

TOYOTA

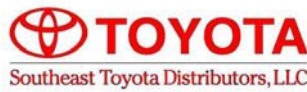
Avalon

2015

REAR LIP SPOILER

Part Number: 00016-07012

Accessory Code: CX10



Conflicts

Note:

Kit Contents

Item #	Quantity Req'd.	Description
1	1	Rear Lip Spoiler
2	1	Hardware Bag

Hardware Bag Contents

Item #	Quantity Req'd.	Description
1	3	M6 Nuts

Additional Items Required For Installation

Item #	Quantity Req'd.	Description
1	1	00016-07022 Mylar Drill Template

Recommended Tools

Safety Tools	
Safety Glasses	
Special Tools	
Magnetic Fishing Tool	
Protective Blanket	
Installation Tools	
Wiping Cloth	Non-Scratch, Lint Free
White Poly Tape	
Drill	
3/8" Drill bit	
3/8" Drill Stop	
1/4" Torque Wrench	
1/4" Drive Ratchet	
1/4" Drive Socket (10mm)	
6" x 1/4" Drive Extension	
1/4" Universal Joint	
Deburring Tool	
3M Auto Body Sealer	
Vacuum	
White Stick/Pry Tool	
Special Chemicals	
Cleaner	Isopropyl Alcohol-Based
	Water 50:50

Color Applicability/ Trim Level

Vehicle/Trim Color	Accessory Color	00016-07012-21	00016-07012-02	00016-07012-03	00016-07012-05	00016-07012-10	00016-07012-11	00016-07012-13
Celestial Silver Metallic		X						
Attitude Black (218)			X					
Sizzling Cimson Mica (3R0)				X				
Champagne Mica (5B2)					X			
Blizzard Pearl (070)						X		
Magnetic Gray Metallic (1G3)							X	
Moulin Rouge Mica (3T0)								X

General Applicability

Note: Avalon Models 2015

Recommended Sequence of Application

Item #	Accessory
1	Rear Lip Spoiler

Legend

- STOP:** Damage to the vehicle may occur. Do not proceed until process has been complied with.
- OPERATOR SAFETY:** Use caution to avoid risk of injury.
- CAUTION:** A process that must be carefully observed in order to reduce the risk of damage to the accessory/vehicle and to ensure a quality installation.
- TOOLS & EQUIPMENT:** Used in Figures calls out the specific tools and equipment recommended for this process.
- REVISION MARK:** This mark highlights a change in installation with respect to previous issue.
- SAFETY TORQUE:** This mark indicates that torque is related to safety.

SPECIAL NOTE:

After TMS and Safety mandated preparatory steps have been taken, the installation sequence is the suggested method for completing the accessory installation. In some instances the suggested sequence is written for one associate to install and in others the sequence is given as part of a team accessory installation. Unless otherwise stated in the document, the associates may perform the installation steps in any order to make the installation as efficient as possible while maintaining consistent quality.



Care must be taken while installing this accessory to ensure damage does not occur to the vehicle. Use approved guidelines to insure a quality installation.

These guidelines can be found in the “Accessory Installation Practices” document.



A. Installation Preparation

1. Verify that the part is for the correct vehicle model and that it fits the vehicle properly.
2. During installation, the vehicle, the part, and the tape MUST be between 60° and 110° F for proper adhesion. Failure to follow proper installation procedure may result in the part not functioning correctly.
3. Inspect the vehicle and parts for damage prior to installing the Rear Lip Spoiler.

Paint: Prepare part surfaces per Toyota paint standards. Do not use lacquer thinner or enamel reducer as a degreaser.

4. Make sure that all Rear Lip Spoiler installation surfaces are free of dirt and/or grease. (FIG. 1)
Use a clean, lint-free cloth and isopropyl alcohol-based cleaner.
5. Open trunk & place a protective blanket that covers inside trunk over rear bumper & lower portion of rear window. (Fig.2)
6. Remove fasteners and trunk lid liner. Retain fasteners for re-installation. (FIG. 3)
7. Mask deck lid with approved tape to protect finish. (FIG. 4)





B. Drilling Procedure DIO



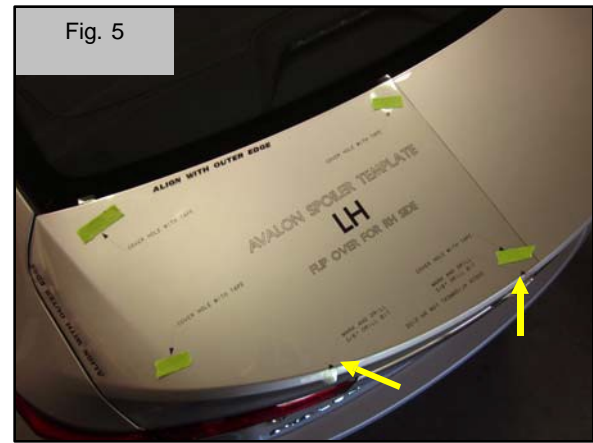
Locate the drill template onto the LH side of the trunk lid and secure with masking tape (Make sure the letters "LH" face up) Using a spring loaded center punch, mark two (2) holes through the cross hairs of the template to the trunk lid. Flip template over and locate onto the RH side of trunk lid, securing with approved tape. Using a spring loaded center punch, mark one (1) hole through the cross hairs of the template to the trunk lid. See FIG 5.



2. Remove template and drill a 1/8" (3mm) hole at each of the locations marked in Step 3. Using a step drill bit, enlarge the holes to the final size of 3/8" (10mm). *Note: Do not use excessive force while drilling.* Thoroughly debur all holes using deburring tool. Remove all shavings from drilling and deburring using an air gun See FIG 6.



HINT: Use vacuum when drilling to collect metal shavings.





C. Drilling Procedure PIO



1. Position drilling fixture on trunk lid aligning it as shown. Ensure the side and rear guides are aligned with the edges of trunk and index entire fixture forward (FIG 7).



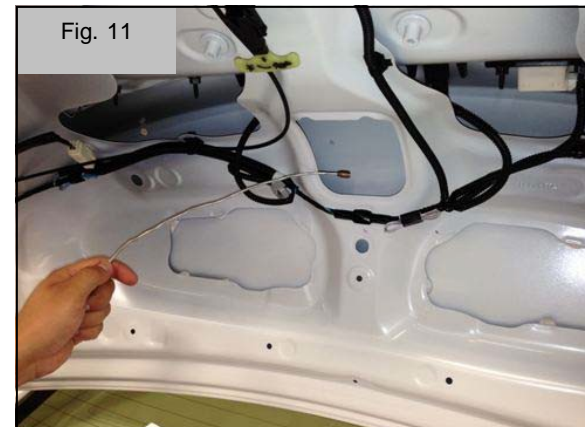
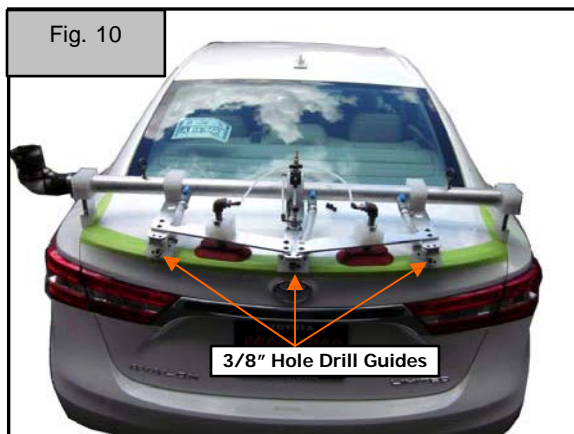
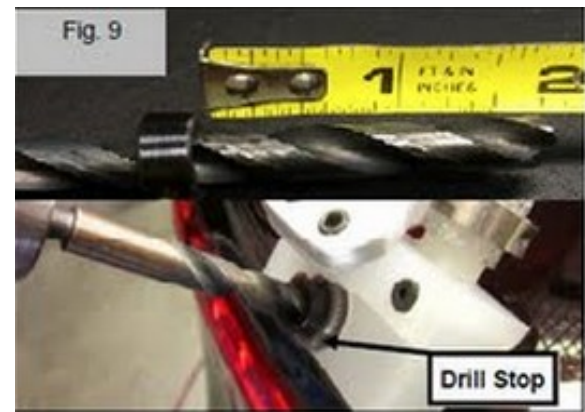
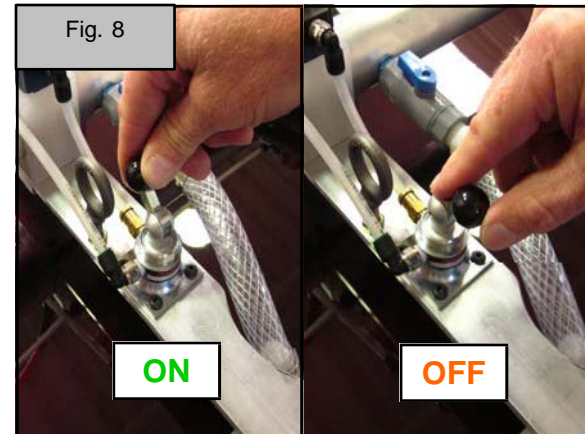
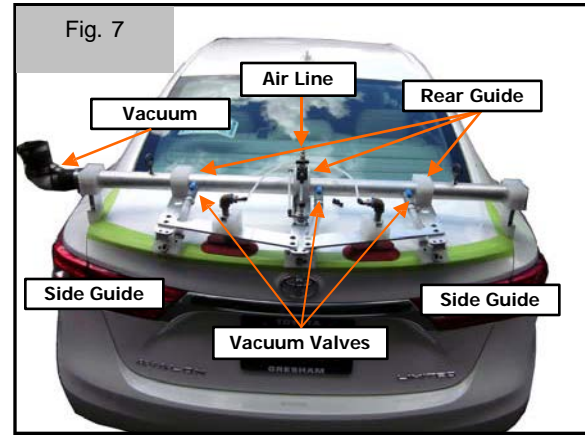
2. Secure the fixture to the trunk lid by toggling the air valve to the "on" position (FIG 8). Ensure all suction cups are properly sealed to trunk lid.



3. Turn vacuum source on. Place specified drill stop over drill bit (Fig 9) 1-3/4" from cutting edge of bit and proceed to drill 3/8" holes at the three locations in fixture (FIG 10).

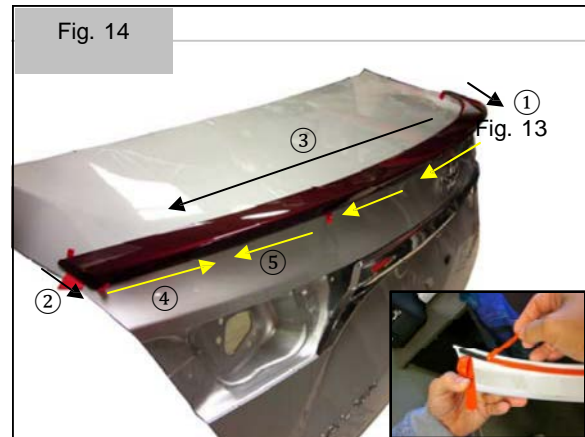
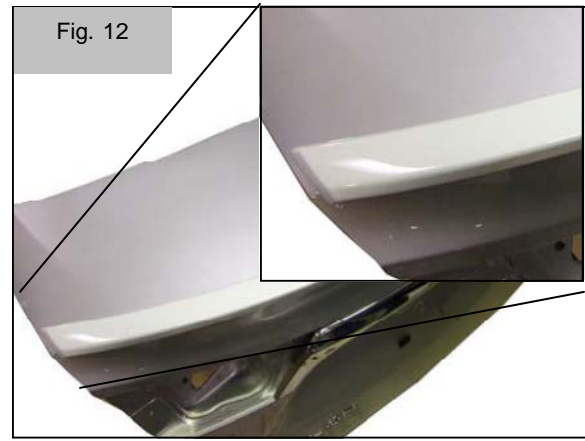


4. Deburr using vacuum to remove shavings.
5. Use Magnetic fishing tool to remove any stray metal fragments. (FIG 11).



D. PIO/DIO Installation

1. Remove rubber stud covers from spoiler studs.
2. Test fit Spoiler onto trunk lid. Align studs on spoiler to holes drilled in trunk lid. Confirm side-to-side alignment of spoiler on trunk lid. Make sure spoiler is even left to right (FIG 12).
3. Remove Spoiler, thoroughly clean trunk lid using 50/50 Isopropyl Alcohol/Water mixture and allow to dry completely. Apply 3M Auto Body Sealant exposed metal around holes (FIG 13).
4. Fold tape liner leaders to outer surface of spoiler for accessibility during installation. Peel liners about 1" from end. Install Spoiler onto trunk lid. Align studs on spoiler to holes drilled in trunk lid. Ensure that tape liner pull tabs are accessible. Fit spoiler to edge with equal distance from edge on both sides. Remove front, rear, and side tape liners in the order and direction specified in (FIG 14). Apply pressure to spoiler after each piece of tape is removed .
5. Using a soft cloth and working from the center outward, apply even pressure along the entire top edge of the rear spoiler. Repeat this step three times. (FIG 15).





PIO/DIO Installation

With the trunk lid open, use a ratchet socket (10mm), extension and universal joint to start M6 nuts onto each spoiler stud. Use a torque wrench to tighten each nut to 30 in.lbs. in the order shown (FIG 17).

8. Vacuum any metal shavings from trunk and trunk lid
9. Replace trunk liner using factory fasteners removed in Step A-6. Installation complete.



<p><u>Check:</u></p> <p><u>Accessory Function Check</u></p> <p>Visual Alignment</p> <p>Gaps between spoiler and trunk lid</p> <p>Vehicle function checks</p>	<p><u>Look For:</u></p> <p>Spoiler should be centered on trunk, +/- 2mm tolerance side to side.</p> <p>Excess gaps greater than 2mm</p> <p>Open and close trunk to ensure the spoiler does not interfere with regular trunk operation.</p>
<p><u>Vehicle Appearance Check:</u></p> <p>After accessory installation and removal of protective covers, perform a visual inspection</p>	<p>Ensure no damage (including scuffs and scratches) was caused during the installation process.</p> <p>(For PPO installations, refer to TMS Accessory Quality Shipping Standard)</p>

