

Part Number: PT278-0T09P

Kit Contents

Item #	Quantity Reqd.	Description
1	2	Roof Rail Assembly
2	2	Roof Rail Cover
3	1	Hardware Bag (see content below)
4	1	Cross Bar Kit (see content below)

Hardware Bag Contents

Item #	Quantity Reqd.	Description
1	1	Instructions
2	10	Rail Mounting Bolts T-30
3	10	Mastic Washers

Cross Bar Kit Contents

Item #	Quantity Reqd.	Description
1	1	Cross Bar Assembly FRT
2	1	Cross Bar Assembly RR
3	1	Cross Bar Hardware Bag

Cross Bar Hardware Bag Contents

Item #	Quantity Reqd.	Description
1	8	Screw M5x0.8x19.0 T-25

Additional Items Required For Installation

Item #	Quantity Reqd.	Description
1		

Conflicts

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Recommended Tools

Personal & Vehicle Protection	Notes
Safety Glasses	
Protective Cloth	
Special Tools	Notes
Tape Cutting Tool	IADS P/N: TAC0-014-01
Hand Roller	Hard Rubber or Wood Hand Roller, 1".
Installation Tools	Notes
T-30 Torx Driver	
T-25 Torx Driver	
Nylon Panel Removal Tool	i.e.: Panel Pry Tool #1 Toyota SST#00002-06001-01
Torque Wrench	0-150 Lbf-in.
Tape Measure	
Shears	
Rubber Mallet	
Special Chemicals	Notes
Cleaner	VDC Approved

General Applicability

All Non-Panoramic Roof Models.

Recommended Sequence of Application


Item #	Accessory
1	


*Mandatory


Vehicle Service Parts (may be required for reassembly)


Item #	Quantity Reqd.	Description
1	As required	Tape, p/n 63163-0T010


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.



Section II - Installation Procedure

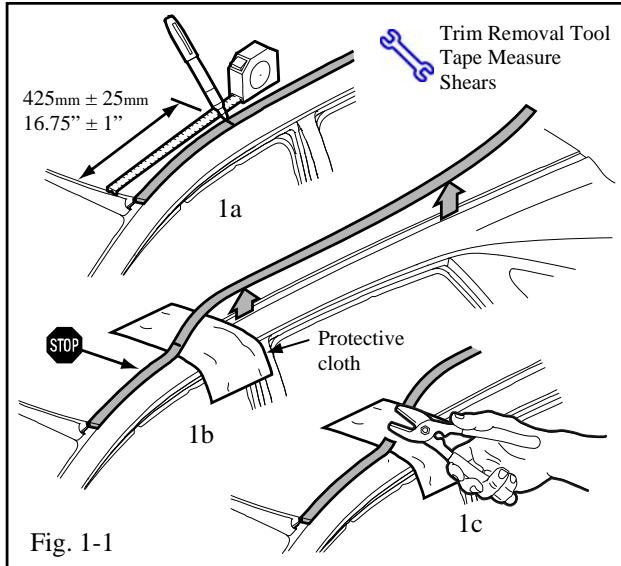
Care must be taken when installing this accessory to ensure damage does not occur to the vehicle. The installation of this accessory should follow approved guidelines to ensure a quality installation.

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.).

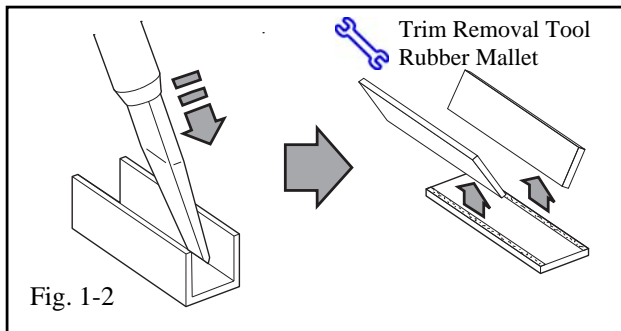
Please see your Toyota dealer for a copy of this document.



1. Vehicle Preparation (Fig. 1-1)

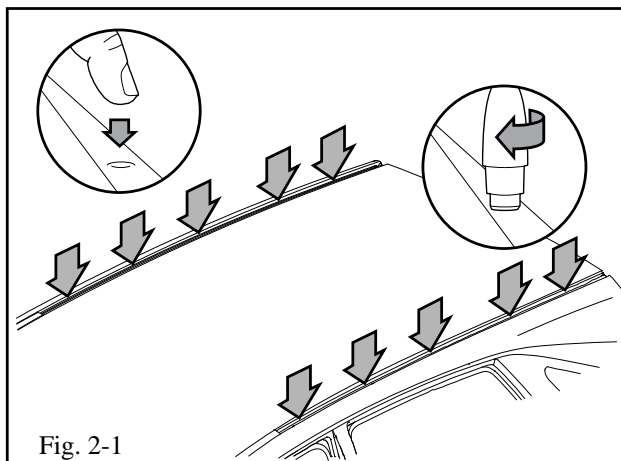
- ⚠ (a) Using tape measure, measure rearward from front window lace 425mm ± 25mm (16³/₄” ± 1”) and mark the factory ditch mold for cutting. (Fig. 1-1a)
- ⚠ (b) Carefully lift ditch molding, starting at the rear to just beyond the cut line. **Do not remove molding totally from front ditch & clip.** Place a protective cloth. (Fig. 1-1b)
- ⚠ (c) Using shears, cut ditch mold. (Fig. 1-1c)
- ⚠ (d) Using a trim removal tool and rubber mallet, break off vertical walls of **rear ditch clips** (RH & LH). Wedge trim removal tool in from inside then tap the trim removal tool with a rubber mallet. This should cause wall to break. Repeat for both sides. (Fig. 1-2)

Note: In the event the clip is dislodged, clean area and apply tape, p/n 63163-0T010

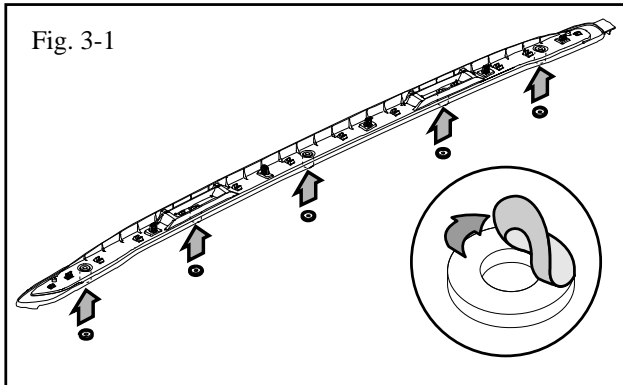


2. Prepare Roof for Rack Installation (Fig. 2-1)

- (a) Using your finger, locate the tape that covers the 10 weldnuts (5 LH & 5 RH) and press down to create a dimple at the location (Fig. 2-1).
- ✚ (b) Using the tape cutting tool, center the tool over the dimple area; press down then rotate the tool in one direction. Lift up the tool and dispose the seal material (Fig. 2-1)
- ⚠ (c) Clean work area before installing rails
 - (1) Saturate a clean lint-free cloth with approved cleaner and clean the work surface of the vehicle. Follow the solvent manufacturer’s directions carefully. Do not allow cleaner to air dry.



- (2) Wipe the clean surface with a clean, dry, lint-free cloth.

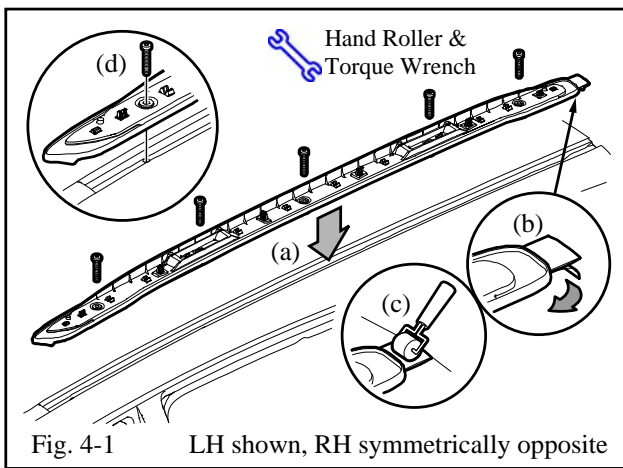


3. Install Mastic Washers (Fig. 3-1)

- (a) Remove tape backing from the adhesive backed washers and install to bottom of side rail base (5 places each side).

4. Secure Rails to Roof (Fig. 4-1)

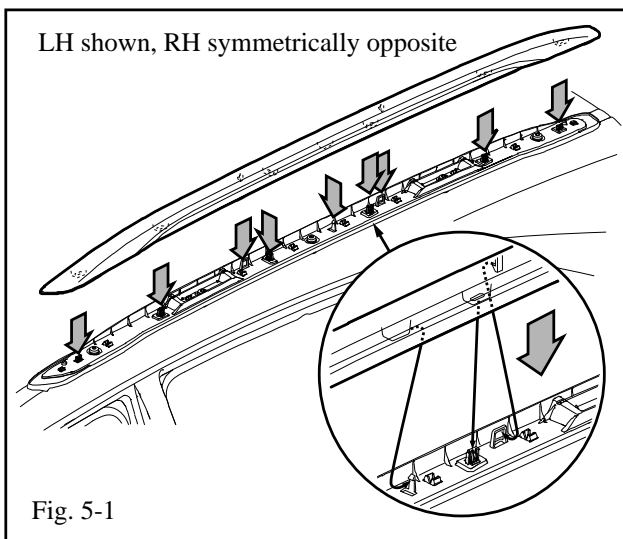
- (a) Fit rail into ditch above hole positions and hand start 5 T-30 mounting screws per rail.
- (b) Remove tape backing from rear ditch molding.
- (c) Using the hand roller, roll around the rear ditch molding with at least 15lbs (7kg) of pressure to ensure complete adhesion of tape to vehicle.
- (d) Using the T-30 torque wrench, torque bolts to 13.3 Nm (118 Lbf.-in.)



⚠ Torque: 13.3 Nm (118 Lbf.-in.)

5. Install Covers (Fig. 5-1)

- ⚠ (a) Align cover over clips on side rails. Starting from the center moving outward, press down onto rail until all clips are fully engaged (9 places per side).
- ⚠ NOTE: Verify clip orientation to rail cover before installation. RH & LH sides are different.



- 6. Place the crossbar kit box inside the cargo area.**
- 7. Place installation instructions in the glove box.**

TOYOTA VENZA 2009- Roof Rails & Cross Bars
 Checklist - these points **MUST** be checked to ensure a quality installation.

<u>Check:</u>	<u>Look For:</u>
<p><u>Accessory Function Checks</u></p> <p><input type="checkbox"/> Covers should be secure</p> <p><input type="checkbox"/> Gap between roof rack side rail pads and vehicle roof surface</p>	<p>Gaps between cover and rail pads and cover looseness</p> <p>Not greater than 1.5 mm</p>
<p><u>Vehicle Function Checks</u></p> <p><input type="checkbox"/> None Required</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>