

TECHNICAL INSTRUCTIONS

FOR

SAFETY RECALL 19TA22

CERTAIN REAR SEAT BELT LOCK(S) MAY BECOME INOPERATIVE

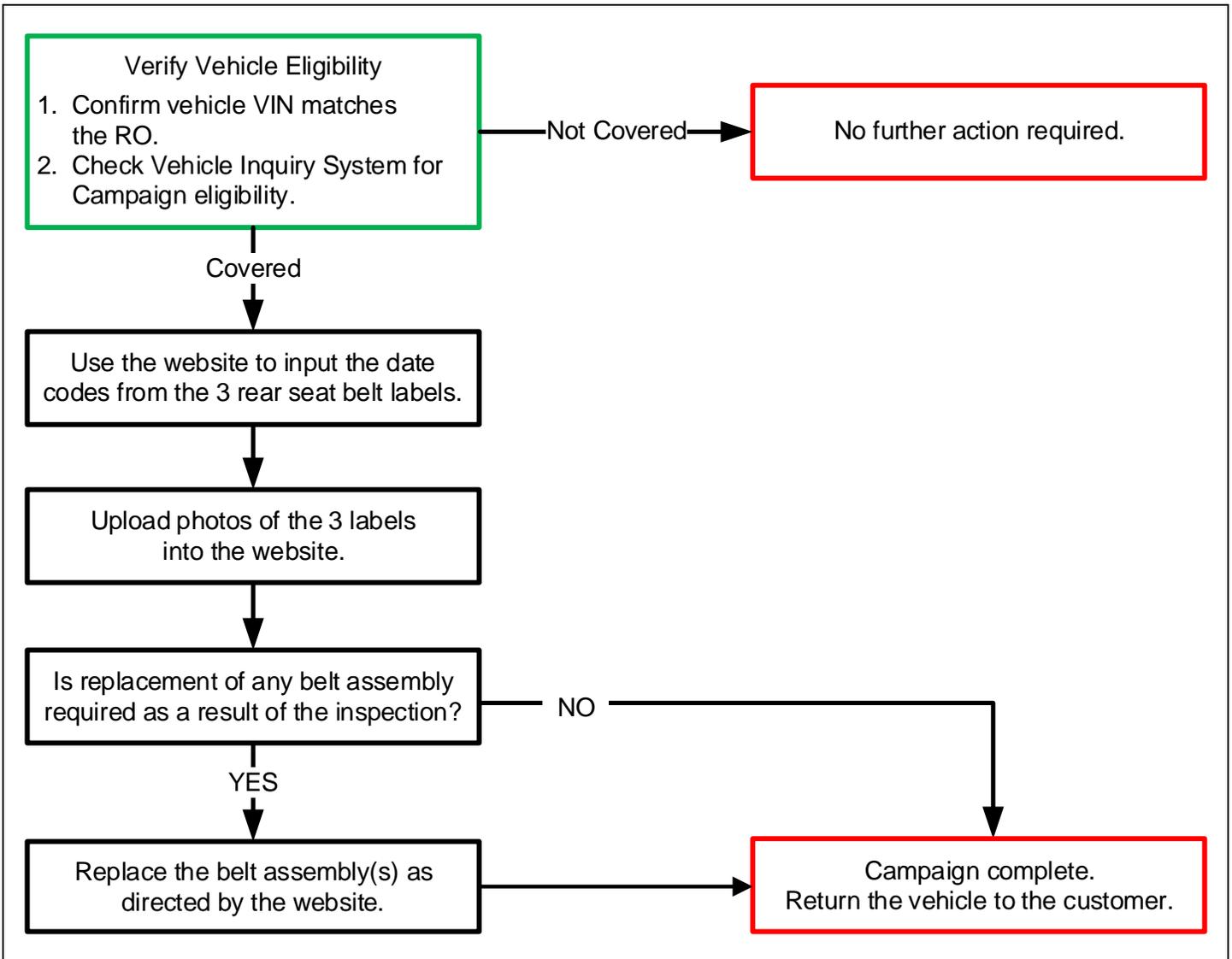
CERTAIN 2020 COROLLA and COROLLA HV

The repair quality of covered vehicles is extremely important to Toyota. 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 currently hold at least one of the following certification levels:

- Certified (any specialty)
- Expert (any specialty)
- Master
- Master Diagnostic Technician

It is the dealership's responsibility to select technicians with the above certification level or greater to perform this recall 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



II. IDENTIFICATION OF AFFECTED VEHICLES

1. CHECK VEHICLE FOR CAMPAIGN ELIGIBILITY

- Compare the vehicles VIN to the VIN listed on the Repair Order to ensure they match.
- Check the TIS Vehicle Inquiry System to confirm the VIN is involved in this Campaign, and that it has not already been completed.

Note: TMNA warranty will not reimburse dealers for repairs completed on vehicles that are not affected or were previously completed, even by another dealer.

III. PREPARATION

A. PARTS

The correct part numbers for each vehicle will be provided to the technician by the website during the inspection process. Each vehicle will have different replacement requirements. Some vehicles may not require any belts to be replaced. Other vehicles may need to have 1, 2 or even 3 belts replaced. Be sure to complete the inspection process to determine which belts, if any, need to be replaced.

DO NOT order any parts unless instructed to do so by the campaign website.

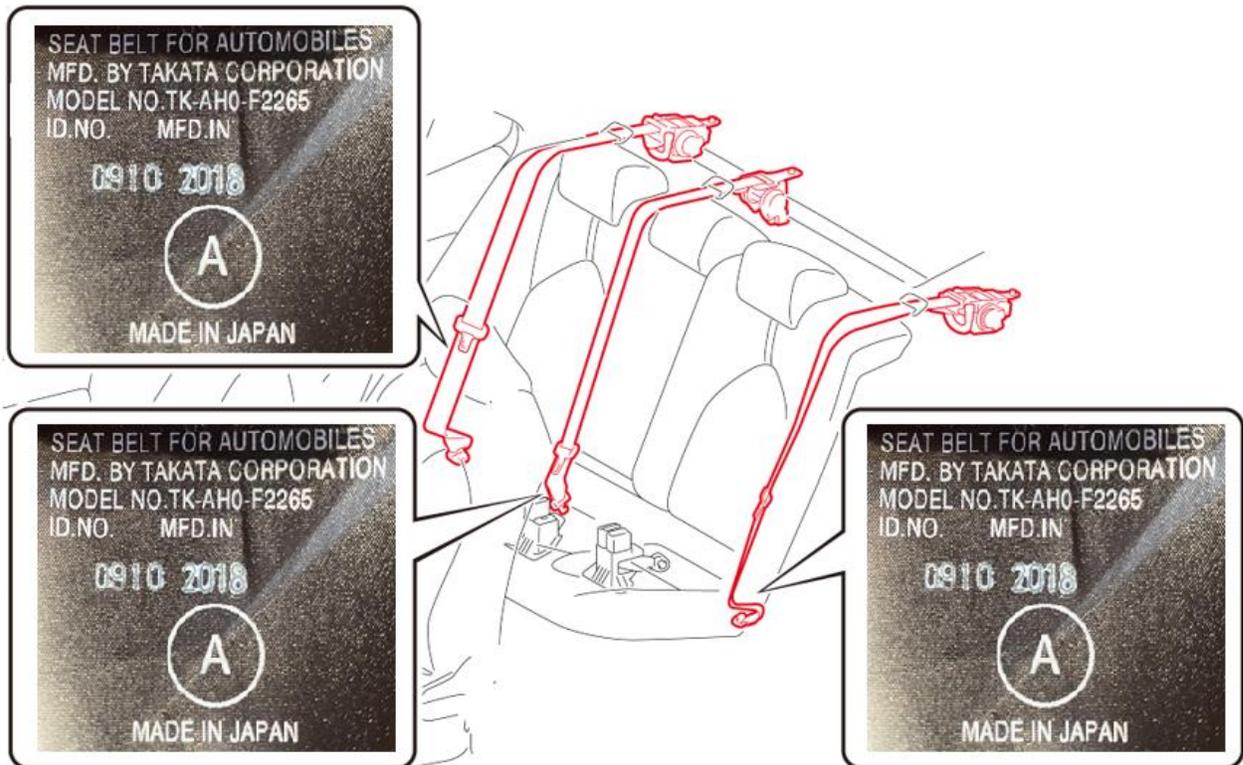
Part Number	Part Description	Quantity
04009-72112-C1	BELT KIT, RR SEAT, OUTER CTR	As indicated by website
04009-72412-C0	BELT KIT, RR SEAT, OUTER RH	As indicated by website
04009-72612-C0	BELT KIT, RR SEAT, OUTER LH	As indicated by website
04009-83212	REPAIR KIT, RR SEAT BELT	As indicated by website

B. TOOLS & EQUIPMENT

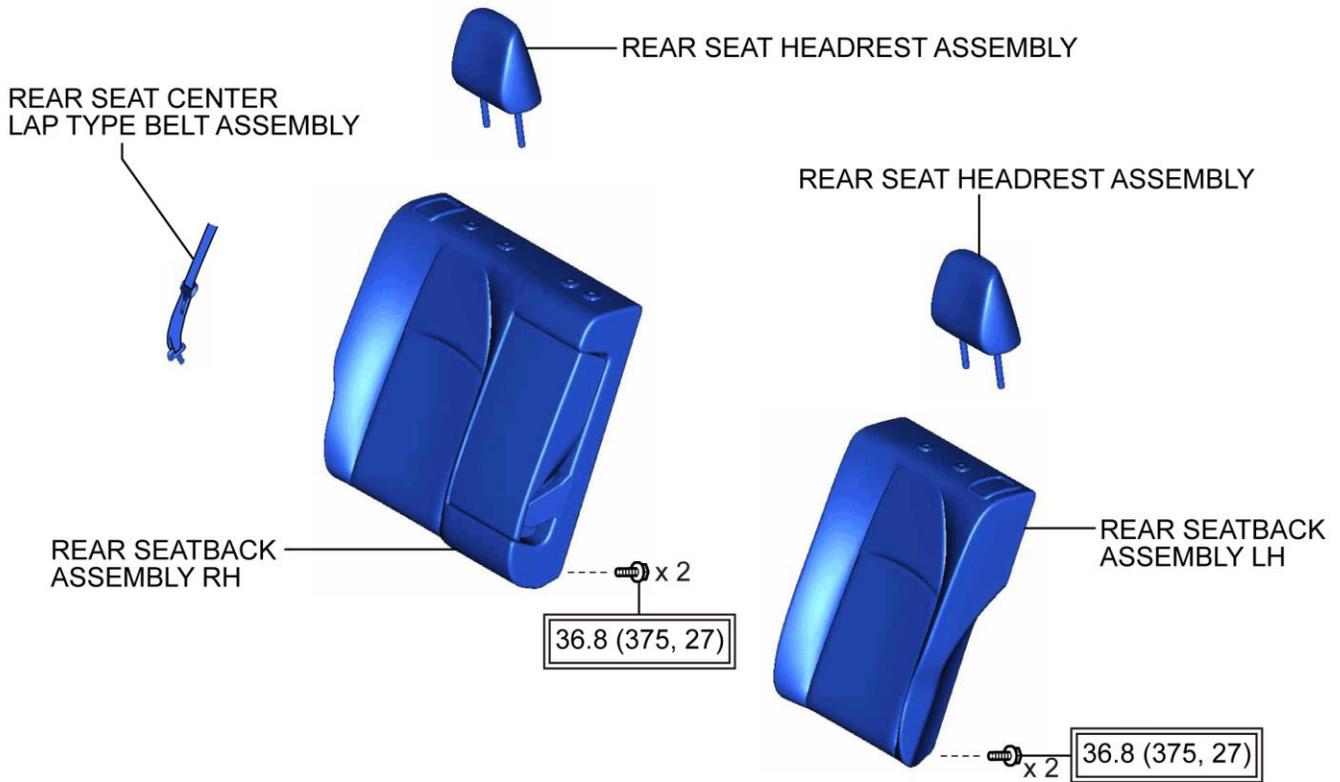
- Standard Hand Tools
- Torque Wrench
- Molding Removal Tool

IV. BACKGROUND

The subject vehicles are equipped with rear seat belt assemblies that have two types of locking mechanisms. One of the locking mechanisms in certain seat belts may not have been assembled correctly. This can cause an occupant to not be restrained properly in certain crashes, increasing the risk of injury.



I. COMPONENTS

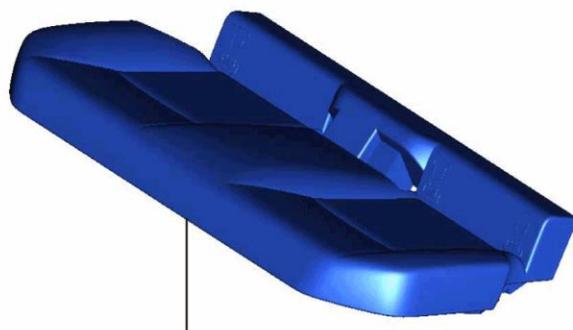


for Gasoline Model:



REAR SEAT CUSHION ASSEMBLY

for HV Model:



REAR SEAT CUSHION ASSEMBLY

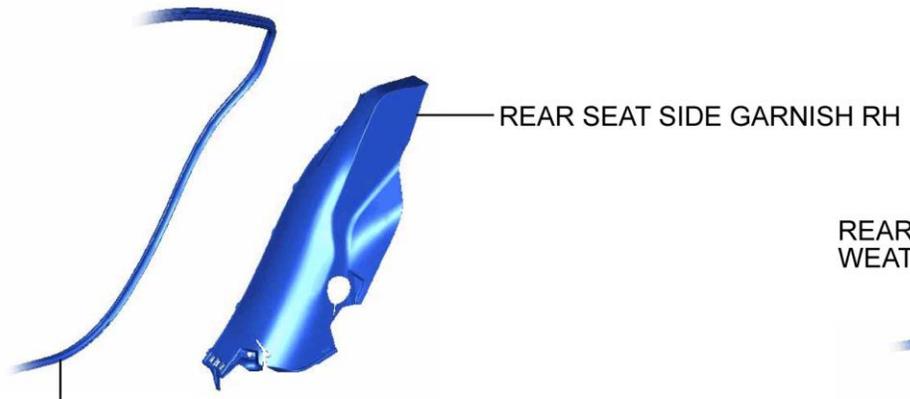


● : Replacement part

N*m (kgf*cm, ft.*lbf) : Tightening torque for "Major areas involving basic vehicle performance such as moving/turning/stopping"

P

B540746



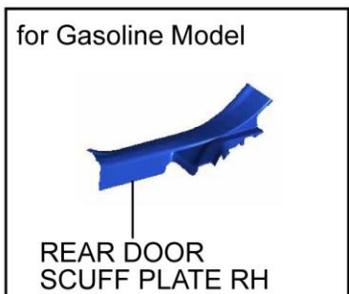
REAR SEAT SIDE GARNISH RH

REAR DOOR OPENING TRIM WEATHERSTRIP RH

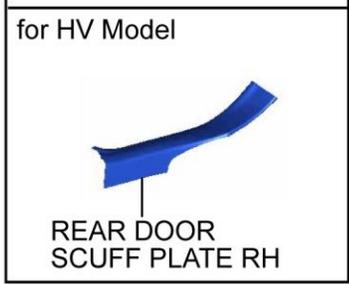
REAR DOOR OPENING TRIM WEATHERSTRIP LH



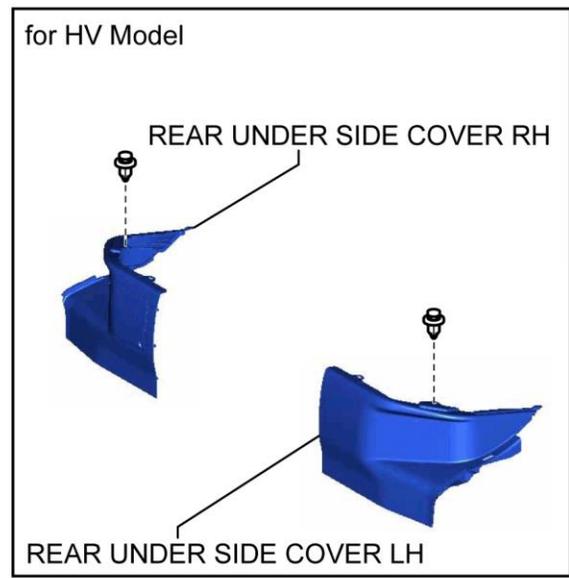
REAR SEAT SIDE GARNISH LH



REAR DOOR SCUFF PLATE RH

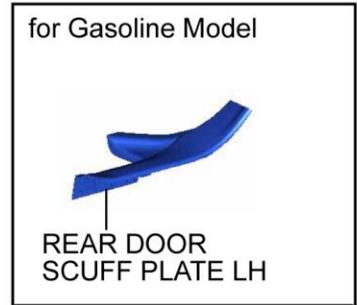


REAR DOOR SCUFF PLATE RH

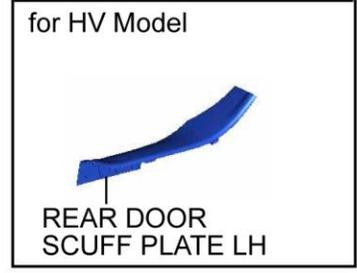


REAR UNDER SIDE COVER RH

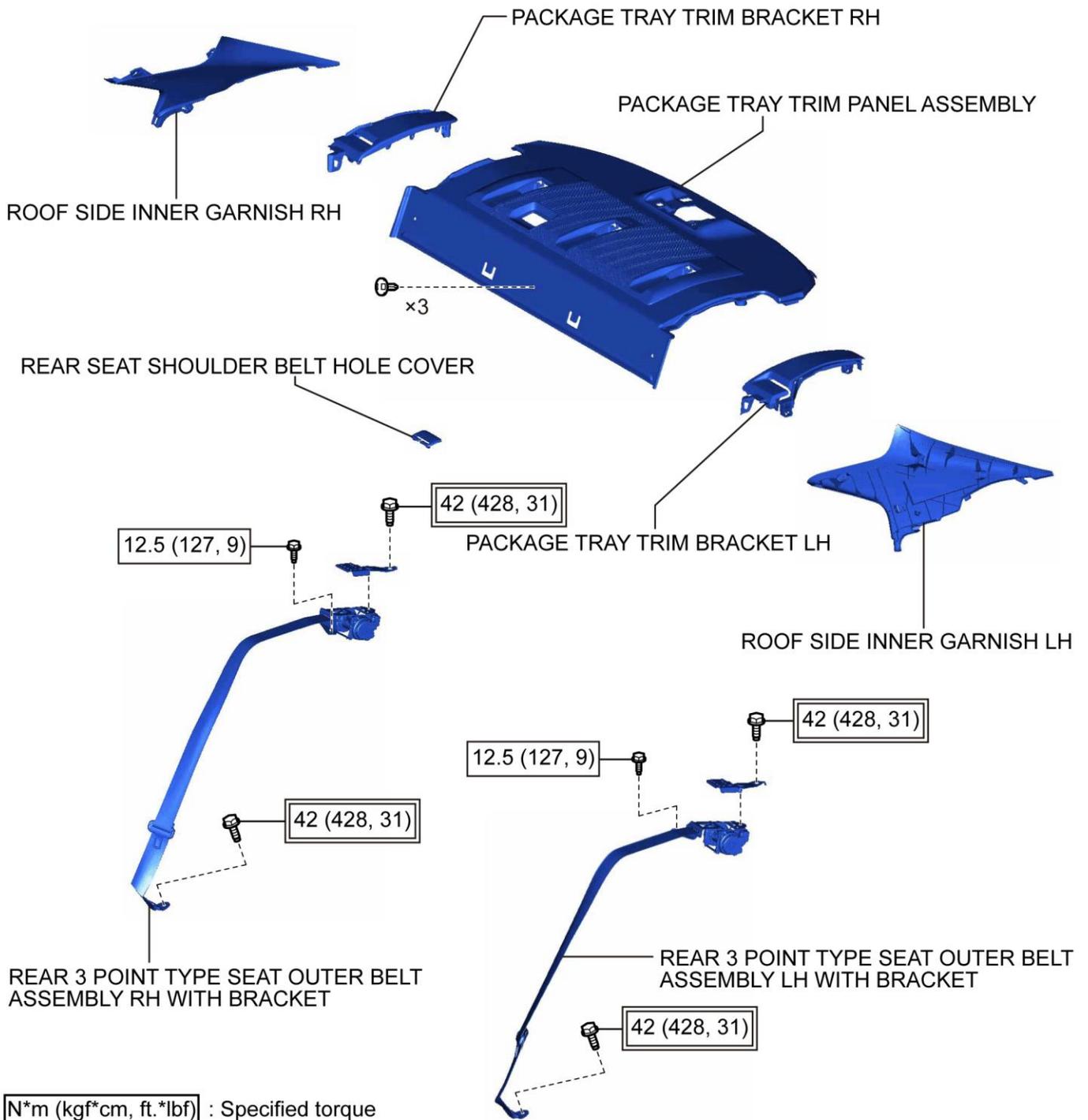
REAR UNDER SIDE COVER LH



REAR DOOR SCUFF PLATE LH



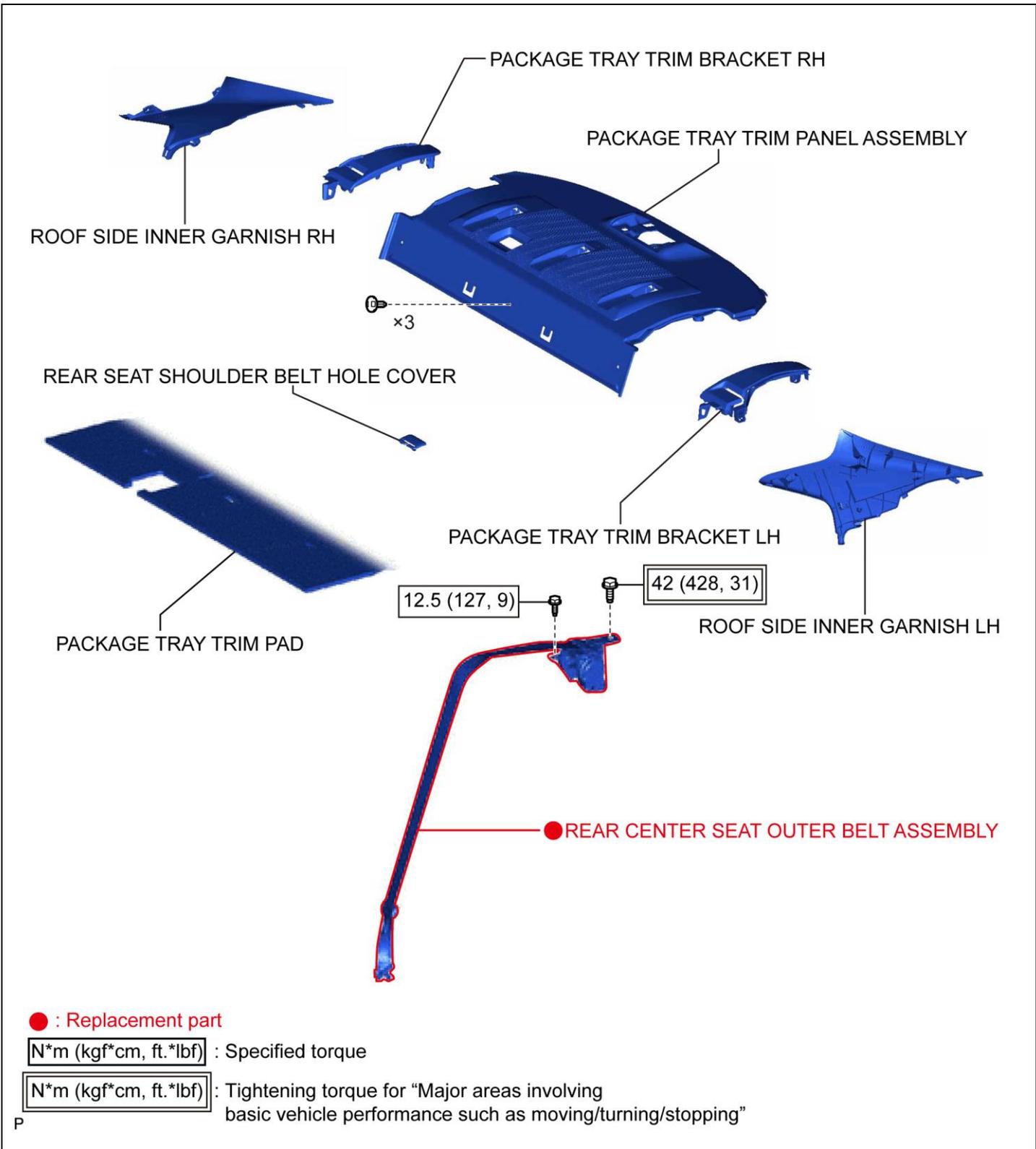
REAR DOOR SCUFF PLATE LH



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

N*m (kgf*cm, ft.*lbf) : Tightening torque for “Major areas involving basic vehicle performance such as moving/turning/stopping”

P

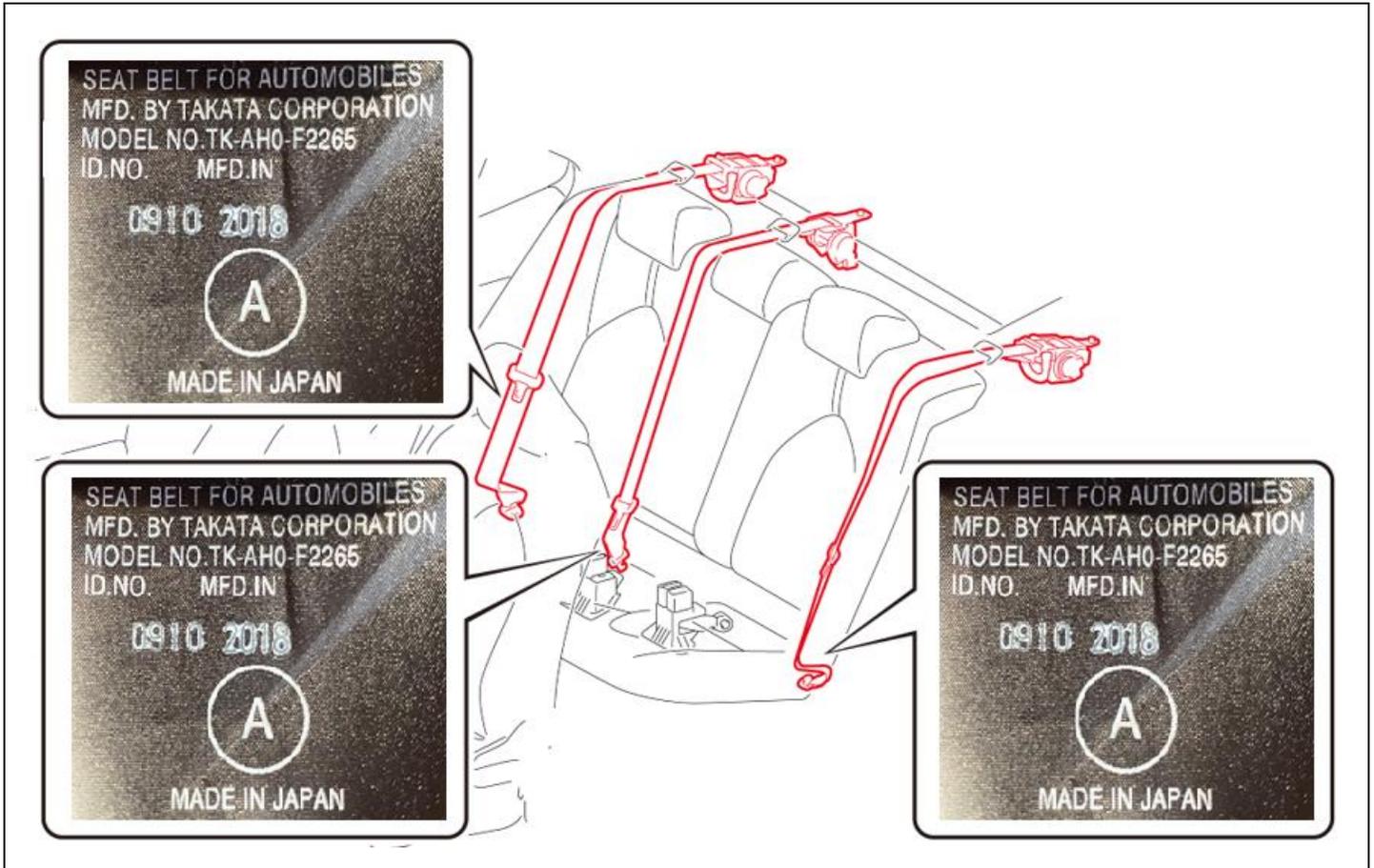


P

V. LABEL INSPECTION

To determine if replacement is necessary for **any of the three Rear Belt Assemblies**, an inspection of the date codes on each seat belt label is required.

Note: Each vehicle will have different replacement requirements. Some vehicles may not require any belts to be replaced. Other vehicle many need to have 1, 2 or even 3 belts replaced. Be sure to complete the inspection process to determine which belts, if any, need to be replaced.



1. OPEN 19TA22 WEBSITE

a. Open the 19TA22 Website by selecting the following link:

<https://19ta22-safety-recall.imagespm.info/>

b. Enter your dealer code in the User ID field.

c. Enter xxxxx (5 x's) for the Password. It will then prompt you to change the password. You can enter the same xxxxx (5 x's) again, or create your own password. If you change the password, be sure to advise other technicians of the updated password.

Note: Selecting the "Forgot Password" link will reset the password to the default password: xxxxx

d. Enter the vehicles VIN. It is critical that the VIN be entered accurately.



The COROLLA inspection is for **ALL 3 REAR SEAT BELTS**. Be sure to complete the inspections as detailed for each seat belt position when requested by the website.

WEBSITE INSPECTION PROCESS:

Left Rear



Center Rear



Right Rear



2. ENTER LEFT REAR ID.NO. INTO WEBSITE

- Locate the label at the base of the **Left Rear** belt, as shown in the photo on the website.
- Determine the **ID. NO.** on the label.
- Enter the **ID. NO.** in to the website.

Left Hand Rear Seat Belt

Enter the ID.NO. and MFD.IN as found on the *Left Hand* Rear Seatbelt label.

VIN: JTDEBRBE8LJ018015

ID. NO.:

MFD. IN:



3. ENTER LEFT REAR MFD.IN INTO WEBSITE

- Determine the **MFD.IN** on the label.
- Enter the **MFD.IN** in to the website.
- Take a photo of the label.

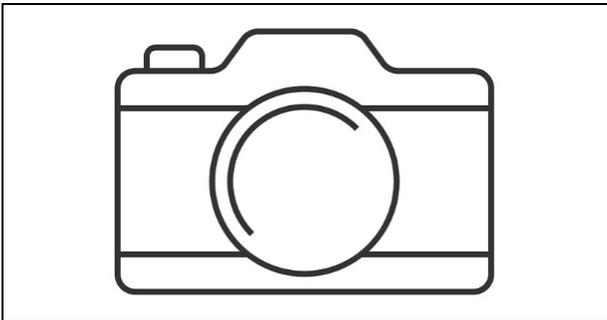
Left Hand Rear Seat Belt

Enter the ID.NO. and MFD.IN as found on the *Left Hand* Rear Seatbelt label.

VIN: JTDEBRBE8LJ018015

ID. NO.:

MFD. IN:



4. **TAKE A PHOTO OF THE LEFT REAR LABEL**
 - a. Take a clear, legible picture of the label so that the date codes can be seen clearly.

Note: A photo of each label will be required for upload into the website.

CENTER REAR:
Input Date Codes

A simple line drawing of a camera, showing the lens, viewfinder, and body. A red arrow points downwards from the text above to the camera icon.

5. **ENTER CENTER REAR DATA**
 - a. Following the directions in the website, repeating Steps 2-4 above to enter the **ID.NO.** and **MFD. IN** data into the website for the **Center Rear** belt assembly.
 - b. Take a photo of the Center Rear label.

RIGHT REAR:
Input Date Codes

A simple line drawing of a camera, showing the lens, viewfinder, and body. A red arrow points downwards from the text above to the camera icon.

6. **ENTER RIGHT REAR SIDE DATA**
 - a. Following the directions in the website, repeating Steps 2-4 above to enter the **ID.NO.** and **MFD. IN** data into the website for the **Right Rear** belt assembly.
 - b. Take a photo of the Right Rear label.

If the ID.NO or MFD.IN numbers on a label cannot be accurately read, email a photo of the label to quality_compliance@toyota.com. You will receive an email response with directions after the photo is reviewed.

WEBSITE IMAGE UPLOAD:

Left Rear



Center



Right Rear

7. UPLOAD IMAGES OF 3 LABELS

- a. Follow the directions in the website to upload a photo image of the Left, Center, and Right-side labels.

Image Upload: Left Hand Rear Seat Belt

Take a photo of the current installed seat belt buckle, select the file locati

VIN: JTDEBRBE8LJ018015

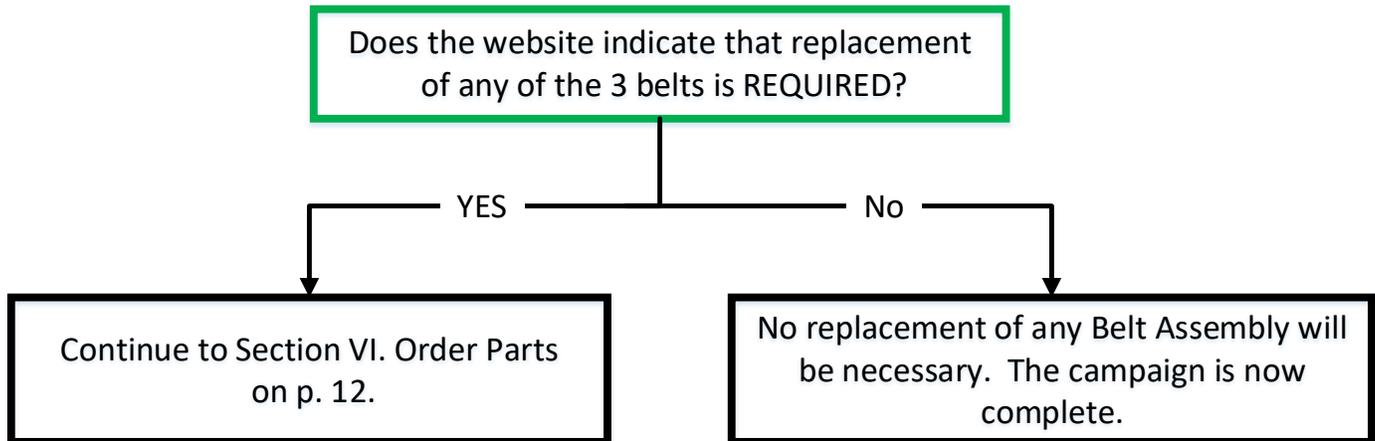
Left Hand Rear Seat Belt:

No file chosen

8. CHECK RESULTS

- a. After completing the Image upload, the website will display the Search Results screen. Review the Search Results to determine which belts, if any, need to be replaced.

DO NOT CLOSE the Search Results screen if any of the 3 belts will need to be replaced.



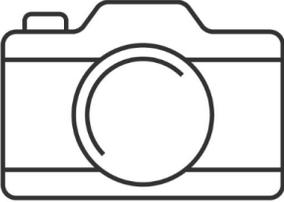
Note: Each vehicle will have different replacement requirements. Some vehicles may not require any belts to be replaced. Other vehicle many need to have 1, 2 or even 3 belts replaced. Be sure to complete the inspection process to determine which belts, if any, need to be replaced.

VI. ORDER PARTS

1. PROVIDE PHOTO OF SEARCH RESULTS SCREEN

The parts kit and belt assemblies are on Manual Allocation Control. It will be necessary for the parts department to send a picture of the Search Results screen with the parts order before the order will ship.

- a. Take a photo of the Search Results screen being sure to include the VIN number, the Results section, and the part numbers.
- b. Provide a photo of the Search Results Screen to the Parts Department when ordering the required parts.

	<p>Search Results</p> <p>Please print screen, or search another VIN.</p> <p>VIN:</p> <p>Results: Replacement of the Left Hand, Center, Right Hand Rear Seat belt(s) is REQUIRED on this vehicle. Refer to page 8 of the Technical Instructions for details. The required parts are listed below.</p> <p>Left Hand Rear Seat Belt: 04009-72612-C0</p> <p>Center Rear Seat Belt: 04009-72112-C1</p> <p>Right Hand Rear Seat Belt: 04009-72412-C0</p> <p>Kit: 04009-83212</p>
---	--

VII. REAR BELT ASSEMBLY REMOVAL



The following procedure is only necessary if the website indicates that replacement of a belt(s) assembly is required. DO NOT replace any belt(s) unless directed by the website.

1. REMOVE REAR BELT ASSEMBLY

- a. Follow the appropriate Repair Manual procedure to remove the appropriate belt(s), as identified during the inspection process.

Outer LH and/or RH:

[SEAT BELT: REAR SEAT OUTER BELT ASSEMBLY \(for Sedan\): REMOVAL; 2020 MY Corolla \(RM100000001GIXT\)](#)

Center:

[SEAT BELT: REAR CENTER SEAT OUTER BELT ASSEMBLY \(for Sedan\): REMOVAL; 2020 MY Corolla \(RM100000001GIY0\)](#)

VIII. REAR BELT ASSEMBLY INSTALLATION

1. INSTALL **NEW** REAR BELT ASSEMBLY

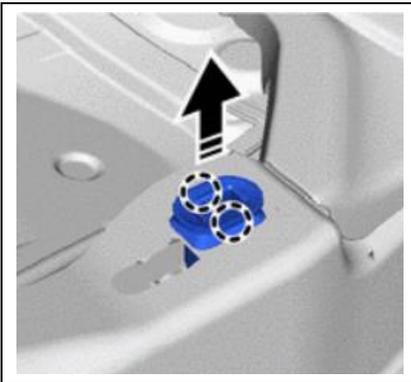
- a. Follow the appropriate Repair Manual procedure to install the **NEW** seat belt assembly(s), as identified during the inspection process.

Outer LH and/or RH:

[SEAT BELT: REAR SEAT OUTER BELT ASSEMBLY \(for Sedan\): INSTALLATION; 2020 MY Corolla](#) (RM100000001GIXV)

Center:

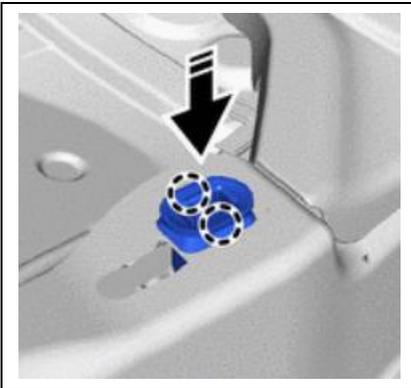
[SEAT BELT: REAR CENTER SEAT OUTER BELT ASSEMBLY \(for Sedan\): INSTALLATION; 2020 MY Corolla](#) (RM100000001GIY1)



2. INSTALL REPAIR KIT

The Repair Kit contains the two (2) lower seat cushion lock hooks. These are considered no-reusable and need to be replaced each time the lower seat cushion is removed.

- a. Disengage the two claws on each of the rear seat cushion lock hooks and slide upward to remove.



- b. Install the two **NEW** rear seat cushion lock hooks by engaging the two claws.

◀ VERIFY REPAIR QUALITY ▶

- Confirm that each belt extends and retracts properly.
- Confirm that each belt latches into the buckle correctly.
- Confirm that the locking mechanism engages when the belt is extended quickly.

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

10. APPENDIX

A. PARTS DISPOSAL

In accordance with Federal law, please make sure all recalled parts (original parts) removed from the vehicle are disposed of in a manner in which they will not be reused, **unless requested for parts recovery return.**

B. CAMPAIGN DESIGNATION DECORDER

