

<b>Last Modified:</b> 12-04-2024	6.11:8.1.0	<b>Doc ID:</b> RM1000000029ODF
<b>Model Year Start:</b> 2023	<b>Model:</b> Prius Prime	<b>Prod Date Range:</b> [12/2022 - ]
<b>Title:</b> WINDOW / GLASS: BACK DOOR GLASS: INSTALLATION; 2023 - 2024 MY Prius Prius Prime [12/2022 - ]		

## INSTALLATION

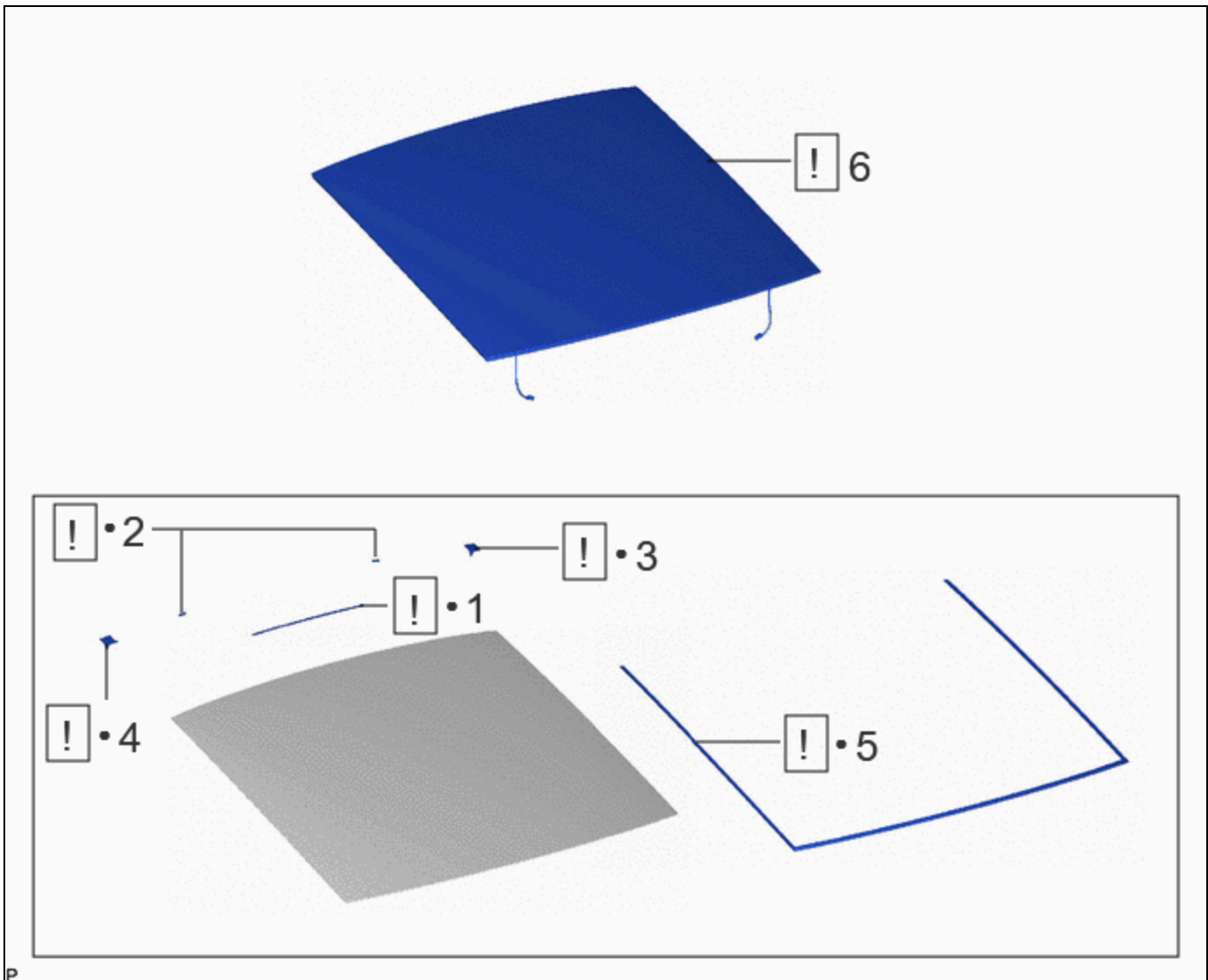
### CAUTION / NOTICE / HINT




#### **NOTICE:**

- Make sure to use Toyota Genuine Windshield Glass Adhesive (High Modulus Type) or an equivalent high modulus adhesive.
- After cutting off the old adhesive remaining on the adhesion surface, apply new adhesive within 2 hours.
- If the cut surface of the old adhesive is left exposed for a long time, the adhesion strength will be reduced, so apply the new adhesive quickly.

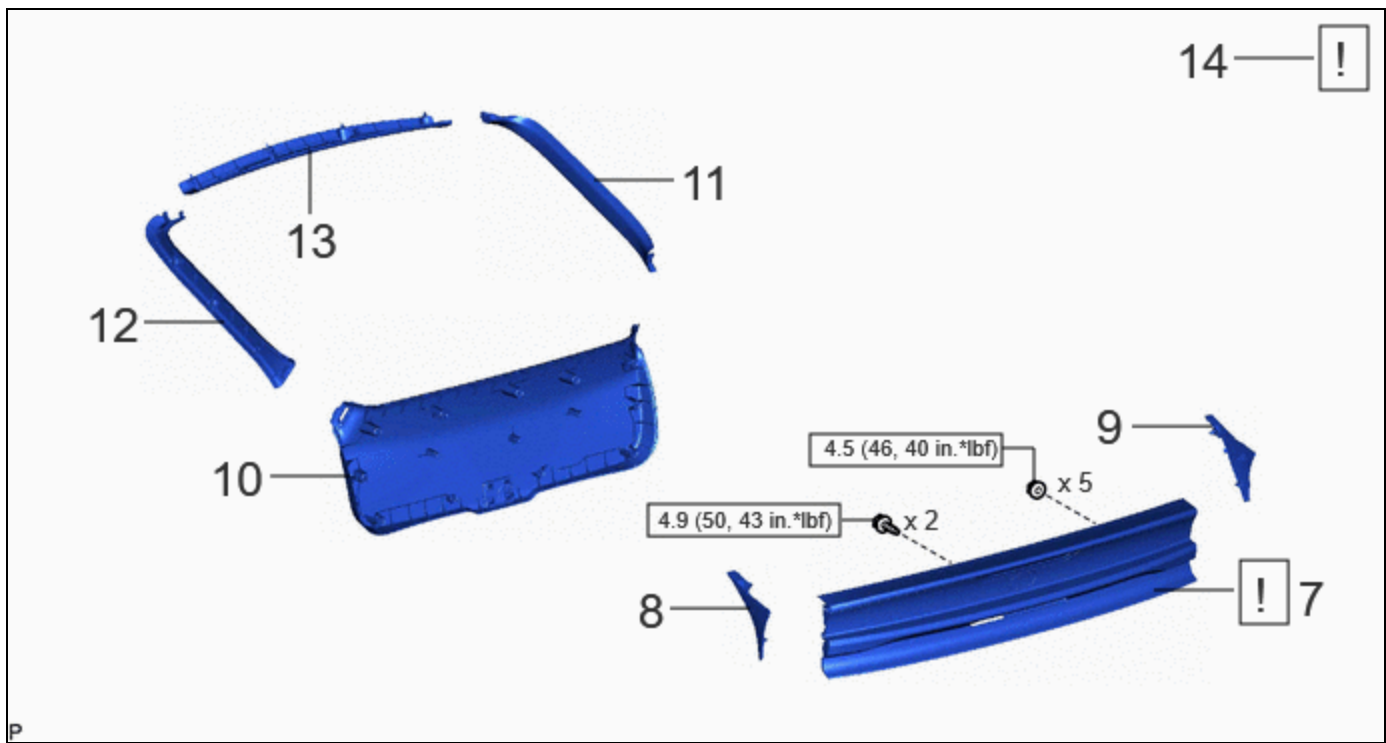
### CAUTION / NOTICE / HINT




#### **COMPONENTS (INSTALLATION)**







	PROCEDURE	PART NAME CODE			
1	BACK DOOR GLASS ADHESIVE DAM	68294A	<a href="#">INFO</a>	-	-
2	BACK DOOR GLASS SPACER	62785F	<a href="#">INFO</a>	-	-
3	NO. 1 BACK WINDOW GLASS SPACER	64818C	<a href="#">INFO</a>	-	-
4	NO. 2 BACK WINDOW GLASS SPACER	64819B	<a href="#">INFO</a>	-	-
5	BACK DOOR WINDOW MOULDING	75571F	<a href="#">INFO</a>	-	-
6	BACK DOOR GLASS	68131	<a href="#">INFO</a>	-	-

•	Non-reusable part	-	-
---	-------------------	---	---



	PROCEDURE	PART NAME CODE			
7	REAR LIGHT ASSEMBLY	-	<a href="#">INFO</a>	-	-
8	BACK DOOR OUTSIDE GARNISH LOWER MOULDING LH	76816	-	-	-
9	BACK DOOR OUTSIDE GARNISH LOWER MOULDING RH	76815	-	-	-
10	BACK DOOR TRIM BOARD ASSEMBLY	67750	-	-	-
11	BACK DOOR SIDE GARNISH RH	67937B	-	-	-
12	BACK DOOR SIDE GARNISH LH	67938A	-	-	-
13	BACK DOOR UPPER TRIM PANEL ASSEMBLY	64790B	-	-	-

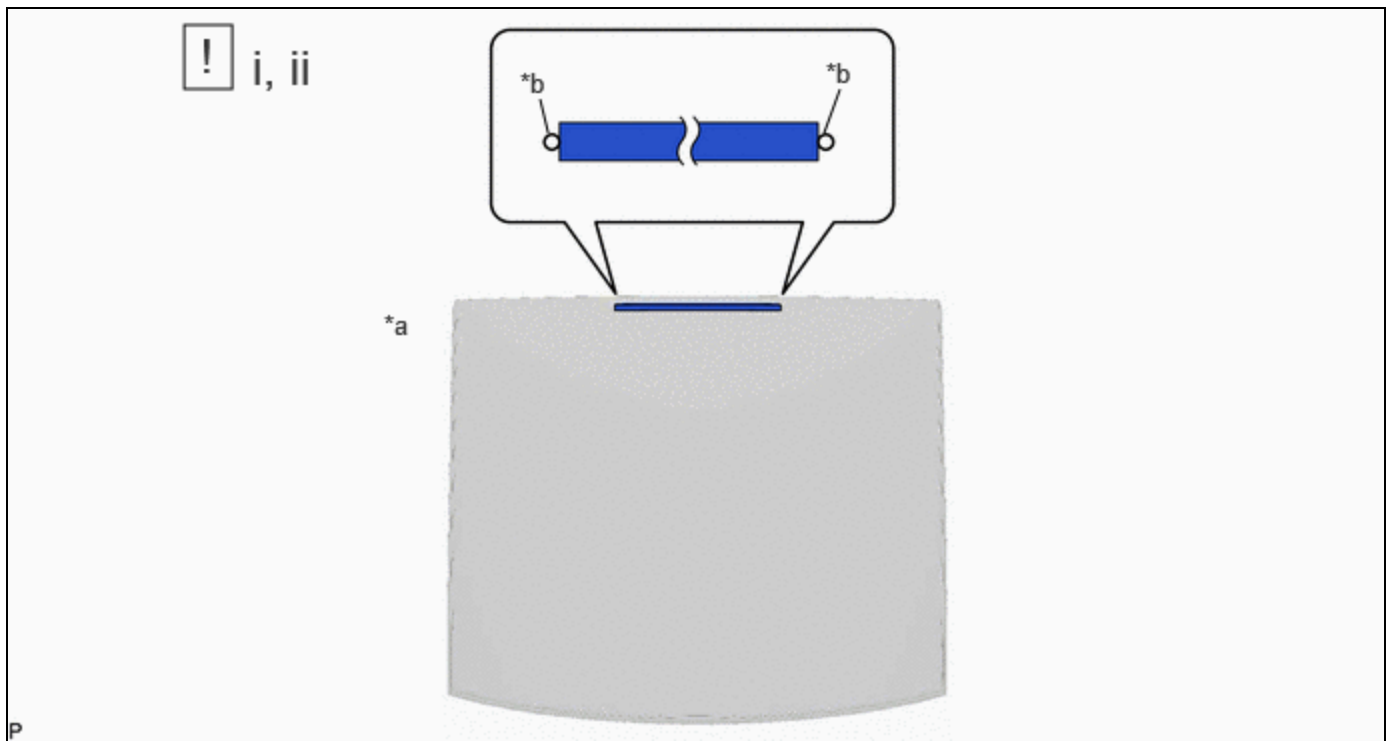
PROCEDURE		PART NAME CODE			
14	INSPECT FOR LEAK AND REPAIR	-	INFO	-	-

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

## PROCEDURE

### 1. INSTALL BACK DOOR GLASS ADHESIVE DAM

(a) When reusing the back door glass:



*a	Back Side	*b	Marking
----	-----------	----	---------

(1) Using a brush or sponge, coat the installation area of the new back window glass adhesive dam with glass primer.

**NOTICE:**

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

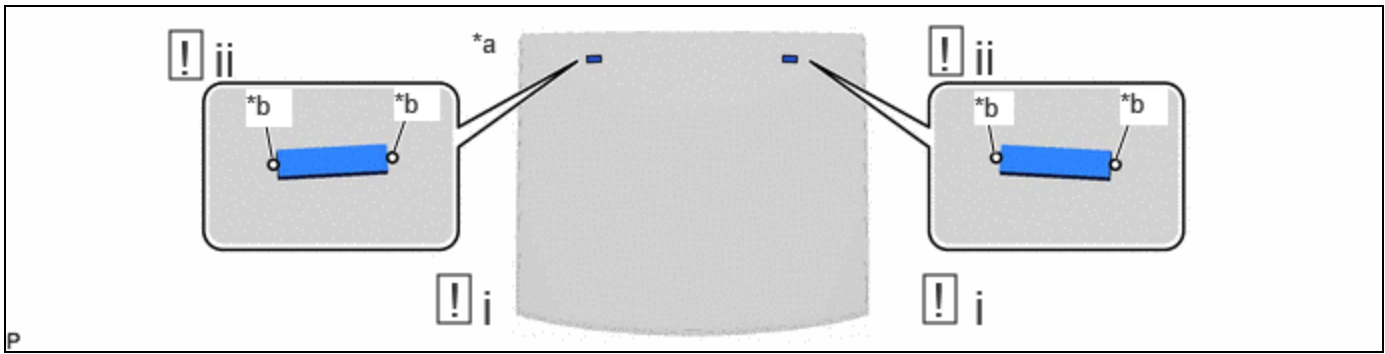
**HINT:**

If an area other than specified is coated by accident, wipe off the glass primer with a clean piece of cloth before it dries.

(2) Install the back window glass adhesive dam to the back window glass as shown in the illustration.

### 2. INSTALL BACK DOOR GLASS SPACER

(a) When reusing the back door glass:



*a	Back Side	*b	Marking
----	-----------	----	---------

(1) Using a brush or sponge, coat the installation area of 2 new back door glass spacers with glass primer.

**NOTICE:**

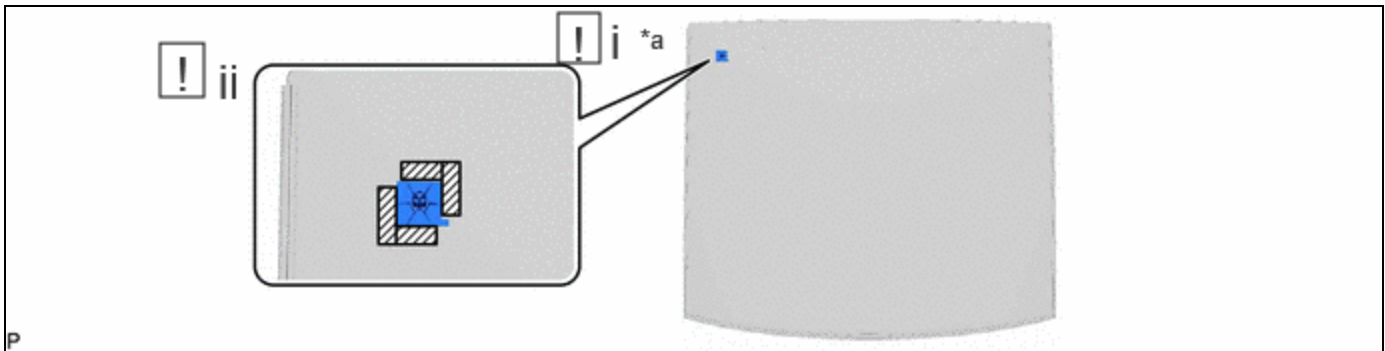
- Do not apply too much glass primer.
- Allow the glass primer to dry for 3 minutes or more.
- Throw away any leftover glass primer.

**HINT:**

If an area other than specified is coated by accident, wipe off the glass primer with a clean piece of cloth before it dries.

(2) Install the 2 back door glass spacers to the back door glass as shown in the illustration.

**3. INSTALL NO. 1 BACK WINDOW GLASS SPACER**



*a	Back Side	-	-
----	-----------	---	---

(1) Using a brush or sponge, coat the installation area of the new No. 1 back window glass spacer with glass primer.

**NOTICE:**

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

**HINT:**

If an area other than specified is coated by accident, wipe off the glass primer with a clean piece of cloth before it dries.

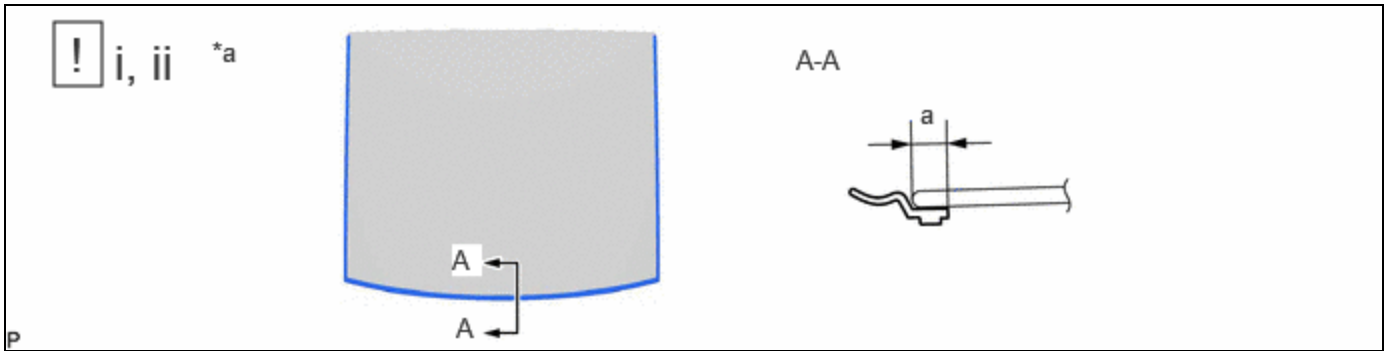
(2) Install the No. 1 back window glass spacer to the back door glass as shown in the illustration.

**4. INSTALL NO. 2 BACK WINDOW GLASS SPACER**

(a) Use the same procedure as for the No. 1 back window glass spacer.

**5. INSTALL BACK DOOR WINDOW MOULDING**

(a) When reusing the back door glass:



*a	Back Side	-	-
----	-----------	---	---

Standard Dimension:

AREA	DIMENSION	AREA	DIMENSION
a	7.3 mm (0.287 in.)	-	-

(1) Using a brush or sponge, coat the installation area of the new back door window moulding with glass primer.

**NOTICE:**

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

**HINT:**

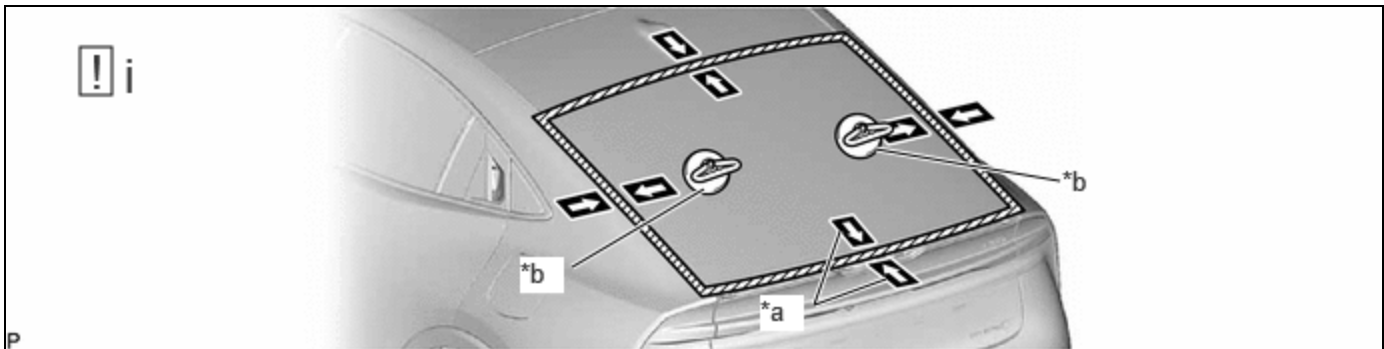
If an area other than specified is coated by accident, wipe off the glass primer with a clean piece of cloth before it dries.

(2) Install the back door window moulding to the back door glass as shown in the illustration.

**6. INSTALL BACK DOOR GLASS**

**NOTICE:**

- After cutting off the old adhesive remaining on the adhesion surface, apply new adhesive within 2 hours.
- If the cut surface of the old adhesive is left exposed for a long time, the adhesion strength will be reduced, so apply the new adhesive quickly.



*a	Matchmark	*b	Suction Cup
----	-----------	----	-------------

(1) Position the back door glass.

1. Using 2 suction cups, place a back door glass in the correct position.
2. Check that the whole contact surface of the back door glass rim is perfectly even.
3. Align the matchmarks on the back door glass and back door panel.

**NOTICE:**

Check that the back window glass clips are engaged to the back door panel correctly.

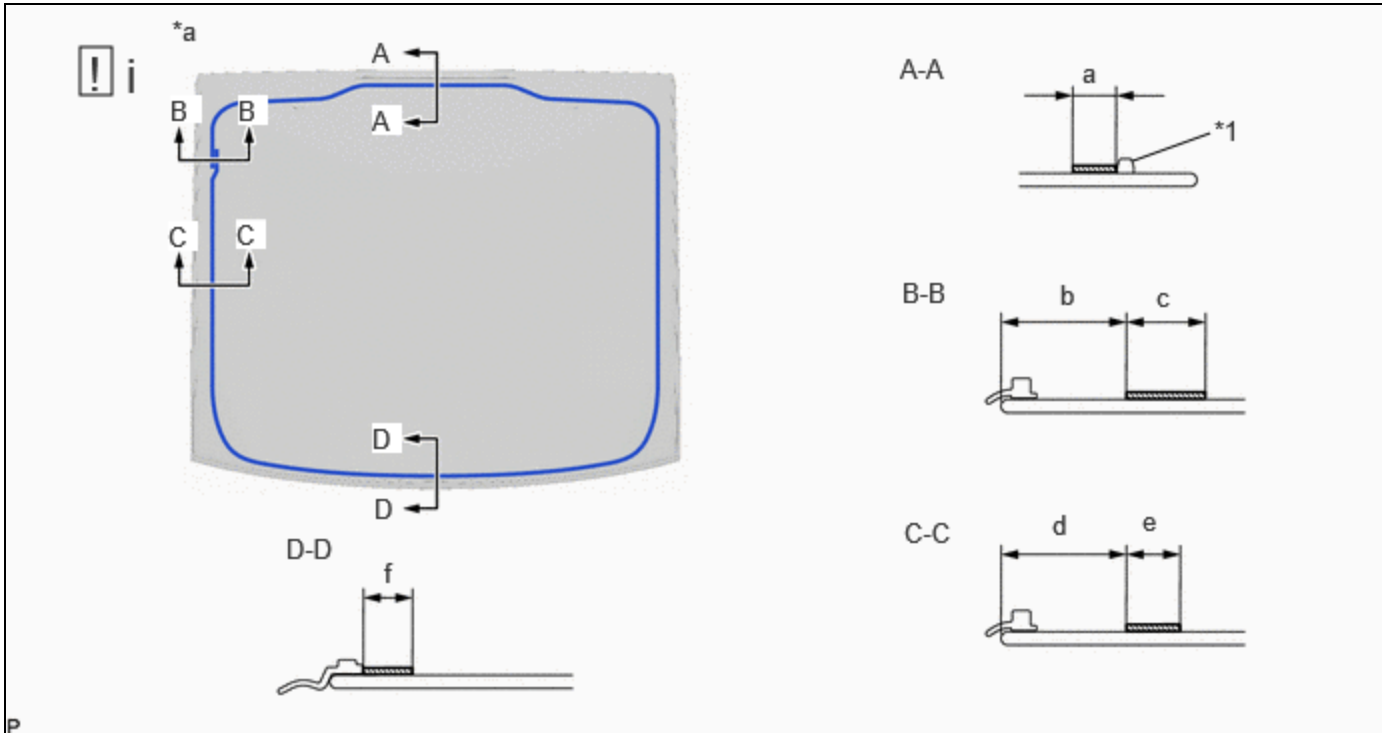
4. Remove the back door glass.
5. Using a brush, coat the installation surfaces on the back door panel with body primer.


**NOTICE:**

- o Do not coat the adhesive with body primer.
- o Do not apply too much body primer.
- o Allow the body primer to dry for 3 minutes or more.
- o Throw away any leftover body primer.

**HINT:**

If an area other than specified is coated by accident, wipe off the body primer with a clean piece of cloth before it dries.



*1	Back Window Glass Adhesive Dam	-	-
*a	Back Side	-	-
	Glass Primer	-	-

Standard Dimension:

AREA	DIMENSION	AREA	DIMENSION
a	10.0 mm (0.394 in.) or more	b	28.7 mm (1.13 in.) or more
c	18.0 mm (0.709 in.) or more	d	28.7 mm (1.13 in.) or more
e	12.0 mm (0.472 in.) or more	f	11.2 mm (0.441 in.) or more

- (1) Using a brush or a sponge, coat the application area of the adhesive with glass primer.

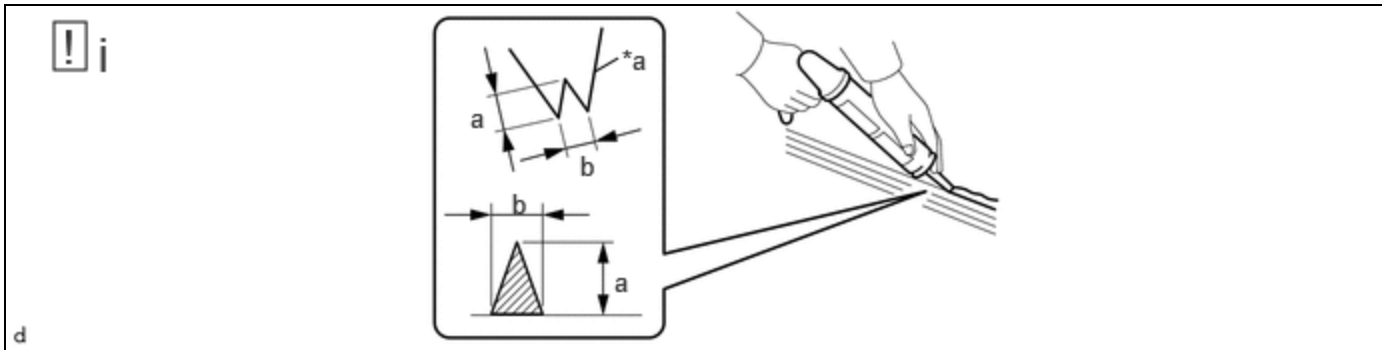
**NOTICE:**

- Do not apply too much glass primer.
- Allow the glass primer to dry for 3 minutes or more.

- Throw away any leftover glass primer.

**HINT:**

- Apply glass primer to the ceramic notches.
- If an area other than specified is coated by accident, wipe off the glass primer with a clean piece of cloth before it dries.



*a	Nozzle	-	-
----	--------	---	---

Adhesive:

Toyota Genuine Windshield Glass Adhesive (High modulus type) or equivalent

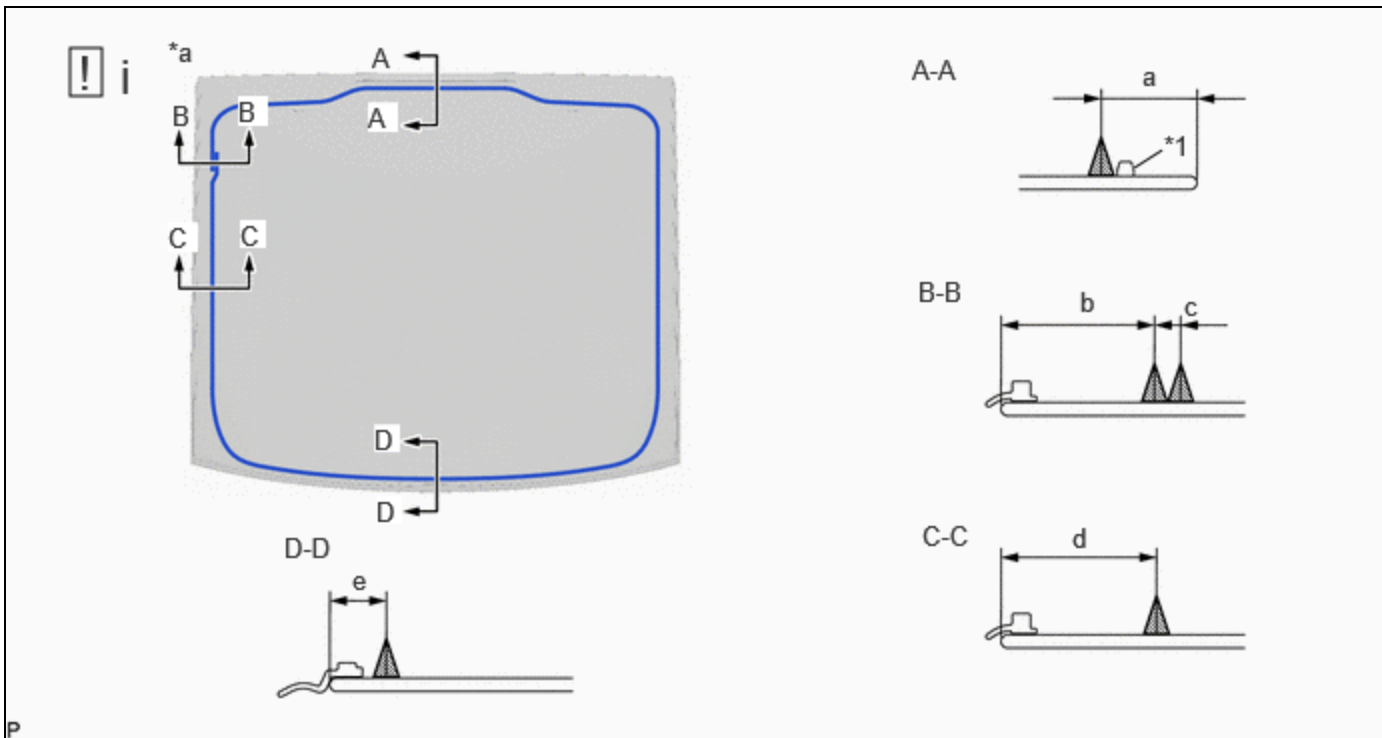
(1) Apply adhesive to the back door glass.

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


Standard Dimension:

AREA	DIMENSION	AREA	DIMENSION
a	10.0 to 13.0 mm (0.394 to 0.512 in.)	b	6.0 to 9.0 mm (0.197 to 0.236 in.)

2. Load the sealer gun with cartridge.



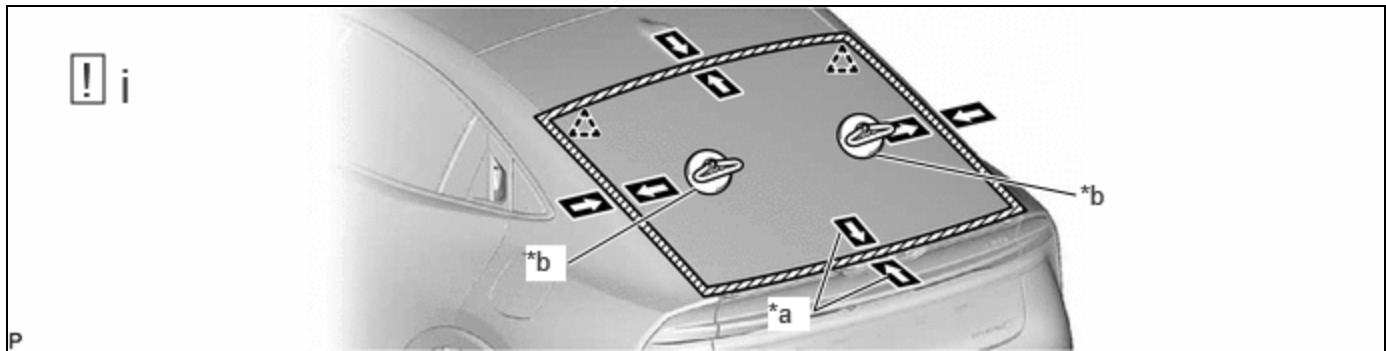
*1	Back Window Glass Adhesive Dam	-	-
*a	Inside	-	-

	Adhesive	-	-
---	----------	---	---

Standard Dimension:

ITEM	DIMENSION	ITEM	DIMENSION
a	23.5 mm (0.925 in.)	b	34.7 mm (1.37 in.)
c	6.0 mm (0.236 in.)	d	34.7 mm (1.37 in.)
e	12.5 mm (0.492 in.)	-	-

(1) Apply adhesive to the back door glass as shown in the illustration.



*a	Matchmark	*b	Suction Cup
----	-----------	----	-------------

(1) Install the back door glass.

- Using 2 suction cups, position the back door glass so that the matchmarks are aligned, and press it in gently along the rim.

**NOTICE:**

- Check that the No. 1 back window glass spacer and No. 2 back window glass spacer are engaged to the back door panel correctly.
- Check the clearance between the back door panel and back door glass.

- Lightly press the front surface of the back door glass to ensure a close fit.

**HINT:**

Press the glass with force of 98 N (10 kgf, 22.0 lbf) or more.

- Using a scraper, remove any excess or protruding adhesive.
- Hold the back door glass using protective tape until the applied adhesive becomes hard.

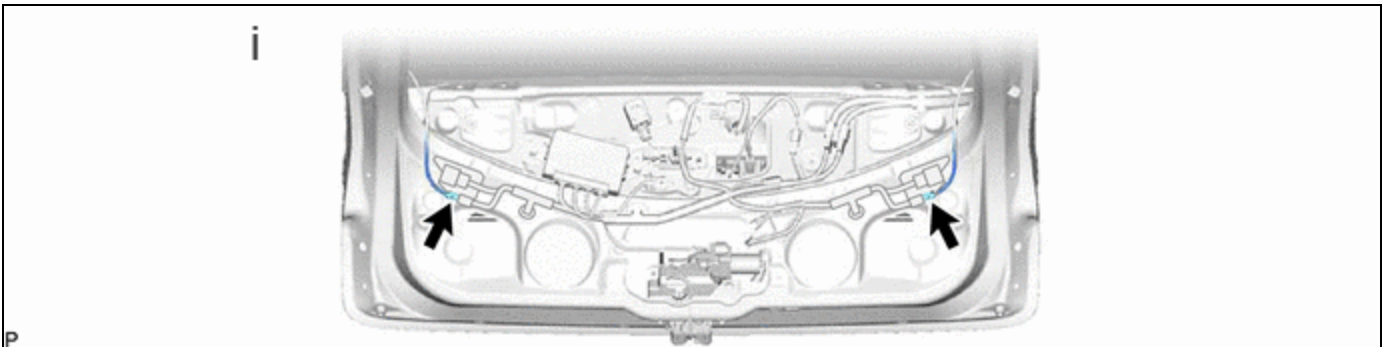
**HINT:**

Follow the instructions supplied by the adhesive manufacturer or in the corresponding instruction manual for the minimum amount of time necessary to wait before driving the vehicle.






(1) Connect the connector.



(1) Connect the 2 connectors.

## 7. INSTALL REAR LIGHT ASSEMBLY

	Click here <a href="#">INFO</a>
---	---------------------------------

## 8. INSTALL BACK DOOR OUTSIDE GARNISH LOWER MOULDING LH

## 9. INSTALL BACK DOOR OUTSIDE GARNISH LOWER MOULDING RH

## 10. INSTALL BACK DOOR TRIM BOARD ASSEMBLY

## 11. INSTALL BACK DOOR SIDE GARNISH RH

## 12. INSTALL BACK DOOR SIDE GARNISH LH

## 13. INSTALL BACK DOOR UPPER TRIM PANEL ASSEMBLY

## 14. INSPECT FOR LEAK AND REPAIR



(1) Inspect for leaks by the below procedure.

1. After the adhesive has hardened, apply water from the outside of the vehicle. Check that no water leaks into the cabin.
2. If water leaks into the cabin, allow the water to dry and add adhesive.
3. Remove the protective tape.

