

TECHNICAL INSTRUCTIONS

FOR

SAFETY RECALL 23TA03 (Interim Notice 23TB03)

TONNEAU COVER MAY COME OFF WHILE DRIVING

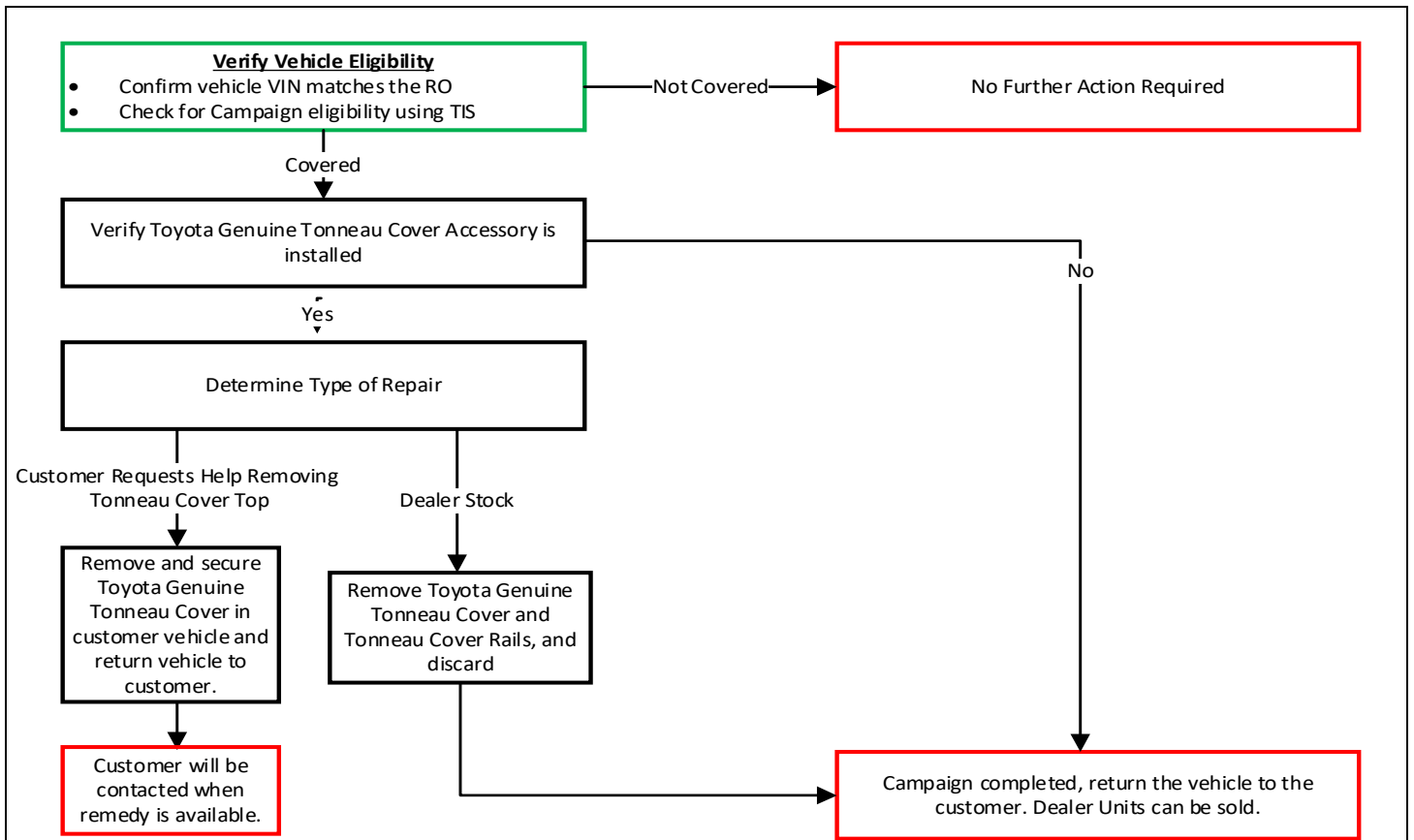
CERTAIN 2022-2023 MODEL YEAR TUNDRA and TUNDRA HV

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
00107-FMVSS	Load Carrying Capacity Modification Label	1

Note: Labels are sold in packs of 25 from the MDC

B. TOOLS & EQUIPMENT

• Standard Hand Tools	• T - 30 Torx Driver	• Torque Wrench
-----------------------	----------------------	-----------------

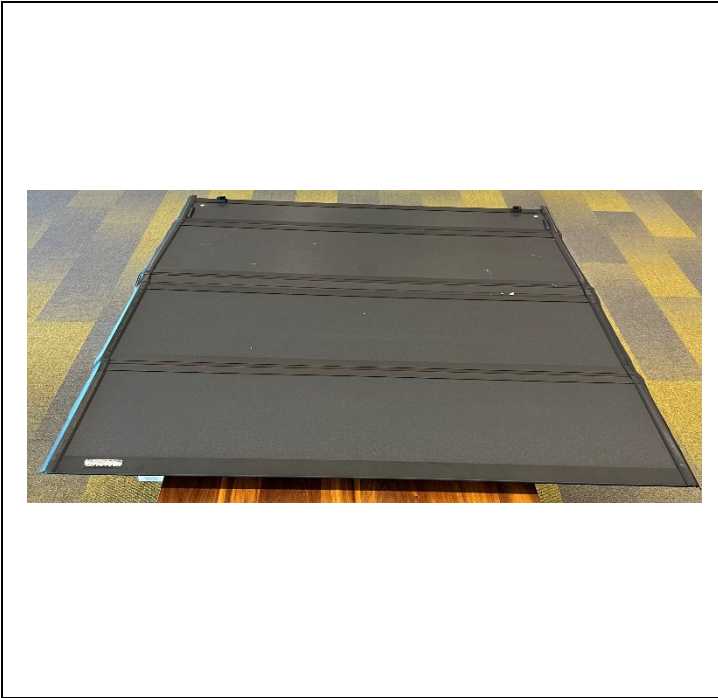
IV. BACKGROUND

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
-------------------	---------------------



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



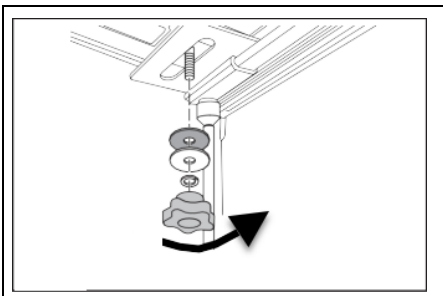
Affected Tonneau Cover for 2022-2023 Tundra and Tundra HV

- 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.

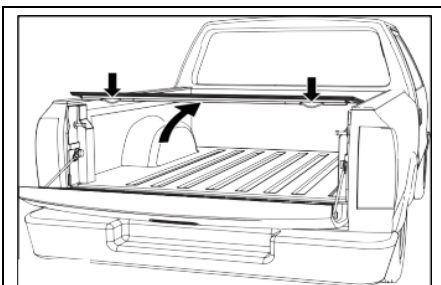
VII. DETERMINE APPROPRIATE PROCESS

For New Vehicle and TCUV Stock, see section VIII.
 For Customer Vehicle, see section IX.

VIII. REMOVE TONNEAU COVER AND TONNEAU COVER RAILS

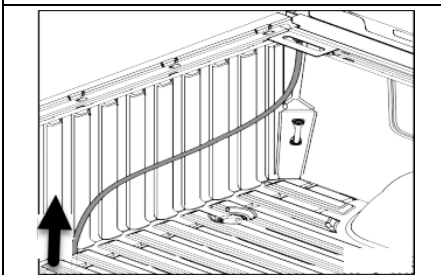
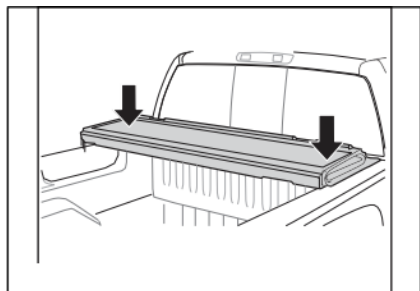


- 1. REMOVE KNOB AND HARDWARE**
 - a. Lower tailgate.
 - b. Loosen knob and remove lock washer, large flat washer, large rubber washer and knob from underneath tonneau cover.



2. REMOVE TONNEAU COVER

- a. Fold tonneau cover back.
- b. Remove from vehicle and set aside.

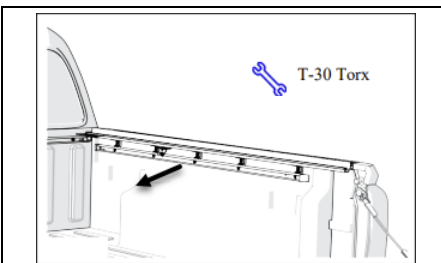


3. REMOVE DRAIN TUBE LH

- a. Remove drain tube from bed.

Hint:

- Use the same procedure for the RH side.
- Do not disconnect drain tube from the Tonneau Cover Rails.

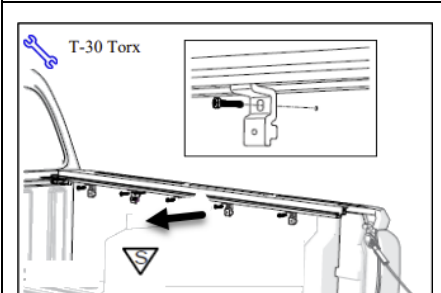


4. REMOVE ACCESSORY RAIL LH FROM TONNEAU COVER RAIL (if equipped)

- a. Loosen the LH accessory rail using T-30 Torx Driver.
- b. Remove accessory rail LH.

Hint:

- Use the same procedure for the RH side.
- Do not discard.

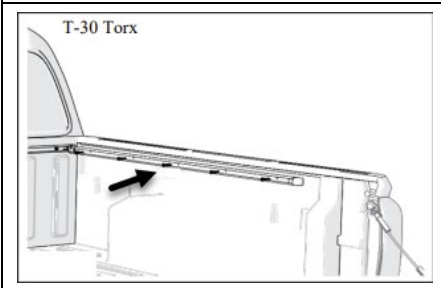


5. REMOVE TONNEAU COVER RAIL LH

- a. Loosen the LH tonneau cover rail fasteners using a T-30 Torx Driver.
- b. Remove tonneau cover rail LH.

Hint:

- Use the same procedure for the RH side.
- Do not discard hardware



6. REINSTALL ACESORY RAIL LH (if equipped)

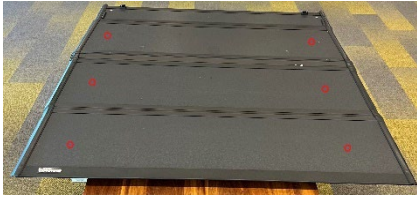
- a. Using hardware removed in Step 5, install accessory rail.

Torque:

9.0 N·m {92 kgf·cm, 6.5 ft·lbf}

Hint:

- Use the same procedure for the RH side.



7. DAMAGE TONNEAU COVER BY DRILLING HOLES IN 6 LOCATIONS AS SHOWN

- a. Using a drill bit 10mm or similar, drill 6 holes in locations shown.
- b. Discard the tonneau cover.

**CAUTION: LOAD
CARRYING CAPACITY
REDUCED**

Modifications to this
Vehicle have reduced
the original load
carrying capacity by
44 kg or
99 lbs.

8. INSTALL NEW LOAD CARRYING CAPACITY REDUCTION LABEL


- a. Locate the Load Carrying Capacity Reduction Label on the B-Pillar, inside the driver's door.
- b. Fill out the new label by subtracting the lbs/kg in the table below from the value on the current label.

Bed Size	kg	lbs
5.5'	24.7	54.5
6.5'	29.5	65.0

- c. Clean the surface of the original label with a dry cloth.
- d. Apply the new label directly over the top of the original label and ensure only new label value can be read.
- e. Confirm the label is properly adhered.

9. REPLACE MONRONEY LABEL WITH LABEL THAT DOES NOT INCLUDE TONNEAU COVER

- a. If Monroney label **does have** tonneau cover, replace Monroney label with label that **does not** include tonneau cover.
- b. If Monroney label **does not have** tonneau cover, there are no changes needed.



TOYOTA

DESC: **TUNDRA 4X4** **PLATINUM CREWMAX 5.5**

VIN: [REDACTED]

YR/MDL: [REDACTED]

CLR: CELESTIAL SILVER/LA21 (01/9/21)

FINAL ASSEMBLY POINT: SAN ANTONIO, TEXAS, U.S.A.

STANDARD EQUIPMENT
UNLESS REPLACED BY OPTIONAL EQUIPMENT

MECHANICAL & PERFORMANCE

- FORCE Twin-Turbo V6, DOHC 24V with Dual VVT-i, 389 hp/479 lb-ft
- 10-Spd Auto Trans with Sequential Shift
- Drive Mode Select with TOW/HAUL Modes
- 4WDemand Part-Time 4WD w/Elec Controlled Transfer Case and Auto Limited Slip Diff
- Multi-Link Rear Suspension
- Tow Hitch w/Trailer 4/7-Pin Connector

SAFETY & CONVENIENCE

- Toyota Safety Sense 2.5: Pre-Collision Sys w/Pedestrian Detection, Full-Speed Range Dynamic Radar Cruise Control, Lane Departure Alert w/Steering Assist, Lane Tracing Assist, Automatic High Beams, Road Sign Assist
- Trailer Brake Cont & Trailer Sway Cont
- Blind Spot Monitor w/RCTA
- Trailer Backup Guide w/Straight Path
- Connected Services Capable, 4G network dependent. SeeToyota.com for details.

BASE MANUFACTURER'S SUGGESTED RETAIL PRICE \$61,775.00

OPTIONAL EQUIPMENT

FE	50 State Emissions	
AQ	Advanced Package - Includes Load-leveling rear height control air suspension, Adaptive Variable Suspension (AVS), and 10-inch color Head-Up Display (HUD)	1,645.00
MQ	PVM + 8SM Tow Mirrors (black)	290.00
RB	Power running boards and power bed step	1,350.00
GN	Cargo Net	49.00
MT	Mini-Truck Bed	45.00
SA	Tri-Fold Tonneau Cover	1,295.00

GOVERNMENT 5-STAR SAFETY RATINGS

This vehicle has not been rated by the government for overall vehicle score, frontal crash, side crash or rollover risk.

Star ratings range from 1 to 5 stars (★★★★★) with 5 being the highest. Source: National Highway Traffic Safety Administration (NHTSA) www.safercar.gov or 1-888-327-4236

EPA DOT Fuel Economy and Environment Gasoline Vehicle

Fuel Economy

19 MPG 17 22

combined city/hwy city highway

5.3 gallons per 100 miles

You spend \$3,750 more in fuel costs over 5 years compared to the average new vehicle.

Annual fuel COST \$2,350

Fuel Economy & Greenhouse Gas Rating (tailpipe only) **Smog Rating** (tailpipe only)

1 4 10 1 5 10

This vehicle emits 460 grams CO₂ per mile. The best emits 0 grams per mile (tailpipe only). Producing and distributing fuel also create emissions. Learn more at fuel economy.gov.

MANUFACTURER'S SUGGESTED RETAIL PRICE \$66,449.00


DELIVERY, PROCESSING AND HANDLING FEE 1,795.00

TOTAL \$68,244.00

Actual results will vary for many reasons, including driving conditions and how you drive and maintain your vehicle. The average new vehicle gets 28 MPG and costs \$5,900 to fuel over 5 years. Cost estimates are based on 15,000 miles per year at \$2.95 per gallon. MPG is miles per gasoline gallon equivalent. Vehicle emissions are a significant cause of climate change and smog.

fuel economy.gov
Calculate personalized estimates and compare vehicles

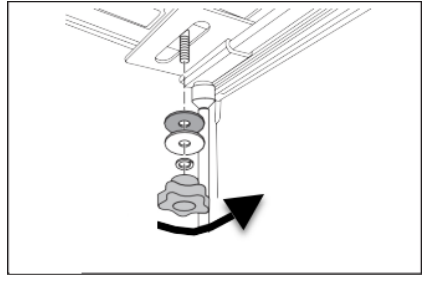
Delivered by Truck to: 04304
TEAM MEMBER VEH SVCS-TOY
ATTN: VEHICLE SERVICES
6565 HEADQUARTERS DR
PLANO TX 75024



THL4E2N1S0F0W0

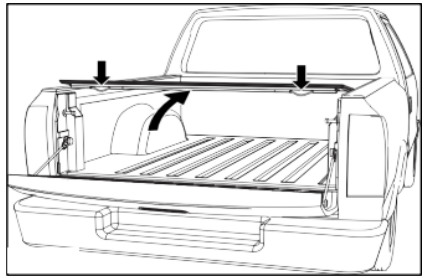
8

IX. CUSTOMER ASSISTED TONNEAU COVER TOP REMOVAL (UPON CUSTOMER REQUEST ONLY)



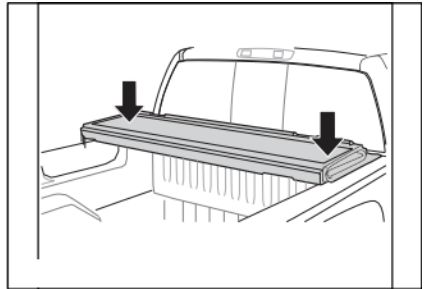
1. REMOVE KNOB AND HARDWARE

- a. Lower tailgate.
- b. Loosen knob and remove lock washer, large flat washer, large rubber washer and knob from underneath tonneau cover.



2. REMOVE TONNEAU COVER

- a. Fold tonneau cover back.
- b. Secure tonneau cover to itself by buckling both buckles as shown.
- c. Release latch to remove tonneau cover from rails.



3. SECURE TONNEAU COVER IN CUSTOMER'S BED

- a. Slide tonneau cover in customer's bed.
- b. Secure in customer's bed.
- c. Advise customer not to use tonneau cover until remedy is available.

◀ VERIFY REPAIR QUALITY ▶

- Confirm all accessory rail fasteners are torqued properly
- Confirm tonneau cover and rails are disposed of properly

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

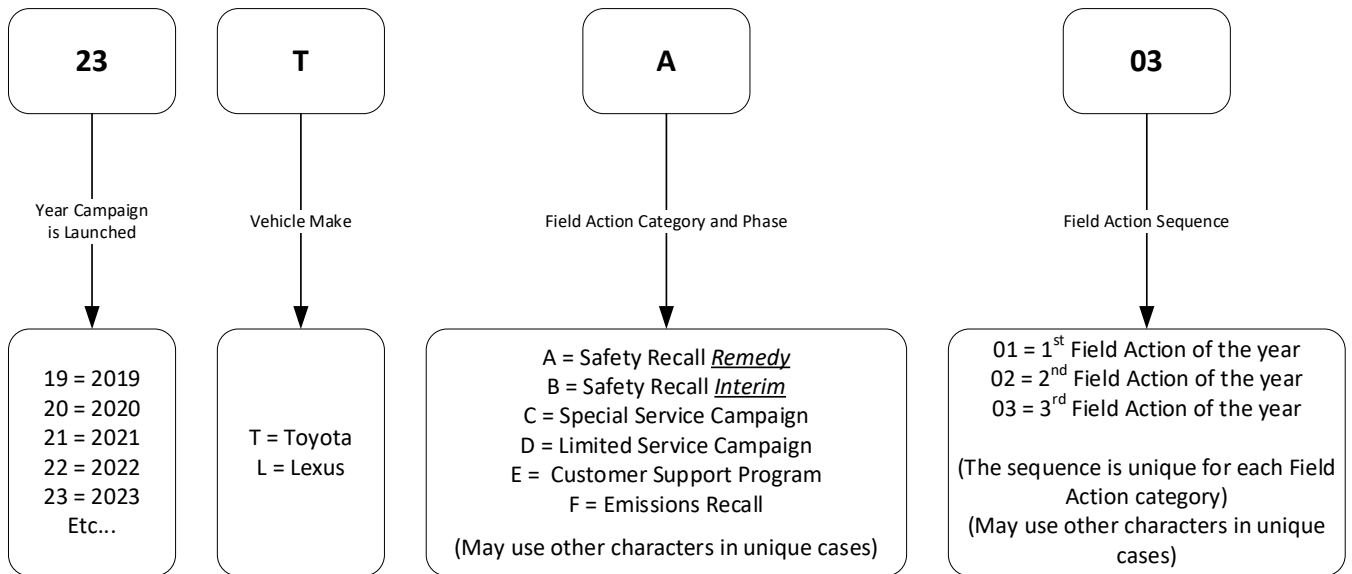
10. APPENDIX

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