

**F SPORT PARTS****MS343-48005/6/7**

rear diffuser

Installation and handling instructions

Thank you very much for purchasing the SPORT PARTS Rear Diffuser. This manual describes the installation and handling of this product and precautions. Please read it before installation and install and handle it correctly. Please give this manual to your customer.

★This product cannot be installed on unregistered vehicles. Installation should be performed after the vehicle is registered.

Product number/Compatible car model

Product number	Paint color	Compatible car models	remarks
MS313-48005-A0	White Nova Glass Flake (083)		
MS313-18005-CO	Graphite Black Glass Flake (223)		
MS313-18006-NP	Unpainted	RX '22.10~	
MS343 48007	Black Edition		

· For the latest compatibility information, please visit the TRD catalog site: <https://www.trdparts.jp/>

\*This product is to be installed together with the "SPORT PARTS sports muffler".

component parts

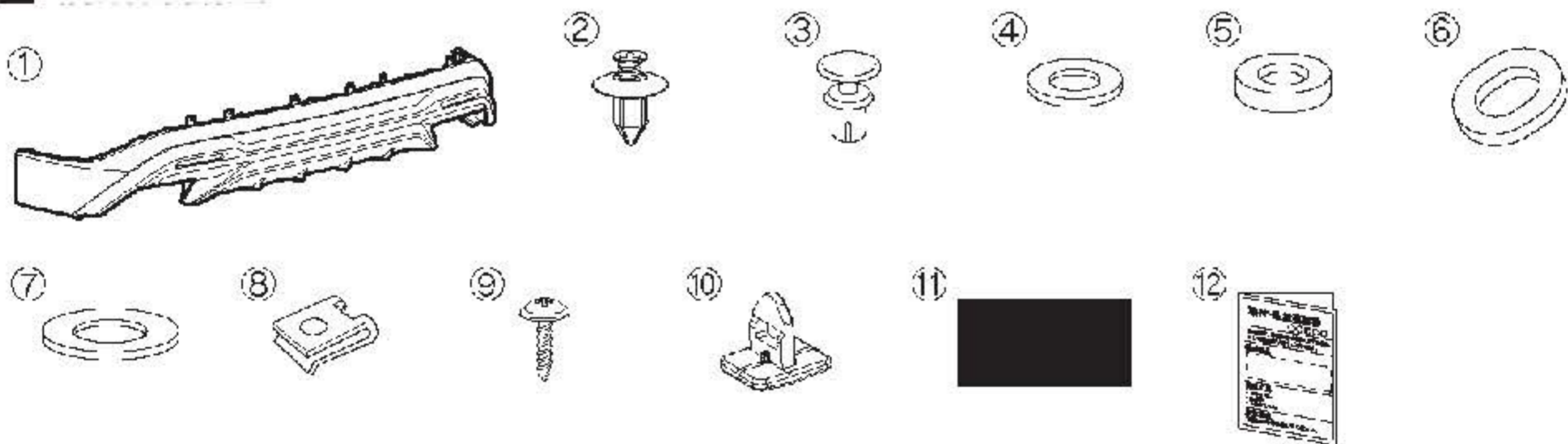
No.	Part name	quantity	remarks
①	Rear diffuser	1	
②	Go to clip	4	
③	Clip B	1	
④	Resin washer A	2	t=2.0 inner diameter 8 Outer diameter 13
⑤	Resin washer	1	l=3.0 Inner diameter 5.5 Outer diameter 15
⑥	Rubber washer A	6	t=1.0 (elliptical shape)
⑦	Rubber washer B	4	l=1.0 Inner diameter 13 Outside diameter 20
⑧	J nut	2	
⑨	Tapping screw	2	
⑩	Bumper clip base	8	
⑪	Blackout film	1	20mm×40mm
12	Installation and handling instructions	1	This book

The following items are included only with MS343-48006-NP (unpainted product set)

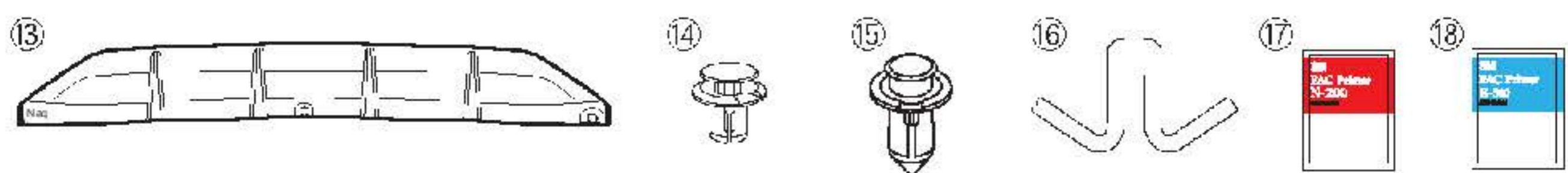
No.	Part name	quantity	remarks
③	Outer beads	1	
④	Clip B	1	
⑩	Clip C	21	
⑩	Masking tape (RII/LII)	each	
⑦	PAC primer (red bag)	1	N-200
18	PAC Primer (blue-bag)	1	K 500

\*Check: Upon receiving this product, please immediately check that there is no damage to the main unit and that all accessories are included.

Component diagram





The following items are included only with MS343 48006 NP (unpainted product set)



# Installation precautions (for installers)

Please be sure to read this before carrying out any work to ensure a safe and reliable installation.

 warn	This indicates that failure to follow this instruction and performing incorrect installation or handling could result in danger to life or serious injury.
 Notice	Failure to follow the precautions and improper installation or handling may result in an accident, injury, or damage to the vehicle.
• Advice	This describes what you need to know to work quickly and safely.

## • Things you shouldn't do

## • What you must do

### warn

Do not modify or alter this product, or install it on vehicles other than those for which it is designed, as this may result in a serious accident or breakdown.

- When installing or replacing this product, please follow the repair manual for the relevant vehicle (issued by Toyota Motor Corporation) and observe the precautions in this manual.
- When installing, be sure to tighten the screws securely according to the specified torque. If the screws are not tightened enough, they may fall off, resulting in a serious accident or breakdown.

### ▲ Attention

- Before installing this product, please check that the main unit and all components are present and that there is no damage or malfunction. We may not be able to respond to claims for damage or malfunction discovered after installation.

When installing this product, please handle it on a protective sheet to prevent scratches, and at the same time, cover the installation area with protective material before proceeding. Please be careful not to scratch or damage the product during installation.

Regarding degreasing work (please also refer to the attached degreasing work instructions)

- When degreasing, use a clean cloth and isopropyl alcohol (IPA). Never use any solvents other than those listed.
- When degreasing, never use surface preparation agents such as body coatings, or solvents such as parts cleaners or brake cleaners. They will not degrease properly and may cause the paint to float or peel off.

### About double-sided tape

- If degreasing is neglected, the double-sided tape will come off even if it is applied.
- Once the double-sided tape has been applied and then removed, its adhesive strength will decrease and it cannot be reapplied.
- The adhesive ability of this product's double-sided tape decreases significantly when the ambient temperature is low, below 20°C.  
If the temperature is not high enough, the double-sided tape will peel off. •

Be sure to apply pressure of 49N (5kgf) or more when applying the double-sided tape (enough to make the vehicle shake slightly).

If the pressure is not enough, the double-sided tape will come off.

After installing this product, please avoid washing the car, water (including wiping with water), rain, etc. Failure to follow the precautions after installation may cause the product to float or peel off.

### Regarding painting of unpainted products

- This product requires surface preparation before painting, so be sure to start with applying a primer.

When painting this product, be sure to completely mask the double-sided tape.

When drying, fix the product in place to prevent deformation. Also, dry at temperatures below 70°C, as high drying temperatures may cause deformation or cracks.

### After installation is complete

- After installation, please make sure that this product does not interfere with the vehicle.
- If you have disconnected the negative battery terminal during installation, please set and check the system after completing the work. • Resetting and adjustment may be required depending on the parts that have been disassembled or removed during this installation.

Please inspect, adjust, and set each part in accordance with the repair manual for the vehicle in question (issued by Toyota Motor Corporation).—

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■ Tools, protective gear, and consumables required for installation

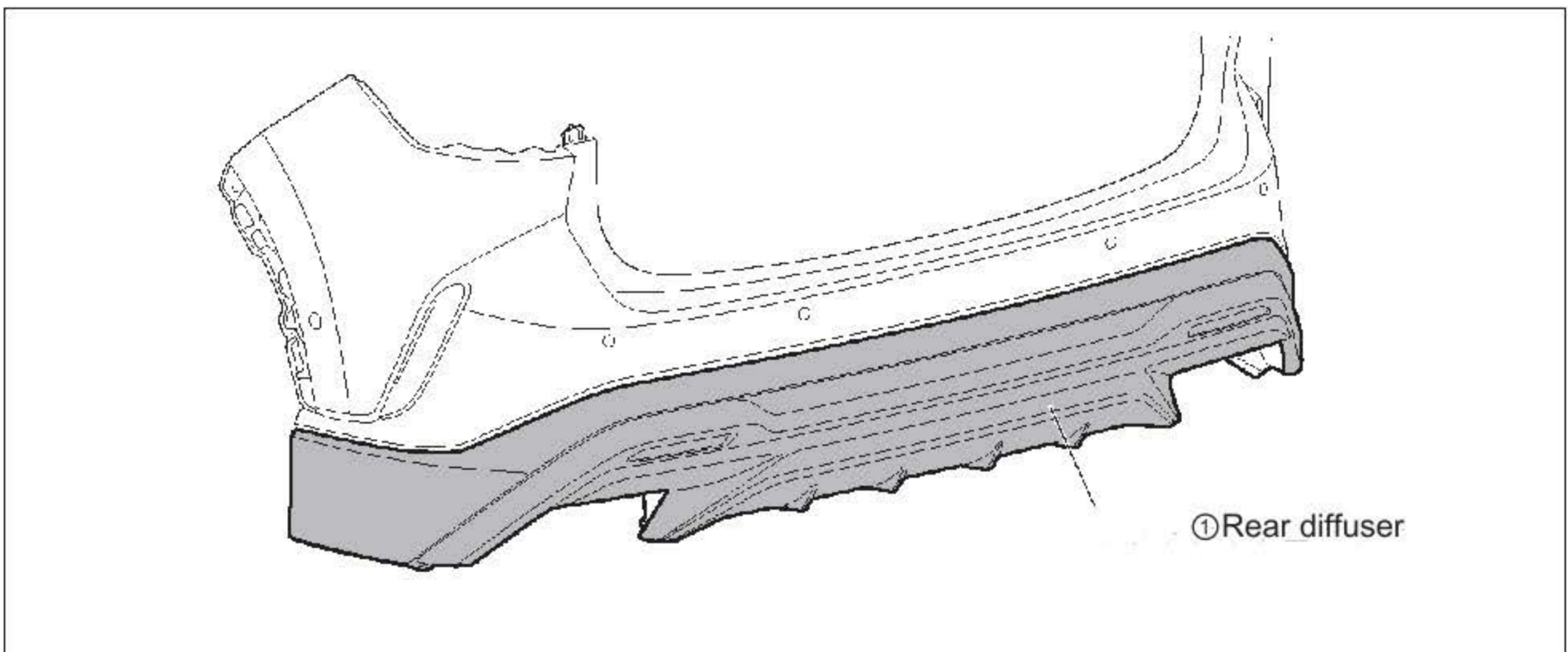
- General tools
- Protective glasses, gloves, protective sheet, protective tape
- Isopropyl alcohol (IPA) - Clean cloth

■ About warranty

This product comes with a 3-year/60,000km warranty (3 years or 60,000km, whichever comes first).

\*For details about the warranty, please see "About Warranty" on the TRD parts catalog site <<https://www.trdparts.jp/>>.

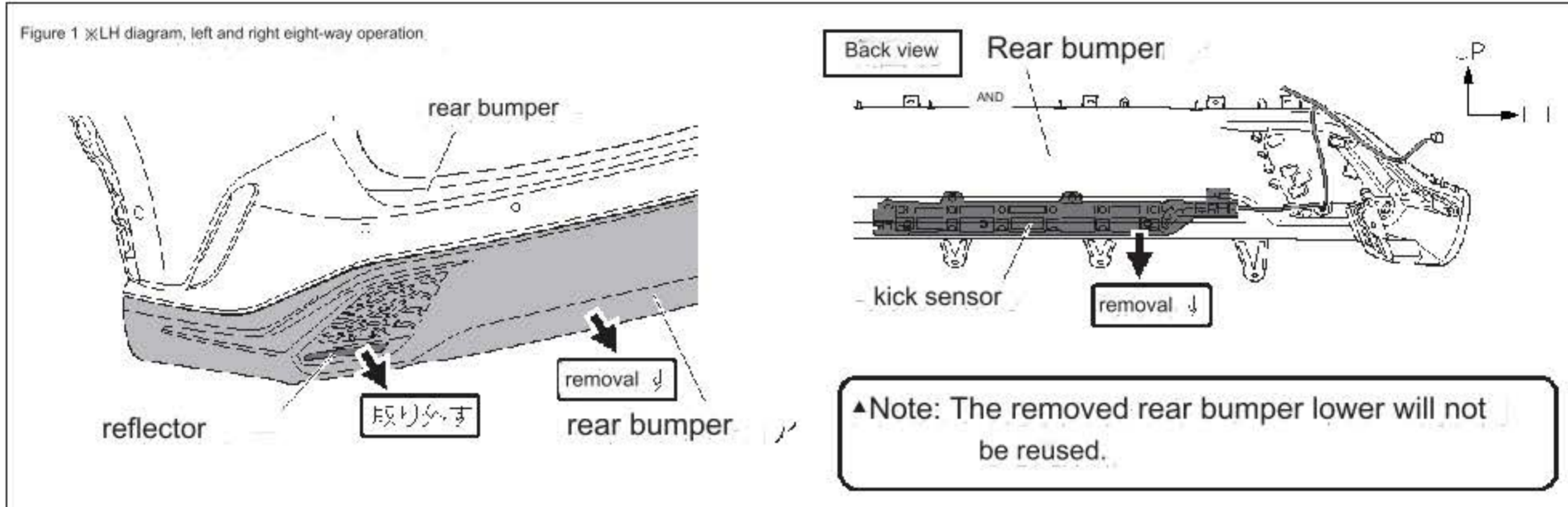
■ Installation configuration diagram



\*This installation and handling manual mainly indicates the LH side, but please do the same for the RH side.

□ Rear diffuser installation preparation

1. Remove the rear bumper from the vehicle according to the repair manual for the vehicle in question.
2. As shown in Figure 1, remove the rear bumper lower from the rear bumper, and then remove the kick sensor and reflector from the rear bumper lower, following the repair manual for the vehicle in question.



▲Note: The removed kick sensors, reflectors, vehicle pins and vehicle clips will be reused, so be sure to store them in a safe place.

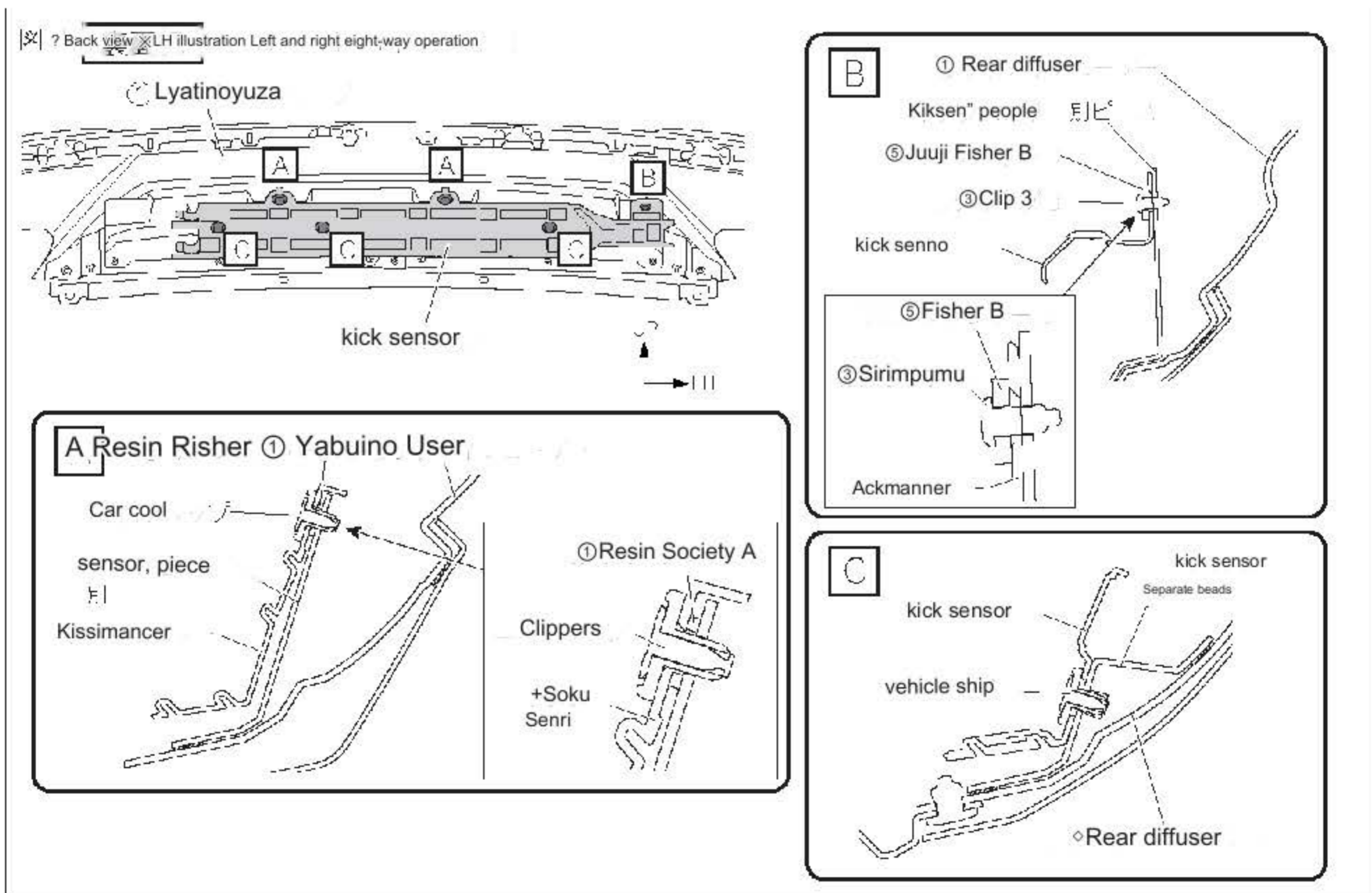
3. Move the kick sensor to the rear diffuser ① as shown in Figure 2.

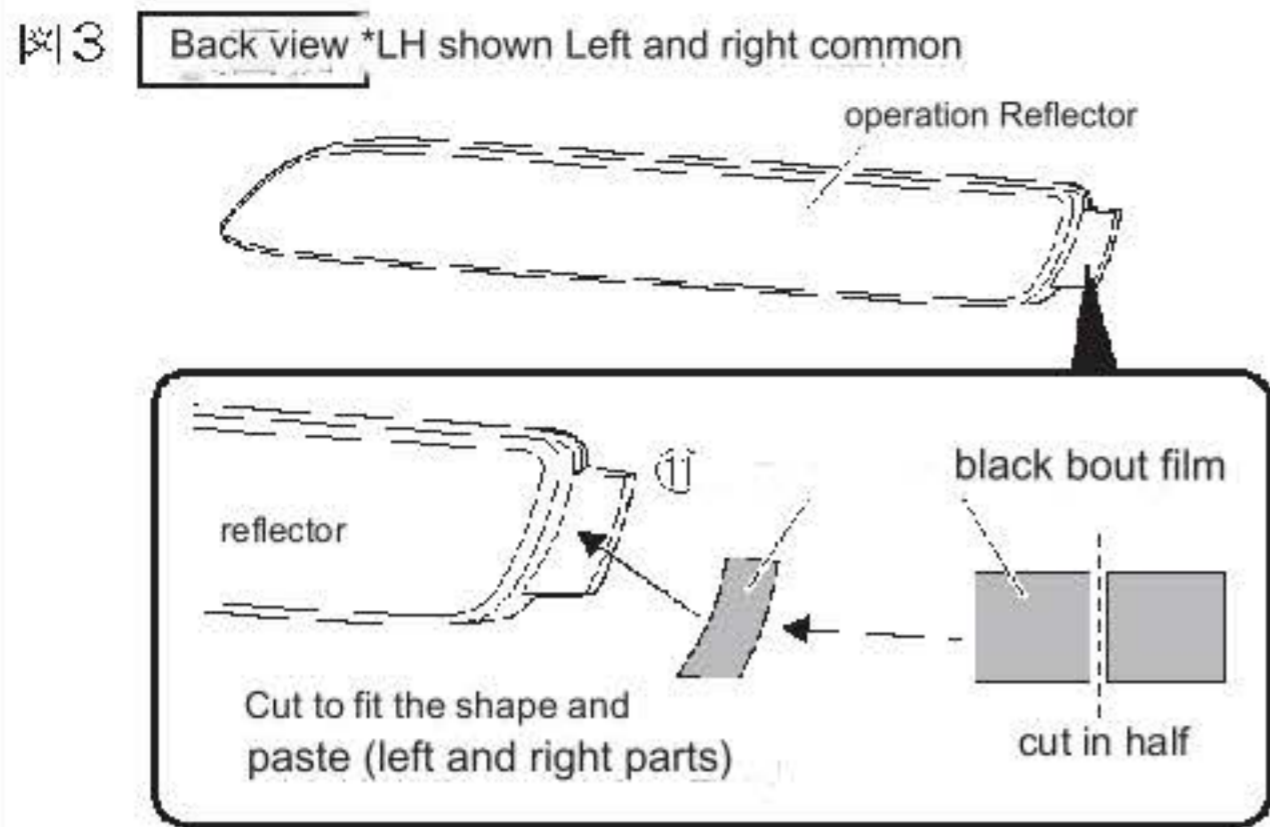
Fastening part 8: Vehicle clip, ④ to plastic washer ※ Attach to separate kick sensor piece (2 places)

Fastening part B: ③ Clip B, ⑤ Resin washer B \* Attach to the kick sensor (1 location)

• Fastening section C: Vehicle clips (3 locations)

\* ④ Resin washer A and ⑤ Resin washer B are attached after degreasing the attachment area.

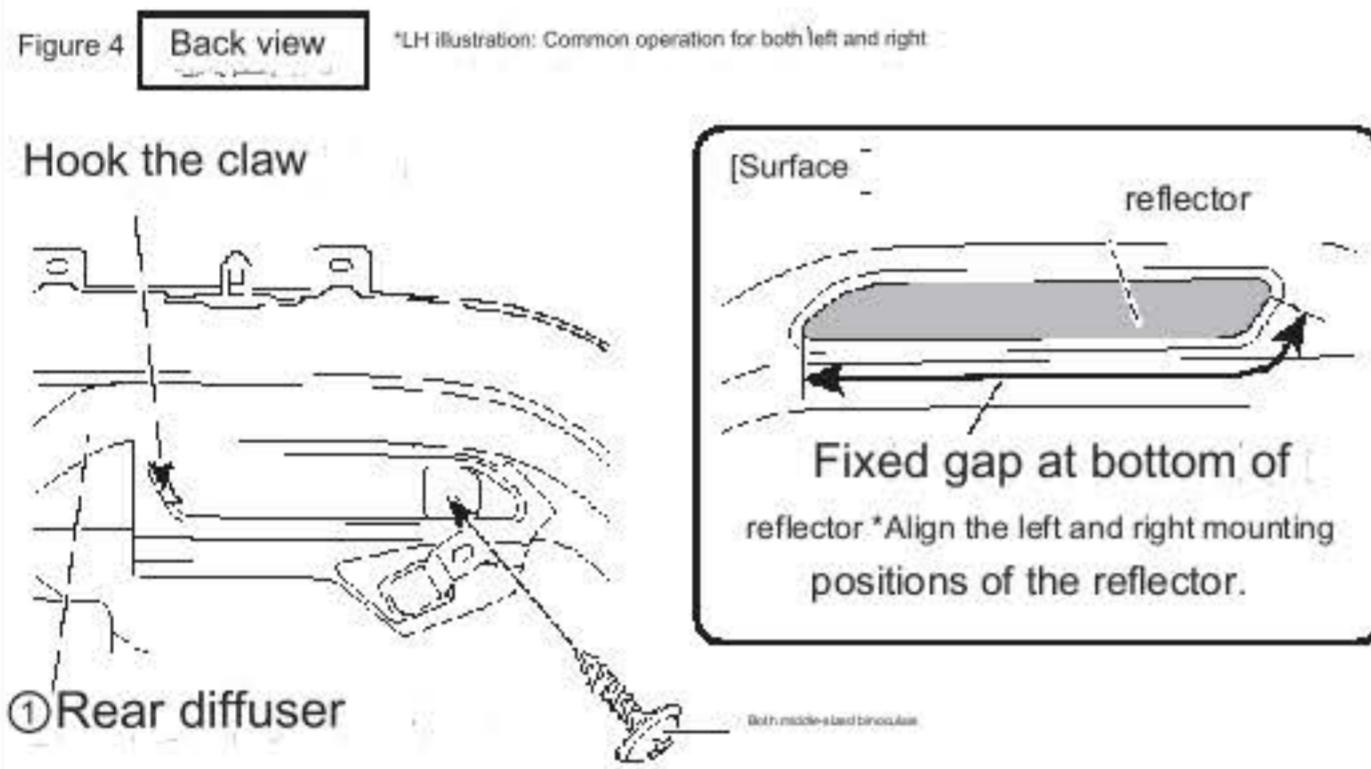




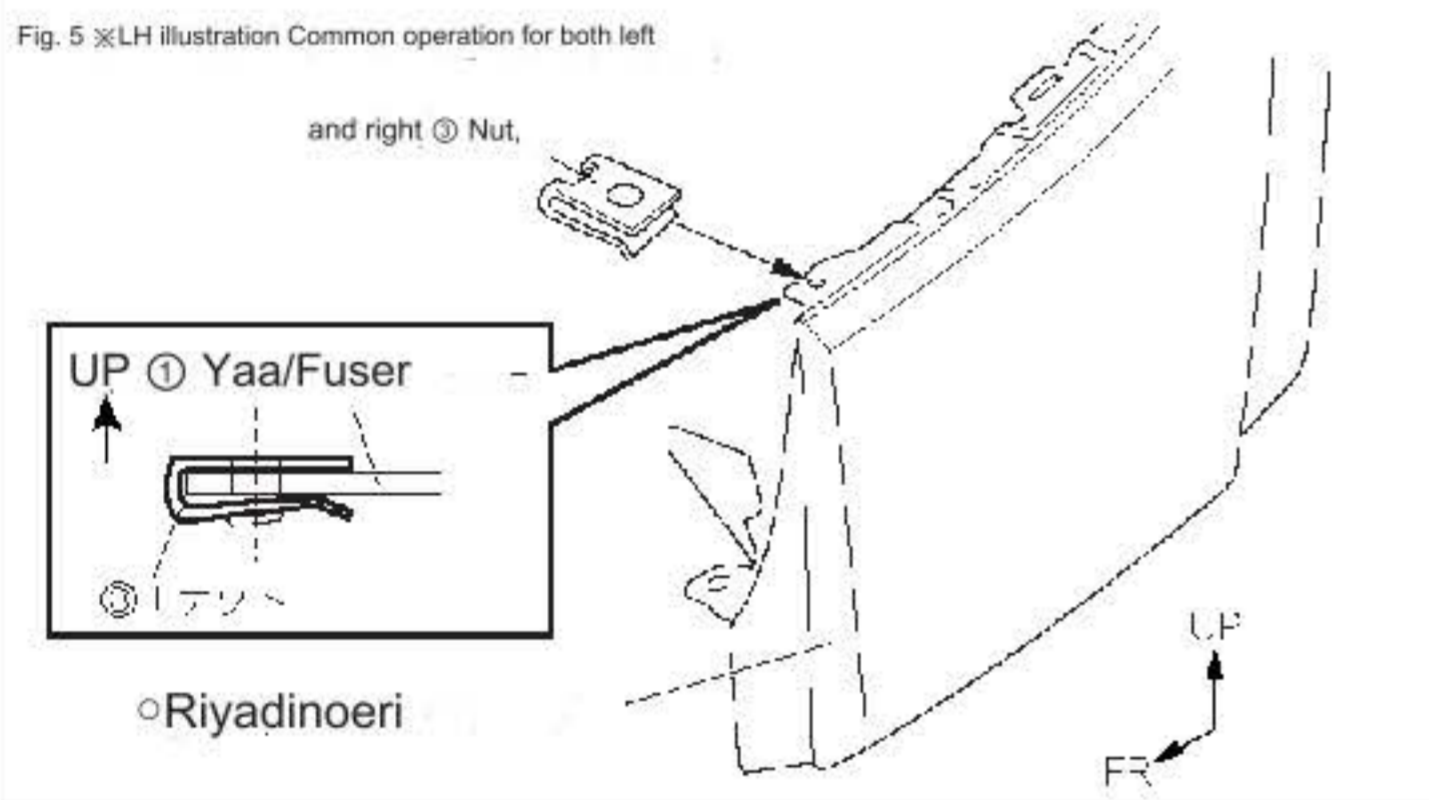
4. As shown in Figure 3, attach the blackout film ① cut to the shape of the tip of the reflector so that the folded part is on the back of the reflector (one on each side). At this time, remove any dirt from the attachment area and wash it in one direction with isopropyl alcohol (IPA). Wipe it down to degrease.

▲Caution: When degreasing, do not use any solvents other than those listed above. This will leave oily residue and cause the tape to peel off.

●Advice: After degreasing, allow to dry for approximately 1 ( ) minute.

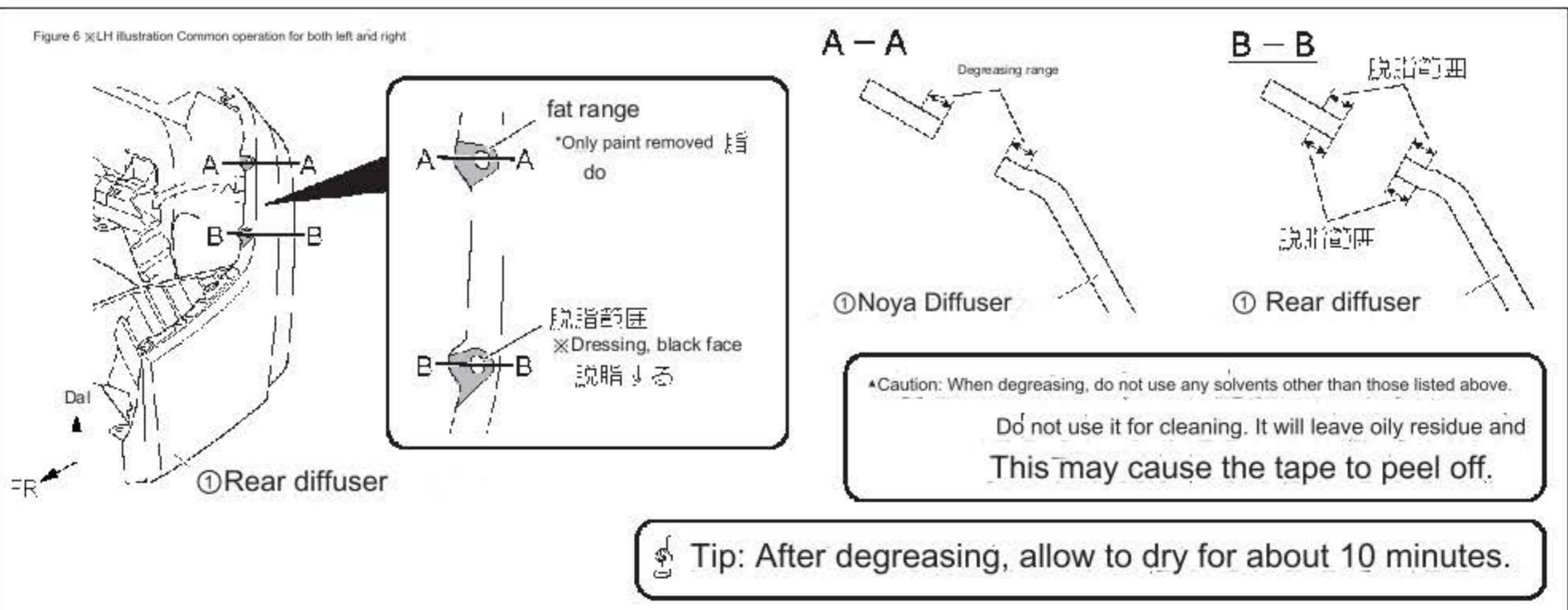


5. As shown in Figure 1, ① install the reflector to the rear diffuser with vehicle screws (one on each side).



6. Install ⑧J nuts to ① rear diffuser-as shown in the illustration (one on each side).

7. As shown in Figure 6, (1) remove any dirt from the area where rubber washer A (ⓐ) of the rear diffuser is attached, and degrease it by wiping it in one direction with isopropyl alcohol (IPA) (three areas on each side).

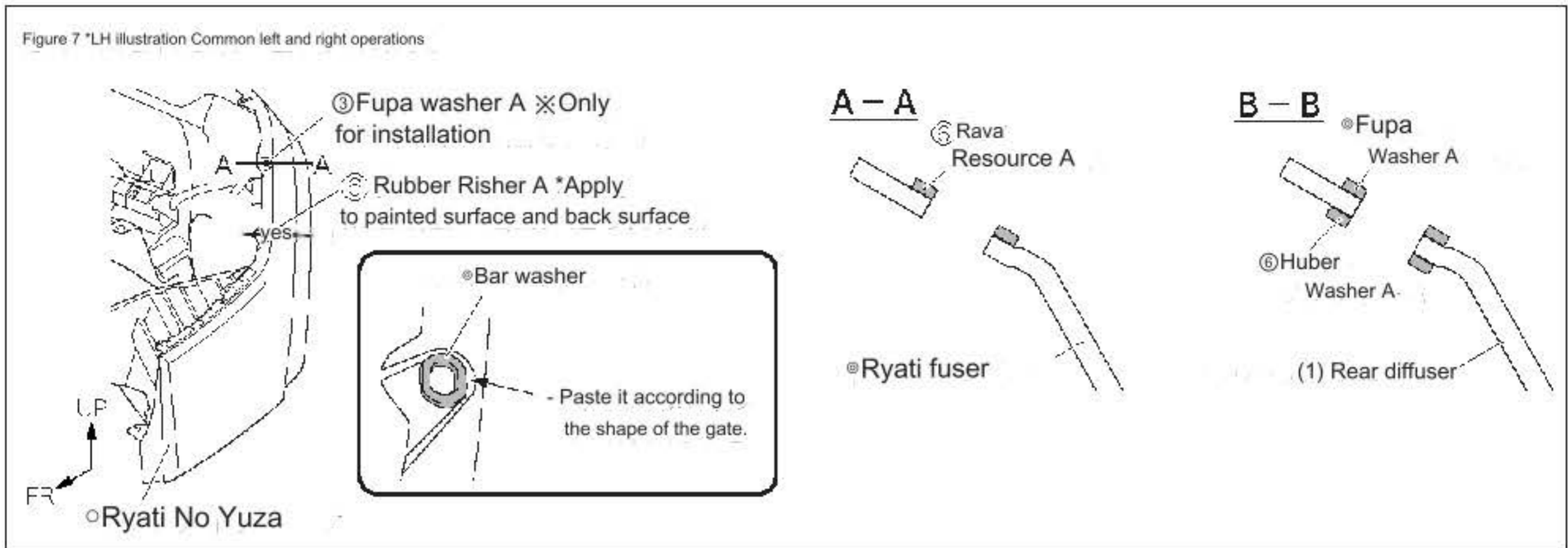


▲Caution: When degreasing, do not use any solvents other than those listed above. Do not use it for cleaning. It will leave oily residue and This may cause the tape to peel off.

Tip: After degreasing, allow to dry for about 10 minutes.

8. As shown in Figure 7, attach ⑥ rubber washer A to ① rear diffuser (three places on each side).

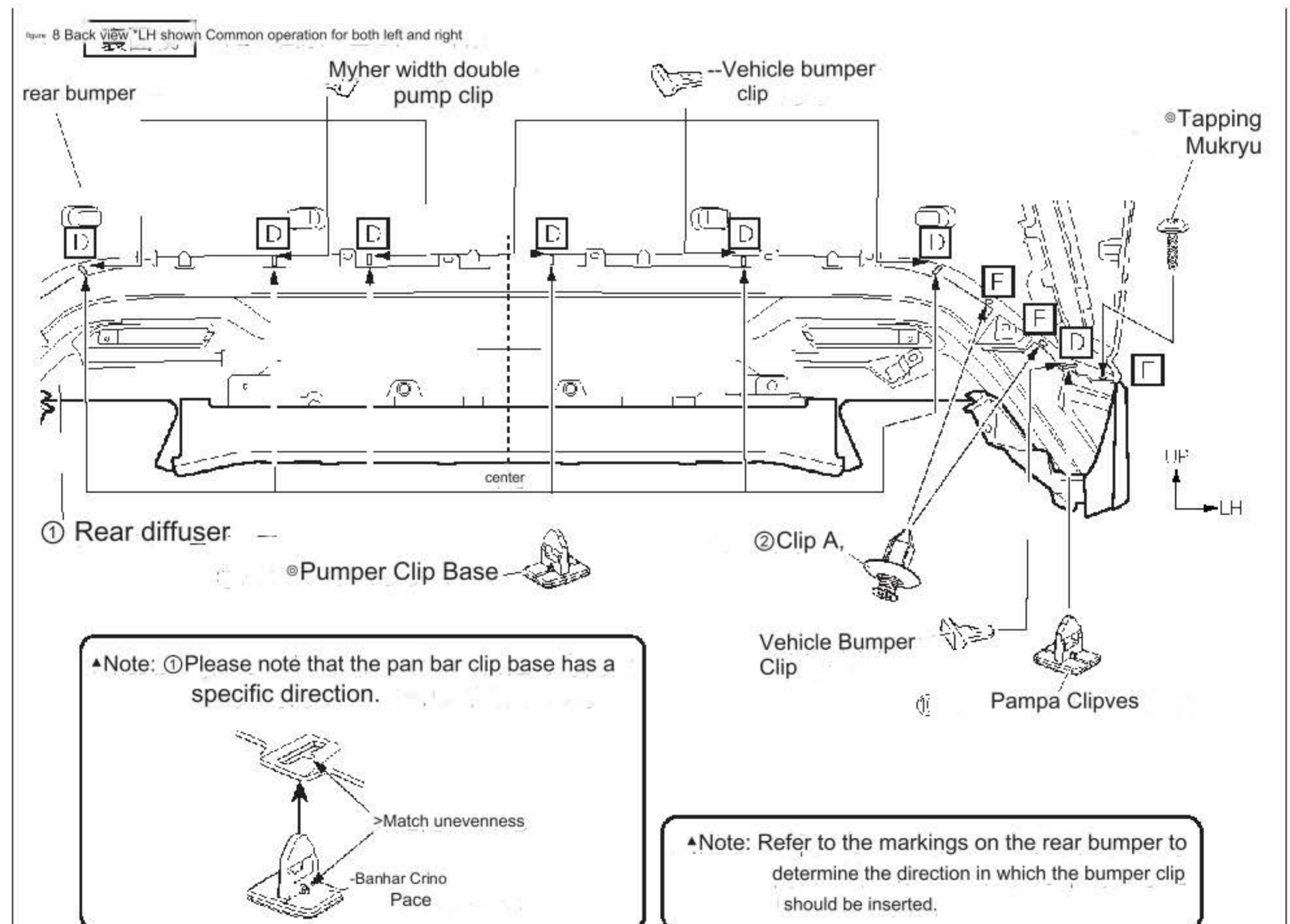
- Part A-A: Attach only to the painted surface.
- Part-B-B: Attach to the painted surface and back side.



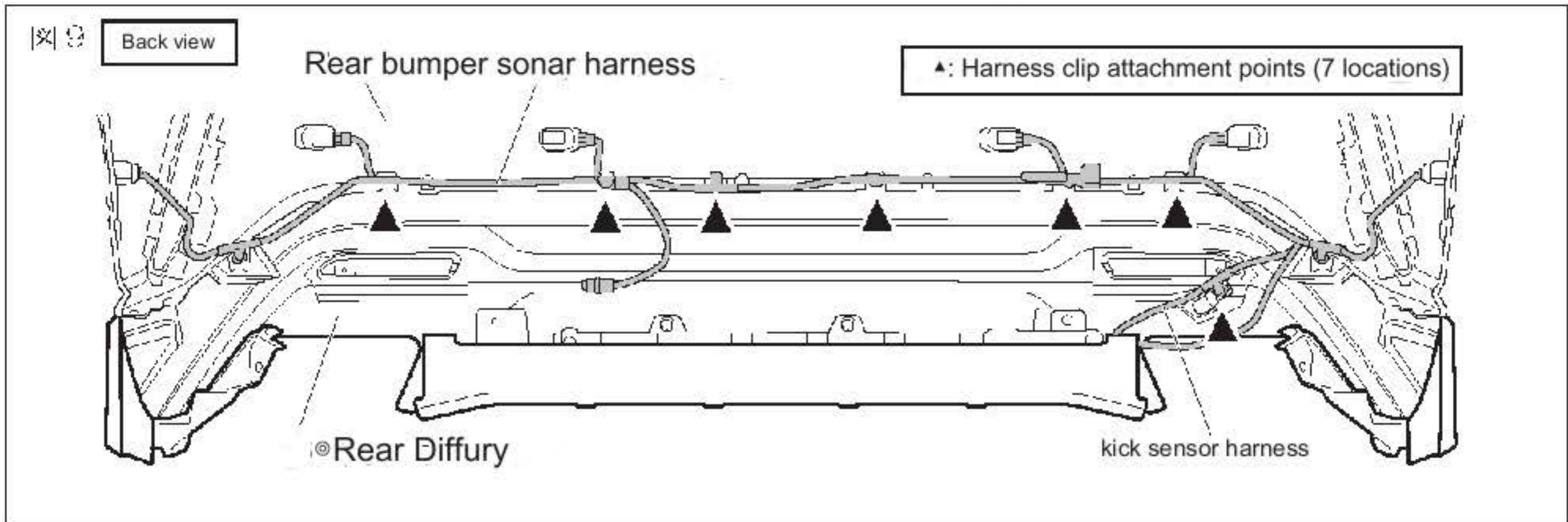
□ Rear diffuser installation instructions

1. Attach the rear diffuser ① to the rear bumper as shown in Figure 8.

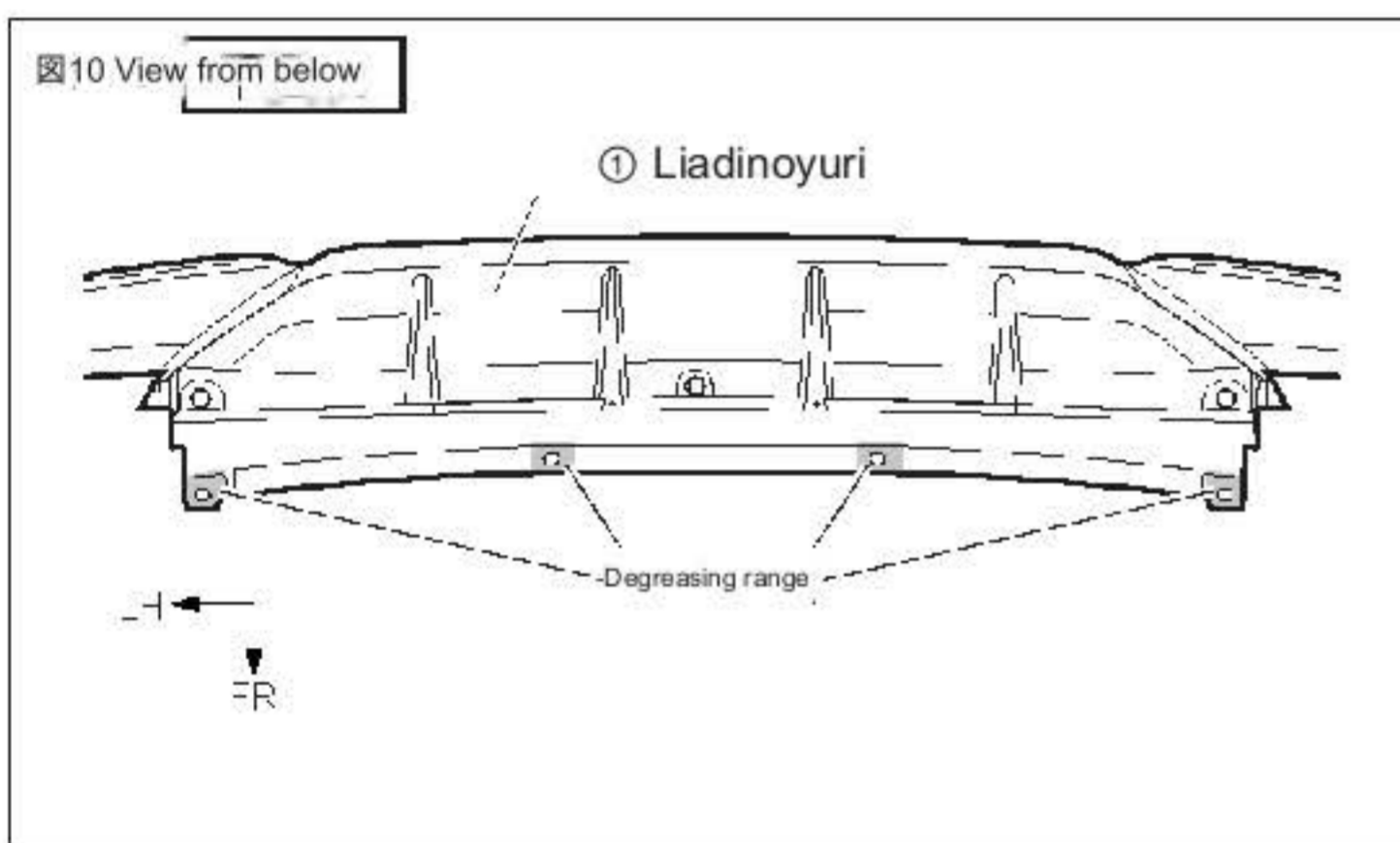
- part D: ⑩ Bumper clip base, vehicle bumper clip (6 in the center, 1 each on the left and right)
- part: ② Clip A (2 places on each side)
- Fastening part: ⑨ Tapping screw (one on each side)



2. Attach the kick sensor harness and sonar harness as shown in the figure.



3. According to the repair manual for the vehicle, restore the rear bumper to the vehicle. \*Do not attach the bottom fastening part at this time.

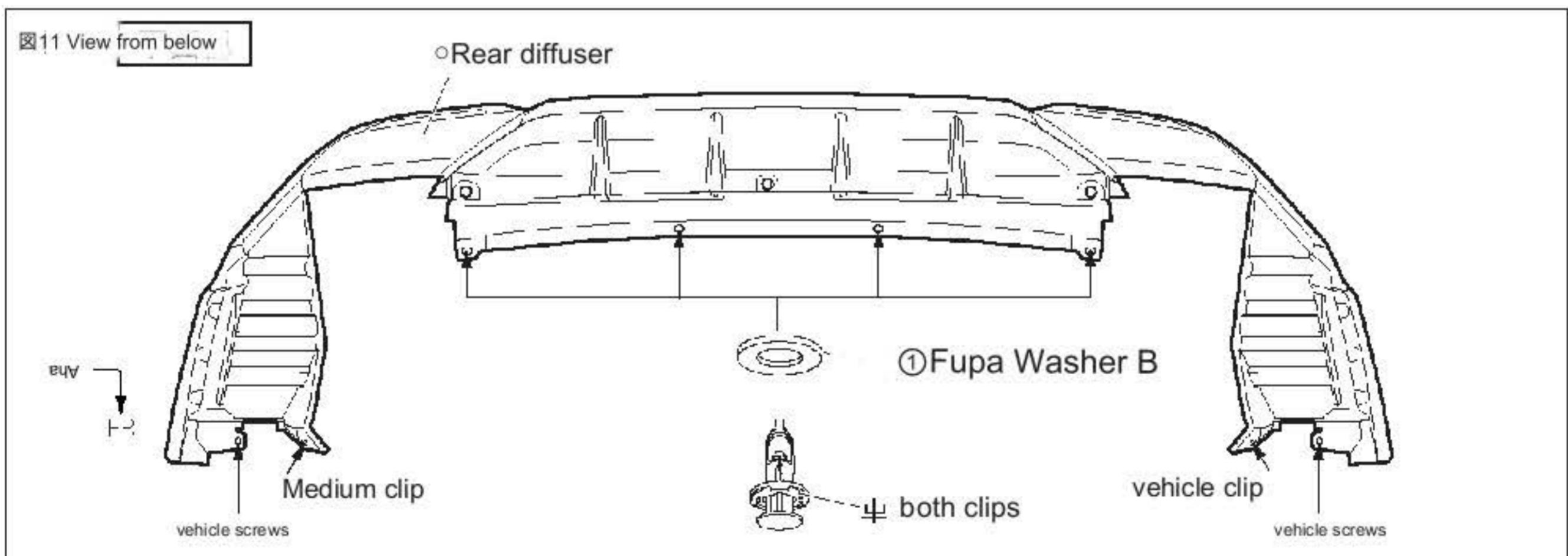


4. As shown in Figure 10, ① remove dirt from the area where rubber washer B is attached on the underside of the rear diffuser, and then wipe in one direction with isopropyl alcohol (1 PA) to degrease it (4 places).

▲Caution: When degreasing, do not use any solvents other than those listed above. This will leave oily residue and cause the tape to peel off.

🔧 Tip: After degreasing, allow to dry for approximately 1 minute.

5. As shown in Figure 11, attach rubber washer B (7) to the center of the underside of the rear diffuser (1) and secure it with vehicle clips (4 places), and then secure the left and right sides of the underside with vehicle screws (1 place each on the left and right) and vehicle clips (1 place each on the left and right).



6- If the grade is F SPORT Performance [Must do]  
 Refer to the section "Doors/Hatches > Power Backdoor System > Customization Functions > PBD Kick Sensor Sensitivity Adjustment" in the repair manual for the vehicle in question and change the sensitivity setting from "+1" to "+2."

■ [Inspection and precautions after installation is complete]

1. Check that there is no lifting, peeling, etc. around the entire circumference of the product.
  2. Check that there are no scratches on the vehicle or around the rear diffuser.
  3. Resetting or adjustment may be required depending on the parts disassembled or removed during this installation.
- Please inspect, adjust and set each part according to the repair manual (issued by Toyota Motor Corporation) for the vehicle in question.



Regarding handling of unpainted products

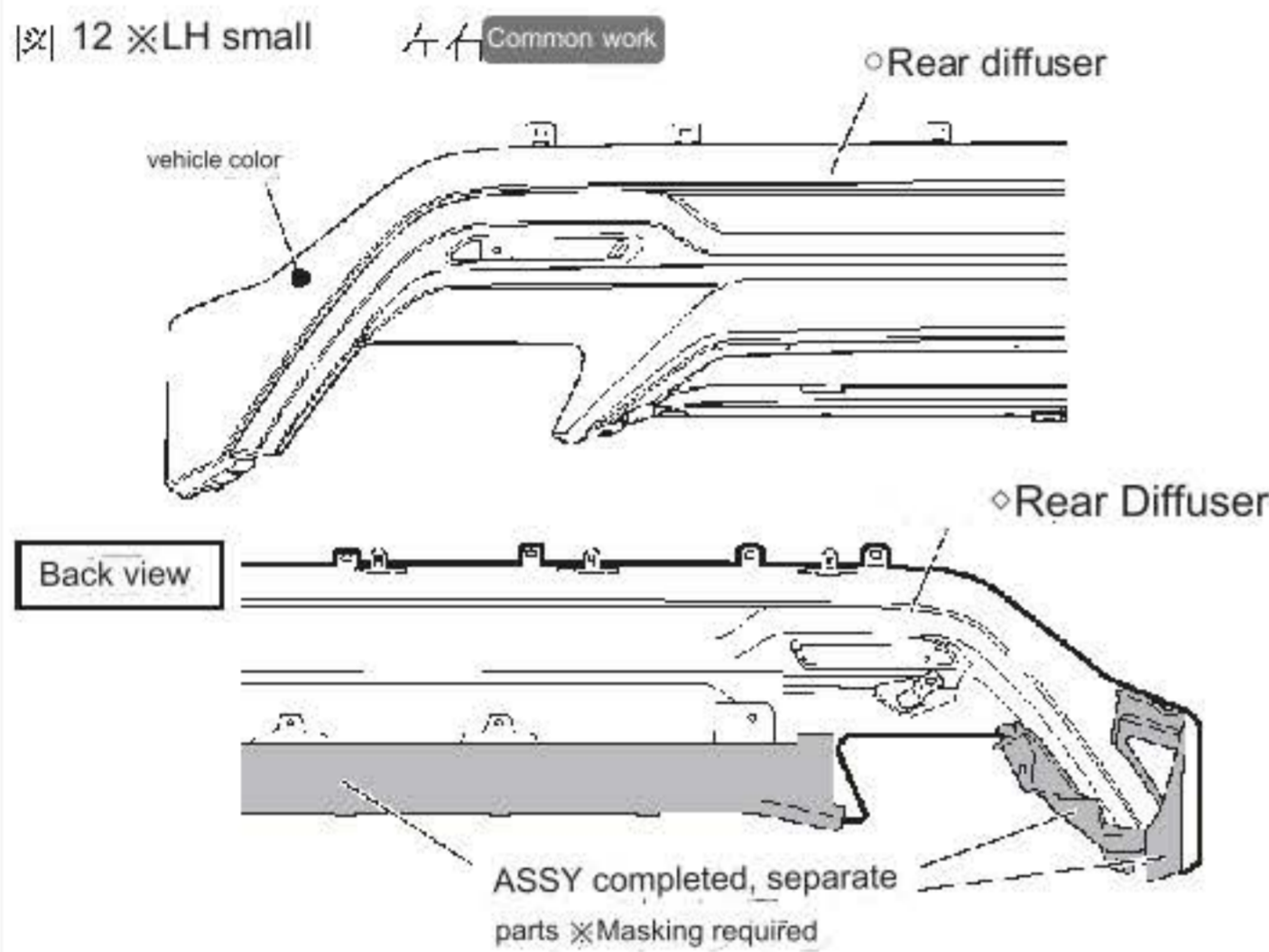
The following describes the procedures before and after painting for the unpainted product (MS313-18006-NP). Please follow the instructions below to carry out the procedures.

▲Note: This product has been subjected to surface preparation including surface finishing. Surface preparation prior to painting should be performed by your dealer including surface preparation, degreasing, and application of primer surfacer.

▲Note: Use a non-conductive primer.

\*This installation and handling manual mainly indicates the LH side, but please do the same for the RH side.

Painting the rear diffuser



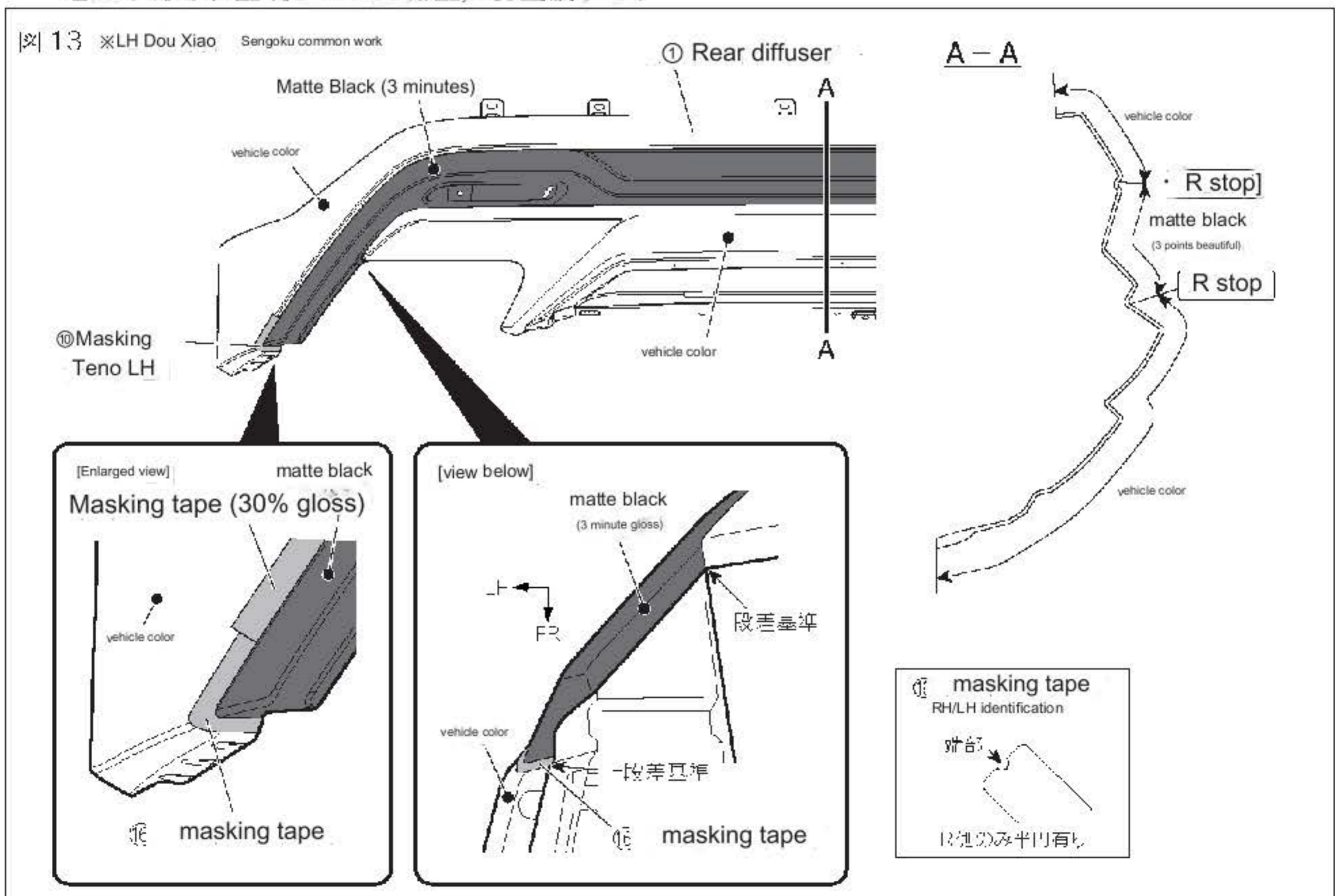
1. Paint the rear diffuser ① in the vehicle color as shown in Figure 12.

▲Note: If the drying temperature is raised above 10°C, the product may deform or crack, so please be careful with the drying temperature. If you force dry the product, make sure to secure it in place to prevent deformation.

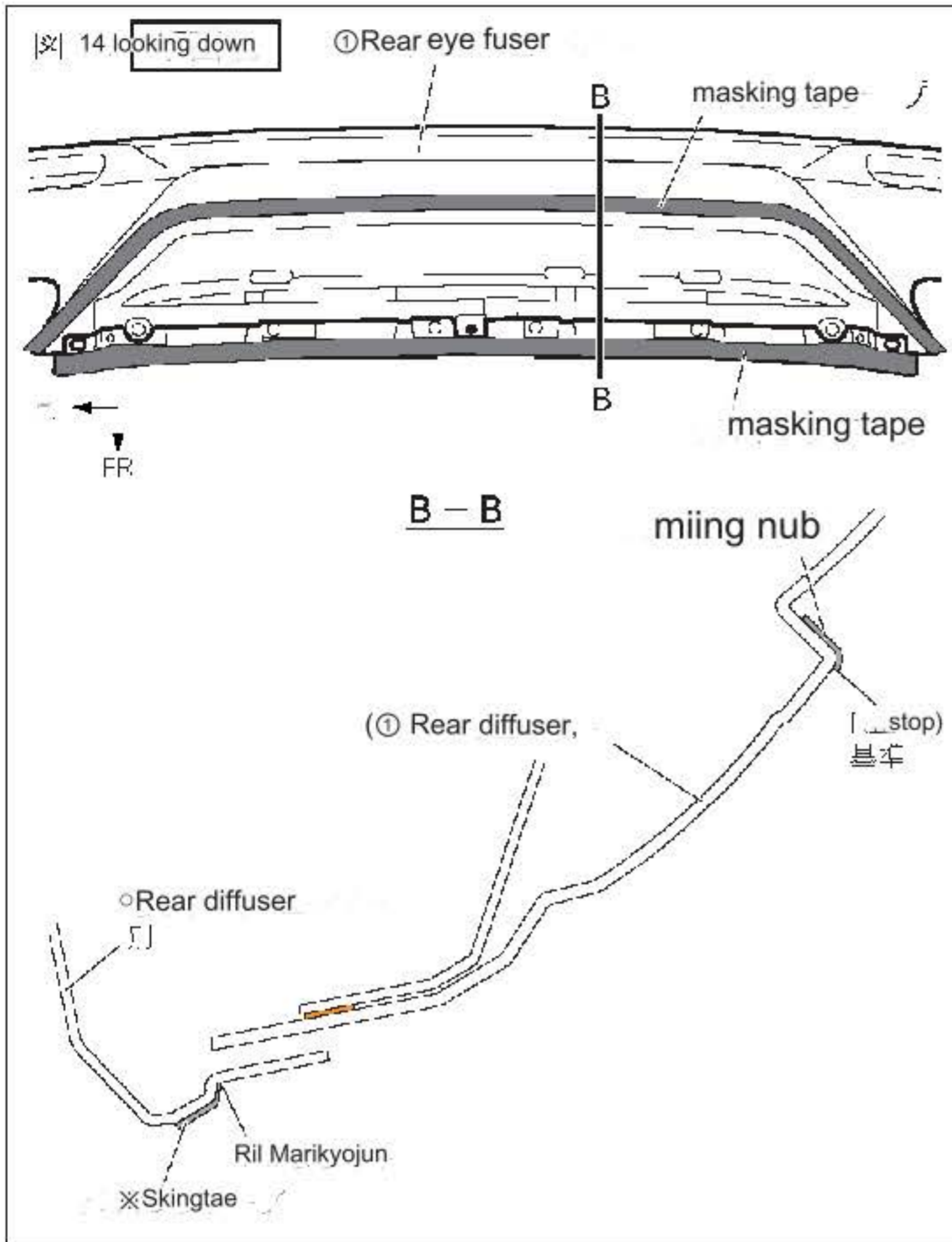
▲Note: ① Mask the separate pieces that are already assembled to the rear diffuser to prevent paint from getting on them.

▲Caution: Be sure to mask off the aluminum tape. Painting it will impair its functionality.

2. As shown in Figure 13, apply masking tape to the rear diffuser ① and to the outer periphery of the matte black part, then paint it matte black (30% gloss).

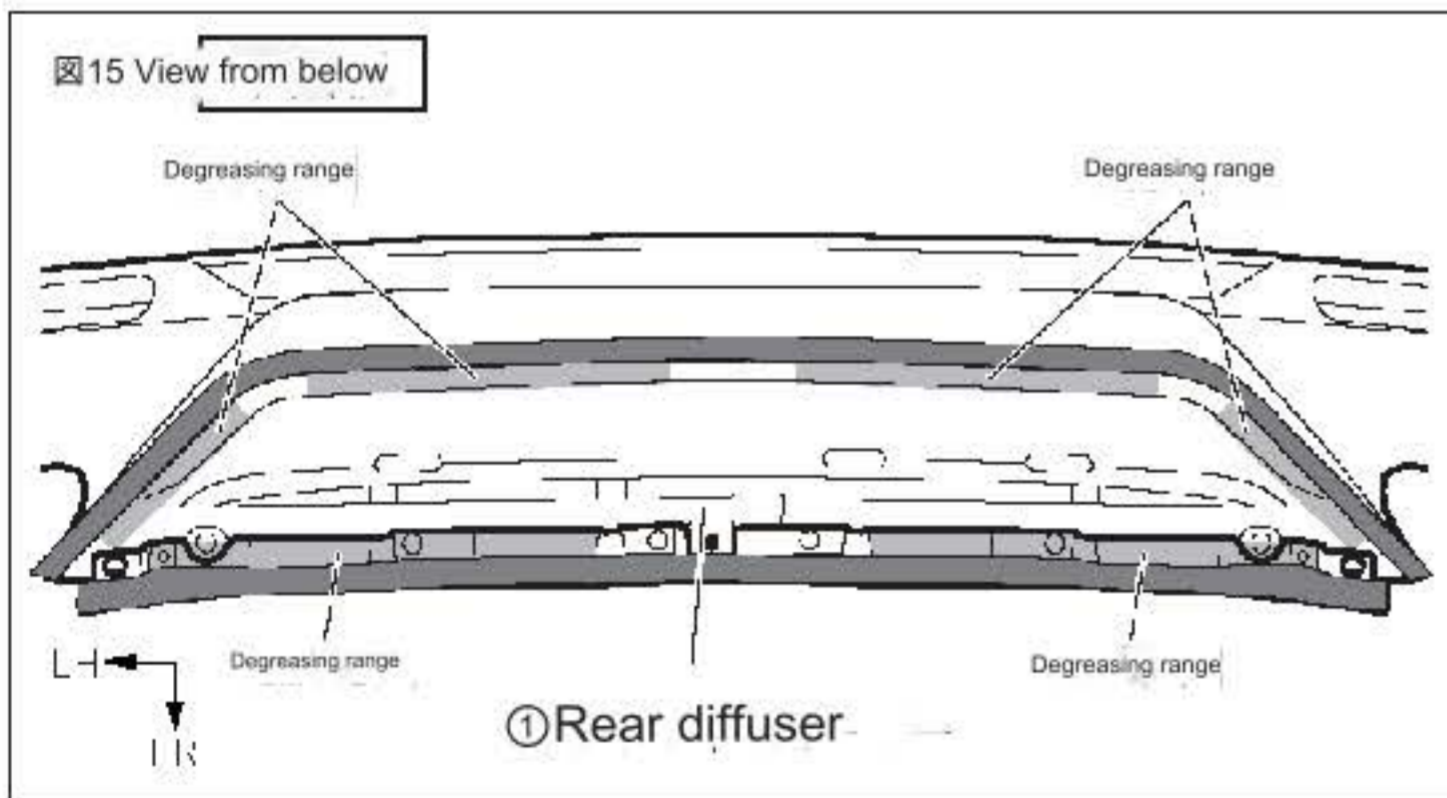


□ Installation of the outer piece



1. As shown in Figure 11, attach masking tape to the rear-diffuser ①, aligning it with the double-sided tape attachment area of the outer piece ⑬.

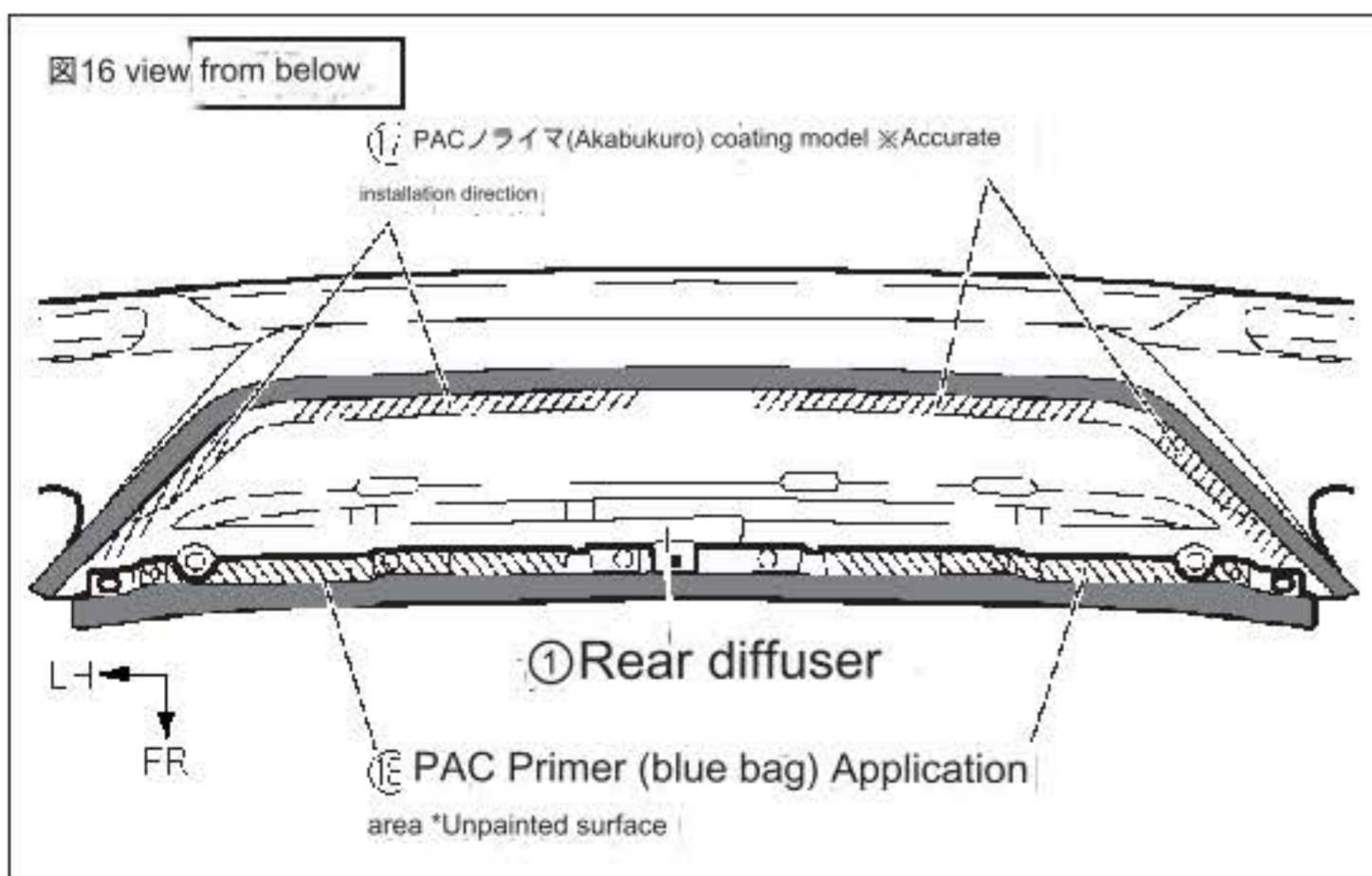
▲ Note: Please be sure to accurately determine and mask the area to be coated with PAC primer.



2. As shown in Figure 15, ① remove any dirt from the double-sided tape attachment area on the underside of the rear diffuser, and degrease it by wiping it in one direction with isopropyl alcohol (IPA).

▲ Caution: When degreasing, do not use any solvents other than those listed above. This will leave oily-residue and cause the tape to peel off.

👉 Tip: After degreasing, allow to dry for about 10 minutes.

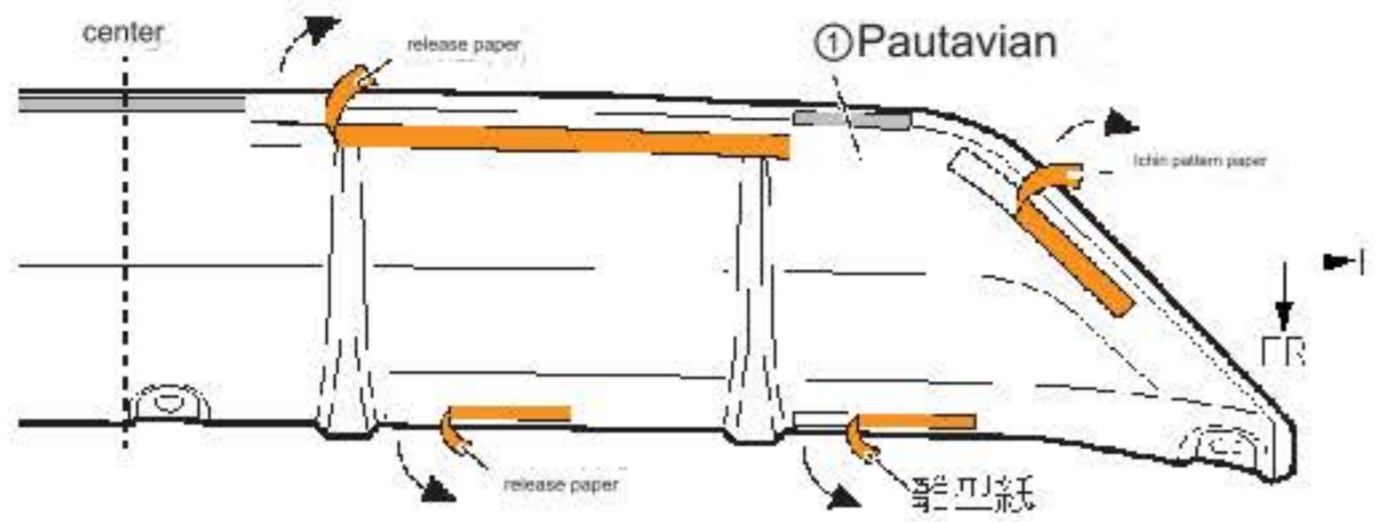


3. As shown in Figure 16, ① apply OPAC primer (red bag) and 18PAC primer (blue bag) to the double-sided tape attachment area (shaded area on the left) on the underside of the rear diffuser.

▲ Caution: If the primer adheres to any area other than the application area, immediately wipe it off with isopropyl alcohol (IPA). If the primer adheres to any area other than the application area, it may cause discoloration.

4. Peel off the masking tape.

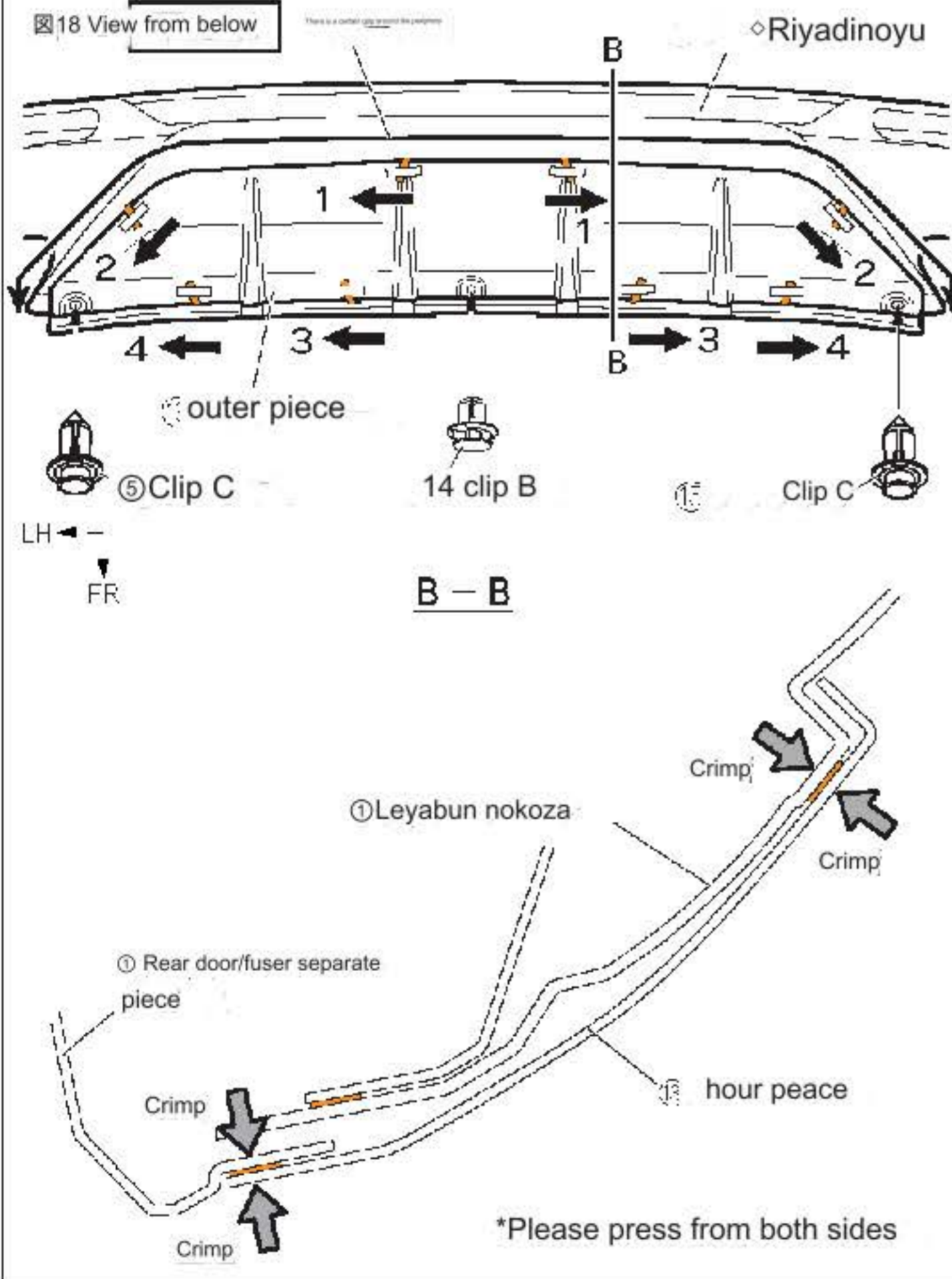
Figure 17 Back view \*LH illustration: Common operation for both left and right



5. As shown in Figure 17, remove the release paper from the double-sided tape on the back of the outer piece ③ by about 3 mm in the direction of the arrow, and attach it to the front side with masking tape or similar. (4 places on each side)

▲Note: In order to maximize the adhesive strength of the double-sided tape, warm up the double-sided tape area and the vehicle area to which it will be attached using a hair dryer or similar to approximately 40°C before application.

Figure 18 View from below



6. As shown in Figure 18, (1) place the outer piece ③ according to the hole position and shape on the underside of the rear-diffuser, and secure the underside with clip B ④ (1 place in the center) and clips (1 place each on the left and right). Check the installation position, and then attach the double-sided tape in the direction of the arrow while peeling off the release paper in the numerical order (four places on each side).

▲Caution: If the release papers from the double-sided tape are not removed in the specified order, gaps may appear.

Toyota Customizing & Development Co., Ltd.

TRD Product Inquiry Desk

TEL:050-3161-2121

<https://www.trdparts.jp/>