

Preparation

Part Number: 08150-52880-XX**NOTE:** Part number of this accessory may not be the same as the part number shown.**Kit Contents**

Item #	Quantity Req'd.	Description
1	1	Rear Spoiler
2	1	Hardware Bag
3	3	Drilling Template
4	1	Installation Instructions

Hardware Bag Contents

Item #	Quantity Req'd.	Description
1	2	Well Nut
2	2	Bolt (M5 x 18)
3	2	Cover

Additional Items Required For Installation

Item #	Quantity Req'd.	Description

Conflicts

None

Recommended Tools

Personal & Vehicle Protection	Notes
Wrist and Belt Buckle Protectors	
Blankets	
Shop Rags	
Masking Tape	2" wide
Special Tools	Notes
Non Intrusive IR Temperature Probe/Gun	
Installation Tools	Notes
Drill Motor	1/2"
Twist Drill Bits	3.0mm, 8.0mm, 10mm
Drill Stops	3.0mm, 8.0mm, 10mm
Screw Driver	Phillips Head
Tape Measure	Metric
Wire or String	
Scissors	
Torque Wrench	0-100 lbf-in
Shop Vacuum	
Hole Deburring Tool	
Magnet With Flex Shaft	
Panel Fastener Removal Tool	
Heat Gun	
Small Parts Bin	
Center Punch	
Lint Free Cloth	

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

General Applicability

All Yaris models (3 door and 5 door)

Recommended Sequence of Application

Item #	Accessory
1	None
2	

*Mandatory

Vehicle Service Parts (may be required for reassembly)

Item #	Quantity Req'd.	Description
1		
2		
3		

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.

Procedure

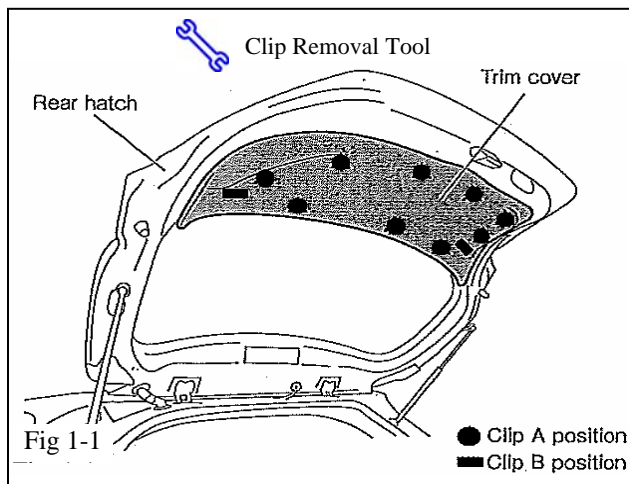
Care must be taken when installing this accessory to ensure damage does not occur to the vehicle. The installation of this accessory should follow approved guidelines to ensure a quality installation.

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

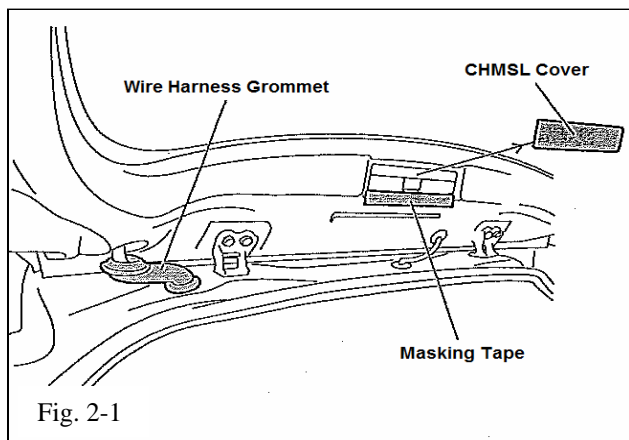


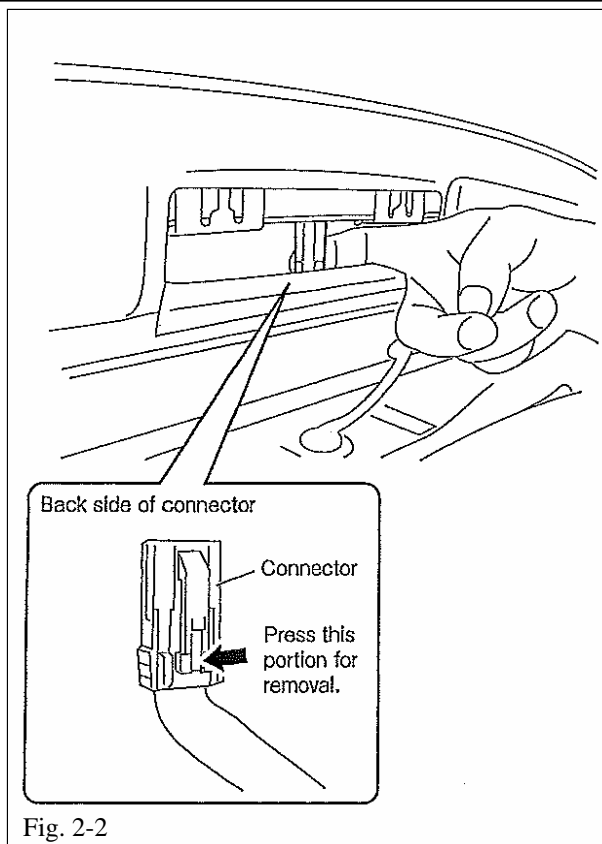
- (a) Open the rear hatch and remove the trim cover (Clip A at nine locations) (Fig. 1-1).
- (b) Remove the remaining clips B from the rear hatch and install them on the trim cover (Clip B at two locations) (Fig. 1-1).

2. CHMSL Wire Harness Removal

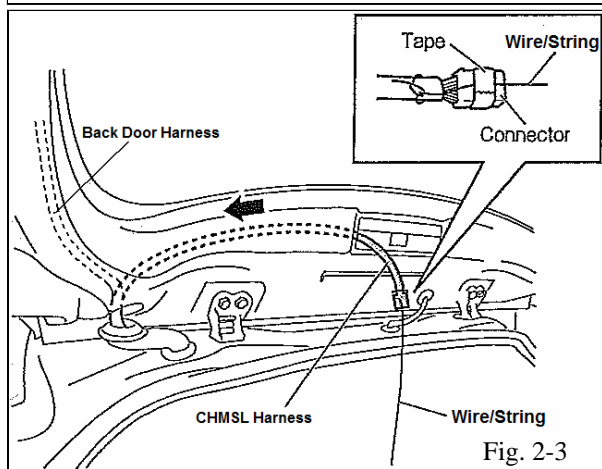


- (a) Remove the wire harness grommet from the rear hatch (Fig. 2-1).
- (b) Remove the CHMSL cover and apply masking tape to the opening to protect from sharp edge as shown in Fig.1-2.





- (c) Remove the connector from the CHMSL light as shown in Fig. 2-2.

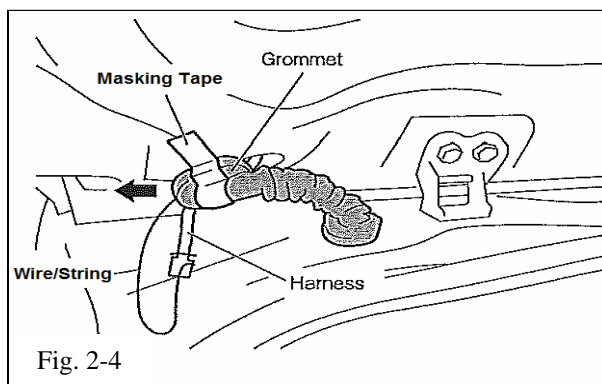


- (d) Tie and tape a wire or string on the removed connector (Fig. 2-3).



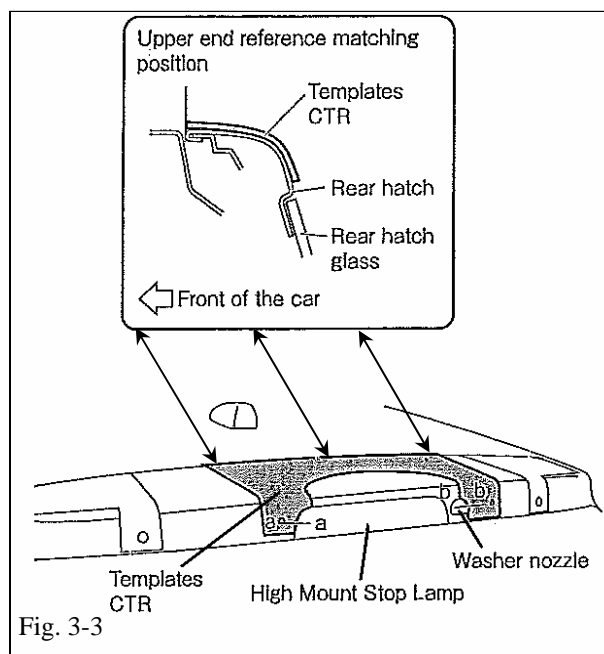
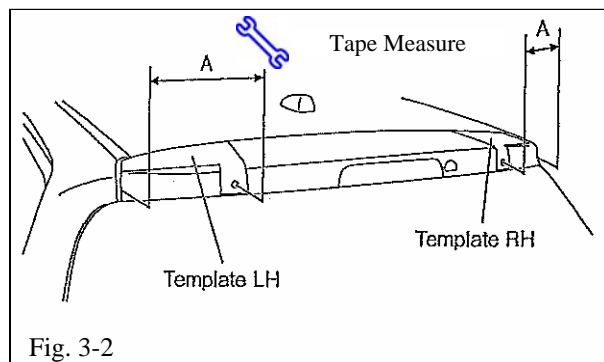
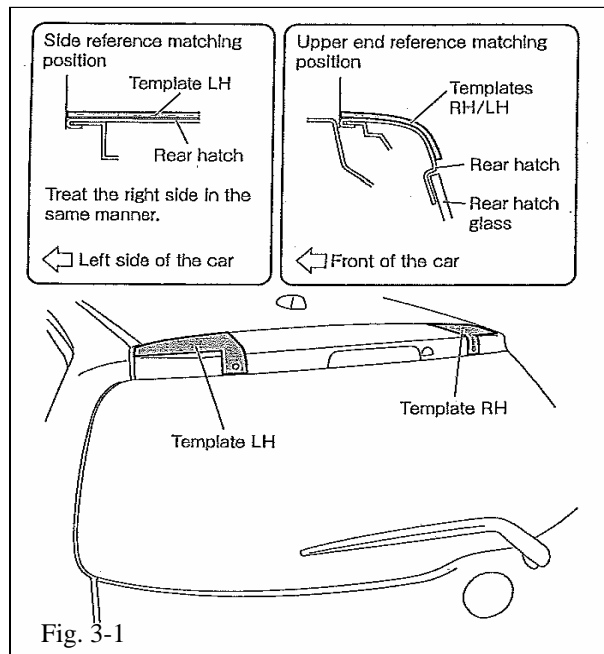
- (e) Carefully pull only the CHMSL harness from the grommet side through the CHMSL opening and out the grommet hole. Make sure the end of the wire/string hangs out the CHMSL opening in order to pull the wire harness back through after drilling (Fig 2-3).

CAUTION: Careful when removing the CHMSL Harness not to damage/pull out the Back Door Harness.



- (f) Using masking tape, tape the pulled out harness and grommet to the rear hatch (Fig. 2-4).

Procedure



3. Drilling Template Placement

- (a) Place and tape the LH and RH paper drilling templates to the outer top corners of the rear hatch.

(1) Align the black edges of the paper drilling template to the outer edges of the rear hatch (Fig. 3-1).



- (b) Measure the dimension “A” along the surface of the LH and RH drilling templates by using a measuring tape to make sure each side is properly positioned. A: Dimension along the surface = 192mm (Fig. 3-2).

(1) If the measured dimension does not indicate the above value, make the appropriate adjustments and reattach the LH and RH templates.

- (c) Place and tape the center (CTR) drilling template around the CHMSL Light and washer nozzle (Figs. 3-3 & 3-4).

(1) The black leading edge of the CTR drilling template is positioned flush with the leading edge of the rear hatch (Fig 3-3).

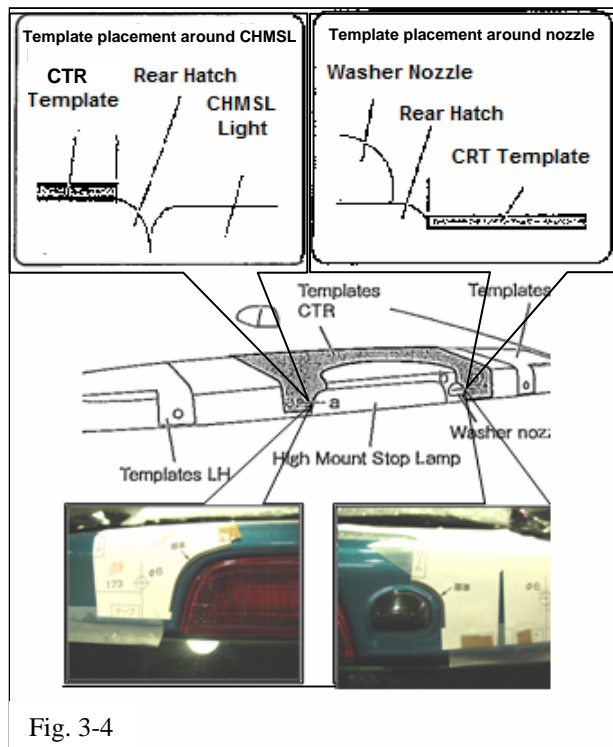


Fig. 3-4

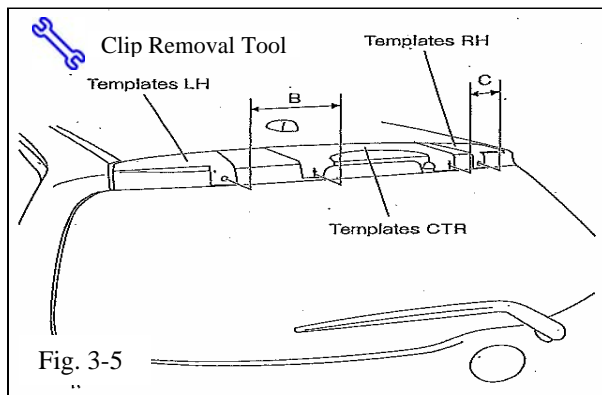


Fig. 3-5

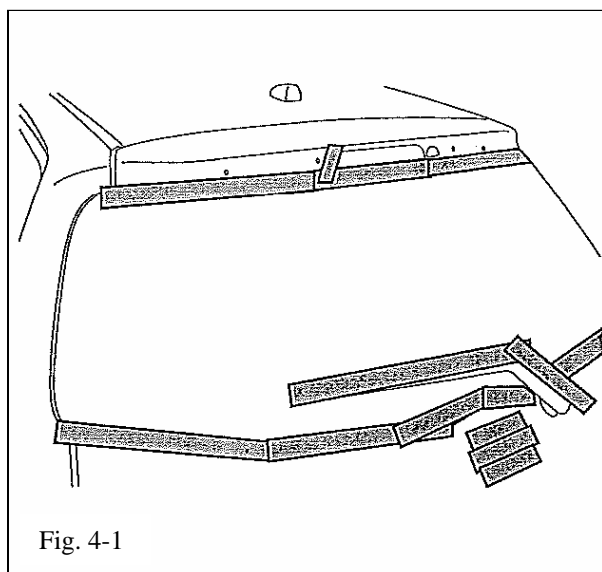


Fig. 4-1



(2) Position the right side of the CTR drilling template to the washer nozzle as shown in Fig. 3-4. Note that the sheet metal surrounding the washer nozzle has a raised edge around the washer nozzle perimeter. The black edge of the template aligns to the washer nozzle sheet metal perimeter before the sheet metal rises to the washer nozzle.

(3) Position the left side of the CTR drilling template to the radius of the CHMSL sheet metal (Fig.3-4).



(d) Measure the hole-to-hole distances “B” and “C” on the drilling templates by using a tape measure to make sure the CTR drilling template has been correctly set. B: hole-to-hole distance = 173mm and C: hole-to-hole distance = 105mm.

(1) If the measured dimension does not indicate the above value, make the appropriate adjustments and reattach the CRT drilling template (Fig 3-5).

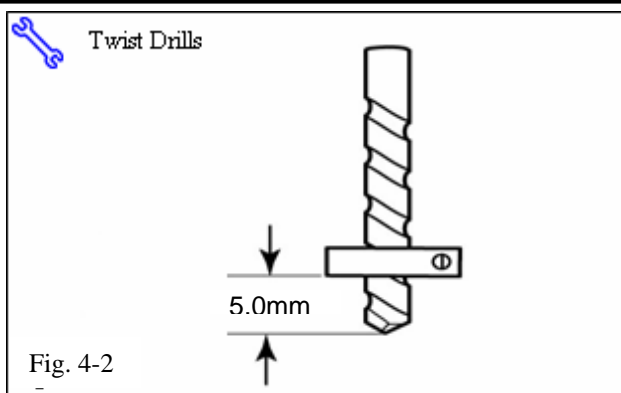
(e) Center punch the center of each of the four (4) holes on the template and remove all three (3) drilling templates.

4. Drilling Holes

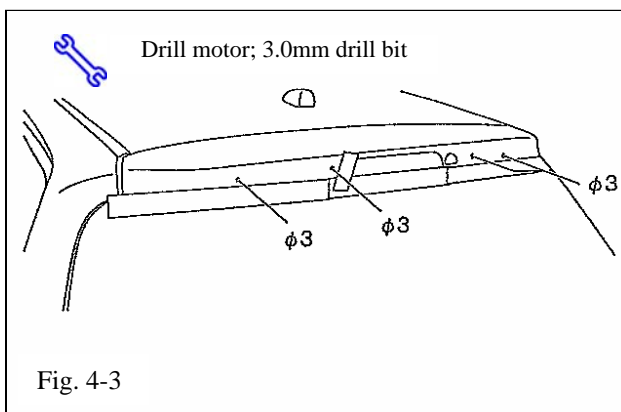


(a) Apply making tape to the rear hatch CHMSL light, glass, wiper and emblem to prevent drilling chips from entering as shown in Fig. 4-1.

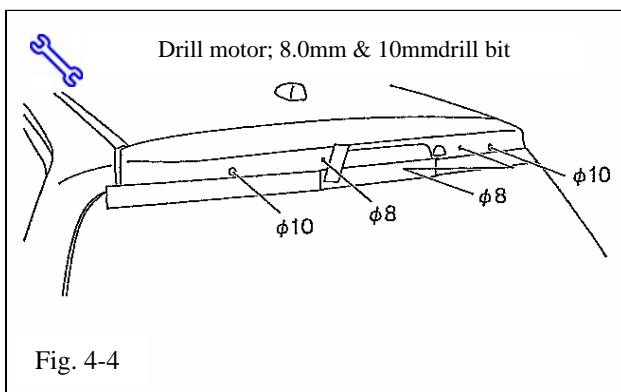
Procedure



(b) Set all drill stops at 5.0mm (Fig. 4-2).



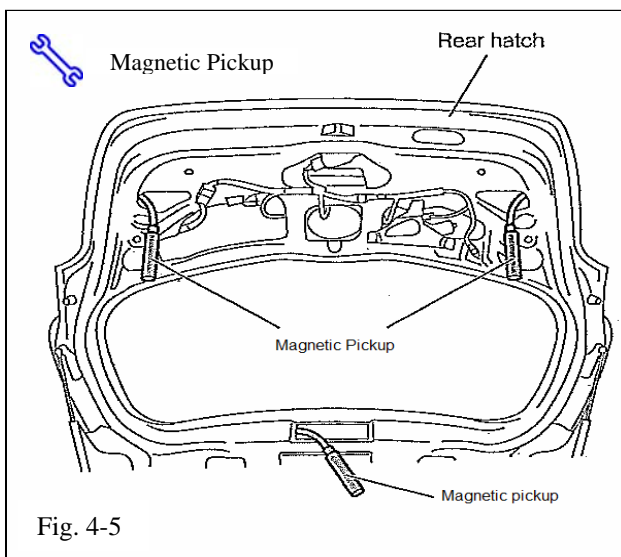
(c) Drill a 3.0mm pilot hole at each of the four (4) drilling locations (Fig. 4-3). Hold the drill perpendicular to the sheet metal where the hole is being drilled to keep the drill bit from wandering.



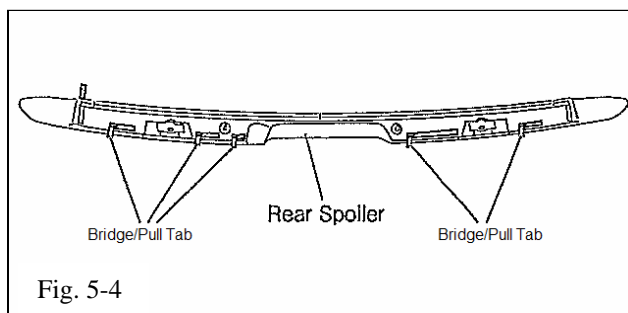
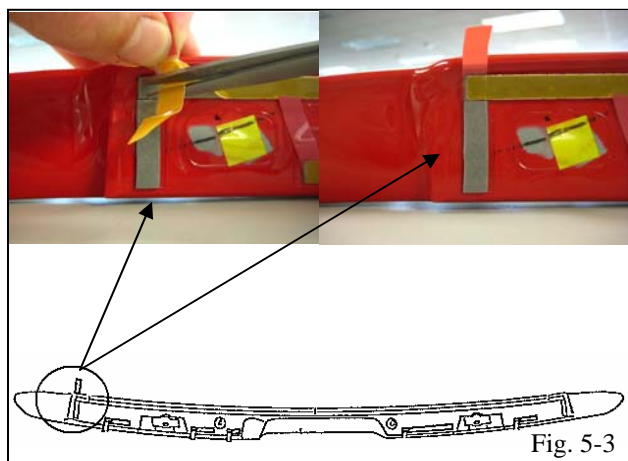
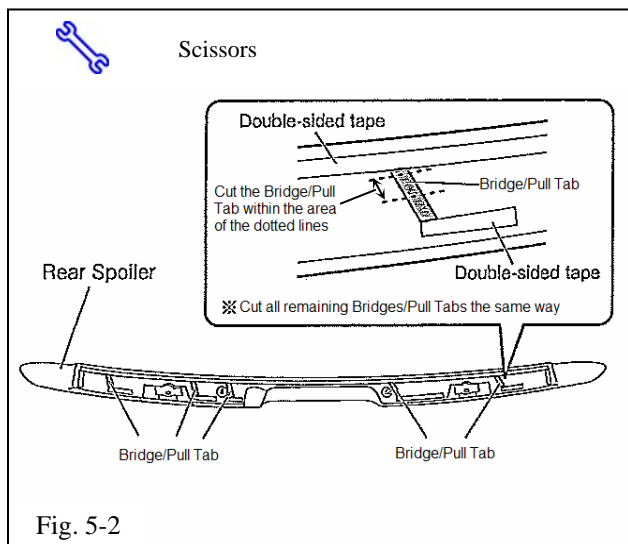
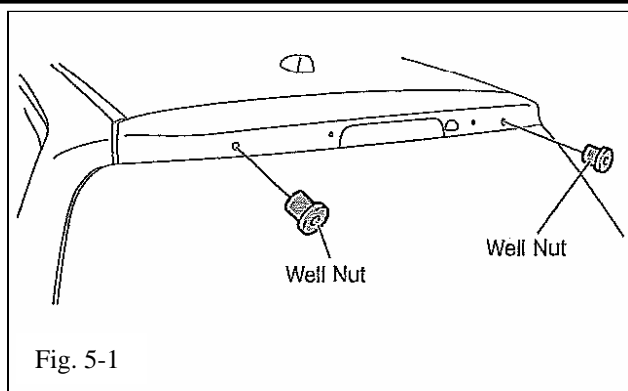
(d) Drill the two (2) outer hole locations to 10mm and drill the two (2) inner holes to 8.0mm (Fig. 4-4).

(e) Using a deburring tool, carefully debur all the drilled holes.

(f) Remove all the masking tape and open the rear hatch and use a magnet with a flexible shaft to remove any remaining metal chips from the drilling process. (Fig. 4-5). Vacuum the inner panel area.



Procedure

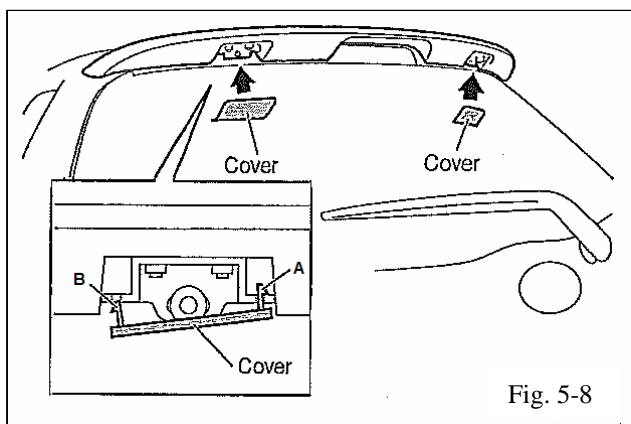
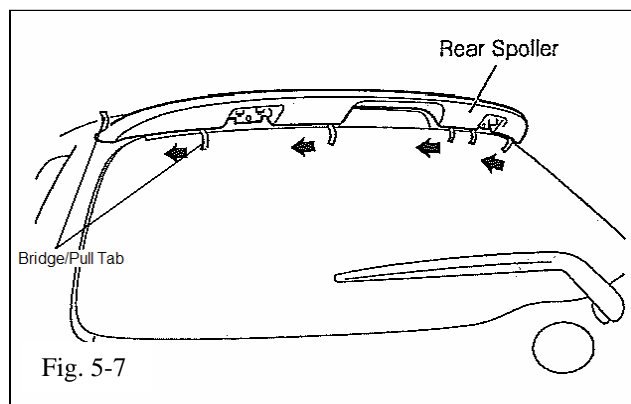
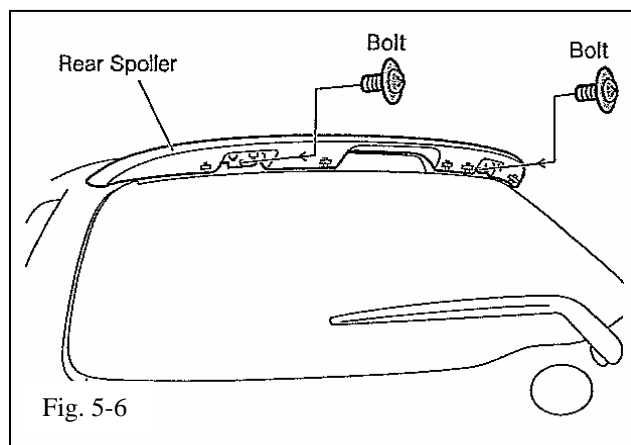
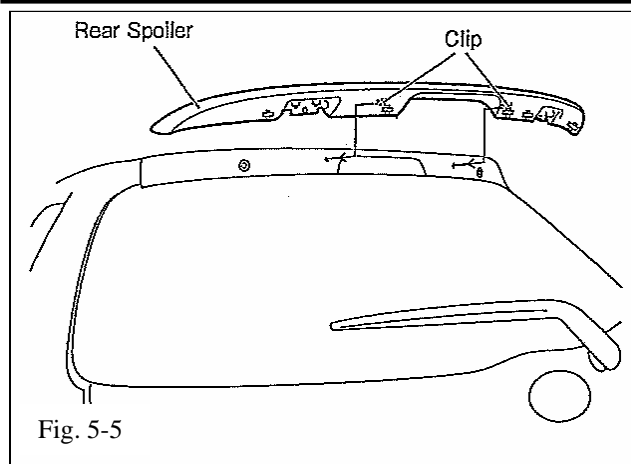


5. Rear Spoiler Installation

- (a) Clean the surface of the rear hatch where the spoiler attaches 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.
- (c) The rear hatch 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 rear hatch for proper sealing.
- (d) Install the two (2) well nuts into the 10mm holes (Fig. 5-1).
- (e) From the reverse side of the rear spoiler, use scissors to cut the bridges/pull tabs in half (at five locations) (Fig. 5-2).
- (f) In addition, cut off and remove short vertical tape liner from the RH side of the spoiler (Fig 5-3).
- (g) Using masking tape, fold and tape all the tape line pull tabs to the A-surface of the spoiler so all the pull tabs are accessible once the spoiler is installed (Fig. 5-4).



Procedure



- (h) Close the rear hatch and install the spoiler to the hatch by inserting the two (2) inner alignment pins into the inner 8.0mm holes (Fig. 5-5).
- (i) Loosely install the two (2) bolts to the outer well nuts (Fig. 5-6).
- (j) Using your fingers, verify the spoiler is centered side to side on the rear hatch. Gently pull the tape liner out from the front leading edge of the spoiler, applying light pressure and work your way to the opposite side of the spoiler (Fig. 5-7).
- (k) From the bottom side of the spoiler. Gently pull the remaining five (5) pull tabs and liners starting from the RH side of the vehicle, pulling the tabs from right to left (Fig. 5-7).
- || (l) Torque the two (2) bolts to 10 lbf-in.
- (m) Install the covers to the bottom side of the rear spoiler.
 - (1) When installing the covers, first clip side A, then clip side B (Fig. 5-8).
- (n) Reinstall all removed parts in the reverse order including reconnecting the CHMSL Harness connector.

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

Check:	Look For:
<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 (+/- 2.0 mm.) Full adhesion with no gaps.
<u>Vehicle Function Checks</u> <input type="checkbox"/> Verify operations of CHMSL	 CHMSL turns on when brakes are applied.