

Part Number: PT890-03150-XX

Kit Contents

Item #	Quantity Req'd.	Description
1	1	Lip Spoiler
2	2	M6 Nut
3	2	Clip with grease
4	1	Torsion Bar, LH
5	1	Torsion Bar, RH

Additional Items Required For Installation

Item #	Quantity Req'd.	Description
1	1	Installation Kit, P/N PT890-03150-TL
2		
3		

Conflicts

None

General Applicability

All Camry models, including Hybrid

Recommended Sequence of Application

Item #	Accessory
1	
2	

*Mandatory

Vehicle Service Parts (may be required for reassembly)

Item #	Quantity Req'd.	Description

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.

Recommended Tools

Personal & Vehicle Protection	Notes
Wrist & Belt Protectors	
Blankets	
Shop Rags	
Masking Tape	2" wide
Special Tools	Notes
Non-Intrusive IR Temperature Probe/Gun	
Torsion Bar Tool	SST: 09804-24010
Installation Tools	Notes
Panel Fastener Removal Tool	
Center Punch	
Drill	
Twist drill bits	8.5 mm (21/64") 9.0 mm (11/32")
Drill stops (2)	One for each drill bit
Deburring tool or file	
Hex Nut Driver	10 mm
Socket	10mm deep socket
Socket Extension	6"
Ratchet	
Torque wrench	Approx 5-60 in-lb range
Scissors	
Hand vacuum	Remove drill shavings
Flex magnet	Remove drill shavings
Heat gun	When mounting surface is below 60° F (15° C)
Lint Free Cloth	
Small Parts Bin	
Special Chemicals	Notes
Sealant	3M™ Ultra-Pro Body Sealant
Simple Green All Purpose Cleaner or equivalent	½ strength

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.

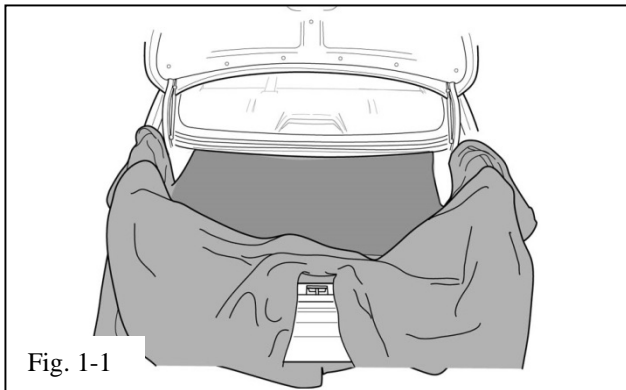
1. Prepare the Vehicle.



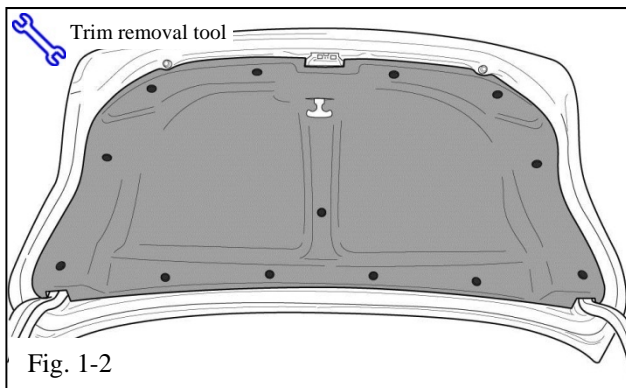
- (a) Installation of the rear spoiler should not take place until the following have been completed:

- (1) The car is washed.
- (2) 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.

- (b) Open the trunk lid and place blankets on the trunk floor and trunk opening (Fig. 1-1).



- (c) Remove the 13 black clips securing the trunk lid liner to the trunk lid and remove the liner (Fig. 1-2).



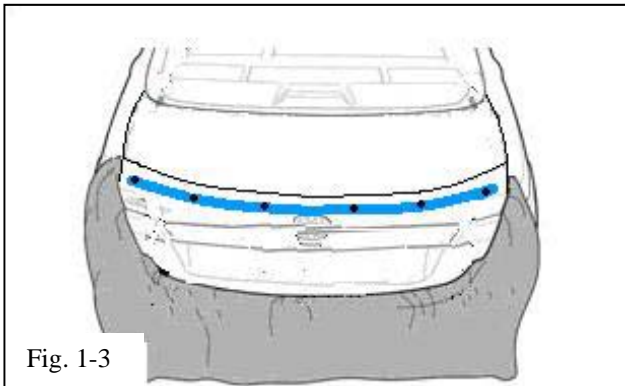



Fig. 1-3

-  (d) Apply masking tape to the trunk lid surface in the areas where the six (6) mounting holes will be drilled (Fig. 1-3). Two inch wide blue painters masking tape is recommended.

NOTE: The above step is not necessary if the trunk lid surface is covered with protective poly-wrap and it is smooth and clean.

2. Drill the Mounting Holes.

- (a) Set all drill stops to 1.0" (Fig. 2-1).
- (b) Although not absolutely necessary, it can be very helpful to first drill a small pilot hole with a 3/32" or 1/8" bit. This will help to keep the larger drill bits from wandering.

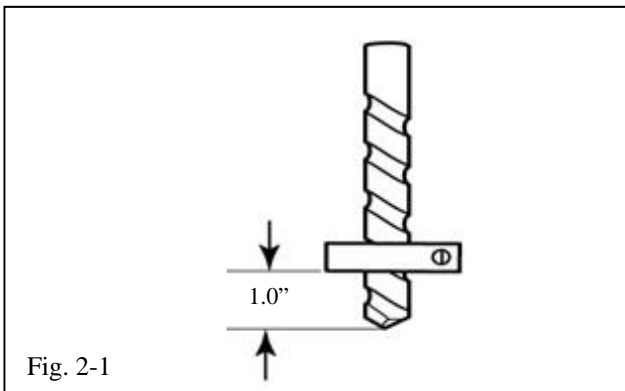


Fig. 2-1

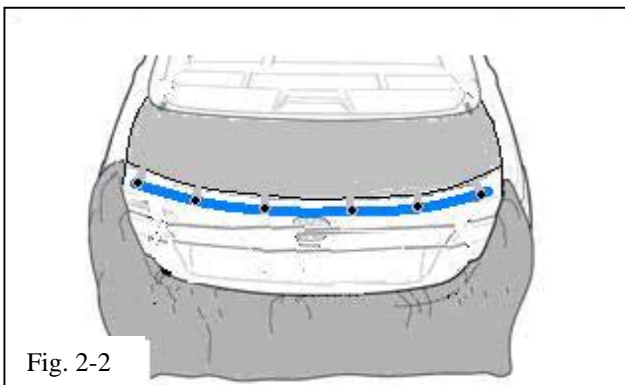
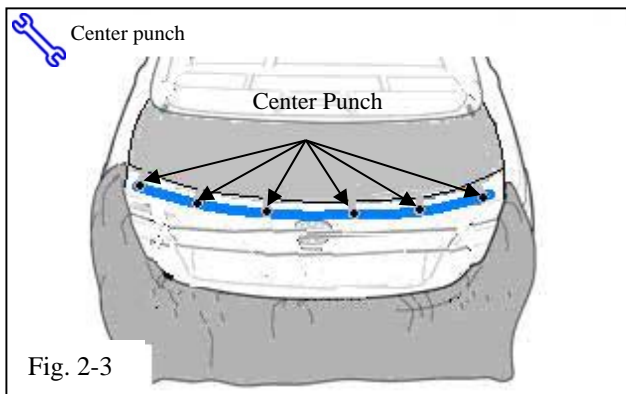


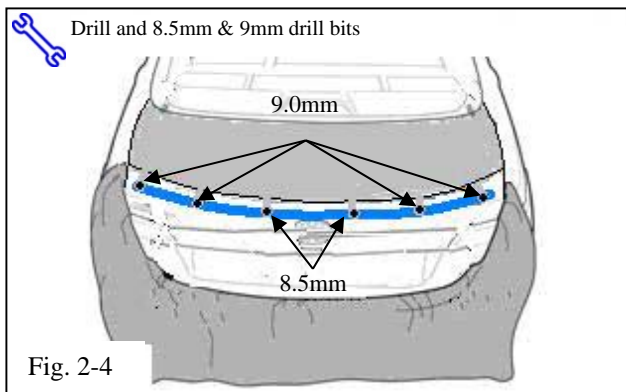
Fig. 2-2

- (c) Place the Mylar drilling template on the vehicle as shown in Fig. 2-2. Tape it in place, making sure the template is completely smooth and flat on the trunk lid surface.
- (d) Locate the six (6) hole locations on the template.



- (e) Use a center punch to carefully punch each of the six hole locations through the Mylar template onto the trunk lid. Each of the six tabs has one hole location (Fig. 2-3).
- (f) Remove the Mylar Template. Make sure all six (6) punch marks are visible.

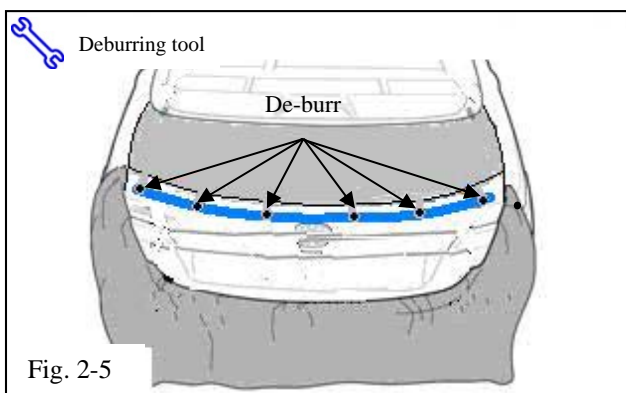
NOTE: To help prevent drilling the wrong hole sizes at the six hole locations, it is useful to write the hole diameter next to each punch mark on the masking tape.



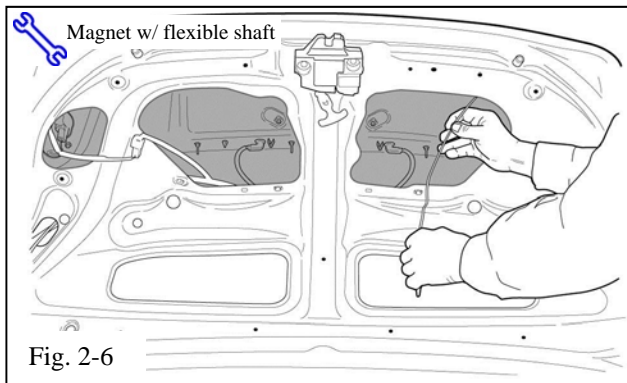
- (g) Carefully drill the six mounting holes. The inner 2 diameters are 8.5mm while the outer 4 are 9.0mm (Fig. 2-4).

+ CAUTION: Eye protection must be worn when drilling all holes.

NOTE: Run the drill in and out of each hole to avoid burrs in the deck lid.



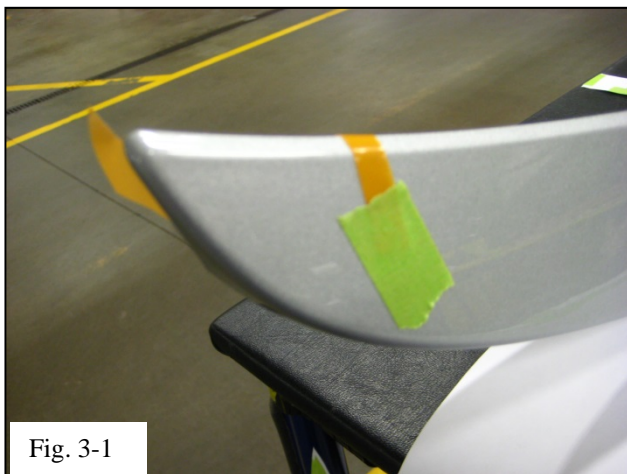
- (h) Use a de-burring tool to remove any burrs on the edges of the drilled holes (Fig. 2-5).
- (i) Vacuum the surface of the trunk lid and the surrounding drilled areas.
- (j) Remove the masking tape.



- (k) Open the trunk lid and use a magnet with a flexible shaft to remove any remaining metal chips from the drilling process (Fig. 2-6).
- (l) Vacuum the inner panel area.

3. Install the Spoiler.

- ⚠ (a) Clean the surface of the trunk lid where the spoiler attaches with a VDC approved cleaner and a lint free cloth.
- ⚠ (b) After cleaning, carefully apply 3M Ultra Pro Body Sealant to all drilled hole edges.
- ⚠ (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.
- (d) The adhesive tape on the spoiler must have full contact between spoiler and trunk lid for proper sealing to trunk lid.
- (e) Fold back and tape the plastic liners to the outside surface of the spoiler. Be careful not to touch or allow any contaminants to come into contact with the adhesive tape (Fig 3-1).



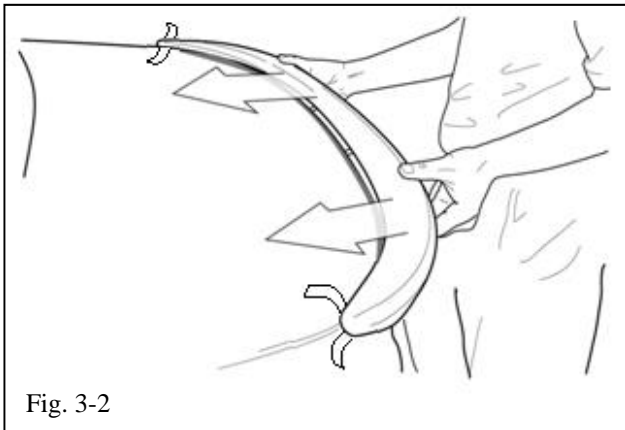


Fig. 3-2

- (f) Position the spoiler behind the trunk lid with the drill holes aligned to the spoiler studs and clips. The two studs go into the two inboard 9.0 mm drilled holes aligning the spoiler side to side and vertically (Fig. 3-2).

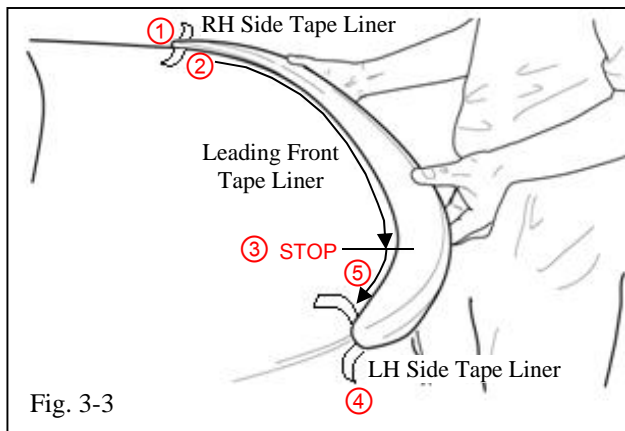



Fig. 3-3

- (g) Press spoiler into place seating the plastic clips into the 8.5 mm holes and outboard 9.0mm holes. (Fig. 3-3).
- (h) Once the clips are fully seated, center the spoiler from side to side on the trunk lid.
- (i) If a gap exists at the trailing edge of the spoiler, gently push the spoiler forward and remove either the LH or RH side tape liner from either side of the spoiler ① (Fig. 3-3).
- (j) Next, begin removing the leading front tape liner from the same side the side tape liner was removed ② (Fig. 3-3). Apply light pressure as the tape liner is removed.
- (k) Continue removing the leading front tape liner until it is $\frac{3}{4}$ of the way across the spoiler and stop ③ (Fig. 3-3).
- (l) Remove the final side tape liner ④ (Fig. 3-3).
- (m) Remove the remaining leading front tape liner ⑤ (Fig. 3-3).

- (n) Once the plastic liners are completely removed, reapply pressure to the entire leading edge and the sides of the spoiler to ensure good tape adhesion.
- (o) Open the trunk lid and install the two M6 nuts to the studs.

 (p) Torque the M6 nuts to 53 in-lbf (5.9N-m).

4. Remove the OE Torsion Bars.

- (a) Open the trunk lid fully.
- (b) Place a support inside the trunk to keep the trunk lid fully open, and ensure that the trunk lid does not close when the torsion bars are removed (Fig. 4-1).



 **CAUTION:** It is important that a trunk lid support be placed inside the trunk. Removing  both torsion bars will cause the trunk lid to fall quickly without the support in place.



Fig. 4-1

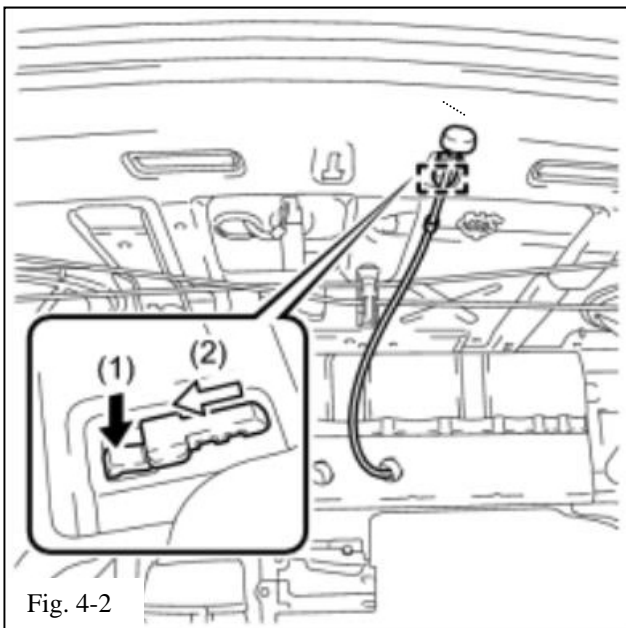
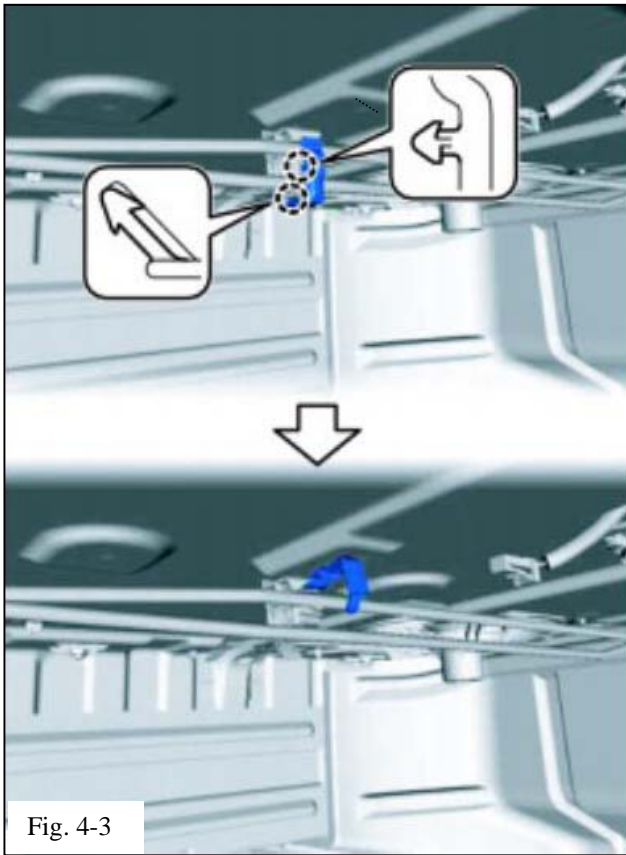
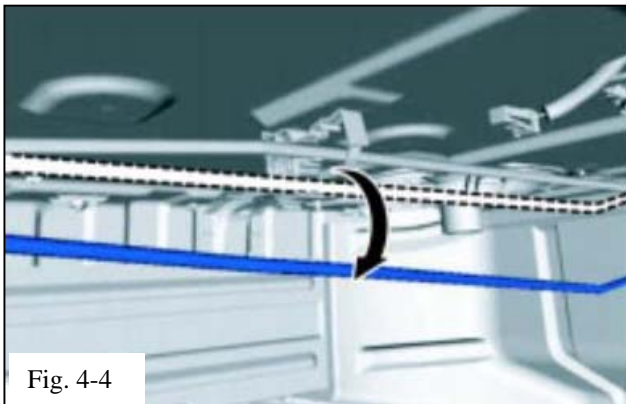


Fig. 4-2

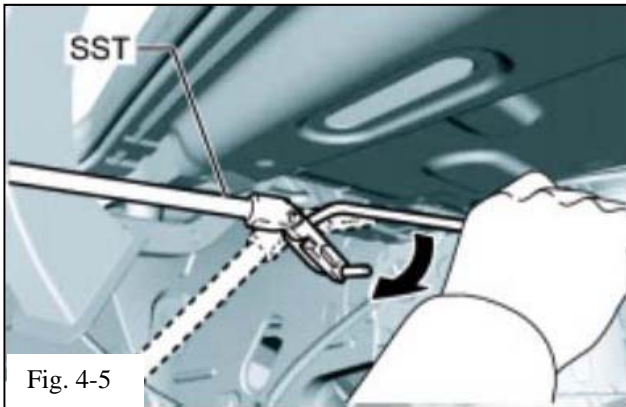
- (c) Disengage the rear seatback lock by removing the hook in the order indicated in the illustration (Fig. 4-2).



- (d) Release the torsion bars from the center support clip by disengaging the 2 claws shown in the illustration (Fig. 4-3).

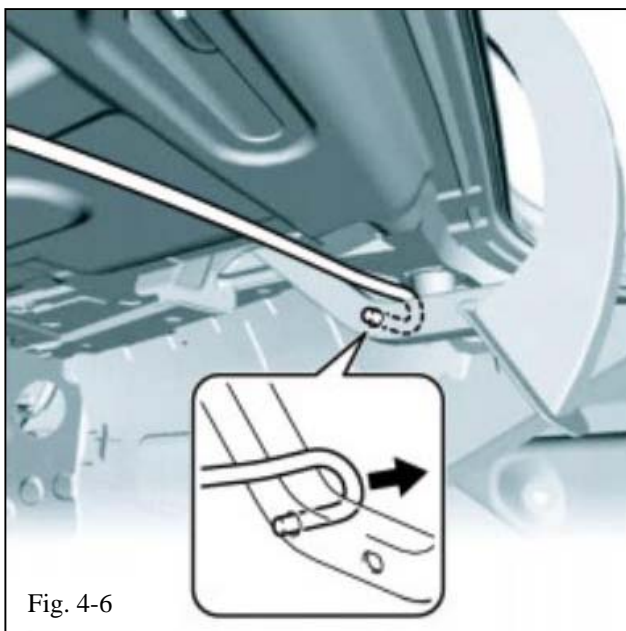


- (e) Remove the RH (lower) torsion bar from the support clip (Fig. 4-4).

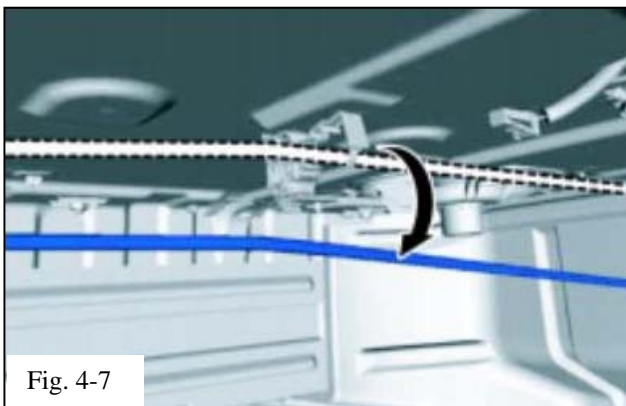


- (f) Use the SST to disconnect the RH torsion bar from the left side of the vehicle body (Fig. 4-5).

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- (g) Remove the RH trunk lid hinge torsion bar from the right side of the vehicle body (Fig. 4-6).

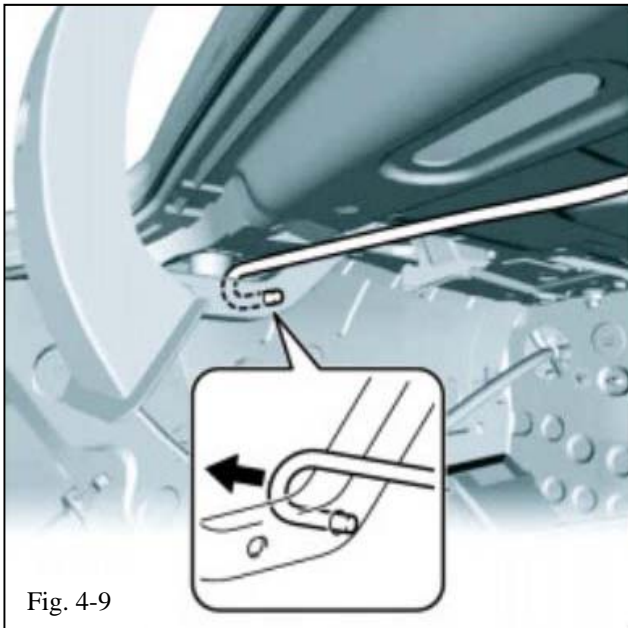


- (h) Remove the LH torsion bar from the support clip (Fig. 4-7).

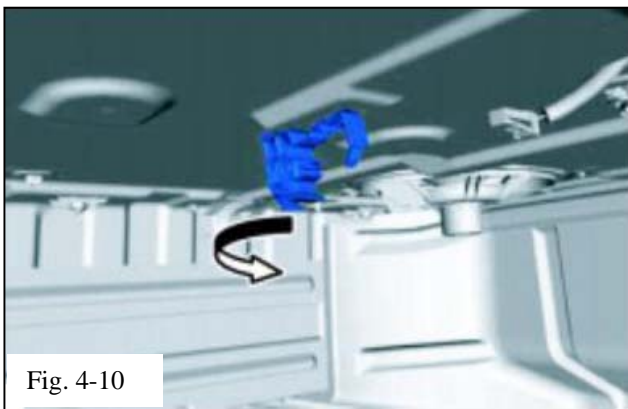


- (i) Remove the LH torsion bar from the support clip (Fig. 4-8).

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- (j) Remove the LH torsion bar from the right side of the vehicle body (Fig. 4-9).

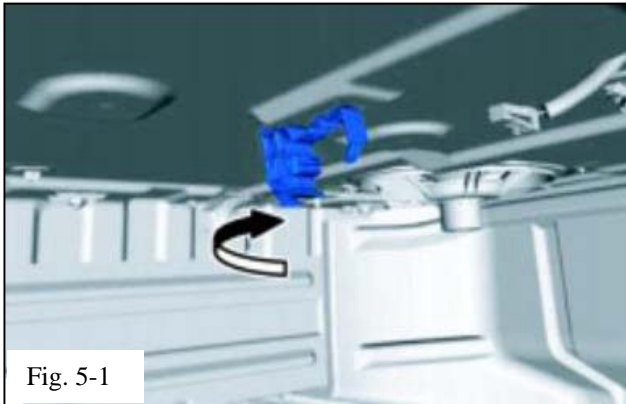


- (k) Remove the trunk lid torsion bar support clip by rotating it as shown in the illustration (Fig. 4-10).

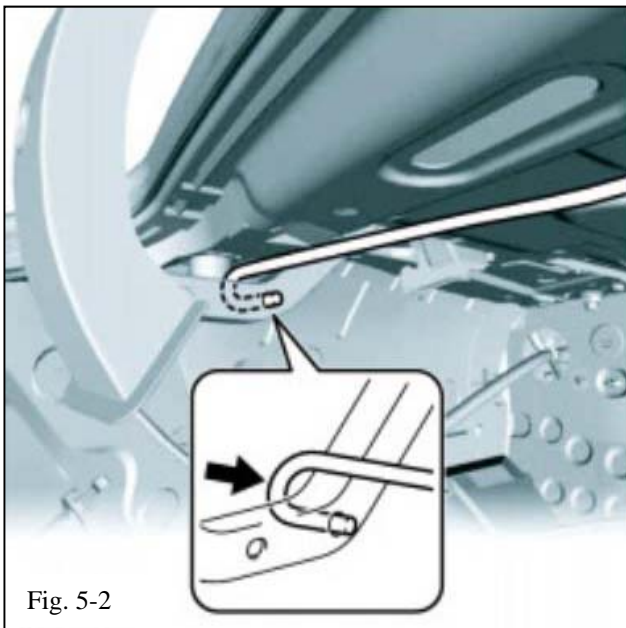
⚠ NOTE: Make sure to replace the torsion bar support clip with a new one.

5. Install the new Torsion Bars.

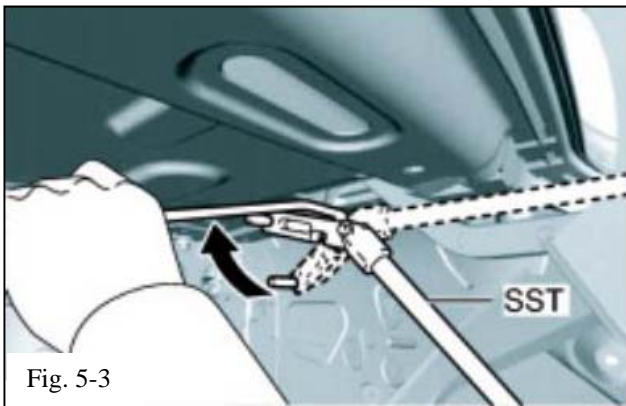
- (a) Install a new torsion bar support clip (Fig. 5-1).

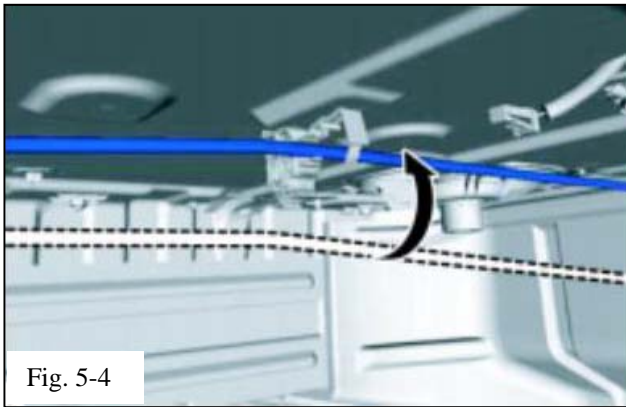


- (b) Connect the LH torsion bar to the left side of the vehicle (Fig. 5-2).

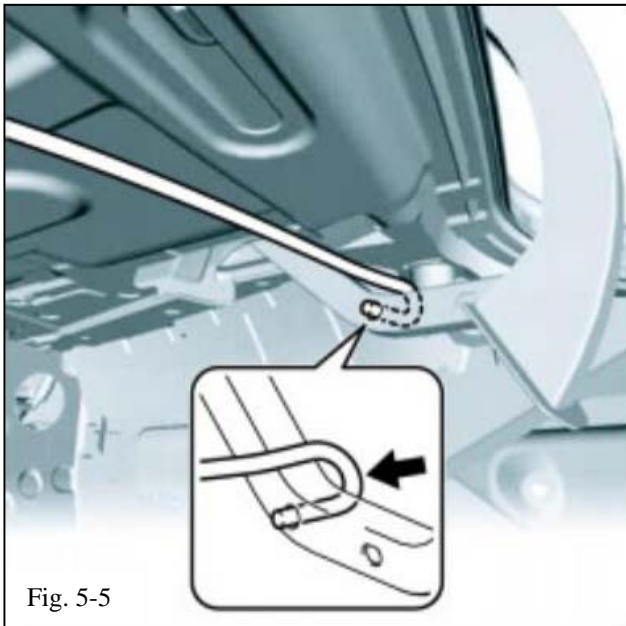


- (c) Use the SST to install the LH torsion bar on the right side of the vehicle body (Fig. 5-3).

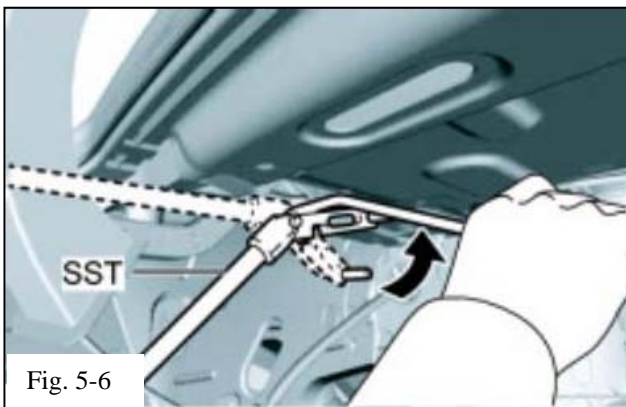




- (d) Connect the LH torsion bar to the upper slot in the support clip (Fig. 5-4).

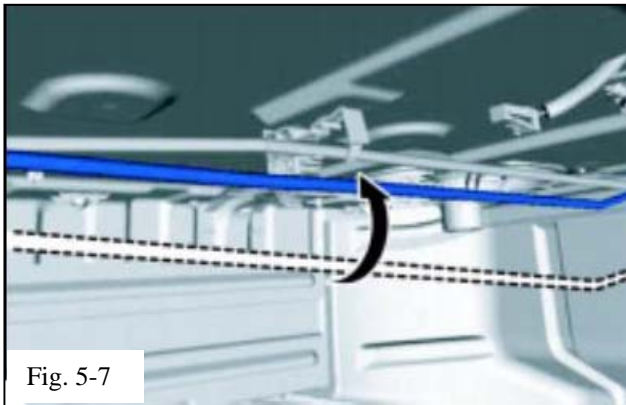


- (e) Connect the RH torsion bar to the right side of the vehicle (Fig. 5-5).

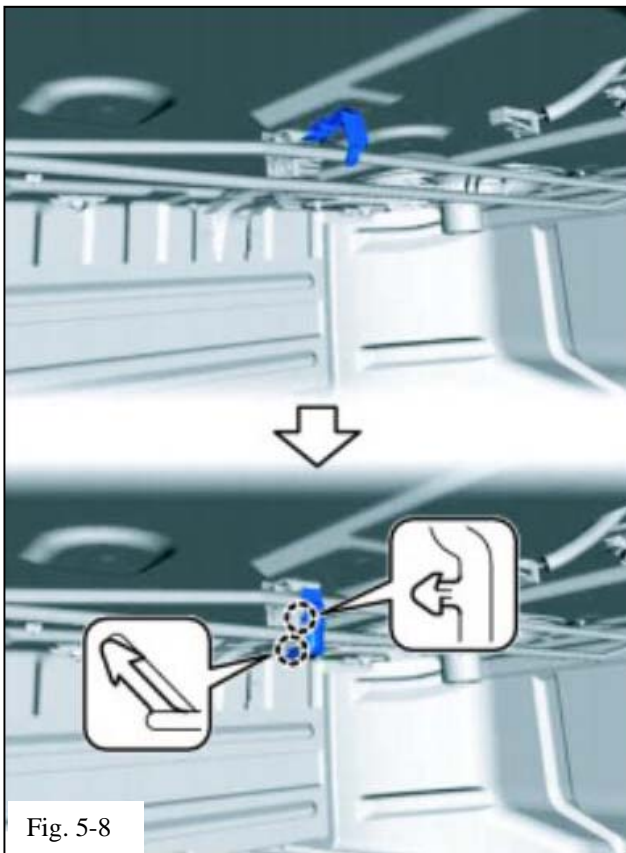


- (f) Use the SST to install the RH torsion bar on the trunk lid hinge on the left side of the vehicle body (Fig. 5-6).

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- (g) Connect the RH torsion bar to the lower slot in the support clip (Fig. 5-7).



- (h) Engage the 2 claws as shown in the illustration (Fig. 5-8).

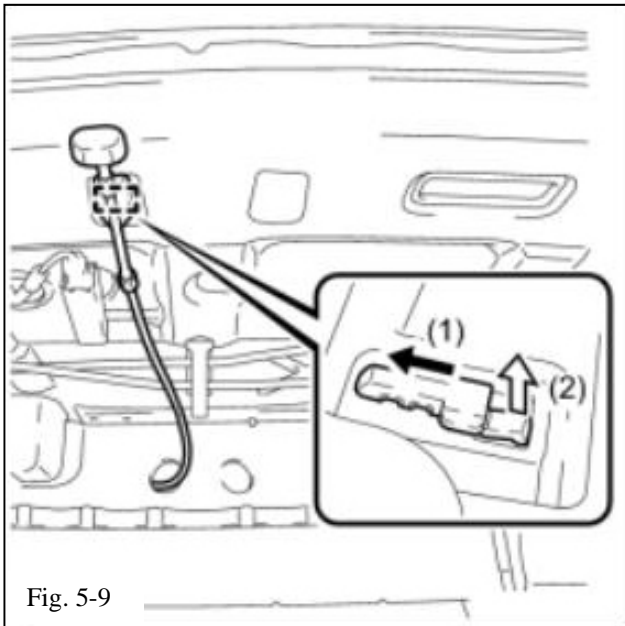


Fig. 5-9

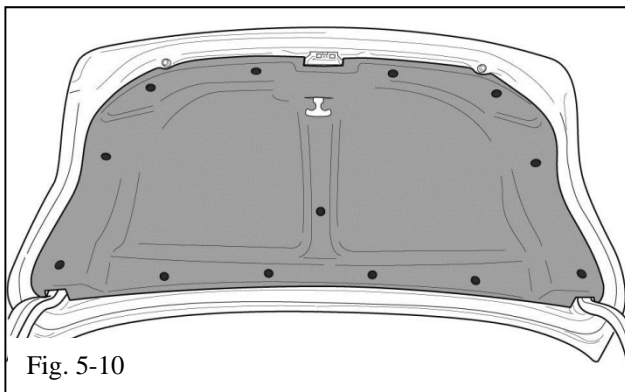


Fig. 5-10

- (i) Connect the rear seatback lock assembly LH (rear seat lock control cable LH) and engage the hook in the order indicated in the illustration (Fig. 5-9).
- (j) Reinstall the inner trunk lid liner by reinstalling the 13 clips removed in Step 1(c) (Fig. 3-13).
- (k) Close the trunk lid and apply pressure to the topside of the spoiler a second time to ensure all of the tape is adhered to the trunk lid.

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

<p><u>Check:</u></p>	<p><u>Look For:</u></p>
<p><u>Accessory Function Checks</u></p> <p><input type="checkbox"/> Check for visual alignment</p> <p><input type="checkbox"/> Check for full tape adhesion</p>	<p>The spoiler should be centered side to side (± 2.0 mm at ends)</p> <p>Full adhesion of tape with no gaps</p>
<p><u>Vehicle Function Checks</u></p> <p><input type="checkbox"/> Trunk lid opens with trunk release lever</p> <p><input type="checkbox"/> When opened fully, the trunk lid remains open on its own</p>	<p>Confirm that the trunk lid will pop open when the trunk lid release is used</p> <p>When fully opened, the trunk lid must not close under its own weight.</p>
<p><u>Vehicle Appearance Check</u></p> <p><input type="checkbox"/> After accessory installation and removal of protective cover(s), perform a visual inspection.</p>	<p>Ensure no damage (including scuffs and scratches) was caused during the installation process. (For PPO installations, refer to TMS Accessory Quality Shipping Standard.)</p>