

TECHNICAL INSTRUCTIONS

FOR

SAFETY RECALL 23TA03

TONNEAU COVER MAY COME OFF WHILE DRIVING

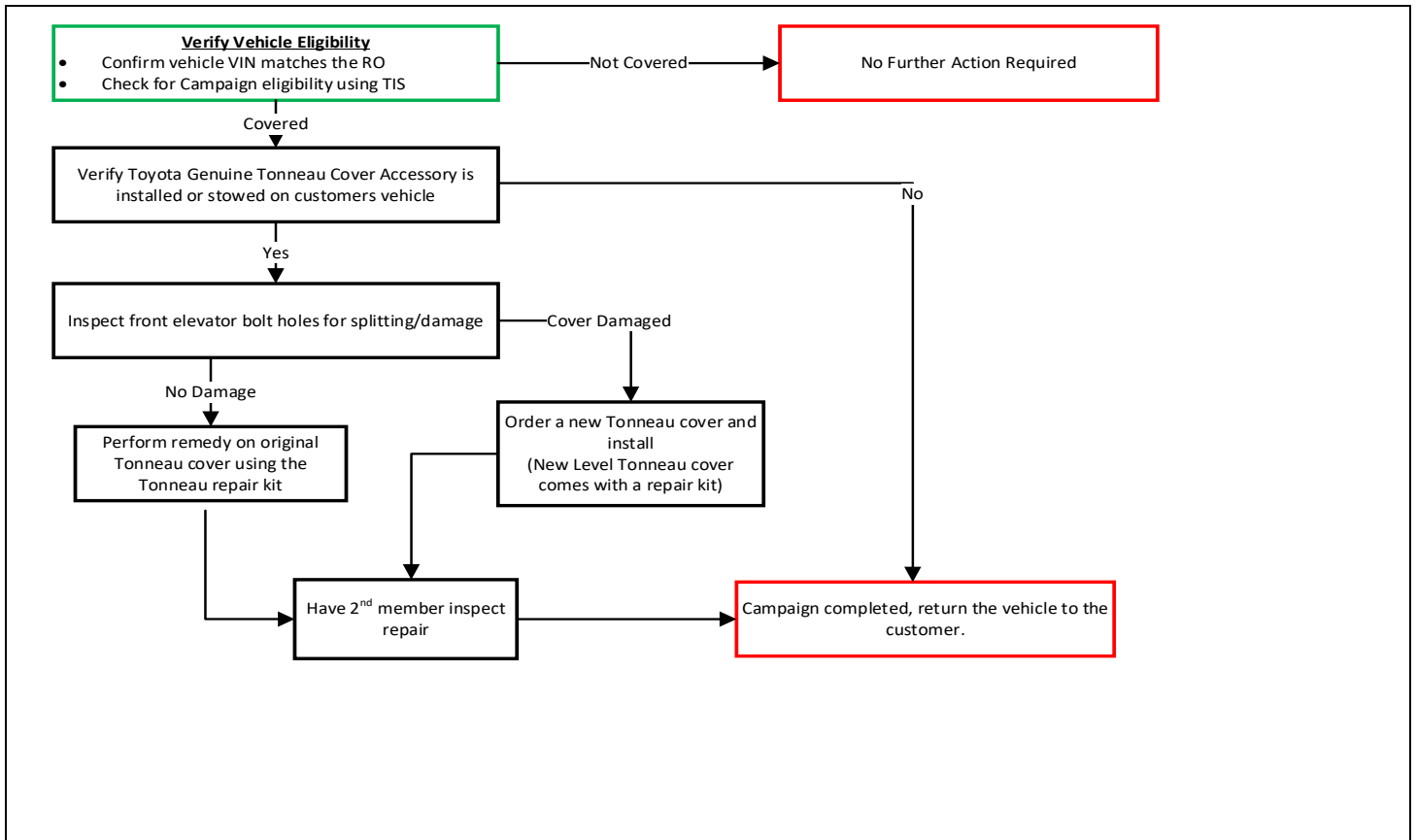
CERTAIN 2022-2023 MODEL YEAR TUNDRA and TUNDRA HV

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 have completed all of the following courses:

-TIC206a Electrical Repair 1

It is the dealership’s responsibility to select technicians that have completed the above courses 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



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

Part Number	Description	Qty
PT954-34220-TT	Tundra Tonneau Cover Repair Kit	1
PT954-34223	New 5.5' Tonneau Cover kit	1 (if applicable)
PT954-34224	New 6.5' Tonneau Cover kit	1 (if applicable)

***Note: New Tonneau cover kits come with the new hardware kit, if new cover is required there is no need to order Repair Kit**

Contents of part repair kit



2 - Labels, 4 - Elevator bolts, 4 - R-clips, 4 - 5/16" nuts, 4 – Lock Washers, 2 - Large Black Spacers, 2 - Small Black Spacers, 4 - flat washers, 8 - rubber washers

B. TOOLS & EQUIPMENT



• Standard Hand Tools	• Drill with 1/8"-1/4" and 5/8" bit	• Torque Wrench
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IV. BACKGROUND

Some of the subject vehicles may be equipped with an optional Toyota genuine truck bed accessory tonneau cover that can detach from the vehicle while driving. A tonneau cover that detaches from a vehicle could increase the risk of a crash or injury.



V. COMPONENTS





Tonneau Cover Top	Tonneau Cover Rails
 A photograph of the black tonneau cover top panel, which is a large, rectangular, textured plastic piece. It is lying flat on a wooden surface, showing its shape and the texture of the material.	 A photograph of two black metal rails for the tonneau cover. They are lying on a wooden surface. Each rail has several blue plastic caps and a silver metal bracket attached. A small plastic bag and a yellow ribbon are also visible near the bottom of the rails.

VI. IDENTIFY TONNEAU COVER TYPE

1. CONFIRM IF VEHICLE IS EQUIPPED WITH A TRI-FOLD HARD TOP TONNEAU COVER

Yes = Go to step 2





No = Campaign Complete

Examples of Tonneau Covers			
YES	NO	NO	NO
			

2. IDENTIFY IF INVOLVED TOYOTA GENUINE TONNEAU COVER IS INSTALLED

- a. Verify Toyota Genuine tonneau cover accessory is installed by checking for the following decals shown.

Affected Tonneau Covers

Affected Tonneau Cover for 2022-2023 Tundra and Tundra HV

- The affected tonneau cover has a Toyota decal on the top of panel closest to the tailgate.

OR

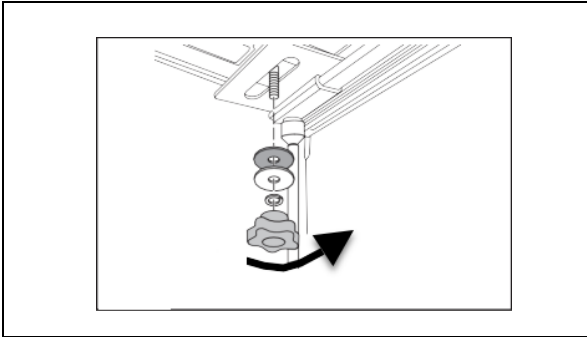
- The affected tonneau cover has a decal underneath showing part number PT954-34220-02 or PT954-34221-02.

OR

- The affected tonneau cover has a decal on either tonneau cover rail showing part number PT954-34220-02 or PT954-34221-02.

Is a Genuine Toyota Cover installed? **YES** - Move to Step VII, **NO** – Campaign Complete

VII. REMOVE OLD MOUNTING BOLTS, INSPECT, AND INSTALL REPAIR KIT



1. REMOVE KNOB AND HARDWARE

- Lower tailgate and fully open the tonneau cover to access the knob.
- Loosen knob and remove lock washer, large flat washer, large rubber washer and knob from underneath tonneau cover.
- Dispose of the original parts that are no longer required. (Knob, rubber washers, flat washers, lock washers.)

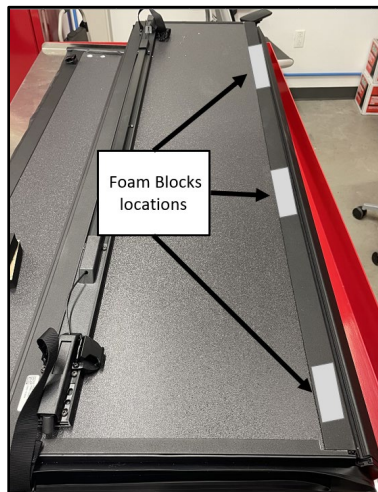


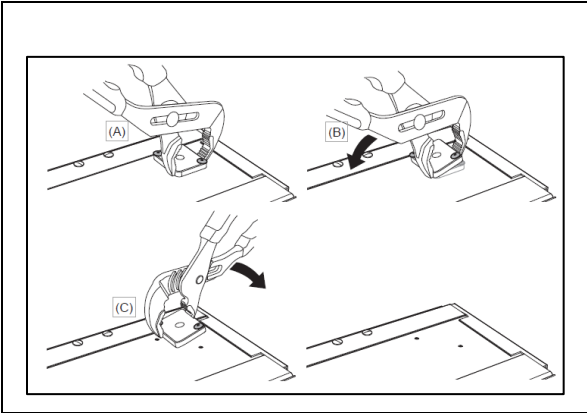
2. INSPECT LH AND RH MOUNTING HOLES

- Once elevator bolt is removed inspect holes for any tears or splits in aluminum. (See example of unacceptable condition)
- If no tears are found continue to step 3
- If any tears or splits are present remove and discard Tonneau Cover.
- Order new Tonneau Cover and skip to step 6.



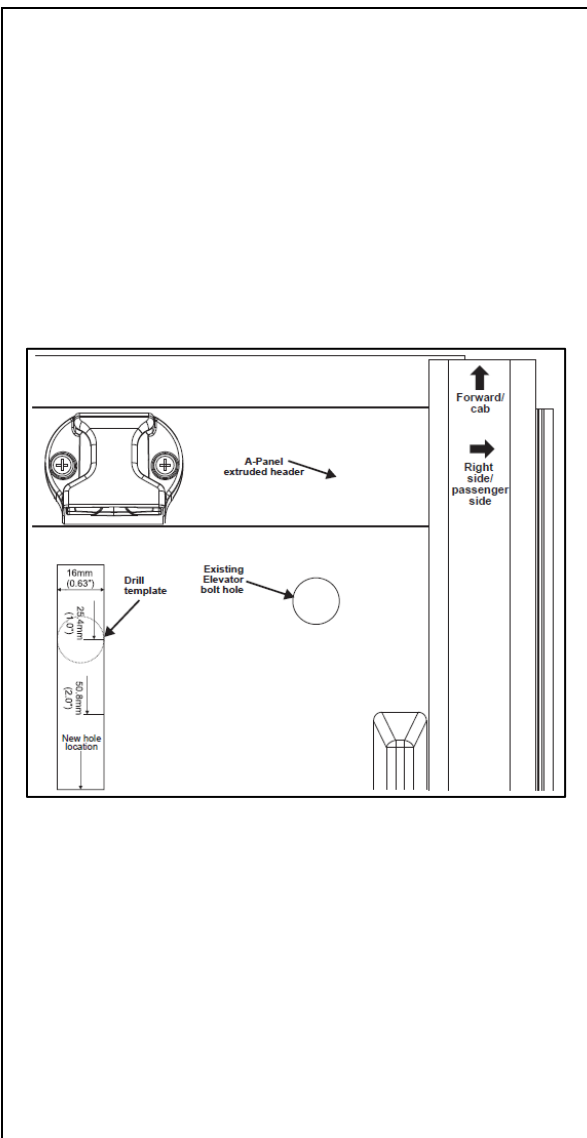
Note: The new Tonneau Cover will need the following items installed before it can be placed on the vehicle:
Foam Blocks & Strap Latch (See pictures below. Reference install instructions for locations)





3. REMOVE PLASTIC BLOCK FROM COVER

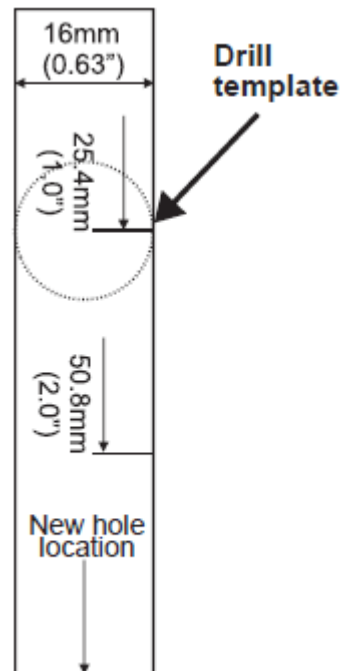
- a. Remove the plastic spacer block (located on the underside of the cover where the elevator bolt is installed) by grabbing the block with channel lock pliers as shown.
- b. Rotate the pliers downward as shown to release the first rivet from the cover.
- c. Change the position of the pliers downward to release the 2nd rivet. Discard the spacer blocks. Do this for both the driver and passenger side blocks.

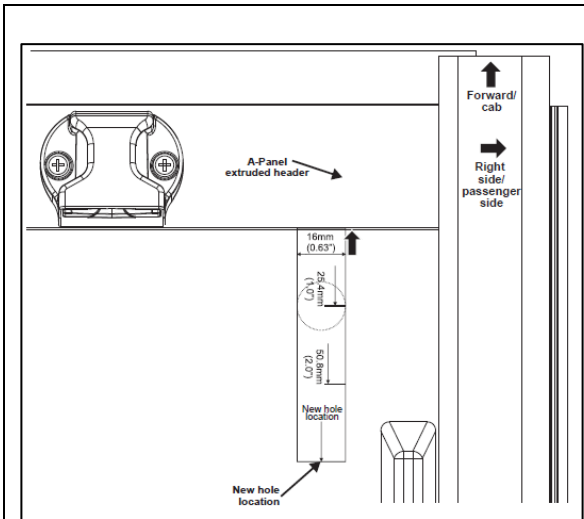


4. Toyota Hard Fold Cover field repair drill template

- a. Print out the Drill Template on pg.14. (See Note below before proceeding)
- b. Make sure the template measures 76mm (3.0") when printed to ensure the template is sized correctly.

Note: After you print the template on pg.14, make sure you check the measurements mentioned on the template before using it to get the correct spacing. **DO NOT PRINT THE TEMPLATE BELOW. Use the template on pg.14.**





5. USING THE FIELD REPAIR DRILL TEMPLATE TO DRILL SECONDARY ELEVATOR BOLT HOLE.

- Align the top of the template to the edge of the A-panel extruded header.
- Center the template onto the existing elevator bolt hole.
- Use the template to mark a drill location for mounting a 2nd elevator bolt to the cover that is rearward to the center of the current elevator bolt hole.
- Mark the drilling location of the new hole with a center punch at the edge of the template as shown on the template by the arrow.
- Use a 1/8" to 1/4" drill bit as a pilot hole, then use a 5/8" drill bit for the final drill hole.
- Be sure to deburr the hole after drilling.

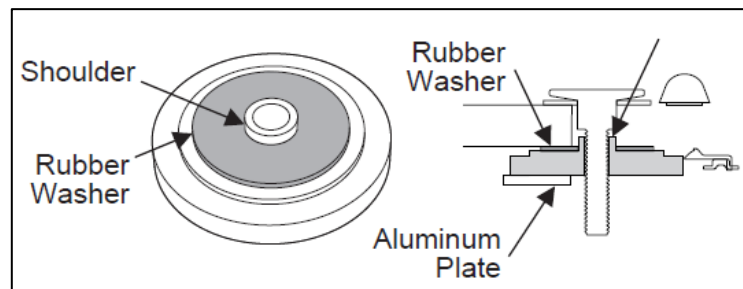
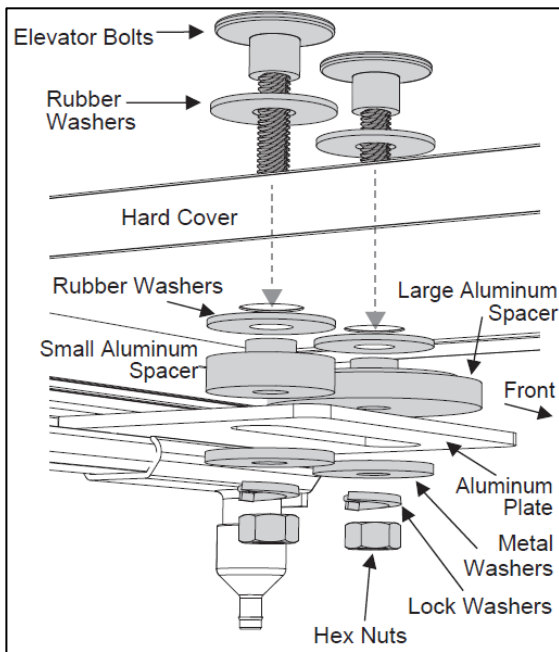
6. Positioning the Fasteners and Spacers

- Position the aluminum spacer with the rubber washers so the elevator bolt will align and pass through both the aluminum spacer and the aluminum plate.
- Assemble the metal washer and the lock washer onto the elevator bolt from underneath the slotted aluminum plate.
- Loosely install the hex nut. Do not fully tighten.

Hint: If the elevator bolt begins to spin press down on the head to stop the spinning.

Note: Make sure the rubber washer fits over the shoulder of the spacer as shown below.

Note: Make sure the large aluminum spacer is in the front and the small aluminum spacer is in the rear.



Hint: It is easiest to align the spacers by placing them on the aluminum plate with the front panel of the Tonneau cover raised (Fig 1) Lower the cover and use

the elevator bolt or an alignment tool to properly orientate the holes (Fig 2).

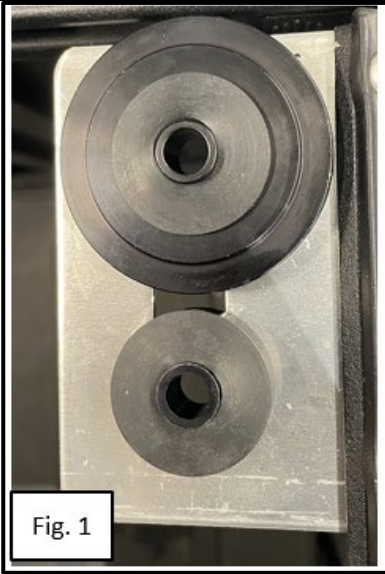
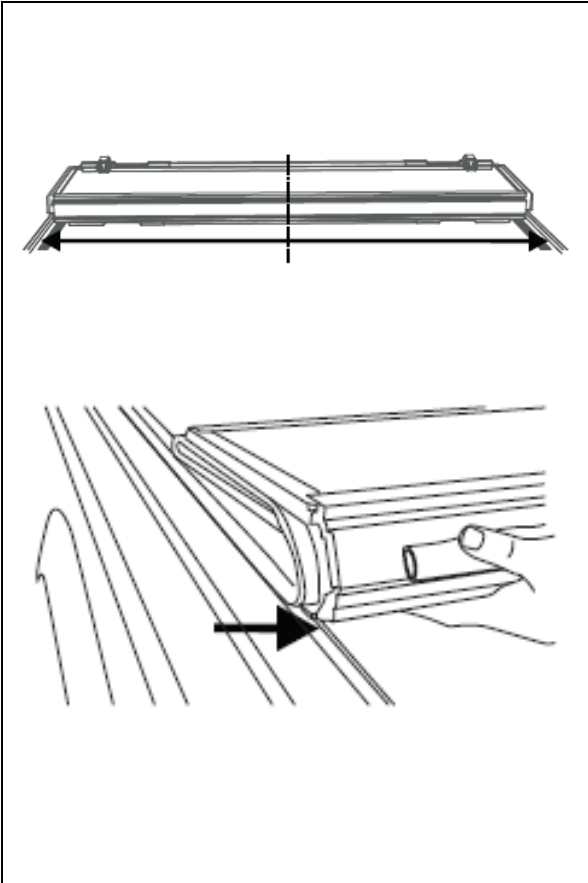


Fig. 1



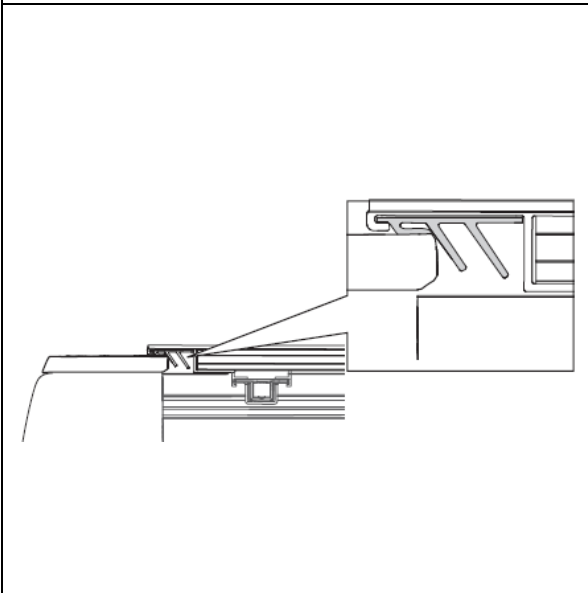
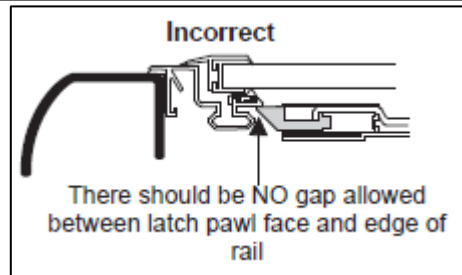
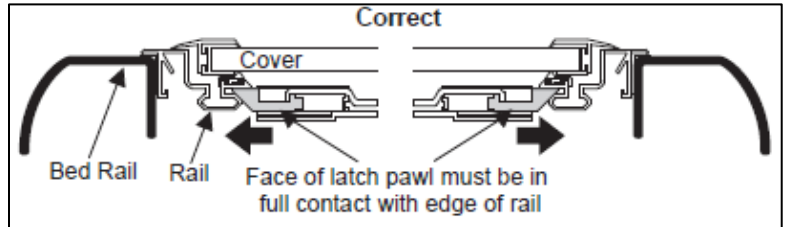
Fig. 2



7. Positioning the Cover

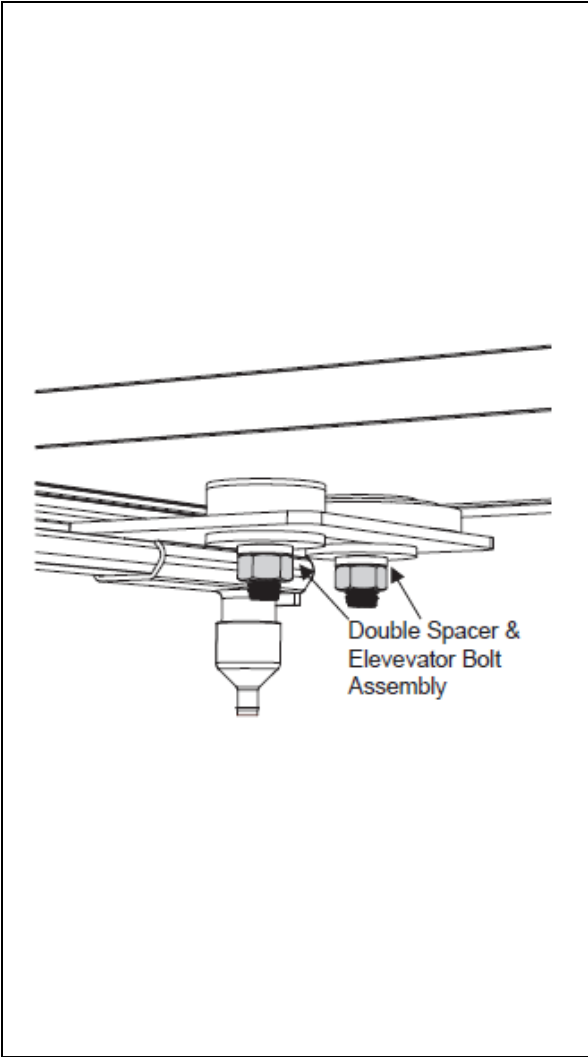
- a. Make sure the front of the cover is positioned correctly on the rail by the bulkhead. Unfold the cover toward the tailgate and make sure the cover fits squarely side to side between the rails.

Note: When the cover is adjusted correctly and is sitting square with the truck bed, the latch pawl will make proper contact with the rail as shown.



8. CHECKING THE COVER SEAL POSITION

- a. Check to make sure that the cover's rear seal has the rearward most fin on top of the tailgate and the second fin leaning on the edge of the tailgate.

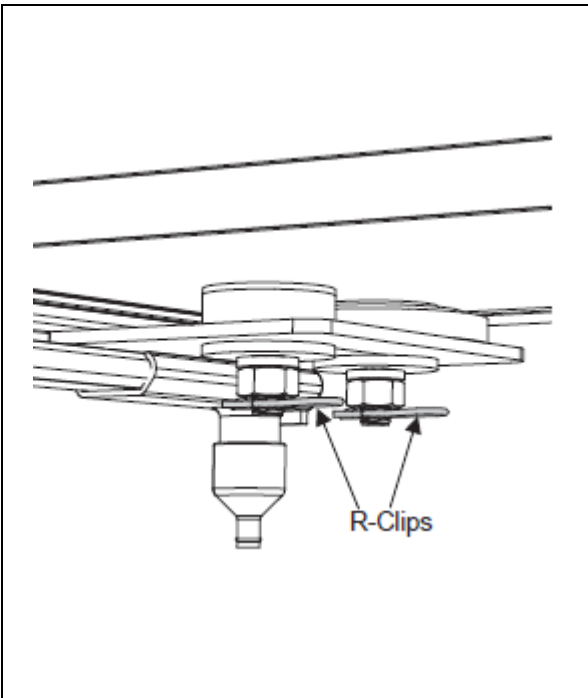
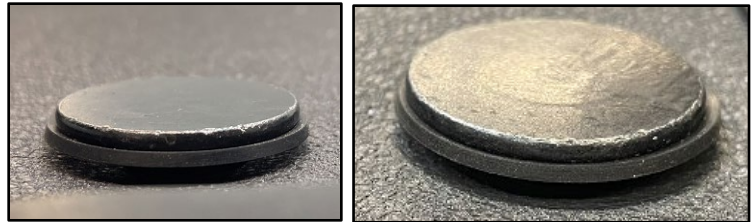


9. INSTALLING AND TORQUEING THE HEX NUTS

- a. Carefully fold the cover forward and tighten the four (4) hex nuts to 13Nm and ensure that the lock washers are completely flat.

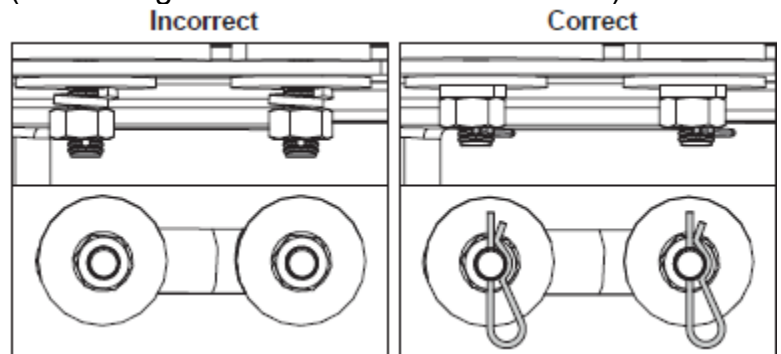
Hint: If the elevator bolt begins to spin press down on the head to stop the spinning.

- b. In some instances, after tightening the hex nut there may be slight gap on the elevator bolt. This does not affect the retention of the Tonneau Cover and is an acceptable condition. (See examples below)



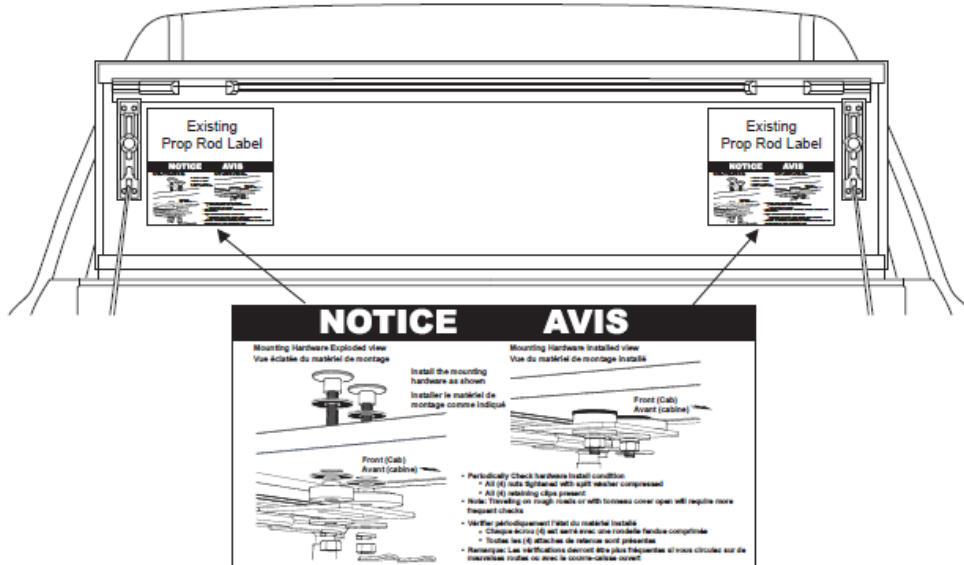
10. SECURING THE R-CLIPS

- a. Secure the four (4) R-Clips (one through the hole of each elevator bolt).



11. ATTACHING THE NEW LABEL

- The label should be attached to the panel as shown under the existing prop rod label.
- Clean the surface before adhering the new label.



◀ VERIFY REPAIR QUALITY ▶

- Confirm hex nuts are torqued properly and R-Clips are installed
- Confirm tonneau cover is aligned properly.
- Confirm that label is attached to the Tonneau cover beneath the Prop rod label.
- Confirm the area is clear of any debris that was created due to drilling, etc.
- Confirm all the old hardware has been disposed of.

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

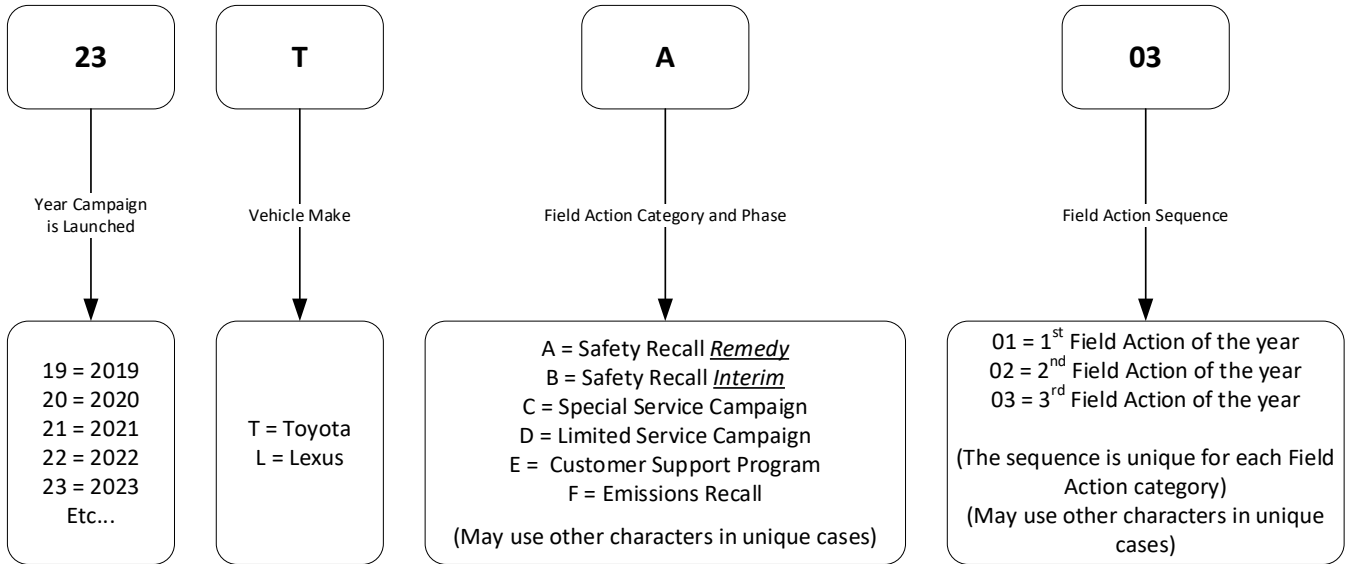
10. APPENDIX

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

23TA03 (Interim Notice 23TB03)



Examples:

- 19TA01 = Launched in 2019, Toyota, Safety Recall Remedy Phase, 1st Safety Recall Launched in 2019**
- 20TC02 = Launched in 2020, Special Service Campaign, 2nd Special Service Campaign Launched in 2020**
- 21TE05 = Launched in 2021, Customer Support Program, 5th Customer Support Program Launched in 2021**

PRINT THIS DRILL TEMPLATE

