

TECHNICAL INSTRUCTIONS
FOR
SAFETY RECALL G0P
FRONT PASSENGER AIRBAG INFLATOR MODULE
CERTAIN 2009 – 2013 MODEL YEAR COROLLA

Updated 1-9-18

Update 1-9-18

- **2013 MY added**

Update 11-2-17

- **2012 MY added**

Update 8-31-17

- **2011 MY added**

Update 06-02-17

- **2010 MY added**

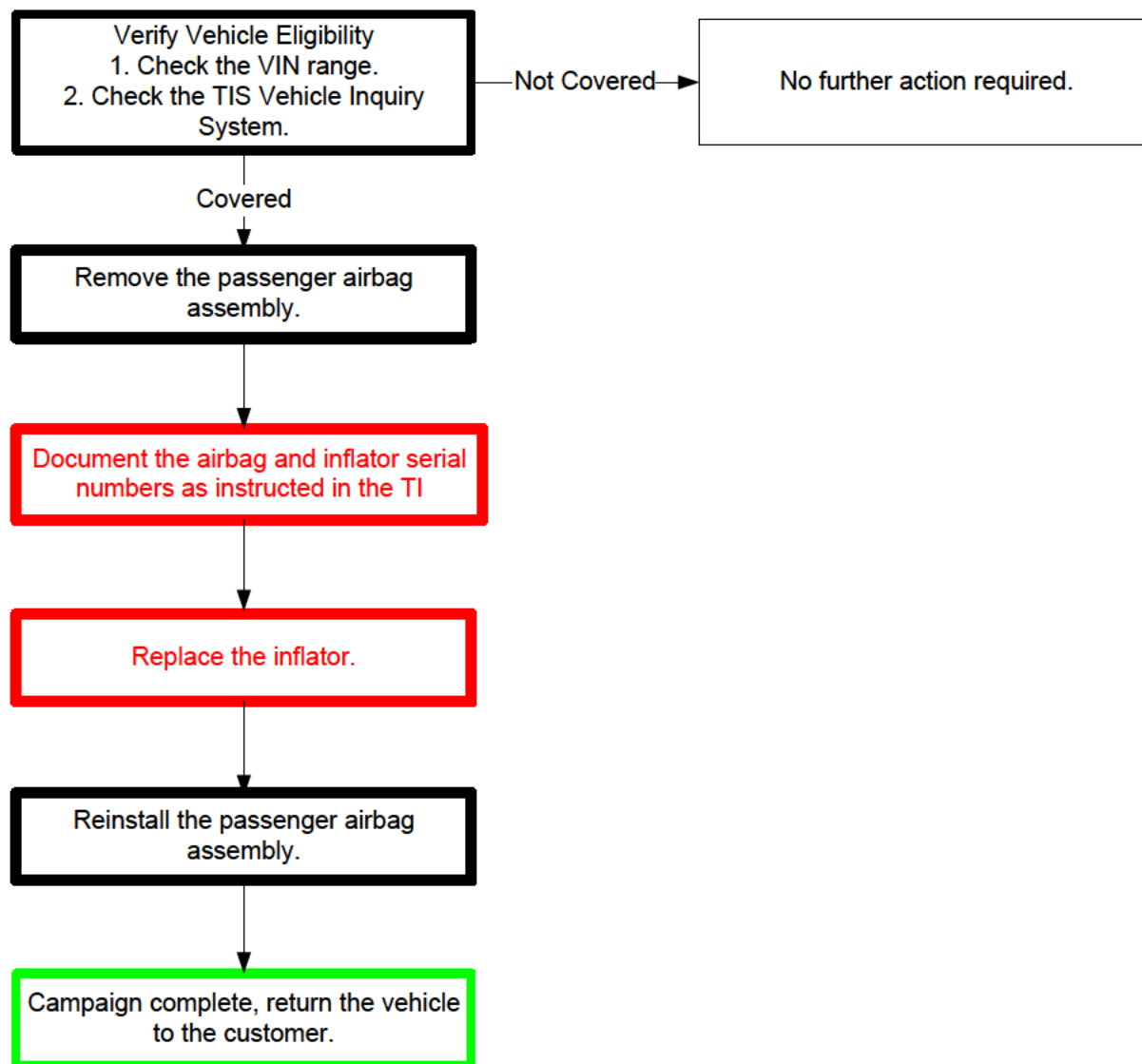
The repair quality of covered vehicles is extremely important to Toyota. All dealership technicians performing this repair are required to successfully complete the most current version of the E-Learning course “Safety Recall and Service Campaign Essentials”. To ensure that all vehicles have the repair performed correctly; technicians performing this repair are required to currently hold at least one of the following certification levels:

- Toyota Expert (Electrical)
- Master
- Master Diagnostic Technicians

Always check which technicians can perform the recall remedy by logging on to <https://www.uotdealerreports.com>. It is the dealership’s responsibility to select technicians with the above certification level or greater to perform this repair. Carefully review your resources, the technician skill level, and ability before assigning technicians to this repair. It is important to consider technician days off and vacation schedules to ensure there are properly trained technicians available to perform this repair at all times.

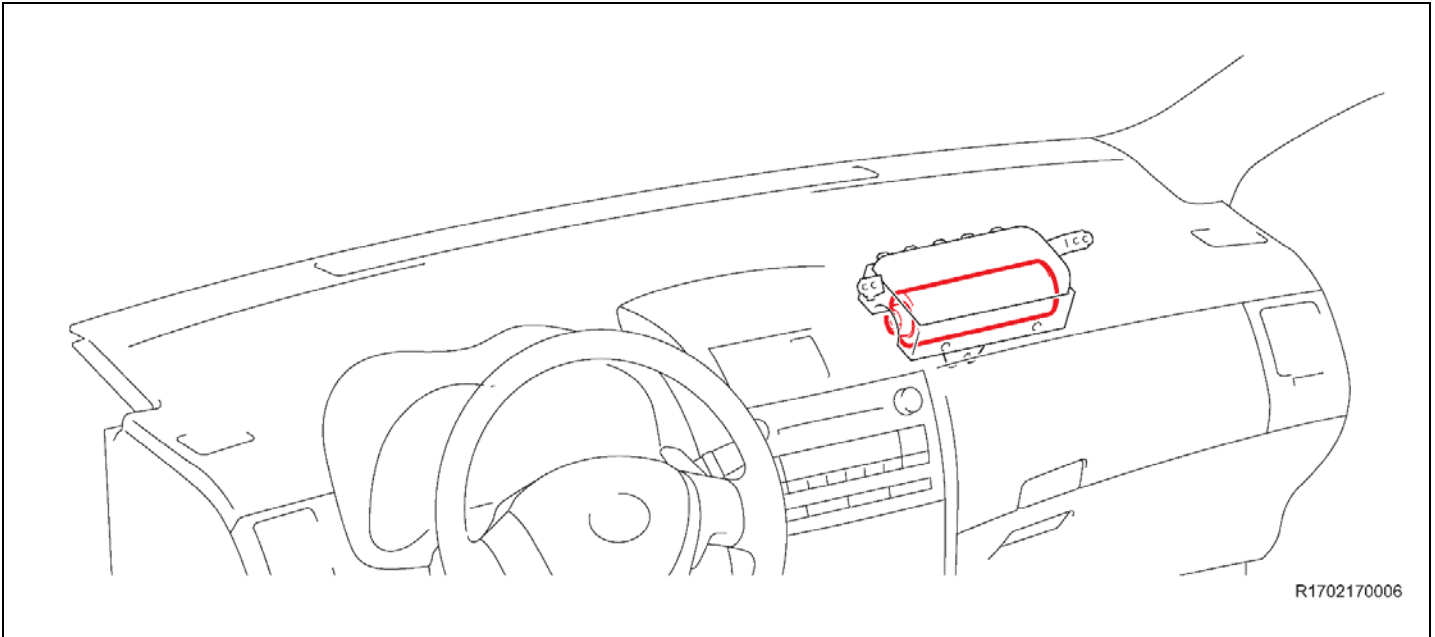
I. OPERATION FLOW CHART

The flow chart is for reference only. **DO NOT** use it in place of the full technical instructions. Follow **ALL** steps as outlined in the full technical instructions to confirm the campaign is completed correctly.



II. BACKGROUND

The subject vehicles are equipped with front passenger airbag inflators produced by Takata. The propellant in these inflators may degrade after prolonged exposure to high absolute humidity and fluctuating high temperatures. Degraded propellant can cause inflator rupture during airbag deployment. In the event of an inflator rupture, metal fragments could pass through the airbag cushion material, striking the vehicle occupants, and result in serious injury or death.



III. IDENTIFICATION OF AFFECTED VEHICLES

- Check the TIS Vehicle Inquiry System to confirm the VIN is involved in this Safety Recall, and that the campaign 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 or were completed by another dealer.**

IV. PREPARATION

A. PARTS

Part Number	Part Description	Quantity
04007-06512	Instrument Panel Airbag Inflator Kit*	1
*The kit above includes the following parts.		
	Inflator	1
	Self Locking Nut	5
	Position Determining Plate	1

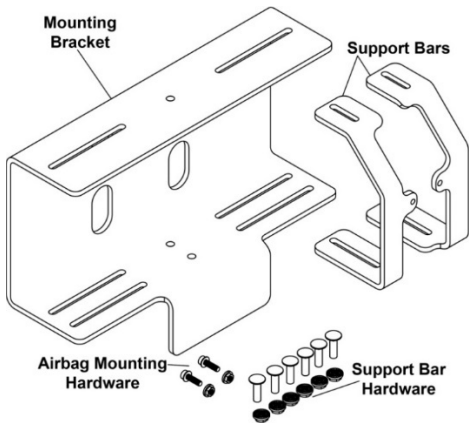
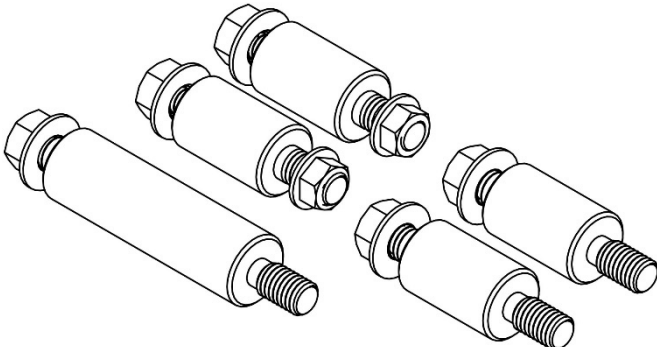
For vehicles equipped with curtain shield airbags

Part Number	Part Description	Quantity
04006-66108	Clip Kit*	1
* The kit above includes the following parts.		
Part Number	Part Description	Quantity
	Front Pillar Garnish Clip	2

B. TOOLS & EQUIPMENT

- Standard hand tools
- Torque wrench
- Techstream
- Molding remover set

D0F CAMPAIGN TOOLS – These tools were previously provided to the dealership for campaign D0F. These tools are required when performing this repair.

Image	Name	Quantity
	Airbag Mounting Bracket & hardware	1
	Adaptor set*	1

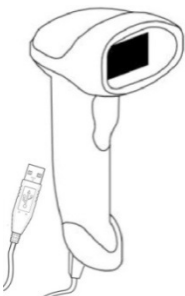
*The adaptor set was sent to dealers at the start of this campaign.

OPTIONAL SST – This is an essential special service tool that the dealership should have. However, this tool is not mandatory when performing this repair.

Part Number	Part Name	Quantity
09890-47010-01	Anti-Static Mat Set	1

F0J CAMPAIGN TOOLS – This tool was provided to the dealership for campaign F0J and will be used for this campaign also. This tool is required when performing this repair.

NOTE: The scanner for F0J must be used, because it has the capability to scan bar and QR codes.

Image	Name	Quantity
	Barcode Scanner	1

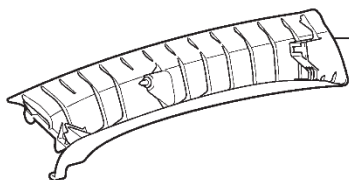
NOTE: This tool CANNOT be ordered through the parts or tools system. If additional tools are needed, they can be sourced locally.

V. COMPONENTS

w/ Curtain Shield Airbag:



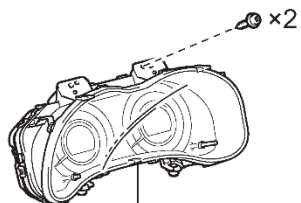
w/ Curtain Shield Airbag:



FRONT PILLAR GARNISH LH



FRONT PILLAR GARNISH RH



COMBINATION METER ASSEMBLY



INSTRUMENT CLUSTER
FINISH PANEL ASSEMBLY

CENTER INSTRUMENT PANEL
REGISTER ASSEMBLY



INSTRUMENT PANEL
FINISH PANEL END LH



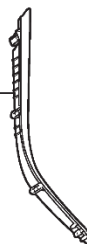
INSTRUMENT PANEL
FINISH PANEL END RH



LOWER INSTRUMENT
PANEL FINISH PANEL LH

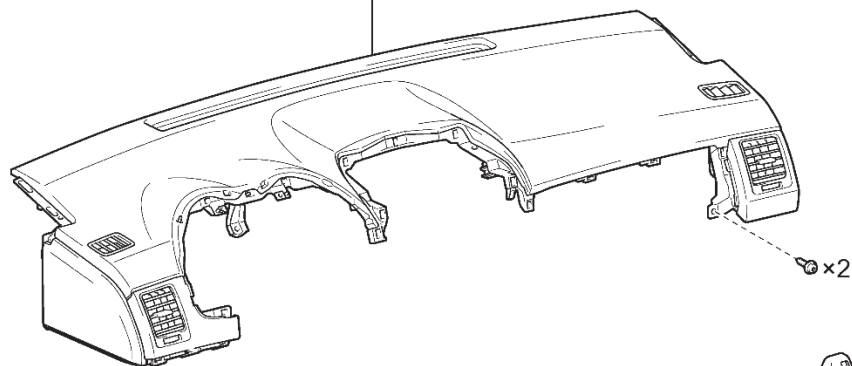
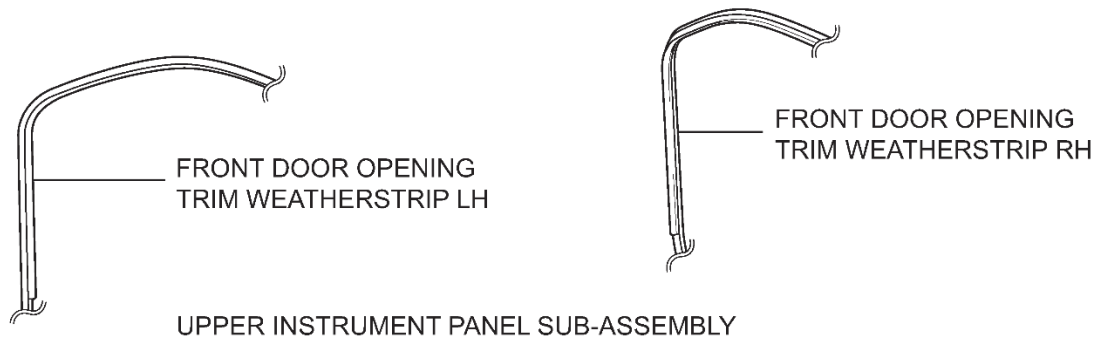


LOWER INSTRUMENT
PANEL FINISH PANEL RH

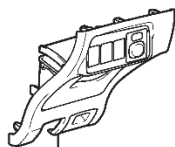


● : Replacement part

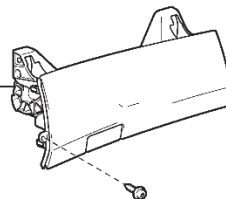
R1702170004



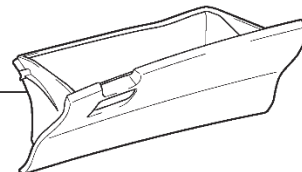
No. 1 INSTRUMENT PANEL BOX DOOR SUB-ASSEMBLY



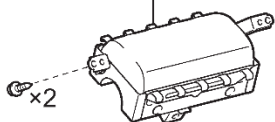
LOWER INSTRUMENT PANEL FINISH PANEL ASSEMBLY



GLOVE COMPARTMENT DOOR ASSEMBLY



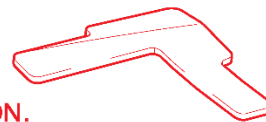
FRONT PASSENGER AIRBAG ASSEMBLY



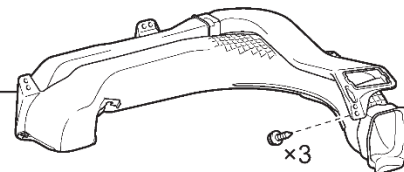
20 (204, 15)

for TMC Made:

BE CAREFUL!
DO NOT remove the
 No. 4 INSTRUMENT PANEL CUSHION.

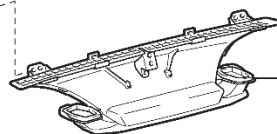


No. 3 HEATER TO REGISTER DUCT



x3

DEFROSTER NOZZLE ASSEMBLY

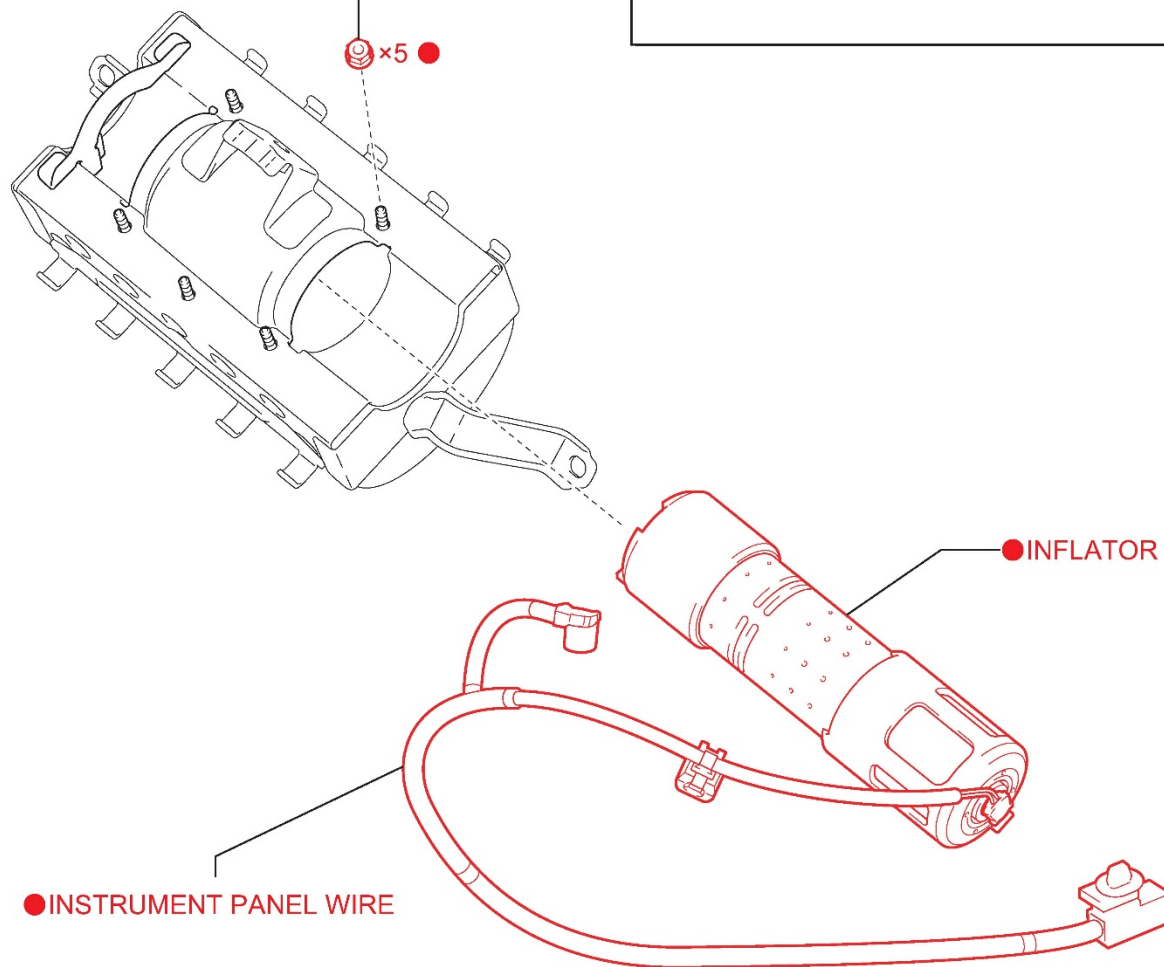


N*m (kgf*cm, ft.*lbf) : Specified torque

R1702170005

3.9 N·m (40, 35 in.*lbf)
Be careful not to
overtighten.

for COROLLA:



● : Replacement part

R1702270035

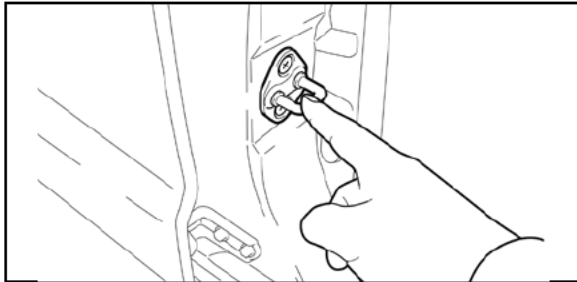
VI. SAFETY PRECAUTIONS



CRITICAL INFORMATION – READ THOROUGHLY

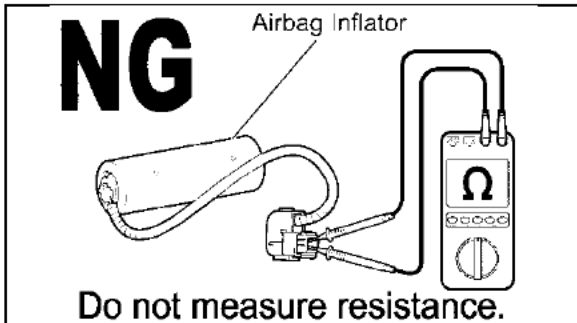


Failure to follow these procedures correctly could cause the SRS to unexpectedly deploy during servicing or the SRS may fail to operate correctly when required after reassembly. Confirm all work is performed as described in these instructions.



1. ELIMINATE STATIC ELECTRICITY

- a) Before starting work and periodically while working on the vehicle, touch a metallic part of the vehicle to discharge static electricity in the body.



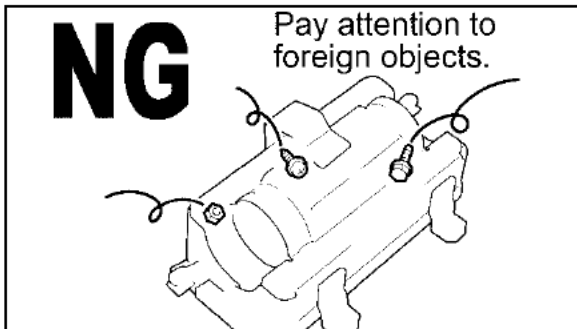
2. DO NOT MEASURE RESISTANCE

- a) **DO NOT** measure resistance of airbag components, this may cause accidental activation.



3. HANDLE THE AIRBAG CAREFULLY

- a) If an inflator is dropped, replace it with a **NEW** inflator.



4. DO NOT ALLOW FOREIGN OBJECTS NEAR AIRBAG

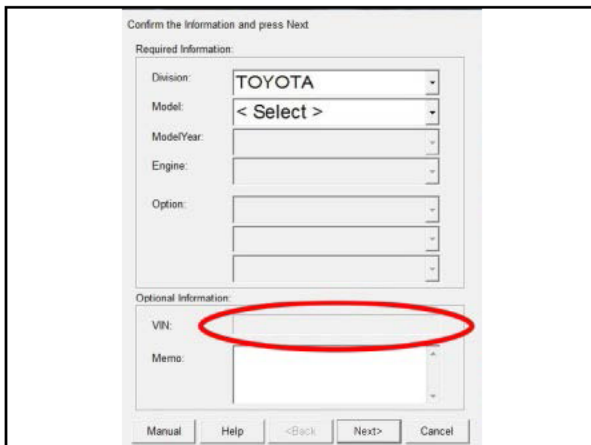
- a) Be sure to collect and account for all removed nuts/bolts to prevent them from landing in the airbag assembly.
- b) Any foreign objects in the airbag assembly may cause damage or injury if the airbag is activated.



5. WEAR PROTECTIVE EQUIPMENT

- a) Always wear appropriate protective equipment when working on the SRS.

VII. SRS SYSTEM HEALTH CHECK



1. PERFORM A HEALTH CHECK

- Confirm the Techstream is connected to the dealership's internet.
- When launching the Techstream software the VIN **MAY NEED** to be entered manually depending upon model year.

NOTE: All letters of the VIN **MUST** be entered in **ALL CAPS**, or the VIN will need to be reentered when running the diagnostic report.

- Perform a health check.



- The VIN **MAY NEED** to be entered manually in **ALL CAPS** when launching the Techstream software, the VIN **MAY OR MAY NOT** auto-populate due to model year.
- The serial number recording application will be disabled and the repair cannot be completed if a health check and diagnostic report is not performed and recorded by TMS.

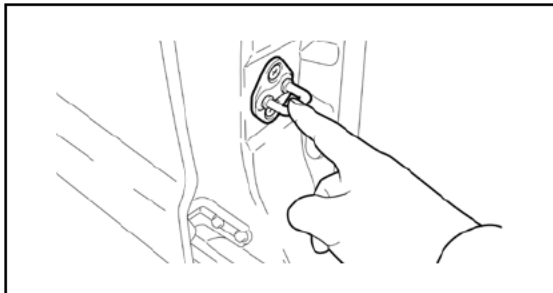
VIII. WORK AREA PREPARATION



CRITICAL INFORMATION – READ THOROUGHLY



The anti-static mat set that is an essential SST may be available at your dealership and is optional to use during inflator replacement. If the anti-static kit is not available, before starting work and periodically while working on the vehicle, touch a metallic part of the vehicle to discharge static electricity in the body.



If the anti-static kit is not available, before starting work and periodically while working on the vehicle, touch a metallic part of the vehicle to discharge static electricity in the body.

IX. PASSENGER AIRBAG INFLATOR REPLACEMENT

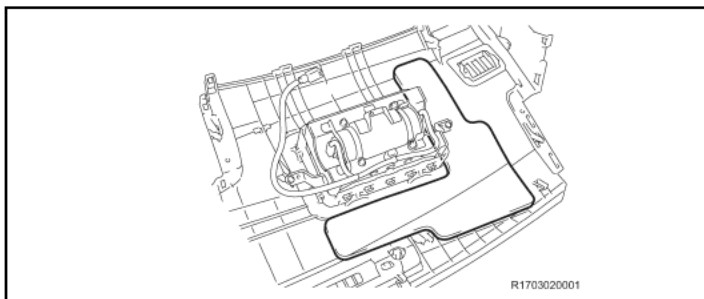
1. REMOVE THE AIRBAG ASSEMBLY



- Wait at least 90 seconds after disconnecting the cable from the negative battery terminal to prevent airbag and seat belt pre-tensioner deployment.
- Follow all precautions as outlined on TIS before servicing the SRS system.

a) Refer to TIS for instructions on airbag removal:

[2009 MY](#) [2010 MY](#) [2011 MY](#) [2012 MY](#) [2013 MY](#)



NOTE: For TMC made Corolla only (VIN starts with JT). Do not remove the No. 4 instrument panel cushion.

2. LAUNCH THE SERIAL NUMBER RECORDING APPLICATION



- The **AIRBAG ASSEMBLY**, **ORIGINAL INFLATOR**, and **NEW INFLATOR** serial numbers **MUST** be recorded using the barcode scanner (provided at the launch of SSC F0J).
- The barcode scanner application **MUST** be completed on every vehicle. These numbers **MUST** be included on every warranty claim that is submitted for inflator module replacement or the claim may be subject to debit.
- The technician performing the work **MUST** have valid TIS login credentials and an internet connection to perform the inspection and scanning process.

- a) Log in to TIS and input the VIN of the vehicle in the Vehicle Inquiry tab.
- b) Confirm the VIN is applicable and that the campaign has not been completed.
- c) Click on the link to launch the serial number recording application.

Vehicle Identification Number Search

Enter a 17 Digit VIN below to search for applicable information:

VIN: 1NX-BA32E-000000000

Vehicle Information

Division: TOYOTA	Model: Corolla	Grade: CE	Model Year: 2003
Drive Type: 2WD	Body Type: 4Dr. Sedan	Engine Family: 4-cylinder - 1ZZ	Transmission:
Date of First Use:	Production Date: 01/18/2002	Plant Code: Z - FREMONT PLANT - NUMMI	
VIN: 1NX-BA32E-000000000		Standard Equipment: Click here to display	
Exterior Color: 03M5, SANDRIFT METALLIC		Interior Color: FA41, FA41	
		Interior Trim Color: FA, *	Interior Fabric: F, *

Vehicle accessories are not currently available. Try your query again later.

Service Campaign

Campaign Description: Safety Recall DOF Remedy Notice - 2003-2004 Model Year Corolla, Corolla Matrix, Sequoia, and Tundra Vehicles, 2002-2003 Model Year

Completion Status: **Not Complete** [Check applicability for VIN](#)

[\[Show Documents\]](#) [E04](#)

d) Reenter TIS password in the serial number recorder application.

NOTE: The person logged-in to TIS **MUST** be the person performing the repair.

Front Passenger Airbag Inflator Module - Safety Recall

SSC - DSF

User ID: Suzuki
Dealer Code: 123456789
Time: 06/10/2014 02:07 PM PDT
Original Inflator Serial #:

Technician Name: Russell
Dealer Name: 123456789
Airbag Serial #:
Replacement Inflator Serial #:

VIN: 1NX-BA32E-000000000

Task	Dealer	User	Time	Status
Airbag # Record				Not Started
Inflator # Record				Not Started
Check & Conditions				Not Started
See Airbag #				Not Started

e) Record the vehicle mileage into the serial number recording application.

NOTE:

- A task status screen will populate next and at other intervals during the repair. This screen will indicate if the inflator was replaced or in some limited cases that the entire airbag assembly was replaced. Click 'next' to proceed to the next step. This information will be used for record keeping by TMS.
- If this screen indicates that the inflator has already been replaced on this VIN, there is no need to perform the campaign again.

3. CONNECT THE BARCODE SCANNER

a) Connect the barcode scanner to the USB port on the Techstream.

b) The scanner will automatically connect and a beep will be heard when the scanner is ready.

NOTE:

- Use the scanner that was provided for SSC F0J. The scanner for F0J is needed due to its ability to read bar and QR codes.
- The scanner works best in low light conditions.
- Always hold the scanner directly in front of and parallel to the barcode label.

4. SCAN THE AIRBAG SERIAL NUMBER

- a) Scan the **AIRBAG ASSEMBLY** serial number 2 times.
 - 1) Confirm the cursor is in the first serial number box then scan the serial.
 - 2) Position the cursor in the second serial number box then scan the serial.
- b) Click next.

NOTE:

- If both serial numbers that are entered do not match, confirm and reenter.
- If the serial number barcode will not scan, it can be entered manually.

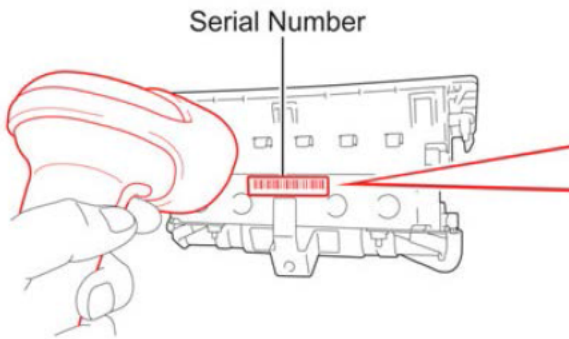
AIRBAG SERIAL NUMBER IDENTIFICATION

- The airbag serial number is **ALWAYS** the 12 **DIGITS** located between the asterisks.
- The 3 digits before the asterisk **ARE NOT** part of the serial number, and **SHOULD NOT** be entered or an inaccurate response may be returned.

Airbag Serial Number Label Example



The **AIRBAG ASSEMBLY** serial number and the **INFLATOR** serial number are **DIFFERENT**. The **AIRBAG ASSEMBLY** serial number **MUST** be recorded prior to replacement.



 A screenshot of a web browser showing a Toyota Safety Recall page. The page title is "Front Passenger Airbag Inflator Module - Safety Recall". The page includes fields for "User ID", "Dealer Code", "VIN", and "Record Airbag Serial Number". The "Record Airbag Serial Number" section has two input fields: "Airbag Assembly Serial Number" and "Reconfirm Airbag Assembly Serial Number". The VIN field is populated with "STD 8744A" and "2003 Sequoia BEIGE H. M.". The page also includes a warning: "Airbag Assembly Serial Numbers do not match. Please check and enter the serial numbers once again."

AIRBAG SERIAL NUMBER IS MISSING OR IS UNREADABLE



If the airbag serial number and barcode are not legible or are not present, check the box in the application indicating the serial number is not legible and contact your regional representative.

- a) If the airbag serial number is unreadable or not present check the box as shown below.

Front Passenger Airbag Inflator Module - Safety Recall
SSC - DSF

1 2 3 4 5

User ID: SuzukiR Technician Name: Russell
Dealer Code: Dealer Name:
Time: 06/12/2014 03:43 PM PDT

VIN: 1NX BR32E 00000000 (2003 Corolla, Beige)

Record Airbag Serial Number

Use of a barcode scanner is strongly recommended when entering Airbag Assembly Serial Number.
If manually typing serial number, you MUST include all leading zeros. (If applicable)

* Airbag Assembly Serial Number:
* Reconfirm Airbag Assembly Serial Number:

If original Airbag Assembly serial number is not visible or missing, check this box: ☒

Please contact Region for further information

(*) - Indicates Required Field(s)

Back Next

- b) After the Region approves the Airbag Assembly replacement and the new part is received, record the NEW airbag serial number in the Serial Number Recording Application.

Front Passenger Airbag Inflator Module - Safety Recall
SSC - DSF

1 2 3 4 5

User ID: SuzukiR Technician Name: Russell
Dealer Code: Dealer Name:
Time: 06/12/2014 03:43 PM PDT

VIN: 1NX BR32E 00000000 (2003 Corolla, Beige)

Record Airbag Serial Number

Use of a barcode scanner is strongly recommended when entering Airbag Assembly Serial Number.
If manually typing serial number, you MUST include all leading zeros. (If applicable)

* New Airbag Assembly Serial Number:

(*) - Indicates Required Field(s)

Next



The new **AIRBAG ASSEMBLY** serial number **MUST** be recorded prior to reinstallation to track the airbag assembly to the vehicle.

X INFLATOR REPLACEMENT

1. WORKING WITH AN AIRBAG

- Carefully place the airbag on the bench inflator side up.

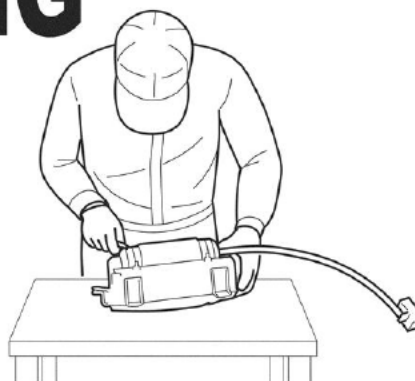
NOTE: Place clean sheet(s) of paper on the bench to protect the airbag.

- Avoid standing directly over the inflator.

OK



NG



* Images of parts shown above may differ from the actual ones.

R1301230008E

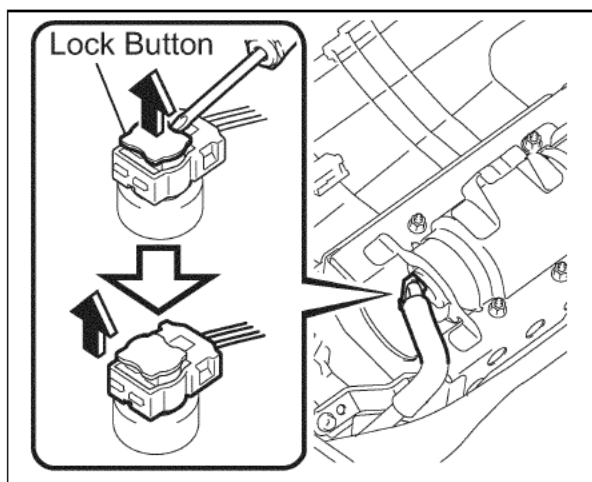
STOP

CRITICAL INFORMATION – READ THOROUGHLY

STOP



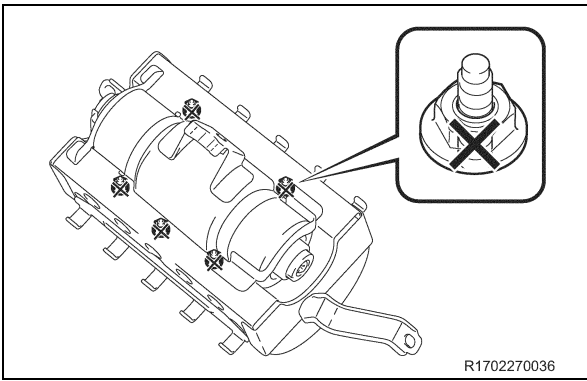
Remember to periodically touch a metallic part of the vehicle to discharge static electricity in the body if the anti-static kit is not being used.



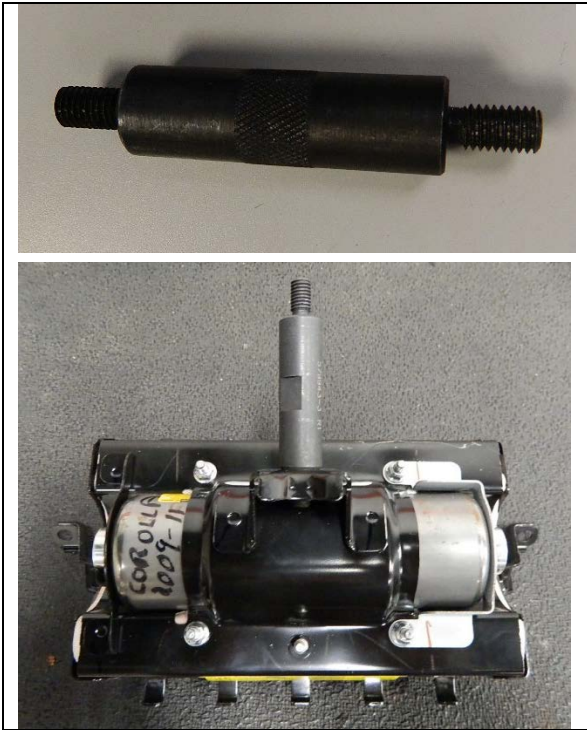
2. AIRBAG PREPARATION

- Use a screwdriver to release the lock button.
- Disconnect the connector.
- Disconnect the wire harness clamps.

NOTE: Disconnect the connector where the fixed stop plate is located.



d) Mark all 5 nuts so they will not be reused.

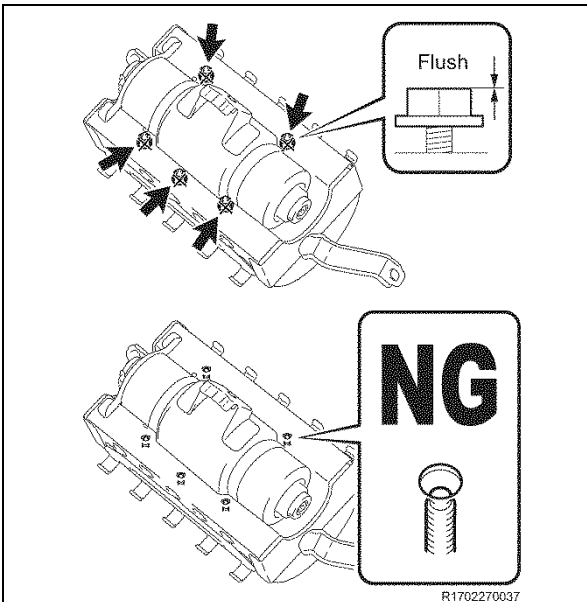


e) Use the long adaptor shown.

f) Thread the adaptor into the airbag as shown.
Note: Use the same mounting nut on the airbag that attaches the airbag to the vehicles cross tube.

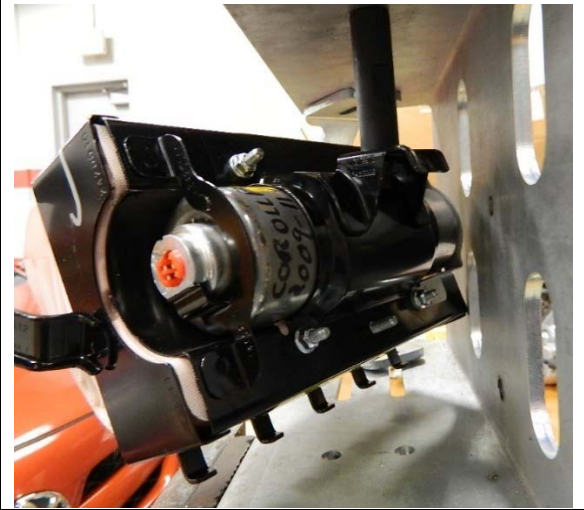


- g) Mount the airbag into the mounting bracket as shown. Pass the stud on the adaptor through the hole, on the top in the middle of the bracket, and secure with the nut.

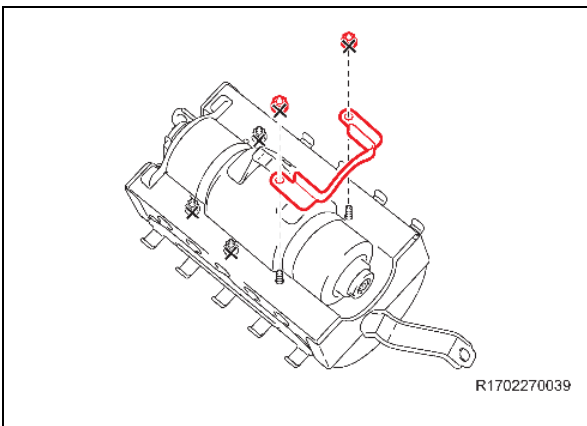


3. REMOVE THE SELF LOCKING NUTS

- a) Loosen the 5 nuts until the nuts are at the top of the studs as shown, through the openings in the mounting bracket.



Note: The airbag may need to be turned to the left or right to access the center nut.



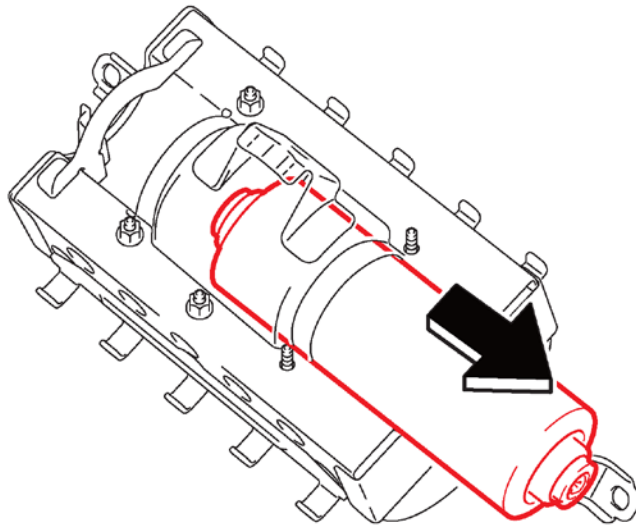
- b) Remove the 2 nuts on the end where the bracket is removable.
- c) Remove the bracket and discard.
- d) Reinstall the 2 nuts, until the nut is flush with the top of the stud.

NOTE:

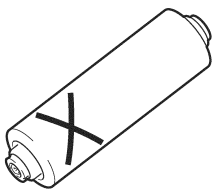
- **DO NOT** use power tools.

4. REMOVE THE INFLATOR

- a) Gently push in the studs until the nuts make contact with the housing to loosen the inflator for removal.



R1702270038



R1701240008

- b) Remove the inflator from the airbag assembly and place it on a safe work surface.
c) Mark the old inflator so it is not reused.

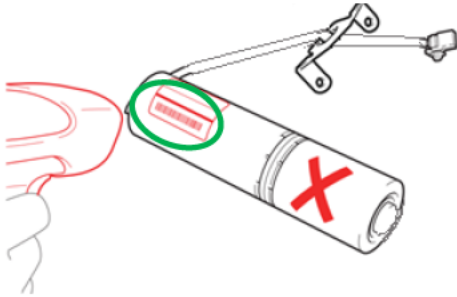
5. SCAN THE OLD AND NEW INFLATOR SERIAL NUMBER

- Scan the **OLD** inflator bar code.
- Scan the **NEW** inflator QR code.

NOTE: This information is **CRITICAL**

- It is recorded by TMS to trace the return parts shipment.
- It is used to track the new inflator that is being installed on the vehicle.

Step a) Old Inflator (bar code)



Step b) New Inflator (QR code)



- Confirm agreement by checking the two boxes.
- Record the Warranty Authorization # to be included in the warranty claim.
- Place the old inflator in the parts box and return it immediately to the parts department.

NOTE:

- Confirm the cursor is in the correct serial number input box before scanning.
- If the serial number barcode will not scan, it can be entered manually.
- If there are any difficulties or concerns with this process, email quality_compliance@toyota.com with details.

Step c)

T3 = SuzukiR - Google Chrome
t3qa.tms.toyota.com/t3Portal/portlets/tis/airBag/AirBagController.portlet?...nfpb=true&_windowLabel=Standalc

Front Passenger Airbag Inflator Module - Safety Recall

SSC - DSF

User ID: SuzukiR Technician Name: Russell
Dealer Code: Dealer Name:
Time: 06/10/2014 05:25 PM PDT Airbag Serial #: *****96
VIN: STD BT44A [2003 Sequoia BEIGE H. M.]

Inflator Module replacement IS REQUIRED on all vehicles under the Safety Recall. Follow the technical instructions and acknowledge the following statements.

If manually typing serial number, you MUST include all leading zeros. (if applicable)

Original Inflator Serial #:
If old inflator serial number is not visible or missing, check this box. ☐
Replacement Inflator Serial #:

If you have a concern with the inflator serial numbers, please email quality_compliance@toyota.com with details.

☒ * I agree to complete the safety recall's remaining technical instructions.
☒ * I agree to perform a vehicle Health Check with Techstream upon completion of the safety recall's technical instructions.

(*) - Indicates Required Frequency

Back Clear Submit

Step d)

T3 = SuzukiR - Google Chrome
t3qa.tms.toyota.com/t3Portal/portlets/tis/airBag/AirBagController.portlet?...nfpb=true&_windowLabel=Standalc

Front Passenger Airbag Inflator Module - Safety Recall

SSC - DSF

User ID: SuzukiR Technician Name: Russell
Dealer Code: Dealer Name:
Time: 06/10/2014 05:13 PM PDT Airbag Serial #: *****96
Original Inflator Serial #: A4EL5110212 Replacement Inflator Serial #: A4EL5110213

SuzukiR has agreed to the following terms and conditions on 06/10/2014 05:13 PM PDT

☒ * I agree to complete the safety recall's remaining technical instructions.
☒ * I agree to perform a vehicle Health Check with Techstream upon completion of the safety recall's technical instructions.

Russell SuzukiR has successfully confirmed completion of Airbag Inflator Module Safety Recall for

VIN - STD BT44A [2003 Sequoia BEIGE H. M.]

Warranty Authorization #: b5511e9f

Airbag inflator module has replaced under this safety recall.

Print this page for your records and then click 'Close' to resume working.

Close

6. INSTALL THE NEW INFLATOR

a) Carefully slide the new inflator into the airbag assembly and align as shown.

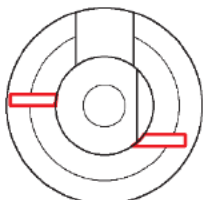


- DO NOT** connect the inflator harness at this time. It is **CRITICAL** to first confirm that the inflator is installed in the correct position before connecting the harness.

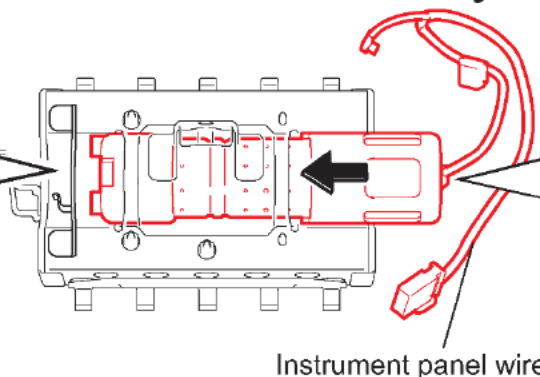
DO NOT insert fully.

Check orientation

Upper side



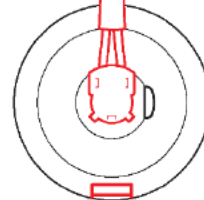
Bottom



Instrument panel wire

Check orientation

Upper side



Bottom

R1702270040

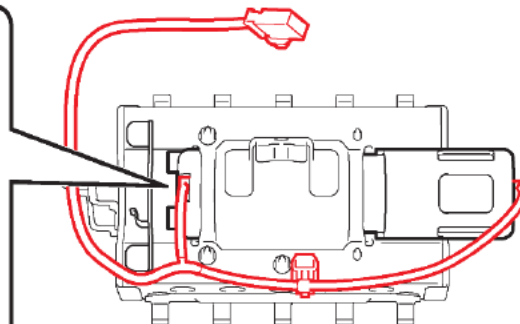
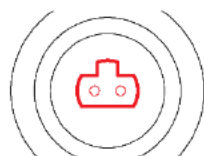
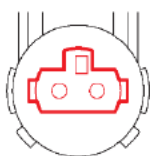
b) Connect the connector to the inflator and ensure that the connector lock is fully engaged as shown.

c) Route and secure the wire harness as shown.

ALIGN CONNECTORS

Wire Harness Side:

Inflator Side:

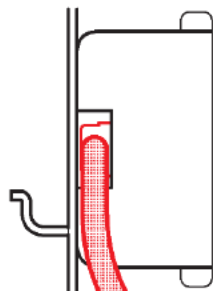


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d) Fully insert the inflator and ensure that the inflator is correctly oriented as shown.

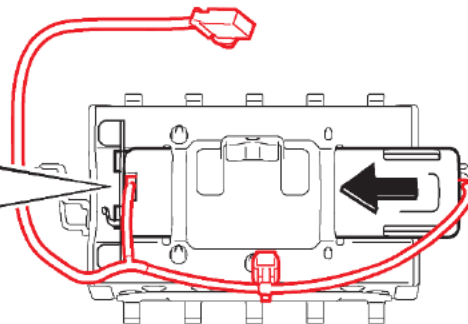
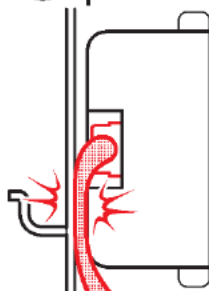
NOTE: DO NOT pinch the wiring between the bracket and the inflator.

OK

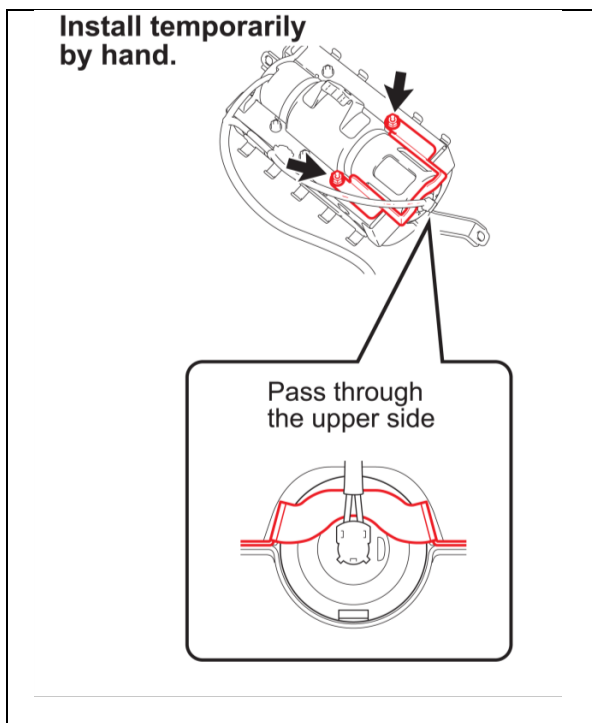
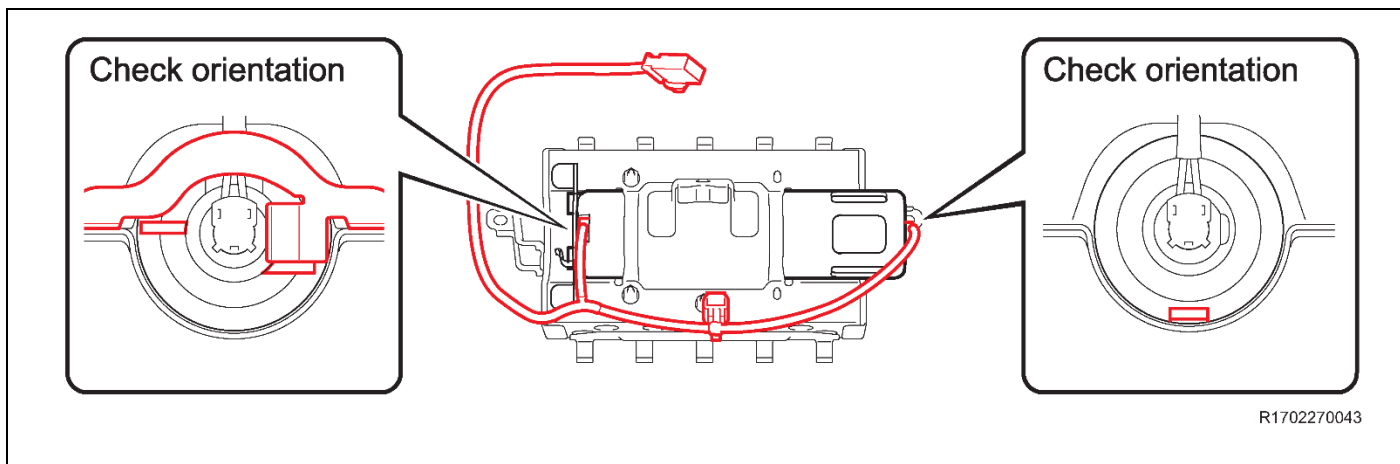


NG

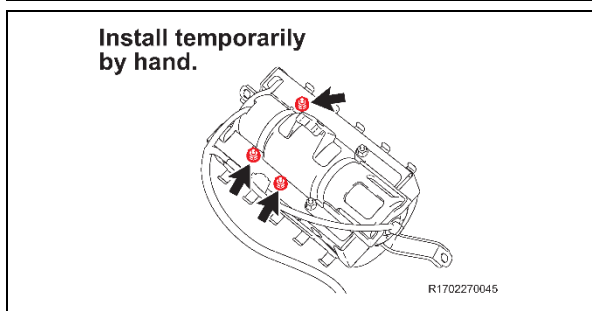
DO NOT
pinch the wire



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- e) Install the **NEW** stopper plate.
- f) Install 2 **NEW** nuts by hand.



- g) Remove the 3 remaining nuts and install the 3 **NEW** nuts
 - h) Loosely tighten the nuts by hand. They will be torqued on a later step.
- NOTE:** You may need to turn the airbag to the left or right to access the center nut.

- i) Push the inflator towards the position determining plate and eliminate any gaps.



- If any gaps exist, the flats may move apart and could result in abnormal operation during airbag deployment.

7. TORQUE THE PLATE NUTS

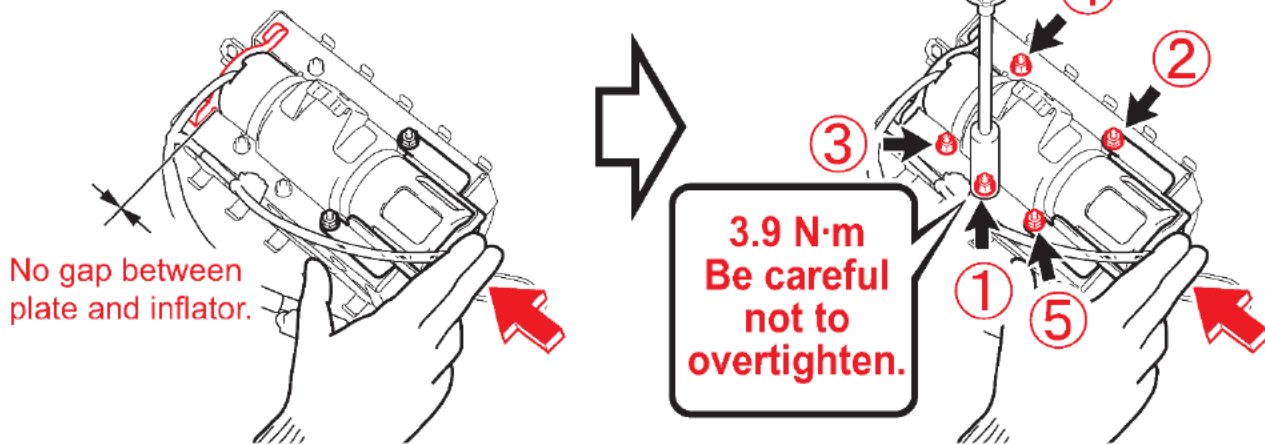
- a) Tighten the 5 nuts evenly in several increments in the sequence shown. Use a socket driver or torque wrench to tighten the nuts.

Torque: 35in. lbf (3.9N·m)



- There will be some resistance when tightening the nuts because they are self-locking, confirm the nuts are tightened correctly.
- **DO NOT** use a power tool, T-handle, or ratchet when tightening the nuts to avoid over torquing and deforming the studs.
- You may need to turn the airbag to the left or right with in the mounting bracket to access the center nut.

OK



NG

NG

NG



These tools cause overtightening !

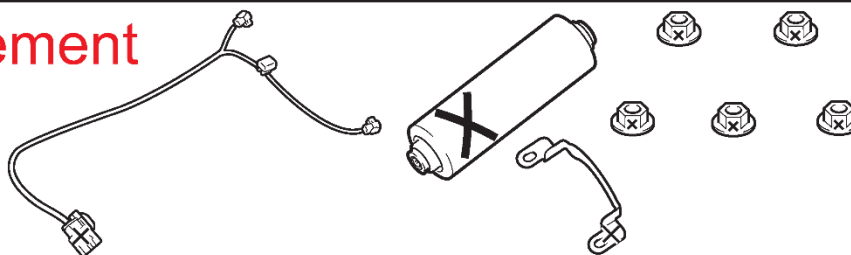
- b) Remove the airbag from the bracket and remove the adaptor.

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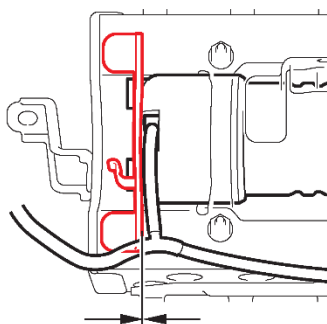
8. INSPECT THE AIRBAG BEFORE INSTALLATION

- Confirm the **NEW** inflator and 5 **NEW** nuts have been installed.
- Confirm the position of the inflator and position determining plates are correct.
NOTE: The flats should be aligned and no gaps between the plates and inflator.
- Confirm the routing of the inflator wire harness.

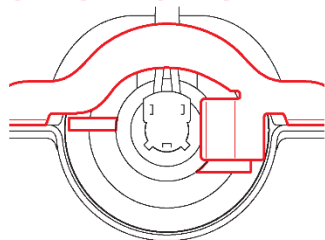
(a) Replacement of parts.



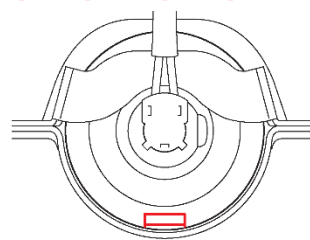
(b) No gap.



(b) Check orientation



(b) Check orientation



R1702270047

XI FRONT PASSENGER AIRBAG ASSEMBLY INSTALLATION

1. REINSTALL THE AIRBAG ASSEMBLY

- Refer to TIS for instructions on airbag installation:
[2009 MY](#) [2010 MY](#) [2011 MY](#) [2012 MY](#) [2013 MY](#)

2. RECONNECT THE NEGATIVE BATTERY CABLE

3. PERFORM ANY NEEDED VEHICLE INITIALIZATIONS

4. PERFORM A HEALTH CHECK AND DIAGNOSTIC REPORT

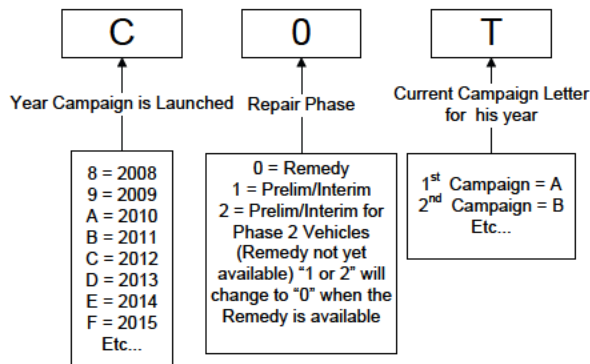
◀ VERIFY REPAIR QUALITY ▶

- Confirm all precautions are followed to ensure safety during the repair
- Confirm the entire serial number checker application is completed and the warranty authorization # is recorded on **EVERY** vehicle
- Confirm the old inflator is handled safely and given to the appropriate parts professional for shipment
- Confirm the inflator harness connector is fully engaged and that the stopper plate and position determining plate are installed correctly

If you have any questions regarding this update, please contact your regional representative.

XII APPENDIX

A. CAMPAIGN DESIGNATION DECODER



B. CAMPAIGN PARTS DISPOSAL

ALL inflators that are removed from vehicles under this campaign **MUST** be packaged and shipped back to the inflator manufacturer following the manufacturer's instructions. The instructions can be found in the following locations:

- Attached to the dealer letter