





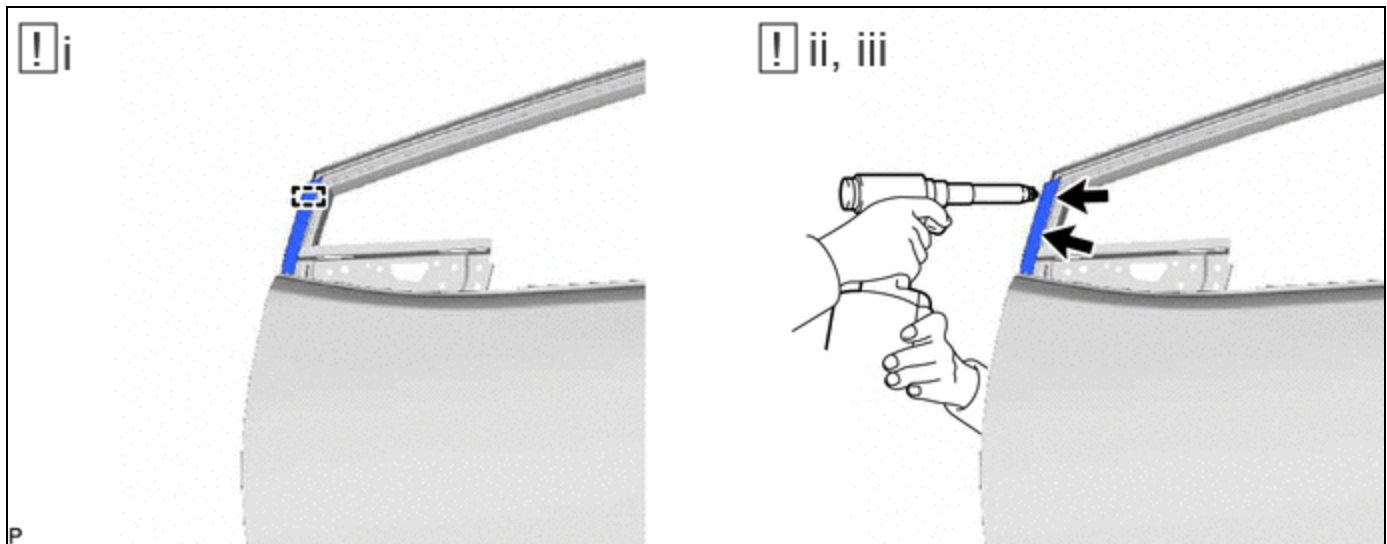


| PROCEDURE | | PART NAME CODE |  |  |  |
|-----------|--|----------------|---|---|---|
| 1 | FRONT DOOR WINDOW FRAME FRONT MOULDING | 75752C | INFO | - | - |
| 2 | FRONT DOOR SUB-ASSEMBLY | - | INFO | - | - |
| 3 | ADJUST FRONT DOOR SUB-ASSEMBLY | - | - | - | INFO |
| 4 | COWL SIDE TRIM BOARD | 62112 | - | - | - |
| 5 | FRONT DOOR SCUFF PLATE | 67914 | - | - | - |
| 6 | FRONT DOOR WINDOW FRAME UPPER MOULDING | 75754A | INFO | - | - |
| 7 | FRONT DOOR WINDOW FRAME REAR MOULDING | 75756C | INFO | - | - |
| 8 | FRONT DOOR WEATHERSTRIP | 67862 | - | - | - |
| 9 | FRONT DOOR BELT MOULDING ASSEMBLY | 75720 | - | - | - |
| 10 | FRONT DOOR FIX WINDOW GLASS | 68126 | - | - | - |

| | | | |
|---|---|---|-------------------|
|  | N*m (kgf*cm, ft.*lbf): Specified torque | • | Non-reusable part |
|  | Toyota Genuine Adhesive 1324, Three Bond 1324 or equivalent |  | Anti-rust coating |
| ★ | Precoated part | - | - |

PROCEDURE

1. INSTALL FRONT DOOR WINDOW FRAME FRONT MOULDING



(1) Engage the guide to temporarily install the front door window frame front moulding to the door frame.

- (2) Install a No. 4 nose piece to an air riveter and insert the mandrel section of a new 4 mm diameter rivet into the nose piece.
- (3) Press the rivets perpendicularly to the installation holes. Using the air riveter, install the front door window frame front moulding with the 2 rivets.

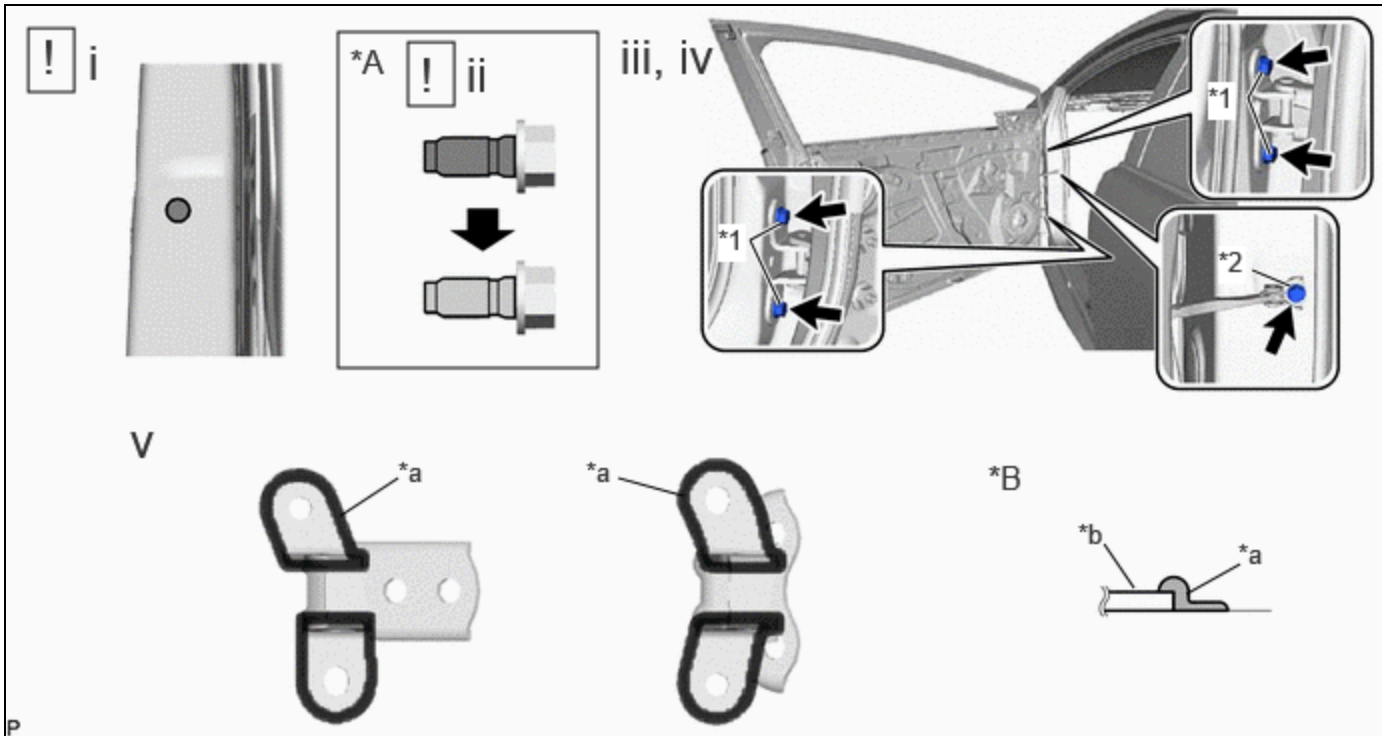
NOTICE:



- When installing the rivets to the panel surface, do not tilt the riveter.
- Do not leave a gap between the rivet head portion and the panel.

HINT:

Pull the trigger again to cut off the rivet if it is not cut off.

2. INSTALL FRONT DOOR SUB-ASSEMBLY



| | | | |
|---|-----------------------|---|---------------------------|
| *A | When reusing the bolt | *B | Section |
| *1 | Bolt (A) | *2 | Bolt (B) |
| *a | Anti-rust Coating | *b | Front Door Hinge Assembly |
|  | Cleaning Area |  | Adhesive |

- (1) Clean the bolt hole in the vehicle body.
- (2) When reusing the bolt:
 - 1. Clean the threads of the bolt.
 - 2. Apply adhesive to the threads of the bolt.

Adhesive:

Toyota Genuine Adhesive 1324, Three Bond 1324 or equivalent

- (3) Install the front door panel sub-assembly with the 4 bolts <A>.

Torque:

21 N·m {214 kgf·cm, 15 ft·lbf}

NOTICE:

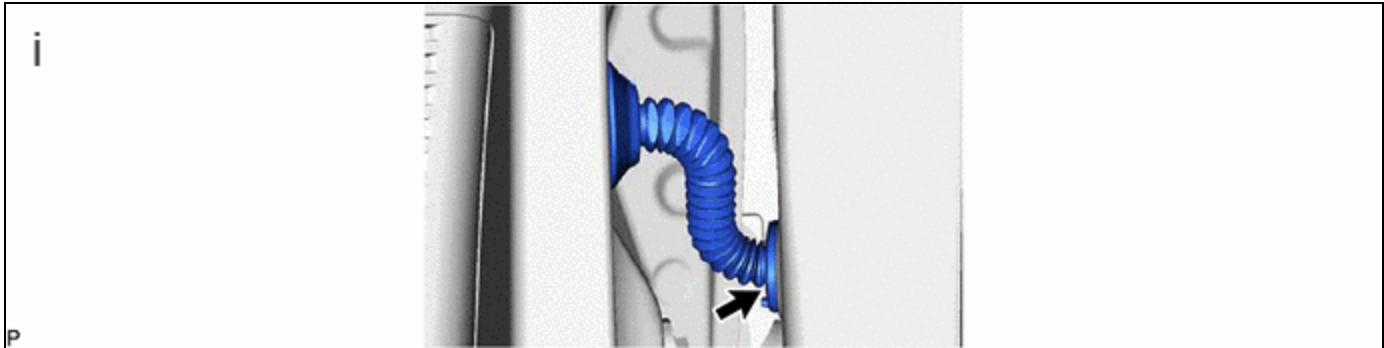
To prevent damage, when installing the front door panel sub-assembly, make sure that there are enough people available to hold it securely.

(4) Install the bolt .

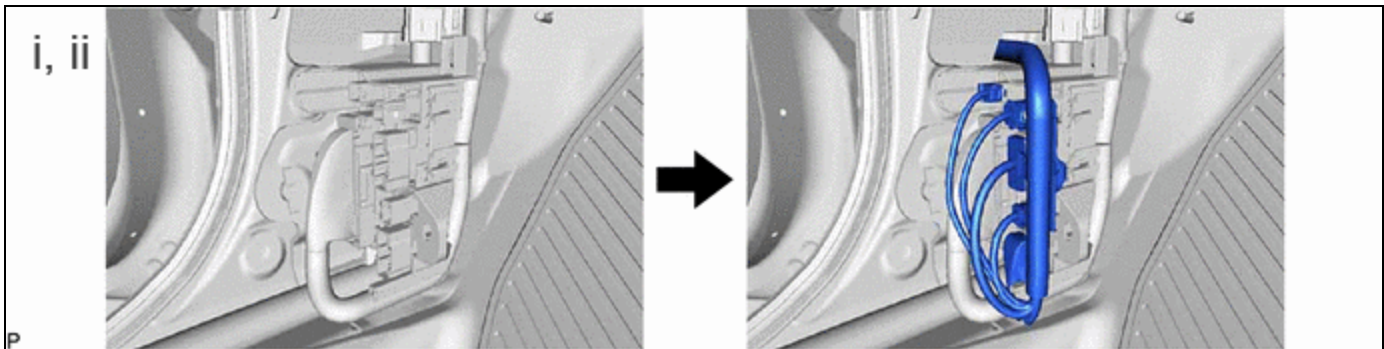
Torque:

30 N·m {306 kgf·cm, 22 ft·lbf}

(5) Using a brush, apply anti-rust coating to each front door hinge assembly.



(1) Engage the grommet.



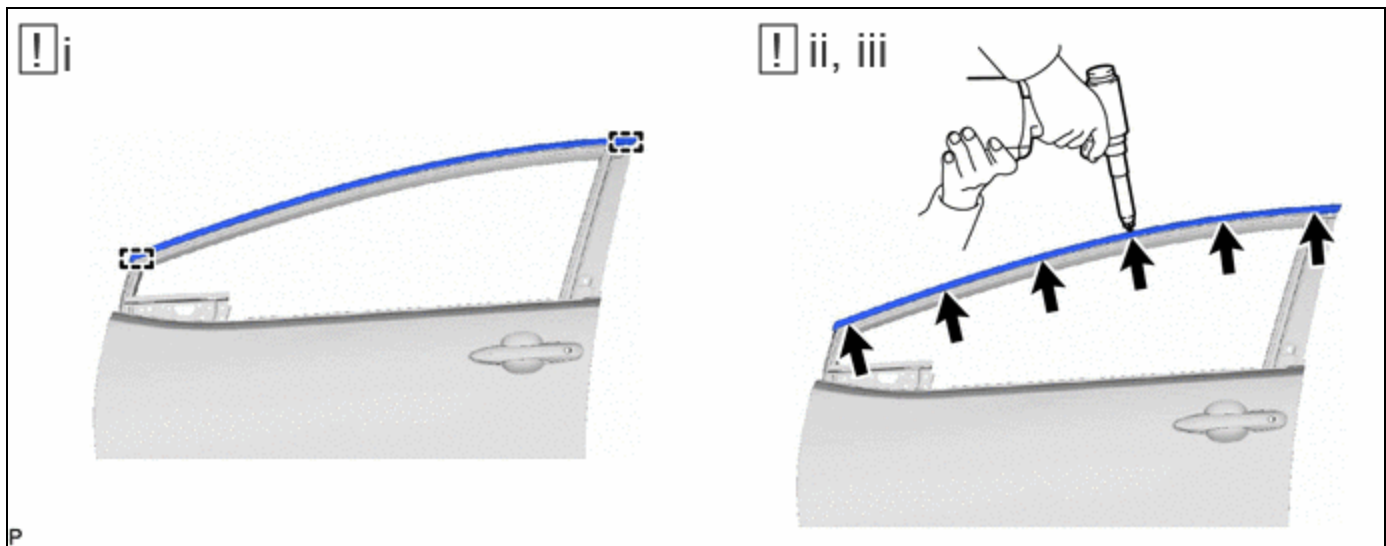
(1) Connect each connector.

(2) Engage each clamp.

3. ADJUST FRONT DOOR SUB-ASSEMBLY

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4. INSTALL COWL SIDE TRIM BOARD**5. INSTALL FRONT DOOR SCUFF PLATE****6. INSTALL FRONT DOOR WINDOW FRAME UPPER MOULDING**



- (1) Engage the 2 guides to temporarily install the front door window frame upper moulding to the door frame.
- (2) Install a No. 4 nose piece to an air riveter and insert the mandrel section of a new 4 mm diameter rivet into the nose piece.
- (3) Press the rivets perpendicularly to the installation holes. Using the air riveter, install the front door window frame upper moulding with the 6 rivets.

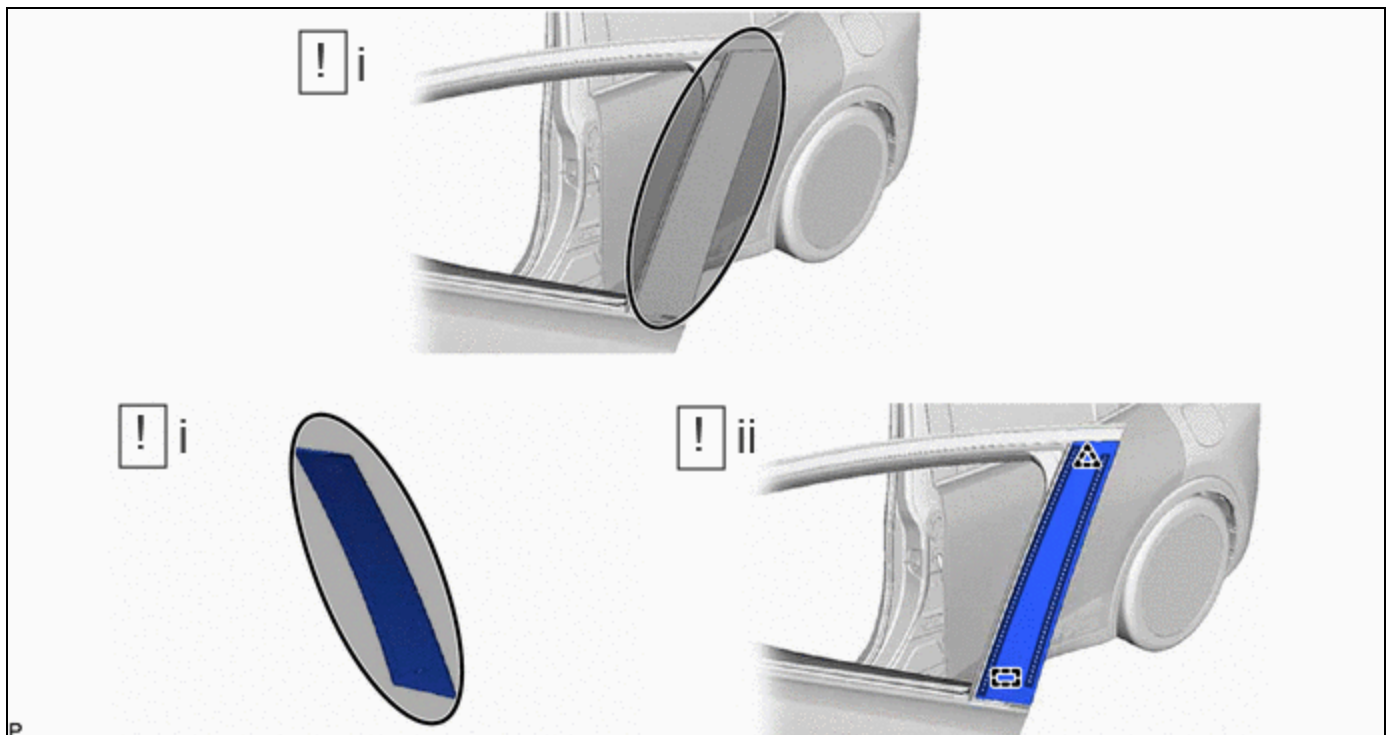
NOTICE:


- When installing the rivets to the panel surface, do not tilt the riveter.
- Do not leave a gap between the rivet head portion and the panel.

HINT:

Pull the trigger again to cut off the rivet if it is not cut off.

7. INSTALL FRONT DOOR WINDOW FRAME REAR MOULDING



| | | | |
|---|--------------|---|---|
|  | Heating Area | - | - |
|---|--------------|---|---|

(1) Clean the vehicle body surface.

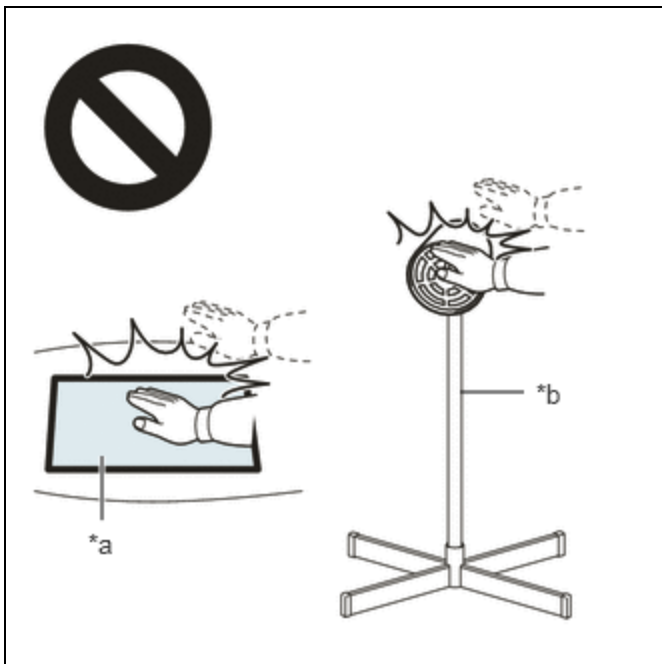
1. Using a heat light, heat the double-sided tape remaining on the vehicle body and front door window frame rear moulding.

Heating Temperature

| AREA | TEMPERATURE | AREA | TEMPERATURE |
|--------------|-----------------------------|---------------------------------------|---------------------------|
| Vehicle Body | 40 to 60 °C (104 to 140 °F) | Front Door Window Frame Rear Moulding | 20 to 30 °C (68 to 86 °F) |

CAUTION:

- Do not touch the heat light and heated parts, touching the heat light may result in burns.
- Touching heated parts for a long time may result in burns.



| | |
|----|-------------|
| *a | Heated Part |
| *b | Heat Light |

NOTICE:

Do not heat the vehicle body excessively.

2. Remove any remaining double-sided tape from the vehicle body.
 3. Wipe off any tape adhesive residue with cleaner.
- (2) Install a new front door window frame rear moulding.

1. Remove the release paper from the front door window frame rear moulding.

HINT:

After removing the release paper, keep the exposed adhesive free from foreign matter.

2. Engage the guide, clip and attach the double-sided tape to install the front door window frame rear moulding.

HINT:

Press the front door window frame rear moulding firmly to install it.

8. INSTALL FRONT DOOR WEATHERSTRIP

9. INSTALL FRONT DOOR BELT MOULDING ASSEMBLY

10. INSTALL FRONT DOOR FIX WINDOW GLASS

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