

Title: **BLACKOUT TAPE APPLICATION**
 Models: '01 RAV4

BODY
BO015-01

Introduction Blackout tape is used instead of black paint on the door sash of the 2001 RAV4. Resistant polyvinyl chloride has been applied to the tape, giving it the same level of weather resistance as high quality paint. Please use the following instructions to apply the blackout tape.

Applicable Vehicles • 2001 model year **RAV4** vehicles.

Parts Information

PREVIOUS PART NUMBER	CURRENT PART NUMBER	PART NAME
75921-42020	Blackout Tape No. 1 RH	Front Door Upper Surface
75922-42020	Blackout Tape No. 1 LH	
75923-42020	Blackout Tape No. 2 RH	Front Door Vertical Surfaces
75924-42020	Blackout Tape No. 2 LH	
75941-42010	Center Pillar Stripe RH	Center Pillar
75942-42010	Center Pillar Stripe LH	
75987-42010	Rear Door Outside Stripe RH	Rear Door Upper Surface
75988-42010	Rear Door Outside Stripe LH	
75925-42010	Blackout Tape No. 3 RH	Rear Door Vertical Surfaces Front
75926-42010	Blackout Tape No. 3 LH	
75977-42010	Rear Door Outside Stripe Lower RH	Rear Door Vertical Surfaces Rear
75978-42010	Rear Door Outside Stripe Lower LH	

Required Tools & Material

TOOLS & MATERIALS	QUANTITY
Squeegee (3M PA-1 or Equivalent)	1
Magnet	As Needed

Warranty Information

OP CODE	DESCRIPTION	TIME	OPN	T1	T2
N/A	Not Applicable to Warranty	—	—	—	—

Index # 055158



Toyota Supports ASE Certification

**Vehicle
Preparation
Procedure**

Clean the paint surface with a wax, grease and silicone remover following the instructions on the label of the cleaner you choose to use.

NOTE:

The presence of wax, grease or silicone on the painted surfaces will prevent the tape from adhering properly.

NOTE:

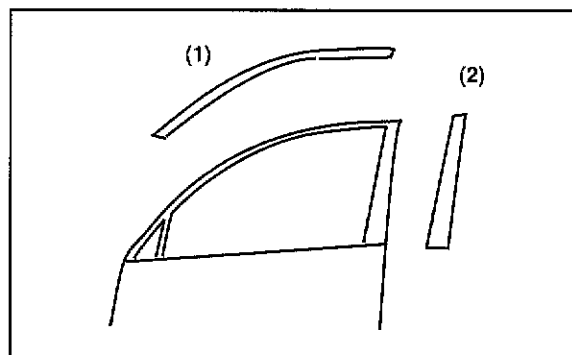
For easier application, the ambient temperature of the body surface and the surrounding area should be between 60° – 90°F.

- The tape is easily stretched. Do not pull it too hard when attaching.
- Shocklines are not apparent as those created by tape with a clear layer. The tape can therefore be removed and reattached to certain extent without damage.

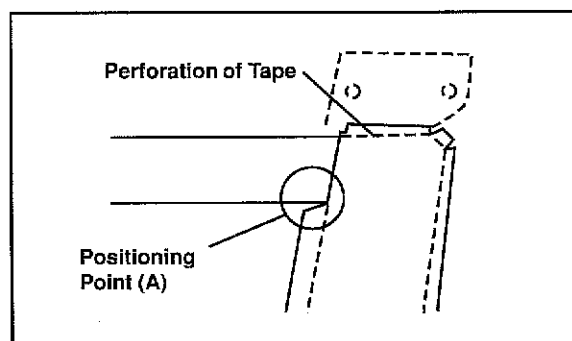
**Application
Procedure**

When replacing the blackout tape on the front door, the vertical piece (2) is applied first with the upper surface (1) applied second, slightly overlapping the vertical piece. Therefore if the vertical piece of tape (2) needs to be replaced, the upper tape (1) will also have to be replaced.

1. Remove the door trim panel, outside rear view mirror and belt molding following the instructions on pages BO-9 & BO-10 in the 2001 RAV4 Repair Manual.
2. Pull the door glass run away from the door window frame, but do not completely remove it from the door.

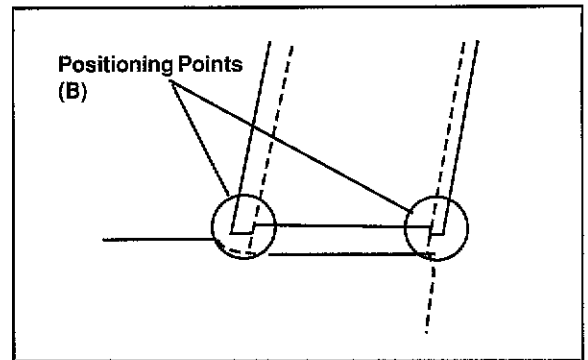
**Front Door Outer Vertical Surfaces**

1. Cut off the excess section of black out tape at the perforated line. Now position the tape against the door as follows:
 - A. Hold the tape against the door sash using point (A) as a reference point.



Application Procedure (Continued)

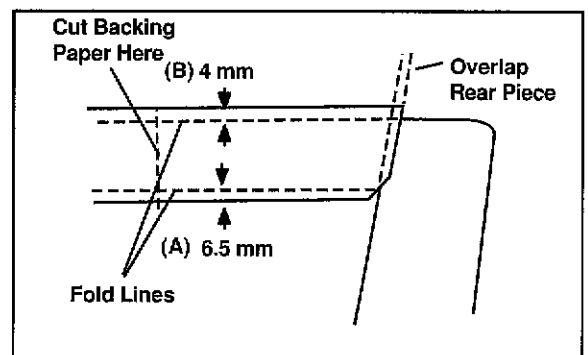
- B. Hold the lower part of the tape to the positioning points (B), and hold it in place with clips or magnetic plate.
2. Cut the separating paper at the top part of tape approximately 80 mm from the top edge, and attach the tape temporarily.
3. Remove the remaining backing paper in a top down direction, and attach the tape. After this, apply pressure twice to the whole area using a squeegee.
4. After applying heat to the rear upper corner with a hair dryer or heat gun, fold it over the corner of the door.
5. Remove bubbles or wrinkles.



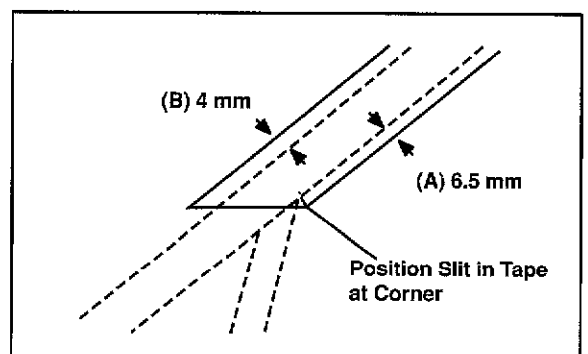
Front Door Outer Upper Surface

1. Attach blackout tape to the door sash with clips or magnets.

- A. At the rear of the door, set the tape position carefully according to the diagram, ensuring fold (A) is 6.5 mm and fold (B) is 4.0 mm in width.



- B. At the front of the door, align the slit in blackout tape to the intersection of the sash and the door mirror bracket. Position the tape so that fold (A) is 6.5 mm and fold (B) is 4.0 mm in width, and hold the tape in place with a clip or magnetic plate.
2. Remove a small piece of the separating paper at the rear of the door in a rearward direction from the cut line, and attach the tape temporarily.

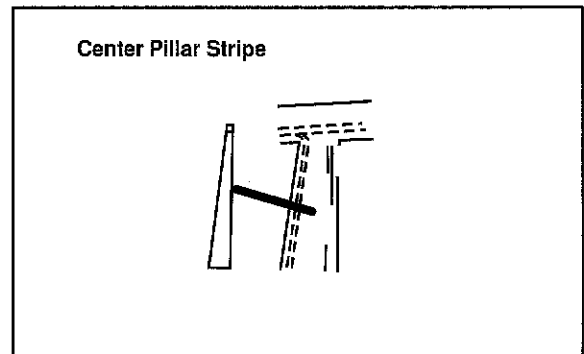


**Application
Procedure**
(Continued)

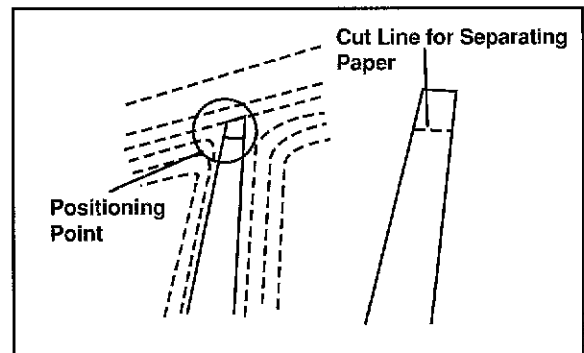
3. Remove the remaining separating paper in a forward direction, and attach the tape. After this, apply pressure twice to the whole area, including the temporarily attached portion.
4. Fold tape over the edges of the door sash and apply pressure.
5. Remove bubbles and wrinkles.

B-Pillar

1. Fit the blackout tape to the attaching position.

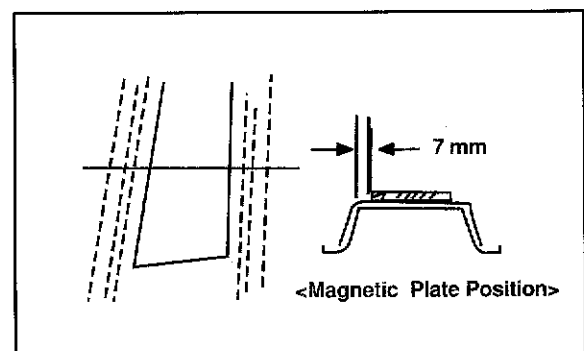


- A. Position the tape by aligning the top edge of the tape to the top of the pillar just before it bends into the roof line.



- B. Set the blackout tape 7 mm from the forward edge of the B-Pillar. Once the blackout tape is in position, attach it temporarily with a magnetic plate.

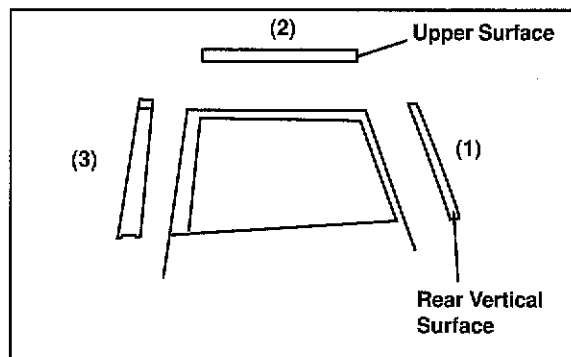
2. Remove the top section of separating paper and attach the tape temporarily.
3. Remove the remaining separating tape in a top-down direction, and attach the tape. After this, apply pressure twice to the whole area, including the temporarily attached position.
4. Remove bubbles and wrinkles.



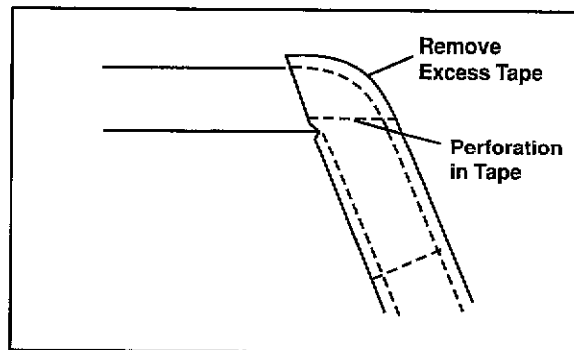
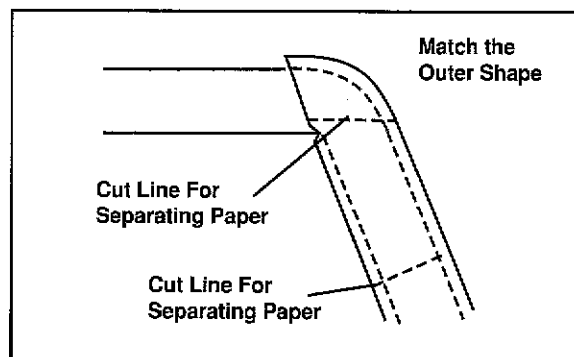
**Application
Procedure**
(Continued)

Rear Door Vertical Surfaces Rear

When replacing the blackout tape on the rear door, the vertical piece is applied first with the upper surface applied second, slightly overlapping the rear vertical piece. The front vertical piece is installed last, slightly overlapping the upper surface piece of tape. Therefore, if the rear vertical piece of tape needs to be replaced, the other two pieces of tape will also have to be replaced.



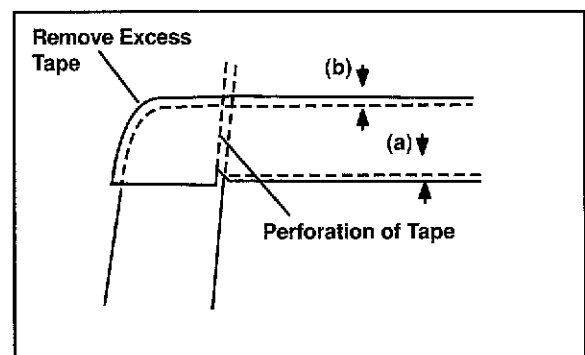
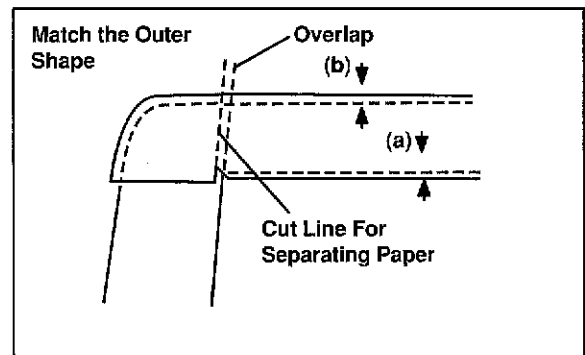
1. Remove the door trim panel, division bar, quarter window glass and door belt molding following the instructions on pages BO-17 & BO-18 in the 2001 RAV4 Repair Manual.
2. Pull the door glass run out of the way. It is not necessary to remove it completely.
3. Fit the blackout tape (1) to the attaching position.
 - For gauging the position of the top part of the tape, see diagram. Position it so that each fold is the same width, and hold it in place with a clip or magnetic plate.
4. Remove the separating paper between the two cut lines. (Do not remove the separating paper from the very top of the piece of tape. This section is only used for locating the tape and will be cut off later.) Temporarily attach the tape to the door.
5. Remove the rest of the separating paper and attach the tape. Then apply pressure twice to the whole area.
6. Place the squeegee at the top of the perforated part, and cut off the excess tape and separating paper. Press the remaining area down with the squeegee.
7. Remove bubbles and wrinkles.



**Application
Procedure**
(Continued)

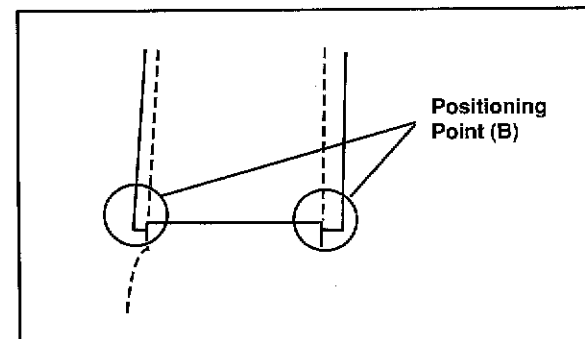
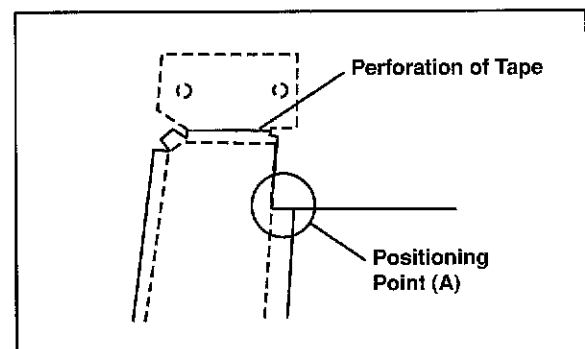
Rear Door Outer Upper Surface

1. Fit the blackout tape to the attaching position.
 - For gauging the position at the rear of the vehicle, see diagram. Position the tape so that fold (a) is 6.5 mm and fold (b) is 4.0 mm in width, and hold the tape in place with a clip or magnetic plate.
2. Remove the separating paper from the blackout tape and attach the tape temporarily.
3. Remove the remaining separating tape in a forward direction, and attach the tape. After this, apply pressure twice to the whole area, including the temporarily fixed position.
4. Now remove the excess tape used to position the tape on the door.
5. Fold the edges of the tape over the edges of the door and apply pressure with the squeegee.
6. After applying heat to the right upper corner sectioned area, fold it over.
7. Remove bubbles and wrinkles.



Rear Door Outer Vertical Surfaces Front

1. Cut the top of tape and separating paper at the perforations, and fit it to the attaching position.
 - A. Attach to the positioning point (A) on the sash as shown in the diagram.
 - B. Fit the lower part of tape to the positioning point (B), and hold it in place with clips or magnetic plate.



**Application
Procedure**
(Continued)

2. Cut approximately 80 mm of the separating paper from the top of the tape, and attach the tape temporarily.
3. Remove the remaining separating paper in a forward direction, and attach the tape. After this, apply pressure twice to the whole area, including the temporarily fixed areas.
4. Fold the edges of the tape over the edges of the door and apply pressure with the squeegee.
5. After applying heat to the right upper corner sectioned area, fold the small tabs over.
6. Remove bubbles and wrinkles.

**Inspection
Procedure**

- If there are no obvious shocklines, bubbles, or creases, and the folded parts and the upper and lower/left and right extremities are positioned correctly, the process is complete.
- If there are large bubbles (over 1 mm diameter) or obvious collection of shocklines, or if there is a series of connecting small bubbles, the tape should be replaced.