

IMPORTANT UPDATE

TECHNICAL INSTRUCTIONS FOR SAFETY RECALL G0P/G0R/H0A FRONT PASSENGER AIRBAG INFLATOR MODULE CERTAIN 2009 – 2013 MODEL YEAR COROLLA

Updated 01-14-2021

Update 01-14-21

- The scanning application process has been updated

Update 1-9-19

- The title has been updated to include G0R and H0A

Update 7-17-18

- The Technician Certification Requirements have changed

Update 4-18-18

- The parts section has been updated

Update 1-9-18

- 2013 MY added

Update 11-2-17

- 2012 MY added

Update 8-31-17

- 2011 MY added

Update 6-02-17

- 2010 MY added

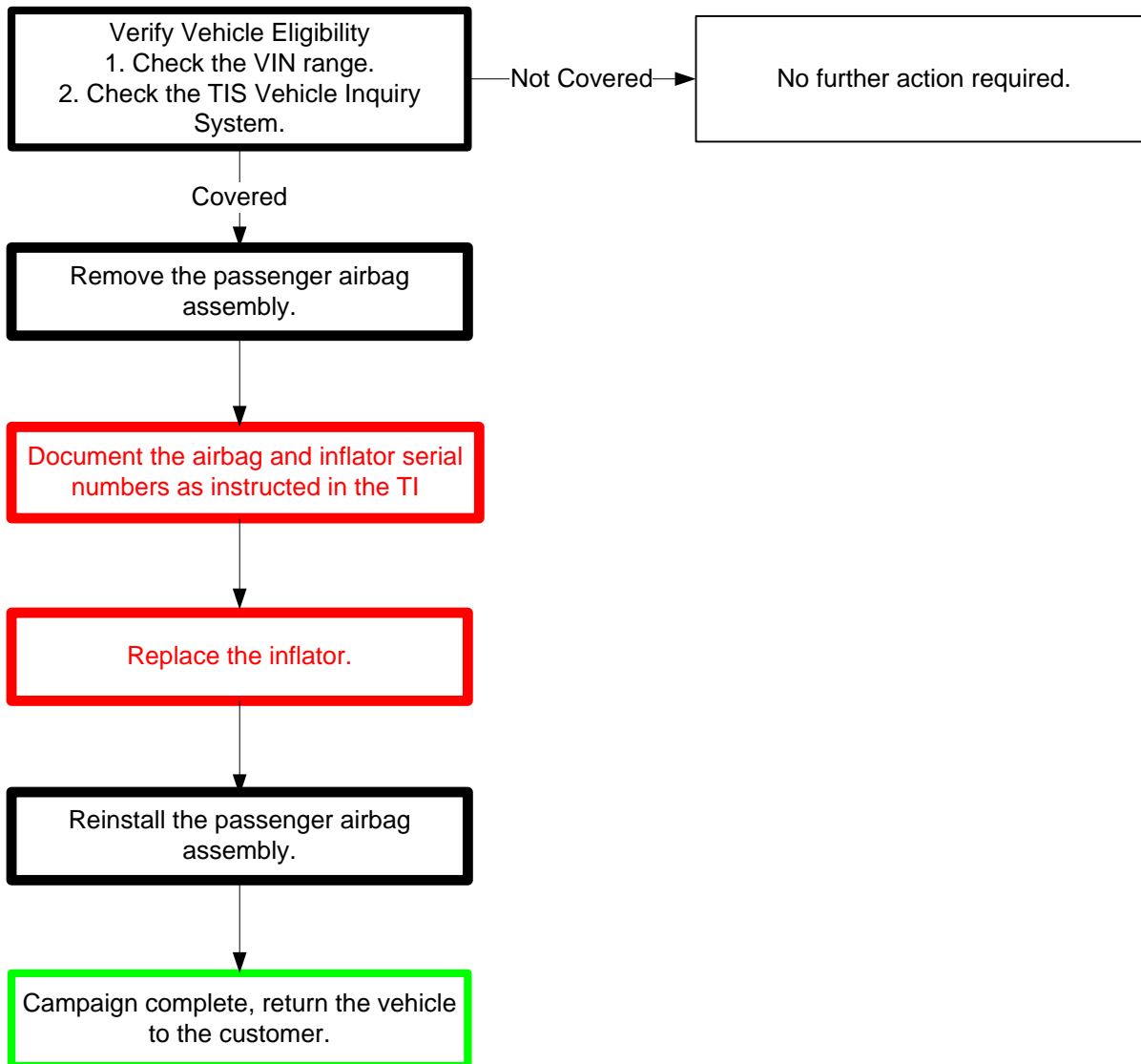
All dealership technicians performing this recall are required to successfully complete the most current version of the E-Learning course “Safety Recall and Service Campaign Essentials”. To ensure that all vehicles have the repair performed correctly; technicians performing this recall repair are required 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

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.

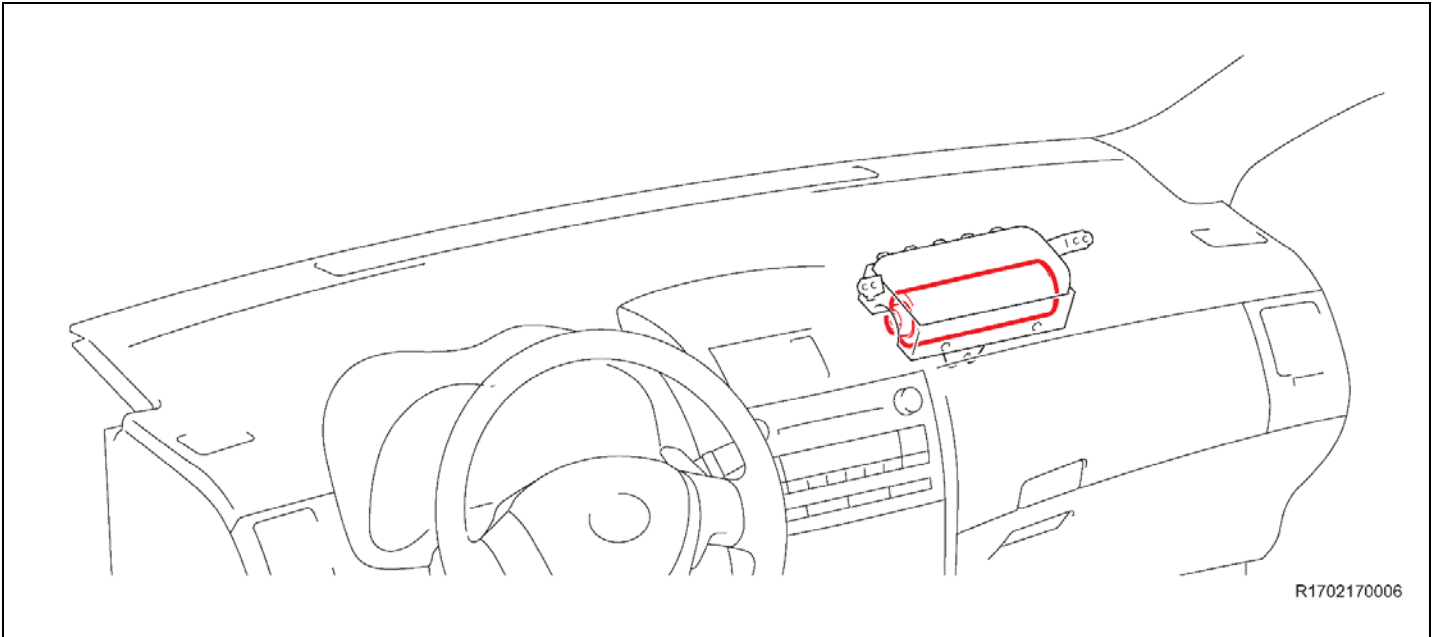
I. OPERATION FLOW CHART

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

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	Part Number	Part Description
Corolla	2009-2010	73960-12130	AIR BAG ASSY, INSTR PNL PASS
		73960-12160	
	2011-2013	73960-02140	
		73960-02120	

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
- 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 adapter 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

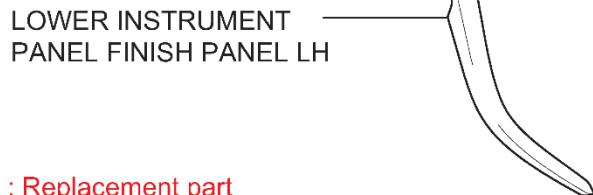
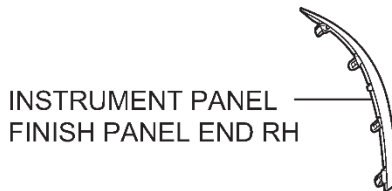
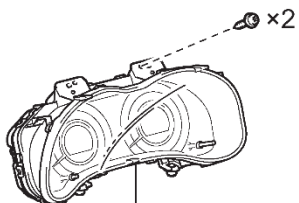
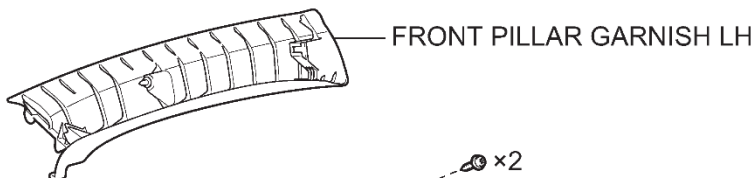
NOTE: This tool CANNOT be ordered through the parts or tools system. If additional tools are needed, they can be sourced locally.

V. COMPONENTS

w/ Curtain Shield Airbag:

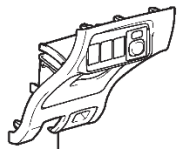
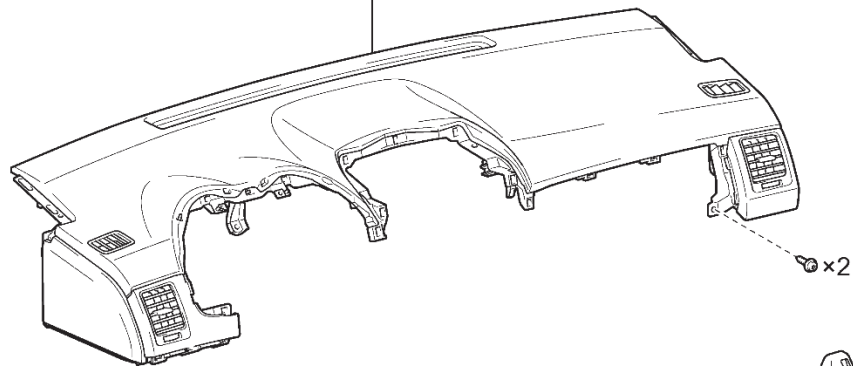
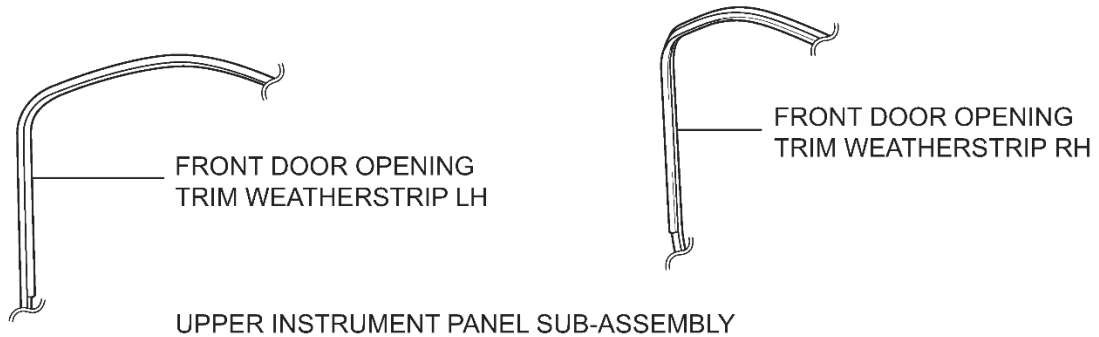


w/ Curtain Shield Airbag:



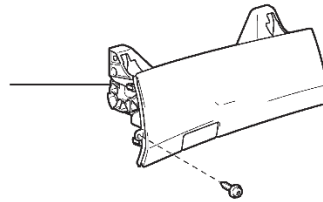
● : Replacement part

R1702170004

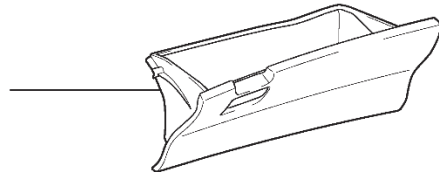


LOWER INSTRUMENT PANEL FINISH PANEL ASSEMBLY

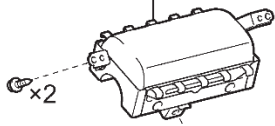
No. 1 INSTRUMENT PANEL BOX DOOR SUB-ASSEMBLY



GLOVE COMPARTMENT DOOR ASSEMBLY



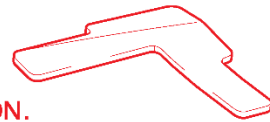
FRONT PASSENGER AIRBAG ASSEMBLY



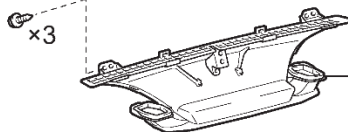
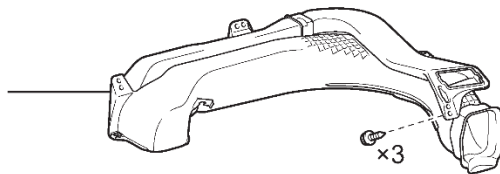
20 (204, 15)

for TMC Made:

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



No. 3 HEATER TO REGISTER DUCT



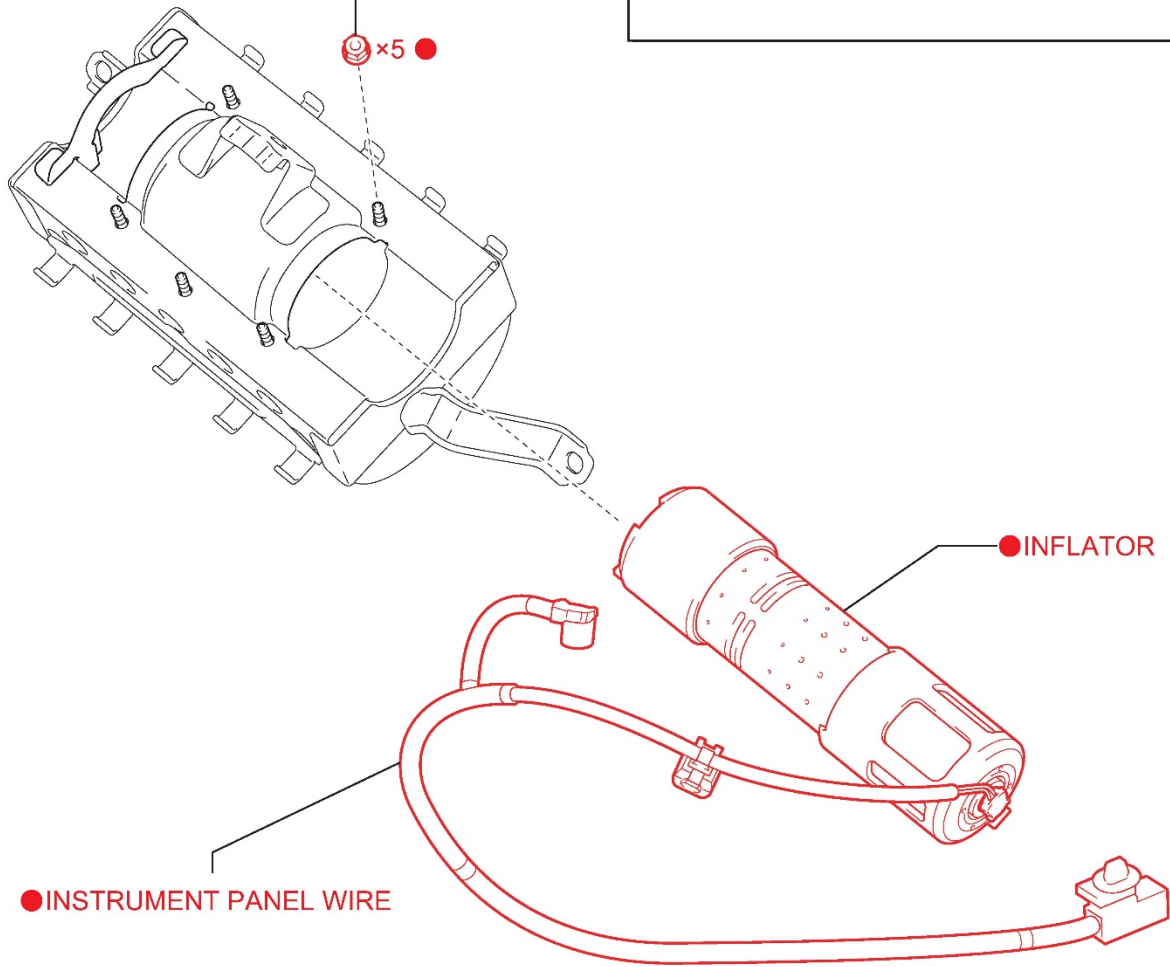
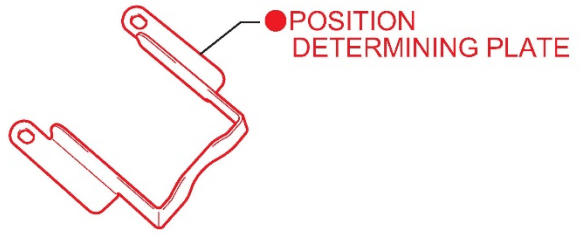
DEFROSTER NOZZLE ASSEMBLY

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

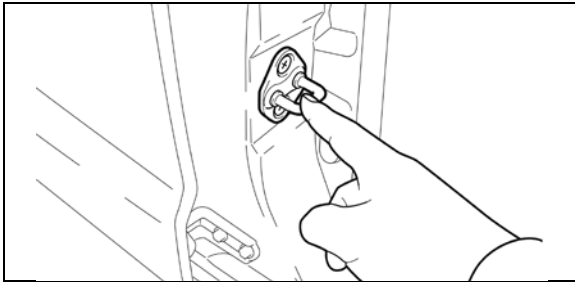
VI. SAFETY PRECAUTIONS



CRITICAL INFORMATION – READ THOROUGHLY

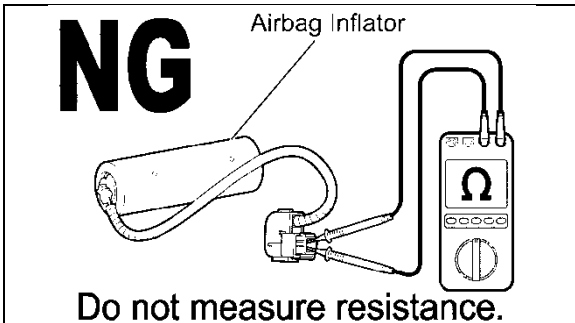


Failure to follow these procedures correctly could cause the SRS to unexpectedly deploy during servicing or the SRS may fail to operate correctly when required after reassembly. Confirm all work is performed as described in these instructions.



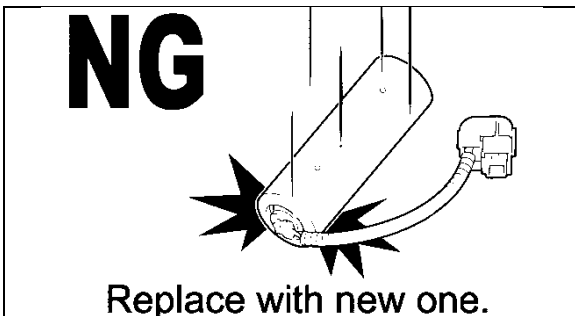
1. ELIMINATE STATIC ELECTRICITY

- 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.



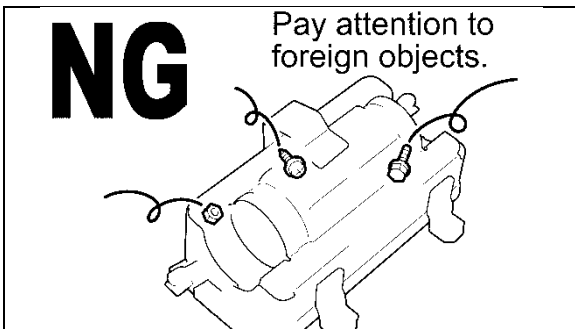
2. DO NOT MEASURE RESISTANCE

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



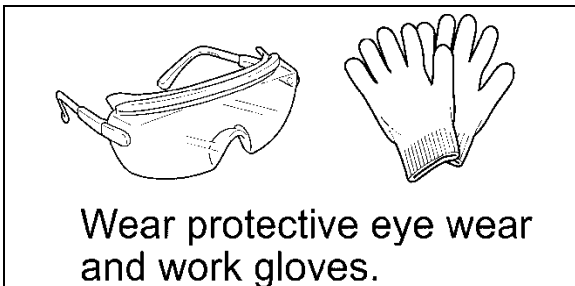
3. HANDLE THE AIRBAG CAREFULLY

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



4. DO NOT ALLOW FOREIGN OBJECTS NEAR AIRBAG

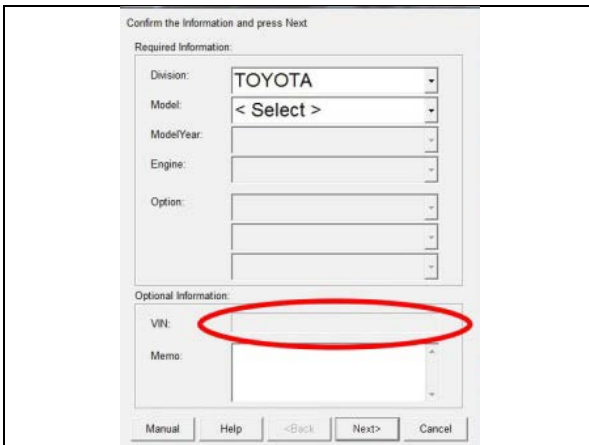
- a) Be sure to collect and account for all removed nuts/bolts to prevent them from landing in the airbag assembly.
- b) Any foreign objects in the airbag assembly may cause damage or injury if the airbag is activated.



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.

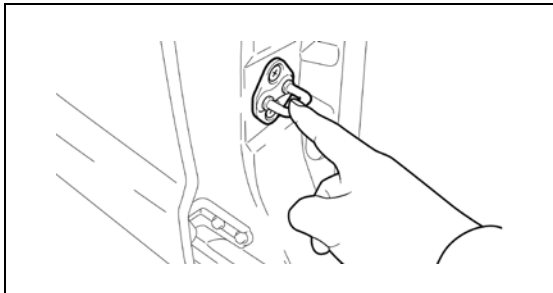
VIII. WORK AREA PREPARATION



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

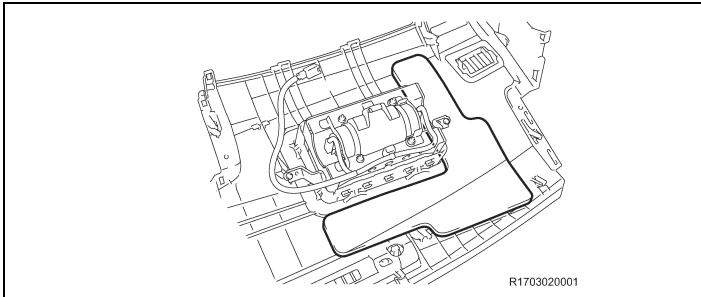
1. REMOVE THE AIRBAG ASSEMBLY



- 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 be sent to the scanning application site.
- d) You can also log into the scanning site via the URL below

Log into the website via the URL below

<https://takata-scan-app.imagespm.info/>

User ID: Dealer Code

First time login password: xxxxx

The screenshot displays the Toyota TIS Vehicle Inquiry interface. At the top, navigation tabs include Home, TIS, TAS, PRS, and QAT. The 'Vehicle Inquiry' tab is active, showing a search form for the VIN '1NX-BR32E-000000000'. Below the search form, vehicle information is displayed, including Division (TOYOTA), Model (Corolla), Grade (CE), Model Year (2003), Drive Type (2WD), Body Type (4Dr. Sedan), Engine Family (4-cylinder - 1ZZ), and Transmission. The VIN is listed as 1NX-BR32E-000000000. Below the vehicle information, there are tabs for Campaign, Service History, Warranty, DTC History, and Diagnostic Report. The 'Service Campaign' section shows a description: 'Safety Recall DOF Remedy Notice - 2003-2004 Model Year Corolla, Corolla Matrix, Sequoia, and Tundra Vehicles, 2002-2003 Model Year Vehicles Front Passenger Airbag Inflator Module'. The completion status is 'Not Completed' with a link to 'Check applicability for VIN'. Red circles and labels 'a)', 'b)', and 'c)' highlight the VIN input field, the completion status, and the 'Check applicability for VIN' link, respectively.

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

a) 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

b) Enter the VIN and vehicle mileage into the site

3. 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.

ORIGINAL Airbag Assembly Serial Number

Scan or enter the **original** Airbag Assembly serial number into the website.

VIN:
Model / Campaign:

* Serial Number of *Original Airbag Assembly*:

* Re-confirm the Serial Number of *Original Airbag Assembly*:

Check if the airbag serial number is missing or not visible, or if installing a new airbag assembly



AIRBAG SERIAL NUMBER IS MISSING OR IS UNREADABLE

NOTE: Skip this section and jump to Section X if the airbag assembly is scannable



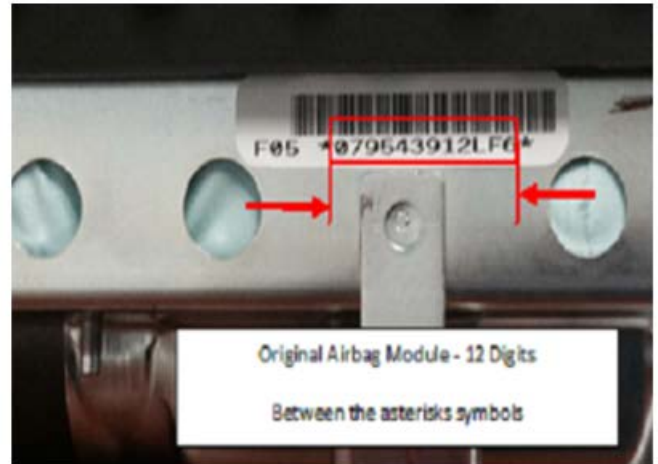
If the airbag serial number and barcode are not legible or are not present, check the box in the application indicating the serial number is not legible and contact your regional representative.

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

ORIGINAL Airbag Assembly Serial Number

Scan or enter the **original** Airbag Assembly serial number into the website.

VIN:
Model / Campaign:
* Serial Number of *Original* Airbag Assembly:
* Re-confirm the Serial Number of *Original* Airbag Assembly:
 Check if the airbag serial number is missing or not visible, or if installing a new airbag assembly
Search



Checking this box requires Air Bag Assembly replacement.

****Note** Contact your region in the event that you are unable to read the serial number.
DO NOT ATTEMPT TO INSTALL INFLATOR**

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

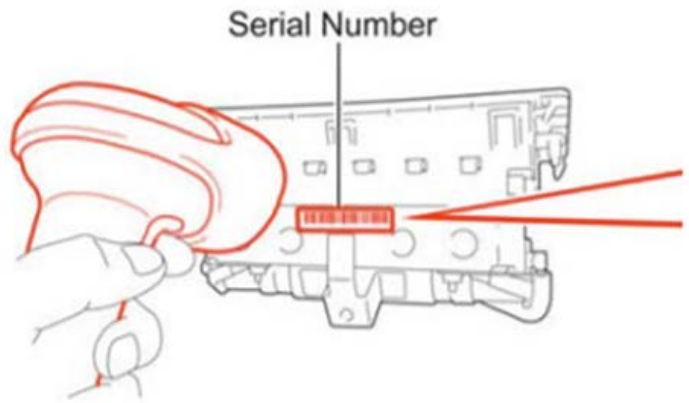
NEW Serial Number

Scan or enter the **new** Airbag Assembly Serial Number into the website.

VIN:

* Serial Number of New Airbag Assembly:

* Re-confirm the Serial Number of New Airbag Assembly:



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

Skip to Section XI If a new airbag assembly was installed instead of an inflator

X INFLATOR REPLACEMENT

1. WORKING WITH AN AIRBAG

a) Carefully place the airbag on the bench inflator side up.

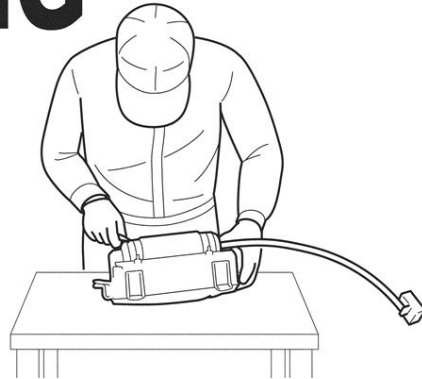
NOTE: Place clean sheet(s) of paper on the bench to protect the airbag.

b) Avoid standing directly over the inflator.

OK



NG



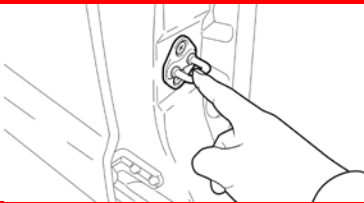
* Images of parts shown above may differ from the actual ones.

R1301230008E

STOP

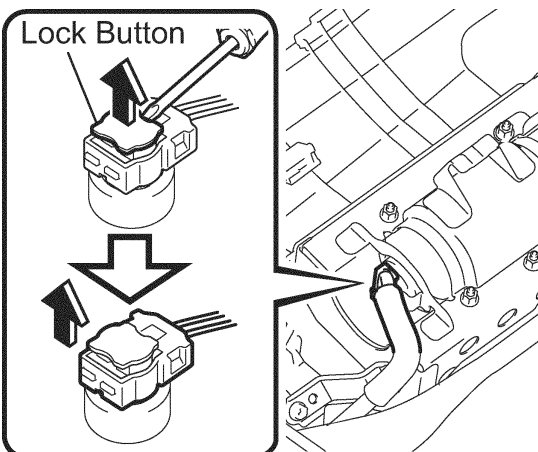
CRITICAL INFORMATION – READ THOROUGHLY

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.

Lock Button



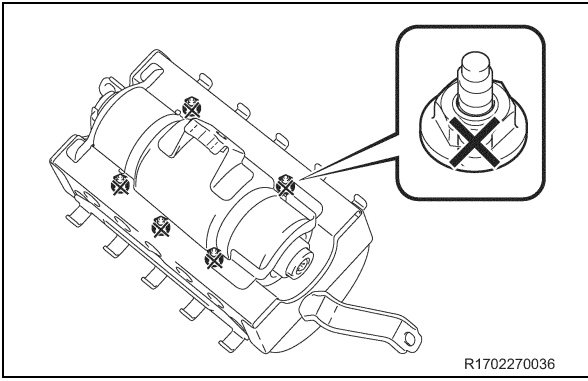
2. AIRBAG PREPARATION

a) Use a screwdriver to release the lock button.

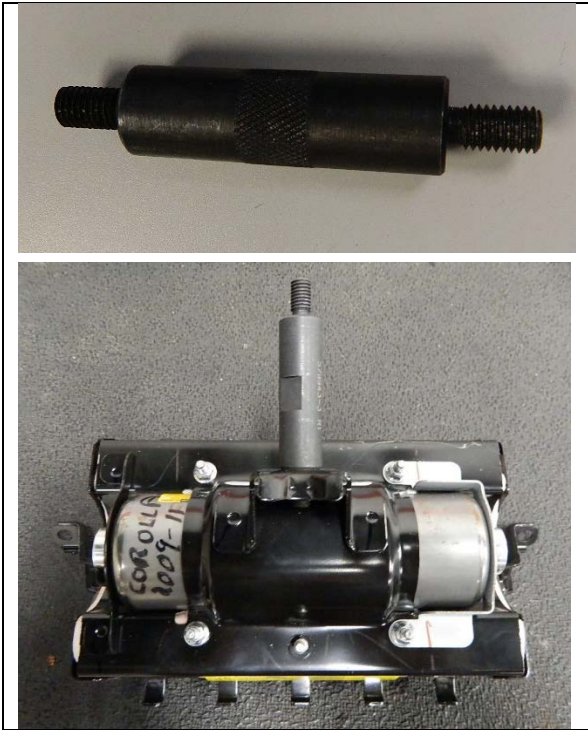
b) Disconnect the connector.

c) Disconnect the wire harness clamps.

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

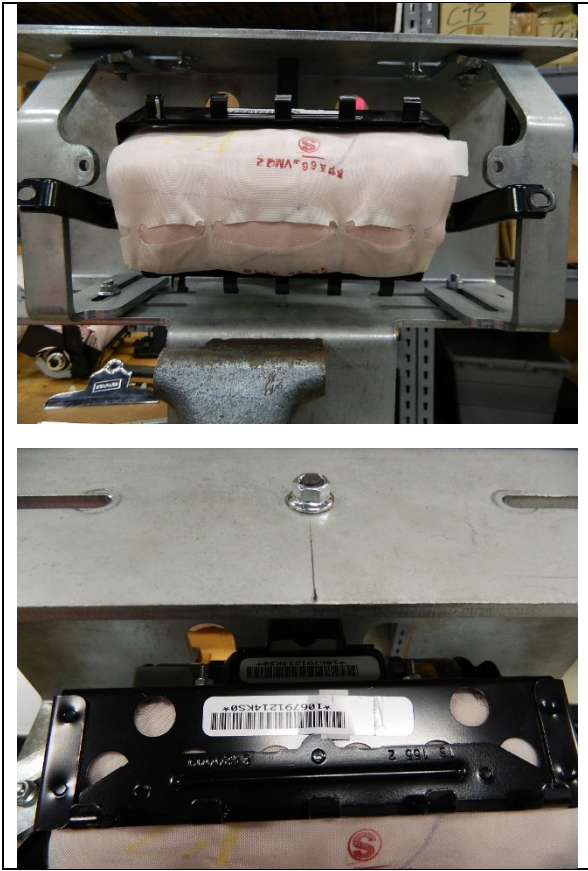


d) Mark all 5 nuts so they will not be reused.

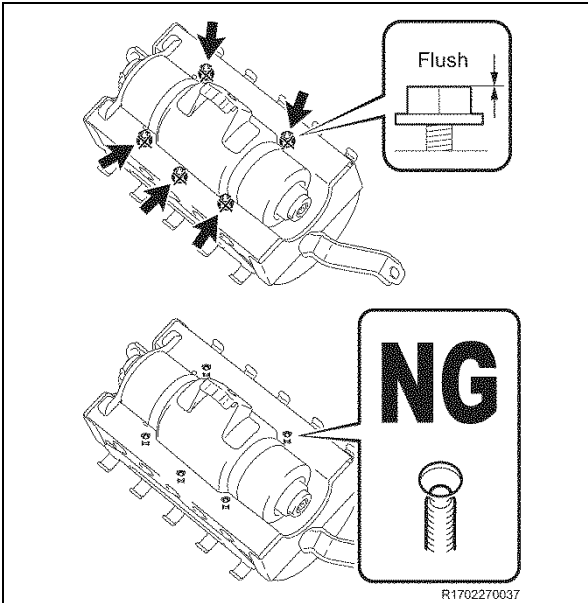


e) Use the long adaptor shown.

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.

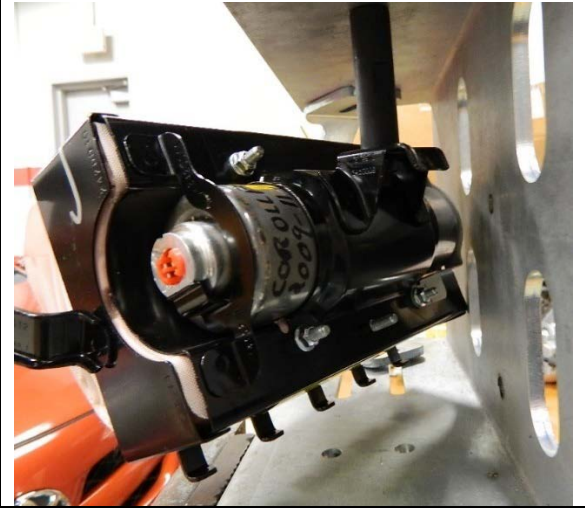


- g) Mount the airbag into the mounting bracket as shown. Pass the stud on the adaptor through the hole, on the top in the middle of the bracket, and secure with the nut.

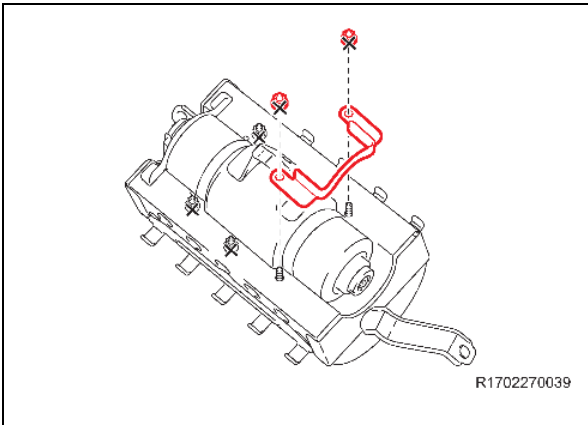


3. REMOVE THE SELF LOCKING NUTS

- 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.



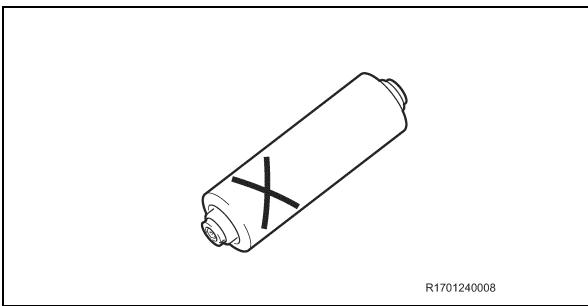
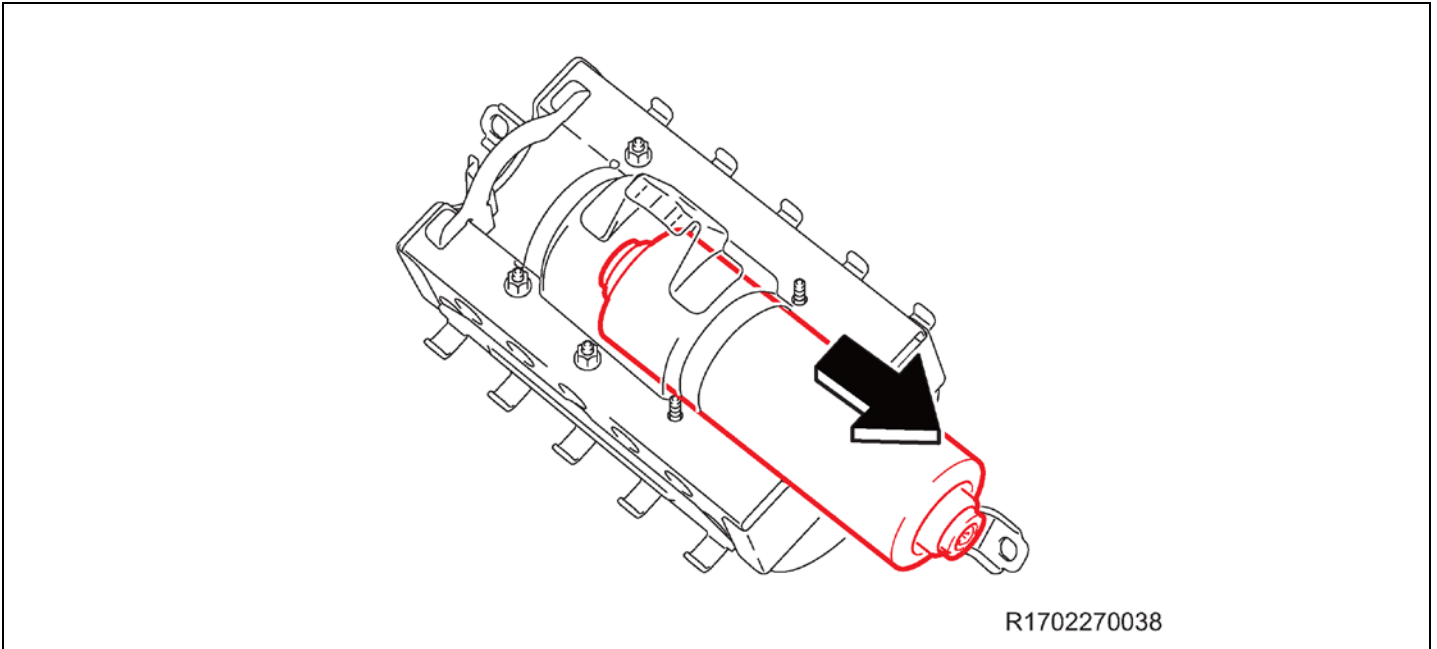
- b) Remove the 2 nuts on the end where the bracket is removable.
- c) Remove the bracket and discard.
- d) Reinstall the 2 nuts, until the nut is flush with the top of the stud.

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.



- 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.



**ENSURE YOU ENTER BOTH THE OLD AND NEW INFLATOR SERIAL NUMBERS IN THE APPROPRIATE SPOT OF THE APPLICATION
-DO NOT ENTER THE AIRBAG SERIAL NUMBER FOR THIS STEP-**



5. SCAN THE OLD AND NEW INFLATOR SERIAL NUMBER

- a) Scan the **OLD** inflator serial number and mark the old inflator so that it will not be reused.
- b) Scan the **NEW** inflator QR code.

ATTENTION: This information is CRITICAL

- It is used to confirm the correct inflator is removed from the vehicle.
- It is recorded by TMS to trace the return parts shipment.
- It is used to track the new inflator that is being installed in the vehicle.

ORIGINAL Inflator Serial Number

Scan or enter the **original** Inflator serial number into the website.

VIN: 2T1BR32E57C810829
 Model / Campaign: 2007 Corolla / E04

* Serial Number of **Original** Inflator:

* Re-confirm the Serial Number of **Original** Inflator:

Check if the inflator serial number is missing or not visible, OR if installing a new airbag assembly

Search



REPLACEMENT Inflator Serial Number

Scan or enter the **replacement** Inflator serial number into the website.

VIN: 2T1BR32E57C810829
 Model / Campaign: 2007 Corolla / E04

* Serial Number of **Replacement** Inflator:

* Re-confirm the Serial Number of **Replacement** Inflator:

Search



c) If the inflator serial number cannot be scanned or is not present check the box as shown below.

ORIGINAL Inflator Serial Number

Scan or enter the **original** Inflator serial number into the website.

VIN: 2T1BR32E57C810829
Model / Campaign: 2007 Corolla / E04

* Serial Number of Original Inflator:

* Re-confirm the Serial Number of Original Inflator:

Check if the inflator serial number is missing or not visible. OR if installing a new airbag assembly



Checking this box requires Air Bag Assembly replacement.

****Note** Contact your region in the event that you are unable to read the serial number.**

DO NOT ATTEMPT TO INSTALL INFLATOR

d) Confirm agreement by checking the two boxes.

e) Record the Warranty Authorization # to be included in the warranty claim.

f) Place the old inflator in the parts box and take 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 e)

Takata Scan App (TEST v2) Final Results

You can [Print Screen](#) or [Search Another VIN](#).

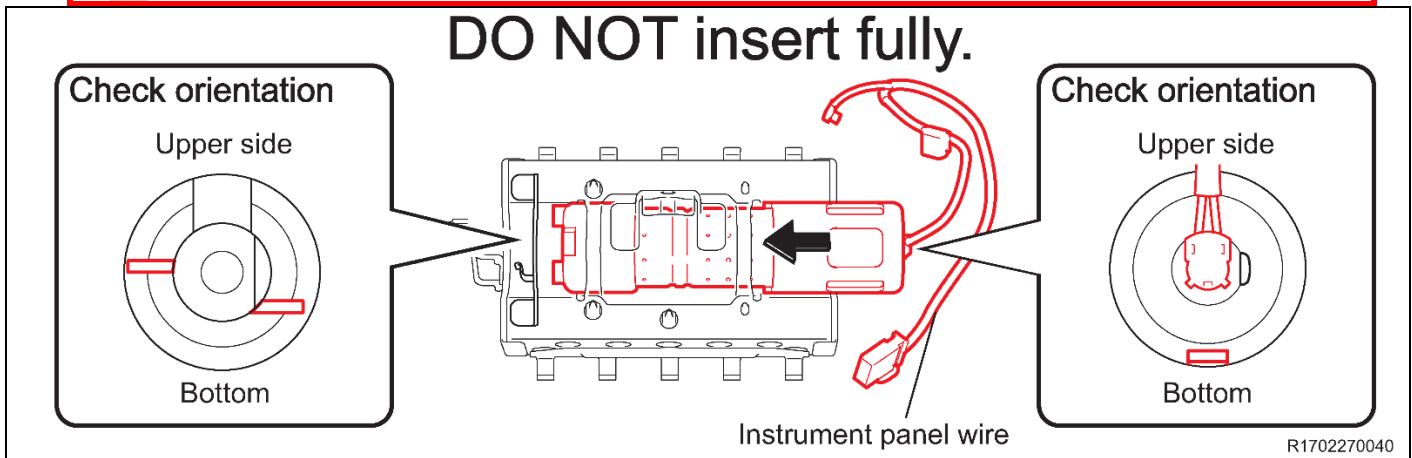
Results:	Inflator Replacement Required
Warranty Authorization Number:	77515K46 <small>This number is required for the warranty claim. Print and save this screen for your records.</small>
VIN:	2T1BR32E57C810829
Vehicle:	2007 Corolla
Campaign:	E04
Original Airbag Serial:	123456789K12
Replacement Airbag Serial:	
Original Inflator Serial:	W0123456789
Replacement Inflator Serial:	W0123456789
Scan Date:	12/22/2020 08:47AM (mm/dd/yyyy)

6. INSTALL THE NEW INFLATOR

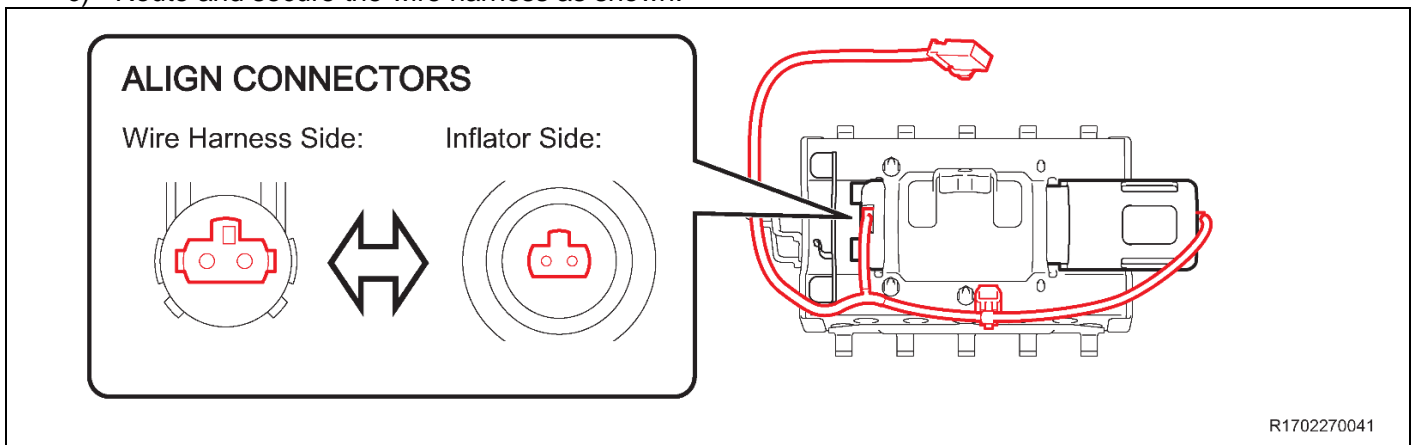
a) Carefully slide the new inflator into the airbag assembly and align as shown.



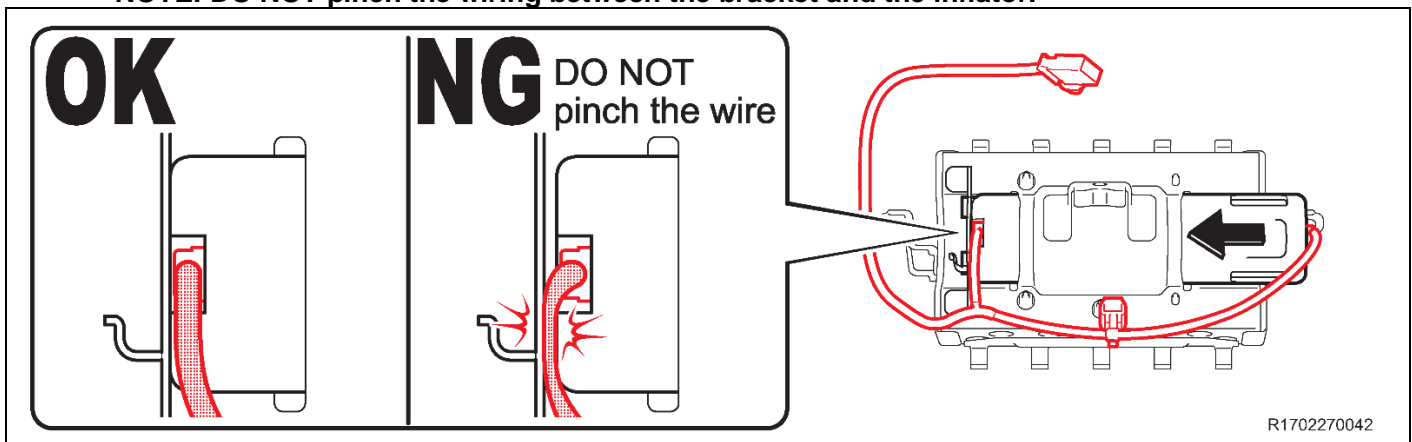
- **DO NOT** connect the inflator harness at this time. It is **CRITICAL** to first confirm that the inflator is installed in the correct position before connecting the harness.

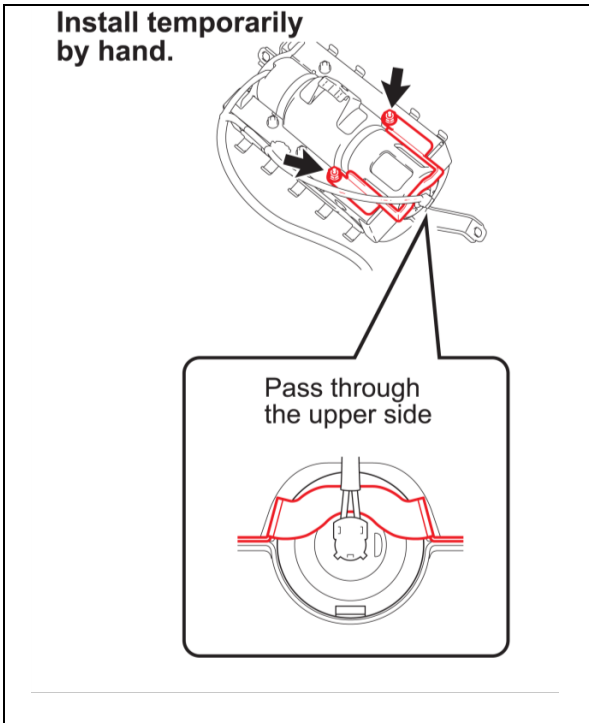
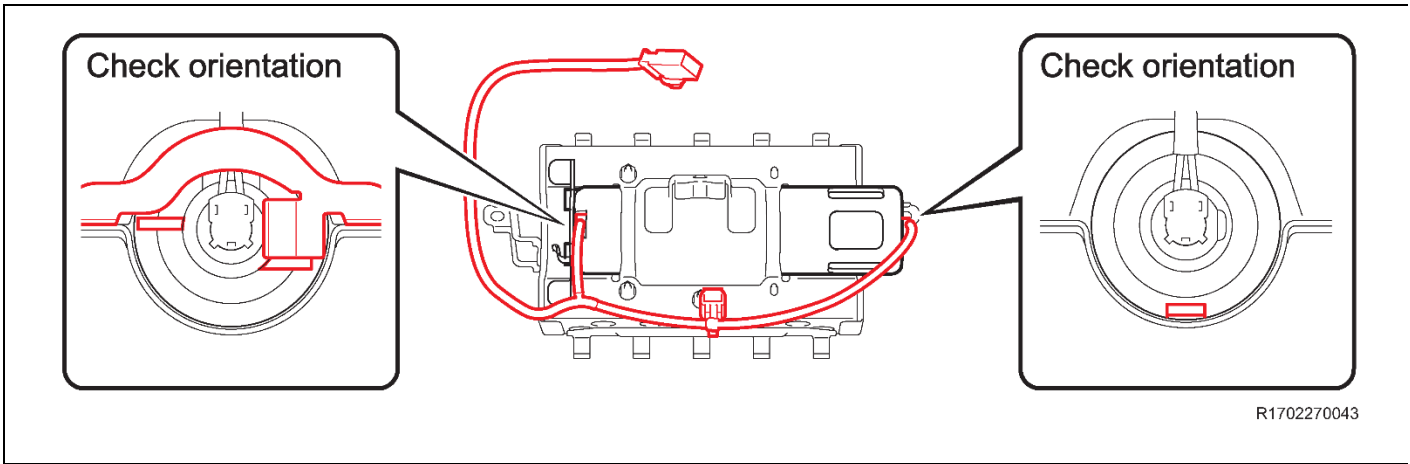


- b) Connect the connector to the inflator and ensure that the connector lock is fully engaged as shown.
c) Route and secure the wire harness as shown.

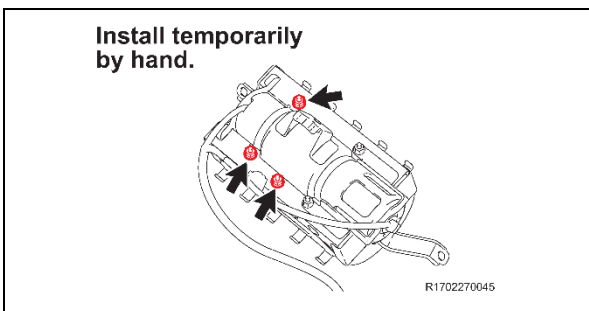


- d) Fully insert the inflator and ensure that the inflator is correctly oriented as shown.
NOTE: DO NOT pinch the wiring between the bracket and the inflator.





- 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.

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

7. TORQUE THE PLATE NUTS

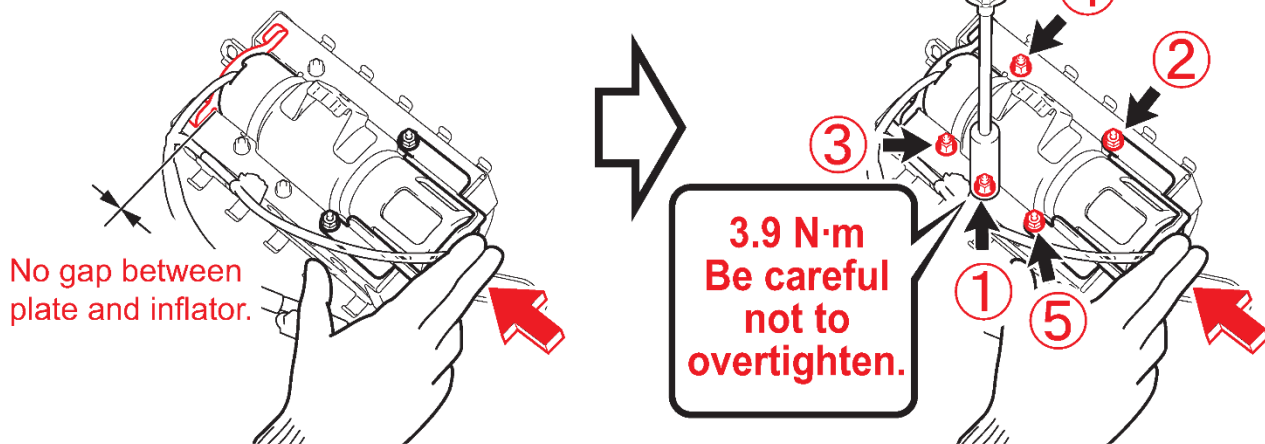
- a) Tighten the 5 nuts evenly in several increments in the sequence shown. Use a socket driver or torque wrench to tighten the nuts.

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.

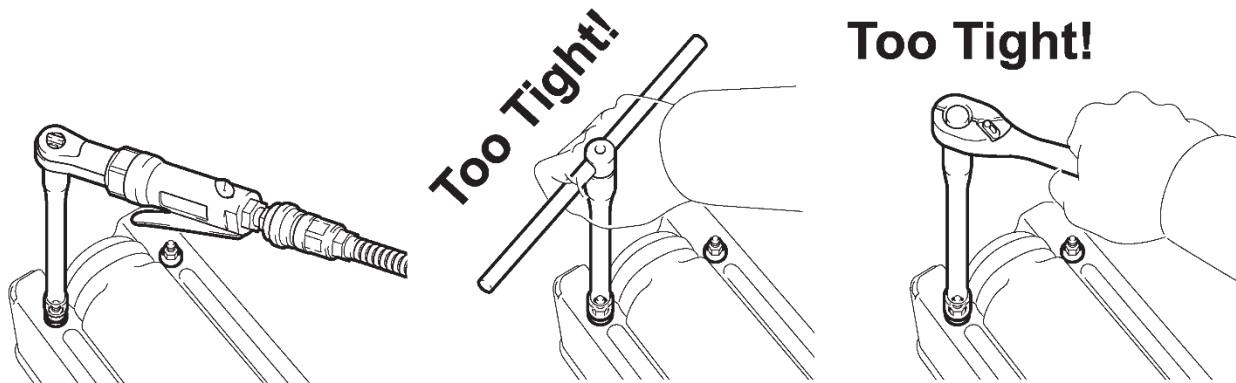
OK



NG

NG

NG



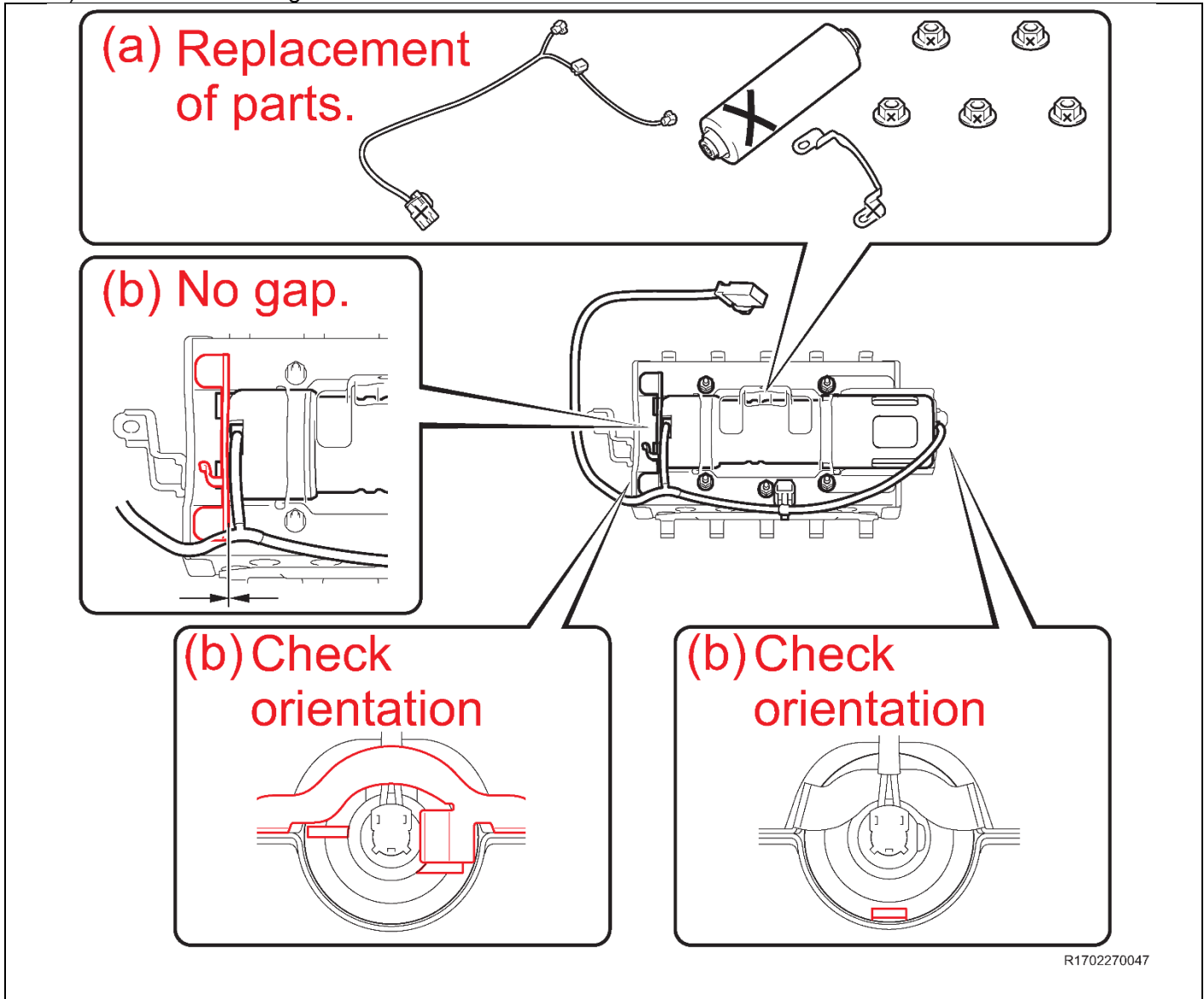
These tools cause overtightening !

R1702270046

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

8. INSPECT THE AIRBAG BEFORE INSTALLATION

- a) Confirm the **NEW** inflator and 5 **NEW** nuts have been installed.
- b) 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.
- c) Confirm the routing of the inflator wire harness.



XI FRONT PASSENGER AIRBAG ASSEMBLY INSTALLATION

1. REINSTALL THE AIRBAG ASSEMBLY
 - a) 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

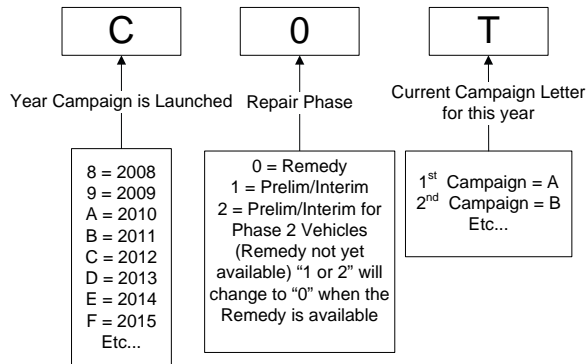
◀ VERIFY REPAIR QUALITY ▶

- 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