

Last Modified: 12-04-2024	6.11:8.1.0	Doc ID: RM1000000029ODD
Model Year Start: 2023	Model: Prius Prime	Prod Date Range: [12/2022 -]
Title: WINDOW / GLASS: WINDSHIELD GLASS: INSTALLATION; 2023 - 2024 MY Prius Prius Prime [12/2022 -]		

INSTALLATION

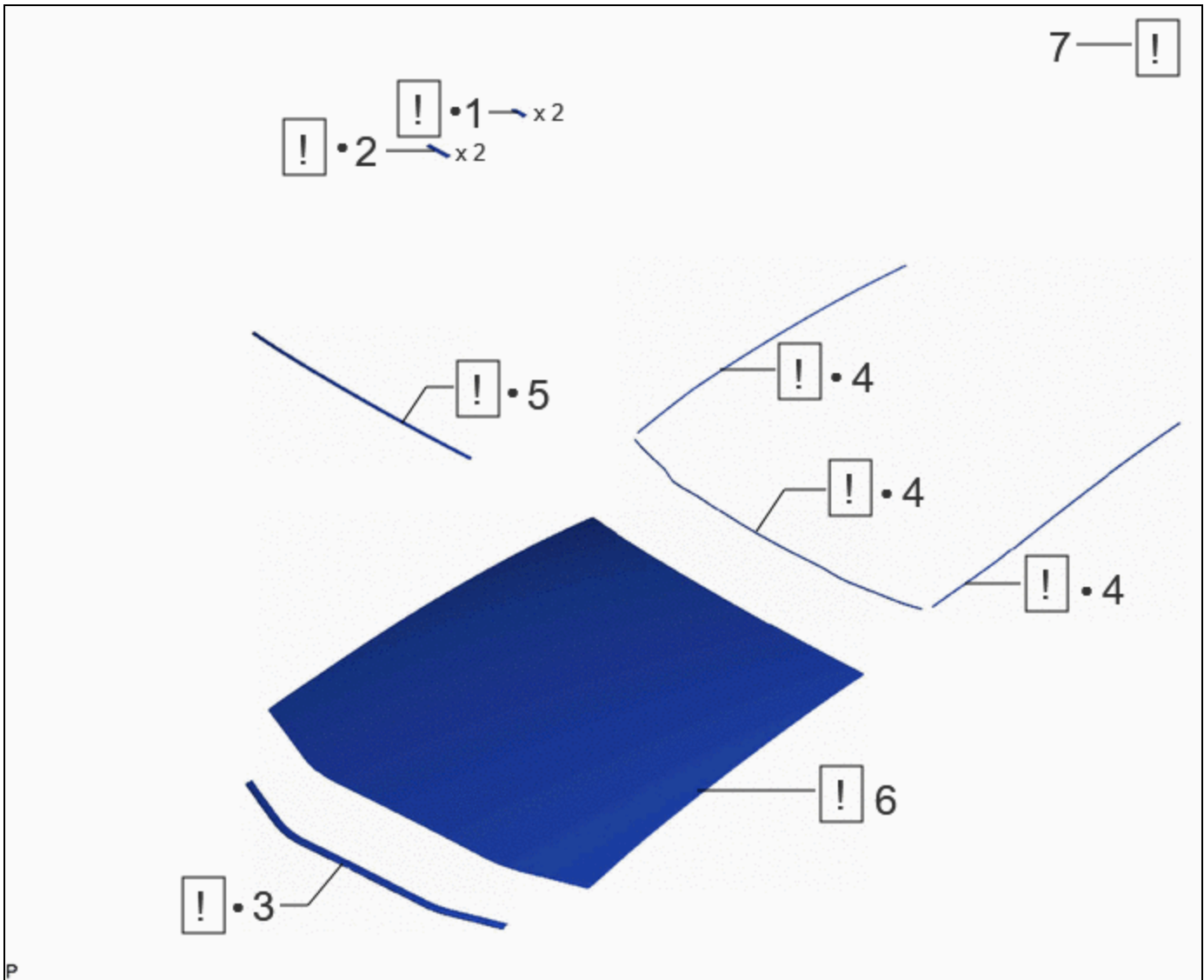
CAUTION / NOTICE / HINT

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.
- When replacing the windshield glass of a vehicle equipped with a forward recognition camera, make sure to use a Lexus genuine part. If a non-Lexus genuine part is used, the forward recognition camera may not be able to be installed due to a missing bracket. Also, the dynamic radar cruise control system, front camera system, lane tracing assist system, pre-collision system or adaptive high beam system may not operate properly due to a difference in the transmissivity or black ceramic border.

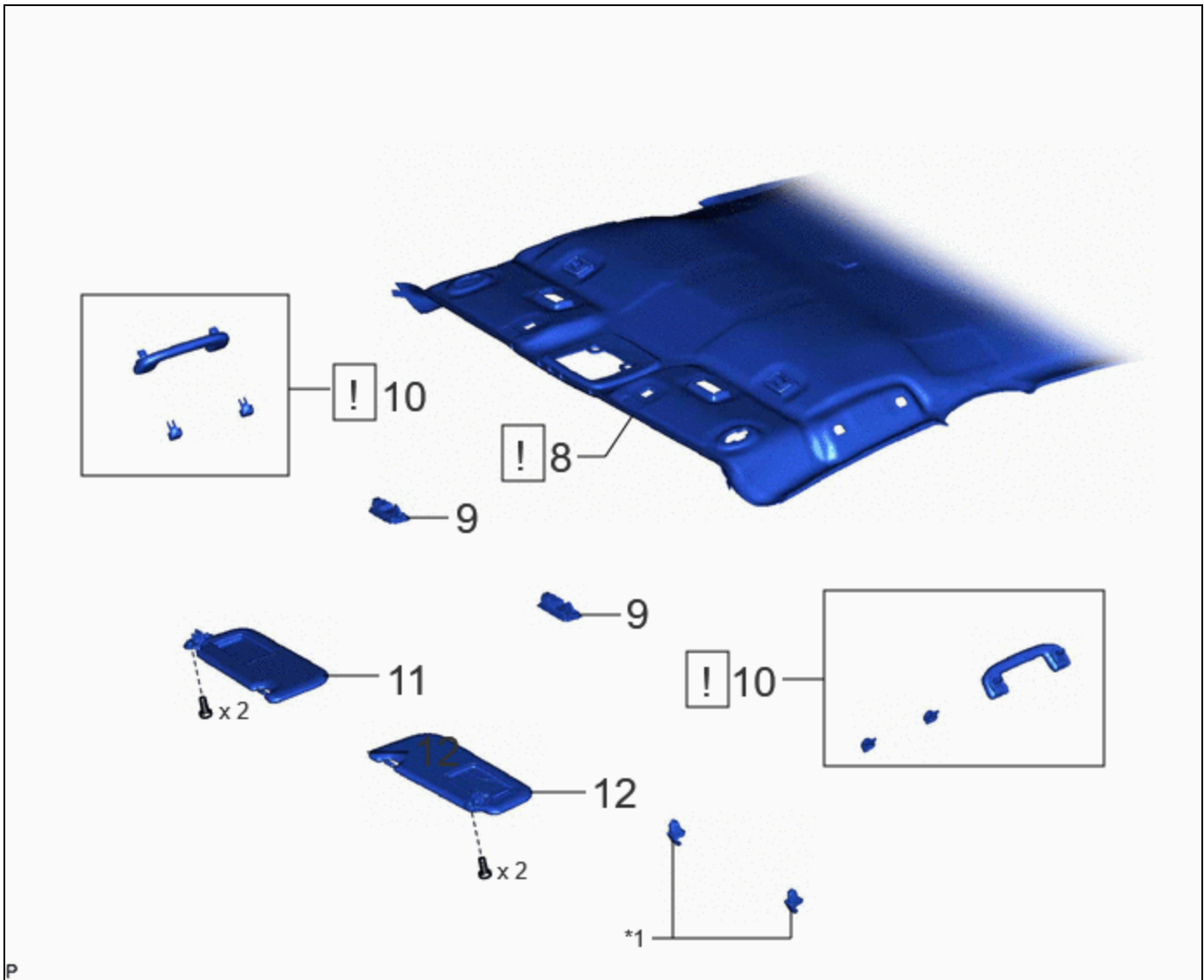
CAUTION / NOTICE / HINT

COMPONENTS (INSTALLATION)

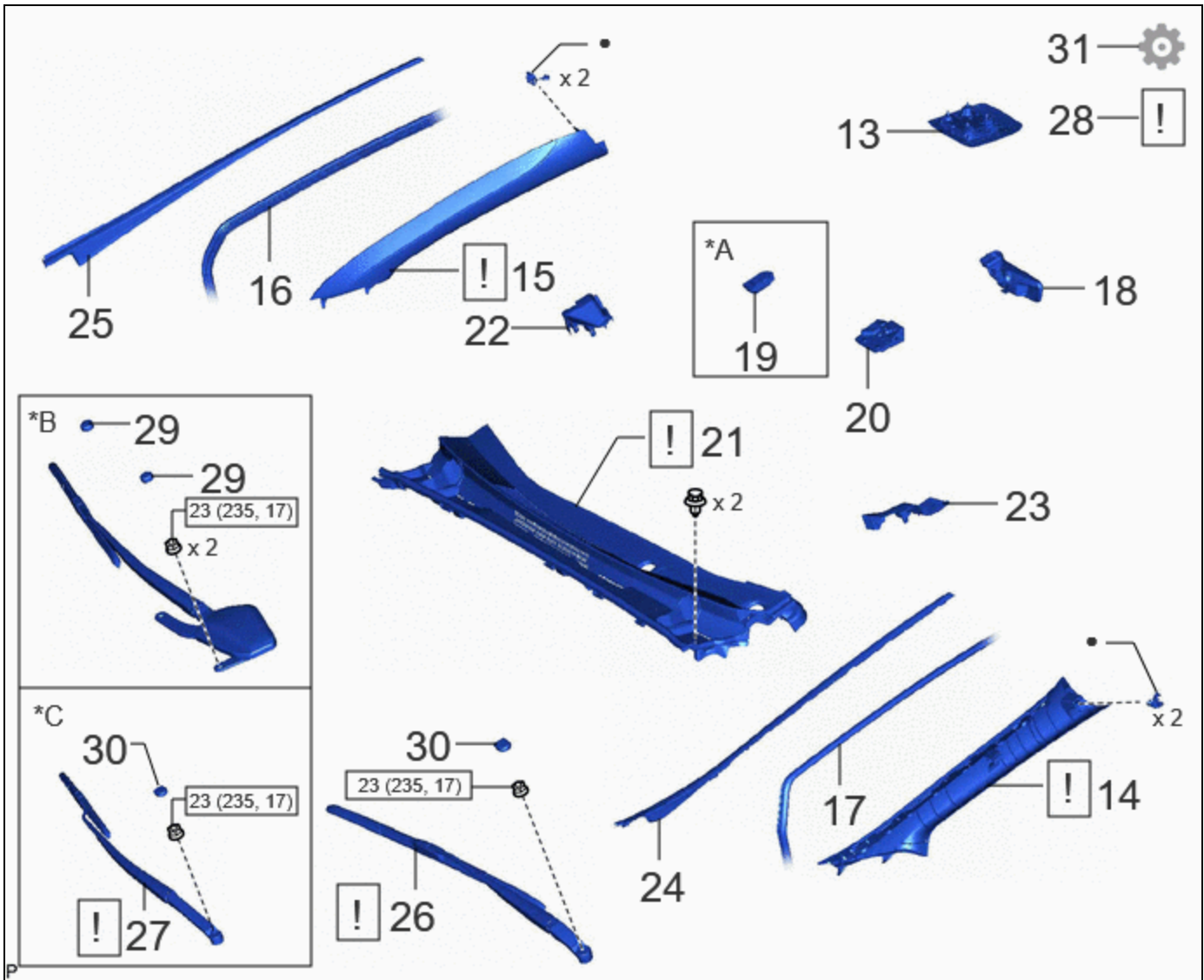





	PROCEDURE	PART NAME CODE			
1	NO. 1 WINDSHIELD GLASS STOPPER	56115A	INFO	-	-
2	NO. 2 WINDSHIELD GLASS STOPPER	56116C	INFO	-	-
3	FRONT WINDOW INNER CENTER MOULDING	56153C	INFO	-	-
4	NO. 2 WINDOW GLASS ADHESIVE DAM	56118B	INFO	-	-
5	WINDSHIELD OUTSIDE MOULDING	75533G	INFO	-	-
6	WINDSHIELD GLASS SUB-ASSEMBLY	-	INFO	-	-
7	INSPECT FOR LEAK AND REPAIR	-	INFO	-	-




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




PROCEDURE		PART NAME CODE			
8	ROOF HEADLINING ASSEMBLY	-	INFO	-	-
9	VANITY LIGHT ASSEMBLY	81340	-	-	-
10	ASSIST GRIP ASSEMBLY	74610E	INFO	-	-
11	VISOR ASSEMBLY RH	74310	-	-	-
12	VISOR ASSEMBLY LH	74320	-	-	-
*1	VISOR HOLDER				



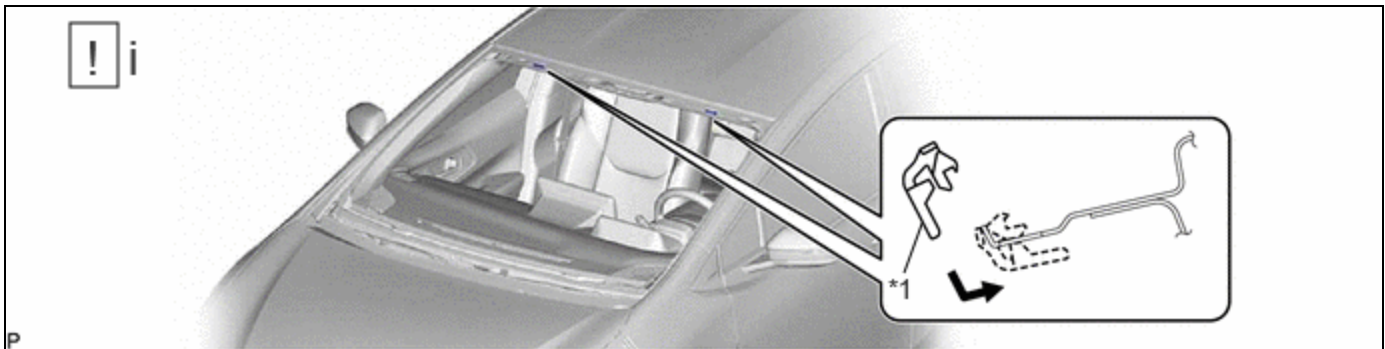
PROCEDURE		PART NAME CODE			
13	MAP LIGHT ASSEMBLY	-	-	-	-
14	FRONT PILLAR GARNISH LH	62212	INFO	-	-
15	FRONT PILLAR GARNISH RH	62211	INFO	-	-
16	FRONT DOOR OPENING TRIM WEATHERSTRIP RH	62311B	-	-	-
17	FRONT DOOR OPENING TRIM WEATHERSTRIP LH	62312B	-	-	-
18	INNER REAR VIEW MIRROR ASSEMBLY	87810	-	-	-
19	RAIN SENSOR	89941	-	-	-
20	FORWARD RECOGNITION CAMERA	8646C	-	-	-
21	COWL TOP VENTILATOR LOUVER SUB-ASSEMBLY	55708	-	-	-
22	COWL WATER EXTRACT SHIELD RH	55753D	-	-	-
23	COWL WATER EXTRACT SHIELD LH	55754F	-	-	-

PROCEDURE		PART NAME CODE			
24	WINDSHIELD LOWER OUTSIDE MOULDING LH	75536D	-	-	-
25	WINDSHIELD LOWER OUTSIDE MOULDING RH	75535F	-	-	-
26	FRONT WIPER ARM AND BLADE ASSEMBLY LH	-	INFO	-	-
27	FRONT WIPER ARM AND BLADE ASSEMBLY RH	-	INFO	-	-
28	INSPECT FRONT WIPER ARM AND BLADE ASSEMBLY	-	INFO	-	-
29	SHIELD CAP	85247	-	-	-
30	FRONT WIPER ARM HEAD CAP	85292B	-	-	-
31	ADJUST FORWARD RECOGNITION CAMERA	8646C	-	-	INFO

*A	w/ Rain Sensor	*B	for M20A-FXS
*C	for 2ZR-FXE	-	-
	N*m (kgf*cm, ft.*lbf): Specified torque	•	Non-reusable part

PROCEDURE

1. INSTALL NO. 1 WINDSHIELD GLASS STOPPER



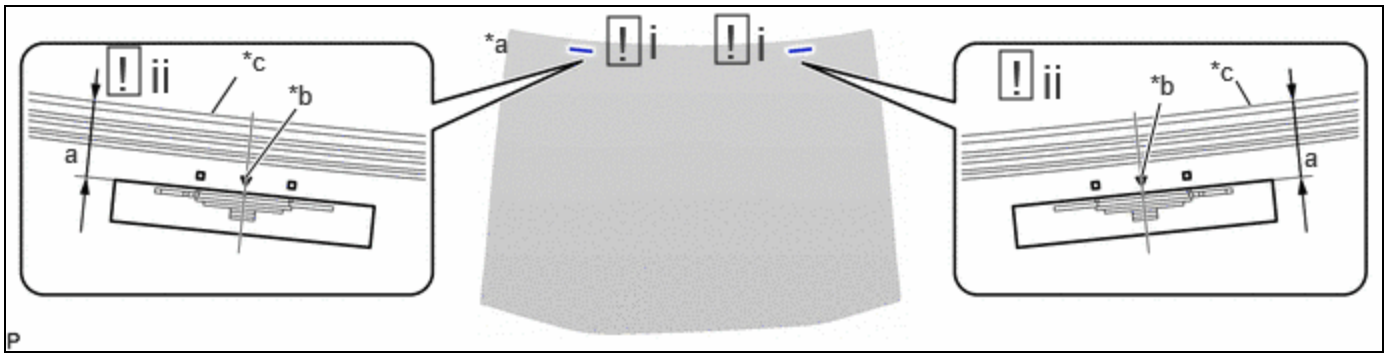
*1	No. 1 Windshield Glass Stopper	-	-
----	--------------------------------	---	---

(1) Install 2 new No. 1 windshield glass stoppers to the vehicle body as shown in the illustration.

HINT:

Only 2-piece type windshield glass stoppers are provided as supply parts. Use 2-piece type stoppers as replacements even if 1-piece type stoppers were originally installed.

2. INSTALL NO. 2 WINDSHIELD GLASS STOPPER



*a	Back Side	*b	Ceramic Notch
*c	Windshield Glass Edge Side	-	-

Standard Dimension:

AREA	DIMENSION	AREA	DIMENSION
a	27.8 mm (1.094 in.)	-	-

(1) Using a brush or sponge, coat the installation area of 2 new No. 2 windshield glass stoppers 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:

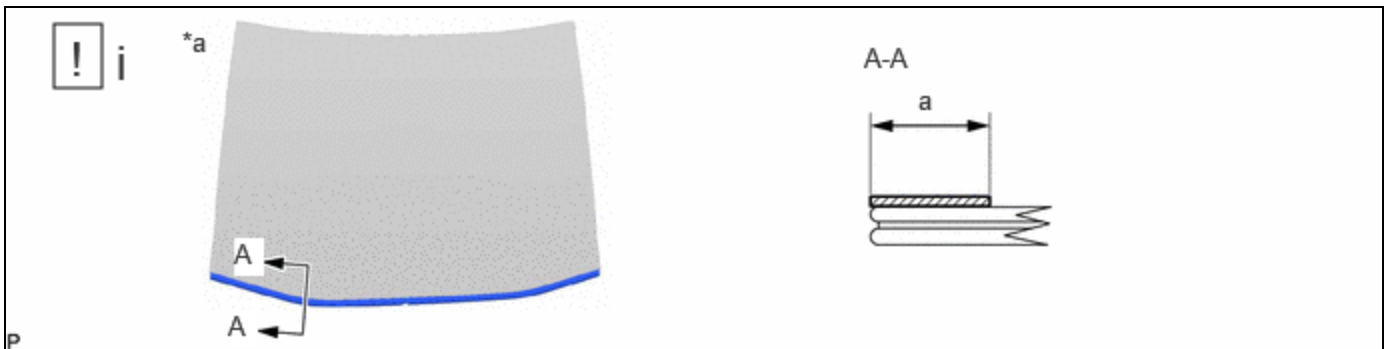
If an area other than specified is coated by accident, wipe off the glass primer with a clean piece of cloth before it dries.

(2) Install the 2 No. 2 windshield glass stoppers to the windshield glass as shown in the illustration.

HINT:

Only 2-piece type windshield glass stoppers are provided as supply parts. Use 2-piece type stoppers as replacements even if 1-piece type stoppers were originally installed.

3. INSTALL FRONT WINDOW INNER CENTER MOULDING



*a	Back Side	-	-
	Glass Primer	-	-

Standard Dimension:

ITEM	DIMENSION	ITEM	DIMENSION
a	17.5 to 20.5 mm (0.689 to 0.807 in.)	-	-

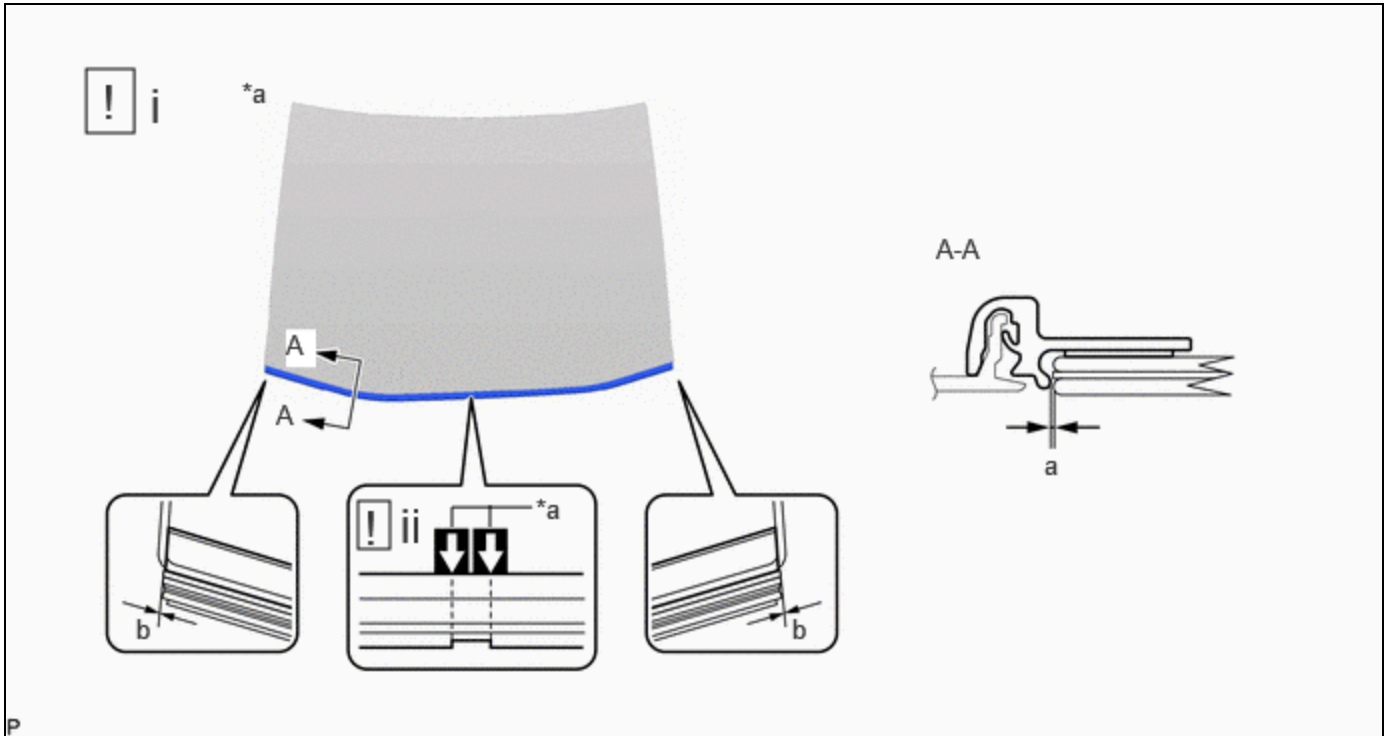
(1) Using a brush or sponge, coat the adhesive application area with glass primer.

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.



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

(1) Install the new front window inner center moulding to the windshield glass as shown in the illustration.

Standard Dimension:

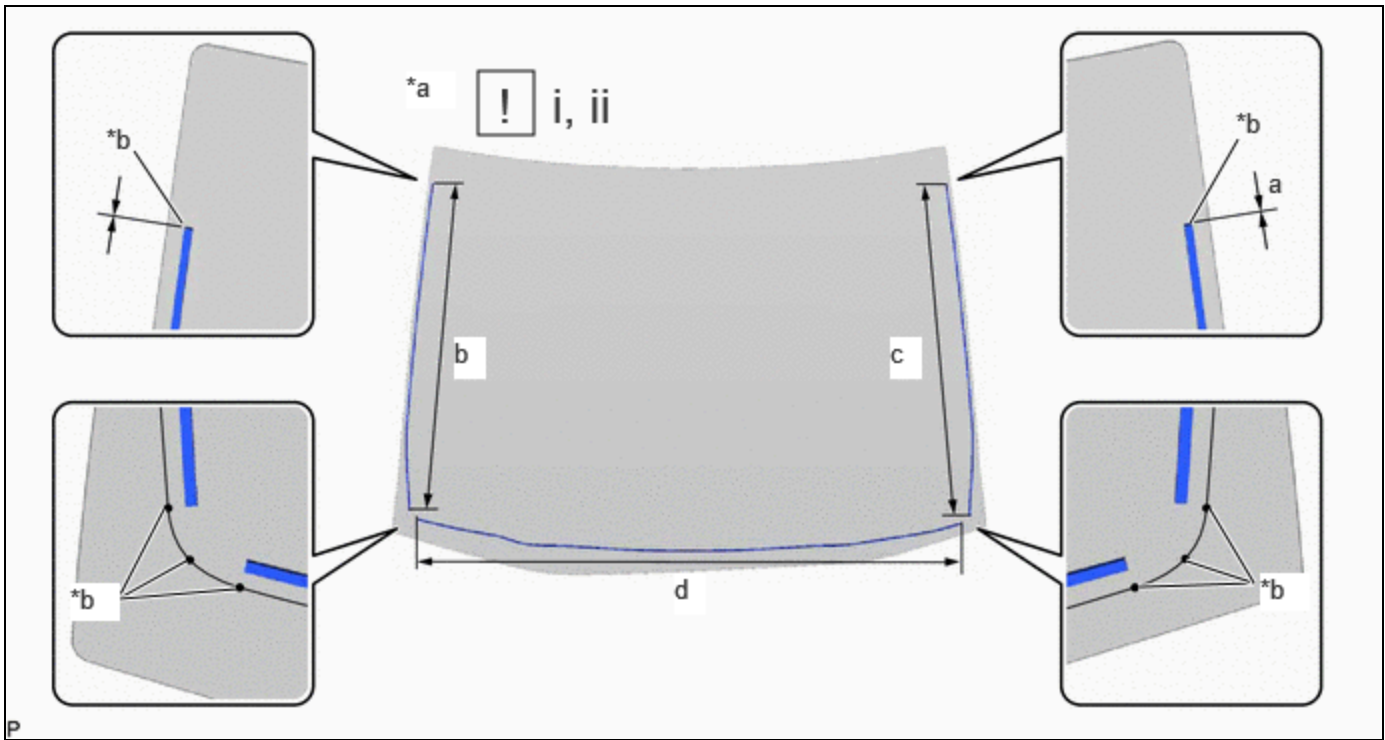
ITEM	DIMENSION	ITEM	DIMENSION
a	0.6 mm (0.0236 in.)	b	-2.0 to 2.0 mm (-0.0787 to 0.0787 in.)

NOTICE:

Do not damage the front window inner center moulding.

(2) Remove the matchmarks.

4. INSTALL NO. 2 WINDOW GLASS ADHESIVE DAM



*a	Back Side	*b	Ceramic Notch
----	-----------	----	---------------

Reference Measurement:

AREA	MEASUREMENT	AREA	MEASUREMENT
a	0.0 mm (0.0 in.)	b	82.1 to 83.1 cm (2.69 to 2.73 ft.)
c	83.2 to 84.2 cm (2.73 to 2.76 ft.)	d	128.8 to 129.8 cm (4.22 to 4.26 ft.)

(1) Using a brush or sponge, coat the installation area of 3 new windshield glass adhesive dams with glass primer.

NOTICE:

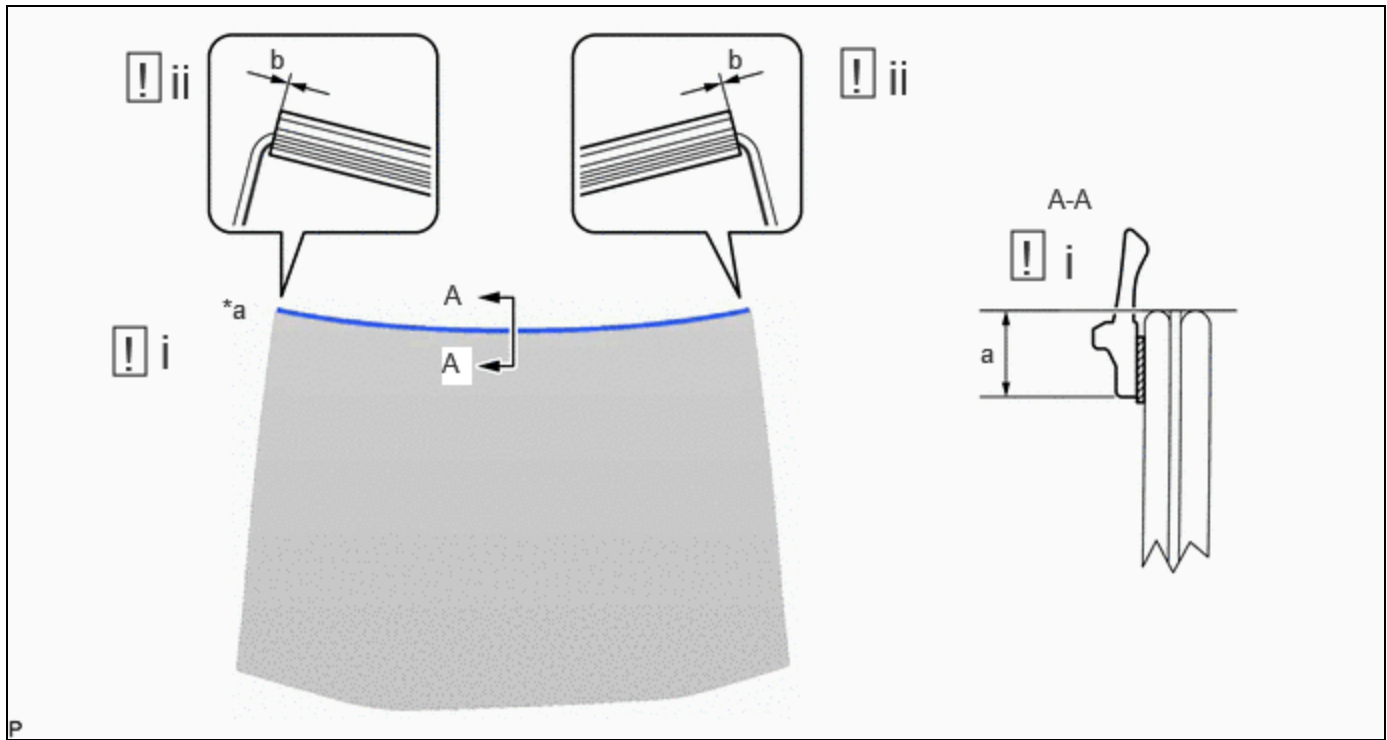
- Do not apply too much glass primer.
- Allow the glass primer to dry for 3 minutes or more.
- Throw away any leftover glass primer.

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 3 windshield glass adhesive dams to the windshield glass as shown in the illustration.

5. INSTALL WINDSHIELD OUTSIDE MOULDING



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

Reference Measurement / Standard Dimension:

AREA	MEASUREMENT	AREA	DIMENSION
a	6.9 mm (0.272 in.)	b	-3.0 to 3.0 mm (-0.118 to 0.118 in.)

(1) Using a brush or sponge, coat the installation area of a new windshield outside 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:

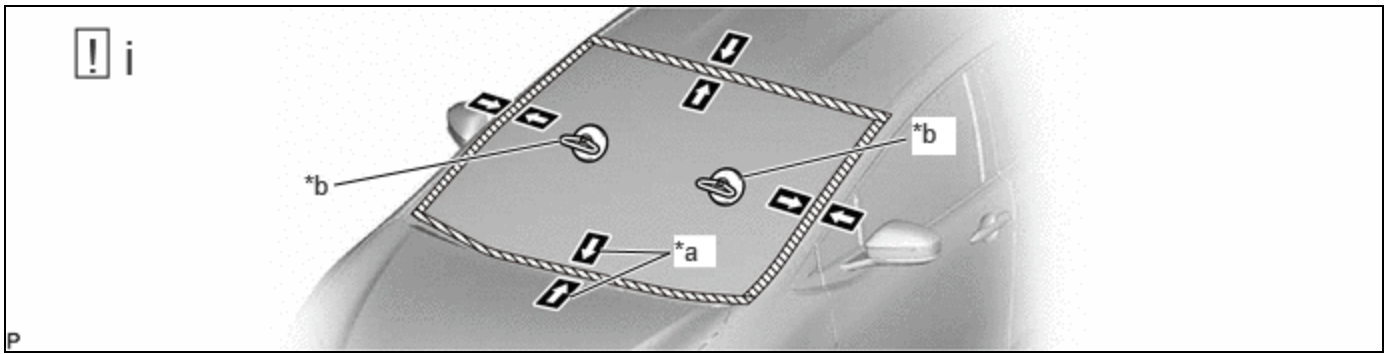
If an area other than specified is coated by accident, wipe off the glass primer with a clean piece of cloth before it dries.

(2) Install the windshield outside moulding to the windshield glass as shown in the illustration.

6. INSTALL WINDSHIELD GLASS SUB-ASSEMBLY

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) Prepare to install the windshield glass by the below procedure.

1. Position the windshield glass.
2. Using 2 suction cups, place the windshield glass in the correct position.
3. Check that the whole contact surface of the windshield glass rim is perfectly even.
4. Align the matchmarks on the windshield glass and vehicle body.

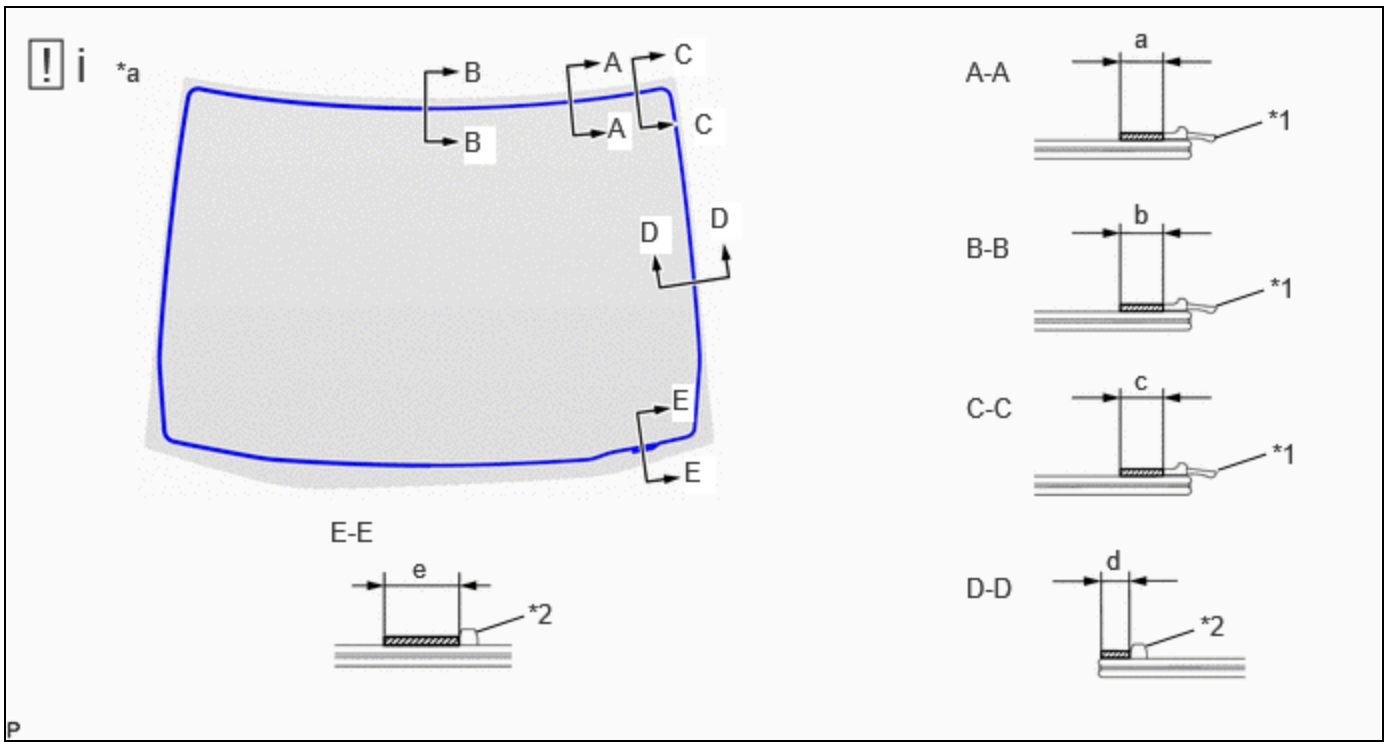
NOTICE:

Check that the windshield glass stoppers are attached to the vehicle body correctly.


5. Remove the windshield glass.
6. Using a brush, coat the installation surface on the vehicle body 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.



*1	Windshield Outside Moulding	*2	Windshield Glass Adhesive Dam
*a	Back Side	-	-

	Glass Primer	-	-
---	--------------	---	---

Standard Dimension:

ITEM	DIMENSION	ITEM	DIMENSION
a	10.5 mm (0.413 in.) or more	b	10.5 mm (0.413 in.) or more
c	10.5 mm (0.413 in.) or more	d	8.0 mm (0.3150 in.) or more
e	18 mm (0.709 in.) or more	-	-

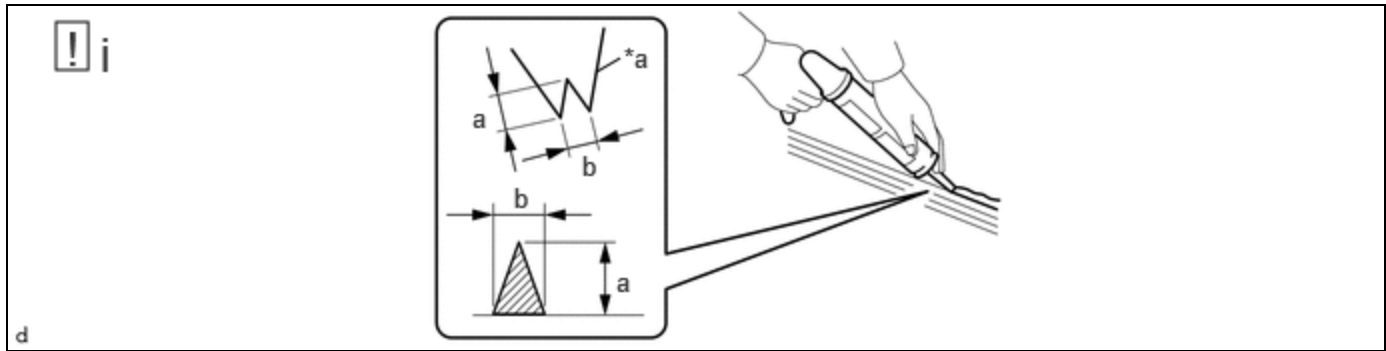
(1) Using a brush or sponge, coat the adhesive application area with glass primer.

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	-	-
----	--------	---	---

(1) Prepare to apply adhesive to the windshield glass by the below procedure.

Adhesive:

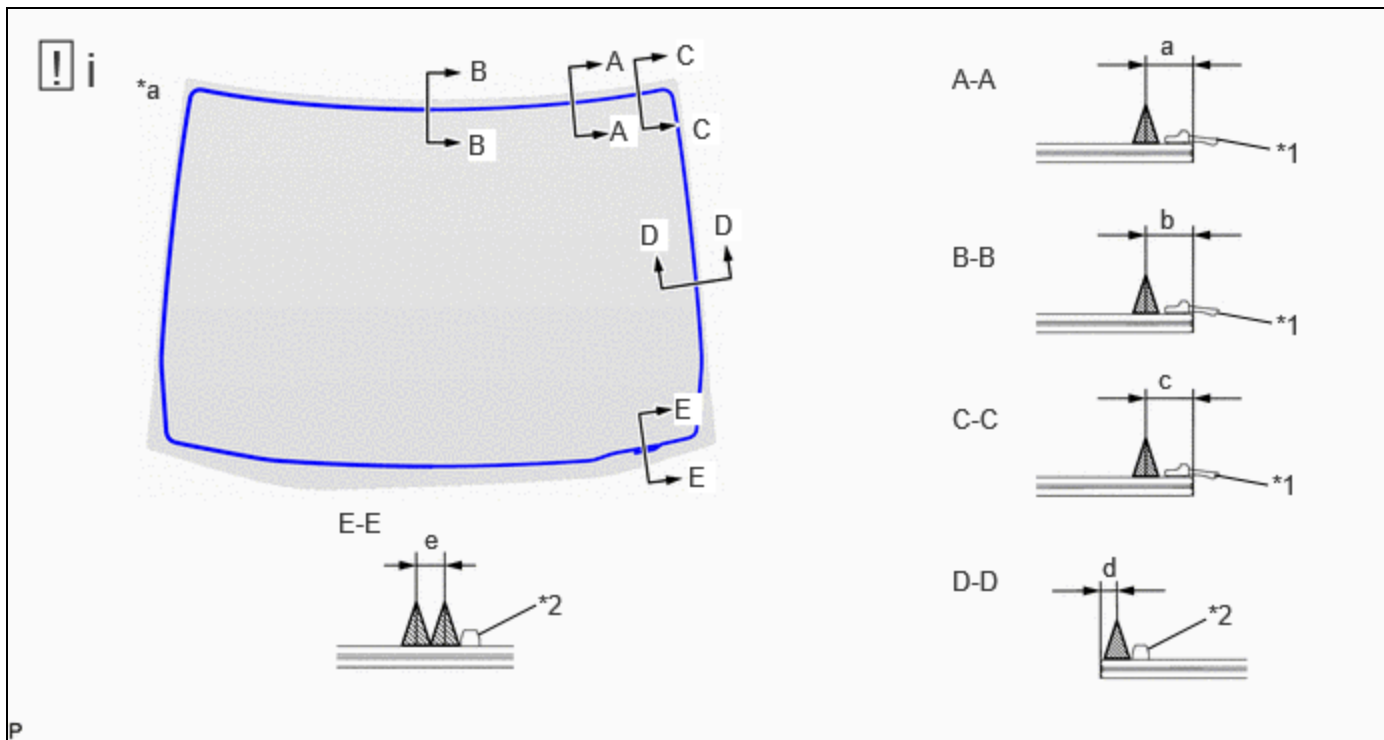
Toyota Genuine Windshield Glass Adhesive (High modulus type) or equivalent


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

Standard Dimension:

ITEM	DIMENSION	ITEM	DIMENSION
a	10.0 to 13.0 mm (0.394 to 0.512 in.)	b	6.0 to 9.0 mm (0.236 to 0.354 in.)

2. Load the sealer gun with cartridge.



*1	Windshield Outside Moulding	*2	Windshield Glass Adhesive Dam
*a	Back Side	-	-
	Adhesive	-	-

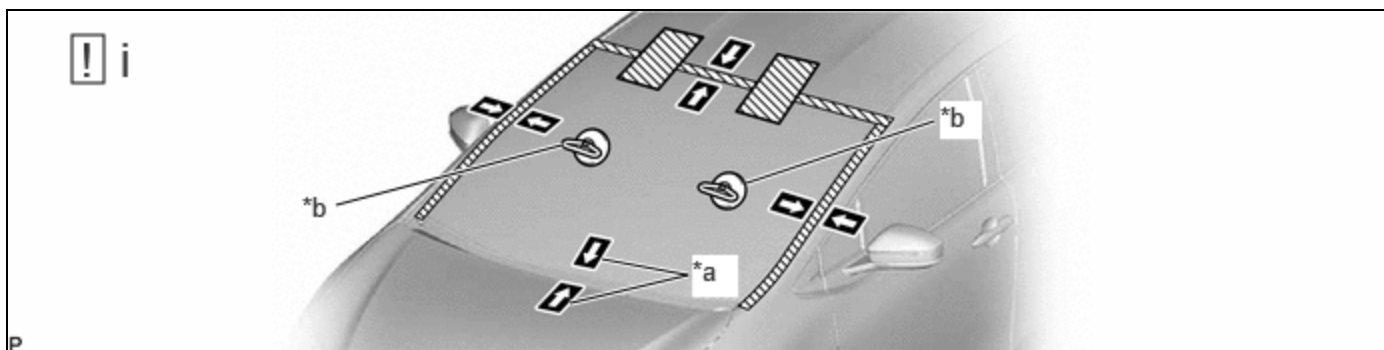
(1) Apply adhesive to the windshield glass, as shown in the illustration.

Standard Dimension:

ITEM	DIMENSION	ITEM	DIMENSION
a	11.5 mm (0.453 in.)	b	11.5 mm (0.453 in.)
c	11.4 mm (0.449 in.)	d	4.0 mm (0.157 in.)
e	6.0 mm (0.236 in.)	-	-

HINT:

Apply adhesive onto the ceramic notches.



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

(1) Install the windshield glass.

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

NOTICE:

- Check that the windshield glass stoppers are engaged to the vehicle body correctly.
- Check the clearance between the vehicle body and windshield glass.

- Lightly press the outer surface of the windshield glass to ensure that the windshield glass is securely fit to the vehicle body.

HINT:

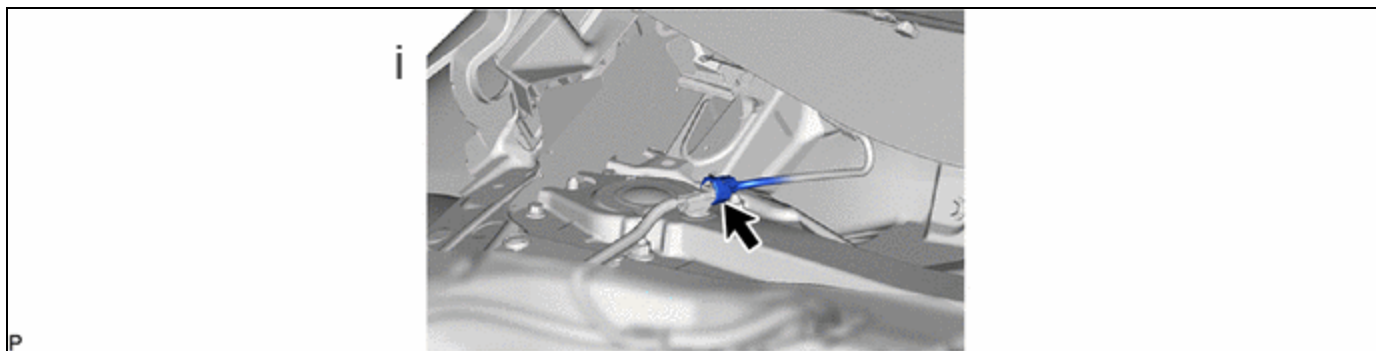
Press the glass with a force of 98 N (10 kgf, 22.0 lbf) or more.

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

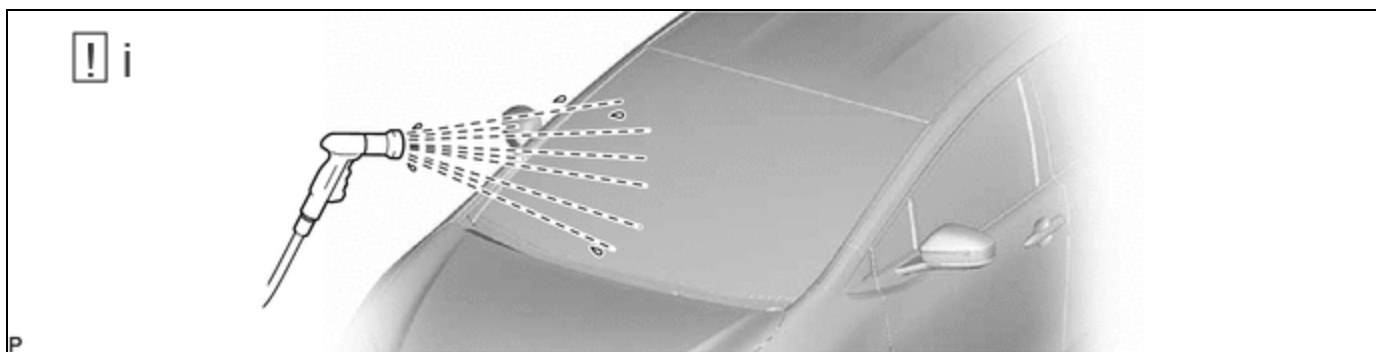
HINT:

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.

(f) w/ Windshield Deicer System:

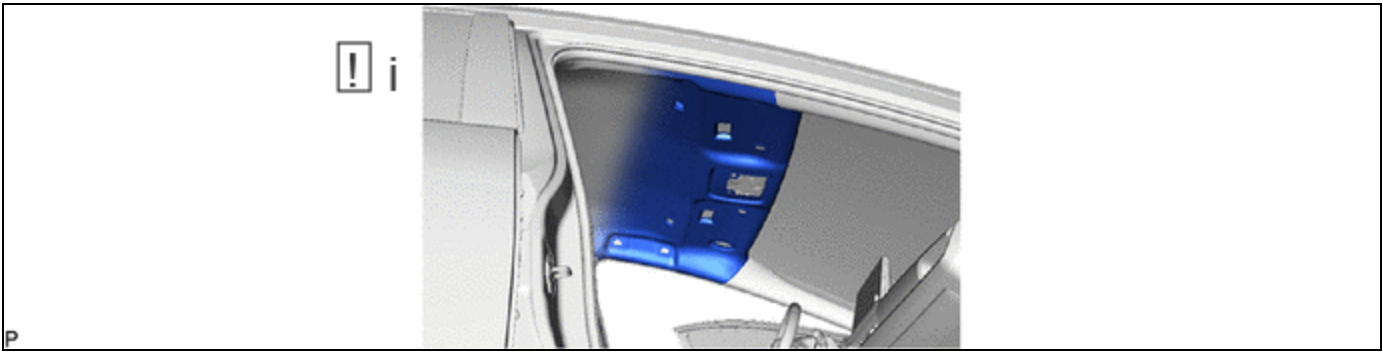


- Connect the connector.

7. INSPECT FOR LEAK AND REPAIR

- Inspect for leaks by the below procedure.
 - After the adhesive has hardened, apply water from the outside of the vehicle. Check that no water leaks into the cabin.
 - If water leaks into the cabin, allow the water to dry and add adhesive.
 - Remove the protective tape.

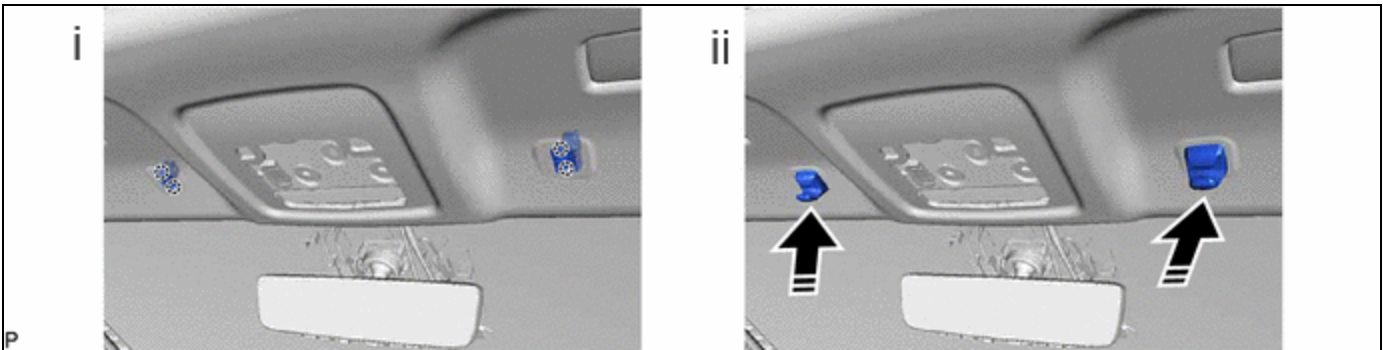
8. INSTALL ROOF HEADLINING ASSEMBLY




(1) Return the front section of the roof headlining assembly to its original position.

NOTICE:

Do not damage the roof headlining assembly or vehicle interior.




	Install in this Direction	-	-
---	---------------------------	---	---

- (1) Engage the 4 claws to install the base of each visor holder.
- (2) Install the 2 visor holders as shown in the illustration.

9. INSTALL VANITY LIGHT ASSEMBLY

10. INSTALL ASSIST GRIP ASSEMBLY


	Click here INFO
---	---------------------------------

11. INSTALL VISOR ASSEMBLY RH

12. INSTALL VISOR ASSEMBLY LH

13. INSTALL MAP LIGHT ASSEMBLY

14. INSTALL FRONT PILLAR GARNISH LH

	Click here INFO
---	---------------------------------

15. INSTALL FRONT PILLAR GARNISH RH

(a) Use the same procedure as for the LH side.

16. CONNECT FRONT DOOR OPENING TRIM WEATHERSTRIP RH**17. CONNECT FRONT DOOR OPENING TRIM WEATHERSTRIP LH****18. INSTALL INNER REAR VIEW MIRROR ASSEMBLY**

w/o EC Mirror: Click here [INFO](#)

w/ EC Mirror: Click here [INFO](#)

for Digital Inner Mirror: Click here [INFO](#)

19. INSTALL RAIN SENSOR (w/ Rain Sensor)

Click here [INFO](#)

20. INSTALL FORWARD RECOGNITION CAMERA

Click here [INFO](#)

21. INSTALL COWL TOP VENTILATOR LOUVER SUB-ASSEMBLY

Click here [INFO](#)

22. INSTALL COWL WATER EXTRACT SHIELD RH**23. INSTALL COWL WATER EXTRACT SHIELD LH****24. INSTALL WINDSHIELD LOWER OUTSIDE MOULDING LH****25. INSTALL WINDSHIELD LOWER OUTSIDE MOULDING RH****26. INSTALL FRONT WIPER ARM AND BLADE ASSEMBLY LH**

Click here [INFO](#)

27. INSTALL FRONT WIPER ARM AND BLADE ASSEMBLY RH

Click here [INFO](#)

28. INSPECT FRONT WIPER ARM AND BLADE ASSEMBLY

Click here [INFO](#)

29. INSTALL SHIELD CAP

30. INSTALL FRONT WIPER ARM HEAD CAP

31. ADJUST FORWARD RECOGNITION CAMERA

- (a) If the forward recognition camera has been replaced with a new one or the windshield glass has been removed and installed, it is necessary to perform Forward Recognition Camera Learning.

HINT:

Forward Recognition Camera Learning can be performed by using either One Time Recognition or Driving Adjustment.

Target Adjustment(One Time Recognition): [Click here](#) 

Driving Adjustment: [Click here](#) 

