

Part Number: PT47A-21051-XX

NOTE: Part number of this accessory may not be the same as the part number shown.

Kit Contents

Item #	Quantity Reqd.	Description
1	1	Painted Spoiler Assembly
2	1	Hardware Bag

Hardware Bag Contents

Item #	Quantity Reqd.	Description
1	2	M6 Hex Nuts
2	2	2 Plastic Grommets

Additional Items Required For Installation

Item #	Quantity Reqd.	Description
1	1	DIO Install Kit P/N PT47A-2105L

Conflicts

None

Recommended Tools

Personal & Vehicle Protection	Notes
Wrist and Belt Buckle Protectors	
Blankets	
Shop Rags	
Masking Tape	
Special Tools	Notes
None	
Installation Tools	Notes
Drill Motor	1/2"
Twist Drill Bit	1/8", 5/16", 3/8"
Hole Cutter	13/16"
Drill Stops	
Center Punch	
Hex Nut Driver	10 mm
Deep Well Socket	10 mm
Socket Extension	3"
Ratchet	
Torque Wrench	0-100 lbf-in
Fastener Removal Tool	
Nylon Removal Tool	e.g. Panel Pry Tool #1 Toyota SST # 00002-06001-01
Shop Vacuum	
Hole Deburring Tool	
Magnet With Flex Shaft	
Screwdriver	Phillips Head #2
Small Parts Bin	

Special Chemicals	Notes
3M Ultra-Pro Body Sealant	
3M Prep Solvent-70	

General Applicability

All Scion tC Models

Recommended Sequence of Application





Item #	Accessory
1	None
2	
3	

*Mandatory

Vehicle Service Parts (may be required for reassembly)

Item #	Quantity Reqd.	Description
1		Fastener
2		White Panel Fastener, P/N 67771-89104

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.

Care must be taken when installing this accessory to ensure damage does not occur to the vehicle. The installation of this accessory should follow approved guidelines to ensure a quality installation.

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

This document covers such items as:-

- Vehicle Protection (use of covers and blankets, cleaning chemicals, etc.).
- Safety (eye protection, rechecking torque procedure, etc.).
- Vehicle Disassembly/Reassembly (panel removal, part storage, etc.).
- Electrical Component Disassembly/Reassembly (battery disconnection, connector removal, etc.).

Please see your Toyota dealer for a copy of this document.

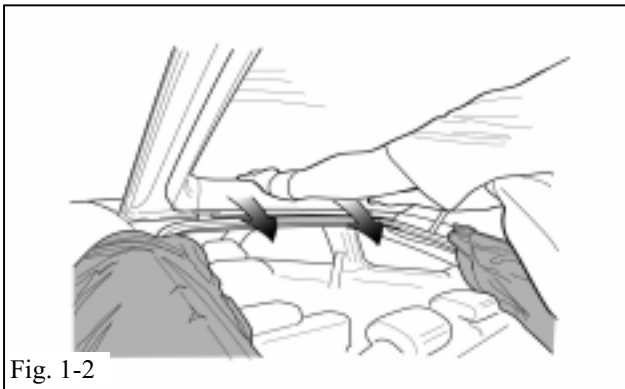
1. Trim Panel Removal.

(a) Open the Lift Gate.

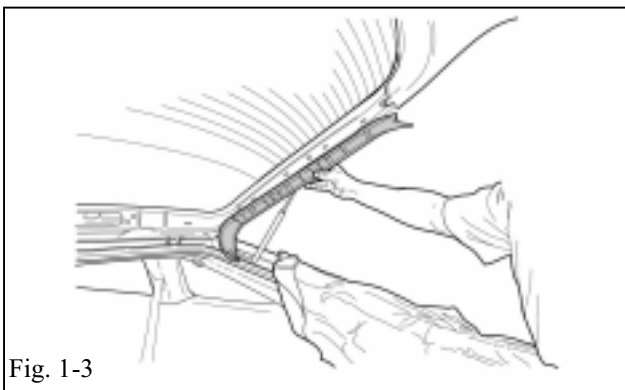
(b) Place blankets inside the cargo area and the lift gate opening. (Fig. 1-1)

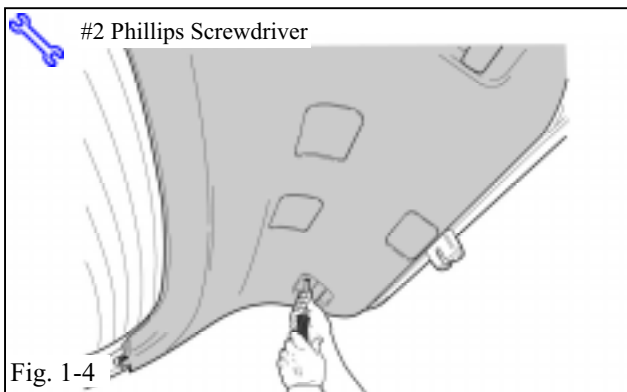


(c) Remove the trim panel across the inside of the lift gate window. (Fig. 1-2)

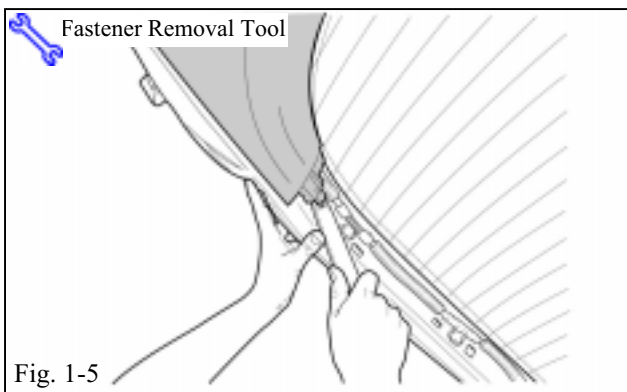


(d) Remove the LH and RH trim panels on the sides of the lift gate window. (Fig. 1-3)



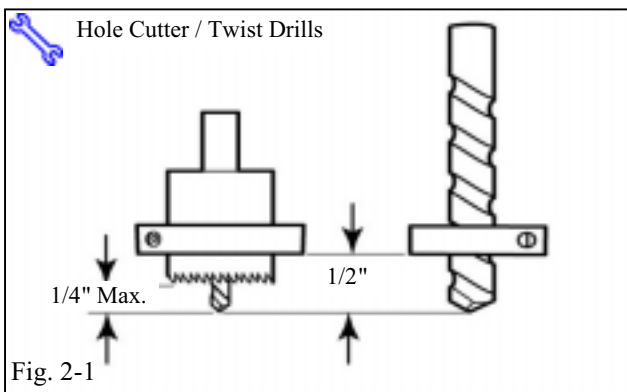


(e) Remove the two Phillips screws just above each handle pull on the lift gate trim panel. (Fig. 1-4)



(f) Remove the two fasteners at the top of the lift gate trim panel and remove the panel. (Fig. 1-5)

2. Hole Drilling



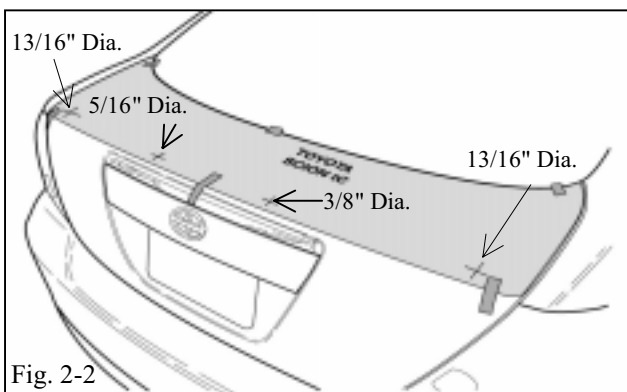
(a) Eye protection must be worn during all hole drilling.



(b) Set all drill stops to 1/2". (Fig. 2-1)

(c) Apply masking tape to the lift gate surface in the areas of the hole locations.

NOTE: The above step is not necessary if the lift gate surface is covered with protective polywrap.

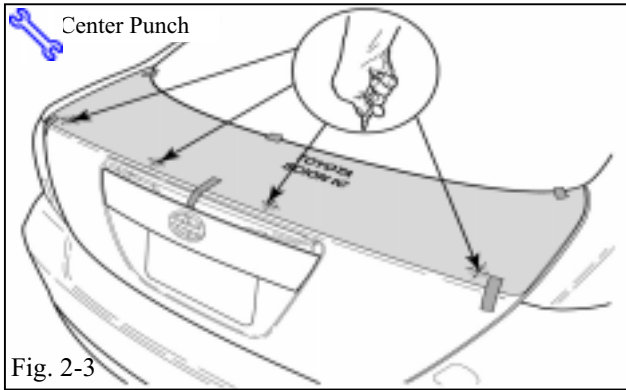


(d) Place the drilling template on the vehicle as shown. Tape in place, making sure template is completely smooth and flat on trunk lid surface. (Fig. 2-2)

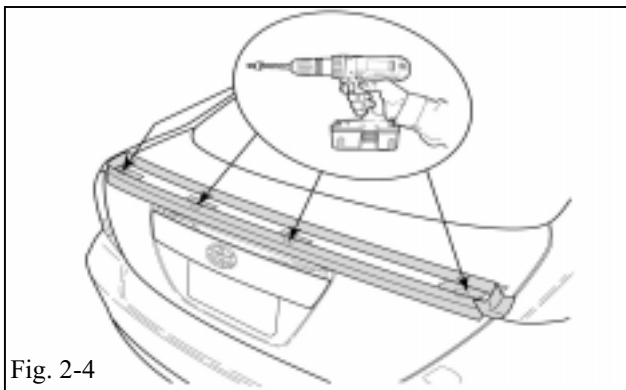
(e) Locate the four (4) hole locations on the template.



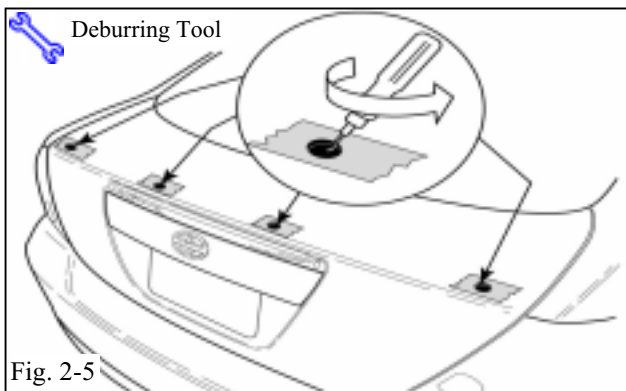
NOTE: The hole centers are punch marks within the segmented circles. The punch marks must be located and used for proper spoiler alignment.



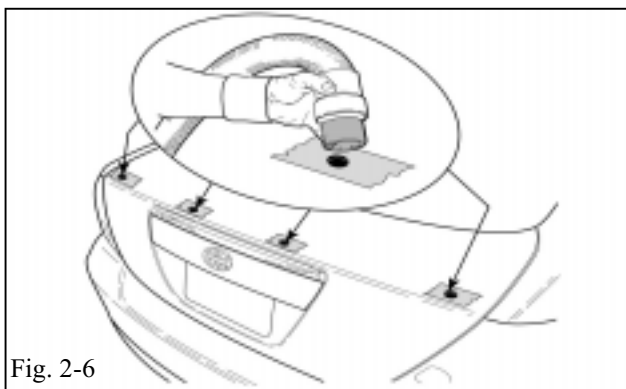
- (f) Using a center punch, punch the centers of the four (4) hole locations. (Fig. 2-3)
- (g) Remove the template. Make sure you can see all four (4) punch marks.



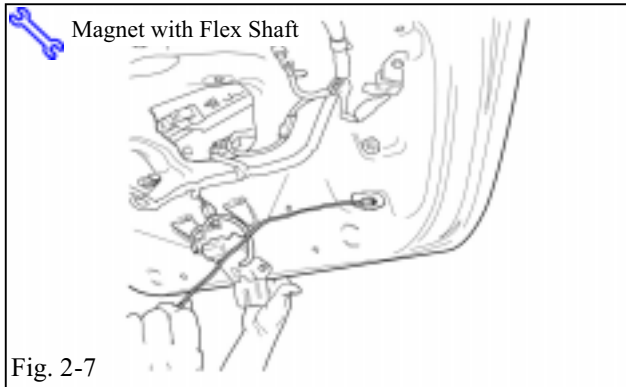
- (h) Using the 1/8" drill bit, drill a pilot hole at all four (4) locations. (Fig. 2-4) Enlarge all holes to the sizes shown. (Fig. 2-2)



- (i) Using a deburring tool, carefully deburr the four (4) drilled holes. (Fig. 2-5)

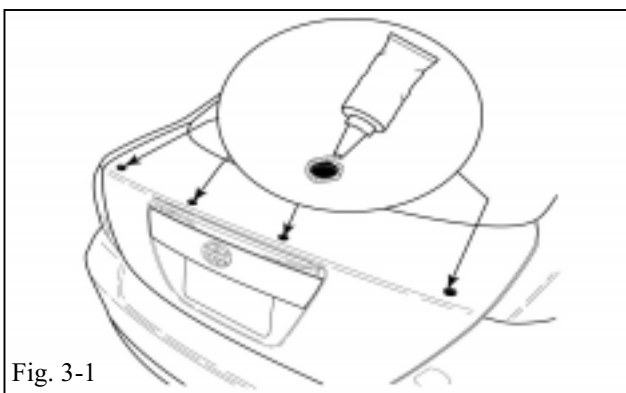


- (j) Vacuum the surface of the trunk lid and the surrounding drilled areas and remove masking tape. (Fig. 2-6)



- (k) Use a magnet with a flexible shaft to remove any remaining metal chips/discs from the drilling process. (Fig. 2-7)

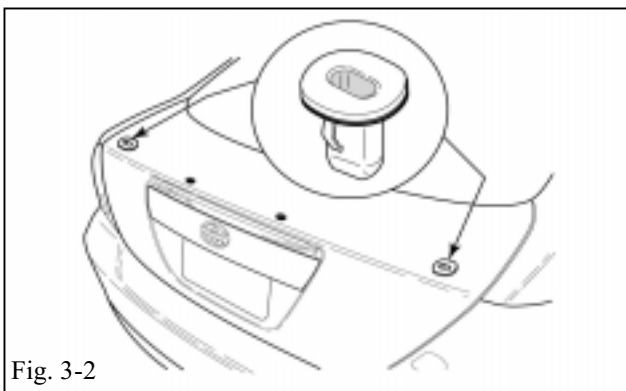
3. Preparation for Spoiler Attachment



- (a) The trunk lid where the spoiler attaches must be cleaned with 3M Prep Solvent-70 and a lint free cloth.

- (b) After cleaning, carefully apply 3M Ultra-Pro Body Sealant to all drilled hole edges. (Fig. 3-1)

- (c) The trunk and spoiler should be a minimum of 60° F for proper set-up of adhesive tape. Use a hot air blower to heat the surface if the temperature is below 60° F. The adhesive tape on the spoiler must have full contact between spoiler and trunk lid for proper sealing to trunk lid.



- (d) Snap a white plastic grommet in each of the two outer 13/16" diameter holes with the long axis oriented as shown. (Fig 3-2)

4. Attaching the Spoiler to the Lift Gate.



- (a) Remove the plastic liners from adhesive tape pads. Be careful not to touch or allow any contaminants to come into contact with adhesive pads.

- (b) Position the spoiler over the lift gate with the drill holes aligned to the spoiler studs. Use your finger tips to ensure the spoiler is centered side to side on the lift gate. (Fig. 4-1)



Fig. 4-2

(c) Lower the spoiler down into place and press down to fully seat grommets. Continue to apply pressure to ensure complete adhesion of the spoiler to lift gate surface. (Fig. 4-2)



(d) Open the trunk lid and install the two (2) nuts to the studs. Tighten the nuts to 53 lbf-in of torque.

5. Reassemble the Vehicle

(a) Reinstall all removed panels and parts. Be sure that all the panel clips are engaged.

Checklist - these points **MUST** be checked to ensure a quality installation.

<u>Check:</u>	<u>Look For:</u>
<u>Accessory Function Checks</u> <input type="checkbox"/> Check for spoiler alignment. <input type="checkbox"/> Check for full tape adhesion.	 Centered from side to side. Full adhesion with no gaps.
<u>Vehicle Function Checks</u> <input type="checkbox"/> None Required	