

**TECHNICAL INSTRUCTIONS**  
**FOR**  
**SAFETY RECALL DSF, E04, J0A, J0B, J0C**  
**FRONT PASSENGER AIRBAG INFLATOR MODULE**  
**CERTAIN 2003 – 2008 MODEL YEAR COROLLA**

**Update 3/25/22**

- **The technical instructions for DSF, E04, J0A, J0B, J0C have been combined**
- **Added a new section for Takata Desiccated Part Recovery**

**Update 9/1/2020**

- **Line art on page 19 has been updated**

**Update 5/28/2020**

- **Airbag Sub-Assembly replacement has been added as an additional repair option if airbag assemblies are not available**

**Update 11/15/2019**

- **The scanning process has been updated**

**Update 10/17/2019**

- **The model year has been extended to 2008 model year**

**Update 8/28/2019**

- **The scanning application process has changed. Please review the technical instructions for the details on this change**
- **The parts sections has been updated**

**Update 6/13/2019**

- **The scanning process for unreadable airbag assembly has been revised**

**Update 6/9/2019**

- **The scanning process has been updated**

**Update 12/18/2018**

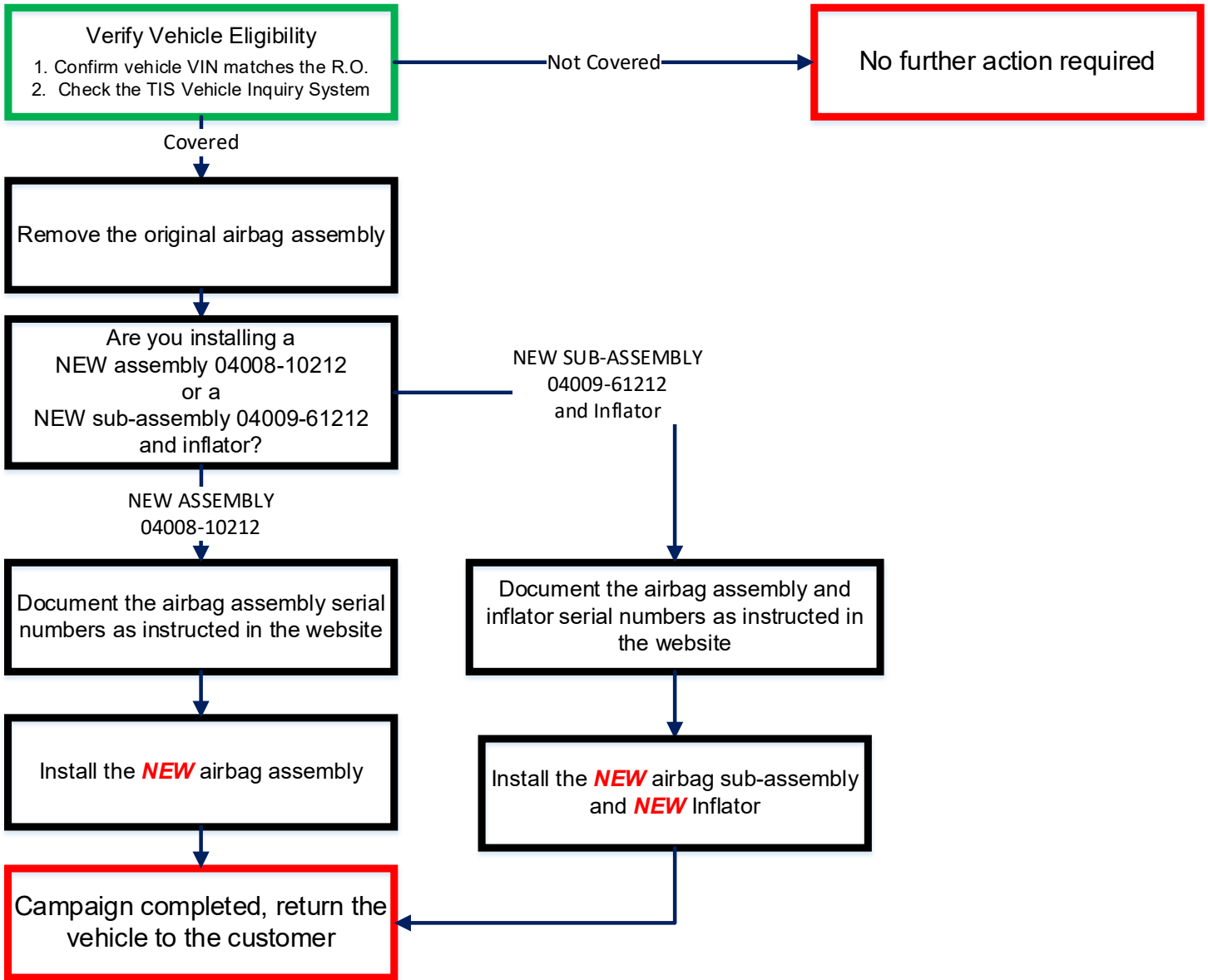
- **The images have been updated to reflect the new parts**

**All dealership technicians performing this recall 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 recall repair are required to have successfully completed E-Learning course SC18A (if you had previously completed E-Learning Course SC13B, you do not have to take SC18A), in addition to “Safety Recall and Service Campaign Essentials”, and currently hold at least one of the following certifications levels:**

- **Toyota Certified (Electrical)**
- **Toyota Expert (Any Specialty)**
- **Master**
- **Master Diagnostic Technicians**

# I. OPERATION FLOW CHART

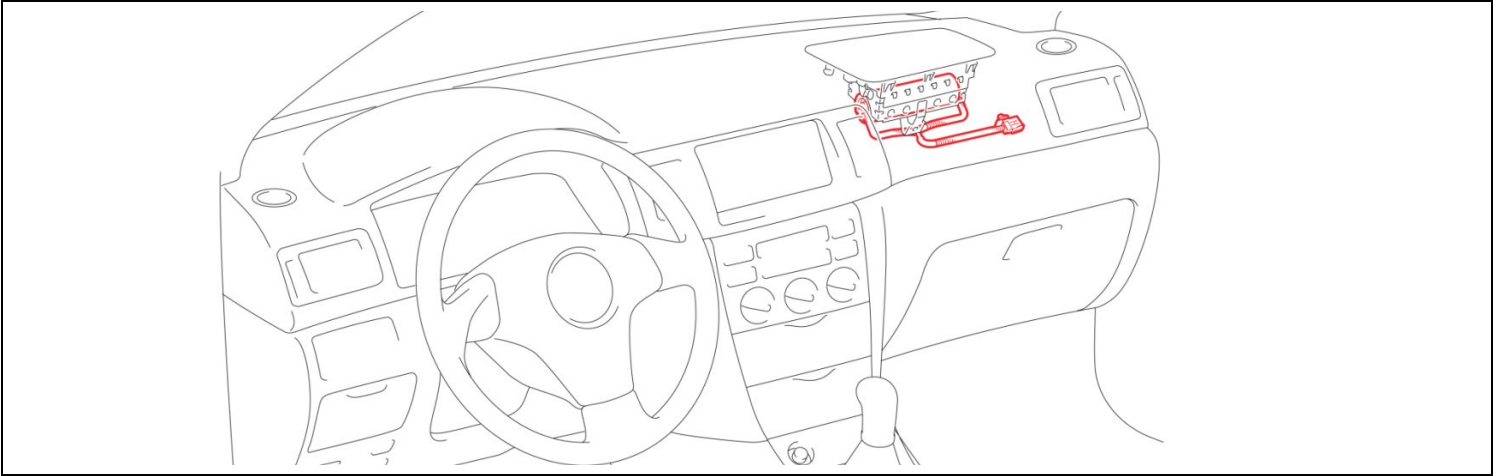
The flow chart is for reference only. **DO NOT** use it in place of the full technical instructions. Follow **ALL** steps as outlined in the full technical instructions to confirm the campaign is completed correctly.



**STOP** Passenger airbag disablement has been **DISCONTINUED** you must repair the vehicle **STOP**

## 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 the inflator to explode during airbag deployment. In the event of an inflator explosion, 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.
- **TMNA warranty will not reimburse dealers for repairs conducted on vehicles that are not affected or were completed by another dealer.**

## IV. PREPARATION

### A. PARTS

Model	Part Number	Part Description	Quantity
2003-2008 MY Corolla	04008-10212	AIR BAG ASSY KIT, INSTR PNL PASS	1

**Dealers should discontinue the installation of the parts listed below for the recalls, customer pay repairs AND over-the-counter sales (if applicable) unless they have a mark on the label.**



Make sure the parts box has a check mark as seen in the image above

**OR**

Model	Part Number	Part Description	Quantity
2003-2008 MY Corolla	04009-61212	AIR BAG KIT	1
	04008-10312	INFLATOR ASSY KIT, INSTR PNL AIR BAG	1

**NOTE: Continue to order 04008-10212 until there is no longer stock at your facing PDC. Once there is no longer stock of the airbag assembly part number 04008-10212 use the airbag kit part number 04009-61212 and inflator kit part number 04008-10312 to perform the remedy for Corolla vehicles.**

**\*\*If there is no longer stock of 04008-10212 and the airbag assy serial number is missing or not legible, use the service module part number to complete the campaign. In these cases do not use the scan app. Instead fill out a job aid and submit to [quality\\_compliance@toyota.com](mailto:quality_compliance@toyota.com).**

## Non-Desiccated Part Recovery

**Dealers should discontinue the installation of the non-desiccated parts listed below for recall, customer pay repairs AND over-the-counter sales (if applicable).**

Model	Model Year	Location	Part Number	Part Description	Qty
Corolla	2003-2004	48 States in Continental U.S.	04003-28102	INFLATOR ASSY KIT, INSTR PNL AIRBAG	1
		USTT, Hawaii & AK	04003-11102		
	2005-2008	48 States in Continental U.S.	04004-75202		
		USTT, Hawaii & AK	04004-75102		

Model	Model Year	Part Number	Part Description
Corolla	2003-2004	73970-02040-B0	AIR BAG ASSY, INSTR PNL PASS
		73970-02040-B1	
		73970-02040-E0	
	2005-2008	73970-02051-B0	
		73970-02051-B1	
		73970-02051-E0	

**Toyota requires all dealers to return any parts listed above that still remain in dealer inventory by utilizing the Hazmat Part Return Program available. Dealers will be issued a refund for all part returns. This part return program is outlined in *PANT Bulletin 2014-042*.**

### Important Note:

In order to return the inflator, packages must **NOT** be opened/tampered with.

## Takata Desiccated Part Recovery

**Dealers should discontinue the installation of the Takata desiccated parts listed below for recall, customer pay repairs AND over-the-counter sales (if applicable).**

Model	Model Year	Location	Part Number	Part Description
Corolla	2003-2004	48 States in Continental U.S.	04006-06102	INFLATOR ASSY KIT, INSTR PNL AIRBAG
		USTT, Hawaii & AK		
	2005-2008	48 States in Continental U.S.		
		USTT, Hawaii & AK		

Model	Model Year	Part Number	Part Description
Corolla	2003-2004	73970-02041-B0	AIR BAG ASSY, INSTR PNL PASS
		73970-02041-B1	
		73970-02041-E0	
	2005-2008	73970-02052-B0	
		73970-02052-B1	
		73970-02052-E0	

**Toyota requires all dealers to return any parts listed above that still remain in dealer inventory by utilizing the Hazmat Part Return Program available. Dealers will be issued a refund for all part returns. This part return program is outlined in *PANT Bulletin 2014-042*.**

### Important Note:

In order to return the inflator, packages must **NOT** be opened/tampered with.

**B. TOOLS & EQUIPMENT**

- Standard hand tools
- Molding remover set
- Torque wrench
- Techstream
- Electrical tape
- Zip Tie

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

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

**CAMPAIGN TOOLS** – These tools were previously provided to the dealership for campaign D0F and will be used for campaign E04. These tools are required when performing this repair.

Image	Name	Quantity
	Airbag Mounting Bracket & hardware	1
	Barcode Scanner	1

**NOTE:** These tools **CANNOT** be ordered through the parts or tools system. There is a very limited supply of tools, but if additional tools are needed, contact your regional representative.

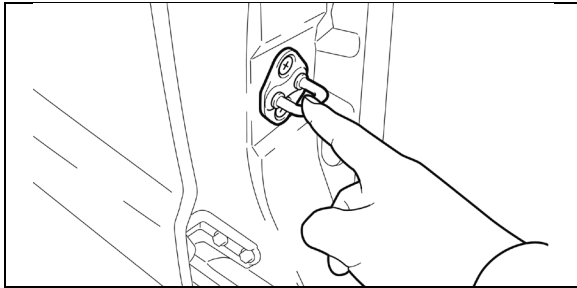
## V. SAFETY PRECAUTIONS



### CRITICAL INFORMATION – READ THOROUGHLY

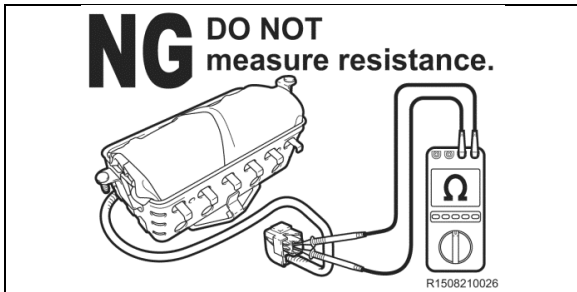


Failure to follow these procedures correctly could cause the SRS to unexpectedly deploy during servicing or the SRS may fail to operate correctly when required after reassembly. Confirm all work is performed as described in these instructions.



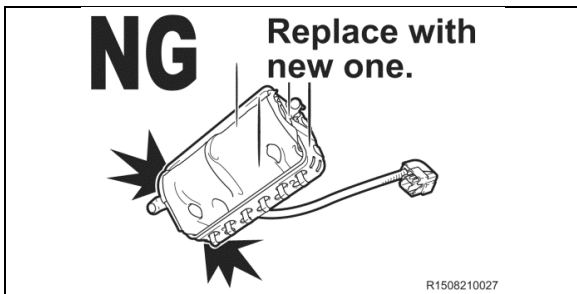
#### 1. ELIMINATE STATIC ELECTRICITY

- 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.



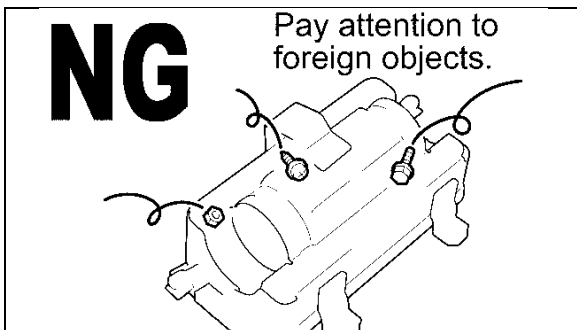
#### 2. DO NOT MEASURE RESISTANCE

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



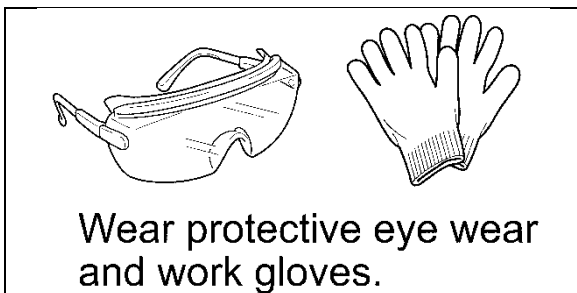
#### 3. HANDLE THE AIRBAG CAREFULLY

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



#### 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. WORK AREA PREPARATION

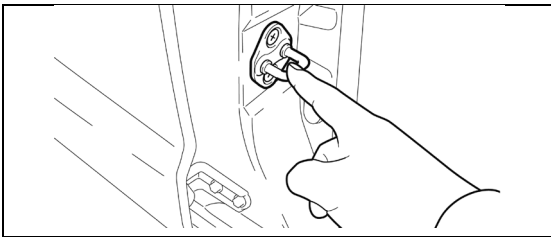
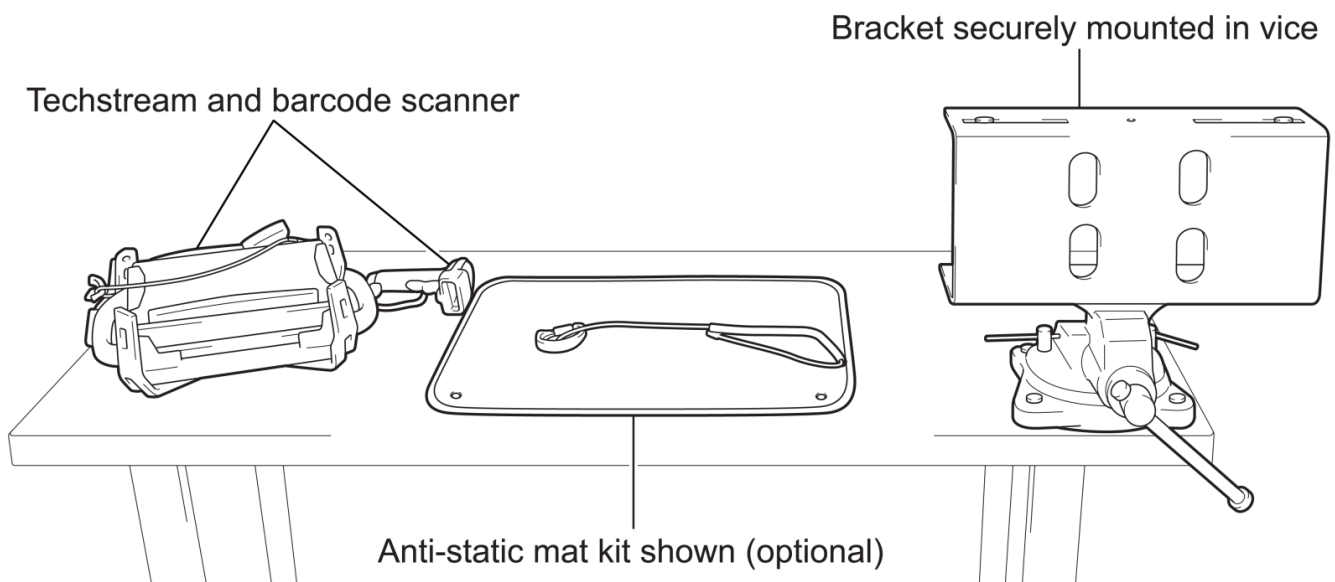
STOP

### CRITICAL INFORMATION – READ THOROUGHLY

STOP

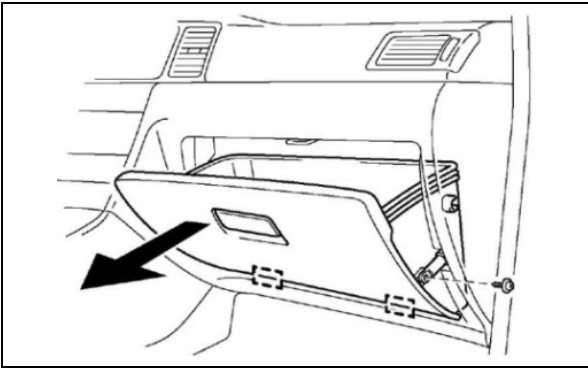
The bracket assembly that was provided at the launch of SSC D0F is a critical added-safety feature that **MUST** be used when replacing the inflator module. Confirm the bracket assembly is installed securely in the vise and confirm the work area being used is appropriate. The anti-static mat set that 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.

Confirm there are no loose objects or people exposed to the back side of the bracket for safety in the unlikely event of airbag deployment due to improper work procedures (Remember that the inflator **IS NOT** being replaced due to an inadvertent deployment concern).



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.

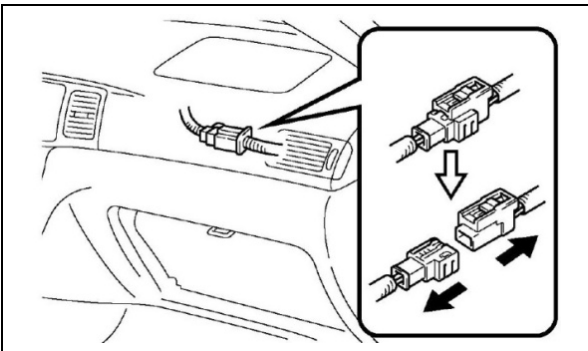
## VIII. PASSENGER AIRBAG ASSEMBLY REPLACEMENT



### 1. REMOVE THE GLOVE BOX

- Remove the screw and disconnect the stopper sub-assembly.
- Completely remove the glove box from the dashboard.

### 2. REMOVE THE AIRBAG ASSEMBLY

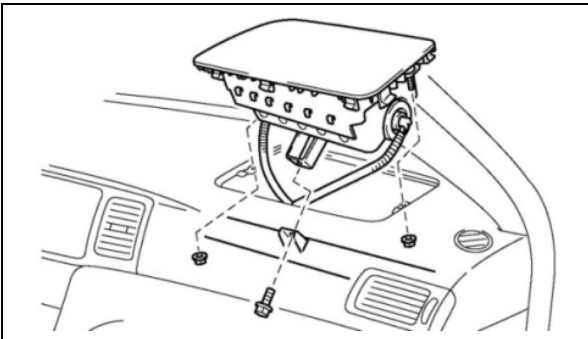


- Disconnect the negative battery cable.



- 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.

- Disconnect the airbag connector.



- Remove the bolt and 2 nuts and remove the airbag assembly.

**NOTE:** Use caution to avoid scratching or damaging the dashboard assembly, place protective tape on the dashboard if needed.

### 3. CONNECT THE BARCODE SCANNER

- Connect the barcode scanner to the USB port on the Techstream.
- The scanner will automatically connect and a beep will be heard when the scanner is ready.

**NOTE:**

- The scanner was provided for SSC D0F.
- The scanner works best in low light conditions.
- Always hold the scanner directly in front of and parallel to the barcode label.

#### 4. LAUNCH THE SERIAL NUMBER RECORDING APPLICATION



- The ORIGINAL AIRBAG ASSEMBLY, and NEW ASSEMBLY serial numbers MUST be recorded using the barcode scanner.
- 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 an internet connection to perform the inspection and scanning process.

- a) Log into the website via the URL below  
<https://takata-scan-app.imagespm.info/>
- b) **User ID:** Dealer Code  
**First time login password:** xxxxx

**Login**

Complete all required (\*) fields below.

\* **User ID (enter your 5-digit dealer code, or 6-digit for Canadian dealers eg. Cnnnnn format):**

\* **Password:**

**Login**

[Forgot Password?](#)

**Technician Information**

Please provide information below before searching for VIN.

**Technician Name:**

**SPIN ID (12 digit code):**

**Search**

- c) Enter your name and SPIN ID into the site

**Enter VIN**

Enter the 17-digit Vehicle Identification Number to begin the search for this campaign.

**VIN:**

**Mileage on Vehicle:**

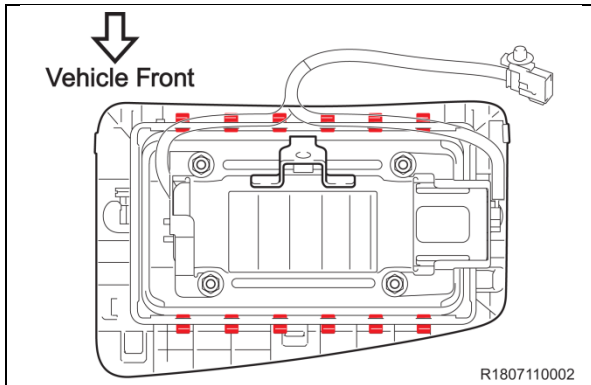
**Search**

- a) Enter the VIN and vehicle mileage into the site

#### 5. FOLLOW THE INSTRUCTIONS IN THE SITE FOR RECORDING SERIAL NUMBERS

- a. Follow the prompts and fill in the requested information in the website.
- b. Once completed, record the Warranty Authorization number if given and provide it to your warranty clerk.

**IX. PASSENGER AIRBAG ASSEMBLY REPLACEMENT (Part Number 04008-10212)  
(for airbag sub-assembly part number 04009-61212 and inflator part number  
04008-10312 replacement go to step IX.)**



**5. INSTALL THE INSTRUMENT PANEL PASSENGER AIRBAG ASSEMBLY COVER**

- a) Install a **NEW** instrument panel passenger airbag taking care not to mistake the mounting direction.
- b) Check that the 12 claws of the instrument panel passenger airbag have engaged securely.

**6. REINSTALL THE AIRBAG ASSEMBLY**

**Note:** During reinstallation of the airbag assembly, ensure the 12mm bolt and two 10mm nuts securing the airbag assembly to the instrument panel are installed and torqued to the required specification identified on TIS.

- a) Refer to TIS for instructions on airbag installation:

Corolla [2003-2005MY](#) [2006MY](#) [2007MY](#) [2008MY](#)

**7. RECONNECT THE NEGATIVE BATTERY CABLE**

**8. 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 airbag assembly is handled safely and given to the appropriate parts professional for shipment

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

**X. AIRBAG SUB-ASSEMBLY AND INFLATOR REPLACEMENT (Part Number 04009-61212 and  
04008-10312)**

(only required if airbag assembly part 04008-10212 is unavailable)



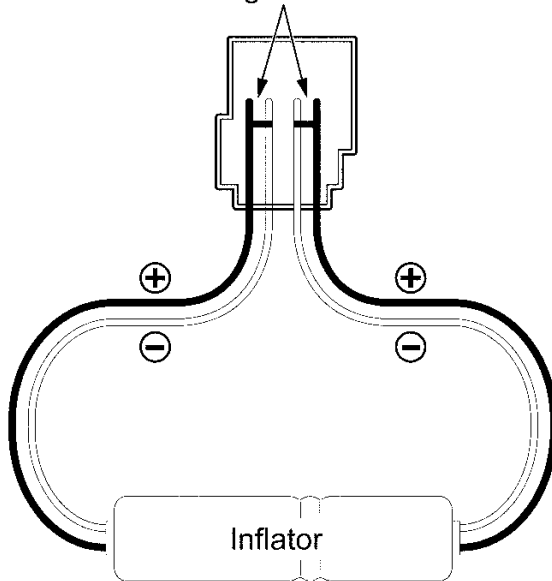
## CRITICAL INFORMATION – READ THOROUGHLY



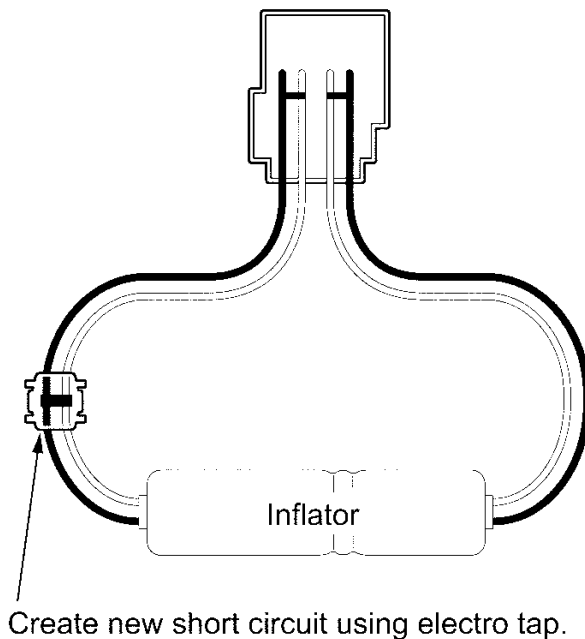
The connector of the inflator module contains a short circuiting mechanism to eliminate voltage variances when the connector(1) is disconnected. To allow for the replacement of the inflator module, a new short circuit(2) **MUST** be created before cutting the wires(3) and removing the inflator. The following steps **MUST** be followed exactly as described to ensure the work is completed correctly and safely.

(1)

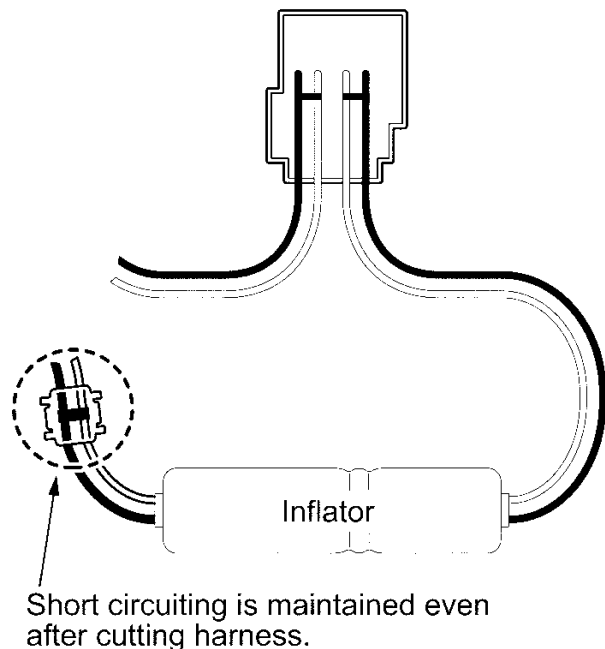
Short circuiting on both sides.



(2)



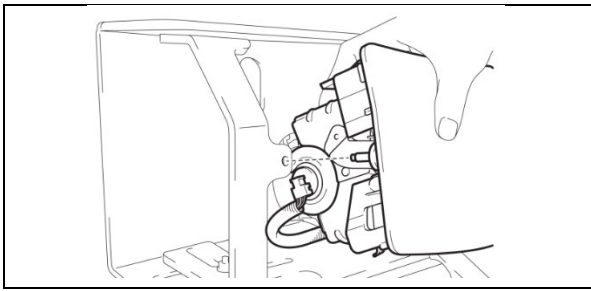
(3)



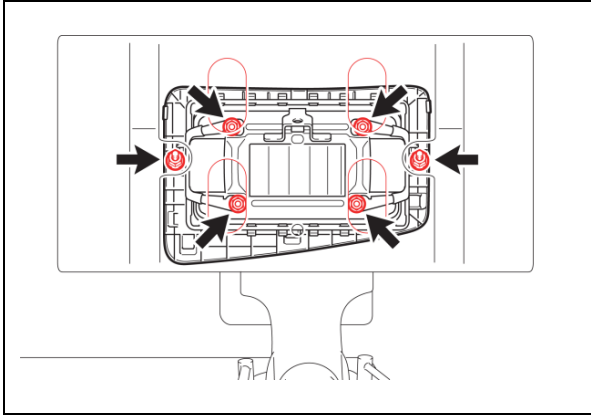
R1302250036E

### 1. MOUNT THE AIRBAG IN THE MOUNTING BRACKET

- Position the two mounting studs on the airbag assembly into the holes on the bracket support bars.

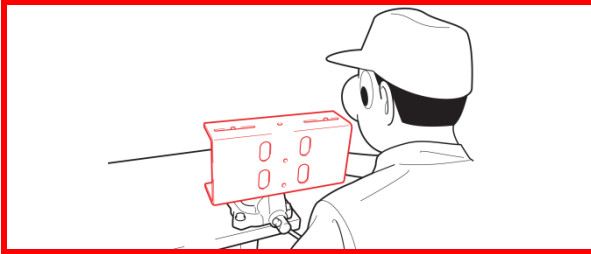


b) Install the airbag to the support bars with the nuts supplied in the bracket kit.

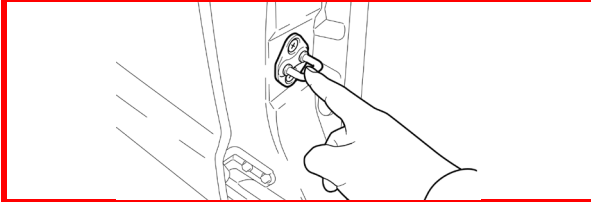


- c) Position the airbag so that all four stopper plate nuts can be removed through the access holes.
- d) Tighten the nuts holding the support bars to the mounting bracket.
- e) Confirm the following:
- Mounting bracket is secure in the vise.
  - Airbag is secure in the support bars.
  - The center mounting bracket on the airbag assembly is facing upward.
  - Support bars are secure on the mounting bracket using 1 bolt/nut at the top of each support bar and 2 nuts/bolts at the bottom of each support bar.

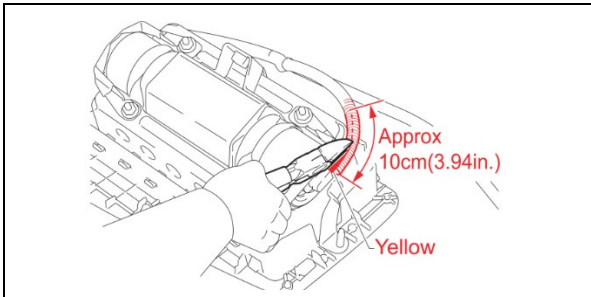
**STOP CRITICAL INFORMATION – READ THOROUGHLY STOP**



**ALWAYS** keep as much of your body as possible in front of the bracket when working on the airbag assembly.



**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. PREPARE TO INSTALL THE SHORT CIRCUIT**

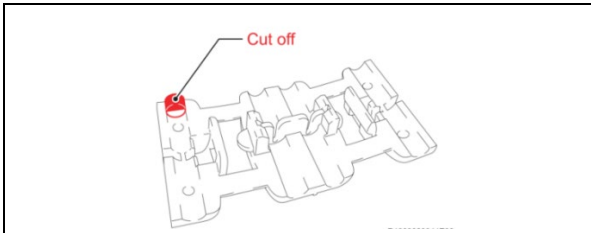
a) Cut the yellow corrugated tube on the harness approximately 4 inches (10 cm) using nippers.

**STOP**

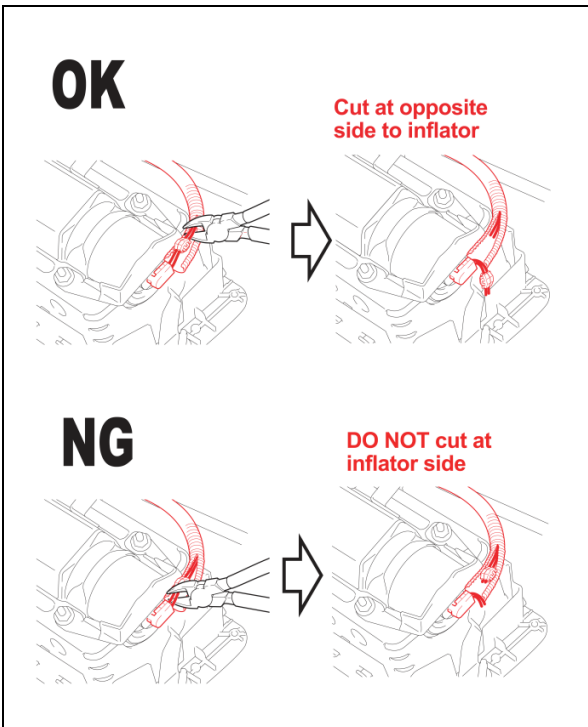
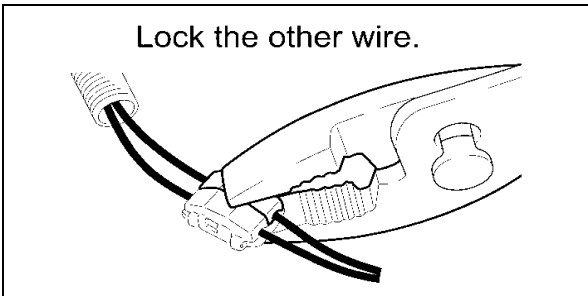
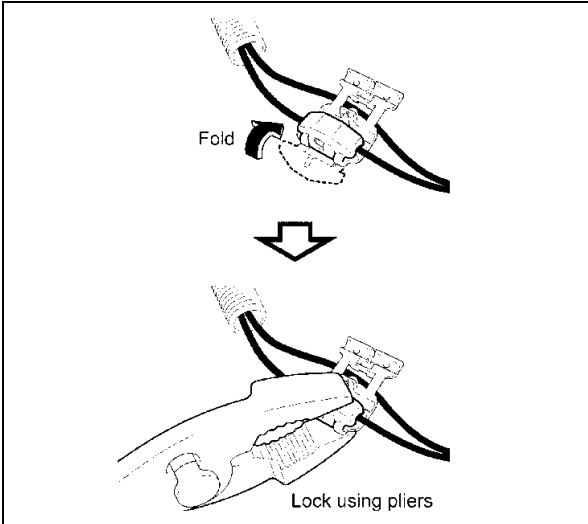
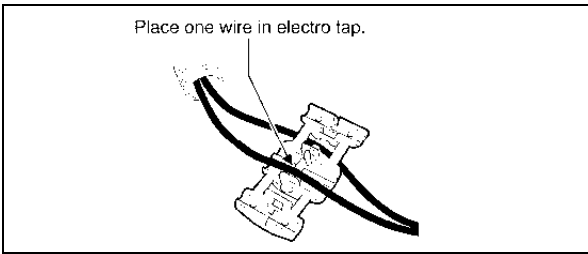
- **DO NOT** damage the wires in the tube.
- **DO NOT** use a knife or razor blade to cut the tube to avoid damaging the wires.
- This may be performed on either end of the inflator.

b) Cut off the tab of the electro tap shown in the illustration.

**NOTE: The electro tap is included in the inflator parts kit.**



**STOP** This tab **MUST** be removed to ensure a good short.



**3. CREATE A NEW SHORT CIRCUIT IN THE INFLATOR HARNESS**

a) Place one wire in the electro tap as shown in the illustration.

b) Fold and pinch the half of the electro tap with the wire and use pliers to lock the electro tap.

**NOTE:**

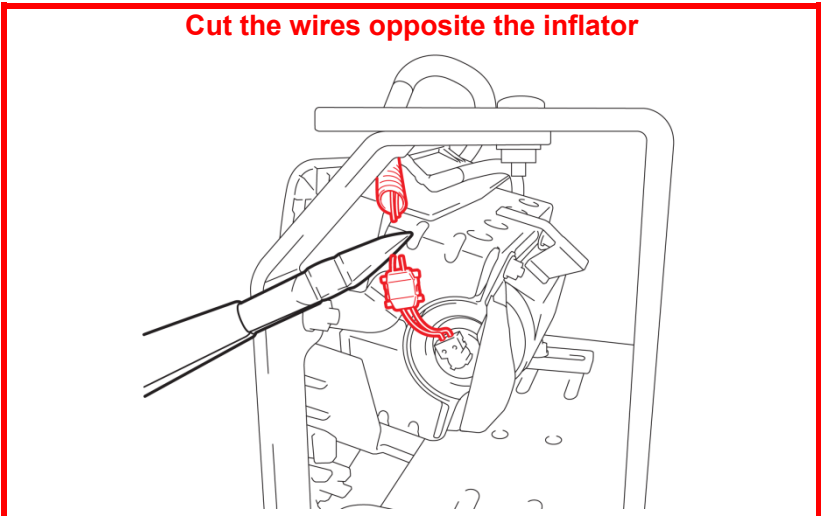
- **DO NOT** work on both wires at the same time to avoid errors.
- Pliers **MUST** be used to confirm the electro tap is firmly locked in place.

c) Set the other wire in the electro tap and lock it in place using pliers.

**STOP** DO NOT measure resistance of the inflator wires, this may cause accidental activation.

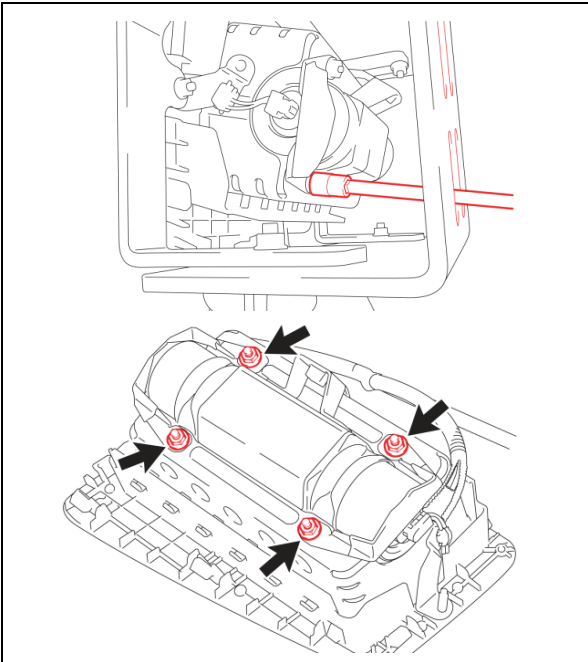
**4. CUT THE INFLATOR WIRES**

a) Cut the 2 wires at the side of the electro tap that is farthest away from the inflator.



**STOP** DO NOT measure resistance of the inflator wires, this may cause accidental activation.



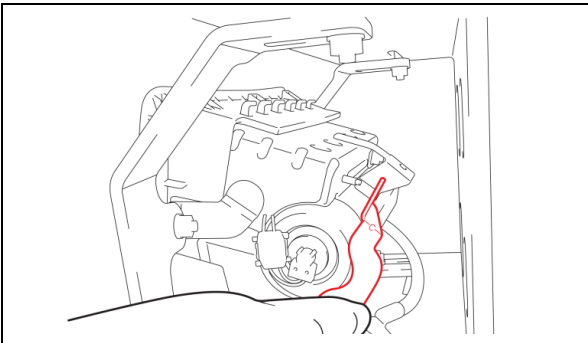


## 5. REMOVE THE SELF LOCKING NUTS

- a) Use the access holes in the bracket to remove the 4 nuts.

### NOTE:

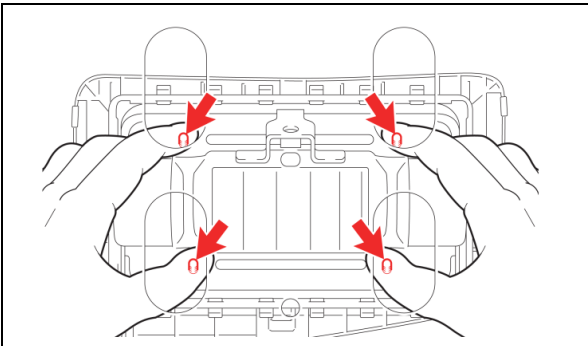
- **DO NOT** use power tools.
- The bracket support bars may need to be repositioned to remove the nuts through the access holes.



- b) Remove the stopper plates.

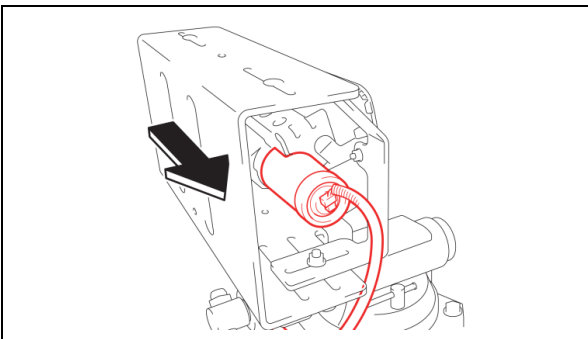
- c) Discard the 4 nuts and 2 stopper plates as they are not to be reused.

**NOTE: DO NOT** reuse the old nuts, new nuts **MUST** be used.

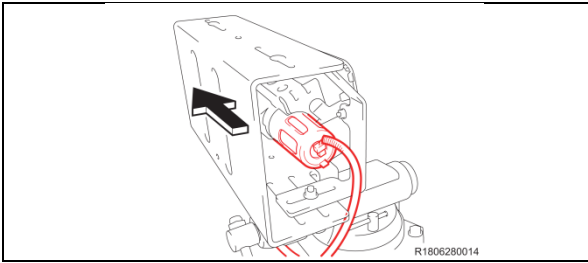


## 6. REMOVE THE INFLATOR

- a) Gently push in the 4 studs to loosen the inflator for removal.



- b) Remove the inflator from the airbag assembly and place it on a safe work surface.

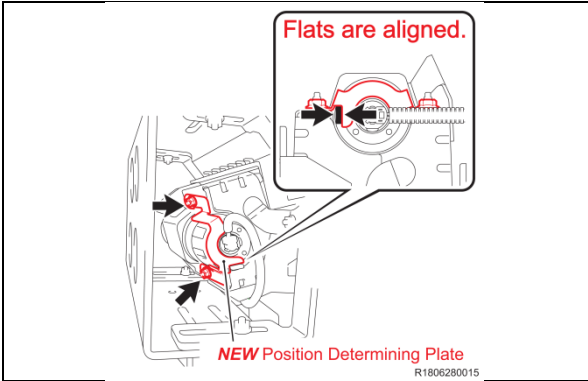


## 7. INSTALL THE NEW INFLATOR

- a) Carefully slide the new inflator into the airbag assembly.



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

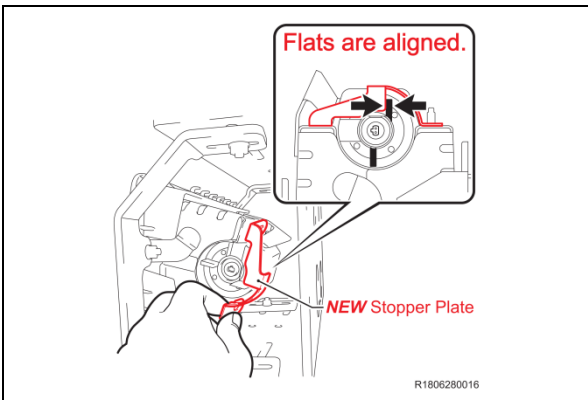


## 8. INSTALL THE NEW POSITION DETERMINING PLATE

- a) Place the **NEW** position determining plate on the side where the harness is already connected.



- Confirm the flats on the position determining plate and inflator are aligned.
- **DO NOT** pinch the harness between the inflator and the plate.



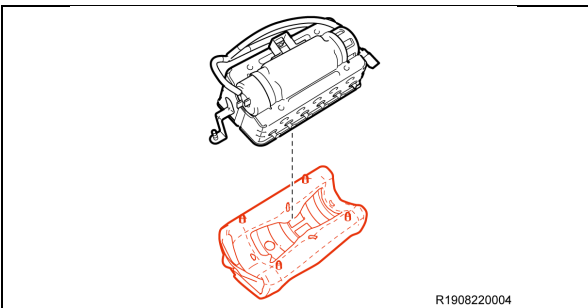
## 9. INSTALL THE NEW POSITION DETERMINING PLATE

- a) Place the **NEW** position determining plate on the airbag assembly on the unconnected side.



- Confirm the flats on the position determining plate and inflator are aligned.

- b. Remove the airbag assembly from the bracket so you may replace the airbag sub-assembly



## 8. REPLACE THE INSTRUMENT PANEL PASSENGER AIRBAG SUB-ASSEMBLY

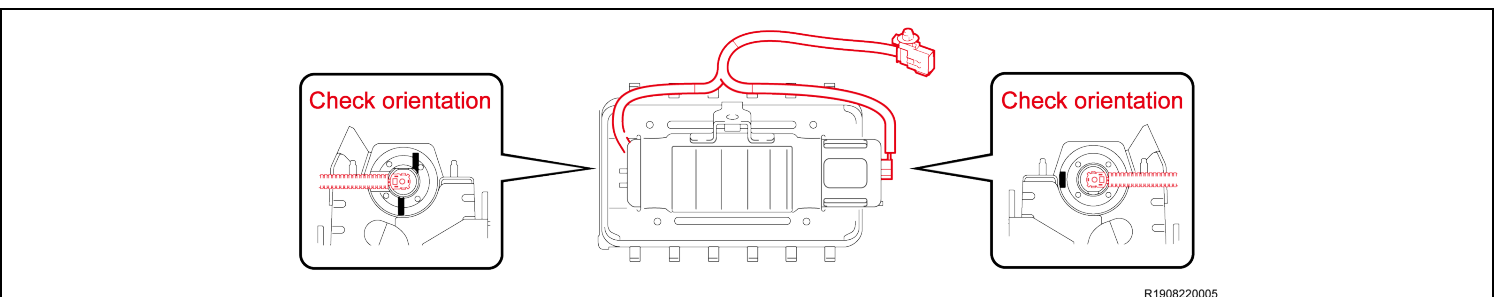
- a) Remove the instrument panel passenger airbag sub-assembly from airbag case.  
 b) Store the removed instrument panel passenger airbag sub-assembly in a replacement part box or other safe location.  
 c) Install the **NEW** instrument panel passenger airbag sub-assembly.

- d) Connect the inflator wire harness

- e) Place the inflator following the top-and-bottom orientation shown in the illustration.



- Make sure that the inflator is oriented correctly as shown in the illustration, not upside down.
- If the passenger airbag inflator is upside down, it will not be able to be fully inserted.

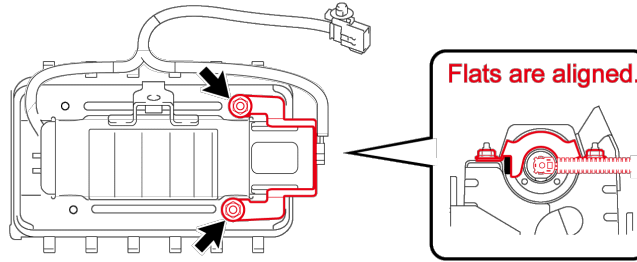


f) Loosely install the plate and airbag inflator with the 2 **NEW** self-locking nuts.



• **DO NOT** mistake the orientation of the plate.

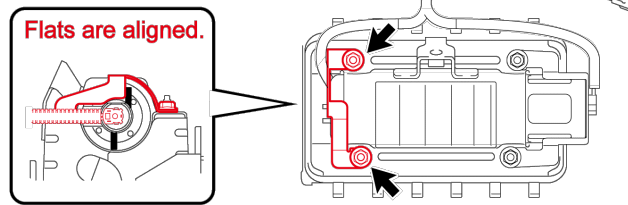
Install loosely  
by hand



R1908220006

g) Loosely install the plate and airbag inflator with the 2 **NEW** self-locking nuts.

Install loosely  
by hand



R1908220007

h) Push the inflator and plate to towards the position determining plate to eliminate any gap.



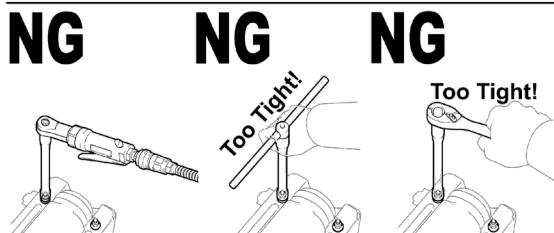
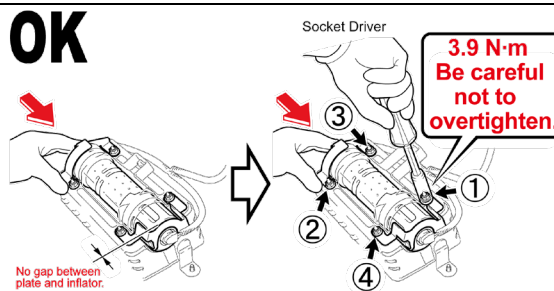
**If any gap exists, the aligned flats may move apart, resulting in failure in normal deployment of the airbag.**

i) Tighten 5 nuts evenly in several increments in the order shown in the illustration using a socket driver while pushing the inflator and plate. (You will encounter some resistance during tightening because these nuts are self-locking nuts.)

**Torque: 3.9 N\*m (40 kgf\*cm, 35 in.\*lbf)**



**The tightening torque is low (3.9 N-m). Use of an air ratchet wrench, a T-handle wrench, or a ratchet handle may cause the stud bolt to stretch or break.**



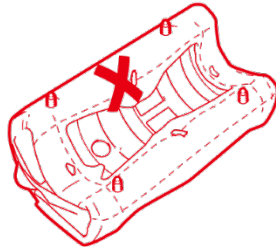
**These tools cause overtightening !**

R1908220008

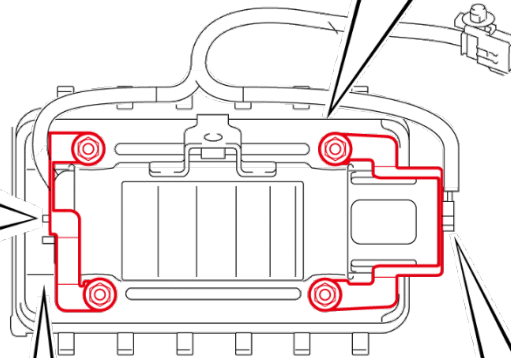
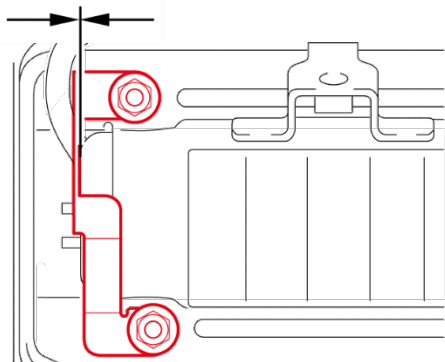
## 9. INTERMEDIATE INSPECTION

- a) Check that the instrument panel passenger airbag sub-assembly and 4 self-locking nuts are replaced.
- b) Check that positions of the inflator and the position determining plate are correct.  
(The flats should be aligned and there should be no gap.)

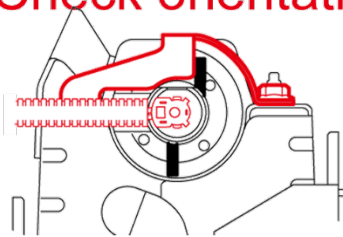
(a) Replacement  
of parts



(b) No gap.

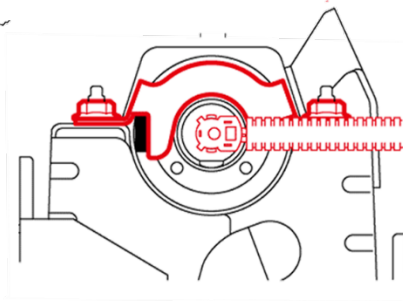


(b) Check orientation



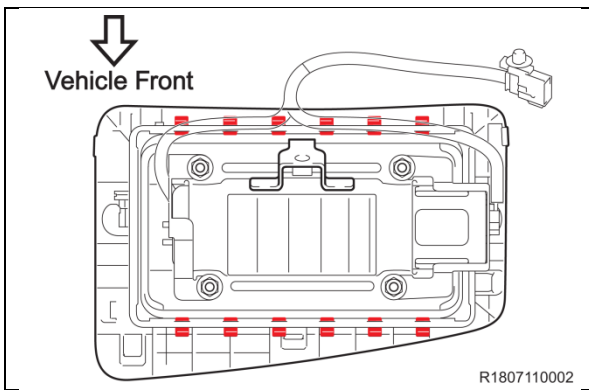
Pass through  
the side

(b) Check orientation



R1908220003

## XI. INSTRUMENT PANEL PASSENGER AIRBAG ASSEMBLY W/O DOOR INSTALLATION



### 1. INSTALL THE INSTRUMENT PANEL PASSENGER AIRBAG ASSEMBLY W/O DOOR

- Install the instrument panel passenger airbag taking care not to mistake the mounting direction.
- Check that the 12 claws of the instrument panel passenger airbag have engaged securely.

### 2. REINSTALL THE FRONT PASSENGER AIRBAG ASSEMBLY

**Note:** During reinstallation of the airbag assembly, ensure the 12mm bolt and two 10mm nuts securing the airbag assembly to the instrument panel are installed and torqued to the required specification identified on TIS.

- Refer to TIS for instructions on airbag installation:

Corolla [2003-2005MY](#) [2006MY](#) [2007MY](#) [2008MY](#)

### 3. RECONNECT THE NEGATIVE BATTERY CABLE

### 4. PERFORM A HEALTH CHECK AND DIAGNOSTIC REPORT

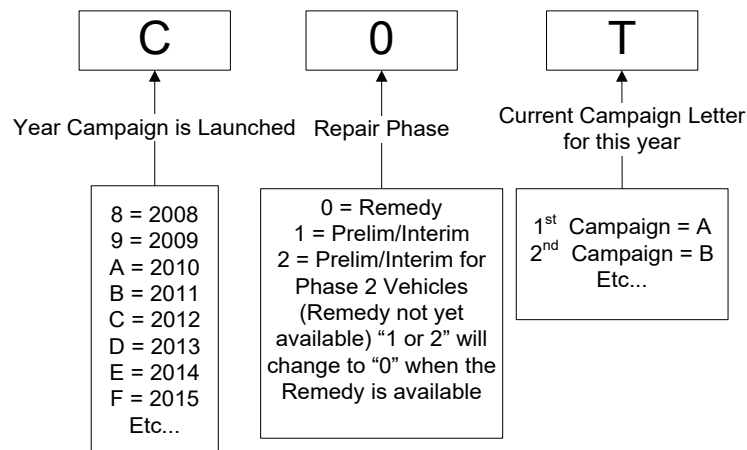
## ◀ VERIFY REPAIR QUALITY ▶

- 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

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