


# TOYOTA CUSTOMER SERVICES

Volume: XI  
Number: TC04-020  
Date: 11/15/2004  
 Action  
 Retain  
 Information

## INTEROFFICE MEMORANDUM

TO: ALL REGION/PRIVATE DISTRIBUTOR GENERAL MANAGERS/  
VICE PRESIDENTS

FROM: DAVE ZELLERS,   
VICE PRESIDENT, PRODUCT QUALITY & SERVICE SUPPORT

SUBJECT: SPECIAL SERVICE CAMPAIGN (SSC) – 40K  
(2000 MODEL YEAR TOYOTA CELICA AND ECHO MASTER CYLINDER INSPECTION)

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Toyota will initiate a voluntary Special Service Campaign (SSC) to inspect, and if necessary, replace the brake master cylinder and booster on certain 2000 Model Year Toyota Celica and ECHO vehicles.

On a small number of 2000 model year Toyota Celica and ECHO vehicles, there is a possibility that the recess that retains a rubber seal ring, which is located at the end of the brake master cylinder, may be corroded due to an improper cleaning process. In this condition, brake fluid may leak from the seal, or a small amount of air may enter the master cylinder, which could lead to an increase of vehicle stopping distance and thus raise the possibility of a crash.

The following vital information is provided to inform you and your staff of the campaign notification schedule and your degree of involvement.

1. **Dealer Letter Mailing Date**

The attached Dealer Letter will be mailed to all Toyota dealers in mid-November, 2004.

2. **Owner Notification Mailing Date**

The owner notification will commence in late November, 2004. We have attached a copy of the owner notification letter for your reference.

If a dealer is contacted by an owner of an involved vehicle, who has not yet received a notification, please instruct them to **verify eligibility through Dealer Daily or TIS**. Dealers should perform repairs as outlined in the attached Technical Instructions.

3. **Number of Vehicles Involved**

Nationally, there are approximately 55,000 Celica and 45,000 ECHO vehicles involved in this campaign. **However, only 3 to 5% of the affected vehicles will require Brake Master Cylinder/Brake Booster replacement. The majority of vehicles will only require an inspection.**

4. **Region/District Summary Reports**

We have enclosed the following SSC 40K Summary Reports in the Region/Private Distributor (PD) Service Manager/Customer Service Operations Manager/Director of Service package:

- Region/PD Summary Report that provides an overview of the entire Region/PD for this campaign.
- District Summary Report that indicates the number of involved vehicles per dealership in each district for this campaign.

**5. Vehicles in Dealer Stock**

As required by Federal Regulation, dealers are not to deliver any vehicle acquired in their inventory, which is involved in a safety recall, until the necessary inspections/replacements have been performed.

**6. Parts Ordering**

Since the actual replacement rate is expected to be between 3 to 5%, dealers should not stock master cylinder/booster assemblies. In the event that a dealer inspects and confirms that the vehicle requires the master cylinder/booster assembly replacement, the necessary parts can be ordered through the dealer's facing PDC. ***The replaced parts will be placed on Warranty Parts Recovery and dealers will be required to return the original parts to TMS. Parts that are not returned or incorrect repairs will result in the claim being debited.***

There are 12 different master cylinder/booster assembly part numbers applicable to the Celica and ECHO based upon vehicle equipment and options. To assist dealers in determining the correct part number to order, a website has been set up to look up part numbers by VIN. Please go to [http://toyotamc.imagespm.info/fra\\_home.cfm](http://toyotamc.imagespm.info/fra_home.cfm) (also linked through TIS), enter the VIN, and the correct part number to order will be displayed. ***The website is for part application reference only and will not order the part nor will it confirm campaign completion status.***

Part No.	Part Name	Vehicle	Qty.
04004-35852	Master Cylinder/Booster Assembly 5-speed w/o ABS	ECHO	1*
04004-35952	Master Cylinder/Booster Assembly 4-auto w/o ABS	ECHO	1*
04004-36152	Master Cylinder/Booster Assembly 5-speed w/ ABS	ECHO	1*
04004-36252	Master Cylinder/Booster Assembly 4-auto w/ ABS	ECHO	1*
04004-38120	Master Cylinder/Booster Assembly GT 5-speed w/o ABS	Celica	1*
04004-38220	Master Cylinder/Booster Assembly GT 4-auto w/o ABS	Celica	1*
04004-38320	Master Cylinder/Booster Assembly GT 5-speed w/ ABS	Celica	1*
04004-38420	Master Cylinder/Booster Assembly GT 4-auto w/ ABS	Celica	1*
04004-38720	Master Cylinder/Booster Assembly GTS 6-speed w/ ABS	Celica	1*
04004-38820	Master Cylinder/Booster Assembly GTS 6-speed w/o ABS	Celica	1*
04004-38920	Master Cylinder/Booster Assembly GTS 4-auto (E-shift) w/o ABS	Celica	1*
04004-39120	Master Cylinder/Booster Assembly GTS 4-auto (E-shift) w/ ABS	Celica	1*
47275-52010	Master Cylinder Gasket	Both	1*
00475-1BF03	Brake Fluid	Both	2

\*Due to the low expected failure rate, the master cylinder/booster assembly will be placed on Manual Allocation Control. Once a dealership inspects a vehicle and confirms that the vehicle requires master cylinder/booster replacement and the dealership orders these parts, a representative from TMS Quality Compliance will review each order and contact the dealership's parts manager to verify the necessity of the order, and will then release orders accordingly. This will assure an adequate and balanced parts inventory.

If there are ***special*** circumstances where a dealer is having difficulty receiving parts for a confirmed customer, dealer associates may contact 310-468-5516 to research the order. ***YOU DO NOT NEED TO CALL FOR ROUTINE RELEASE.*** The associate should have the following information ready to expedite research of the order status:

- Dealer Information (Dealer Code, Contact Name, Telephone Number)
- Order Reference Number
- Customer Name and Vehicle 17-digit VIN

Please note that during the period the parts are on-order, customer rental car through the Toyota Rent-A-Car (TRAC) Program is available. Follow the Toyota Transportation Assistance Program (TTAP) guidelines. DSPM authorization will be required for vehicle rentals exceeding 3 days.

7. **Reimbursement Procedures**

The Reimbursement Procedures can be found in the attached Dealer Letter. As this is predominantly an inspection Special Service Campaign, dealers will be requested to **file inspection reimbursement claims as an SSC claim**. Dealers will be requested to **file a normal Warranty Claim using the operation codes provided if the Brake Master Cylinder/Brake Booster requires replacement**.

Please review this entire Special Service Campaign package with the appropriate associates so that they may provide the necessary support to the dealerships and maximize our combined customer satisfaction efforts.

Thank you for your cooperation.

TOYOTA MOTOR SALES, U.S.A, INC.

Enclosures

cc: Region/Private Distributor Assistant General Managers  
Region/Private Distributor Customer Service Operations Managers  
Region/Private Distributor Service Managers/Directors/VPs  
Region/Private Distributor Parts Managers/Directors/VPs  
Region/Private Distributor Customer Services Field Managers  
Region/Private Distributor Technical Services and Training Managers  
Region/Private Distributor District Service and/or Parts Managers  
Region/Private Distributor Customer Relations Managers  
Region/Private Distributor PDC Managers  
Region/Private Distributor Field Technical Specialists  
Region/Private Distributor Service Training Specialists  
Region/Private Distributor Vehicle Operations Managers  
All NAPC General Managers  
All TMS Sales Administration Managers  
All TMS Product Quality & Service Support Managers  
All Field Product Engineers

E. Bastien	D. Esmond	T. Nagata
J. Beseda	G. Fogg	D. Ogilvie
R. Broughman	Y. Funo	J. Olson
G. Bryan	J. Hanson	D. Pettitt
D. Camden	J. Hollis	J. Press
B. Carter	N. Kawakami	E. Taira
D. Cecconi	J. Lang	T. Takada
R. Daly	K. Masumoto	J. Tetherow
C. Davis	E. Matsuda	M. Tomozoe
T. Devany	M. Michels	A. Vaish
B. Ertmann	I. Miller	M. Yamaguchi



Toyota Motor Sales, U.S.A., Inc.  
19001 South Western Avenue  
P.O. Box 2991  
Torrance, CA 90509-2991

TO: ALL TOYOTA DEALER PRINCIPALS,  
SERVICE MANAGERS, PARTS MANAGERS

SUBJECT: SPECIAL SERVICE CAMPAIGN (SSC) – 40K  
(2000 MODEL YEAR TOYOTA CELICA AND ECHO MASTER CYLINDER)

**Toyota will initiate a voluntary Special Service Campaign (SSC) to inspect, and if necessary, replace the brake master cylinder and booster on certain 2000 Model Year Toyota Celica and ECHO vehicles.**

On a small number of 2000 model year Toyota Celica and ECHO vehicles, there is a possibility that the recess that retains a rubber seal ring, which is located at the end of the brake master cylinder, may be corroded due to an improper cleaning process. In this condition, brake fluid may leak from the seal, or a small amount of air may enter the master cylinder, which could lead to an increase of vehicle stopping distance and thus raise the possibility of a crash.

The following vital information is provided to inform you and your staff of the campaign notification schedule and your degree of involvement.

**1. Owner Notification Letter Mailing Date**

The owner notification will commence late November, 2004.

If you are contacted by an owner of an involved vehicle, who has not yet received a notification, please verify eligibility by confirming through Dealer Daily or TIS prior to performing repairs. Dealers should perform inspections/repairs as outlined in the attached Technical Instructions.

**2. Identification of Involved Vehicles**

Nationally, there are approximately 55,000 Celica and 45,000 ECHO 2000 model year vehicles involved in this campaign. **However, only 3 to 5% of the affected vehicles will require Brake Master Cylinder/Brake Booster replacement. The majority of vehicles will only require an inspection.**

MODEL	YEAR	VIN Range	
		VDS	Range
Celica	2000	DR32T	0001037 – 0065493
		DR38T	0001097 – 0064653
		DY32T	0001075 – 0034768
		DY38T	0001047 – 0034764

MODEL	YEAR	VIN Range	
		VDS	Range
ECHO	2000	AT123	0001083 – 0092445 5000009 – 5018895
		AT183	0055398 – 0059085
		BT123	0001049 – 0092464 5000006 – 5021183
		BT183	0056321 – 0059055

**NOTE: As always, consult Dealer Daily/TIS to confirm VIN eligibility and to assure the SSC is applicable. This will verify the vehicle is affected and has not already been completed prior to dealer shipment or by another dealer. TMS warranty will not reimburse dealers for repairs conducted on vehicles that are not affected.**

**3. Vehicles in Dealer Stock**

As required by Federal Regulation, dealers are not to deliver any vehicle acquired in their inventory, which is involved in a safety recall, until the necessary inspections/replacements have been performed.

**4. Inspection Procedures**

Refer to the attached Technical Instructions for the Inspection Procedure.

**5. Dealer/Owner Lists**

Affected vehicle VIN Lists (VIN only due to changes in Privacy Laws) for SSC 40K have been distributed to each dealership's Service and Parts Managers. These lists are based on the dealership's Primary Marketing Area (PMA) or the selling dealership where applicable. Dealerships which did not sell an affected vehicle, or do not have affected vehicles in their PMA, will receive a report indicating so.

A UIO by state matrix is listed below to inform dealers of the number of vehicles in their area:

**Celica**

State	UIO
AK	45
AL	704
AR	318
AZ	932
CA	8,982
CO	834
CT	737
DC	56
DE	238
FL	5,286

State	UIO
GA	1,400
IA	244
ID	116
IL	2,506
IN	888
KS	455
KY	913
LA	587
MA	1,388
MD	1,937

State	UIO
ME	96
MI	846
MN	483
MO	938
MS	220
MT	43
NC	1,523
ND	46
NE	212
NH	333

State	UIO
NJ	2,454
NM	278
NV	507
NY	2,485
OH	2,747
OK	394
OR	608
PA	2,555
RI	202
SC	601

State	UIO
SD	54
TN	987
TX	3,823
UT	308
VA	1,933
VT	85
WA	1,009
WI	841
WV	367
WY	38

**ECHO**

State	UIO
AK	85
AL	484
AR	252
AZ	927
CA	9,196
CO	672
CT	571
DC	101
DE	166
FL	4,303

State	UIO
GA	939
IA	166
ID	135
IL	1,381
IN	403
KS	275
KY	520
LA	640
MA	1,459
MD	1,613

State	UIO
ME	195
MI	664
MN	377
MO	454
MS	211
MT	56
NC	1,183
ND	34
NE	103
NH	309

State	UIO
NJ	1,333
NM	230
NV	383
NY	1,931
OH	1,543
OK	299
OR	644
PA	1,857
RI	198
SC	395

State	UIO
SD	29
TN	663
TX	3,106
UT	304
VA	1,540
VT	132
WA	962
WI	565
WV	267
WY	50

## 6. Parts Ordering

Since the actual replacement rate is expected to be between 3 to 5%, dealers should not stock master cylinder/booster assemblies. In the event that a dealer inspects and confirms that the vehicle requires master cylinder/booster assembly replacement necessary parts can be ordered through the dealer's facing PDC. ***The replaced parts will be placed on Warranty Parts Recovery and dealers will be required to return the original parts to TMS. Parts that are not returned or incorrect repairs will result in the claim being debited.***

There are 12 different master cylinder/booster assembly part numbers applicable to the Celica and ECHO based upon vehicle equipment and options. To assist dealers in determining the correct part number to order, a website has been set up to look up part numbers by VIN. Please go to [http://toyotamc.imagespm.info/fra\\_home.cfm](http://toyotamc.imagespm.info/fra_home.cfm) (also linked through TIS), enter the VIN, and the correct part number to order will be displayed. ***The website is for part application reference only and will not order the part nor will it confirm campaign completion status.***

Due to the low expected failure rate, the master cylinder/booster assembly will be placed on Manual Allocation Control. Once a dealership inspects a vehicle and confirms that the vehicle requires master cylinder/booster replacement and the dealership orders these parts, a representative from TMS Quality Compliance will review each order and contact the dealership's parts manager to verify the necessity of the order, and will then release orders accordingly. This will assure an adequate and balanced parts inventory.

If there are ***special*** circumstances where a dealer is having difficulty receiving parts for a confirmed customer, dealer associates may contact 310-468-5516 to research the order. ***YOU DO NOT NEED TO CALL FOR ROUTINE RELEASE.*** The associate should have the following information ready to expedite research of the order status:

- Dealer Information (Dealer Code, Contact Name, Telephone Number)
- Order Reference Number
- Customer Name and Vehicle 17-digit VIN

Please note that during the period the parts are on-order, customer rental car through the Toyota Rent-A-Car (TRAC) Program is available. Follow the Toyota Transportation Assistance Program (TTAP) guidelines. DSPM authorization will be required for vehicle rentals exceeding 3 days.

Part No.	Part Name	Vehicle	Qty.
04004-35852	Master Cylinder/Booster Assembly 5-speed w/o ABS	ECHO	1*
04004-35952	Master Cylinder/Booster Assembly 4-auto w/o ABS	ECHO	1*
04004-36152	Master Cylinder/Booster Assembly 5-speed w/ ABS	ECHO	1*
04004-36252	Master Cylinder/Booster Assembly 4-auto w/ ABS	ECHO	1*
04004-38120	Master Cylinder/Booster Assembly GT 5-speed w/o ABS	Celica	1*
04004-38220	Master Cylinder/Booster Assembly GT 4-auto w/o ABS	Celica	1*
04004-38320	Master Cylinder/Booster Assembly GT 5-speed w/ ABS	Celica	1*
04004-38420	Master Cylinder/Booster Assembly GT 4-auto w/ ABS	Celica	1*
04004-38720	Master Cylinder/Booster Assembly GTS 6-speed w/ ABS	Celica	1*
04004-38820	Master Cylinder/Booster Assembly GTS 6-speed w/o ABS	Celica	1*
04004-38920	Master Cylinder/Booster Assembly GTS 4-auto (E-shift) w/o ABS	Celica	1*
04004-39120	Master Cylinder/Booster Assembly GTS 4-auto (E-shift) w/ ABS	Celica	1*
47275-52010	Master Cylinder Gasket	Both	1*
00475-1BF03	Brake Fluid	Both	2

**7. Reimbursement Procedures**

As this is predominantly an inspection Special Service Campaign, dealers will be requested to **file inspection reimbursement claims as an SSC claim**. Dealers will be requested to **file a normal Warranty Claim using the operation codes provided if the Brake Master Cylinder/Brake Booster requires replacement**.

The **SSC Inspection operation codes** to be used are:

SSC #	Model	Op. Code	Description	Flat Rate Hour	Claim Type
40K	Celica or ECHO	4531HA	External Inspection of Brake Master Cylinder/Brake Booster and check for air by bleeding the brakes.	1.0 hr/vehicle	SSC

NOTE: The above flat rate times includes 0.1 hours of administrative cost per unit for the dealership.

Use the following **SSC Inspection operation codes** *only* if the Brake Booster was recently replaced and the master cylinder is removed, per the technical instructions attached, to conduct the inspection. **This operation code should rarely be used and TMS will be monitoring the usage of this operation code.**

SSC #	Model	Op. Code	Description	Flat Rate Hour	Claim Type
40K	Celica or ECHO	4531HD	External Inspection of Brake Master Cylinder/Brake Booster, check for air by bleeding the brakes and remove the master cylinder to check inside the brake booster.  <i>Use Only</i> if the Brake Booster was recently replaced.	1.4 hr/vehicle	SSC

NOTE: The above flat rate times includes 0.1 hours of administrative cost per unit for the dealership.

In the rare event that a Brake Master Cylinder/Brake Booster requires replacement, dealers will be requested to **file a normal Warranty Claim using the operation codes provided below**. The replaced parts will initially be placed on Warranty Parts Recovery. **Parts that are not returned or incorrect repairs will result in the claim being debited.**

SSC #	Description	Model	Op. Code	Flat Rate Hour	Claim Type
40K	External Inspection of Brake Master Cylinder/Brake Booster and replace Brake Master Cylinder/Brake Booster.	Celica	4531HH	3.3 hr/vehicle	Warranty
		ECHO	4531HG	2.6 hr/vehicle	
	External Inspection of Brake Master Cylinder/Brake Booster, check for air by bleeding the brakes and replace Brake Master Cylinder/Brake Booster.	Celica	4531HC	3.8 hr/vehicle	
		ECHO	4531HB	3.1 hr/vehicle	
	External Inspection of Brake Master Cylinder/Brake Booster, check for air by bleeding the brakes, remove the master cylinder to check inside the brake booster and replace Brake Master Cylinder/Brake Booster.	Celica	4531HF	4.2 hr/vehicle	
ECHO	4531HE	3.5 hr/vehicle			

NOTE: The above flat rate times includes 0.1 hours of administrative cost per unit for the dealership. **These operation codes have been specially set up to be usable regardless of whether the vehicle is outside of normal warranty coverage.** Please note that during the period the parts are on-order, customer rental car through the Toyota Rent-A-Car (TRAC) Program is available. Follow the Toyota Transportation Assistance Program (TTAP) guidelines. DSPM authorization will be required for vehicle rentals exceeding 3 days.

Please review this entire package with your Service and Parts staff to familiarize them with the proper step-by-step procedures required to implement this Special Service Campaign.

Thank you for your cooperation.  
TOYOTA MOTOR SALES, U.S.A., INC.



**2000 Model Year Toyota Celica and ECHO  
Brake Master Cylinder Inspection  
Special Service Campaign**

Dear Toyota Customer:

This notice is sent to you in accordance with the requirements of the National Traffic and Motor Vehicle Safety Act. Toyota has decided that a defect, which relates to motor vehicle safety, exists in certain 2000 Model Year Toyota Celica and ECHO vehicles.

**What is the problem?**

On a small number of 2000 model year Toyota Celica and ECHO vehicles, there is a possibility that the recess that retains a rubber seal ring, which is located at the end of the brake master cylinder, may be corroded due to an improper cleaning process. In this condition, brake fluid may leak from the seal, or a small amount of air may enter the master cylinder, which could lead to an increase of vehicle stopping distance and thus raise the possibility of a crash.

**What will Toyota do?**

Any Toyota dealer will inspect the brake master cylinder to determine if the end of the brake master cylinder is corroded. Based upon the inspection results, it may be necessary for the Toyota dealer to replace the brake master cylinder and the brake booster. Both the inspection, and if necessary, brake master cylinder and brake booster replacement will be performed at **NO COST** to you.

**What should you do?**

Please contact your authorized Toyota dealer and make an appointment to have your vehicle inspected at your earliest convenience. The labor time to inspect the brake master cylinder is approximately one hour. If the replacement of the brake master cylinder and brake booster is necessary, the labor time is approximately three hours. However, depending upon the dealer's work schedule, it may be necessary to make your vehicle available for a longer period of time.

**Please present this notice to the Toyota Dealer when you bring the vehicle in for your service appointment.**

If you no longer own the vehicle or have changed addresses, please indicate so on the enclosed postage paid form, providing us with the updated name and address.

**What if you have other questions?**

***Your local Toyota dealer will be more than happy to answer any of your questions and set up an appointment to perform the repair.*** If you require further assistance, you may contact the Toyota Customer Experience Center at 1-888-270-9371 Monday through Friday, 5:00 am to 9:30 pm, Saturday and Sunday 7:00 am through 3:00 pm Pacific Standard Time.

If you believe that the dealer or Toyota has failed or is unable to remedy the defect within a reasonable time, you may submit a complaint to the Administrator, National Highway Traffic Safety Administration, 400 Seventh Street S.W., Washington, D.C. 20590, or call the toll free Auto Safety Hot Line at 1-888-327-4236.

**What if you have previously paid for replacement of the brake master cylinder and/or brake booster for this specific condition?**

If you have previously paid for the replacement of the brake master cylinder and/or brake booster for a leakage or seepage issue prior to receiving this letter, please mail a copy of your repair order, proof-of-payment, and proof-of-ownership to the following address for reimbursement consideration. ***Please note that reimbursement does not cover brake pads.***

Toyota Motor Sales, U.S.A., Inc.  
Toyota Customer Experience, WC 10  
19001 South Western Avenue  
Torrance, CA 90509

Include your name, address, and telephone number(s) in your request. Please allow 4 to 6 weeks to review your request.

If you are a vehicle lessor, Federal law requires that any vehicle lessor receiving this recall notice must forward a copy of this notice to the lessee within ten days.

As always, Toyota wants to ensure you complete satisfaction with your vehicle and ownership experience. We sincerely regret any inconvenience this condition may have caused you.

Thank you for driving a Toyota.

Sincerely,

TOYOTA MOTOR SALES, U.S.A., INC.



**Special Service Campaign (SSC) Q&A  
2000 Model Year Toyota Celica and Echo Brake Master Cylinder Inspection**

**Q1: What is the condition?**

A1: In certain 2000 MY Celica and Echo vehicles, there is a possibility that the recess that retains a rubber seal ring, which is located at the end of the brake master cylinder, may be corroded due to an improper cleaning process. In this condition, brake fluid may leak from the seal, or a small amount of air may enter the master cylinder, which could lead to an increase of vehicle stopping distance and thus raise the possibility of a crash.

**Q2: What is the cause of this condition?**

A2: During the manufacturing process, a portion of the brake master cylinder may have been improperly cleaned, corroding the recess that retains a rubber seal ring.

**Q3: Are there any warnings that this condition exists?**

A3: Yes, the vehicle may exhibit a soft brake pedal condition and/or increased stopping distances.

**Q4: Which and how many vehicles are involved?**

A4: Only certain 2000 Model Year Celica and Echo are involved. There are approximately 109,000 vehicles in the U.S.

**Q5: What is the production period of the affected vehicles?**

A5: The affected vehicles were produced:

- Toyota Celica July, 1999 through June, 2000
- Toyota Echo August, 1999 through June, 2000

**Q6: Are there any other Toyota or Lexus vehicles involved?**

A6: No, this condition only affects certain 2000 Model Year Celica and Echo vehicles.

**Q7: How many incidents of this condition have been reported?**

A7: There have been no cases of this condition reported in the affected Celica and Echo vehicles.

**Q8: Have there been any accidents reported?**

A8: There have been no reported cases of accidents related to this condition.

**Q9: What is Toyota going to do?**

A9: Owners of the involved vehicles will receive a Special Service Campaign notification by first class mail beginning in mid-October, 2004. Toyota dealers will inspect and, if necessary, replace the brake master cylinder and booster at **NO COST** to the vehicle owners.

**Q10: How long will the repair take?**

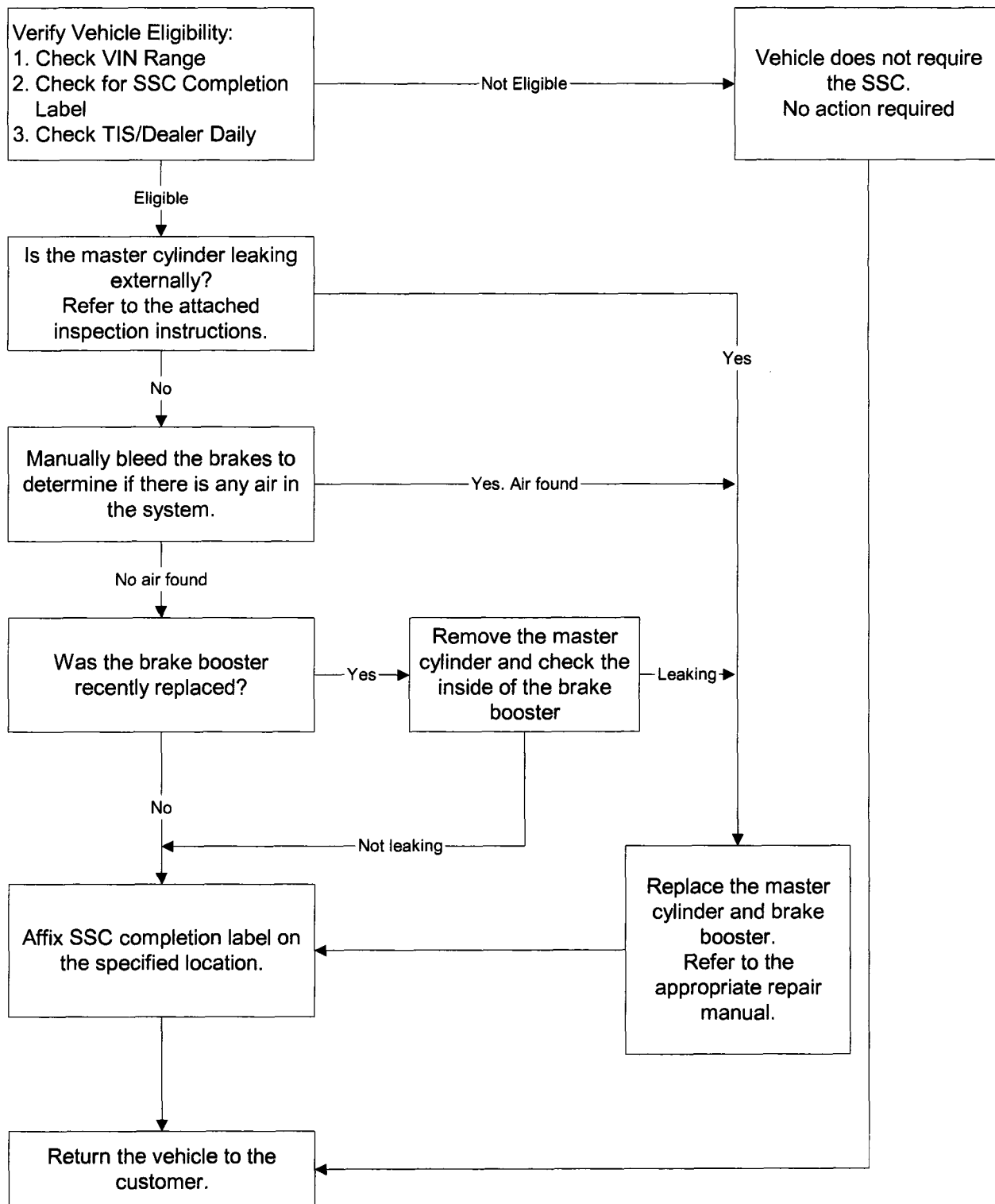
A10: The inspection/repair will take approximately three hours. However, depending upon the dealer's work schedule, it may be necessary to make the vehicle available for a longer period of time.

**Q11: What should an owner do if they experience the condition?**

A11: Owners are requested to contact their local Toyota dealer for diagnosis and repair.

**TECHNICAL INSTRUCTIONS**  
**FOR**  
**SPECIAL SERVICE CAMPAIGN 40K**  
**2000 CELICA**  
**MASTER CYLINDER AND BRAKE BOOSTER INSPECTION**

# I. OPERATION FLOW CHART



**NOTE: Do NOT throw away the Brake Master Cylinder and Brake Booster assembly. They will be recovered under the Warranty Parts Recovery Program.**

## II. AFFECTED VIN RANGE

MODEL	YEAR	VIN Range	
		VDS	Range
Celica	2000	DR32T	0001037 - 0065493
		DR38T	0001097 - 0064653
		DY32T	0001075 - 0034768
		DY38T	0001047 - 0034764

### NOTE:

Not all vehicles in the VIN range are affected. Always consult Dealer Daily or TIS to confirm VIN eligibility and to assure the SSC is applicable. This will verify the vehicle is involved and has not already been completed by another dealer. TMS warranty will not reimburse dealers for repairs conducted on vehicles that are not affected.

## III. PREPARATION

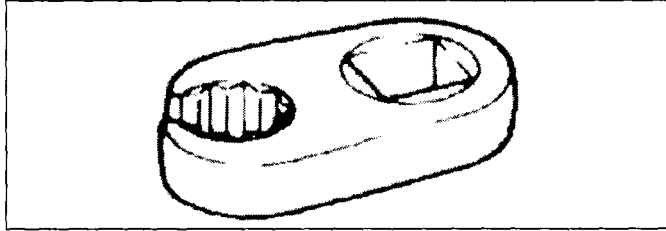
### A. PARTS

Parts when replacement is necessary (only one kit is needed per vehicle dependent upon options)

Model	Part Number	Description	Qty/ Vehicle
Celica	04004-38120	Brake Master Cylinder/Booster Kit GT 5-speed w/o ABS	1
	04004-38220	Brake Master Cylinder/Booster Kit GT 4-auto w/o ABS	1
	04004-38320	Brake Master Cylinder/Booster Kit GT 5-speed w/ ABS	1
	04004-38420	Brake Master Cylinder/Booster Kit GT 4-auto w/ ABS	1
	04004-38720	Brake Master Cylinder/Booster Kit GTS 6-speed w/ ABS	1
	04004-38820	Brake Master Cylinder/Booster Kit GTS 6-speed w/o ABS	1
	04004-38920	Brake Master Cylinder/Booster Kit GTS 4-auto (E-shift) w/o ABS	1
	04004-39120	Brake Master Cylinder/Booster Kit GTS 4-auto (E-shift) w/ ABS	1
	00475 - 1BF03	Brake Fluid	2

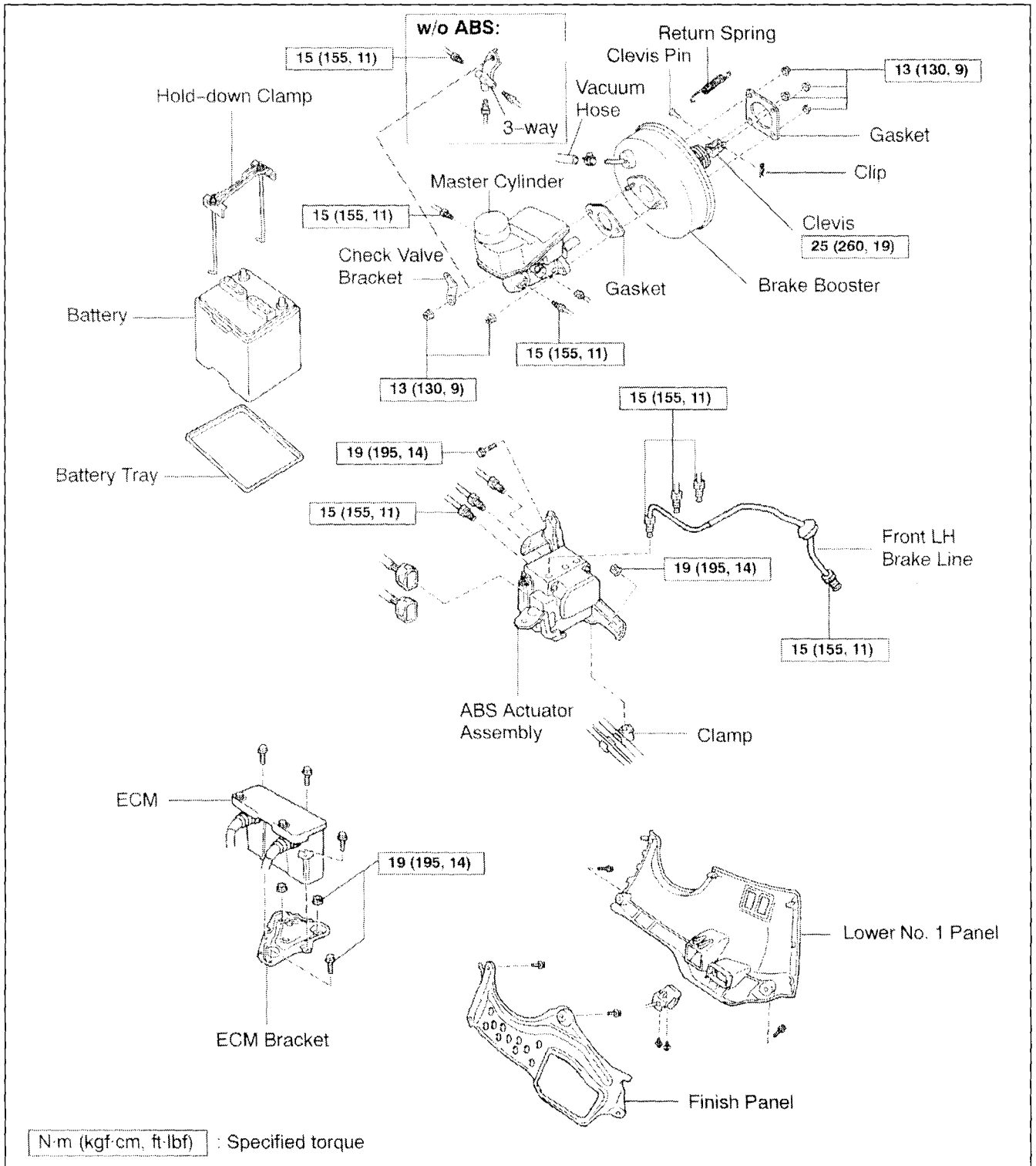
To assist dealers in determining the correct part number to order, a website has been set up to look up part numbers by VIN. Please go to [http://toyotamc.imagespm.info/fra\\_home.cfm](http://toyotamc.imagespm.info/fra_home.cfm) (also linked through TIS), enter the VIN, and the correct part number to order will be displayed. **The website is for part application reference only and will not order the part nor will it confirm campaign completion status.** The actual replacement rate is expected to be between 3 to 5%. Dealers should not stock master cylinder/booster assemblies. In the event that a dealer inspects and confirms that vehicle requires master cylinder/booster assembly replacement, the necessary parts can be ordered through the dealer's facing PDC. **Replaced master cylinder/brake boosters must be retained and returned as requested under the terms of the Warranty Parts Recovery policy.**

## B. TOOLS



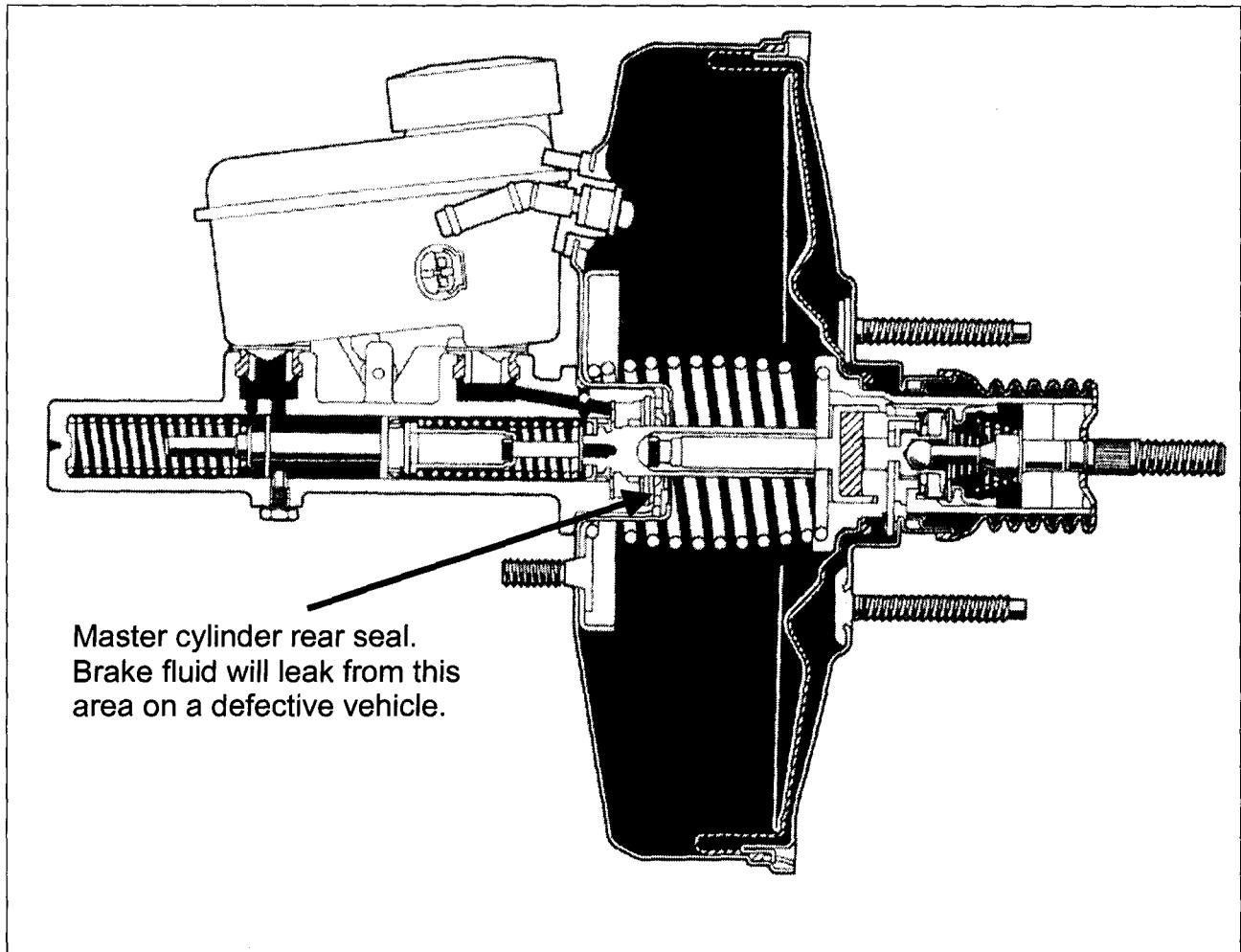
Standard Hand Tools  
Torque Wrench  
SST: 09023 – 00101 Union Nut Wrench  
(or equivalent)

# C. LOCATION

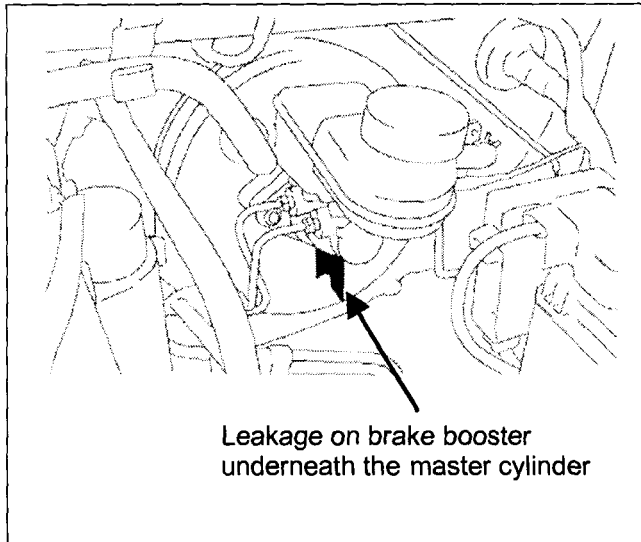




## IV INSPECTION



This SSC involves inspection to determine if the brake master cylinder is leaking. In certain 2000 MY Celica and Echo vehicles, there is a possibility that the recess that retains a rubber seal ring, which is located at the end of the brake master cylinder, may be corroded due to an improper cleaning process. In this condition, brake fluid may leak from the seal, or a small amount of air may enter the master cylinder, which could lead to an increase of vehicle stopping distance and thus raise the possibility of a crash. While doing the inspection ensure that any signs of external leakage are not from previous overfilling or spillage of the brake fluid when refilling the reservoir. ***The brake master cylinder/brake booster assembly replacement rate is expected to be between 3 and 5%.***



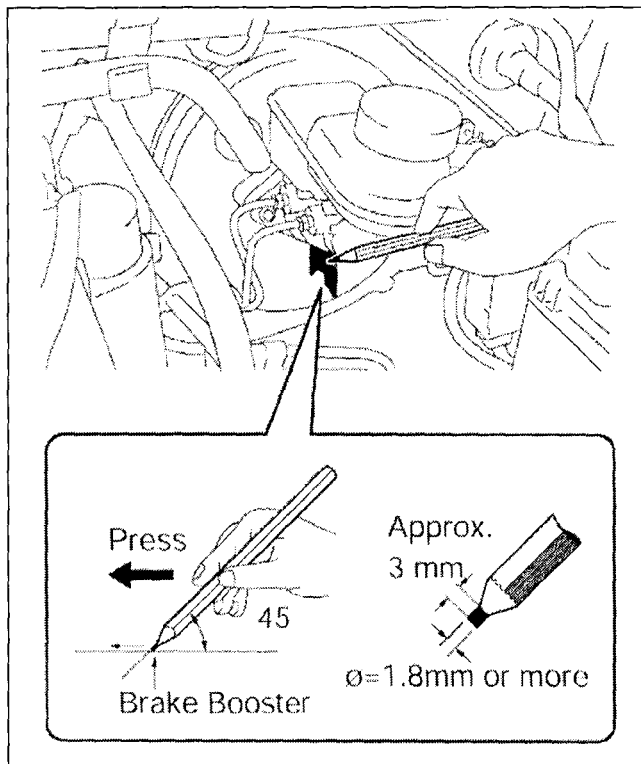
**1. INSPECT BRAKE MASTER CYLINDER EXTERNALLY FOR LEAKAGE**

- (a) Check (visually and by feel) for fluid leakage from the master cylinder in the area shown.

If the master cylinder is leaking, it must be replaced along with the brake booster. Refer to the appropriate repair manual for replacement procedures and to page 3 for parts information. (Remember to keep the replaced master cylinder/brake booster assembly under the terms of the Warranty Parts Recovery policy)

**NOTE:**

**Ensure that any signs of brake fluid leakage is not a result of overfill/spillage from a previous repair.**

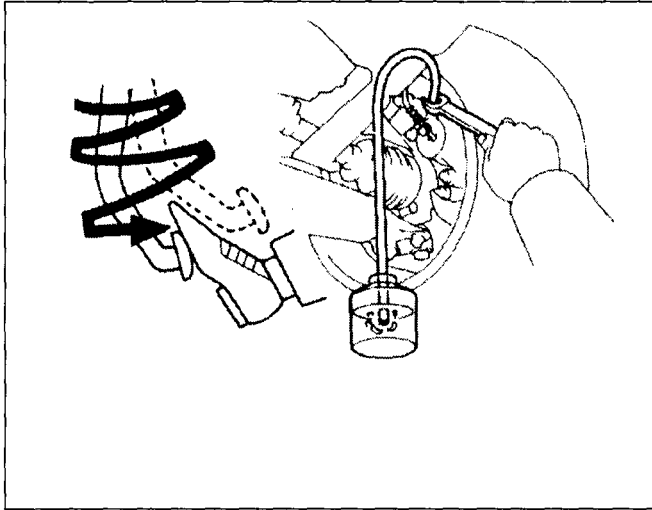


- (b) Using a sharpened pencil, as shown, check that the paint from the brake booster does not come off.

If the master cylinder is leaking, it must be replaced along with the brake booster. Refer to the appropriate repair manual for replacement procedures and to page 3 for parts information. (Remember to keep the replaced master cylinder/brake booster assembly under the terms of the Warranty Parts Recovery policy)

**NOTE:**

**The pencil is used as a non-abrasive tool to determine if the paint on the booster has been damaged due to leaking brake fluid.**



**2. INSPECT FOR AIR BY MANUALLY BLEEDING THE BRAKE SYSTEM.**  
(Do not use a pressure or vacuum type brake bleeder)

- (a) Fill the brake master cylinder reservoir.
- (b) Bleed the brake system in the following sequence to determine if any air is in the master cylinder.
  - 1. Right Rear
  - 2. Left Rear
  - 3. Right Front
  - 4. Left Front

If any air is found, the master cylinder and brake booster must be replaced.

***However, ensure that the any air found in the brake system is from the master cylinder. Due to the distance of the master cylinder, immediately visible air is not from the master cylinder. (Remember to keep the replaced master cylinder/brake booster assembly under the terms of the Warranty Parts Recovery policy)***

Refer to the appropriate repair manual for replacement procedures and to page 3 for parts information. (Remember to keep the replaced master cylinder/brake booster assembly under the terms of the Warranty Parts Recovery policy)

**NOTE:**

**Do not let the brake fluid level to drop below minimum.**

- (c) Check and adjust brake fluid level as necessary.

**3. DETERMINE IF BRAKE BOOSTER WAS RECENTLY REPLACED**

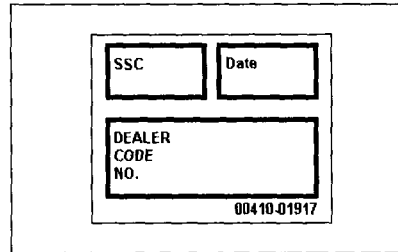
If it appears that the brake booster has been recently replaced, proceed to Appendix A, master cylinder removal and inspection.

## V. SSC COMPLETION LABEL INSTALLATION

**A.** After completing the repair and before returning the vehicle to the owner, an SSC completion label, that is enclosed in the owner's notification, must be affixed to the left front door hinge post near the check strap.

**B.** The label is to be filled out as follows:

- Write in SSC 40K.
- Write in the date of the repair.
- Write in your dealer code.



The diagram shows a rectangular label form with a double-line border. It is divided into three main sections. At the top left is a small box labeled 'SSC'. At the top right is a small box labeled 'Date'. Below these two boxes is a larger rectangular box labeled 'DEALER CODE NO.'. At the bottom right corner of the entire label, the part number '00410-01917' is printed.

**C.** Additional SSC completion labels, in sheets of 50 (P/N 00410-01917), may be ordered through the non-parts system on a 1450 order form or through the TDN system.

# Appendix A. MASTER CYLINDER REMOVAL AND INSPECTION (IF BRAKE BOOSTER WAS RECENTLY REPLACED)

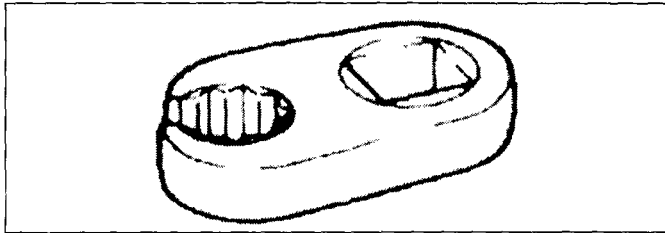
## I. PREPARATION

### A. PARTS

Parts for master cylinder inspection only

Model	Part Number	Description	Qty/ Vehicle
Celica	47275-52010	Brake Master Cylinder Gasket	1
	00475-1BF03	Brake Fluid	2

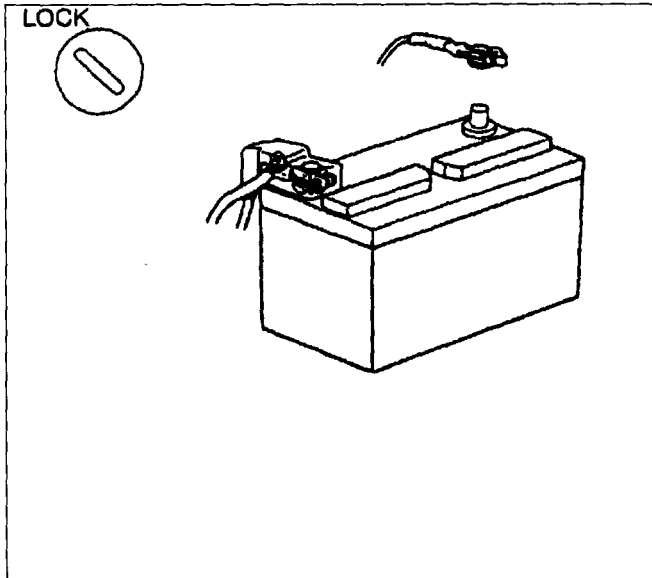
### B. TOOLS



Standard Hand Tools  
Torque Wrench  
SST: 09023 – 00101 Union Nut Wrench  
(or equivalent)

**NOTE:**

This inspection is only necessary if it appears that the brake booster has been recently replaced.

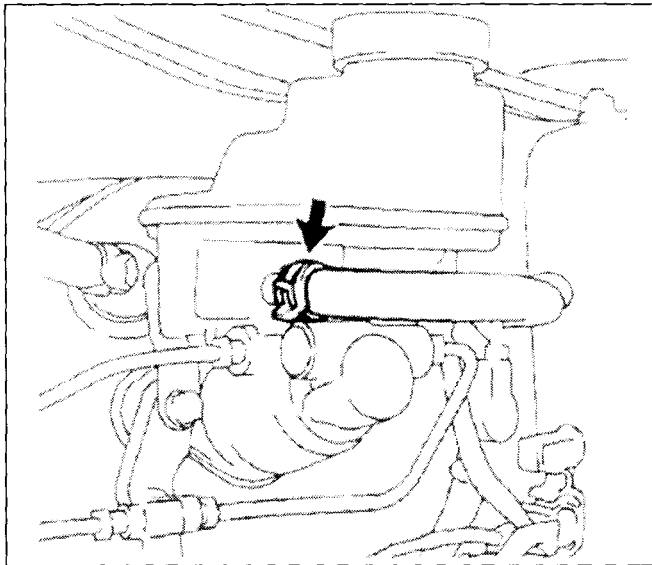


**1. INSPECT MASTER CYLINDER FOR INTERNAL LEAKAGE FROM REAR SEAL**

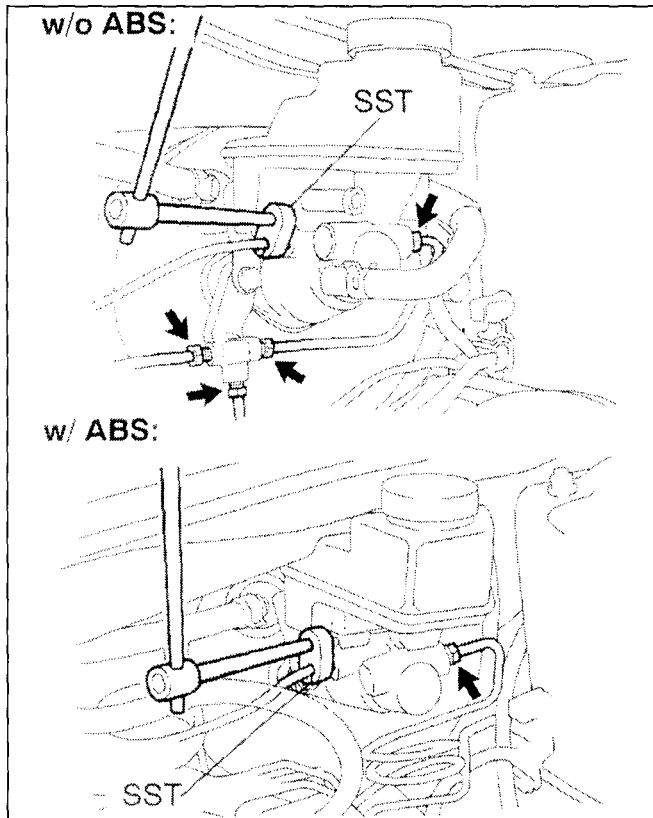
- (a) Disconnect the negative battery cable.
- (b) Disconnect the positive battery cable.
- (c) Remove battery hold down.
- (d) Remove battery.
- (e) Disconnect the brake fluid level sensor from the master cylinder reservoir.
- (f) Remove the brake fluid from the reservoir.
  - 1. Using a syringe, drain the reservoir.

**NOTE:**

Immediately clean off any brake fluid spilled on painted surfaces. Brake fluid will damage the vehicle's finish.



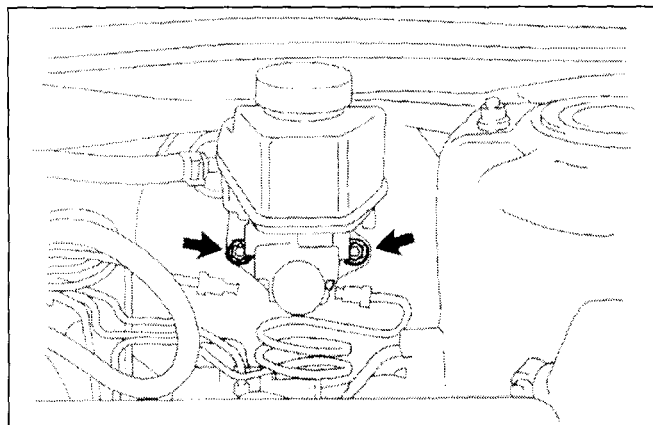
- (g) Disconnect the supply hose going to the clutch master cylinder from the reservoir (manual transmission vehicles).



(h) Using the SST disconnect the brake lines.

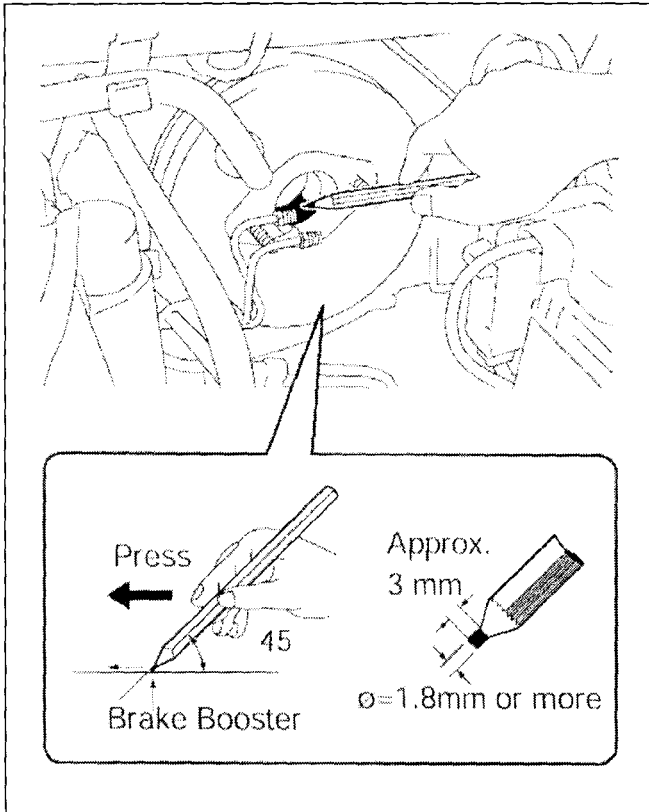
1. Disconnect the brake lines from the master cylinder:
  - **(w/o ABS) 5 lines:**  
2 lines from the master and 3 lines from the 3 way union
  - **(with ABS)**  
2 lines

**SST: 09023 – 00100 (or equivalent)**



(i) Remove the master cylinder.

1. Remove the 2 nuts securing the master cylinder to the brake booster.
2. Remove the master cylinder and the gasket.
  - **(w/o ABS):**  
**Remove the check valve bracket and 3-way valve along with the master**



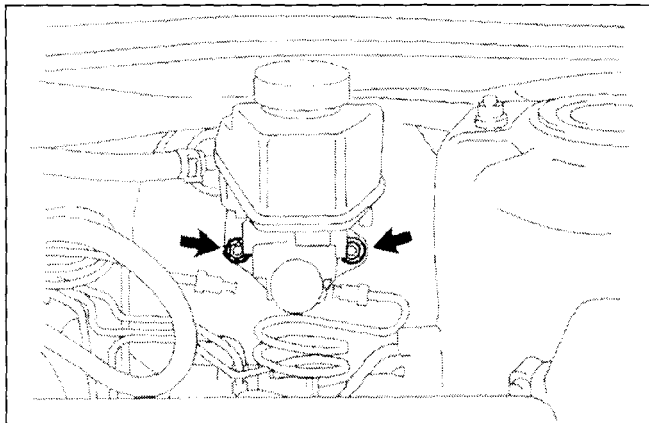
- (j) Check for signs of brake fluid leakage inside the booster. Use a pencil as shown. Check that the paint does not come off the brake booster.

If the master cylinder is leaking, it must be replaced along with the brake booster. Refer to the appropriate repair manual for replacement procedures and to page 3 for parts information. (Remember to keep the replaced master cylinder/brake booster assembly under the terms of the Warranty Parts Return Policy)

**If the master cylinder is not leaking, proceed to step 2 REINSTALL THE MASTER CYLINDER.**

**NOTE:**

The pencil is used as a non-abrasive tool to determine if the paint on the booster has been damaged due to leaking brake fluid.

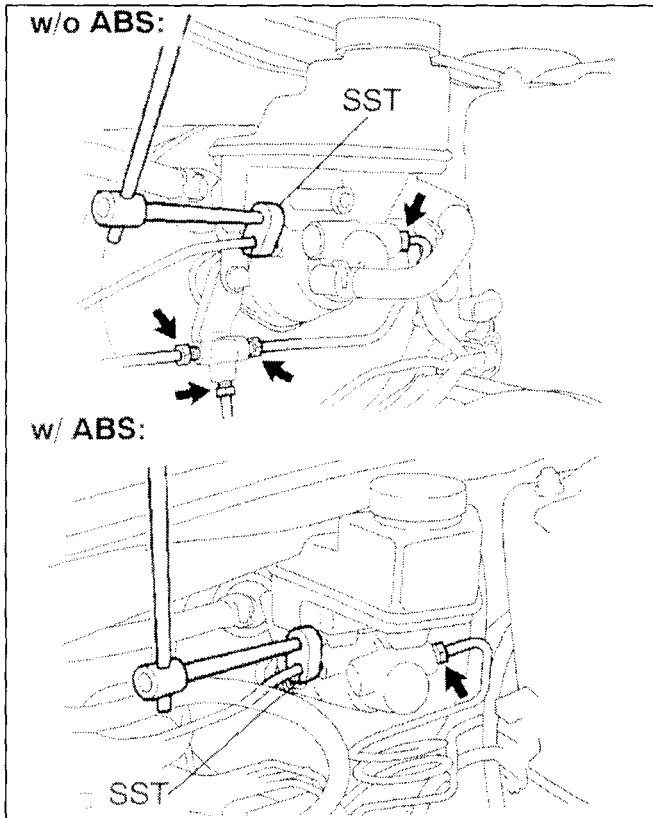


**2. REINSTALL THE MASTER CYLINDER**

- (a) Install the new gasket on the brake booster.
- (b) Reinstall the master cylinder.
  - (w/o ABS):  
Reinstall the check valve bracket and 3-way valve along with the master cylinder

**TORQUE: 13 N•m (130 kgf•cm, 9 ft•lbf)**

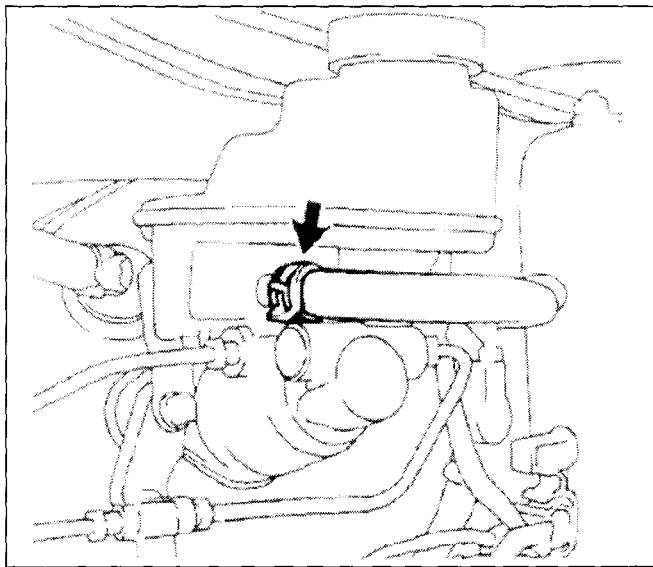




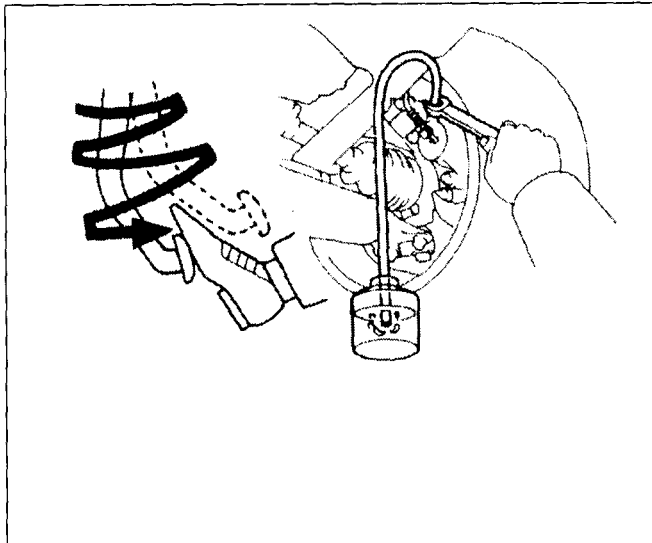
- (c) Reconnect the brake lines
- **(w/o ABS):**  
5 lines (2 lines to the master and 3 lines to the 3 way union)
  - **ABS:**  
2 lines

**SST 09023-00100**

**TORQUE: 15 N•m (155 kgf•cm, 11 ft•lbf)**



- (d) Reconnect the supply line for the clutch master cylinder to the reservoir.  
(manual transmission vehicles)



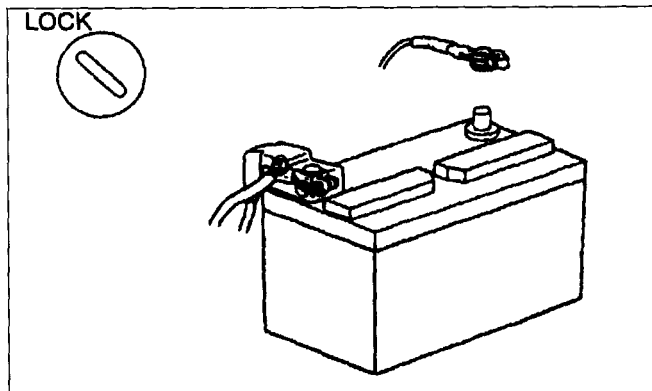
### 3. BLEED THE BRAKE SYSTEM.

- (a) Fill the brake master cylinder reservoir.
- (b) Bleed the brake system in the following sequence to remove any air from the system.
  1. Right Rear
  2. Left Rear
  3. Right Front
  4. Left Front

**NOTE:**

**Do not let the brake fluid level to drop below minimum.**

- (c) Check and adjust brake fluid level as necessary.



- (d) Reinstall the battery
- (e) Reinstall the hold down clamp.
- (f) Reconnect the positive battery terminal.
- (g) Reconnect the negative battery terminal.

## SSC COMPLETION LABEL INSTALLATION

**A.** After completing the repair and before returning the vehicle to the owner, an SSC completion label, that is enclosed in the owner's notification, must be affixed to the left front door hinge post near the check strap.

**B.** The label is to be filled out as follows:

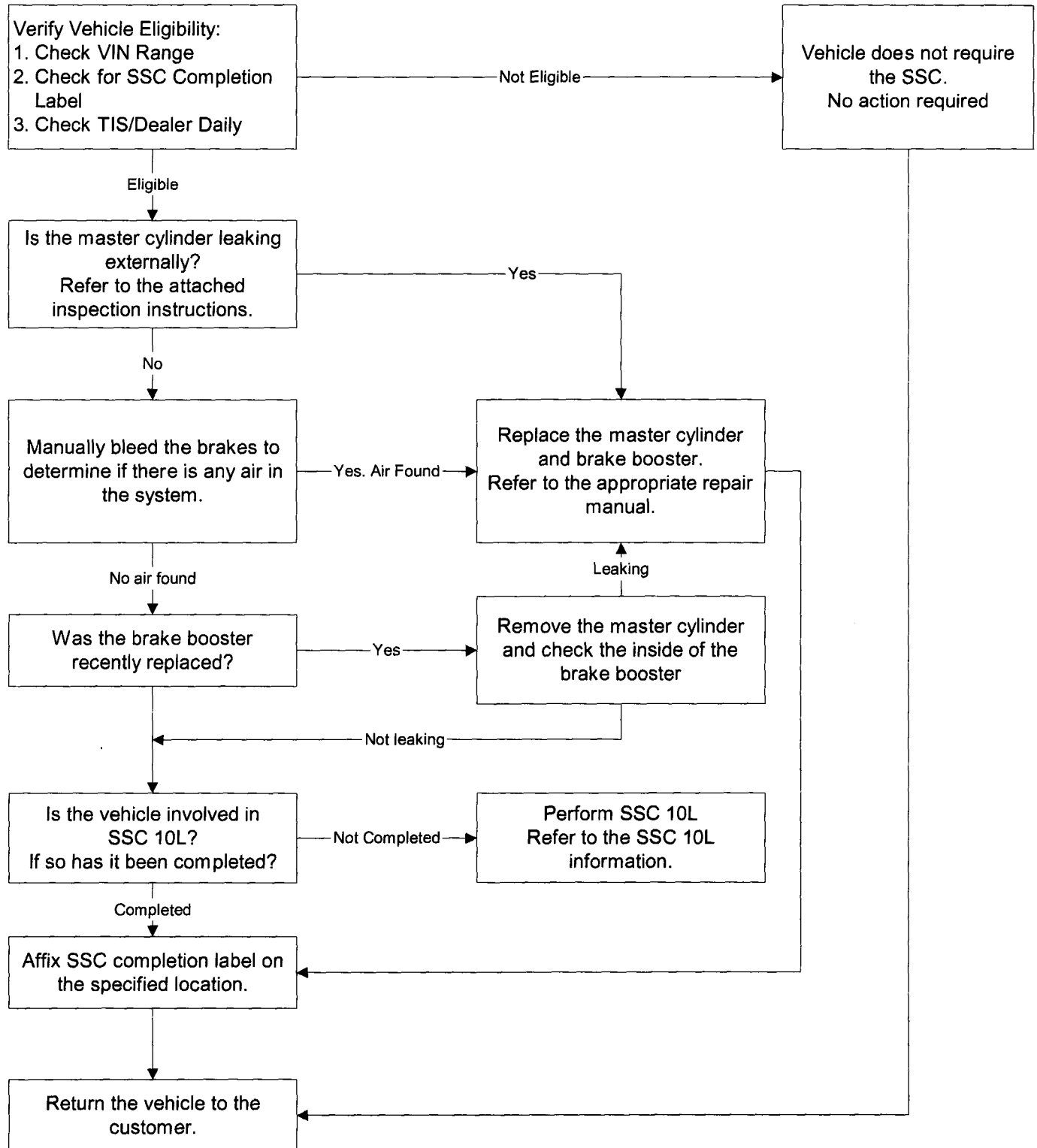
- Write in SSC 40K.
- Write in the date of the repair.
- Write in your dealer code.

SSC	Date
DEALER CODE NO.	
00410-01917	

**C.** Additional SSC completion labels, in sheets of 50 (P/N 00410-01917), may be ordered through the non-parts system on a 1450 order form or through the TDN system.

**TECHNICAL INSTRUCTIONS**  
**FOR**  
**SPECIAL SERVICE CAMPAIGN 40K**  
**2000 ECHO**  
**MASTER CYLINDER AND BRAKE BOOSTER INSPECTION**

# I. OPERATION FLOW CHART



**NOTE: Do NOT throw away the Brake Master Cylinder and Brake Booster assembly. They will be recovered under the Warranty Parts Recovery Program.**

## II. AFFECTED VIN RANGE

MODEL	YEAR	VIN Range	
		VDS	Range
ECHO	2000	AT123	0001046 - 0092445 5000009 - 5000827
		AT183	0055398 - 0059085
		BT123	0001045 - 0092464 5000006 - 5000842
		BT183	0056321 - 0059055

**NOTE:**

Not all vehicles in the VIN range are affected. Always consult Dealer Daily or TIS to confirm VIN eligibility and to assure the SSC is applicable. This will verify the vehicle is involved and has not already been completed by another dealer. TMS warranty will not reimburse dealers for repairs conducted on vehicles that are not affected.

## III. PREPARATION

### A. PARTS

Parts when replacement is necessary (only one kit is needed per vehicle)

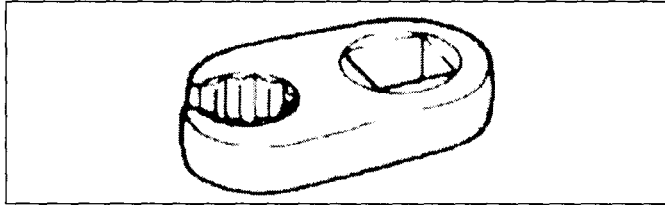
Model	Part Number	Description	Qty/ Vehicle
ECHO	04004-36152	Brake Master Cylinder/Booster Kit (with ABS) 5 Speed Manual	1
	04004-36252	Brake Master Cylinder/Booster Kit (with ABS) 4 Speed Auto	1
	04004-35852	Brake Master Cylinder/Booster Kit (w/o ABS) 5 Speed Manual	1
	04004-35952	Brake Master Cylinder/Booster Kit (w/o ABS) 4 Speed Auto	1
	00475 -1BF03	Brake Fluid	2

To assist dealers in determining the correct part number to order, a website has been set up to look up part numbers by VIN. Please go to [http://toyotamc.imagespm.info/fra\\_home.cfm](http://toyotamc.imagespm.info/fra_home.cfm) (also linked through TIS), enter the VIN, and the correct part number to order will be displayed. **The website is for part application reference only and will not order the part nor will it confirm campaign completion status.**

The actual replacement rate is expected to be between 3 to 5%. Dealers should not stock master cylinder/booster assemblies. In the event that a dealer inspects and confirms that vehicle requires master cylinder/booster assembly replacement, the necessary parts can be ordered through the dealer's facing PDC.

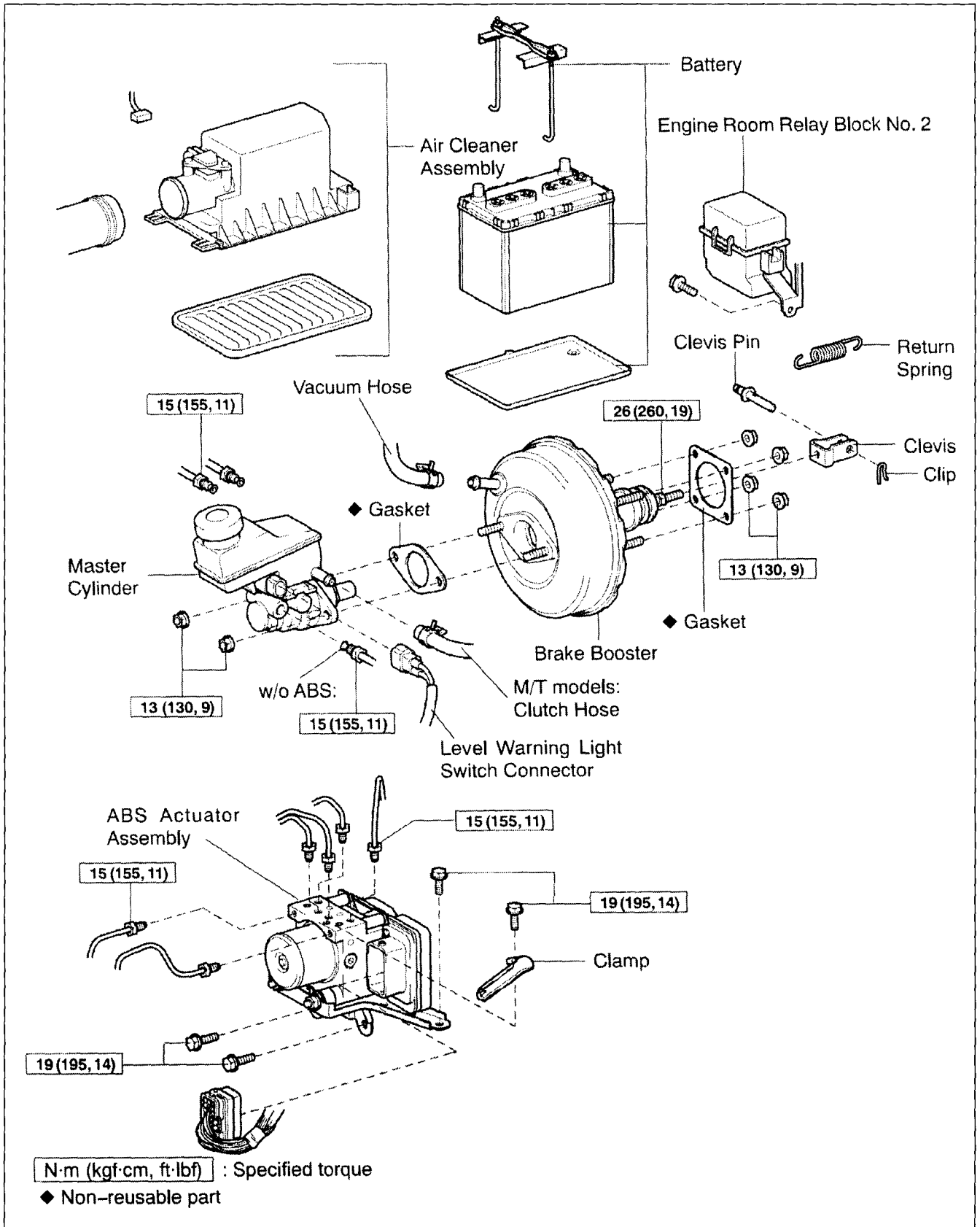
**Replaced master cylinder/brake boosters must be retained and returned as requested under the terms of the Warranty Parts Recovery policy.**

## B. TOOLS

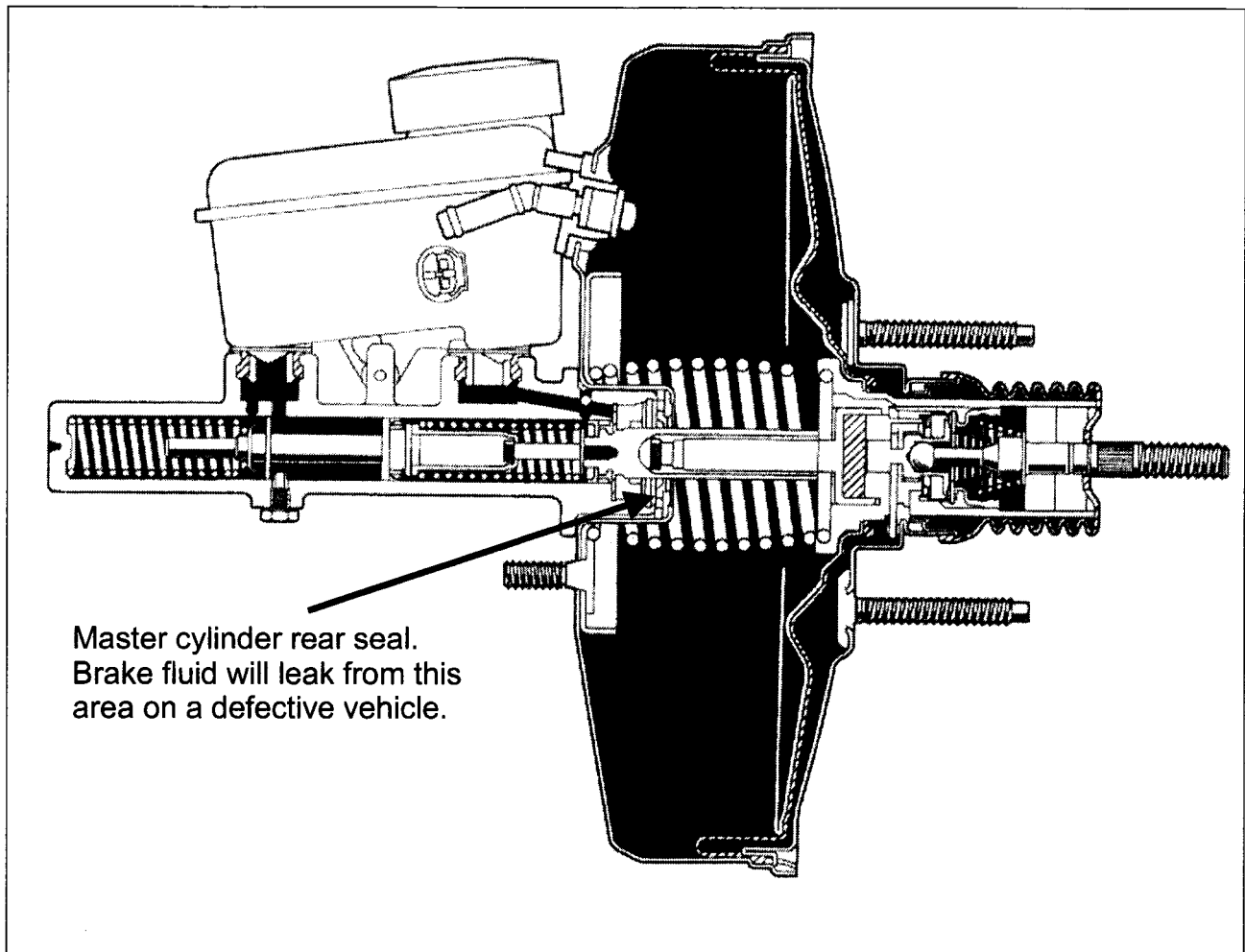


Standard Hand Tools  
Torque Wrench  
SST: 09023 – 00101 Union Nut Wrench  
(or equivalent)

# C. LOCATION

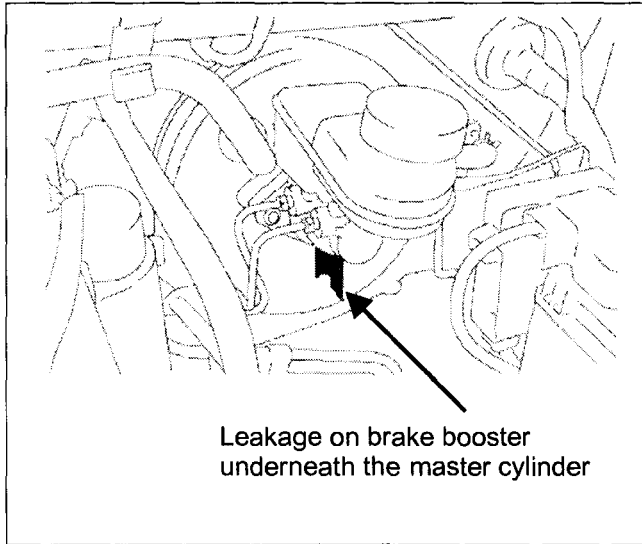


#### IV. INSPECTION



This SSC involves inspection of the rear seal of the brake master cylinder for leakage. In certain 2000 MY Celica and Echo vehicles, there is a possibility that the recess that retains a rubber seal ring, which is located at the end of the brake master cylinder, may be corroded due to an improper cleaning process. In this condition, brake fluid may leak from the seal, or a small amount of air may enter the master cylinder, which could lead to an increase of vehicle stopping distance and thus raise the possibility of a crash. While doing the inspection ensure that any signs of external leakage are not from previous overfilling or spillage of the brake fluid when refilling the reservoir. ***The brake master cylinder/brake booster assembly replacement rate is expected to be between 3 and 5%.***





**1. INSPECT BRAKE MASTER CYLINDER EXTERNALLY FOR LEAKAGE**

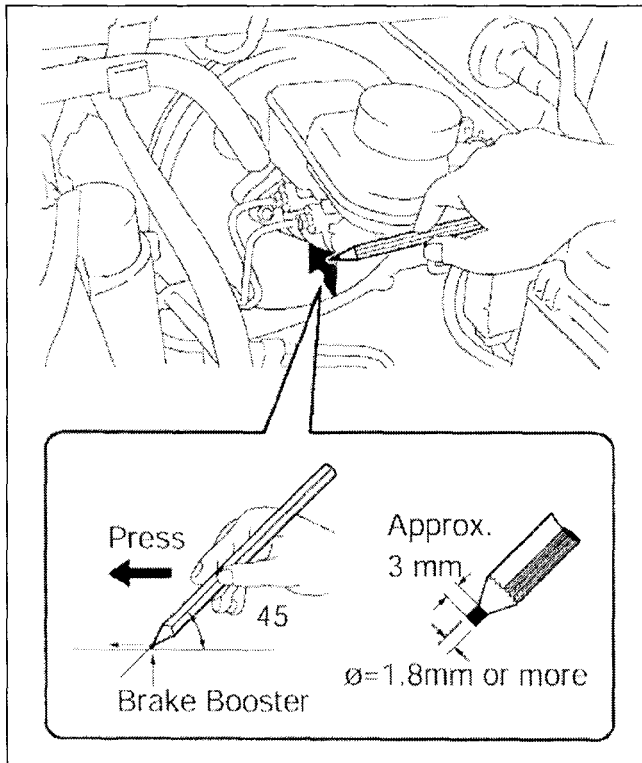
- (a) Check (visually and by feel) for fluid leakage from the master cylinder in the area shown.

If the master cylinder is leaking, it must be replaced along with the brake booster. Refer to the appropriate repair manual for replacement procedures and to page 3 for parts information. (Remember to keep the replaced master cylinder/brake booster assembly under the terms of the Warranty Parts Recovery policy)

If the master cylinder is not leaking, proceed to step 2 page 8.

**NOTE:**

**Ensure that any signs of brake fluid leakage is not a result of overfill/spillage from a previous repair.**

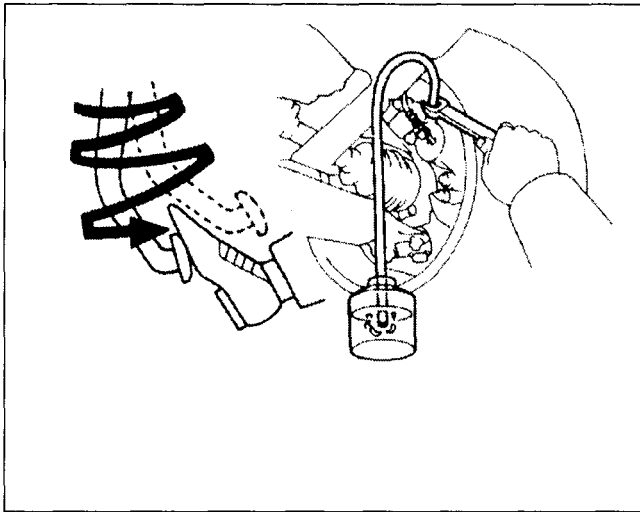


- (b) Using a sharpened pencil, as shown, check that the paint from the brake booster does not come off.

If the master cylinder is leaking, it must be replaced along with the brake booster. Refer to the appropriate repair manual for replacement procedures and to page 3 for parts information. (**Remember to keep the replaced master cylinder/brake booster assembly under the terms of the Warranty Parts Recovery policy**)

**NOTE:**

**The pencil is used as a non-abrasive tool to determine if the paint on the booster has been damaged due to leaking brake fluid.**



**2. INSPECT FOR AIR BY MANUALLY BLEEDING THE BRAKE SYSTEM.**  
**(Do not use a pressure or vacuum type brake bleeder)**

- (a) Fill the brake master cylinder reservoir.
- (b) Bleed the brake system in the following sequence to remove any air from the system.
  - 1. Right Rear
  - 2. Left Rear
  - 3. Right Front
  - 4. Left Front

If any air is found, the master cylinder and brake booster must be replaced.

***However, ensure that the any air found in the brake system is from the master cylinder. Due to the distance of the master cylinder, immediately visible air is not from the master cylinder. (Remember to keep the replaced master cylinder/brake booster assembly under the terms of the Warranty Parts Recovery policy)***

Refer to the appropriate repair manual for replacement procedures and to page 3 for parts information.

**NOTE:**

**Do not let the brake fluid level drop below minimum.**

- (c) Check and adjust brake fluid level as necessary.

**3. DETERMINE IF BRAKE BOOSTER WAS RECENTLY REPLACED**

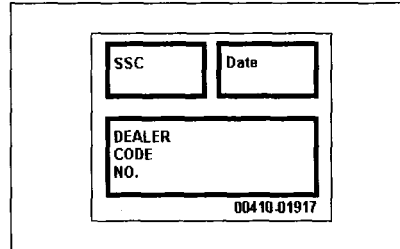
If it appears that the brake booster has been recently replaced, proceed to Appendix A, master cylinder removal and inspection.

## V. SSC COMPLETION LABEL INSTALLATION

**A.** After completing the repair and before returning the vehicle to the owner, an SSC completion label, that is enclosed in the owner's notification, must be affixed to the left front door hinge post near the check strap.

**B.** The label is to be filled out as follows:

- Write in SSC 40K.
- Write in the date of the repair.
- Write in your dealer code.



The diagram shows a rectangular label form with a border. At the top, there are two small rectangular boxes side-by-side. The left box is labeled "SSC" and the right box is labeled "Date". Below these two boxes is a larger rectangular box labeled "DEALER CODE NO.". At the bottom right corner of the label, the part number "00410-01917" is printed.

**C.** Additional SSC completion labels, in sheets of 50 (P/N 00410-01917), may be ordered through the non-parts system on a 1450 order form or through the TDN system.

# Appendix A. MASTER CYLINDER REMOVAL AND INSPECTION (IF BRAKE BOOSTER WAS RECENTLY REPLACED)

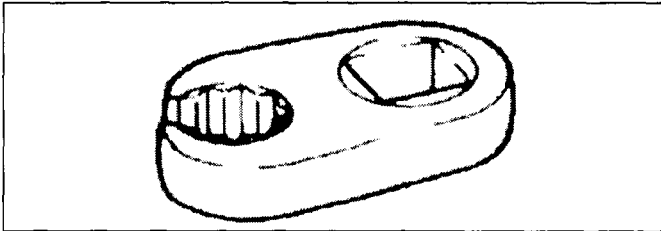
## I. PREPARATION

### A. PARTS

Parts for master cylinder inspection only

Model	Part Number	Description	Qty/ Vehicle
ECHO	47275-52010	Brake Master Cylinder Gasket	1
	00475-1BF03	Brake Fluid	2

### B. TOOLS



Standard Hand Tools  
Torque Wrench  
SST: 09023 – 00101 Union Nut Wrench  
(or equivalent)

**1. INSPECT MASTER CYLINDER FOR INTERNAL LEAKAGE FROM REAR SEAL**

- (a) Disconnect the brake fluid level sensor from the master cylinder reservoir.
- (b) Remove the brake fluid from the reservoir.
  - 1. Using a syringe, drain the reservoir.

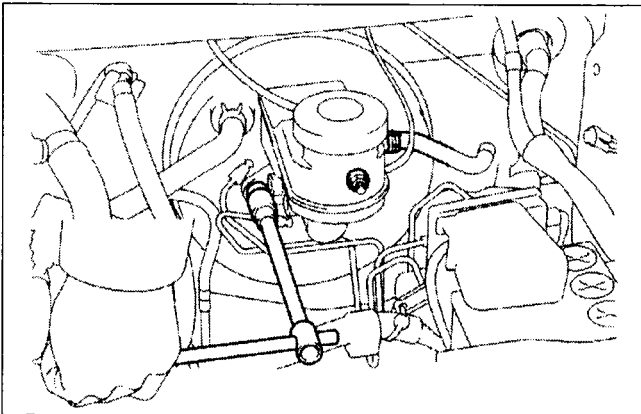
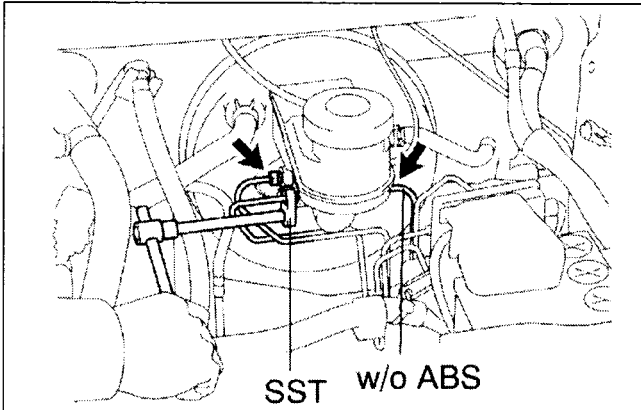
**NOTE:**

**Immediately clean off any brake fluid spilled on painted surfaces. Brake fluid will damage the vehicle's finish.**

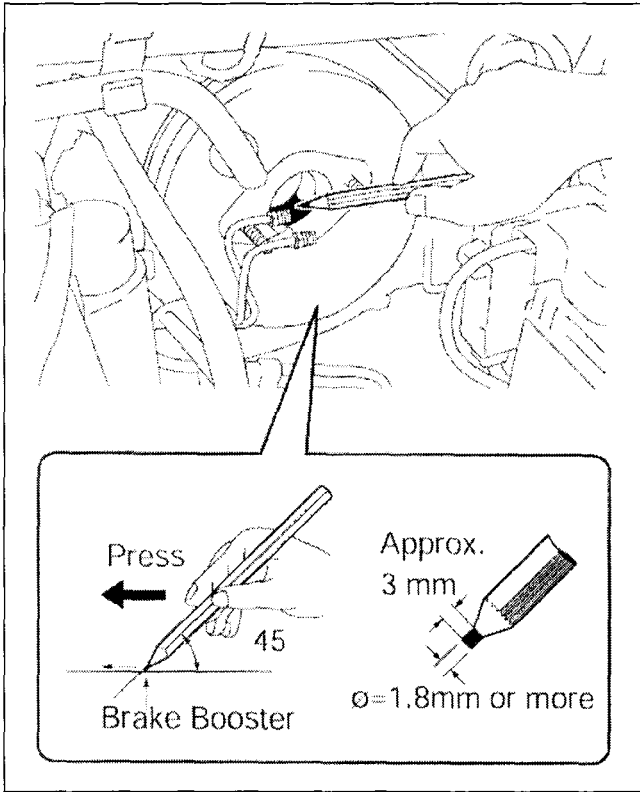
- (c) Using the SST, disconnect the brake lines.
  - 1. Disconnect the 2 (**ABS**) or 3 (**w/o ABS**) brake lines from the master cylinder.

**SST: 09023 – 00101 (or equivalent)**

- (d) Disconnect the supply hose from the clutch master cylinder to the reservoir (manual transmission vehicles).



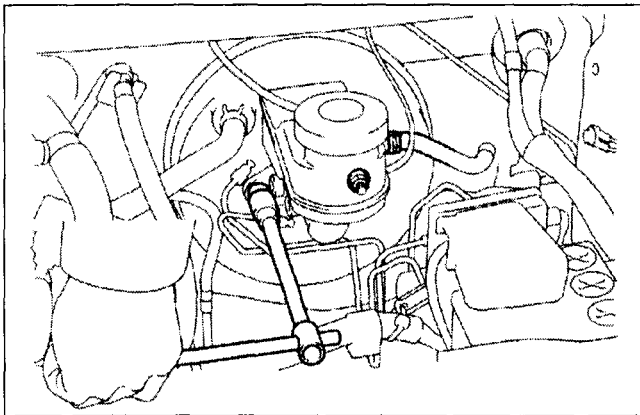
- (e) Remove the master cylinder.
  - 1. Remove the 2 nuts securing the master cylinder to the brake booster.
  - 2. Remove the master cylinder and the gasket.



- (f) Check for signs of brake fluid leakage inside the booster. Use a pencil as shown. Check that the paint does not come off the brake booster.

If the master cylinder is leaking, it must be replaced along with the brake booster. Refer to the appropriate repair manual for replacement procedures and to page 3 for parts information.

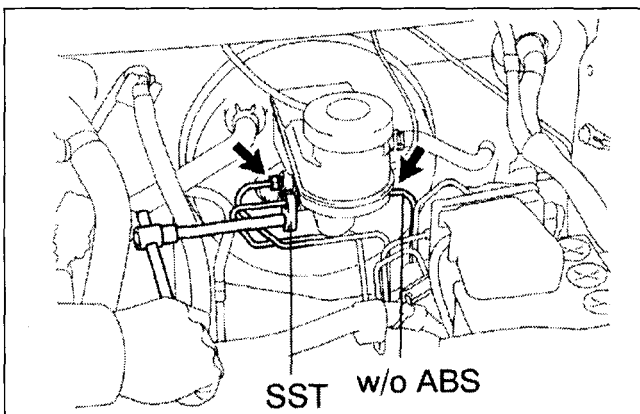
**If the master cylinder is not leaking, proceed to step 2, REINSTALL THE MASTER CYLINDER.**



## 2. REINSTALL THE MASTER CYLINDER

- (a) Install a new gasket onto the brake booster.  
 (b) Reinstall the master cylinder.

**TORQUE: 13 N•m (130 kgf•cm, 9 ft•lbf)**

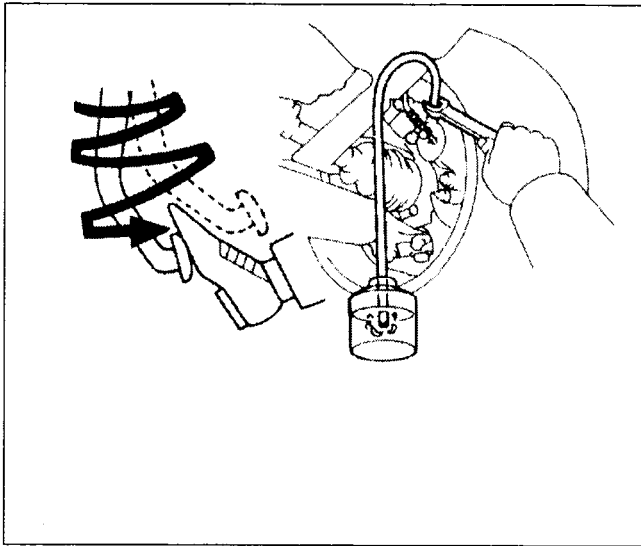


- (c) Reconnect the 2 (ABS) or 3 (w/o ABS) brake lines to the master cylinder using SST.

**SST 09023-00101**

**TORQUE: 15 N•m (155 kgf•cm, 11 ft•lbf)**

- (d) Reconnect the supply line for the clutch master cylinder to the reservoir.  
 (manual transmission vehicles)



### 3. BLEED THE BRAKE SYSTEM.

- (a) Fill the brake master cylinder reservoir.
- (b) Bleed the brake system in the following sequence to remove any air from the system.
  1. Right Rear
  2. Left Rear
  3. Right Front
  4. Left Front

**NOTE:**

**Do not let the brake fluid level drop below minimum.**

- (c) Check and adjust brake fluid level as necessary.

## SSC COMPLETION LABEL INSTALLATION

**A.** After completing the repair and before returning the vehicle to the owner, an SSC completion label, that is enclosed in the owner's notification, must be affixed to the left front door hinge post near the check strap.

**B.** The label is to be filled out as follows:

- Write in SSC 40K.
- Write in the date of the repair.
- Write in your dealer code.

SSC	Date
DEALER CODE NO.	
00410-01917	

**C.** Additional SSC completion labels, in sheets of 50 (P/N 00410-01917), may be ordered through the non-parts system on a 1450 order form or through the TDN system.