

# COLLISION REPAIR INFORMATION

## FOR THE TOYOTA DEALER

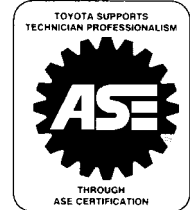
TITLE: URETHANE ADHESIVE SEALANT FOR  
FIXED GLASS INSTALLATION

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SECTION: STRUCTURAL REPAIR BULLETIN #31

MODELS: ALL

DATE: NOVEMBER 1988



In order to comply with FMVSS 212 – Windshield Retention and FMVSS 216 – Roof Crush Resistance, the factory uses a urethane adhesive sealant with bonded strength of not less than 40 kilograms per square centimeter or 569 pounds per square inch for certain bonded windshields and rear windows on Toyota vehicles.

A Urethane adhesive sealant of at least equivalent strength must be used to maintain these retention and roof crush standards when windshield glass replacements are performed by either the dealer or an outside glass shop.

Since the adhesive kits listed in Toyota Repair Manuals are not available in the U.S.A., a listing of some locally available equivalent materials is provided below. Be sure to follow the sealant manufacturer's instructions for best results.

- CVS Urethane Auto Glass Sealer by American Sure Seal  
Bonding strength = 600 pounds per square in. (approximate)
- Super Fast Urethane by 3M  
Bonding strength = 1000 pounds per square in. (approximate)
- Unrest 212 by Kent Industries  
Bonding strength = 600 pounds per square in. (approximate)
- Urethane E Auto Glass Sealer by Protective Treatment Inc.  
Bonding strength = 600 pounds per square in. (approximate)

For more detailed application information, see the attached “Urethane Adhesive Sealant Application for Toyota Models”.

Rear quarter windows on some models are bonded, however, the adhesive for these windows requires less bonding strength and therefore, use of Butyl sealer may be sufficient for these windows.

This bulletin is for information and clarification purposes only. Existing Warranty policy and Flat Rate information have not been changed. Toyota is not responsible for problems that occur from usage of improper sealants or procedures which fail to meet Toyota specifications. PLEASE CONSULT THE APPROPRIATE TOYOTA SERVICE MANUAL FOR THE PROPER REPAIR PROCEDURES.

**NOTE: PLEASE ROUTE THIS BULLETIN TO YOUR COLLISION REPAIR CENTER  
MANAGER**



**URETHANE ADHESIVE SEALANT APPLICATION FOR TOYOTA MODELS**

MODEL	BODY	WINDSHIELD	REAR WINDOW	QUARTER WINDOW
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**TERCEL**

AL/EL 8608 to date EL	2-Dr Sdn 4-Dr Sdn 5-Dr Sdn	Urethane Bonded	Conventional Weatherstrip	Butyl Bonded
8308 to 8802 AL	5-Dr Wgn	Urethane Bonded	Conventional Weatherstrip	Conventional Weatherstrip
8208 to 8607 AL	3-Dr L/B	Urethane Bonded	Conventional Weatherstrip	Conventional Weatherstrip

**COROLLA**

FWD AE 8708 to date	2-Dr S/C 4-Dr Sdn	Urethane Bonded	Urethane Bonded	Butyl Bonded
	All-Trac Wgn	Urethane Bonded	Urethane Bonded	Butyl Bonded
	4-Dr Wgn	Urethane Bonded	Conventional Weatherstrip	Butyl Bonded
FWD AE 8409 to 8707	4-Dr Sdn	Urethane Bonded	Conventional Weatherstrip	Conventional Weatherstrip
	5-Dr L/B	Urethane Bonded	Conventional Weatherstrip	Butyl Bonded
FX Models 8608 to 8807	3-Dr L/B	Urethane Bonded	Conventional Weatherstrip	Conventional Weatherstrip
RWD AE 8409 to 8707	2-Dr S/C 2-Dr L/B	Urethane Bonded	Conventional Weatherstrip	Butyl Bonded

**MR2**

AW 8501 to date	2-Seater	Urethane Bonded	Conventional Weatherstrip	Butyl Bonded
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**CELICA**

ST 8509 to date	2-Dr S/C 2-Dr L/B	Urethane Bonded	Urethane Bonded	Butyl Bonded
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**SUPRA**

MA70 8601 to date	2-Dr L/B	Urethane Bonded	Urethane Bonded	Butyl Bonded
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**URETHANE ADHESIVE SEALANT APPLICATION FOR TOYOTA MODELS (cont'd)**

MODEL	BODY	WINDSHIELD	REAR WINDOW	QUARTER WINDOW
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**CAMRY**

SV/VV 8609 to date	4-Dr Sdn	Urethane Bonded	Urethane Bonded	Butyl Bonded
	5-Dr Wgn	Urethane Bonded	Urethane Bonded	Butyl Bonded
SV/CV 8409 to 8608	4-Dr Sdn 5-Dr L/B	Urethane Bonded	Conventional Weatherstrip	Butyl Bonded

**CRESSIDA**

MX 8808 to date	4-Dr Sdn	Urethane Bonded	Conventional Weatherstrip	Urethane Bonded
8404 to 8807	4-Dr Sdn	Urethane Bonded	Urethane Bonded	Butyl Bonded
	5-Dr Wgn	Urethane Bonded	Conventional Weatherstrip	Butyl Bonded

**VAN**

YR 8309 to date	Passenger/ Cargo	Urethane Bonded	Conventional Weatherstrip	Conventional Weatherstrip
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**LAND CRUISER**

FJ	4-Dr Wgn	Conventional Weatherstrip	Conventional Weatherstrip	Conventional Weatherstrip
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**TRUCK**

RN/LN 8808 to date	4 x 2 4 x 4	Refer to Service Manual	Conventional Weatherstrip	Conventional Weatherstrip
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**TRUCK**

RN/LN 8309 to 8807	4 x 2 4 x 4	Refer to Service Manual	Conventional Weatherstrip	Conventional Weatherstrip
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**4RUNNER**

8408 to date	All	Urethane Bonded	Conventional Weatherstrip	Butyl Bonded
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The following urethane adhesive kits described in Toyota Repair Manuals are not available in the U.S.A.

Adhesive Kits in Toyota Repair Manuals

P/N      08850-00070 32 to 59 degrees F (0 to 15 degrees C)  
           08850-00080 59 to 95 degrees F (15 to 35 degrees C)  
           08850-00090 95 to 113 degrees F (35 to 45 degrees C)