

**TECHNICAL INSTRUCTIONS**  
**FOR**  
**SAFETY RECALL DSC,ELG,JLI,JLJ,JLK**  
**FRONT PASSENGER AIRBAG INFLATOR MODULE**  
**CERTAIN 2002 – 2010 MODEL YEAR SC 430**

**Update 3/25/22**

- The technical instructions for DSC,ELG,JLI,JLJ,JLK have been combined
- Added a new section for Takata Desiccated Part Recovery

**Update 1/14/21**

- The scanning application process has been updated

**Update 10/17/19**

- The model year range has been expanded to 2010 model year

**Update 6/9/19**

- The scanning process has been updated

**Update 12/18/18**

- Images have been updated to reflect new part design

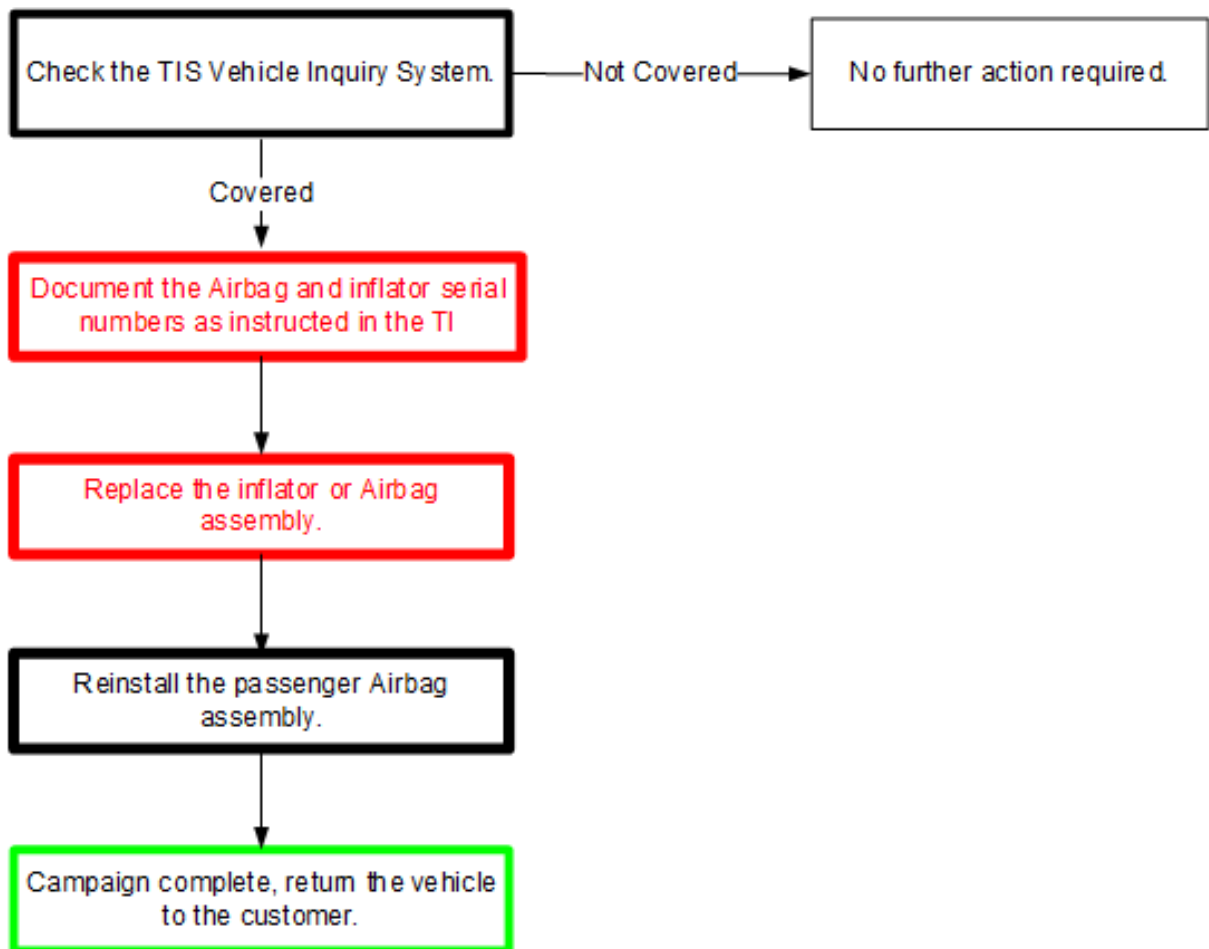
**All dealership associates involved in the recall process are required to successfully complete E-Learning course LSC13A. To ensure that all vehicles have the repair performed correctly; technicians performing this recall repair are required to have successfully completed E-Learning course LSC13B, in addition to LSC13A, and currently hold at least one of the following certifications levels:**

- **MASTER SERVICE TECHNICIANS**
- **MASTER DIAGNOSTIC SPECIALISTS**

**NOTE: To support additional service capacity, Lexus Certified and Senior Service Technicians, with at least 36 months Lexus experience AND L652 course credit, may also perform this repair following successful completion of course LSC13B.**

## I. OPERATION FLOW CHART

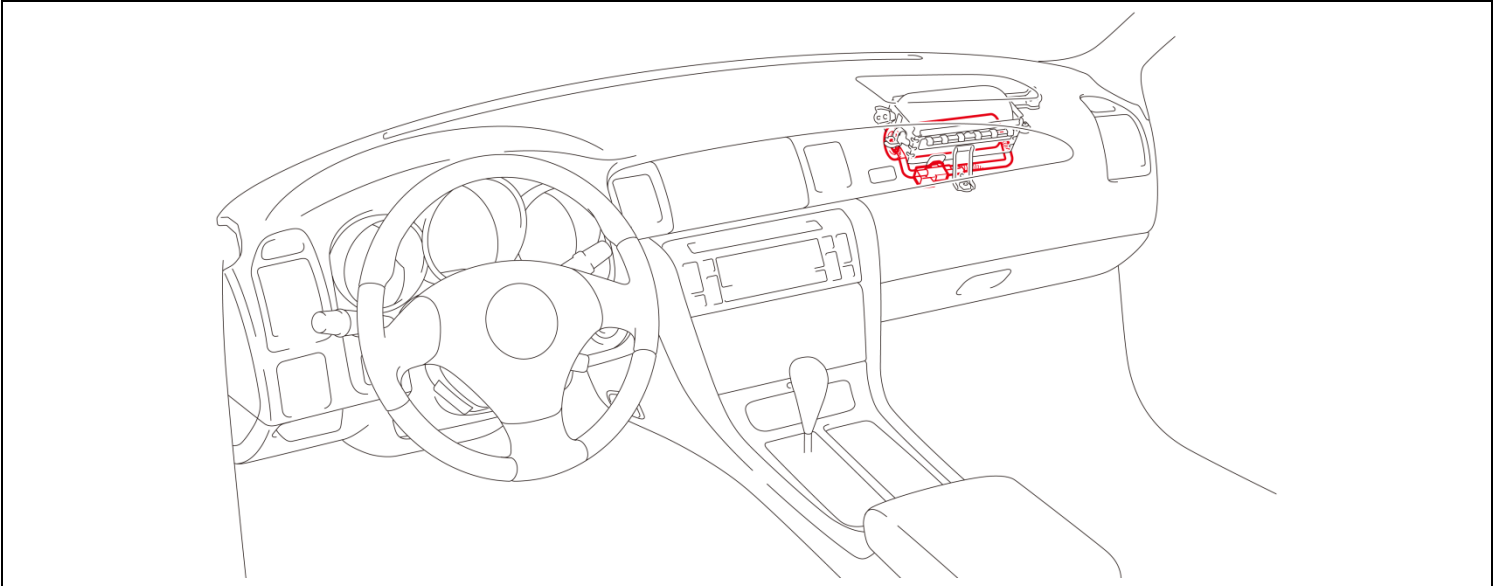
The flow chart is for reference only. **DO NOT** use it in place of the full technical instructions. Follow **ALL** steps as outlined in the full technical instructions to confirm the campaign is completed correctly.



**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

### A. COVERED VIN RANGE

- 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

Part Number	Part Description	Quantity
04008-03124 2002-2010 MY	INFLATOR ASSY KIT, INSTR PNL AIR BAG*	1
*The kit above includes the following parts.		
Inflator		1
Position Determining Plate		1
Self Locking Nut		4
Electro Tap		1

### 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
SC 430	2002-2010	04003-28124 04005-09524	INFLATOR ASSY KIT, INSTR PNL AIR
		73960-24010 73960-24030	AIR BAG ASSY, INSTR PNL PASS

**Lexus 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 non-desiccated parts listed below for recall, customer pay repairs AND over-the-counter sales (if applicable).**

Model	Model Year	Part Number	Part Description
SC 430	2002-2010	04006-05324 04006-05424	INFLATOR ASSY KIT, INSTR PNL AIR
		73960-24011 73960-24031	AIR BAG ASSY, INSTR PNL PASS

**Lexus 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*.**

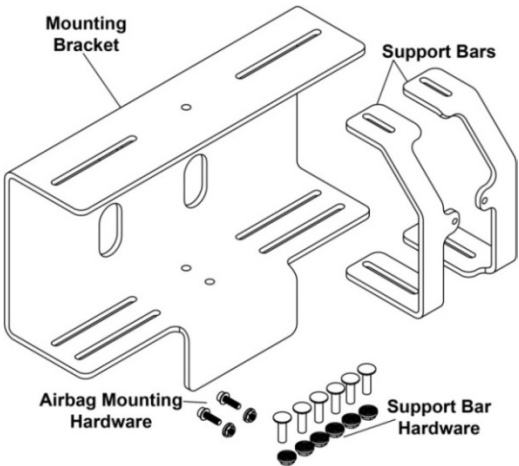
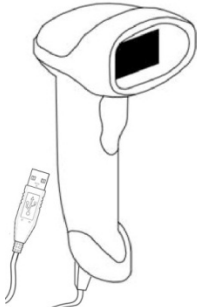
#### Important Note:

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

## B. TOOLS & EQUIPMENT

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

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

Image	Name	Quantity
 A technical line drawing of an airbag mounting bracket assembly. It includes a large L-shaped 'Mounting Bracket' with slots and holes. Two 'Support Bars' are shown separately, one of which is being inserted into the bracket. Below these, there are two groups of hardware: 'Airbag Mounting Hardware' (small screws and bolts) and 'Support Bar Hardware' (longer screws and bolts).	Airbag Mounting Bracket & hardware	1
 A line drawing of a handheld barcode scanner. It has a rectangular scanning head at the top and a handle with a trigger button. A USB cable is attached to the bottom of the handle.	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 area representative.

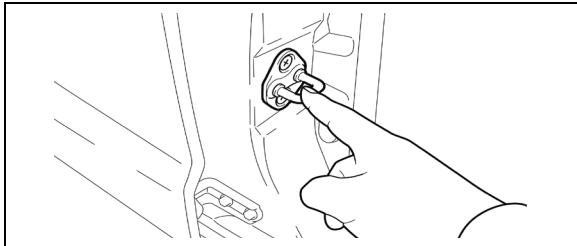
## V. SAFETY PRECAUTIONS



### CRITICAL INFORMATION – READ THOROUGHLY

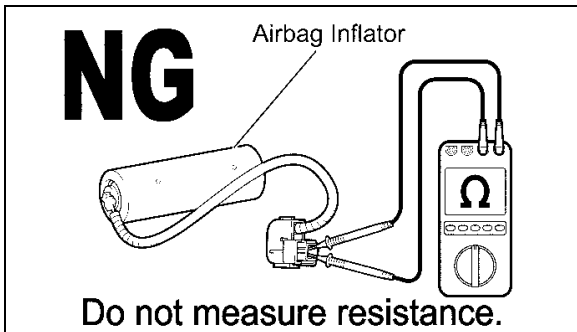


Failure to follow these procedures correctly could cause the SRS to unexpectedly deploy during servicing or the SRS may fail to operate correctly when required after reassembly. Confirm all work is performed as described in these instructions.



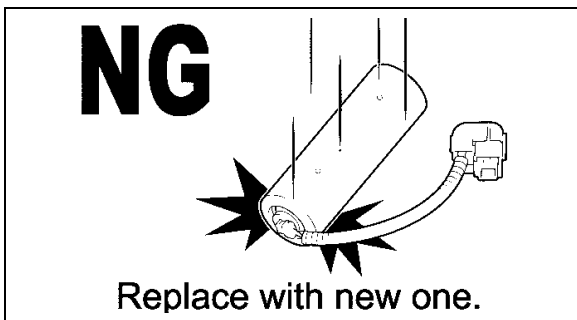
#### 1. ELIMINATE STATIC ELECTRICITY

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



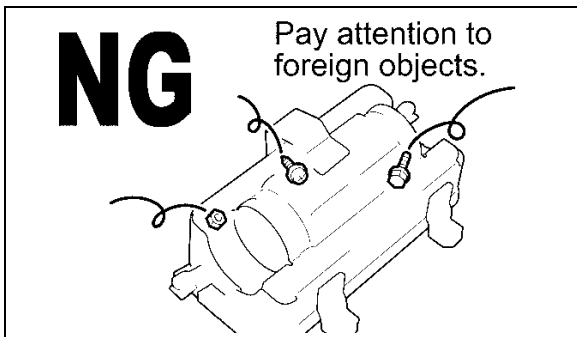
#### 2. DO NOT MEASURE RESISTANCE

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



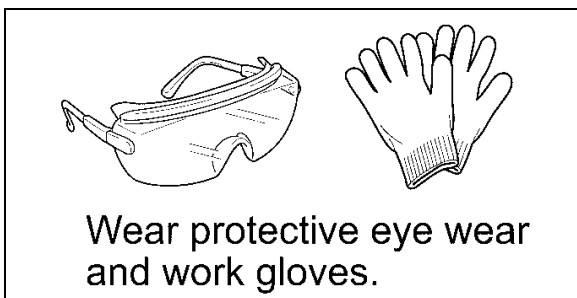
#### 3. HANDLE THE AIRBAG CAREFULLY

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



#### 4. DO NOT ALLOW FOREIGN OBJECTS NEAR AIRBAG

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



#### 5. WEAR PROTECTIVE EQUIPMENT

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

## VI. 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 **MUST** be entered manually.

**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.**

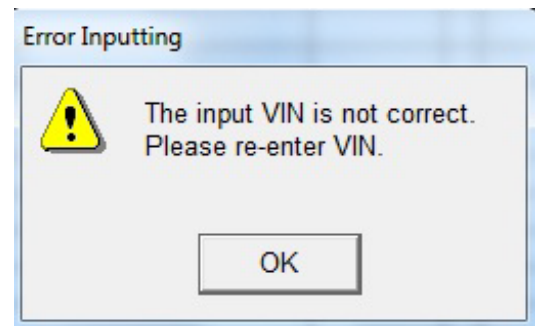
- Perform a health check.

**Note: The VIN may auto populate on the later model year vehicles, if this happens DO NOT change the VIN.**

### 2. RUN A DIAGNOSTIC REPORT

- After the health check has completed, run a diagnostic report by clicking on the link on the health check screen.

**NOTE: If the VIN was not entered in ALL CAPS when Techstream was launched, an error will be displayed and there will be a prompt to reenter the VIN**



- Enter the vehicle mileage and repair order information, then click the 'report' button.



- The VIN **MUST** be entered manually in ALL CAPS when launching the Techstream software, the VIN **WILL NOT** auto-populate due to vehicle age.
- A health check and diagnostic report with VIN **MUST** be performed within the last 36 hours and recorded by TMNA. If the diagnostic report is not run, the healthcheck will not be recognized by TMNA.
- The serial number recording application will be disabled and the inspection cannot be completed if a health check and diagnostic report is not performed and recorded by TMNA.

## VII. WORK AREA PREPARATION

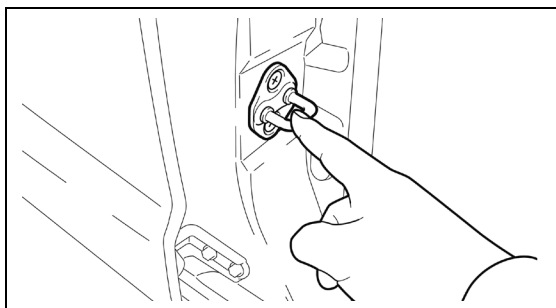
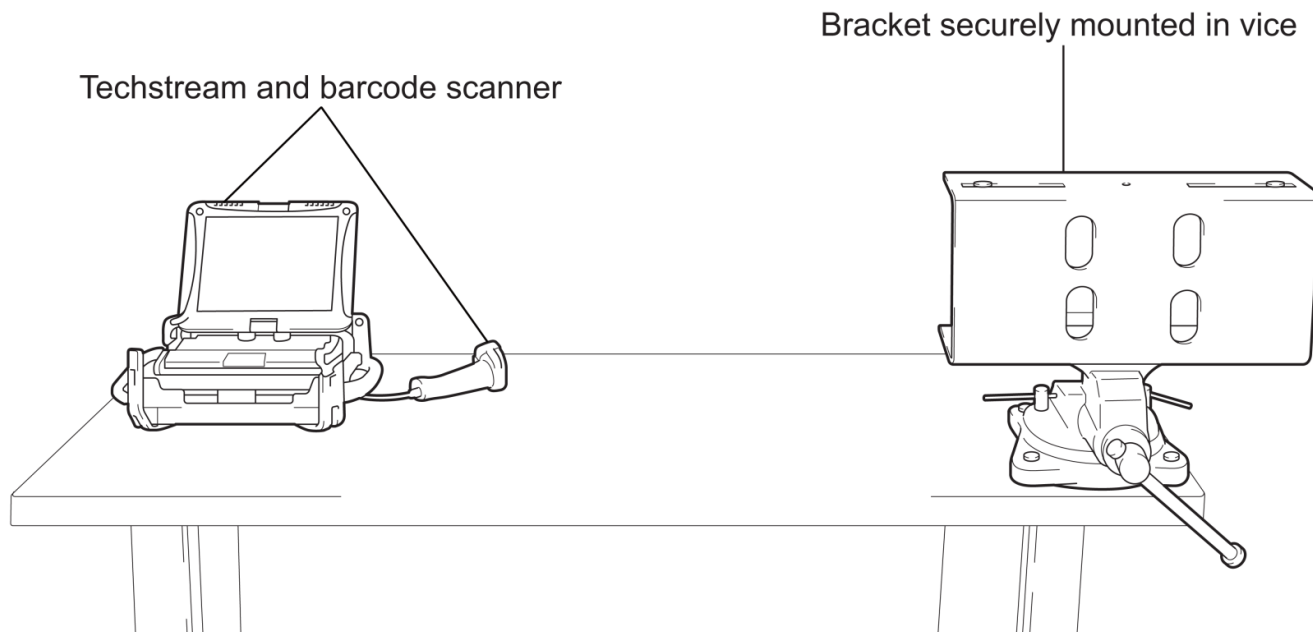


## CRITICAL INFORMATION – READ THOROUGHLY



The bracket assembly that was provided at the launch of SSC DLC 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. 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).



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. FRONT PASSENGER AIRBAG ASSEMBLY REMOVAL

### 1. DISCONNECT THE NEGATIVE BATTERY TERMINAL



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

### 2. REMOVE THE INSTRUMENT PANEL SAFETY PAD SUB-ASSEMBLY

a) Refer to TIS for removal instructions

[2002-2005 MY](#)

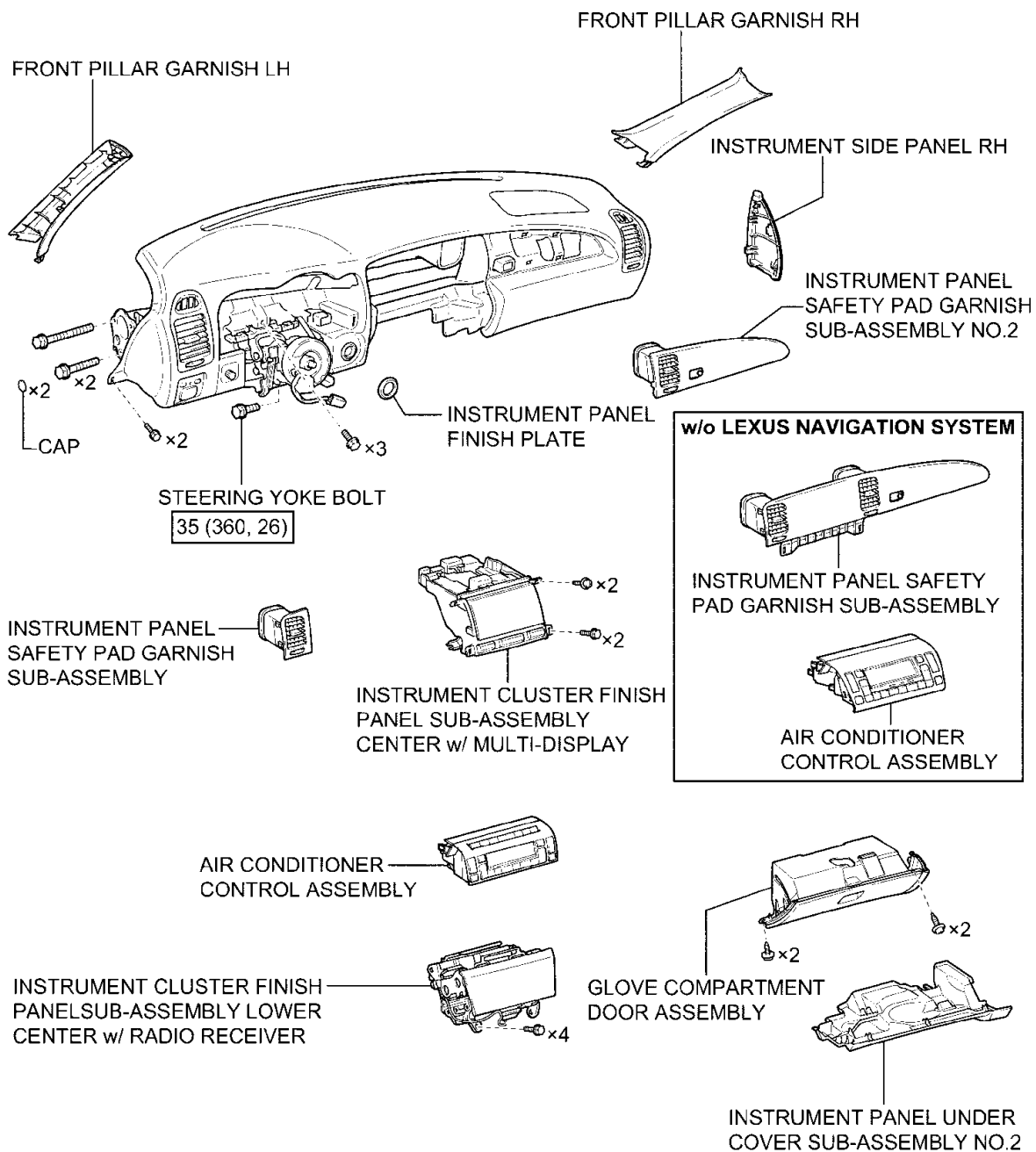
[2006MY](#)

[2007MY](#)

[2008MY](#)

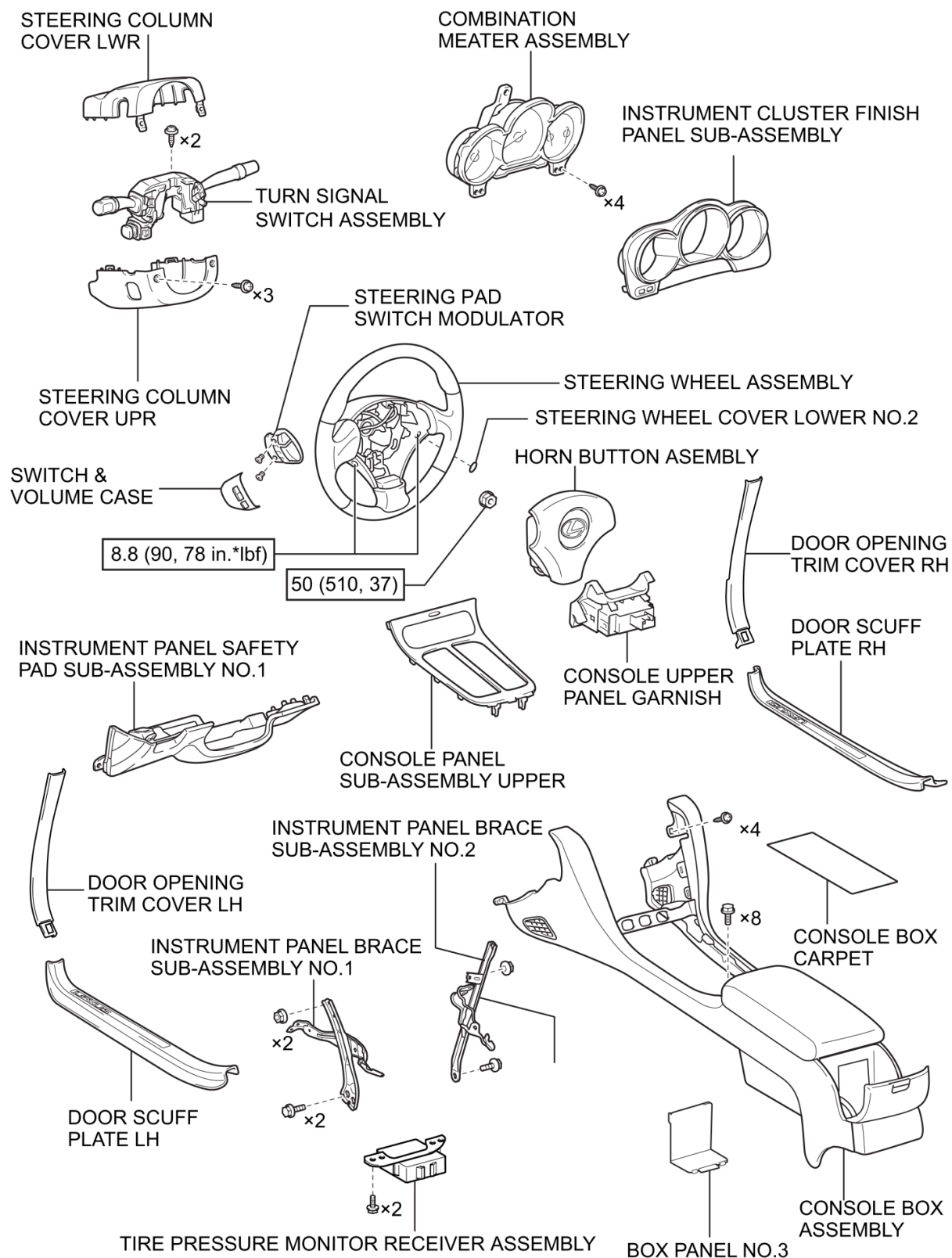
[2009MY](#)

[2010MY](#)



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

B51330



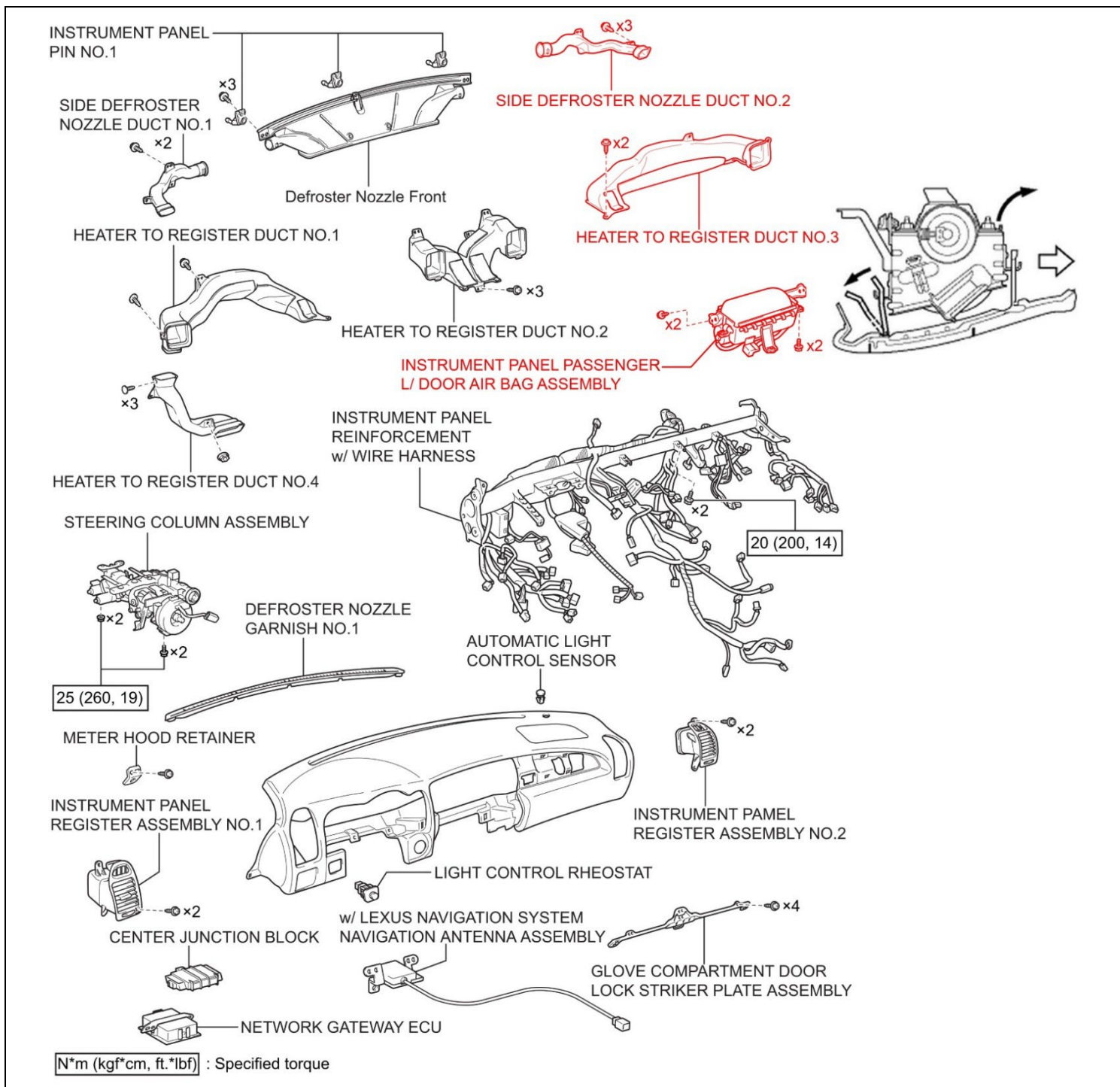
[N·m (kgf·cm,ft·lbf)] :Specified torque

B52001

### 3. REMOVE THE AIRBAG FROM THE INSTRUMENT PANEL

- Remove the 3 screws and the side defroster nozzle.
- Remove the 2 screws and the heater to register duct.
- Remove the 4 bolts, disengage the straps, and then remove the airbag assembly.

**NOTE: Only remove the components highlighted in red; there is *NO NEED* to remove any other components.**



## IX. AIRBAG ASSEMBLY RECORDING

### 1. LAUNCH THE SERIAL NUMBER RECORDING APPLICATION

[Video Supplement: Serial Number Recording](#)

**Note:** The Serial Number Recording Application for ELG is the same application used for DSC.



- The **AIRBAG ASSEMBLY**, **ORIGINAL INFLATOR**, and **NEW INFLATOR** serial numbers **MUST** be recorded using the barcode scanner (provided at the launch of SSC DLC).
- 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 (Toyota Information System) interface. At the top, there are navigation tabs: Home, TIS, TAS, PRS, QAT, and a Toyota logo with links for Help, My Account, and Logout. Below these are sub-tabs: Library, Diagnostics, Tech Assistance, and Vehicle Inquiry (which is selected). The main content area is titled 'Vehicle Identification Number Search' and contains a form with the instruction 'Enter a 17-Digit VIN below to search for applicable information:'. The VIN field is populated with '1NX-BR32E-000000000' and is circled in red with a red 'a)' next to it. There are 'Clear' and 'Lookup' buttons. Below the search form is a section titled 'Vehicle Information' containing a table of vehicle details: Division: TOYOTA, Model: Corolla, Grade: CE, Model Year: 2003, Drive Type: 2WD, Body Type: 4Dr. Sedan, Engine Family: 4-cylinder - 1ZZ, Transmission: (blank), Date of First Use: (blank), Production Date: 01/18/2002, Plant Code: Z - FREMONT PLANT - NUMMI, VIN: 1NX-BR32E-000000000, and Standard Equipment: Click here to display. Below this table are fields for Exterior Color (03MS, SANDRIFT METALLIC), Interior Color (FA41, FA41), Interior Trim Color (FA, \*), and Interior Fabric (F, \*). A message states 'Vehicle accessories are not currently available. Try your query again later.' Below the vehicle information is a section titled 'Service Campaign' with tabs for Campaign, Service History, Warranty, DTC History, and Diagnostic Report. The Campaign tab is selected, showing a 'Campaign Description' for a Safety Recall D0F Remedy Notice for 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' and is circled in red with a red 'b)' next to it. Below the status is a link '[Show Documents]'. At the bottom of the campaign section, there is a red circle around the text 'check applicability for VIN' with a red 'c)' next to it, and another red circle around the text 'E04' with a red 'd)' next to it. The footer of the page includes '© 2013 Toyota Motor Sales, Inc.' and links for Feedback, Privacy, and Legal.

# 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

## 2. 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 DLC.
- The barcode scanner works best in low light conditions.
- Always hold the scanner directly in front of and parallel to the barcode label.



### 3. SCAN THE AIRBAG SERIAL NUMBER

## ATTENTION: This information is **CRITICAL**

- Scan the **AIRBAG ASSEMBLY** serial number 2 times.
  - Confirm the cursor is in the first serial number box then scan the serial.
  - Position the cursor in the second serial number box then scan the serial.
- 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:

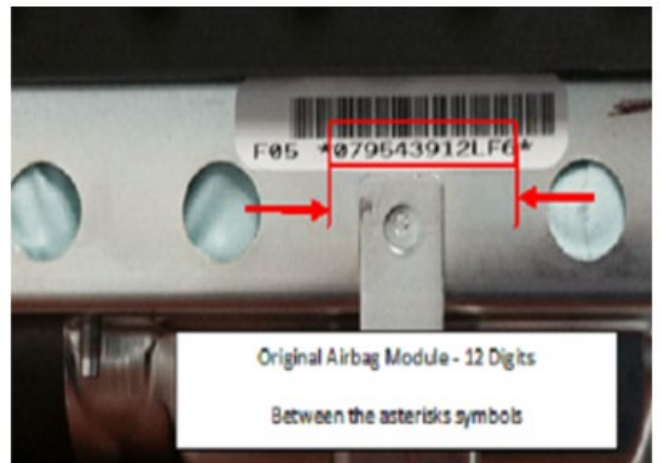
Model / Campaign:

\* 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

Search



## 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:

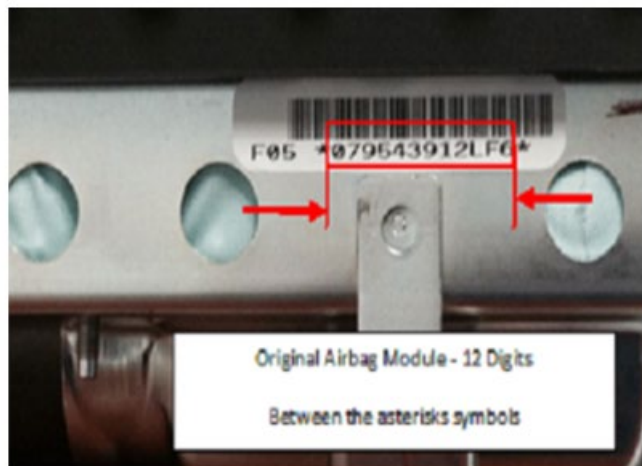
Model / Campaign:

\* 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.



Takata Scan App

TMS Test Dealership

[Search Another VIN](#) | [Print Screen](#) | [Log Out](#)

## NEW Serial Number

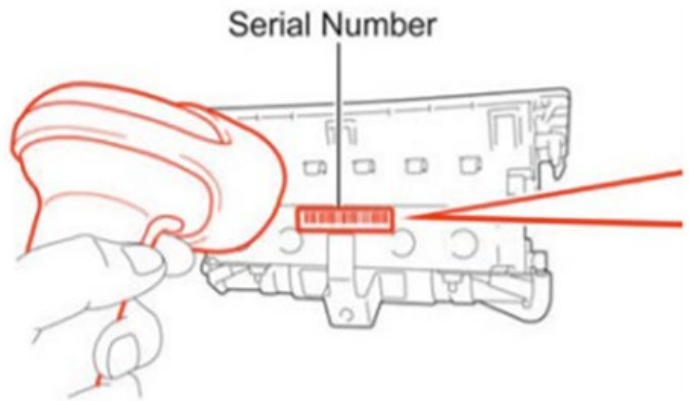
Scan or enter the **new** Airbag Assembly Serial Number into the website.

VIN:

\* Serial Number of New Airbag Assembly:

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

Search



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



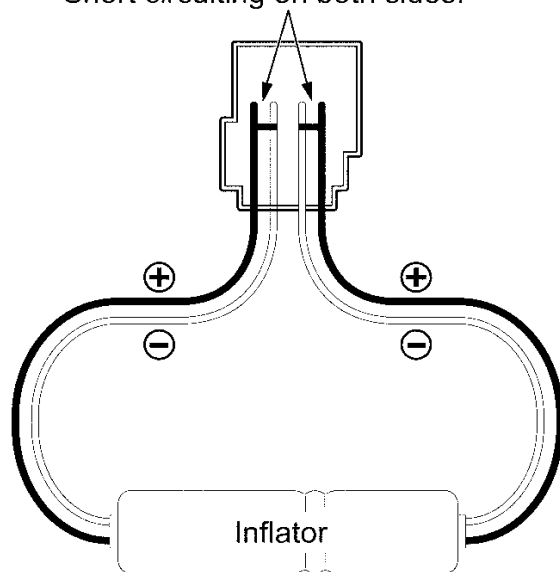
### CRITICAL INFORMATION – READ THOROUGHLY



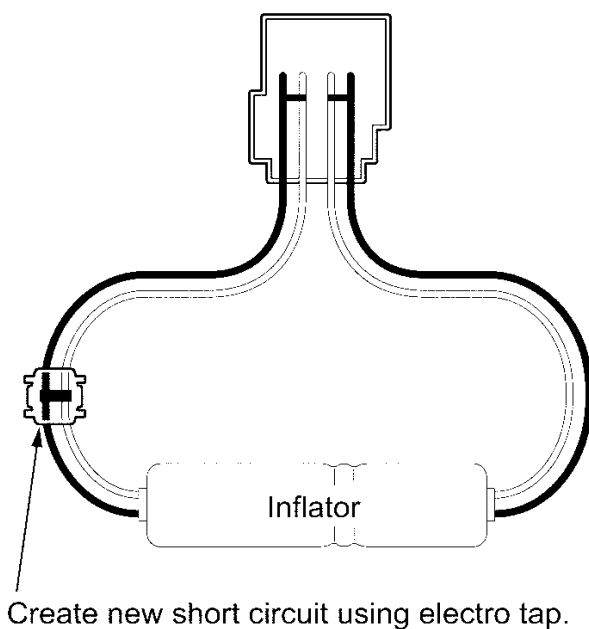
The connector of the inflator module contains a short circuiting mechanism to eliminate voltage variances when the connector (1) is disconnected. To allow for the replacement of the inflator module, a new short circuit (2) **MUST** be created before cutting the wires (3) and removing the inflator. The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

(1)

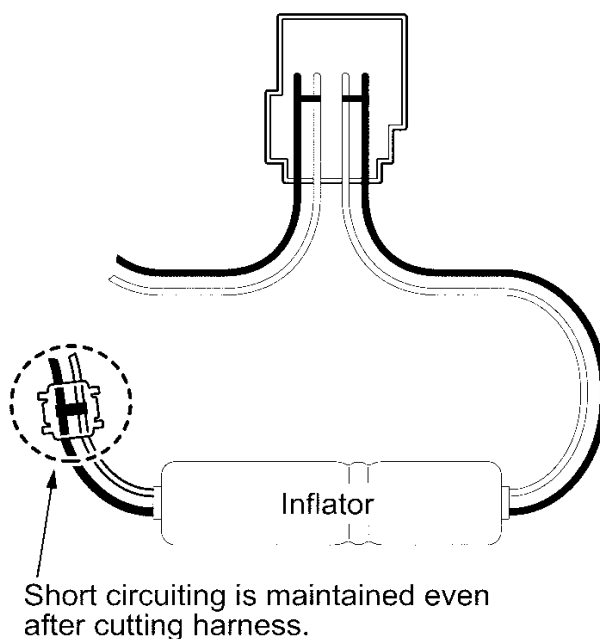
Short circuiting on both sides.



(2)

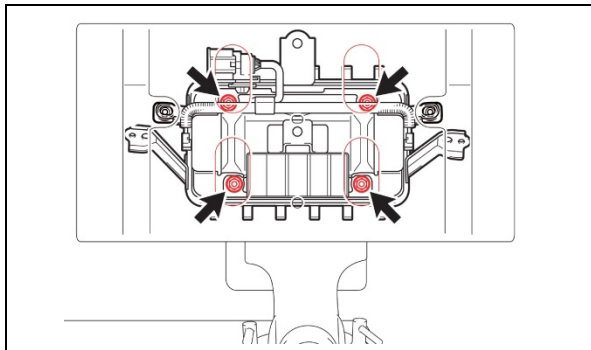
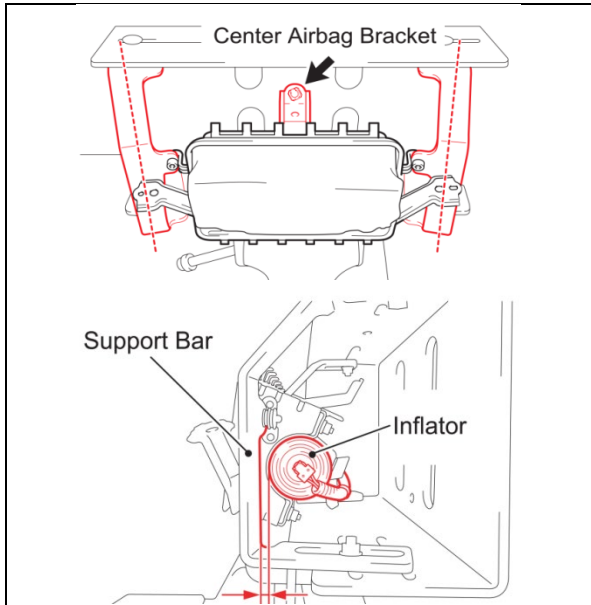
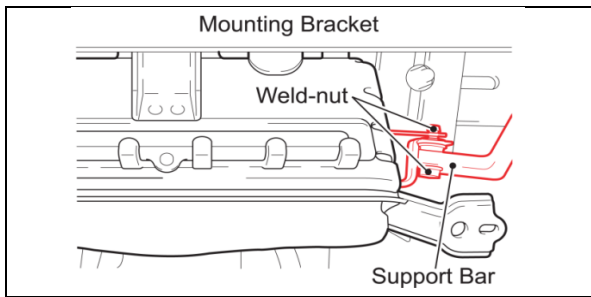


(3)



R1302250036E

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

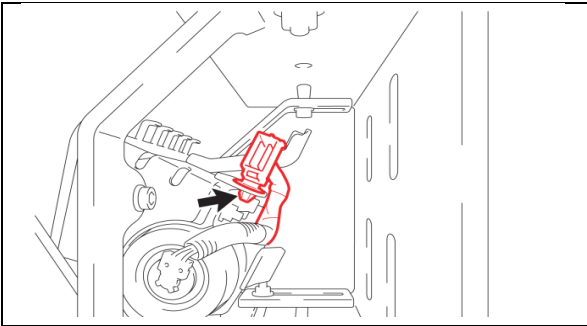


- a) Position the airbag so that the airbag weld-nuts are between the support bars and mounting bracket and install the bolts.
- b) Position the support bars at an angle as shown in the illustration.
- c) Confirm the center airbag bracket is facing up.

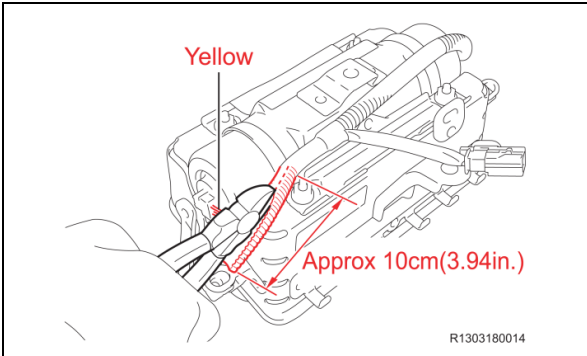
**NOTE: The position of the support bars is critical to create clearance for the removal of the inflator.**

- d) Position the airbag so that all four nuts can be removed through the access holes.
- e) Tighten the nuts holding the support bars to the mounting bracket.
- f) Confirm the following:
  - Mounting bracket is secure in the vise.
  - Airbag is secure in the support bars.
  - 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.

<div style="display: inline-block; width: 40px; height: 40px; border: 2px solid black; border-radius: 50%; display: flex; align-items: center; justify-content: center;">STOP</div> <div style="margin: 0 20px;"><b>CRITICAL INFORMATION – READ THOROUGHLY</b></div> <div style="display: inline-block; width: 40px; height: 40px; border: 2px solid black; border-radius: 50%; display: flex; align-items: center; justify-content: center;">STOP</div>	
	<p><b>ALWAYS</b> keep as much of your body as possible in front of the bracket when working on the airbag assembly.</p>
	<p><b>Remember to periodically touch a metallic part of the vehicle to discharge static electricity in the body.</b></p>
<b>2. PREPARE TO INSTALL THE SHORT CIRCUIT</b>	



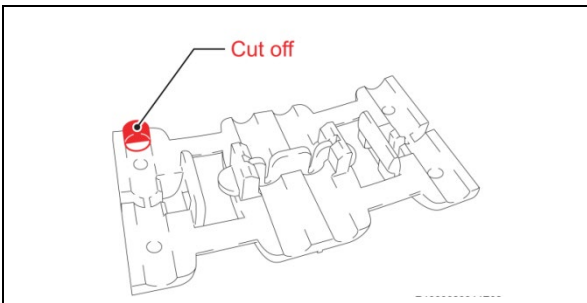
a) Disengage the harness clamp.



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



- **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.

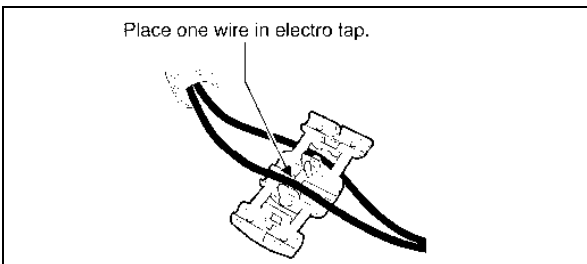


c) Cut off the tab of the electro tap shown in the illustration.

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

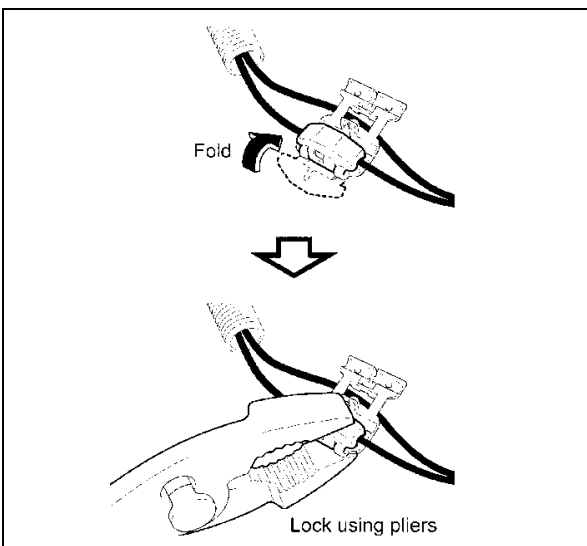


**This tab *MUST* be removed to ensure a good short.**



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

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

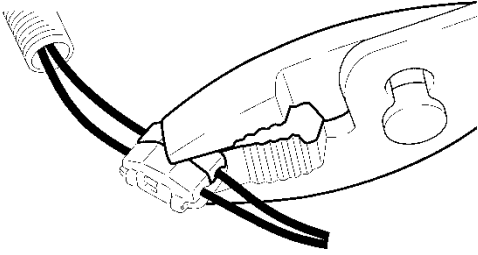


b) Fold and pinch the half of the electro tap with the wire and use pliers to lock the electro tap.

**NOTE:**

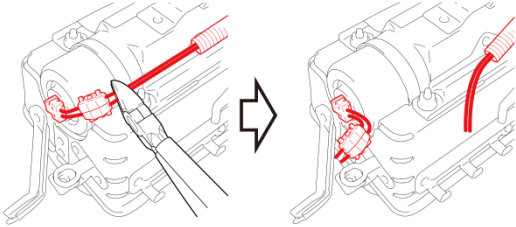
- **DO NOT** work on both wires at the same time to avoid errors.
- Pliers **MUST** be used to confirm the electro tap is firmly locked in place.

Lock the other wire.



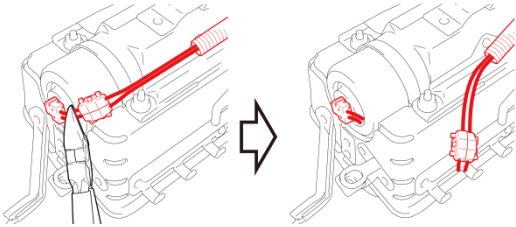
**OK**

Cut at opposite  
side to inflator



**NG**

DO NOT cut at  
inflator side



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

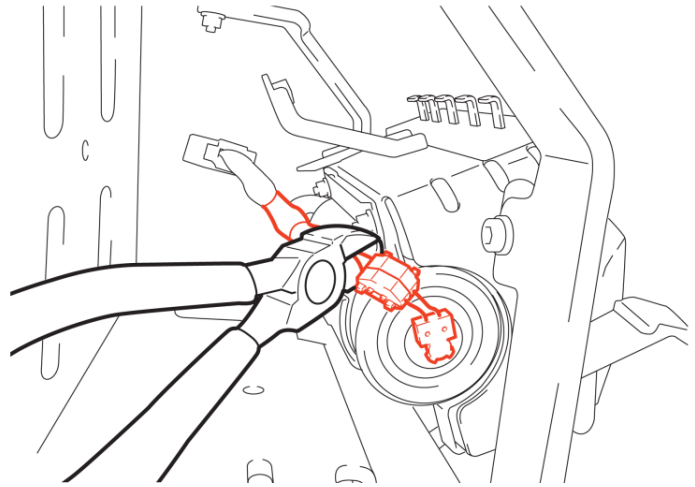
**STOP**

**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.

Cut the wires opposite the inflator



**STOP**

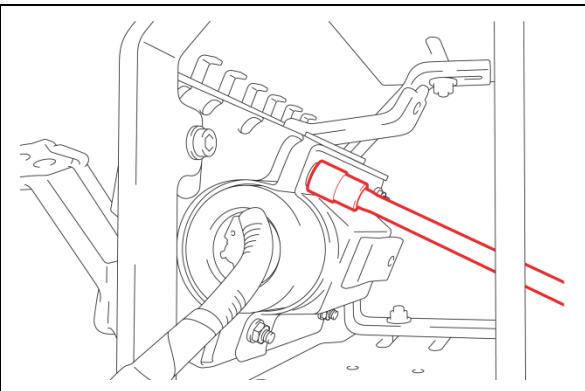
**DO NOT** measure resistance of the inflator wires, this may cause accidental activation.

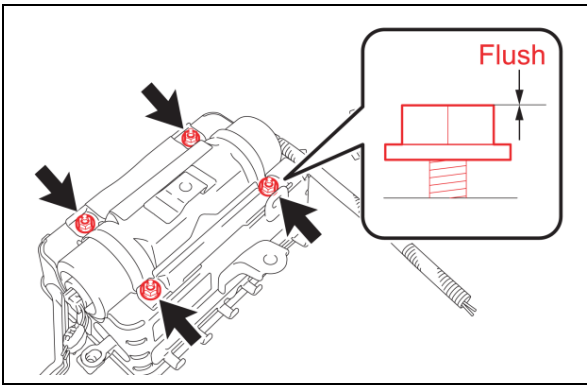
#### 5. LOOSEN THE SELF LOCKING NUTS

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

**NOTE:**

- **DO NOT** use power tools.
- **DO NOT** remove the nuts or the bag may fall out of the airbag assembly.

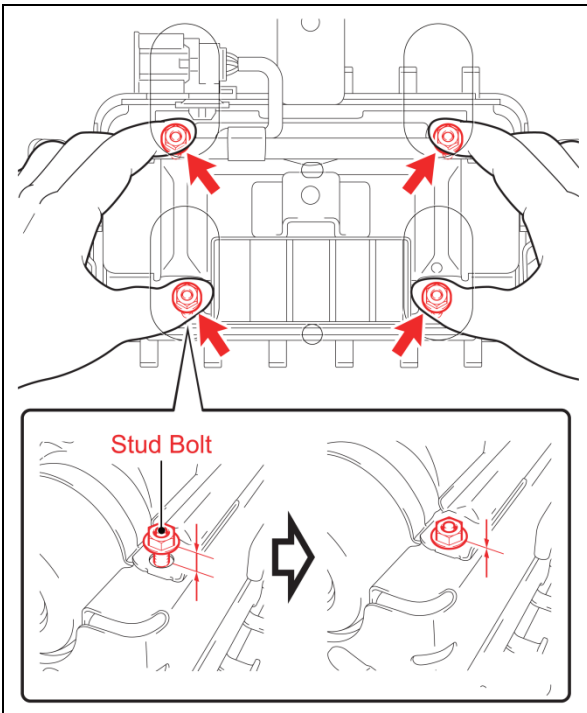




b) Loosen the nuts until they are flush with the studs.

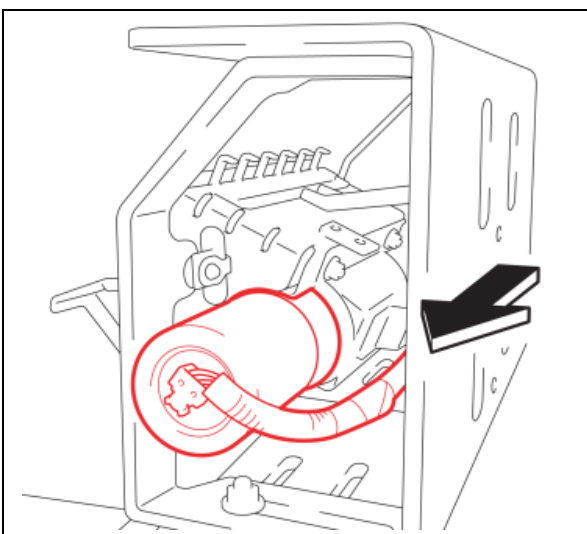
c) Use a marker to mark the nuts as they are not to be reused.

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



## 6. REMOVE THE INFLATOR

a) Gently push in the 4 studs until the nuts contact the airbag case to allow for inflator removal.



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



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



## 7. SCAN THE OLD AND NEW INFLATOR SERIAL NUMBER

- Scan the **OLD** inflator serial number and mark the old inflator so that it will not be reused.
- 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 TMNA 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.

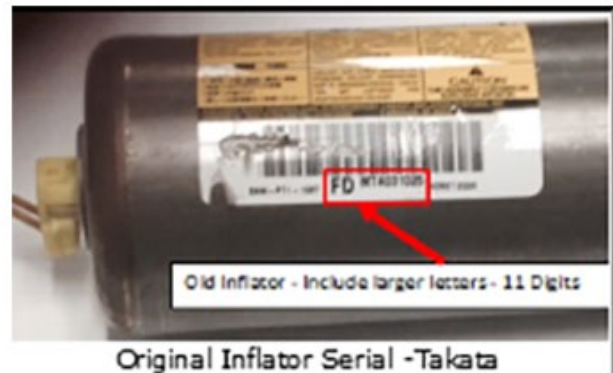
VIN: 2T1BR32E57C810829  
Model / Campaign: 2007 Corolla / E04

\* 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



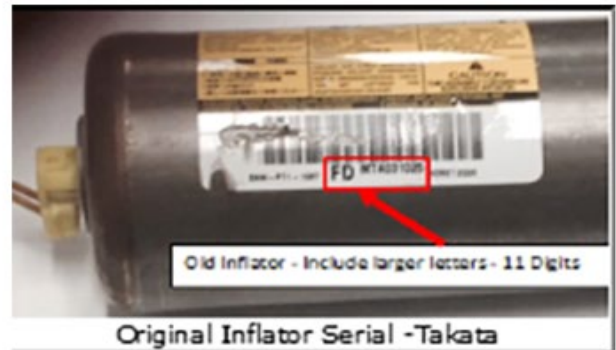
- If the inflator serial number cannot be scanned or is not present check the box as shown below.



## 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  
**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**

- 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](mailto: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:	77513K40 <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)

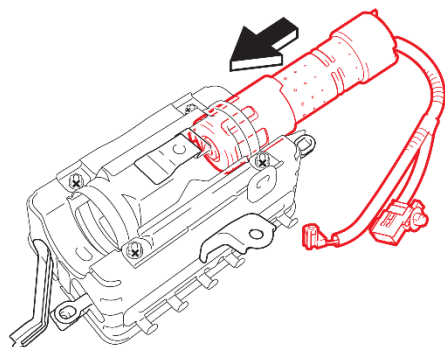
## 8. INSTALL A NEW INFLATOR

- a) Insert a **NEW** inflator into the airbag case as shown in the illustration.

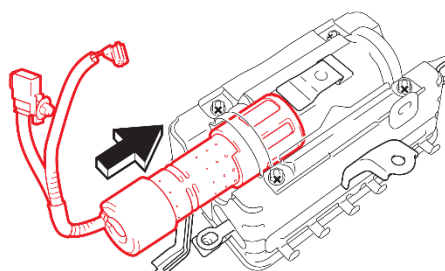


**Make sure to install the passenger airbag inflator with the correct orientation.**

# OK

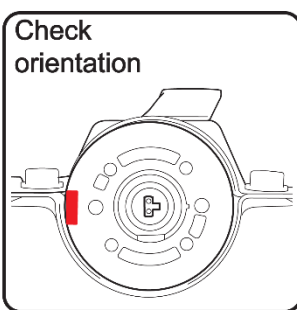


# NG

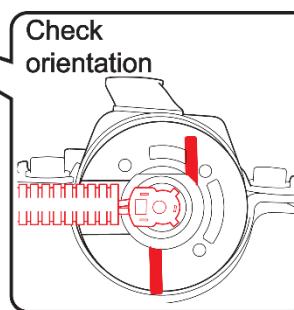
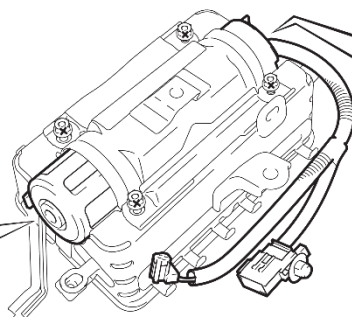


R1712010007A01

- b) Set the inflator with the correct orientation as shown in the illustration.



Check  
orientation



Check  
orientation

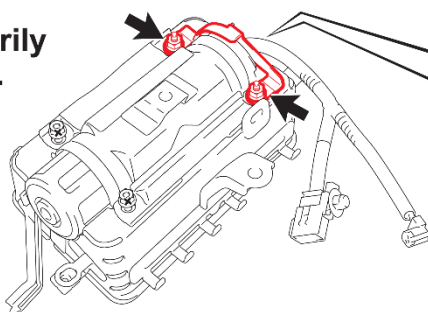
R1712010008A01

- c) Remove the 2 old nuts on the harness connected side.
- d) Store the removed nuts in a separate container.
- e) Match the flat part of a **NEW** position determining plate of the harness connected side with the projecting part of the inflator.
- f) Temporarily install 2 **NEW** nuts and position determining plate by hand on the stud bolts.

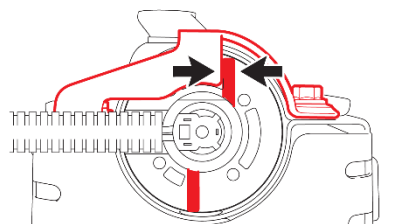


**If the flat surfaces are not aligned with each other, the orientation of the inflator could be displaced, causing the airbag to fail in deployment.**

Install  
temporarily  
by hand.



Flats are aligned.



R1712010010A01

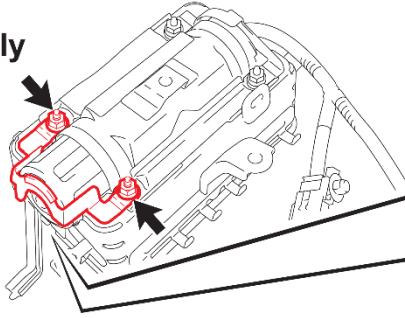


- g) Remove the 2 old nuts on the harness unconnected side.
- h) Store the removed nuts in a separate container.
- i) Match the flat part of a **NEW** position determining plate of the harness unconnected side with the projecting part of the inflator.
- j) Temporarily install 2 **NEW** nuts and position determining plate by hand on the stud bolts.

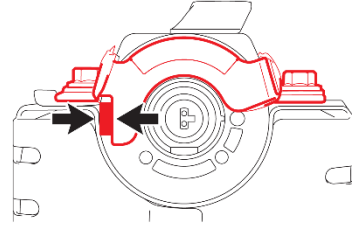


If the flat surfaces are not aligned with each other, the orientation of the inflator could be displaced, causing the airbag to fail in deployment.

Install temporarily by hand.



Flats are aligned.



R1712010012A01

- k) Push the inflator towards the position determining plate of the harness unconnected side to eliminate any gap.



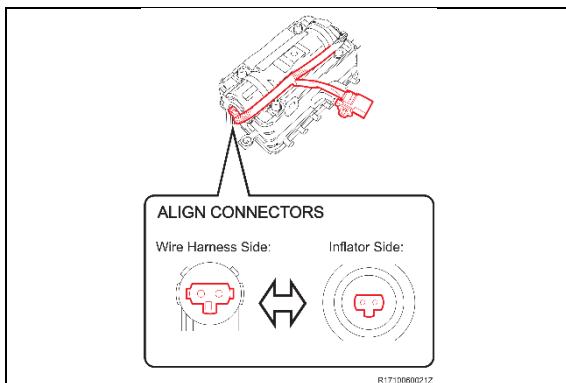
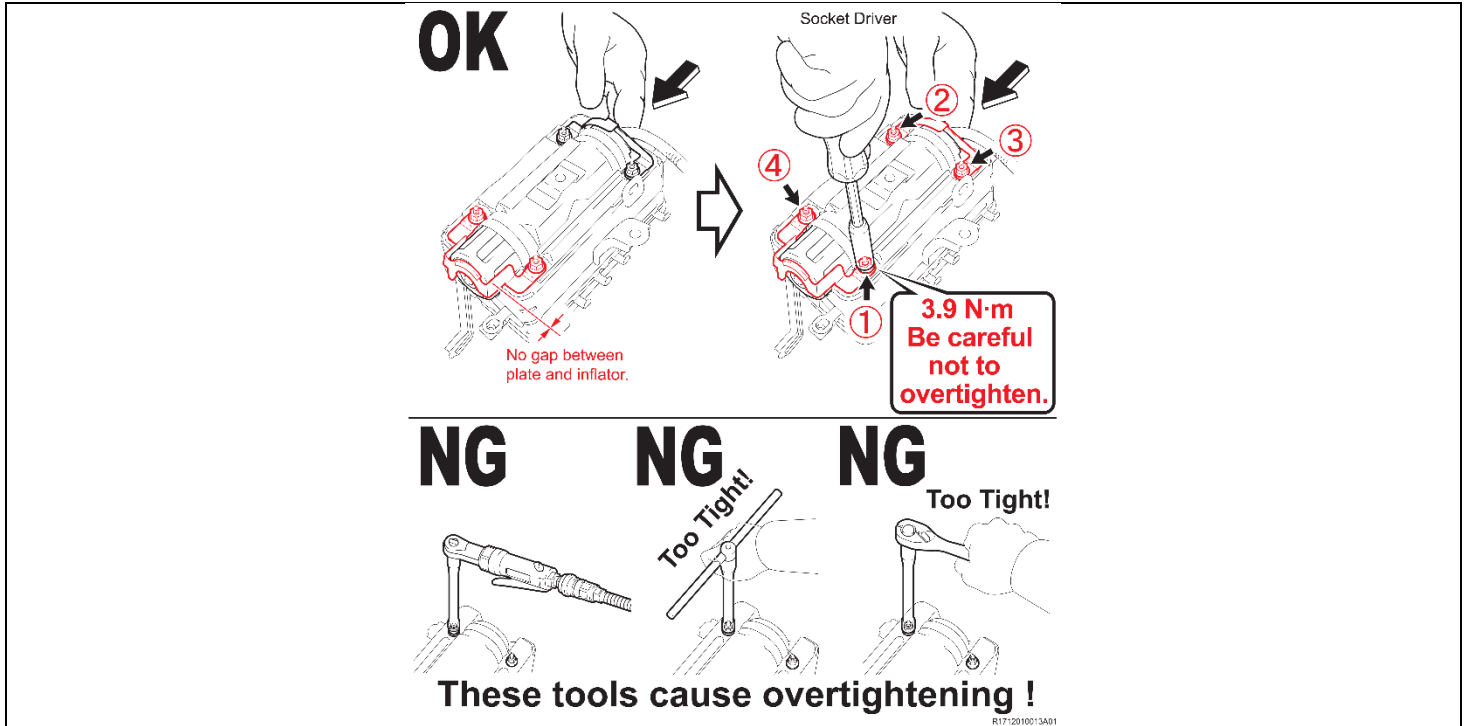
If any gap exists, the aligned flats may move apart, resulting in failure in normal deployment of the airbag.

- l) Tighten 4 nuts evenly in several increments in the order shown in the illustration using a socket driver while pushing the position determining plate of the harness connected side and inflator. (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 or tightening strongly with a T-handle wrench or a ratchet handle may cause deformation of the stud bolt.

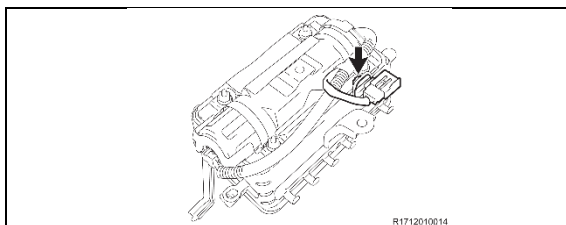


## 9. CONNECT THE HARNESS CONNECTOR

- a) Connector the harness connector to the inflator.



- Make sure to correctly align the connectors before connecting them.
- Make sure that the airbag connectors are securely connected.

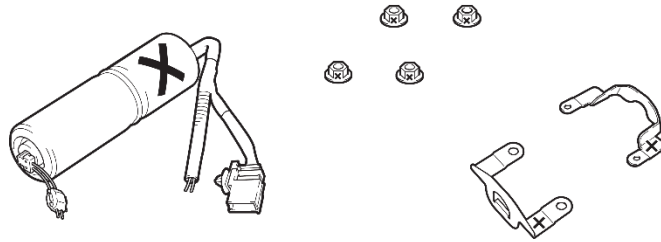


- b) Engage the clamp.

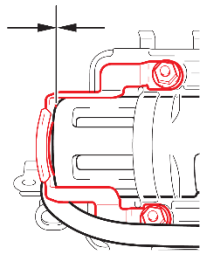
## 10. INTERMEDIATE INSPECTION

- a) Check that the inflator, plates and 4 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.)

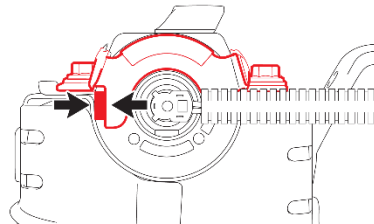
(a) Parts are replaced.



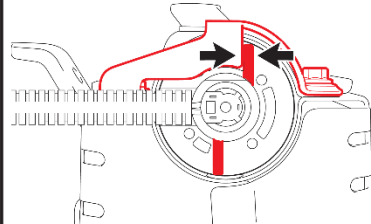
(b) No gap.



(b) Flats are aligned.



(b) Flats are aligned.

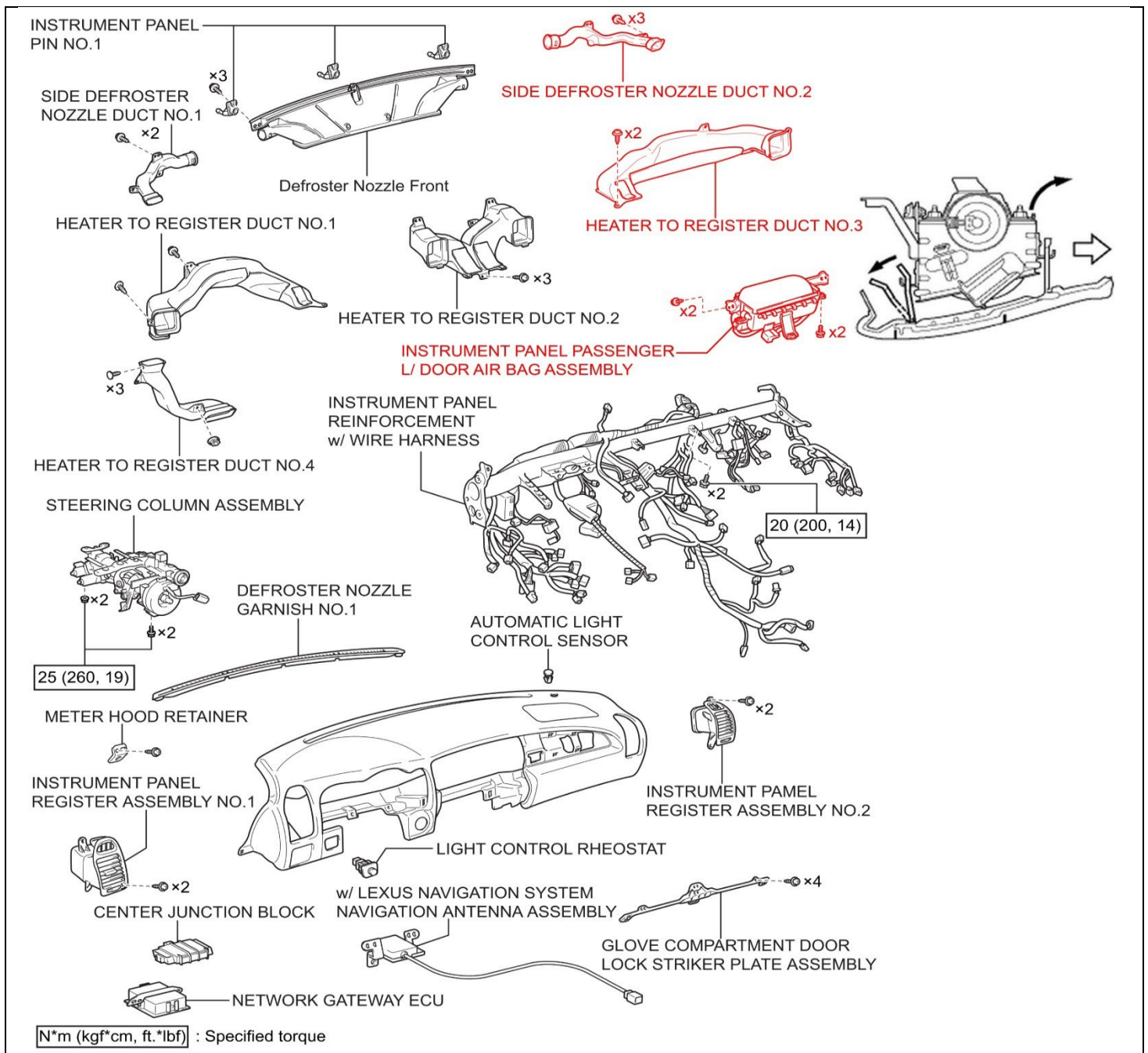


R1712010015A01

## XI. FRONT PASSENGER AIRBAG ASSEMBLY INSTALLATION

### 1. REINSTALL THE AIRBAG ASSEMBLY IN THE INSTRUMENT PANEL

- Position the airbag assembly in the instrument panel, engage the straps, and then install the 4 bolts.
- Install the 2 screws and the heater to register duct.
- Install the 3 screws and the side defroster nozzle.



### 1. INSTALL THE INSTRUMENT PANEL SAFETY PAD SUB-ASSEMBLY

- Refer to TIS for reinstallation instructions

[2002-2005 MY](#)   [2006MY](#)   [2007MY](#)   [2008MY](#)   [2009MY](#)   [2010MY](#)

### 2. RECONNECT THE NEGATIVE BATTERY CABLE

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

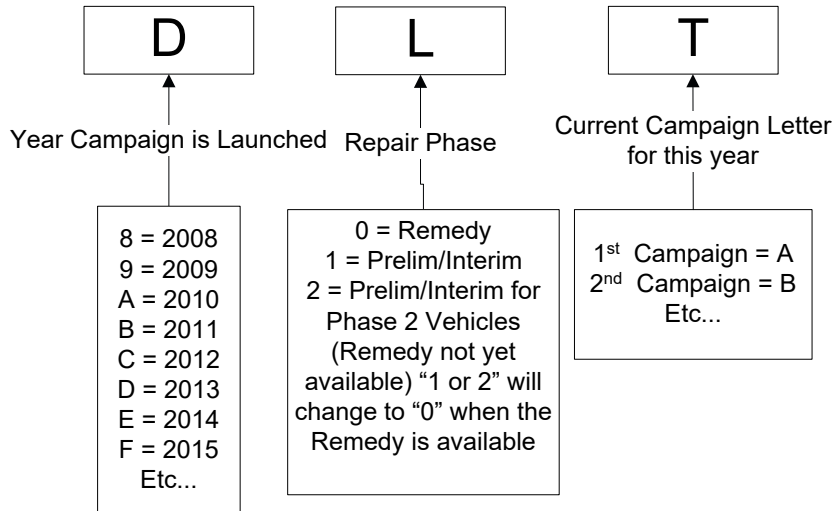
## ◀ VERIFY REPAIR QUALITY ▶

- 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 position determining plate is installed correctly

If you have any questions regarding this update, please contact your area 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