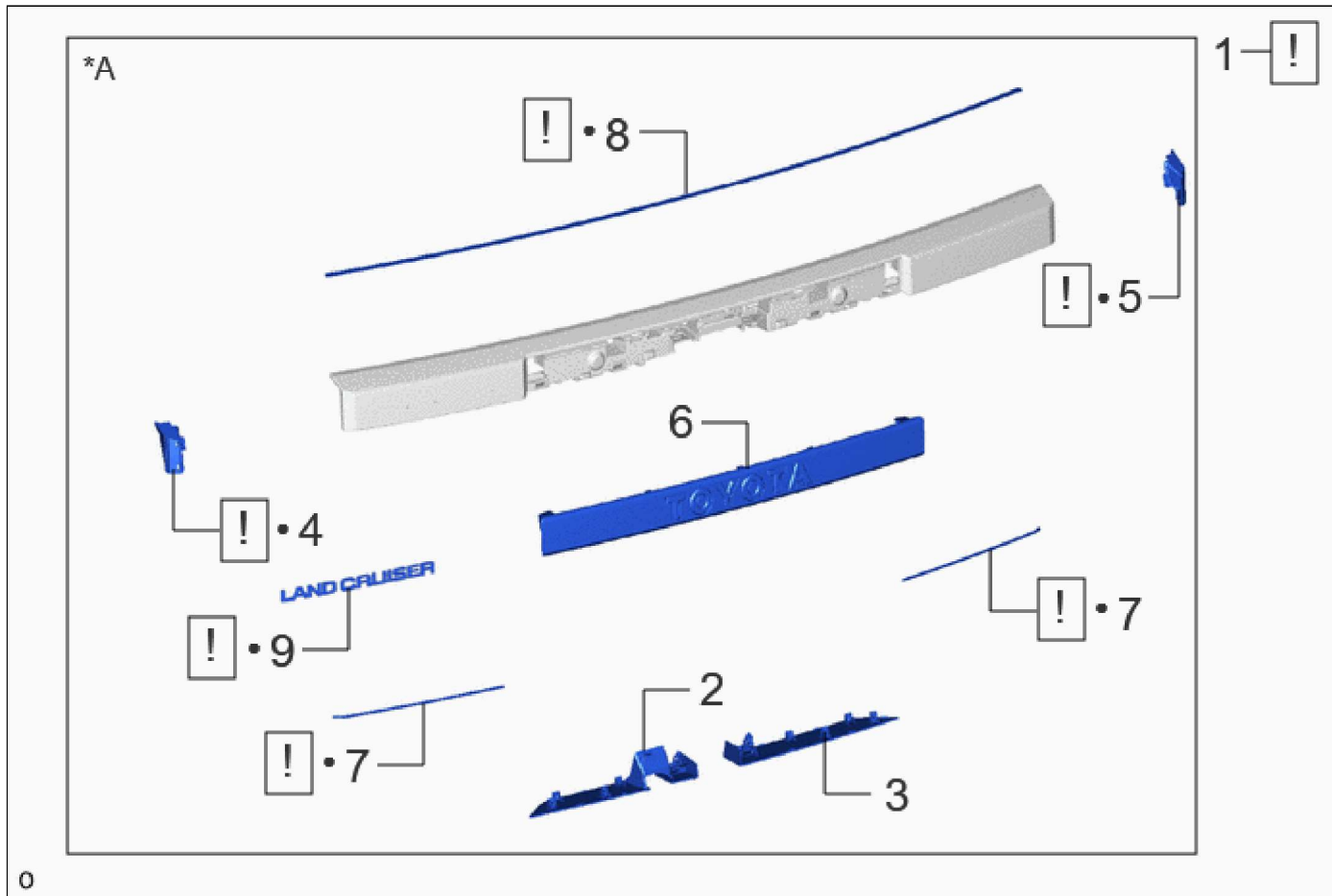





<b>Last Modified:</b> 07-05-2024	6.11:8.1.0	<b>Doc ID:</b> RM100000002K9IW
<b>Model Year Start:</b> 2024	<b>Model:</b> Land Cruiser	<b>Prod Date Range:</b> [02/2024 -     ]
<b>Title:</b> EXTERIOR PANELS / TRIM: BACK DOOR OUTSIDE GARNISH: REASSEMBLY; 2024 MY Land Cruiser [02/2024 -     ]		




## REASSEMBLY

## CAUTION / NOTICE / HINT

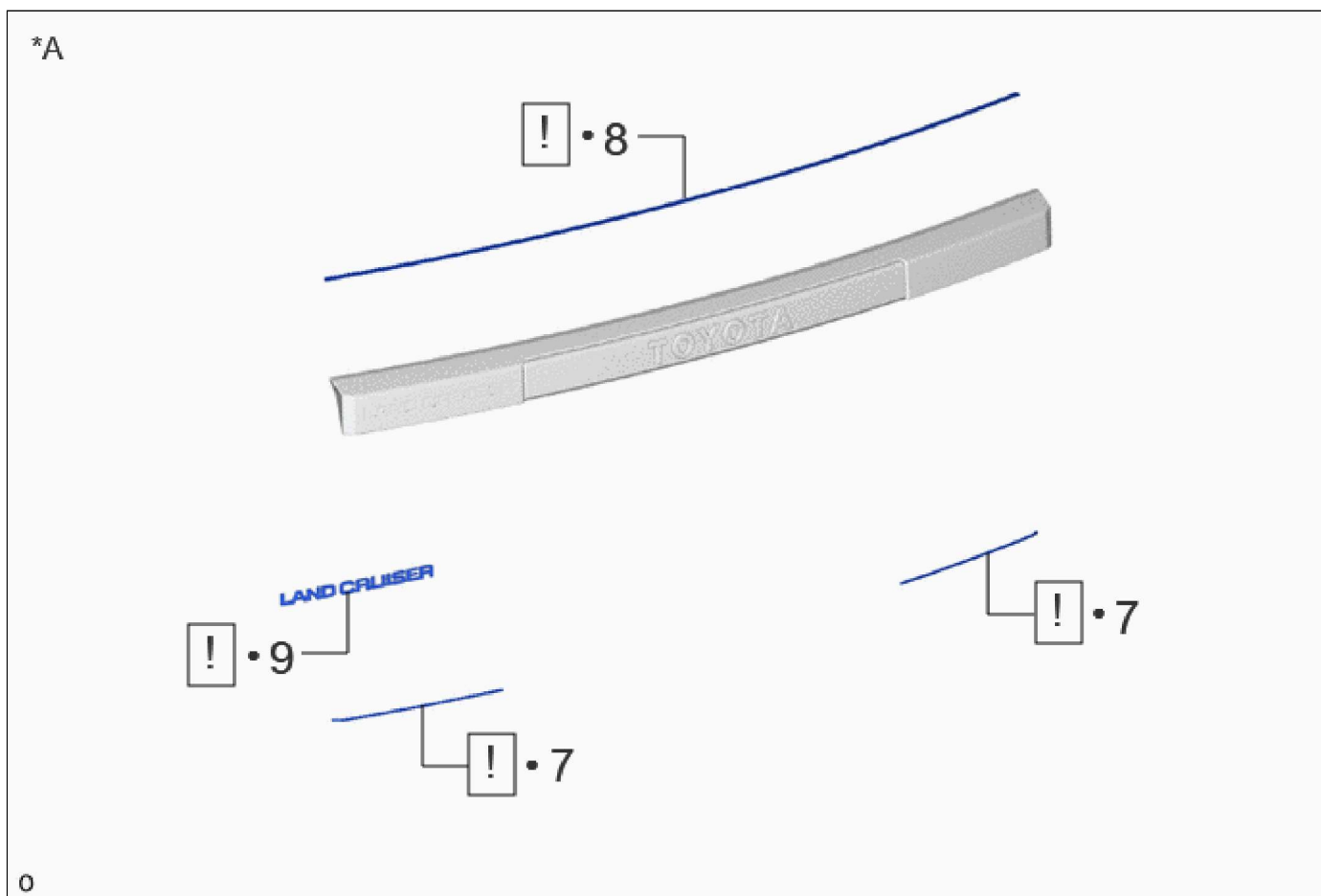
### COMPONENTS (REASSEMBLY)






PROCEDURE		PART NAME CODE			
1	PRECAUTION	-	INFO	-	-
2	LOWER BACK DOOR OUTSIDE GARNISH MOULDING LH	76816B	-	-	-
3	LOWER BACK DOOR OUTSIDE GARNISH MOULDING RH	76815C	-	-	-
4	BACK DOOR GARNISH SIDE PROTECTOR LH	76822D	INFO	-	-
5	BACK DOOR GARNISH SIDE PROTECTOR RH	76821C	INFO	-	-
6	NO. 2 BACK DOOR OUTSIDE GARNISH	76812A	-	-	-

PROCEDURE		PART NAME CODE			
7	BACK DOOR OUTSIDE GARNISH PROTECTOR	76825C	<a href="#">INFO</a>	-	-
8	BACK DOOR OUTSIDE GARNISH PROTECTOR	76825	<a href="#">INFO</a>	-	-
9	NO. 1 REAR NAME PLATE	75441	<a href="#">INFO</a>	-	-

*A	for Type B	-	-
•	Non-reusable part	-	-



PROCEDURE		PART NAME CODE			
7	BACK DOOR OUTSIDE GARNISH PROTECTOR	76825C	<a href="#">INFO</a>	-	-
8	BACK DOOR OUTSIDE GARNISH PROTECTOR	76825	<a href="#">INFO</a>	-	-
9	NO. 1 REAR NAME PLATE	75441	<a href="#">INFO</a>	-	-

*A	for Type A	-	-
•	Non-reusable part	-	-

# PROCEDURE

## 1. PRECAUTION



### NOTICE:

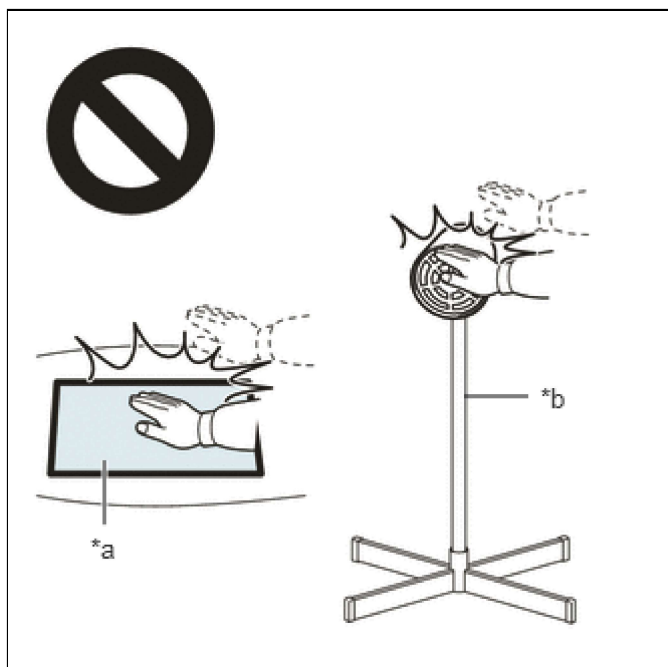
When installing parts with double-sided tape, heat the portion with adhesive and the application surface of the parts and with a heat light.

Standard Value:

PART	TEMPERATURE
Metal parts	40 to 60°C (104 to 140°F)
Resin parts	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

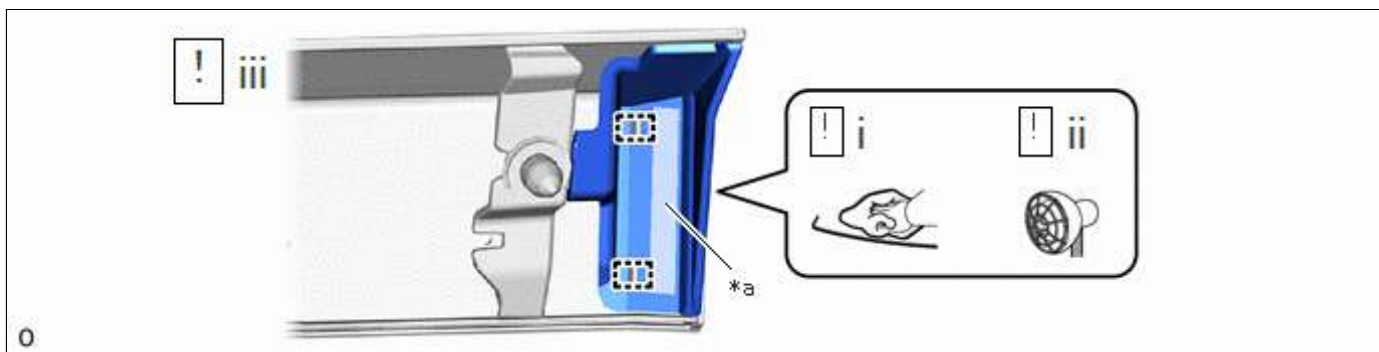
### NOTICE:

Do not heat the parts excessively.

**2. INSTALL LOWER BACK DOOR OUTSIDE GARNISH MOULDING LH (for Type B)**

**3. INSTALL LOWER BACK DOOR OUTSIDE GARNISH MOULDING RH (for Type B)**

**4. INSTALL BACK DOOR GARNISH SIDE PROTECTOR LH (for Type B)**



*a	Double-sided Tape	-	-
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- (1) Clean the surface of the back door outside garnish sub-assembly.
  1. Using a heat light, heat the back door outside garnish sub-assembly surface.
  2. Remove any remaining double-sided tape from the back door outside garnish sub-assembly.
  3. Wipe off any tape adhesive residue with cleaner.

**NOTICE:**

- Installing the back door garnish side protector LH with some double-sided tape remaining may cause poor adhesion. Perform this procedure until the tape is sufficiently removed.
- Make sure to use a cloth when removing. Using a screwdriver, etc., may cause damage and poor adhesion.
- Clean the surface even when using a new part.

- (2) Using a heat light, heat the back door outside garnish sub-assembly and a new back door garnish side protector LH.
- (3) Attach the guide and install the back door garnish side protector LH.

**HINT:**

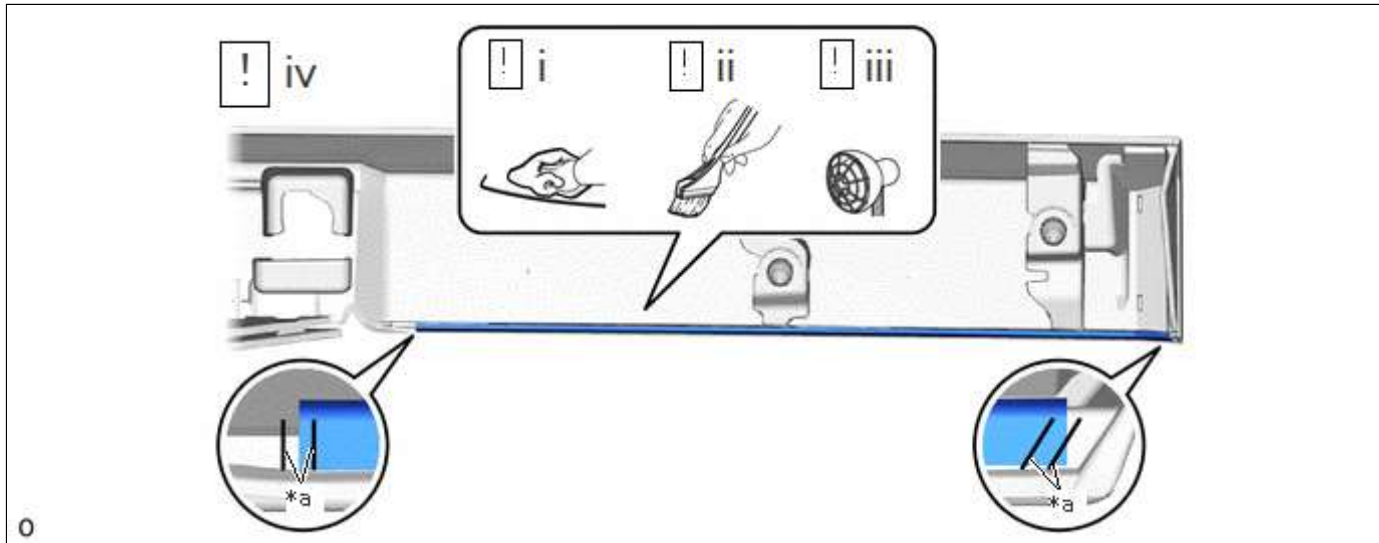
Apply pressure so that it does not lift up from the back door outside garnish sub-assembly.

**5. INSTALL BACK DOOR GARNISH SIDE PROTECTOR RH (for Type B)**

- (a) Use the same procedure described for the LH side.

**6. INSTALL NO. 2 BACK DOOR OUTSIDE GARNISH (for Type B)**

**7. INSTALL BACK DOOR OUTSIDE GARNISH PROTECTOR**



*a	Mark-off Line	-	-
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- (1) Clean the surface of the back door outside garnish sub-assembly.

1. Using a heat light, heat the back door outside garnish sub-assembly surface.
2. Remove any remaining double-sided tape from the back door outside garnish sub-assembly.
3. Wipe off any tape adhesive residue with cleaner.

**NOTICE:**

- Installing the back door outside garnish protector with some double-sided tape remaining may cause poor adhesion. Perform this procedure until the tape is sufficiently removed.
- Make sure to use a cloth when removing. Using a screwdriver, etc., may cause damage and poor adhesion.
- Clean the surface even when using a new part.

(2) Apply primer.

1. Apply primer to the back door outside garnish sub-assembly on the installation area of the back door outside garnish protector using a brush or felt.

**NOTICE:**

- Replace the brush or felt if it is dirty or has become hardened.
- Keep any painted surface free from primer.
- If the primer contacts a painted surface, it may leave light primer marks.
- Do not touch surfaces to which primer has been applied until the back door outside garnish protector has been attached.

2. Let the primer dry sufficiently.

**NOTICE:**

Do not touch applied surfaces until the primer is dry.

Recommended drying time:

10 minutes or more (at 23°C (73°F))

- (3) Using a heat light, heat the back door outside garnish sub-assembly and a new back door outside garnish protector.
- (4) Install the back door outside garnish protector so that it fits inside the mark-off line as shown in the illustration.

**NOTICE:**

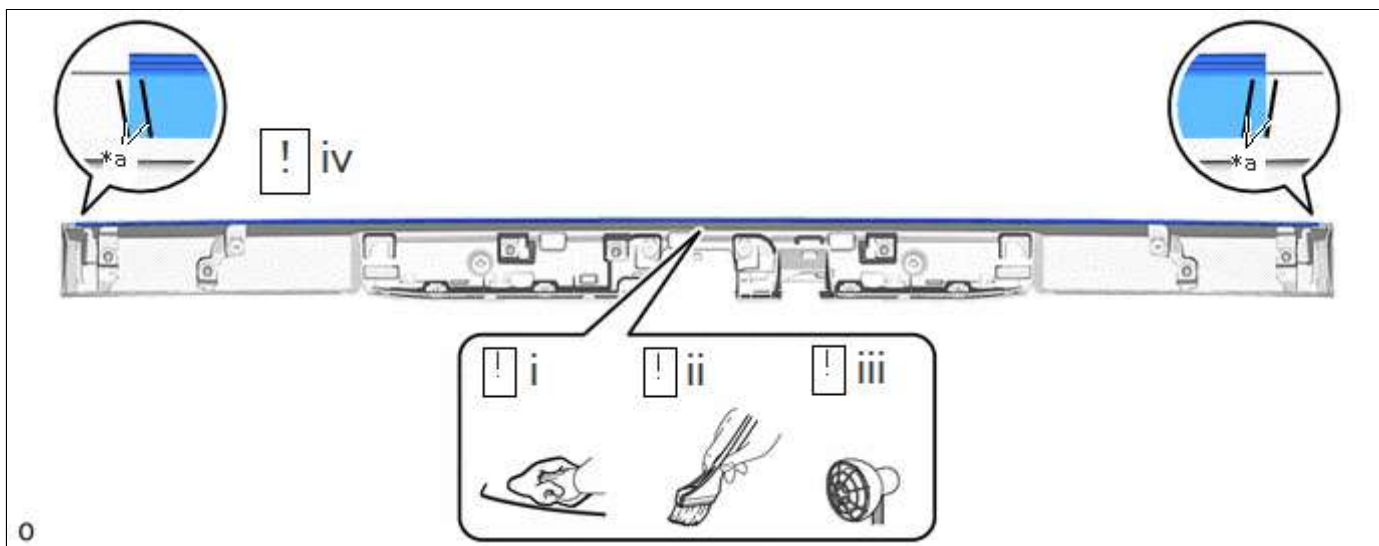
The application strength of the back door outside garnish protector will weaken if reapplied. If reapplication is necessary, be sure to replace it with a new one.

**HINT:**

Apply pressure so that it does not lift up from the back door outside garnish sub-assembly.

- (b) Use the same procedure for the other side.

## **8. INSTALL BACK DOOR OUTSIDE GARNISH PROTECTOR**



*a	Mark-off Line	-	-
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(1) Clean the surface of the back door outside garnish sub-assembly.

1. Using a heat light, heat the back door outside garnish sub-assembly surface.
2. Remove any remaining double-sided tape from the back door outside garnish sub-assembly.
3. Wipe off any tape adhesive residue with cleaner.

**NOTICE:**

- Installing the back door outside garnish protector with some double-sided tape remaining may cause poor adhesion. Perform this procedure until the tape is sufficiently removed.
- Make sure to use a cloth when removing. Using a screwdriver, etc., may cause damage and poor adhesion.
- Clean the surface even when using a new part.

(2) Apply primer.

1. Apply primer to the back door outside garnish sub-assembly on the installation area of the back door outside garnish protector using a brush or felt.

**NOTICE:**

- Replace the brush or felt if it is dirty or has become hardened.
- Keep any painted surface free from primer.
- If the primer contacts a painted surface, it may leave light primer marks.
- Do not touch surfaces to which primer has been applied until the back door outside garnish protector has been attached.

2. Let the primer dry sufficiently.

**NOTICE:**

Do not touch applied surfaces until the primer is dry.

Recommended drying time:

10 minutes or more (at 23°C (73°F))

- (3) Using a heat light, heat the back door outside garnish sub-assembly and a new back door outside garnish protector.
- (4) Install the back door outside garnish protector so that it fits inside the mark-off line as shown in the illustration.

**NOTICE:**

The application strength of the back door outside garnish protector will weaken if reapplied. If reapplication is necessary, be sure to replace it with a new one.

**HINT:**

Apply pressure so that it does not lift up from the back door outside garnish sub-assembly.

## 9. INSTALL NO. 1 REAR NAME PLATE



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