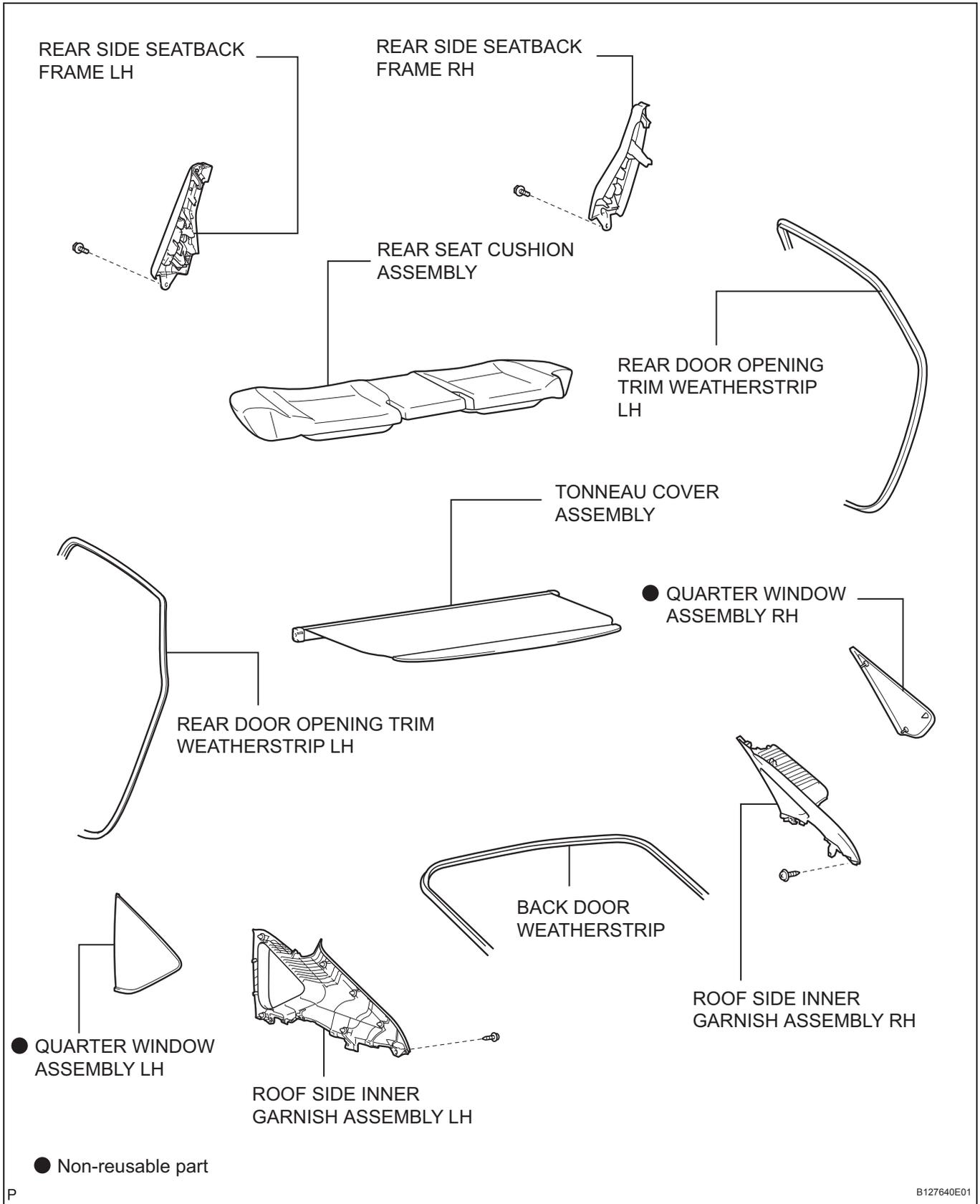
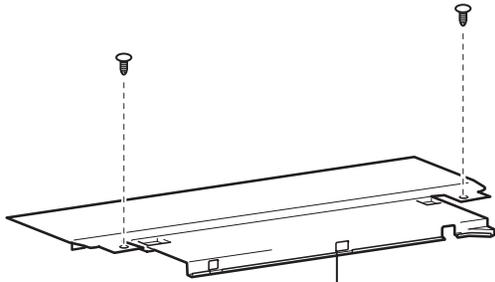


QUARTER WINDOW GLASS

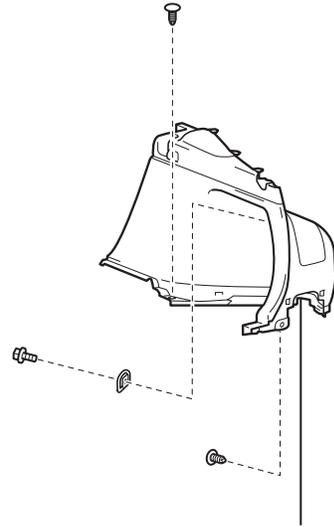
COMPONENTS



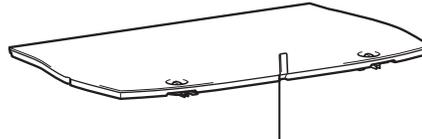
WS



REAR NO. 1 FLOOR BOARD



DECK TRIM SIDE PANEL ASSEMBLY RH



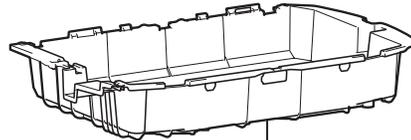
REAR NO. 2 FLOOR BOARD



REAR NO. 4 FLOOR BOARD



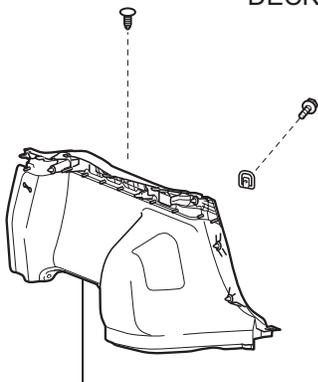
DECK FLOOR BOX LH



REAR DECK FLOOR BOX



REAR NO. 3 FLOOR BOARD



DECK TRIM SIDE PANEL ASSEMBLY LH



REAR DECK TRIM COVER

WS

REMOVAL

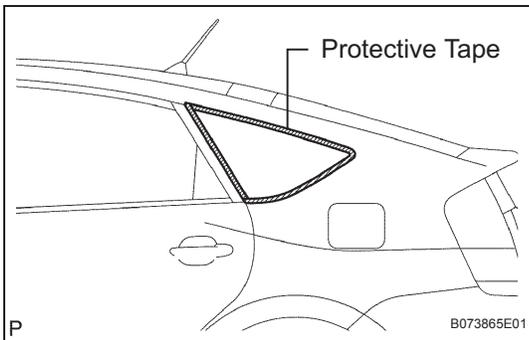
HINT:

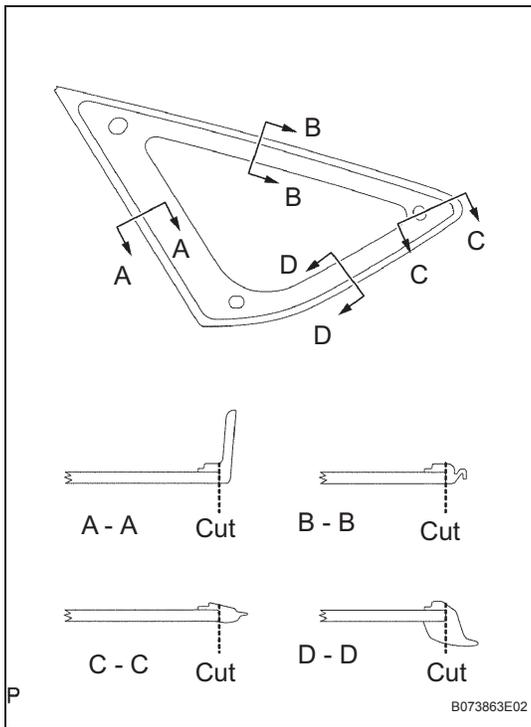
- Use the same procedures for the LH side and RH side.
- The procedures listed below are for the LH side.

1. REMOVE REAR SEAT CUSHION ASSEMBLY (See page [SE-15](#))
2. REMOVE REAR SIDE SEATBACK FRAME LH (See page [IR-9](#))
3. REMOVE REAR DOOR OPENING TRIM WEATHERSTRIP LH
4. REMOVE BACK DOOR WEATHERSTRIP
5. REMOVE TONNEAU COVER ASSEMBLY
6. REMOVE REAR NO. 2 FLOOR BOARD
7. REMOVE REAR NO. 3 FLOOR BOARD
8. REMOVE REAR NO. 4 FLOOR BOARD
9. REMOVE REAR DECK FLOOR BOX
10. REMOVE DECK FLOOR BOX LH
11. REMOVE REAR NO. 1 FLOOR BOARD (See page [IR-10](#))
12. REMOVE REAR DECK TRIM COVER (See page [IR-10](#))
13. REMOVE DECK TRIM SIDE PANEL ASSEMBLY LH (See page [IR-11](#))
14. REMOVE ROOF SIDE INNER GARNISH ASSEMBLY LH (See page [IR-11](#))
15. REMOVE QUARTER WINDOW ASSEMBLY LH
 - (a) Apply protective tape to the outer surface of the vehicle body to prevent scratches.

NOTICE:

When removing the quarter window glass from the vehicle, be careful not to damage the vehicle's paint or interior/exterior ornaments.





- (b) Using a knife, cut off the moulding as shown in the illustration.

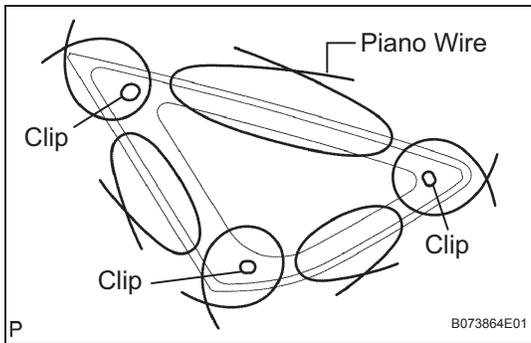
NOTICE:

Be careful not to damage the vehicle body with the knife.

- (c) Remove the remaining moulding.

HINT:

Make a partial cut in the moulding. Then pull and remove it by hand.



- (d) From the interior, insert a piano wire between the vehicle body and the quarter window glass as shown in the illustration.

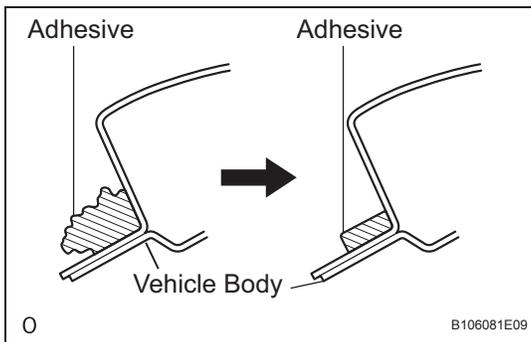
- (e) Tie objects that can serve as handles (for example, wooden blocks) to both wire ends.

- (f) Cut through the adhesive by pulling the piano wire around the quarter window glass.

NOTICE:

Leave as much adhesive on the vehicle body as possible when removing the quarter window glass.

- (g) Using suction cups, remove the quarter window glass.



16. CLEAN VEHICLE BODY

- (a) Clean and shape the contact surface of the vehicle body.

- (1) On the contact surface of the vehicle body, use a knife to cut away excess adhesive as shown in the illustration.

HINT:

Leave as much adhesive on the vehicle body as possible.

NOTICE:

Be careful not to damage the vehicle body.

- (2) Clean the contact surface of the vehicle body with cleaner.

HINT:

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

INSTALLATION

HINT:

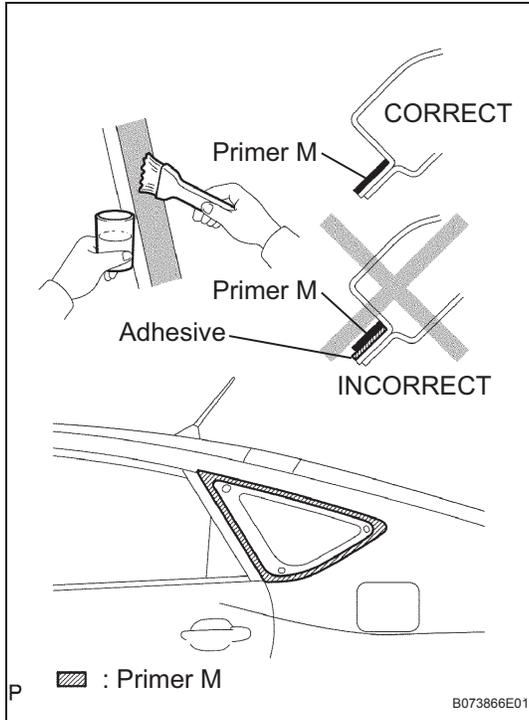
- Use the same procedures for the LH side and RH side.
- The procedures listed below are for the LH side.
- A bolt without a torque specification is shown in the standard bolt chart (see page [SS-2](#)).

1. INSTALL QUARTER WINDOW ASSEMBLY LH

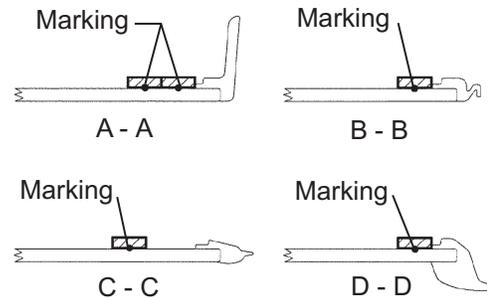
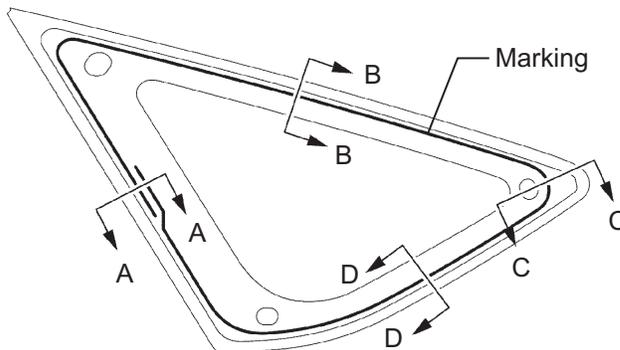
- (a) Using a brush or sponge, apply primer M to the exposed part of the vehicle body.

NOTICE:

- **Allow the primer coating to dry for 3 minutes or more.**
 - **Throw away any leftover primer.**
 - **Do not apply too much primer.**
- (b) Using a brush or sponge, apply primer G to the contact surface of the glass.



Backside



P

: Primer G

B073867E01

HINT:

If primer is applied to an area that is specified, wipe off the primer with white gasoline before it dries.

NOTICE:

- **Allow the primer to dry for 3 minutes or more.**
- **Throw away any leftover primer.**
- **Do not apply too much primer.**

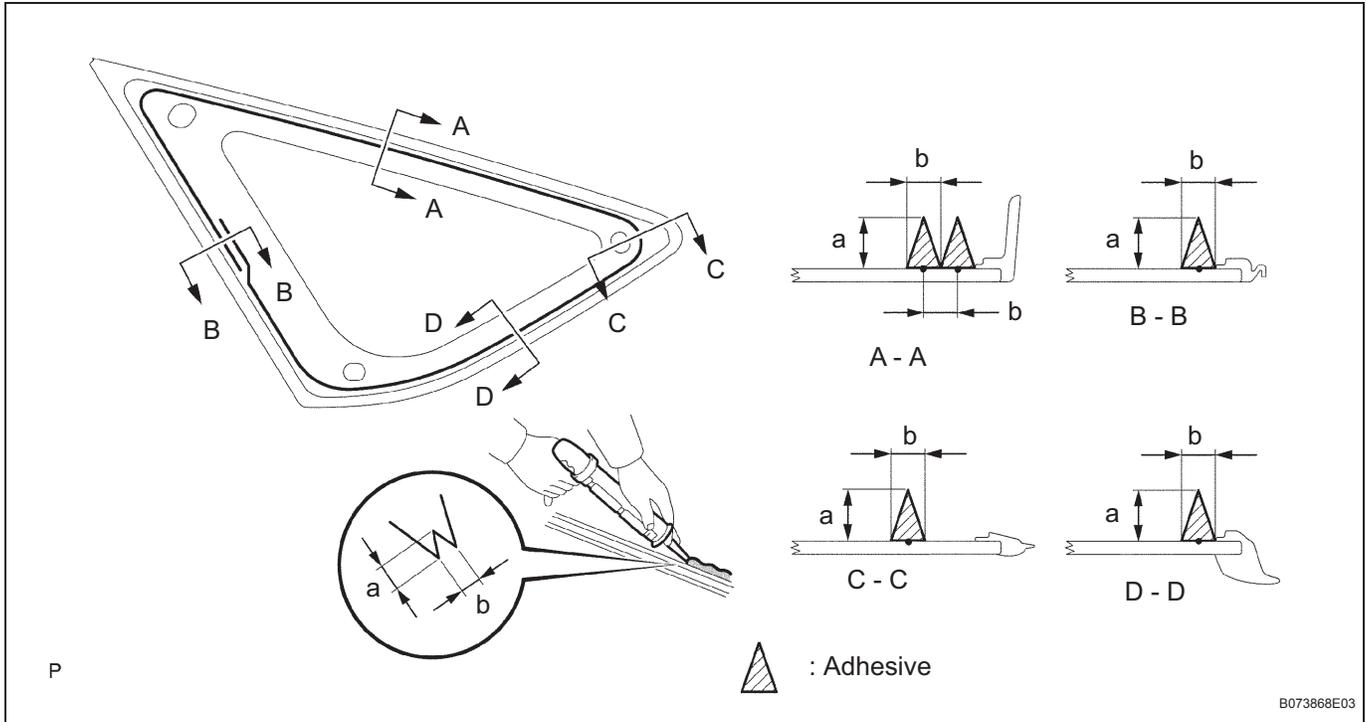
WS

(c) Apply adhesive to the quarter window glass.

Adhesive:

Toyota Genuine Windshield Glass Adhesive or Equivalent

(1) Cut off the tip of the cartridge nozzle as shown in the illustration.



Standard measurement

Area	Specified Condition
a	12.0 mm (0.472 in.)
b	8.0 mm (0.315 in.)

HINT:

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

Usage time frame

Temperature	Usage Time Frame
35°C (95°F)	15 minutes
20°C (68°F)	1 hour 40 minutes
5°C (41°F)	8 hours

(2) Load the sealer gun with the cartridge.

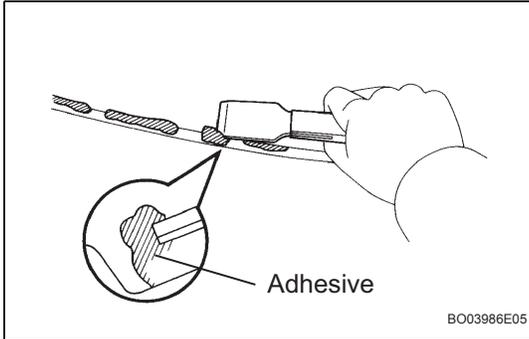
(3) Apply adhesive to the quarter window glass as shown in the illustration.

(d) Install the quarter window glass to the vehicle body.

(1) Hold the quarter window glass in place securely with protective tape or equivalent until the adhesive hardens.

NOTICE:

- Allow the primer coating to dry for 3 minutes or more.
- Check that the clips are attached to the body correctly.



- **Check the clearance between the body and glass.**

- (2) Lightly press the front surface of the glass to ensure a close fit.
- (3) Using a scraper, remove any excess or protruding adhesive.

HINT:

Apply adhesive onto the glass rim.

NOTICE:

Do not drive the vehicle within the time written in the table below.

Minimum time

Temperature	Minimum time prior to driving vehicle
35°C (95°F)	1 hour 30 minutes
20°C (68°F)	5 hours
5°C (41°F)	24 hours

2. **INSTALL ROOF SIDE INNER GARNISH ASSEMBLY LH (See page [IR-15](#))**
3. **INSTALL DECK TRIM SIDE PANEL ASSEMBLY LH (See page [IR-15](#))**
4. **INSTALL REAR DECK TRIM COVER (See page [IR-16](#))**
5. **INSTALL REAR NO. 1 FLOOR BOARD (See page [IR-16](#))**
6. **INSTALL DECK FLOOR BOX LH**
7. **INSTALL REAR DECK FLOOR BOX**
8. **INSTALL REAR NO. 4 FLOOR BOARD**
9. **INSTALL REAR NO. 3 FLOOR BOARD**
10. **INSTALL REAR NO. 2 FLOOR BOARD**
11. **INSTALL TONNEAU COVER ASSEMBLY**
12. **INSTALL BACK DOOR WEATHERSTRIP**
13. **INSTALL REAR DOOR OPENING TRIM WEATHERSTRIP LH**
14. **INSTALL REAR SIDE SEATBACK FRAME LH (See page [IR-17](#))**
15. **INSTALL REAR SEAT CUSHION ASSEMBLY (See page [SE-23](#))**
16. **CHECK FOR LEAKS AND REPAIR**
 - (a) Conduct a leak test after the adhesive has completely hardened.
 - (b) Seal any leaks with auto glass sealer.