

**Part Number: PT478-11170-09**

**Kit Contents**

Item #	Quantity Req.	Description
1	1	Rear spoiler
2	1	Hardware kit
3		

**Hardware Bag Contents**

Item #	Quantity Req.	Description
1	4	M5 Nut
2	4	Clip
3	4	Hole plug

**Additional Items Required For Installation**

Item #	Quantity Req.	Description
1		
2		
3		

**Conflicts**

Vehicles with retractable deck lid spoiler
--

**General Applicability**







All models without retractable rear deck lid spoiler
--

**Recommended Sequence of Application**

Item #	Accessory
1	
2	
3	

\*Mandatory

**Legend**

	<b>STOP:</b> Damage to the vehicle may occur. Do not proceed until process has been complied with.
	<b>OPERATOR SAFETY:</b> Use caution to avoid risk of injury.
	<b>CAUTION:</b> 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.
	<b>TOOLS &amp; EQUIPMENT:</b> Used in Figures calls out the specific tools and equipment recommended for this process.
	<b>REVISION MARK:</b> This mark highlights a change in installation with respect to previous issue.
	<b>SAFETY TORQUE:</b> This mark indicates that torque is related to safety.

**Recommended Tools**

<b>Personal &amp; Vehicle Protection</b>	Notes
Safety glasses	
<b>Special Tools</b>	Notes
Outer drill fixture	
Access hole drill fixture	
1/4" Collet	9/16" body diameter drill bit extension – part #3016A251
Drill bit extension	4" length, 3/8" shank diameter, 9/16" body diameter – part #3016A15
5/16" Collet	9/16" body diameter drill bit extension
Non-intrusive IR temperature probe/gun	
<b>Installation Tools</b>	Notes
Panel pry tool	
Scissors	
Tape measure	Metric
Masking tape	
Center punch	Spring loaded
Drill	
Drill bit	3mm (1/8"), 6.4mm (1/4"), 7.9mm (5/16")
Drill stop	3mm (1/8"), 6.4mm (1/4"), 7.9mm (5/16")
Hole saw	19mm (3/4")
Deburring tool	
Ratchet	1/4" drive
Socket (deep)	8mm, 1/4" drive
Universal joint	1/4" drive
Long extension	1/4" drive
Torque wrench	1/4" drive, 5 N-m, 25 in-lbf
Vacuum	
Lint-free cloth	Micro fiber
Hot air blower	When mounting surface is below 60° F (15° C)
<b>Special Chemicals</b>	Notes
Cleaner	VDC approved cleaner

**Vehicle Service Parts** (may be required for reassembly)

Item #	Quantity Req.	Description
1		
2		
3		

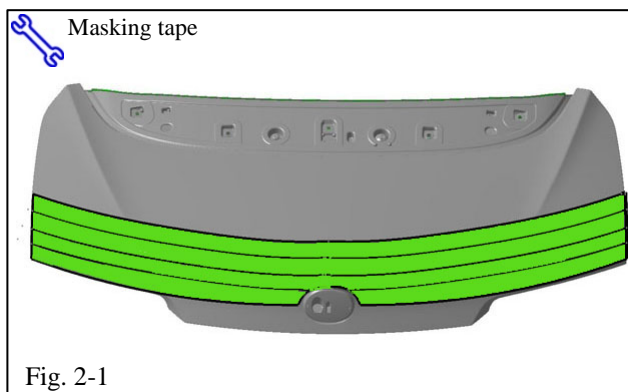
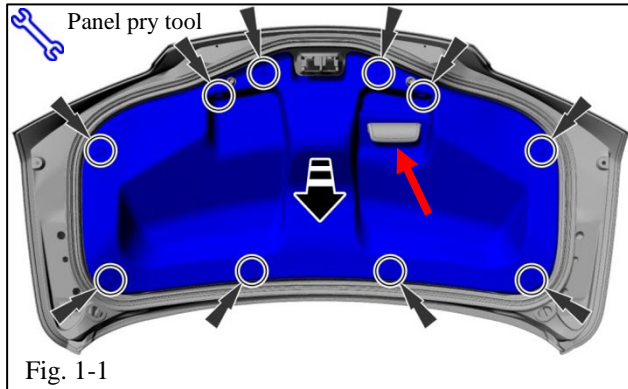
Care must be taken when installing this accessory to ensure damage does not occur to the vehicle. The installation of this accessory should follow approved guidelines to ensure a quality installation.

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 Lexus dealer for a copy of this document.



## 1. Prepare the Vehicle.

- (a) Open trunk lid.
- (b) Place a drop cloth in the trunk to cover and protect the inside against debris.
- (c) Use a panel pry tool to remove the plastic latch (red arrow, Fig. 1-1). Retain them for reuse.
- (d) Use a panel pry tool to remove the 10 fasteners (Fig. 1-1). Retain them for reuse
- (e) Remove the liner.
- (f) Close the trunk lid.

## 2. Secure the Drill Fixture.

- (a) If the vehicle still has Wrap Guard in place, do not remove it. Otherwise, apply tape to the entire rear deck lid (Fig. 2-1).

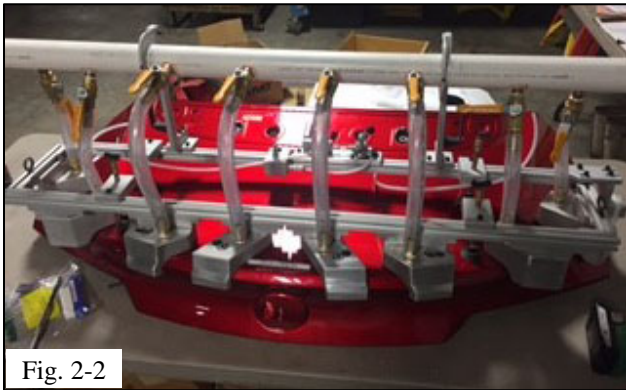


Fig. 2-2

(b) After the rear spoiler drill fixture has been calibrated, place the drill fixture on the rear door (Fig. 2-2). Ensure the vacuum and air supply are connected.

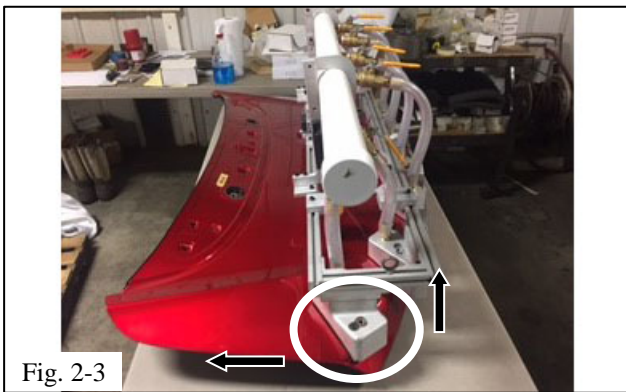


Fig. 2-3

(c) Align the fixture in position on the rear deck lid by ensuring the right side Delrin locator fits into the deck lid gap and the locating pads seat fully forward to the deck lid (Fig. 2-3).

(d) Once the fixture is located, turn on the vacuum to secure it in place.

### 3. Drill the Outer Deck Lid.



Fig. 3-1

(a) Starting with all chip vacuum valves closed, turn on the vacuum one valve at a time and drill the hole in the location where the valve is opened (Fig. 3-1).

**+ CAUTION:** Wear eye protection while drilling holes.

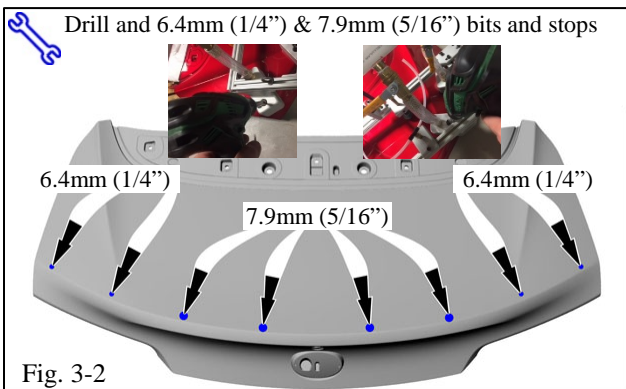
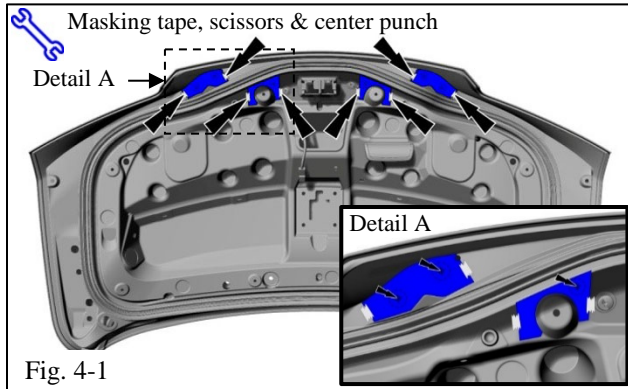


Fig. 3-2

(b) Use a 6.4mm (1/4") drill bit with a drill stop set at 58mm (2-9/32") to drill the 2 outboard holes (Fig. 3-2).

(c) Use an 8mm (5/16") drill bit with a drill stop set at 48mm (1-7/8") to drill the 4 inboard holes (Fig. 3-2).



#### 4. Secure the Inner Access Hole Templates.

- (a) Locate and cut out the inner access hole templates (Part No. PT478-11170-TL).
- (b) Position the LH and RH inboard and outboard access hole templates. Align the templates to the trunk lid inner as specified on the templates and tape them in place (Fig. 4-1).
- (c) Use a center punch to mark the hole centers at the 6 crosshairs on the drill templates (Fig. 4-1).
- (d) Remove the templates.

#### 5. Drill the Inner Access Holes.

**+** **CAUTION:** Wear eye protection while drilling holes.

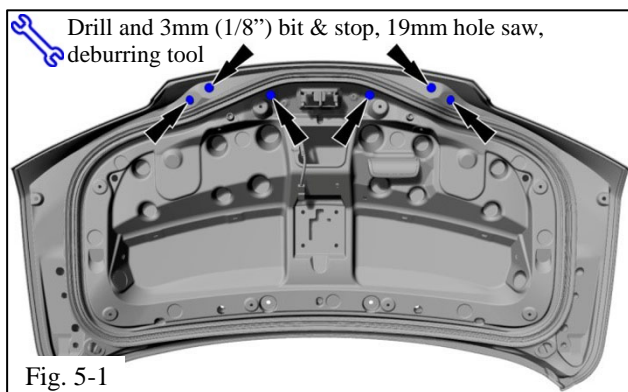
- (a) Ensure the blankets fully cover the vehicle interior below each back drill location.
- (b) Use a 3mm (1/8") drill bit with a drill stop set at 10mm (13/32") to drill pilot holes at the 6 center punch marks (Fig. 5-1).

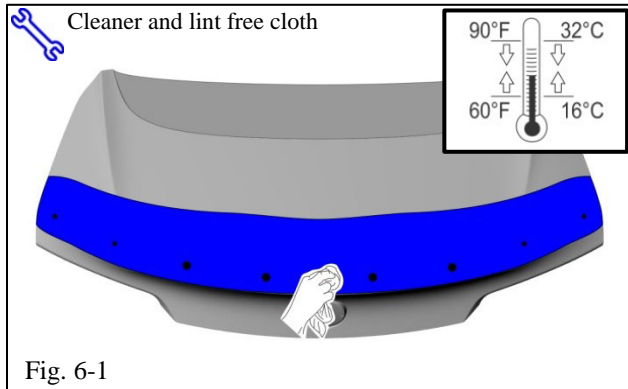
**STOP** **WARNING:** Do not allow the drill bit to contact the outer trunk panel.

- (c) Use a 19.0mm (3/4") hole saw to drill the 6 holes to final size.

**STOP** **WARNING:** Do not allow the hole saw to contact the outer trunk panel.

- (d) Use a deburring tool to clean the sharp edges of the 6 access holes.
- (e) Vacuum and remove all debris after drilling.
- (f) Close the trunk lid.





### 6. Prepare the Trunk Lid Surface.

- (a) Use VDC approved cleaner to thoroughly clean the surface area where the part will be mating to the trunk lid and allow it to dry before continuing (Fig. 6-1).

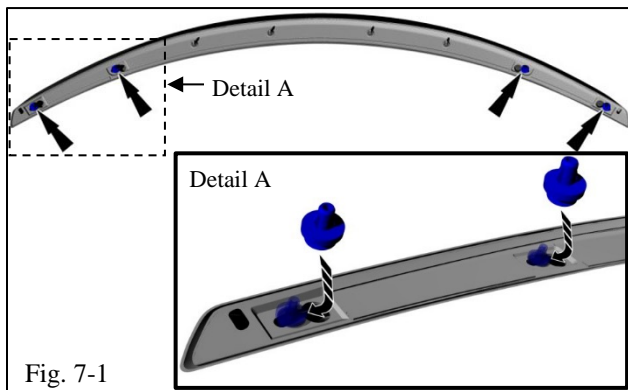
**⚠ NOTE:** The part will not adhere properly if the surface has not been completely cleaned of any contaminants.

**⚠ NOTE:** Once cleaned, do not contaminate the cleaned surfaces by touching them with bare hands.

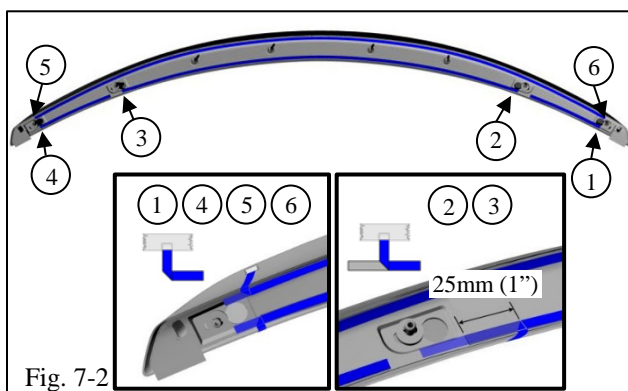
**⚠ (b)** The trunk lid and spoiler should be between 60°F and 90°F (16°C and 32°C) for proper set-up of adhesive tape. Use a hot air blower to heat the surface if the temperature is below 60°F (16°C).

### 7. Prepare the Rear Spoiler.

- (a) Attach supplied plastic push clips in the keyhole slots at the 4 locations on the spoiler (Fig. 7-1).



- (b) Carefully peel back the liner tabs and use masking tape to attach them to the spoiler. Ensure the liner tabs are folded as shown (Fig. 7-2).



- (c) When folding back the tape liners, expose 25mm (1") of adhesive tape ONLY at locations 2 and 3 to hold the spoiler in place after positioning it correctly (Fig. 7-2).

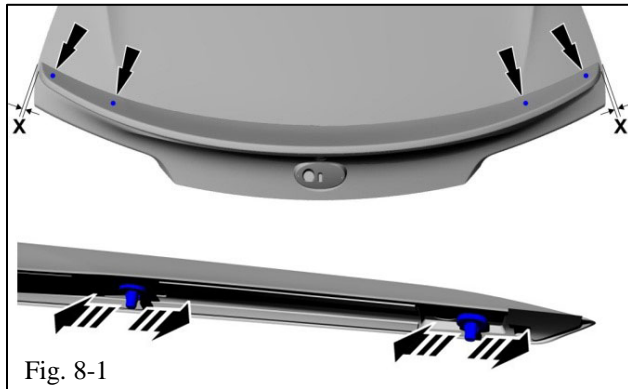


Fig. 8-1

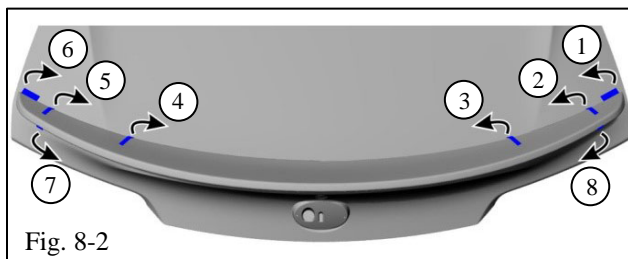


Fig. 8-2

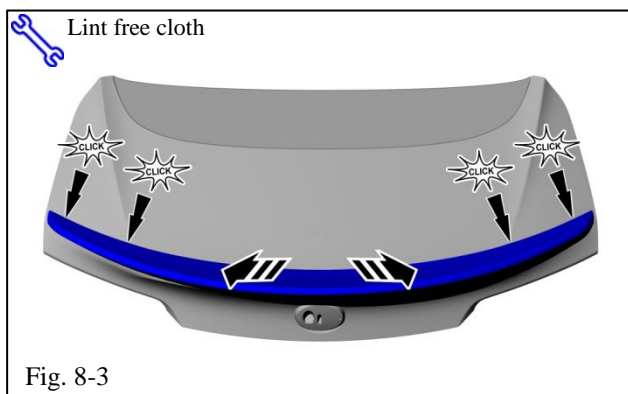


Fig. 8-3

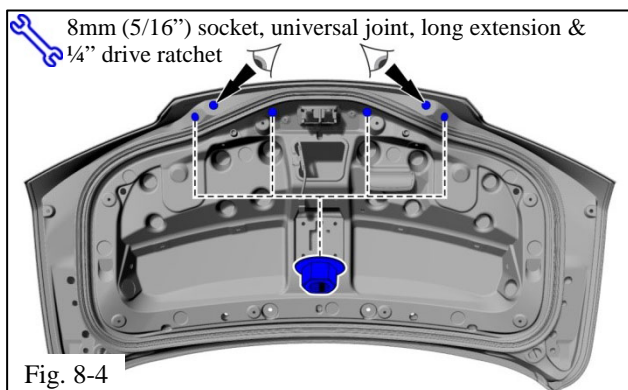
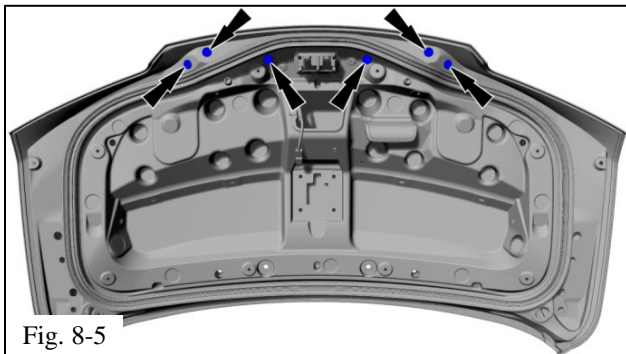


Fig. 8-4

### 8. Attach the Rear Spoiler to the Trunk Lid.

- (a) Adjust the 4 sliding clips to line up to the holes (Fig. 8-1). Confirm even spacing LH and RH at the outboard edges of the spoiler to the trunk lid.
  - (b) Before contacting the tape to the trunk lid, verify that the spoiler is centered (Fig. 8-1).
  - (c) After ensuring the spoiler is positioned correctly inboard/outboard, press the spoiler to the trunk lid.
  - (d) Remove the tape liners in the numerical order and direction as shown in Fig. 8-2.
- STOP NOTE:** Ensure the spoiler is properly aligned prior to removing any tape liners and pressing the spoiler in place. If the tape liners are difficult to remove, slightly pull the spoiler away from the trunk lid to assist.
- (e) Use a lint-free cloth to apply 15 lbs. of pressure to the spoiler to ensure the adhesive tape contacts the trunk lid around the entire perimeter of the part. Apply pressure starting from the center and move outboard (Fig. 8-3).
  - (f) Ensure the clips are engaged with a “click” sound at the 4 clip locations (Fig. 8-3).
  - (g) Open the trunk lid.
  - (h) Use a 1/4” drive ratchet, universal joint, extension, and 8mm (5/16”) deep socket to install M5 nuts to the studs through the access holes (Fig. 8-4).



- (i) Tighten the 4 M5 nuts to 2.35 N-m (21 in-lbf) of torque.

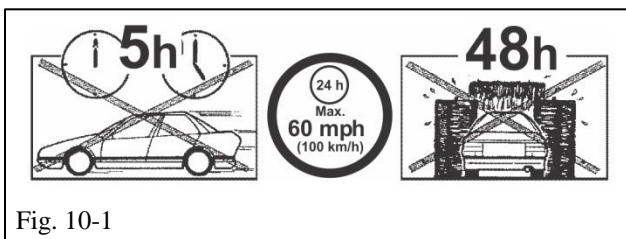
**⚠ Torque: 2.35 N-m (21 in-lbf)**

- (j) Install 4 Hole Plugs into the deck lid (Fig. 8-5).



**9. Reinstall the Trunk Lid Liner.**

- (a) Reinstall the 10 fasteners removed in Step 1(b) (Fig. 9-1).
- (b) Reinstall the plastic latch removed in Step 1(c).



**10. Let the Part Cure.**

- (a) Do not drive vehicle for 5 hours (Fig. 10-1).
- (b) Do not exceed 60 mph (100km/h) within 24 hours (Fig. 10-1).
- (c) Do not use high pressure water or an automated car wash machine within 48 hours (Fig. 10-1).

**LEXUS LC/LCh 2018 - CARBON FIBER REAR SPOILER**

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> <ul style="list-style-type: none"><li><input type="checkbox"/> Check for alignment</li><li><input type="checkbox"/> Check for gaps between spoiler and attaching base, including vehicle trunk lid</li></ul>	<p>Rear spoiler is centered left to right +/- 3.0mm</p> <p>Full adhesion of tape, maximum gap of 0.8mm</p>
<p><u>Vehicle Function Checks</u></p> <ul style="list-style-type: none"><li><input type="checkbox"/> Verify trunk lid operation</li><li><input type="checkbox"/> Verify rear camera operation</li></ul>	<p>When opened, the trunk lid should pop up and remain in the fully raised position</p> <p>Proper operation when vehicle is placed in Reverse</p>
<p><u>Vehicle Appearance Check</u></p> <ul style="list-style-type: none"><li><input type="checkbox"/> After accessory installation and removal of protective cover(s), perform a visual inspection.</li></ul>	<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>