

COLLISION REPAIR INFORMATION

FOR THE TOYOTA DEALER

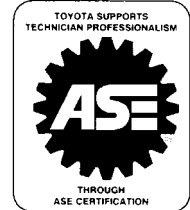
TITLE: URETHANE ADHESIVE SEALANT FOR
FIXED GLASS INSTALLATION

PAGE 1 of 3

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)

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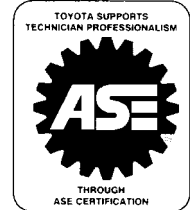
TITLE: WELDING HIGH STRENGTH
STEEL (H.S.S.)

PAGE 1 of 5

SECTION: WELDING BULLETIN #27

MODELS: ALL TOYOTA MODELS

DATE: JULY 1988



In today's body shop environment high strength steel (H.S.S.) body parts are frequently welded during collision damage repairs. Typical uses for H.S.S. are the front cross member, front body outer pillar, floor side member and door side impact protection beam. Because H.S.S. is used in these areas of potential high stress, repairs must be done properly to maintain the structural integrity of the vehicle.

Two types of H.S.S. are used. Solution hardened H.S.S. is used for door panels, hood outer panel, etc., while precipitation hardened H.S.S. is used for door impact beams and bumper reinforcements. It is not necessary to distinguish solid solution hardened steel from ordinary steels for repair purposes.

The location of H.S.S. parts can be found in the Toyota Repair Manual for Collision Damage under the Body Panel Construction section. A sample chart from the 1987 Camry Collision Repair Manual is on page 3 of this bulletin. A list of available Toyota Collision Repair manuals is on page 4.

REPAIR GUIDELINES

H.S.S. and ordinary steel parts in Toyota vehicles are welded using the same methods. The following precautions apply:

- Use either spot welding or MIG/MAG (shield gas) welding. MIG/MAG (shield gas) welding should only be done by an experienced body shop person.
- Only braze body components previously brazed at the factory and as indicated in the Toyota Repair Manual for Collision Damage.
- Do not use an oxy-acetylene torch for fusion welding auto bodies. The large heat affected zone may destroy galvanized coatings and cause excessive panel distortions. In addition, an oxy-acetylene torch will reduce the strength and increase the brittleness of H.S.S.

REFERENCE MATERIALS

The following manuals should be readily available in the body shop:

- Toyota Fundamental Body Repair Procedures Manual
- Complete set of Toyota Repair Manuals for Collision Damage

TOOLS

Proper tools are mandatory for H.S.S. repair. Tools include:

- MIG/MAG welder
- Spot welder
- H.S.S. spot weld cutter that will cut 8mm and 10mm holes
- Air saw
- Plasma cutter
- Air power chisel with panel cutter
- Hole punch
- Head protector
- Dust mask
- Face protector
- Vise grip pliers
- Weld through primer (see page 5 of this bulletin)
- Ear plugs
- Car cover for glass and interior

WELDS

Four types of welding are required in the repair of Toyota vehicles:

- Spot
- Plug
- Continuous
- Braze

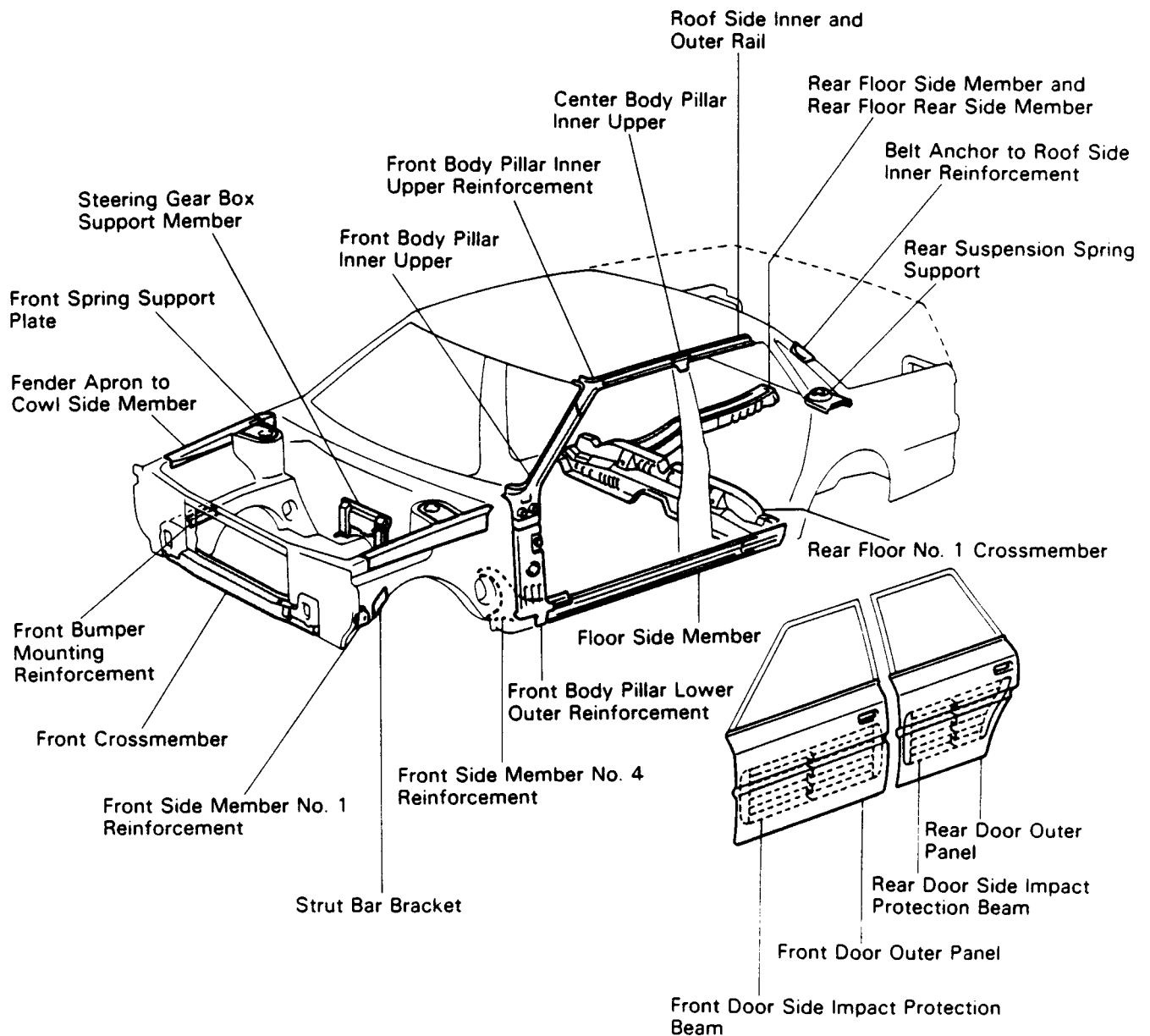
Technicians doing repair work must be proficient in doing all four types of welding since all four are used in various locations throughout the vehicle. The Toyota Repair Manuals for Collision Damage show the location and type of welds that must be used. The correct number and type of welds must be used to ensure structural integrity.

PROCEDURE

The complete in-depth procedure for welding H.S.S. and ordinary steel can be found in the Toyota Fundamental Body Repair Procedures manual for the applicable vehicle. The basic procedure requires:

1. Removal of auxiliary parts
2. Removal of damaged parts
3. Prepare new parts
4. Position new parts
5. Welding
6. Finishing of welded areas.

BODY PANEL CONSTRUCTION — High Strength Steel (H.S.S.) Parts



TOYOTA SERVICE PUBLICATIONS

PART NUMBER	DESCRIPTION
3643-8E	Fundamental Painting Procedures
BRM00-2E	Fundamental Collision Repair
3643-1E	Tercel 2WD
3643-2E	Tercel 4WD
3643-4E	Corolla 83-87
36182	Celica/Supra 82-86
BRM00-1E	Celica 86-88
BRM00-5E	Supra 86-88
3643-3E	Camry 83-86
36118	Cressida 81-84
3644-1E	Cressida 85-88
3644-2E	Cressida Wgn. 85-88
3644-oA	MR2 85-88
BRM00-3E	Van 84-87
BRM01-1U	Tercel Coupe 87-88
BRM01-0U	Camry 87
BRM00-7U	Tercel Sedan 87-88
BR012	Corolla 88
BRM00-6E	FX/FX 16 87-88
BRM00-9E	Supra Sport Roof 86-88
BRM00-8E	MR2 T-Roof 85-88

You may order these on your TDN through the non-parts ordering system.

WELD-THROUGH PRIMER SUPPLIERS *

1. HTP "Cold Galvanizing Compound"
Part No. 12022
HTP America, Inc.
261 Woodwork Lane
Palatine, IL 60067
2. TTE "Dan-Prime"
Transnational Technology Enterprises, Inc.
3541 Old Conejo Road, #107
Newbury Park, CA 91320
3. Anchor Brand "Spray-Galv"
NASCO
Welding Equipment and Safety Supplies
Chicago, IL
4. 3M "Weld-Thru Coating"
Part No. 051131-05913
3M Automotive Trades Division
St. Paul, MN
5. Kent "Spotweld Primer"
Part No. 50190
Kent Industries
4500 Euclid Ave.
Cleveland, OH 44103

* There may be other sources for this material that are not listed here.

COLLISION REPAIR INFORMATION

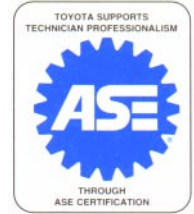
FOR THE TOYOTA DEALER

TITLE: 2000 PAINT & REFINISH FORMULA CODES PAGE 1 of 3

SECTION: REFINISH BULLETIN #98

MODELS: ALL TOYOTA

DATE: NOVEMBER 1999



Attached for your reference is a list of all 2000 Toyota paint codes and the refinish formula codes for the following paint manufacturers:

BASF, DuPont, PPG, Sherwin-Williams, Sikkens, Spies-Hecker, and ICI Autocolor.

NOTE: The vehicle paint code is on the certification label which can be located on the drivers side door jamb or the lower section of the "B" pillar.

Please contact your local paint representative for the actual paint mixing formulas or if you need help in color matching.

2000 TOYOTA PAINT CODES AND COLOR NAMES

COL-OR CODE	COLOR NAME	BASF	DUPONT	PPG	SHERWIN-WILLIAMS	SIKKENS	SPIES-HECKER	ICI AUTOCOLOR
040	Super White	Toy04 0	W8430	90288	35000	Toy040	17143	KK47
049	White Pearl Mica	Toy04 9	L9018 N9033	90673 96674	40881 40882	Toy049	97746	PC61B
051	Diamond White Pearl	Toy05 1	L9246 L9247	90822 90826	42872 42873	Toy051	98125 16329	PF76B TD86G
056	Natural White	Toy05 6	F1858	91452	52893	Toy056	15217	BAB5
057	Golden Pearl	Toy05 7	F3080 F3081	5555 5556	54857 54858	Toy057	15815	HYT8B HYT9G
062	Crystal White	Toy06 2	M4393 M5150	5641 5656	60444 60445	Toy062	23536	TXY3B
1A0	Platinum Metallic	Toy1A 0	N9923	4896	49700	Toy1A0	70809	6ED5B
1A5	Desert Dune Pearl	Toy1A 5	F1458	36090	52139	Toy1A5	72759	8NH3B
199	Alpine Silver Metallic	Toy19 9	L9990	4900	48976	Toy199	70706	5TX1B
1B1	Champagne Pearl	Toy1B 1	F2186	5252	53074	Toy1B1	20699	FLT9B
1B2	Antique Sage Pearl	Toy1B 2	F2201	5324	54757	Toy1B2	73622	HRE5B
1B9	Quicksilver Fx	Toy1B 9	F4996	5449	56738	Toy1B9	74332	LJC5B
1C0	Millennium Silver Metallic	Toy1C 0	F4928	5557	56793	Toy1C0	74500	LCJ4B
1C2	Smoky Topaz Mica	Toy1C 2	F7165	5558	57243	Toy1C2	74553	LXY5B



MN 0408-03000-87

2000 TOYOTA PAINT CODES AND COLOR NAMES

1C3	Riverrock Green Mica	Toy1C3	F4513	5559	57226	Toy1C3	74488	LVT2B
1C4	Silverstream Op	Toy1C4	F5137	5560	57927	Toy1C4	74771	NPD6B
1C6	Graphite Gray Pearl	Toy1C6	M0016	5642	59271	Toy1C6	75202	PXE1B
1C7	Thunder Gray Metallic	Toy1C7	F5581	5600	58581	Toy1C7	74806	PEJ6B
1C8	Lunar Mist Metallic	Toy1C8	F8569	5539	58582	Toy1C8	74807	PEJ7B
1D0	Liquid Silver Metallic	Toy1D0	M4399	5643	60455	Toy1D0	75418	TYA8B

202	Black (Lexus Black Onyx)	Toy202	F0220	95100	57871	Toy202	72941	TH21B
204	Black Metallic	Toy204	H8645	9624	35533	Toy204	96020	A237B
209	Black Sand Pearl	Toy209	F5135	5644	57925	Toy209	74770	NPD4B
210	Carbon Blue	Toy210	M4603	5645	60456 60457	Toy210	66492	TYA9B

3H7	Cardinal Red	Toy3H7	L9026	73279	40890	Toy3H7	38805	WJ91
3K4	Sunfire Red Pearl	Toy3K4	W9546	4511	46144	Toy3K4	99722	PM54B
3L2	Renaissance Red	Toy3L2	L9992	4902	48978	Toy3L2	30491	5TX3B
3L5	Radiant Red	Toy3L5	F2688	5287	54291	Toy3L5	33476	GNK8
3M5	Sandrift Metallic	Toy3M5	F3531	5444	56742	Toy3M5	34261	LCP1B
3M6	Napa Burgundy Pearl	Toy3M6	F3747	5447	56739	Toy3M6	34262	LJC2B
3M8	Venetian Red Pearl	Toy3M8	F4929	5561	56795	Toy3M8	34300	LCJ5B
3M9	Baroque Red Metallic	Toy3M9	F4464	5421	56658	Toy3M9	34185	KWB9B
3N1	Cinnabar Pearl	Toy3N1	F4483	5435	56752	Toy3N1	34400	LCP9B
3N2	Mahogany Pearl	Toy3N2	F7144	5562	57227	Toy3N2	34317	LVT3B
3N5	Red Flame Metallic	Toy3N5	F5138	5563	57928	Toy3N5	34587	NPD7B
3N6	Vintage Red Pearl	Toy3N6	F8568	5525	58338	Toy3N6	34622	PBB8B
3P0	Absolutely Red	Toy3P0	M4604	5646	60458	Toy3P0	35055	TYB1B
4M4	Sierra Beige Metallic	Toy4M4	H9879	4743	47606	Toy4M4	20157	4SS7B
4M9	Cashmere Beige Metallic	Toy4M9	N9924	4903	49702	Toy4M9	20261	6ED6B
4N7	Sable Pearl	Toy4N7	F3748	5448	56740	Toy4N7	22236	LNK6B
4P1	Antique Bronze Mica	Toy4P1	F4465	5422	56659	Toy4P1	81600	KWC1B
4P2	Burnished Gold Metallic	Toy4P2	F4485	5436	56753	Toy4P2	22500	LCJ2B
4P3	Desert Bronze Metallic	Toy4P3	F7145	5564	57228	Toy4P3	22317	LVT4B
4P5	Autumn Blaze Metallic	Toy4P5	F5583	5526	58340	Toy4P5	34623	PEC1B
4P6	Autumn Red Mica	Toy4P6	F5139	5565	57929	Toy4P6	34588	NPD8B
4P7	Mystic Gold Metallic	Toy4P7	F5584	5523	58336	Toy4P7	22797	PEB6B
4P9	Angora Beige Metallic	Toy4P9	F5582	5524	58337	Toy4P9	81851	PEB7B
4Q2	Desert Sand Mica	Toy4Q2	M4316	5653	60451	Toy4Q2	82004	TVM8B
4Q3	Cognac Brown Mica	Toy4Q3	M4318	5654	60452	Toy4Q3	82003	TYA5B
4Q5	Gold Dust Metallic	Toy4Q5	M4650	5655	60579	Toy4Q5	82002	VAK7B

576	Solar Yellow	Toy576	F0166	4417	49703	Toy576	10823	6ED8
578	Golden Sand Metallic	Toy578	F3749	5457	56741	Toy578	22189	LCP4B
583	Satin Gold Metallic	Toy583	M4605	5647	60459	Toy583	82005	TYB2B

2000 TOYOTA PAINT CODES AND COLOR NAMES

6M3	Silver Spruce Metallic	Toy6M3	W9514	4474	45931	Toy6M3	99679	D381B
6P3	Deep Jewel Green Pearl	Toy6P3	F1805	5166	52887	Toy6P3	61928	ARD3B
6Q7	Imperial Jade Mica	Toy6Q7	F3750	5423	56660	Toy6Q7	65222	KWC2B
6R1	Woodland Pearl	Toy6R1	F7147	5566	57230	Toy6R1	65321	LVT6B
6R3	Fairway Green Pearl	Toy6R3	F5140	5567	57930	Toy6R3	65706	NPD9B
6R4	Electric Green Mica	Toy6R4	F5136	5648	57926	Toy6R4	65705	NPD5B
6R6	Mineral Green Op	Toy6R6	M4395	5649	60447	Toy6R6	66493	TXY8B
760	Mystic Teal Mica	Toy760	F3533	5445	56258	Toy760	65225	LCP2B

8L4	Atlantis Blue Mica	Toy8L4	F1898	19705	52994	Toy8L4	54483	BGT9B
8L5	Royal Sapphire Pearl	Toy8L5	F2728	5329	54485	Toy8L5	55068	HDJ4B
8L7	Stellar Blue Pearl	Toy8L7	F2059	5206	53072	Toy8L7	54562	ETB9B
8L9	Denim Blue Mica	Toy8L9	F2722	5443	54872	Toy8L9	55325	JCD1B
8M5	Vista Blue Mica	Toy8M5	F3562	5434	56261	Toy8M5	55825	KBA1B
8M6	Spectra Blue Mica	Toy8M6	F4496	5437	56754	Toy8M6	56300	LCJ3B
8M8	Twilight Blue Pearl	Toy8M8	F7274	5601	57452	Toy8M8	56542	LXY2B
8N1	Horizon Blue Metallic	Toy8N1	F5223	5527	58341	Toy8N1	56813	PEC2B
8N4	Constellation Blue Pearl	Toy8N4	M4319	5650	60453	Toy8N4	66518	TYA6B
8N7	Sailfin Blue Pearl	Toy8N7	M4320	5651	60454	Toy8N7	66519	TVN2B
8P2	Seafoam Blue Metallic	Toy8P2	M4606	5652	60460	Toy8P2		TYB3B

TWO-TONE COMBINATIONS

2FC	6Q7 Imperial Jade Mica 1C7 Thunder Gray Metallic	Toy2FC	F3750 F5581	5423 5600	56660 58581	Toy2FC	43580	KWC2B PEJ6B
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NOTE: Standox uses the Toyota color code to identify the color.

Example: Toyota color code 056 = Standox 056

For additional information about color matching Toyota vehicles, refer to the repainting section of the Toyota Fundamental Painting procedure manual (part # 00400-BR024) or contact your regional office to obtain information about Toyota Collision Repair and Refinish Training Programs.

COLLISION REPAIR INFORMATION

FOR THE TOYOTA DEALER

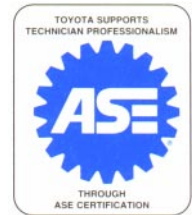
TITLE: MR2 SPYDER EXTERIOR COLORS
PROCEDURE

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SECTION: REFINISH BULLETIN #100

MODELS: 2000 MR2 SPYDER

DATE: MARCH 200



The following information outlines exterior body color codes used on the 2000 MR2 Spyder. The color code can be found on the certification regulation label, which is located on the drivers side door jamb.



COLOR CODES	COLOR NAME
040	Super White
1D0	Liquid Silver Metallic
202	Black
3P0	Absolutely Red
576	Solar Yellow
8M6	Spectra Blue Mica

**PLEASE ROUTE THIS BULLETIN TO YOUR COLLISION REPAIR CENTER MANAGER
AND COLLISION REPAIR TECHNICIANS**



MN 0408-03000-87

COLLISION REPAIR INFORMATION

FOR THE TOYOTA DEALER

TITLE: SRS AIRBAG COMPONENT REPLACEMENT & DISPOSAL PROCEDURES

SECTION: ELECTRICAL

BULLETIN # 99

PAGE 1 of 7

MODELS: TOYOTA

DATE: APRIL 2000



The SRS Airbag system is an important safety feature of Toyota vehicles. It supplements the vehicle's seat belt system by providing additional protection to vehicle occupants in the event of a severe frontal or side collision (if equipped with side airbags).

In order to assure correct system operation, it is necessary to replace certain components of the airbag system following a collision. In order to assist technicians in determining which components should be inspected, tested, or replaced, the repair manual information has been organized in the attached matrix and replacement notes.

Even in cases of a minor collision where the SRS does not deploy, the steering wheel pad, front passenger airbag assembly, side airbag assembly, airbag sensor assembly, and side airbag sensor assembly should be inspected and diagnostic tests should be performed. Always refer to the Toyota service repair manual for the correct diagnostic and repair procedures.

The attached SRS airbag component replacement information includes:

- ☞ A matrix indicating components requiring replacement, inspection, or testing after the deployment of the driver and/or passenger SRS airbag (page 2).
- ☞ Component replacement notes (page 3).
- ☞ A sample repair manual page outlining airbag deployment procedures when scrapping a vehicle (page 4-6). Please refer to the specific vehicle repair manual for procedures to deploy an airbag that has been removed from the vehicle.
- ☞ A sample repair manual page outlining passenger airbag manual on-off switch inspection procedures (page 7).

CAUTION: SRS Airbag service work can only be performed AFTER 90 seconds from the time the ignition switch is turned to the "lock" position and the negative (-) terminal cable is disconnected from the battery.

**PLEASE ROUTE THIS BULLETIN TO YOUR COLLISION REPAIR CENTER MANAGER
AND COLLISION REPAIR TECHNICIANS**

2000 Toyota SRS Parts Replacement Requirements* Collision Repair Chart

2000 MODELS:	AVALON	CAMRY	CELICA	COROLLA	ECHO	SIENNA	SOLARA	LAND CRUISER	RAV4 & RAV4 EV	TACOMA	4RUNNER	TUNDRA*	MR2 SPYDER*
STEERING WHEEL PAD	REPLACE (1)	REPLACE (1)	REPLACE (1)	REPLACE (1)	REPLACE (1)	REPLACE (1)	REPLACE (1)	REPLACE (1)	REPLACE (1)	REPLACE (1)	REPLACE (1)	REPLACE (1)	REPLACE (1)
SPIRAL CABLE	INSPECT (2)	INSPECT (2)	INSPECT (2)	INSPECT (2)	INSPECT (2)	INSPECT (2)	INSPECT (2)	INSPECT (2)	INSPECT (2)	INSPECT (2)	INSPECT (2)	INSPECT (2)	INSPECT (2)
STEERINGWHEEL	INSPECT (3)	INSPECT (3)	INSPECT (3)	INSPECT (3)	INSPECT (3)	INSPECT (3)	INSPECT (3)	INSPECT (3)	INSPECT (3)	INSPECT (3)	INSPECT (3)	INSPECT (3)	INSPECT (3)
PASSENGER AIRBAG	REPLACE (4)	REPLACE (4)	REPLACE (4)	REPLACE (4)	REPLACE (4)	REPLACE (4)	REPLACE (4)	REPLACE (4)	REPLACE (4)	REPLACE (4)	REPLACE (4)	REPLACE (4)	REPLACE (4)
INSTRUMENT PANEL	INSPECT (5)	INSPECT (5)	INSPECT (5)	INSPECT (5)	INSPECT (5)	INSPECT (5)	INSPECT (5)	INSPECT (5)	INSPECT (5)	INSPECT (5)	INSPECT (5)	INSPECT (5)	INSPECT (5)
FRONT IMPACT SENSORS (BOTH)	REPLACE (6)	REPLACE (6)	REPLACE (6)	REPLACE (6)	REPLACE (6)	REPLACE (6)	REPLACE (6)	REPLACE (6)	REPLACE (6)	REPLACE (6)	REPLACE (6)	REPLACE (6)	REPLACE (6)
AIRBAG SENSOR ASSEMBLY	REPLACE (7)	REPLACE (7)	REPLACE (7)	REPLACE (7)	REPLACE (7)	REPLACE (7)	REPLACE (7)	REPLACE (7)	REPLACE (7)	REPLACE (7)	REPLACE (7)	REPLACE (7)	REPLACE (7)
WIRE HARNESS	INSPECT (8)	INSPECT (8)	INSPECT (8)	INSPECT (8)	INSPECT (8)	INSPECT (8)	INSPECT (8)	INSPECT (8)	INSPECT (8)	INSPECT (8)	INSPECT (8)	INSPECT (8)	INSPECT (8)
SIDE IMPACT AIRBAGS	SEE NOTE (9)	SEE NOTE (9)	SEE NOTE (9)	SEE NOTE (9)	N/A	N/A	SEE NOTE (9)	N/A	N/A	N/A	N/A	N/A	N/A
SIDE IMPACT SENSORS	SEE NOTE (10)	SEE NOTE (10)	SEE NOTE (10)	SEE NOTE (10)	N/A	N/A	SEE NOTE (10)	N/A	N/A	N/A	N/A	N/A	N/A
SEATBELT PRETENSIONERS	REPLACE (11)	REPLACE (11)	REPLACE (11)	REPLACE (11)	REPLACE (11)	REPLACE (11)	REPLACE (11)	REPLACE (11)	REPLACE (11)	REPLACE (11)	REPLACE (11)	REPLACE (11)	REPLACE (11)

*The notes above refer to the Component Replacement Notes on page 3.

*Some Toyota vehicles are equipped with a **Passenger Airbag Manual On-Off Switch**, and other Toyota models may have a retrofit passenger airbag switch installed at the dealership. To analyze the condition of the manual on-off switch, technicians must follow specific inspection procedures which are outlined on page 7 of this bulletin. However, complete airbag manual on-off switch inspection and repair procedures can be found in vehicle-specific Toyota Repair Manuals.

Note - for all Toyota vehicles

Following all collisions when the SRS does NOT deploy inspect:

- | | |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <ul style="list-style-type: none"> <input type="checkbox"/> Steering wheel pad <input type="checkbox"/> Side airbags and seat frames <input type="checkbox"/> Front & side airbag sensors | <ul style="list-style-type: none"> <input type="checkbox"/> Wiring harness and connectors <input type="checkbox"/> Front passenger airbag assembly <input type="checkbox"/> Malfunction indicator lamp for correct operation |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

Component Replacement Notes

Note 1 ☒ Replace the **Steering Wheel Pad**:

- If the airbag has been deployed or dropped
- If the steering wheel pad is diagnosed as needing replacement when troubleshooting or during inspection

Note 2 ☒ Inspect and if necessary replace the **Spiral Cable**:

- If the spiral cable is diagnosed as needing replacement when troubleshooting or during inspection

Note 3 ☒ Inspect and if necessary replace the **Steering Wheel**:

- If the steering wheel is diagnosed as needing replacement during inspection

Note 4 ☒ Replace the **Passenger Airbag** assembly:

- If the passenger airbag has been deployed or dropped
- If the airbag is diagnosed as needing replacement when troubleshooting or during inspection

Note 5 ☒ Visually inspect and if necessary replace the following items if deformed:

- Instrument panel and instrument panel reinforcement
- Glove compartment or glove compartment door

Note 6 ☒ Replace the **Front Impact Sensors**:

- If either the driver or passenger airbag has deployed (**replace both front impact sensors**)
- If a front airbag sensor is diagnosed as needing replacement when troubleshooting or during inspection

Note 7 ☒ Replace the **Airbag Sensor Assembly**:

- If any airbag has been deployed in a collision, or the airbag sensor assembly has been dropped, or is diagnosed as needing replacement when troubleshooting

Note 8 ☒ Inspect and if necessary replace the **Wire Harness** assembly:

- If any part of the SRS wire harness or any connector is diagnosed as needing replacement when troubleshooting or during inspection

Note 9 ☒ Replace the:

- **Side Impact Airbag** if it has been deployed, dropped, or is diagnosed as needing replacement when troubleshooting or during inspection
- **Seat cover** if it has cuts and/or frayed seams, or is diagnosed as needing replacement during inspection
- **Seat frame** if it is bent or has become damaged

Note 10 ☒ Replace the **Side Impact Sensors**:

- If the side airbag assembly has been deployed, dropped, or is diagnosed as needing replacement when troubleshooting or during inspection

Note 11 ☒ In the event of driver or passenger airbag deployment, replace all seatbelt **Pretensioners**.

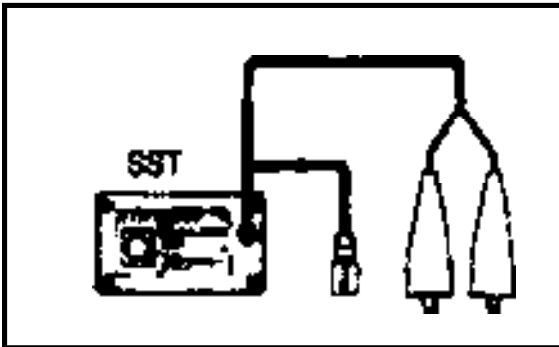
DISPOSAL

HINT:

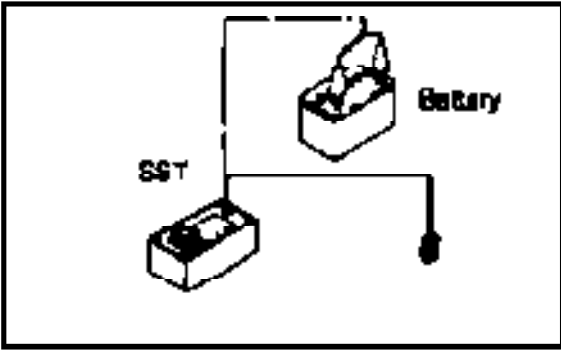
When scrapping vehicle equipped with an SRS or disposing of a steering wheel pad (with airbag), always first deploy the airbag in accordance with the procedure described below. If any abnormality occurs with the airbag deployment, contact the SERVICE DEPT. of TOYOTA MOTOR SALES, U.S.A. INC. When disposing of a steering wheel pad with an airbag deployed in a collision, follow the same procedure given in step 1-(d) in [DISPOSAL](#).

CAUTION:

- Never dispose of a steering wheel pad which has an undeployed airbag.
- The airbag produces a sizeable exploding sound when it deploys, so perform the operation out of doors and where it will not create a nuisance to nearby residents.



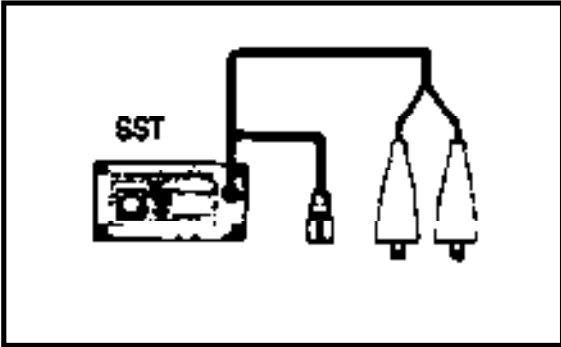
- When deploying the airbag, always use the specified SST (SRS Airbag Deployment Tool). Perform the operation in a place away from electrical noise.
- **SST 09082-00700**
- When deploying an airbag, perform the operation at least 10m (33ft) away from the steering wheel pad.
- The steering wheel pad is very hot when the airbag is deployed, so leave it alone for at least 30 minutes after deployment.
- Use gloves and safety glasses when handling a steering wheel pad with the deployed airbag.
- Always wash your hands with water after completing the operation.
- Do not apply water, etc. to a steering wheel pad with the deployed airbag.



1. AIRBAG DEPLOYMENT WHEN SCRAPPING VEHICLE

HINT:

Have a battery ready as the power source to deploy the airbag.

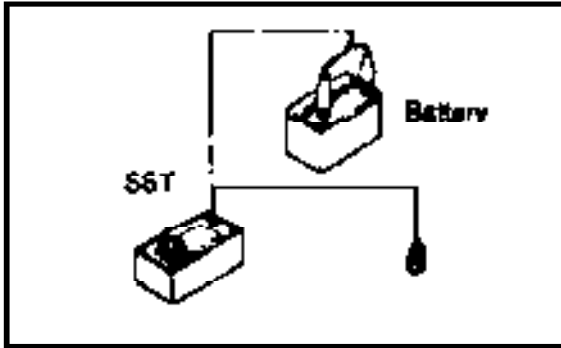


(a) Check the functioning of the SST.

CAUTION:

When deploying the airbag, always use the specified SST:
SRS Airbag Deployment Tool.

SST 09082-00700

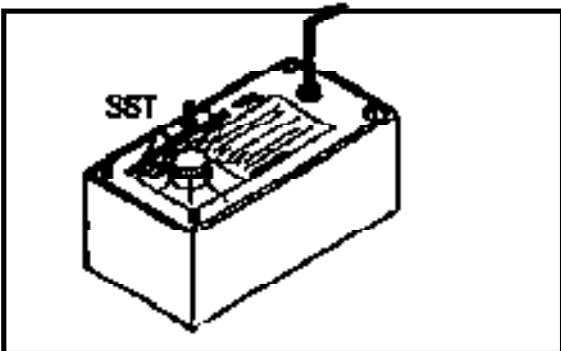


(1) Connect the SST to the battery.

Connect the red clip of the SST to the battery positive (+) terminal and the black clip to the battery negative (-) terminal.

HINT:

Do not connect the yellow connector which will be connected with the supplemental restraint system.

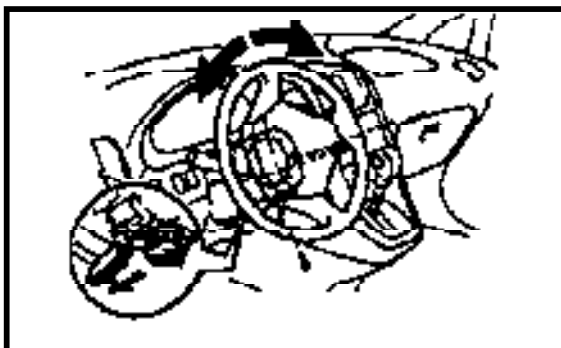


(2) Check the functioning of the SST.

Press the SST activation switch, and check that the LED of the SST activation switch lights up.

CAUTION:

If the LED lights up when the activation switch is not being pressed, SST malfunction is probable, so definitely do not use the SST.



(b) Install the SST.

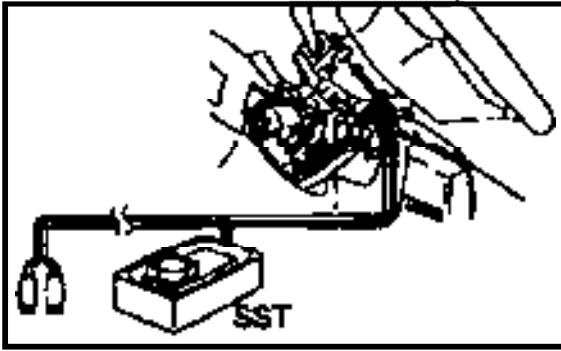
CAUTION:

Check that there is no looseness in the steering wheel and steering wheel pad.

(1) Remove the steering column lower cover.

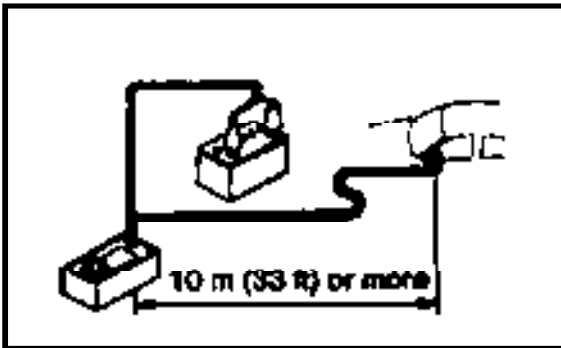
(2) Disconnect the airbag connector of the spiral cable.

SUPPLEMENTAL RESTRAINT SYSTEM - STEERING WHEEL PAD AND SPIRAL CABLE



- (3) Connect the SST connector to the airbag connector of the spiral cable.

SST 09082-00700

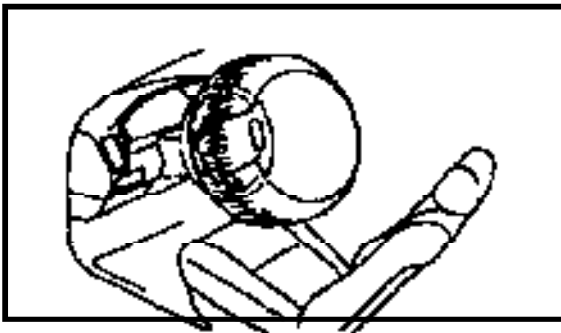


- (4) Move the SST at least 10m (33ft) away from the front of the vehicle.
 (5) Close all the doors and windows of the vehicle.

NOTICE:

Take care not to damage the SST wire harness.

- (6) Connect the SST red clip to the battery positive (+) terminal and the black clip to the negative (-) terminal.



- (c) Deploy the airbag.
 (1) Confirm that no one is inside the vehicle or within 10m (33ft) area around the vehicle.
 (2) Press the SST activation switch and deploy the airbag.

HINT:

The airbag deploys simultaneously as the LED of the SST activation switch lights up.

- (d) Dispose of the steering wheel pad (with airbag).

CAUTION:

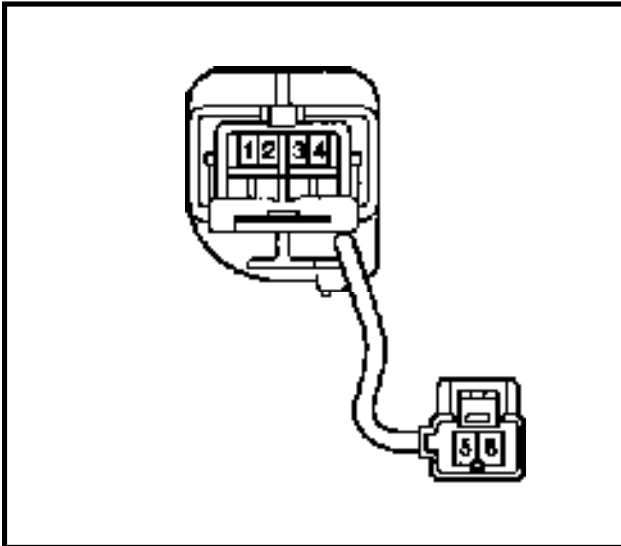
- The steering wheel pad is very hot when the airbag is deployed, so leave it alone for at least 30 minutes after deployment.
 - Use gloves and safety glasses when handling a steering wheel pad with the deployed airbag.
 - Always wash your hands with water after completing the operation.
 - Do not apply water, etc. to a steering wheel pad with the deployed airbag.
- (1) When scrapping a vehicle, deploy the airbag and scrap the vehicle with the steering wheel pad still installed.
 (2) When moving a vehicle for scrapping which has a steering wheel pad with deployed airbag, use gloves and safety glasses.

PASSENGER AIRBAG MANUAL ON-OFF SWITCH INSPECTION

1. INSPECT PASSENGER AIRBAG MANUAL ON-OFF SWITCH CONTINUITY

HINT:

Release the activation prevention mechanism of the passenger airbag manual on-off switch connector on the airbag sensor assembly side. (See page DI-456)



SWITCH POSITION	TESTER CONNECTION	SPECIFIED CONDITION
ON	1-3 2-4	CONTINUITY
	3-4 5-6	NO CONTINUITY
OFF	5-6	CONTINUITY
	2-4	NO CONTINUITY
	3-4	RESISTANCE 2.1-2.7 OHMS

If continuity is not as specified, replace the switch.

2. INSPECT PASSENGER AIRBAG MANUAL ON-OFF INDICATOR OPERATION

- Check that continuity exists between 5 and 6.
- Connect the positive (+) lead from the battery to terminal 1 and negative (-) lead to terminal 2.
- Check that the indicator light lights up.

If the operation is not as specified, replace the indicator.

