



ATTENTION: This Technical Service Bulletin was issued by Southeast Toyota Distributors, LLC.

For Toyota Dealers located within the Southeast Region: Please refer to SET Dealer Daily to obtain instructions on how to order parts and submit a warranty claim (If applicable).

For Lexus Dealers or Toyota Dealers NOT located in Florida, Georgia, Alabama, South Carolina or North Carolina: For Repair Authorization, Parts Ordering, and Warranty Claims please contact Southeast Toyota Distributors Warranty Claims Department:

(888)851-2722

Press 5, then Press 4 for Out of Region SET Repairs

Accessory.Warranty@SEToyota.com

Thank you for your continued support.

2013-15 Avalon

Rear Lip Spoiler lifting

Applicability

YEAR(S)	MODEL(S)	INSTALLED ACCESSORY INFORMATION		
		DESCRIPTION	ACCESSORY CODE	KIT PART NUMBER
2013-15	Avalon	Rear Lip Spoiler	CX10	00016-07012-XX

***This Publication does not apply to Vehicles Equipped with a Rear Lip Spoiler from the factory or added by other manufacturers.*

Introduction

Southeast Toyota has identified an improper DIO installation technique may cause rear spoilers on Avalon vehicles to lift from the trunk lid. This publication shall outline the inspection of the condition and outline procedures for removal of the spoiler, application of adhesive tape and reinstallation.

Warranty Information

OP CODE	DESCRIPTION	TIME	OFF	T1	T2
NA	NA	NA	NA	NA	NA

Please contact the SET Accessory Warranty Department at (888) 851-2722 or email Accessory.Warranty@SETToyota.com for claim payment instructions.

Parts Information

PART NUMBER	DISCRIPTION
00016-07012-50	Service Kit Part Number Required
SERVICE KIT CONTAINS:	
QUANTITY	DESCRIPTION
1	120 inch roll of 1\4 inch wide 3M EX4000 series tape
2	1-1\4 inch diagonally cut 1 inch wide 3M EX4000 series tape
3	Foam Rings

If you are a dealer outside of the SET region, please contact the SET accessory department at (888) 851-2722 or email Accessory.Warranty@SETToyota.com.

Avalon Rear Lip Spoiler (Cont.)

Recommended Tools

SAFETY TOOLS
Safety Glasses
SPECIAL TOOLS
Protective Blanket
SPECIAL CHEMICALS
Cleaner- 50/50 solution of Isopropyl Alcohol and water
3M General Purpose Adhesive Cleaner

INSTALLATION TOOLS
Wiping Cloth- Non-Scratch, Lint Free
White Stick / Plastic Pry Tool
1/4" Drive Ratchet
1/4" Torque Wrench
6" x 1/4" Drive Extension
1/4" Drive Socket (10mm)
1/4" Universal Joint

Inspection / Description of Condition

Review VIN inquiry and service history to verify SET Accessory

- a. **CX10** accessory code indicates SET Port installed Spoiler
- b. **00016-07012-0?** Showing in vehicle service history Indicates Dealer installed SET Spoiler.
- c. This TSB does not apply to vehicles without SET accessory installed

This TSB addresses a common installation error causing the outer edges of the spoiler to lift as shown (Fig. 1).

NOTICE: If during installation the backing from the adhesive tape is removed prior to positioning the spoiler properly on the deck lid. The spoiler may twist when the retaining nuts are tightened.

Please follow all steps in order to ensure proper installation.



NOTICE: Care must be taken while re-working this accessory to ensure damage does not occur to the vehicle or spoiler. Use approved guidelines to insure a quality installation.

Avalon Rear Lip Spoiler (Cont.)

Preparation

1. Verify that the part is in workable condition.
2. During re-work, the vehicle, the part, and the tape MUST be between 60° and 110° F for proper adhesion.

NOTICE: Failure to follow proper rework and installation procedures may result in the part not functioning correctly.

3. Inspect the vehicle and Rear Lip Spoiler for damage before beginning repairs.
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. 2) Use a clean, lint-free cloth and isopropyl alcohol-based cleaner.



5. Open trunk and place protective blanket inside trunk and over rear bumper. Place a second protective blanket over rear window. (Fig. 3)



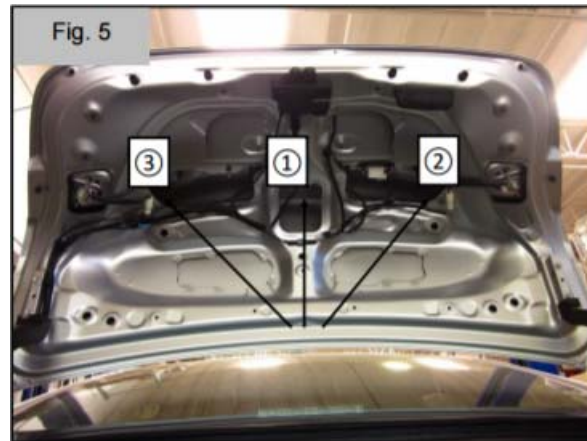
Avalon Rear Lip Spoiler (Cont.)

Lip Spoiler Removal Procedure

6. Remove fasteners and trunk lid liner. Retain fasteners for re-installation. (Fig. 4)



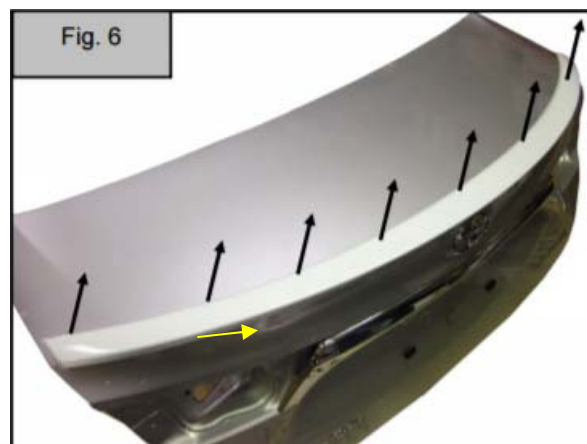
7. With the trunk lid open, remove 3 M6 nuts using a (10mm) ratchet socket, extension, and universal joint. (Fig 5)



8. With the trunk lid closed, starting with one side of the spoiler, carefully pull up and away slowly to avoid stressing or bending the spoiler. (Fig 6)

HINT: The tape may hold the spoiler firmly to the deck lid. To aid in the removal start at the outer edge with a piece of cloth or string between the spoiler and deck lid. Pull towards the center using a sawing motion to release tape. Stop at studs.

Once the lip spoiler is removed, inspect all surfaces for damage. If no damage is found, continue with tape removal procedure.



Avalon Rear Lip Spoiler (Cont.)

9. Clean deck-lid thoroughly with a non-scratch lint free cloth and remove any remaining tape or glue residue using 3M General Purpose Adhesive Cleaner.

Deck lid should be completely clean of all tape residues. (Fig 7)

10. Use 50/50 Isopropyl Alcohol/Water mixture to wipe down the area and allow to dry.



Fig. 7

Lip Spoiler Preparation

Hint: For best working conditions, move spoiler to a clean work space away from the vehicle. Work should take place in a well ventilated area. Make sure work is being done on a non-scratch surface to prevent damage to the painted surface of the part

11. Using a plastic non-gouging scraping tool, scrape off any excess tape as you can before starting the next step.

NOTICE: Use of a steel bladed scraper will score the lip spoiler tape surface and may result in ineffective repairs.

12. Using 3M General Purpose Adhesive Cleaner spray liberally onto the old tape. Allow the adhesive cleaner to sit for 10 minutes, working in 1ft sections at a time (Fig 8).



Fig. 8

13. Once the adhesive cleaner has been allowed to sit for 10 minutes, start at one end of the spoiler removing tape using the non-gouging scraping tool and a terry cloth towel. Repeat step to remove all tape from part (Fig 9).

NOTICE: Use of a steel bladed scraper will score the lip spoiler tape surface and may result in ineffective repairs.



Fig. 9

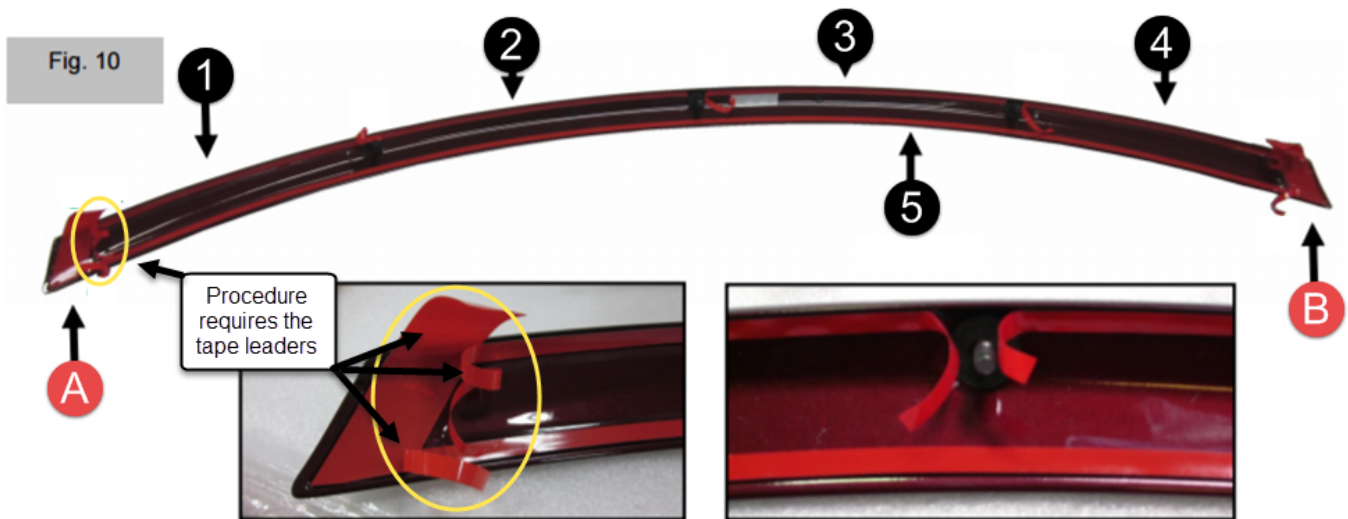
Avalon Rear Lip Spoiler (Cont.)

14. Once clean, wipe surface with a clean terry cloth towel and 50/50 Isopropyl Alcohol/Water mixture to remove any remaining adhesive cleaner residue. (Fig 10).



Application of tape to Spoiler

NOTICE: The following steps include special procedures to cut the tape leaving extra backing leader tabs. These leaders are mandatory for proper installation. Failure to include tape leaders during the tape application will result in ineffective repairs.



15. Apply the 1 ¼ in x 1 in wide diagonally cut pieces at the ends of the spoiler. Locations A and B as noted in Fig 10

Avalon Rear Lip Spoiler (Cont.)

16. For Tape positions 1, 2, 3, 4, and 5 as noted in Fig. 10 apply tape using the following process.

- a. Roll out the tape to the desired length needed for the section (Fig 11).

HINT: Tape should lie entirely within the tape channel.



- b. Cut the tape 2 inches longer than needed.
- c. Peel the red backing from the 2 inch section so that the tape and backing connect back at the cutting point of the tape (Fig 12).



- d. Once you have split the tape and red backing to desired length, cut tape, leaving 2 inch red tab behind (Fig 13).



- e. Repeat Procedure for locations 1-5 as noted in fig 10.

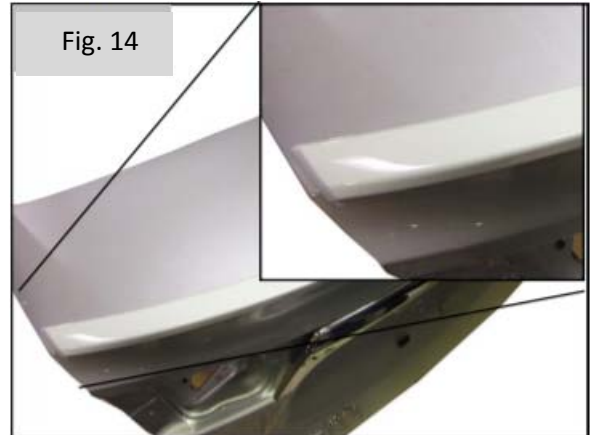
Avalon Rear Lip Spoiler (Cont.)

Spoiler Installation

NOTICE: Do not remove red backing from tape until step 21 of page 9. Failure to follow proper sequence will result in repeat repairs.

17. Test fit Spoiler onto trunk lid. Align studs on spoiler to holes in trunk lid. Make sure spoiler is centered left to right ± 2 mm (Fig 14).

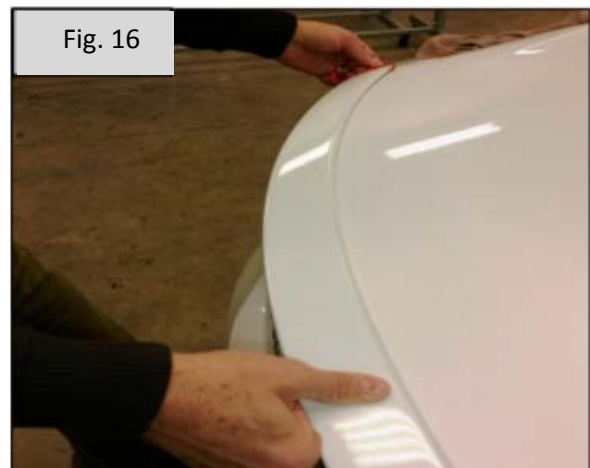
HINT: Verify the rear of the spoiler is in contact with the deck lid just above Toyota emblem. There should be no gaps between the spoiler and the deck lid.



18. Remove Spoiler, thoroughly clean trunk lid using 50/50 Isopropyl Alcohol/Water mixture and allow to dry completely. Apply 3M Paint Sealer to exposed metal around holes if needed (Fig 15).

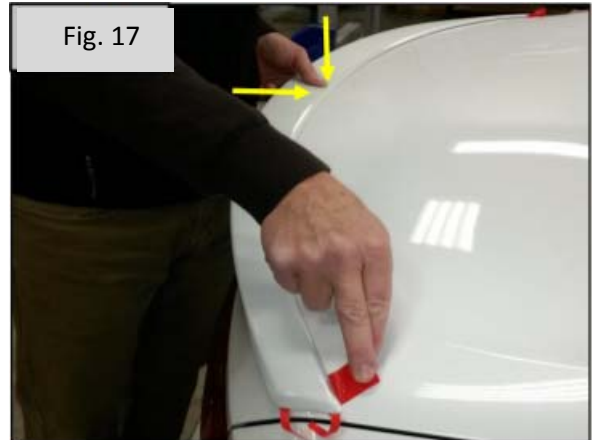


19. Install the 3 foam rings on the treaded spoiler studs.
20. Position spoiler on trunk lid by aligning studs on spoiler to holes drilled in trunk. Align spoiler an equal distance from edge on both ends ± 2 mm (Fig 16).



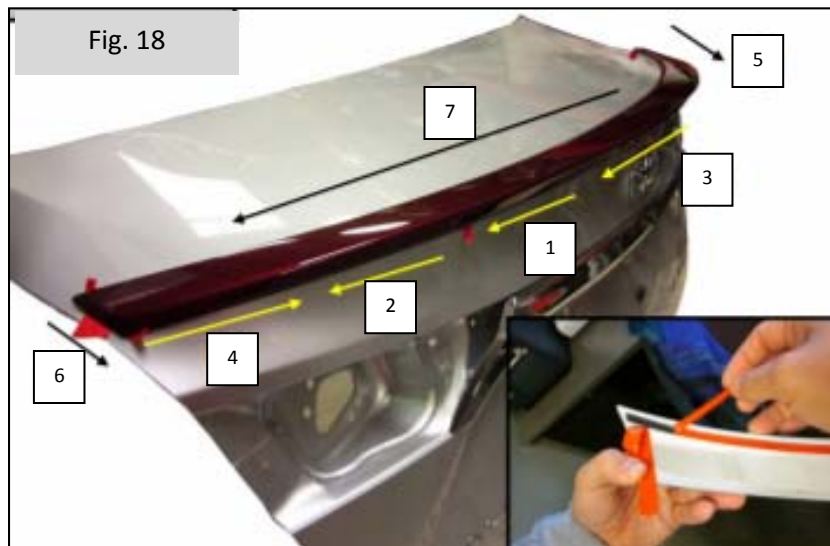
Avalon Rear Lip Spoiler (Cont.)

21. Position Spoiler forward and down to eliminate potential gapping on lower rear edge of the spoiler where it meets the rear trunk surface. Doing so will also minimize potential gapping on the front edge of the spoiler where it meets the top trunk. Ensure that tape liner pull tabs are accessible (Fig. 17).



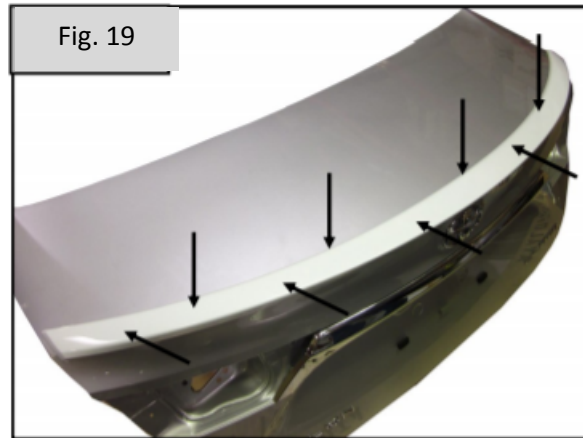
22. With the spoiler positioned correctly on the deck lid, pull the red tape liners in the order and direction specified in Fig 18. Apply pressure to spoiler after each piece of tape is removed.

NOTICE: Make sure the rear of the spoiler is in contact with the center of the deck lid before removing the tape liner. Gaps between the spoiler and deck lid in this area may result in ineffective repairs.



Avalon Rear Lip Spoiler (Cont.)

23. Using a soft cloth and working from the center outward, apply even forward and downward pressure along the rear edge of the spoiler to ensure proper bonding of the adhesive tape. Repeat this step three times (Fig 19).



24. Working from the center outward, apply even pressure along the top surface of the spoiler. Repeat this process one time (Fig 20).



25. 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, do not exceed 30 in.lbs. in the order shown (Fig 21).

NOTICE: Over tightening of the spoiler retaining nuts will cause internal tension in spoiler resulting in ineffective repair.



26. Vacuum any metal shavings from trunk and trunk lid

Avalon Rear Lip Spoiler (Cont.)

27. Reinstall trunk liner using factory fasteners removed in step 6 (Fig 22).

