

# Loose Front Door Glass Run

**Service Category** Vehicle Exterior

**Section** Window/Glass

**Market** USA

Toyota Supports  
 ASE Certification 

## Applicability

YEAR(S)	MODEL(S)	ADDITIONAL INFORMATION
2010 - 2020	Sienna	

### REVISION NOTICE

May 04, 2021 Rev1:

- Applicability has been updated to include 2010 and 2013 – 2020 model year Sienna vehicles. Any previous printed versions of this bulletin should be discarded.

### SUPERSESSION NOTICE

The information contained in this bulletin supersedes Service Bulletin No. T-SB-0052-13. Service Bulletin No. T-SB-0052-13 is obsolete and any printed versions should be discarded.

## Introduction

Some 2010 – 2020 model year Sienna vehicles may exhibit a condition where the front door glass run on either the right-hand or left-hand side comes loose from the door channel during window operation. Follow the Repair Procedure in this bulletin to address this condition.

## Warranty Information

OP CODE	DESCRIPTION	TIME	OFP	T1	T2
BD2003	R & R Loose Front Door Glass Run	0.7	68141-#####*	62	13
Combo A	Opposite Side	0.6	68151-#####*		

\*Choose the correct OFP for the vehicle being repaired by searching the parts in EPC using the EPC VIN filter. Warranty claims MUST be submitted with the correct OFP with 10 digits.

### APPLICABLE WARRANTY

- This repair is covered under the Toyota Basic Warranty. This warranty is in effect for 36 months or 36,000 miles, whichever occurs first, from the vehicle's in-service date.
- Warranty application is limited to occurrence of the specified condition described in this bulletin.

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### Parts Information

PART NUMBER	PART NAME	QTY
68141-08020	Run, Front Door Glass, RH	1
68151-08020	Run, Front Door Glass, LH	1

### Required Tools & Equipment

REQUIRED TOOLS & MATERIAL	PART NUMBER	QUANTITY
3M™ Black Super Weatherstrip and Gasket Adhesive*	08008	1

\*Order at local automotive shop.

**NOTE**

One tube of adhesive can service multiple vehicles and has a shelf life of 24 months.

### Repair Procedure

1. Visually inspect the vehicle to confirm the condition exists.  
Does the front door glass run on either the right-hand or left-hand side come loose from the door channel during window operation?
  - **YES** — Continue to step 2.
  - **NO** — This bulletin does NOT apply. Continue diagnosis using the applicable Repair Manual.

**Figure 1. Front Door Glass Run Failure**



2. Remove the front door glass run.  
Refer to TIS, applicable model and model year Repair Manual:
  - [2010](#) Sienna:  
*Vehicle Exterior – Door/Hatch – “Engine Hood / Door: Front Door: Disassembly”*
  - [2011](#) / [2012](#) / [2013](#) / [2014](#) / [2015](#) / [2016](#) / [2017](#) / [2018](#) / [2019](#) / [2020](#) Sienna:  
*Vehicle Exterior – Door/Hatch – “Door / Hatch: Front Door: Disassembly”*

## Loose Front Door Glass Run

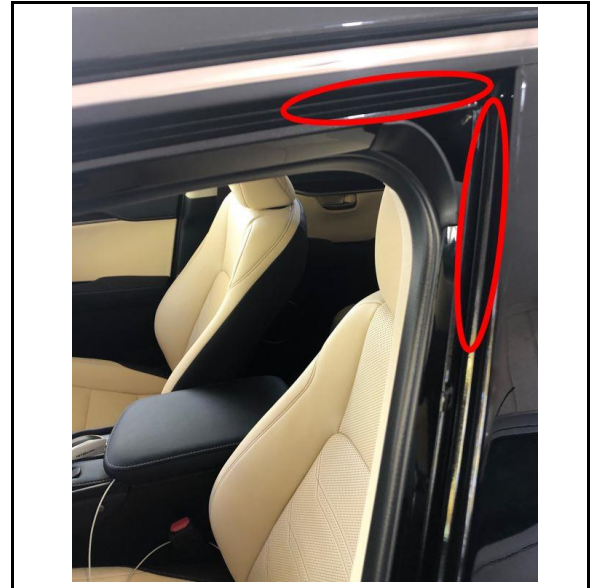
### Repair Procedure (continued)

- Clean the door channel in the upper B-pillar corner with isopropyl alcohol as shown.

**NOTE**

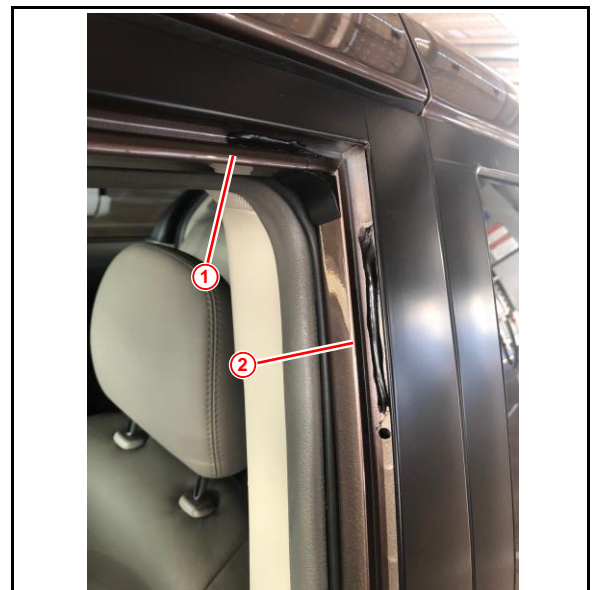
Let the surface dry for AT LEAST 30 seconds BEFORE proceeding to the next step.

**Figure 2.**



- Apply 3M™ Black Super Weatherstrip Adhesive to the areas shown.  
The top section bead should be AT LEAST 3 in. long, and the B-pillar bead should be AT LEAST 4 in. long.

**Figure 3.**



<b>1</b>	Apply Adhesive to the Inboard Side of Door Channel
<b>2</b>	Apply Adhesive to the back side of Door Channel (B-pillar)

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### Repair Procedure (continued)

5. Install the NEW front door glass run.

Refer to TIS, applicable model and model year Repair Manual:

- [2010](#) Sienna:  
*Vehicle Exterior – Door/Hatch – “Engine Hood / Door: Front Door: Reassembly”*
- [2011](#) / [2012](#) / [2013](#) / [2014](#) / [2015](#) / [2016](#) / [2017](#) / [2018](#) / [2019](#) / [2020](#) Sienna:  
*Vehicle Exterior – Door/Hatch – “Door / Hatch: Front Door: Reassembly”*

6. Use a plastic tool to press in the upper rear corner of the glass run to help fully seat the glass run.

**Figure 4.**



7. Visually check around the upper rear corner for any excess sealer that might be outside the door channel. Clean off the excess sealer.
8. Confirm the window operates properly and the front door glass run stays in place by cycling the window once and leave the window in the full closed position.

**NOTE**

Advise customer NOT to operate the window for 24 hours.