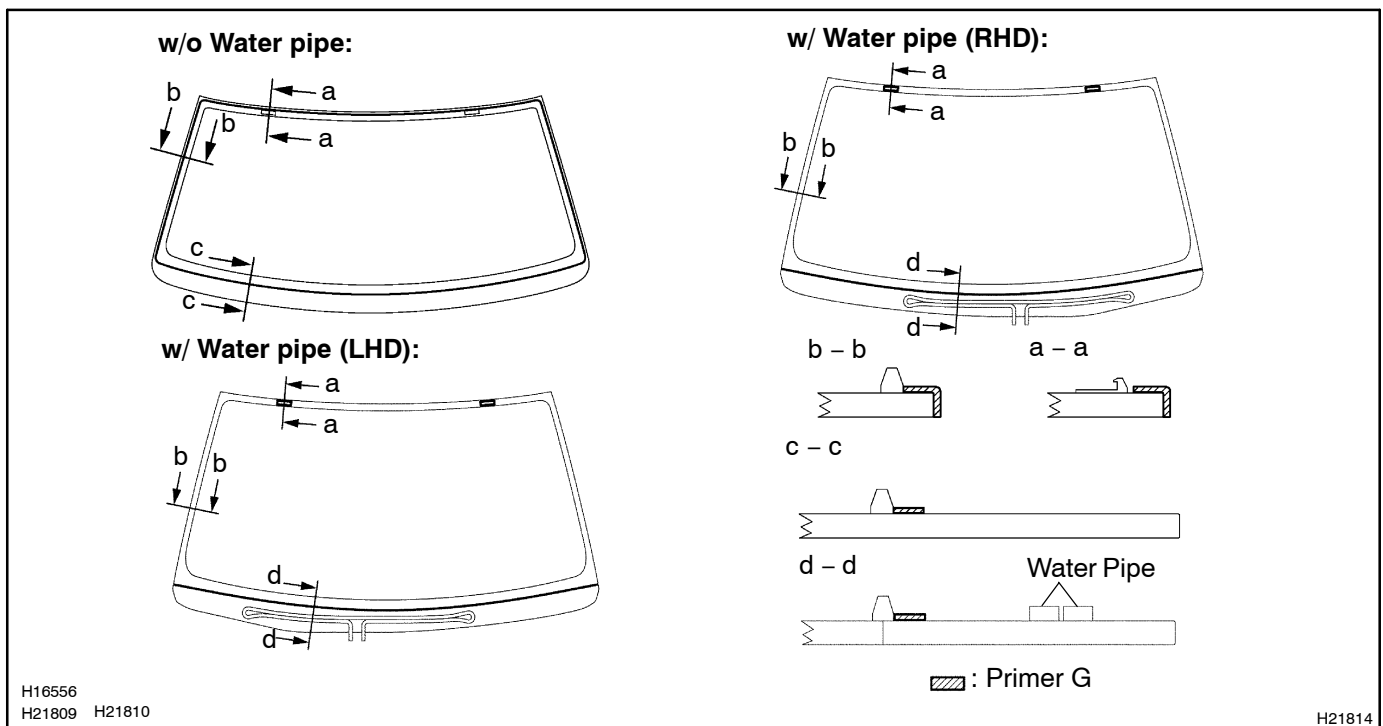
- Let the primer coating dry for 3 minutes or more.
- Do not coat Primer M to the adhesive.
- Do not keep any of the opened Primer M for later use.

## 9. 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.
- Before the primer dries, wipe it off with a clean shop rag.

### NOTICE:

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



**10. APPLY ADHESIVE**

(a) Cut off the tip of the cartridge nozzle.

**Part No. 08850-00801 or equivalent**

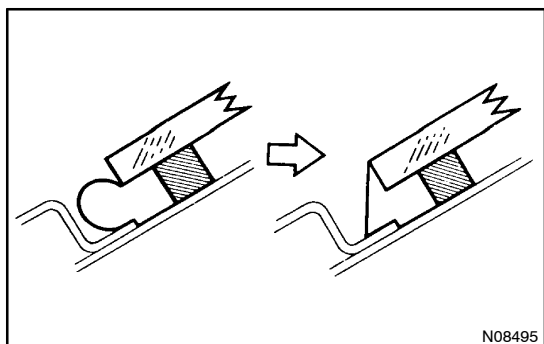
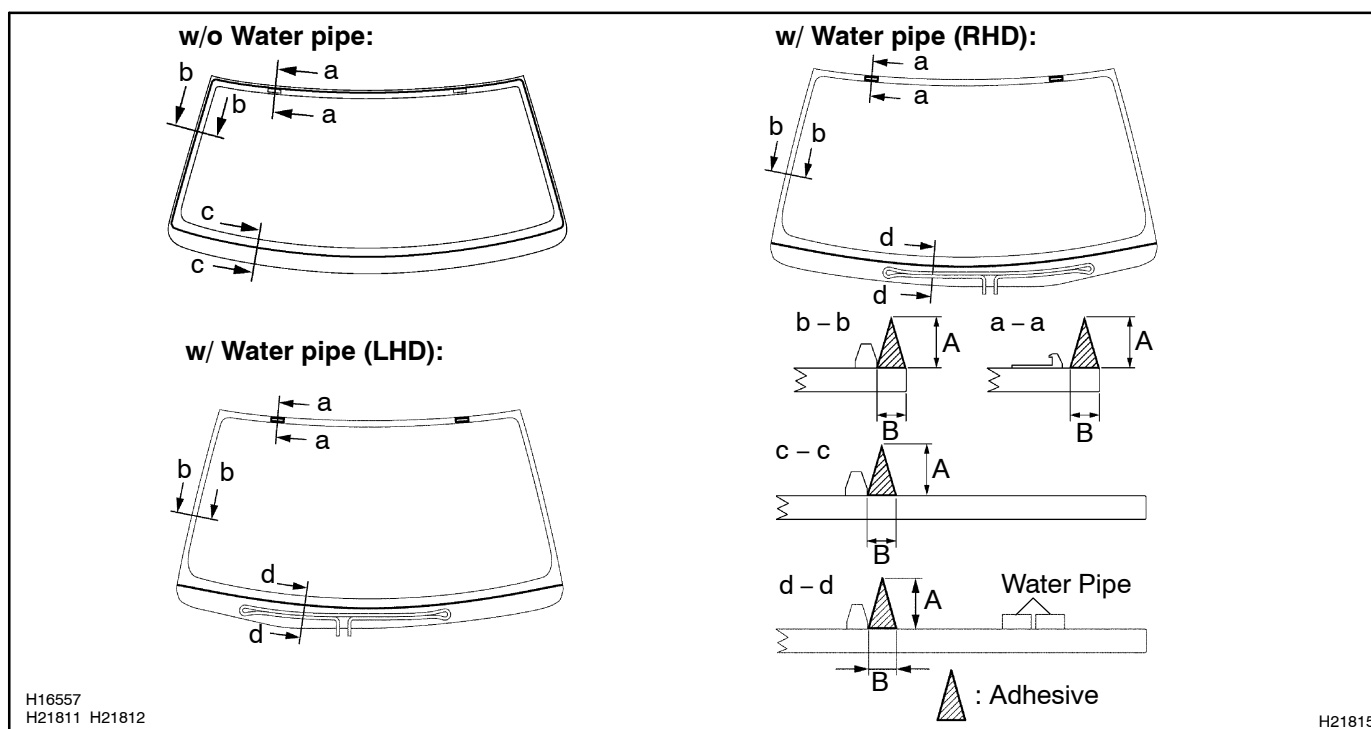
HINT:

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

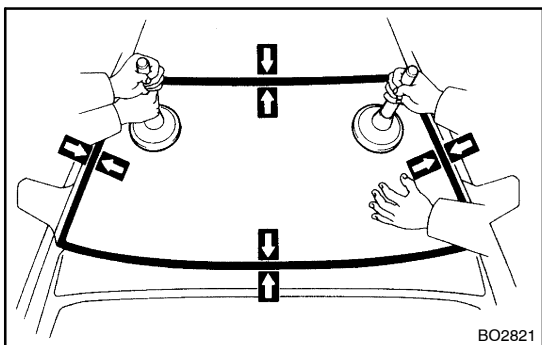
(b) Load the cartridge into the sealer gun.

(c) Coat the glass with adhesive as shown.

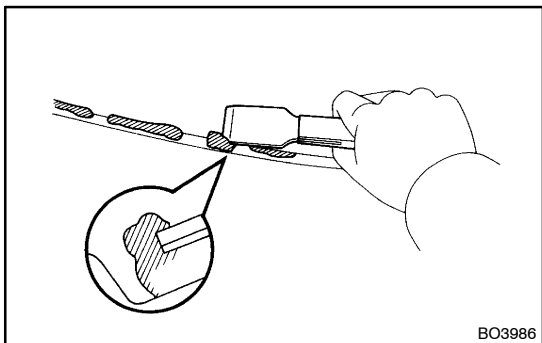
**A: 12.5 mm (0.492 in.)****B: 8.0 mm (0.315 in.)****11. INSTALL GLASS**

HINT:

Confirm that the dam is attached to the body panel as shown in the illustration.



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

**NOTICE:**

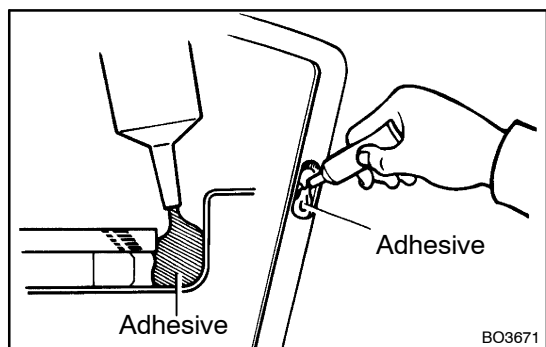
**Take care not to drive the vehicle during the time described in the table below.**

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

**12. INSPECT FOR LEAK AND REPAIR**

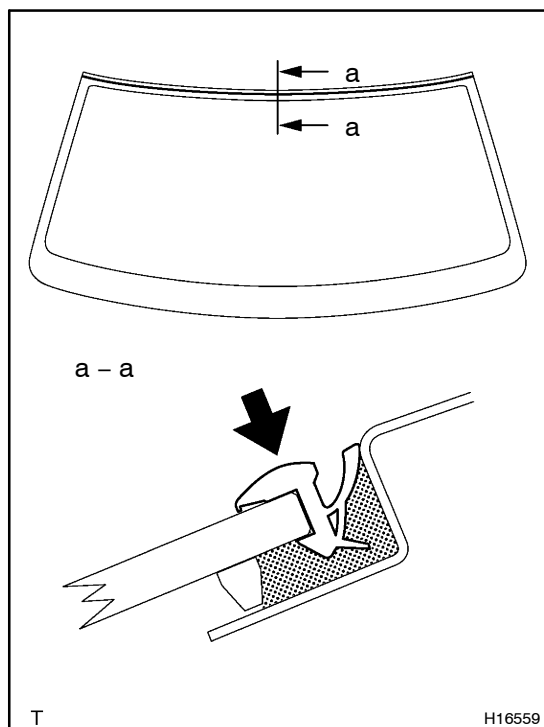
- (a) Conduct a leak test after the hardening time has elapsed.
- (b) Seal any leak with sealant.

**Part No. 08833-00030 or equivalent**

**13. APPLY ADHESIVE TO MOULDING INSTALLATION AREA**

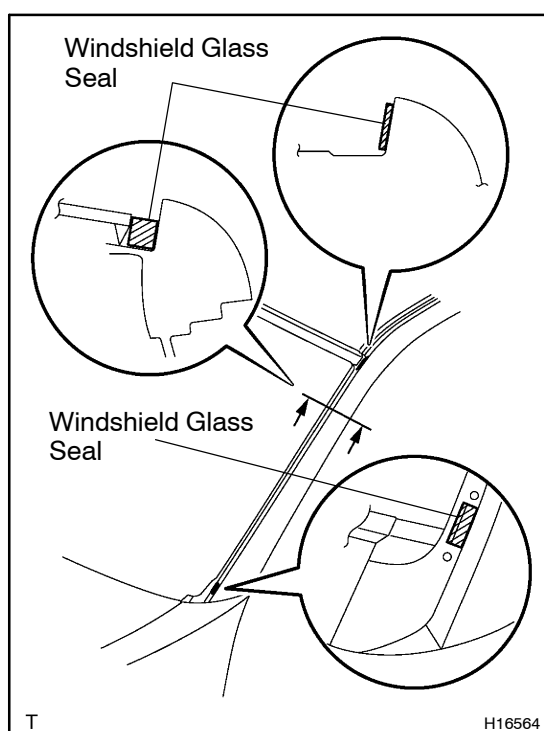
Apply adhesive to the moulding installation area between the glass and the body.

**Part No. 08833-00030 or equivalent**



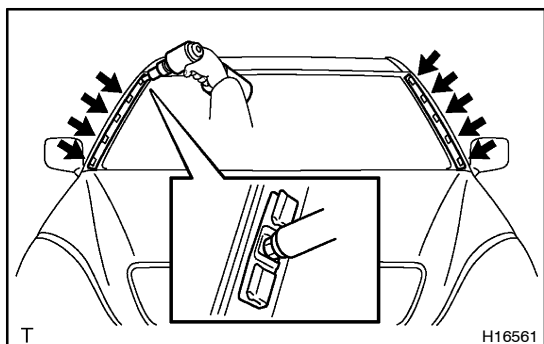
#### 14. INSTALL NEW WINDSHIELD UPPER MOULDING

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



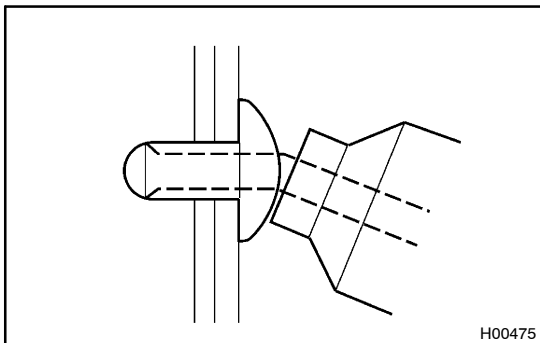
#### 15. INSTALL NEW WINDSHIELD GLASS SEAL

- Clean the installation areas.
- Attach new windshield glass seal as shown in the illustration.
- Employ the same manner described above to the other side.



#### 16. INSTALL WINDSHIELD OUTSIDE MOULDING CLIPS

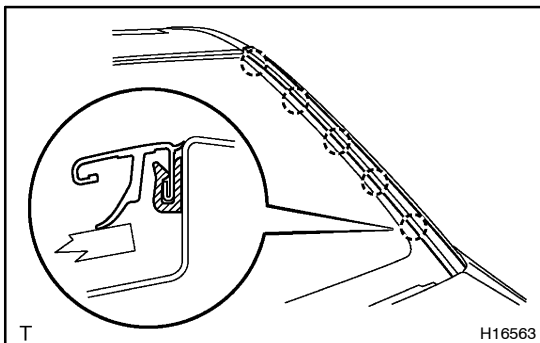
Using an air riveter with nose piece, strike rivets into the body panel to install the windshield outside moulding clips to the body panel as shown in the illustration.



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**NOTICE:**

If the rivet is not positioned perpendicularly it will bend the mandrel. When the trigger is then pulled, it may damage SST.



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**17. INSTALL WINDSHIELD OUTSIDE MOULDING**

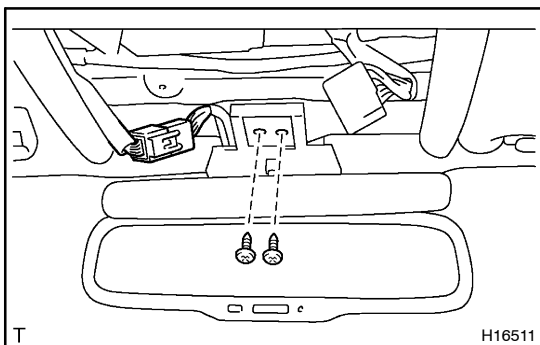
- (a) Install the windshield outside moulding as shown in the illustration.
- (b) Employ the same manner described above to the other side.

**18. INSTALL FRONT PORTION OF ROOF HEADLINING****19. INSTALL SUN VISOR HOLDERS**

Install the 2 sun visor holders with the 2 screws.

**20. INSTALL SUN VISORS**

- (a) Connect the connector.
- (b) Install the sun visor with the 2 screws.
- (c) Install the cap.
- (d) Employ the same manner described above to the other side.



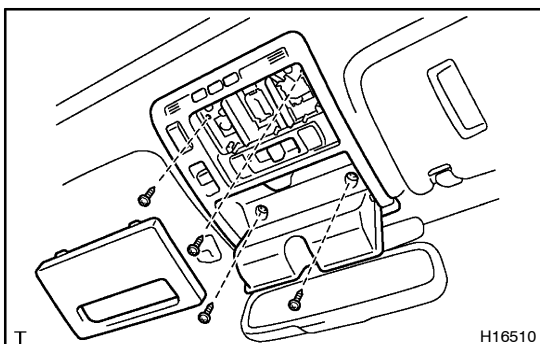
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**21. INSTALL INNER REAR VIEW MIRROR**

- (a) Connect the connector.
- (b) Set the connector to the body.
- (c) Install the inner rear view mirror with the 2 screws.

**Torque: 5.5 N·m (56 kgf·cm, 49 in.-lbf)**

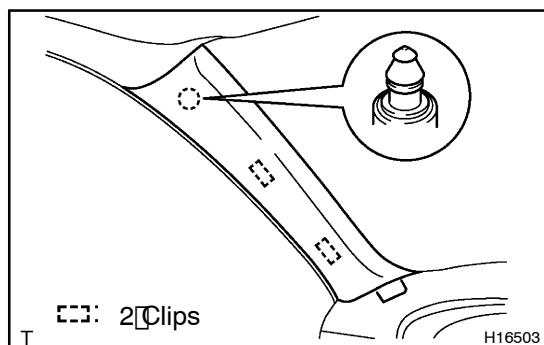


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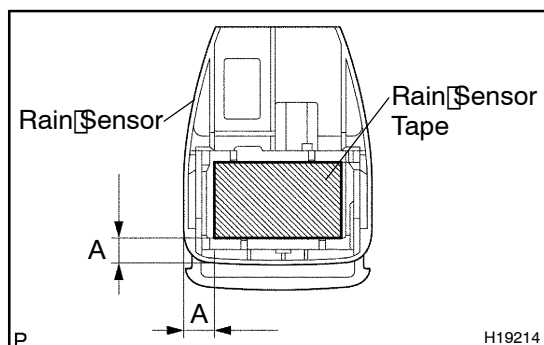
**22. INSTALL MAP LIGHT ASSEMBLY**

- (a) Connect the connector.
- (b) Install the map light assembly with the 4 screws.
- (c) Install the lens.
- (d) w/o LEXUS link system:  
Close the upper console.
- (e) w/ LEXUS link system:  
Close the control switch box.

**23. INSTALL FRONT PILLAR GARNISH****NOTICE:**

When install the front pillar garnish, replace new clip on the upper portion of front pillar garnish.

- (a) Install the front pillar garnish as shown in the illustration.
- (b) Employ the same manner described above to the other side.

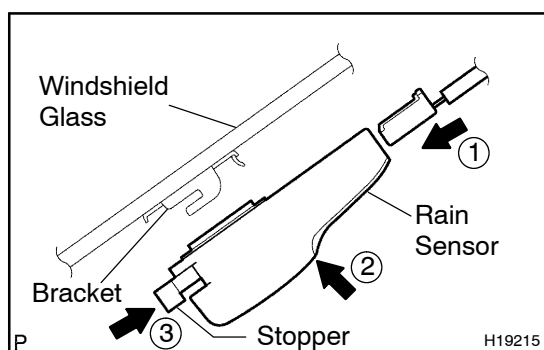
**24. w/ Rain sensor:****INSTALL RAIN SENSOR**

- (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 the new rain sensor tape on the lens surface 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 the tape.
- Clean the glass face with a cloth, etc.
  - (1) Connect the connector.
  - (2) Peel the separation paper of the rain sensor tape.
  - (3) Securely insert the rain sensor into the bracket.
  - (4) Push the stopper upward.

**25. w/ Water pipe:****CONNECT WATER PIPE****26. REFILL WITH ENGINE COOLANT (See page CO-2)****27. CHECK ENGINE COOLANT FOR LEAKS (See page CO-2)****28. INSTALL COWL TOP VENTILATOR LOUVER (See page BO-76)****29. INSTALL WIPER ARMS (See page BO-76)**