

TECHNICAL INSTRUCTIONS

FOR

SAFETY RECALL 25TA12

SECOND ROW SEAT RAIL REPLACEMENT ON BRAUN REAR ENTRY

MOBILITY VEHICLES.

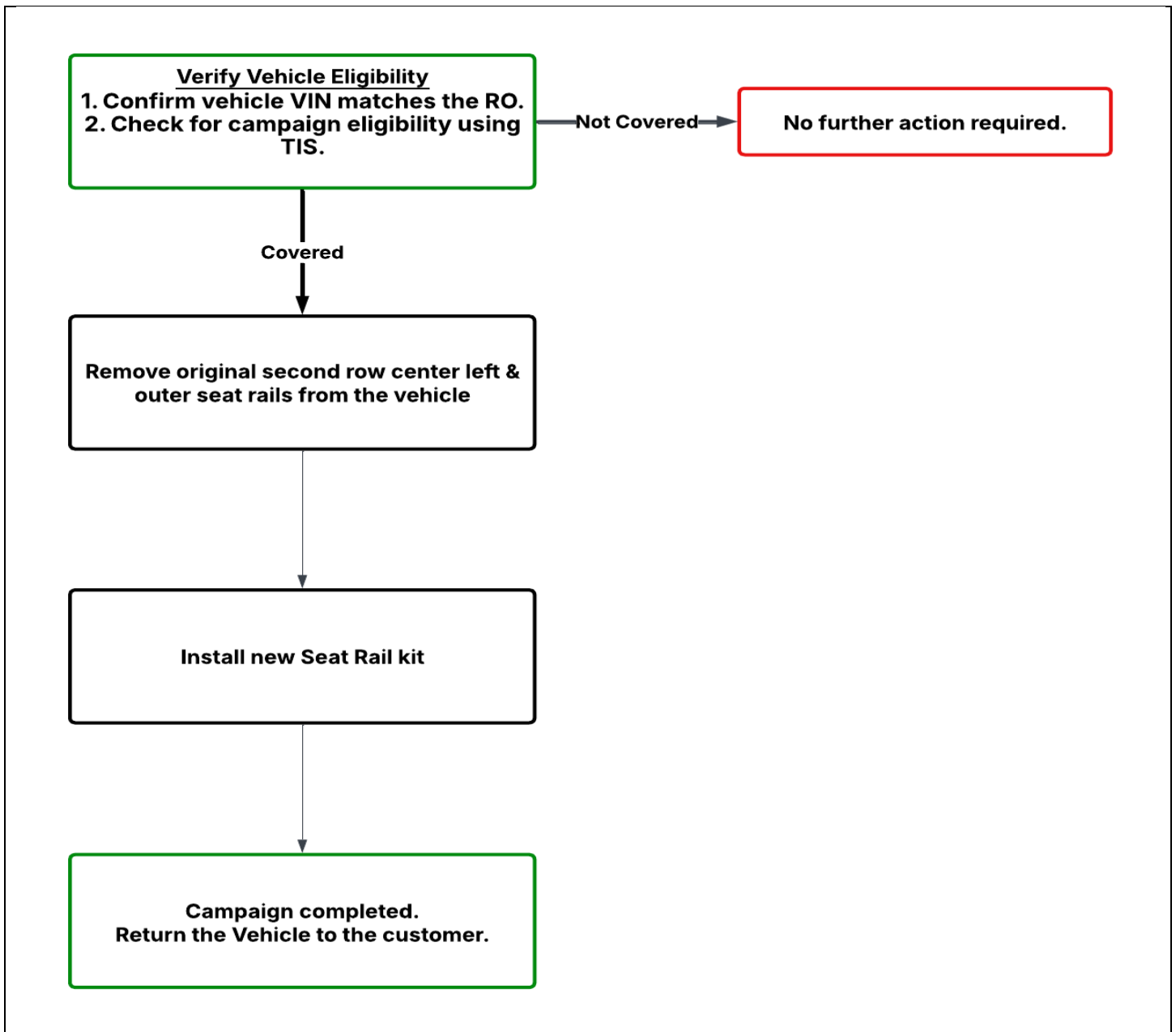
CERTAIN 8 PASSENGER 2025 MODEL YEAR SIENNA

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 repair are required to currently have completed all of the following courses:

- TIC206B Electrical Repair 2

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 vehicle's 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

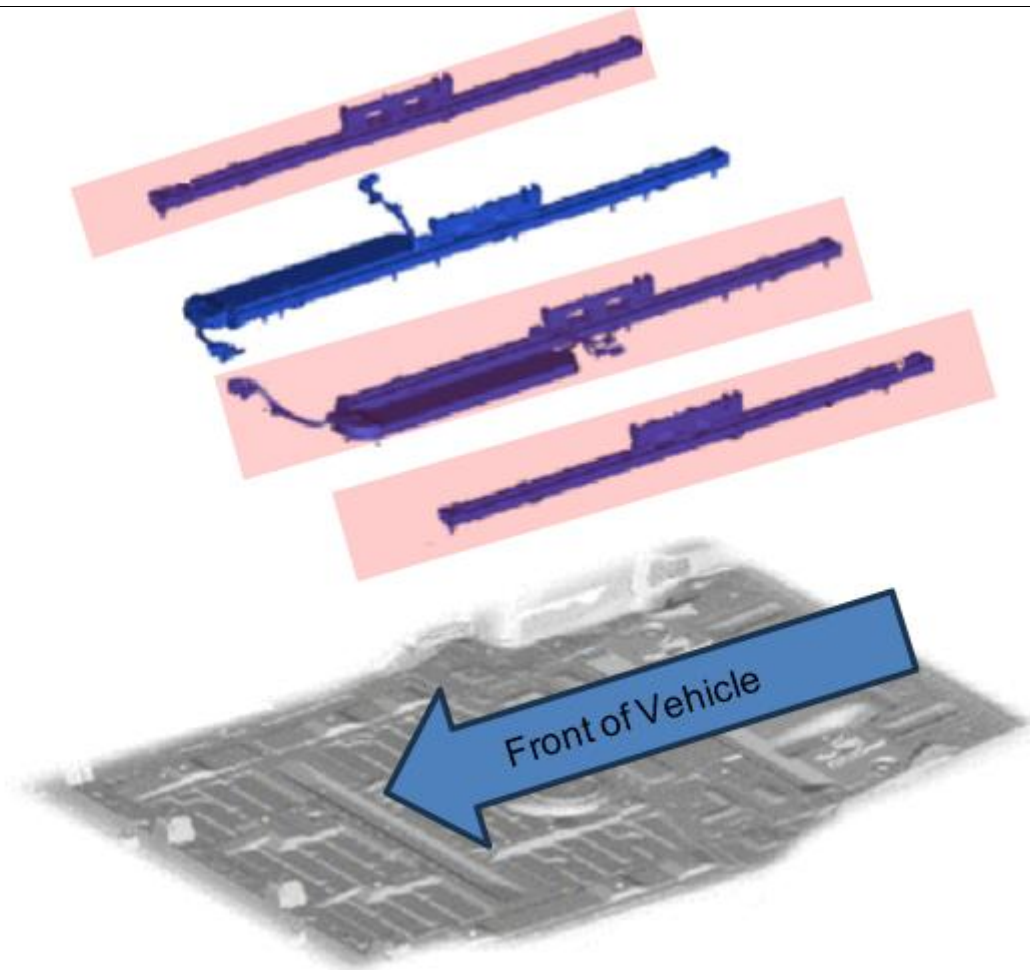
Part Number	Part Description	Quantity
04005-41208	TRACK ASSY, SEAT SET	1*
*The kit above includes the following parts:		
Part Number	Part Description	Quantity
72190-08240	TRACK ASSY, NO.2 SEAT, LH	1
72170-08100	TRACK ASSY, RR SEAT, OUTER LH	1
72160-08110	TRACK ASSY, RR SEAT, OUTER RH	1

B. TOOLS & EQUIPMENT

• Techstream	• Standard Hand Tools	• Torque Wrench
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IV. BACKGROUND

The subject vehicles contain second-row seats that are mounted on seat rails that may have been improperly welded



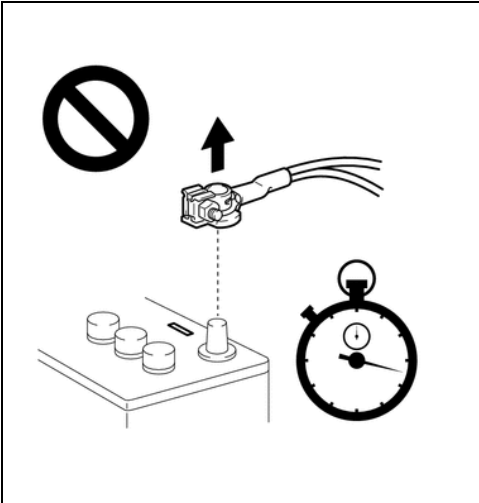
V. WORK PROCEDURE



1. PREPARE INTERIOR FOR REPAIR

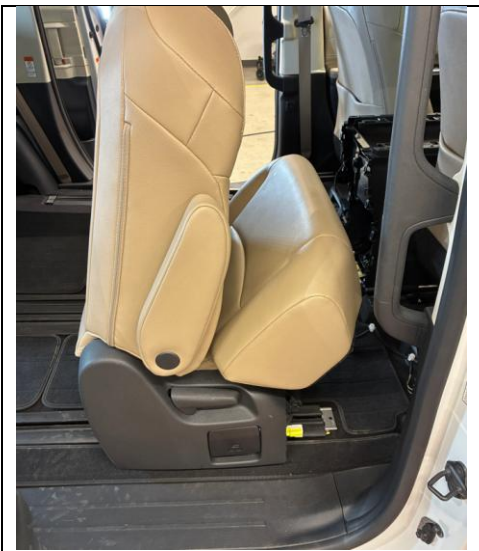
- Adjust the front seats to their forward-most positions.
- Adjust the recline setting to its upward position.
- Install fender covers onto the sliding door entrances.
- Stage a moving blanket to place removed seats and interior panels.

- Remove the 2nd row seat headrests and place them in a safe area.



2. REMOVE THE NEGATIVE BATTERY TERMINAL.

- a. Remove the negative battery terminal and wait at least 60 seconds after disconnecting the cable from the negative (-) terminal before disconnecting any airbag connectors.

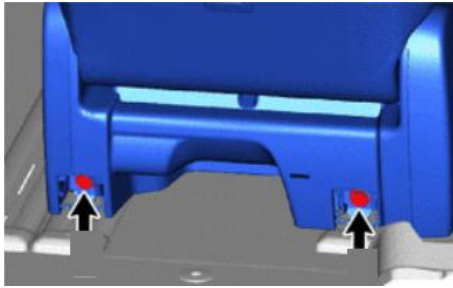


3. REMOVE THE PASSENGER SIDE 2ND ROW SEAT

- a. Adjust the passenger side 2nd row seat to its forward-most position.



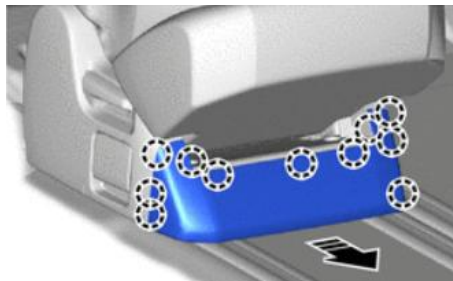
- b. Open the (2) passenger side rear bolt access covers.



- c. Remove the (2) bolts on the rear side of the passenger side rear No. 1 seat assembly.



- d. Slide the 2nd row passenger seat to its rearward-most position.



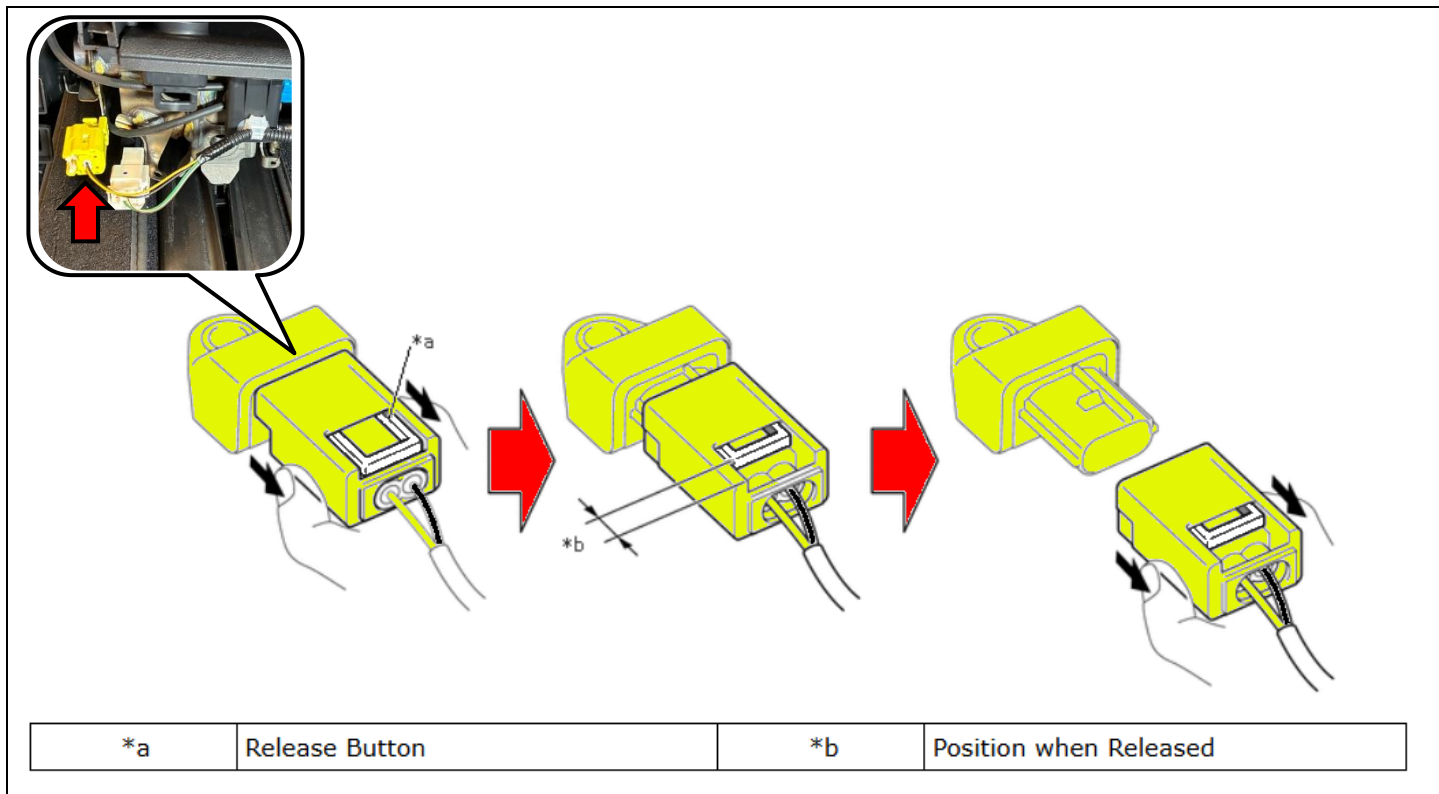
- e. Remove the seat cushion lower shield by pulling forward to disengage the clips.

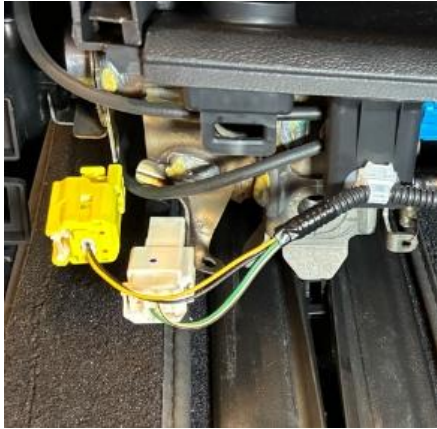


- f. Disconnect the yellow rear seat airbag assembly connector under the passenger side rear No. 1 seat assembly
- I. Push down the release button and slide the sides of the connector in the direction shown by the arrows in the illustration below. (**At this time, the connector cannot be disconnected yet.**)
- HINT: Check that the position of the release button is as shown in the illustration below.
- II. Push down the release button and slide the connector again to disconnect the airbag connector.

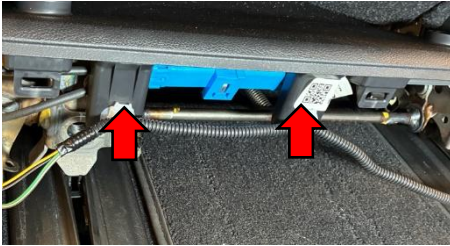
NOTE:

- When disconnecting any airbag connector, take care not to damage the airbag wire harness.
- Pushing down on the top of the connector will prevent the lock from being released, so hold the sides of the connector.





- g. Disconnect the white connector.
- h. Detach the (2) harness clips from the seat assembly.



- i. Remove the (2) bolts on the front side of the passenger side rear No. 1 seat assembly.

NOTE: Be sure not to damage the airbag connector or harness when removing the seat bolt.



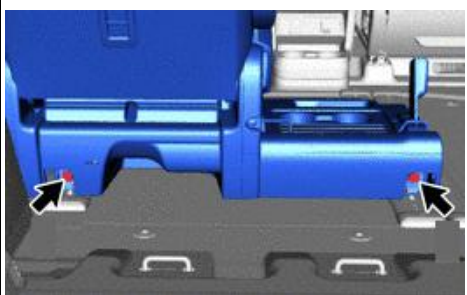


4. REMOVE THE DRIVER SIDE 2ND ROW SEAT

a. Adjust the driver side 2nd row seat to its forward-most position.



b. Open the (2) driver side rear bolt access covers.

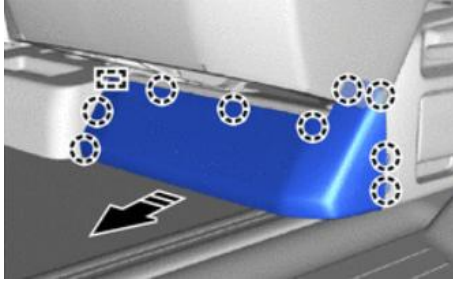


c. Remove the (2) bolts on the rear side of the driver side rear No. 1 seat assembly.

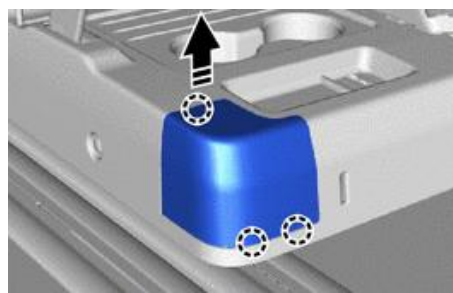




d. Slide the 2nd row driver's seat to its rearward-most position.



e. Remove the seat cushion lower shield by pulling forward to disengage the clips.



f. Remove the seat cushion center shield by pulling up to disengage the clips.



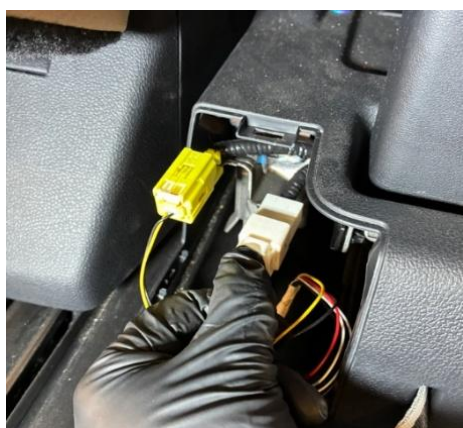
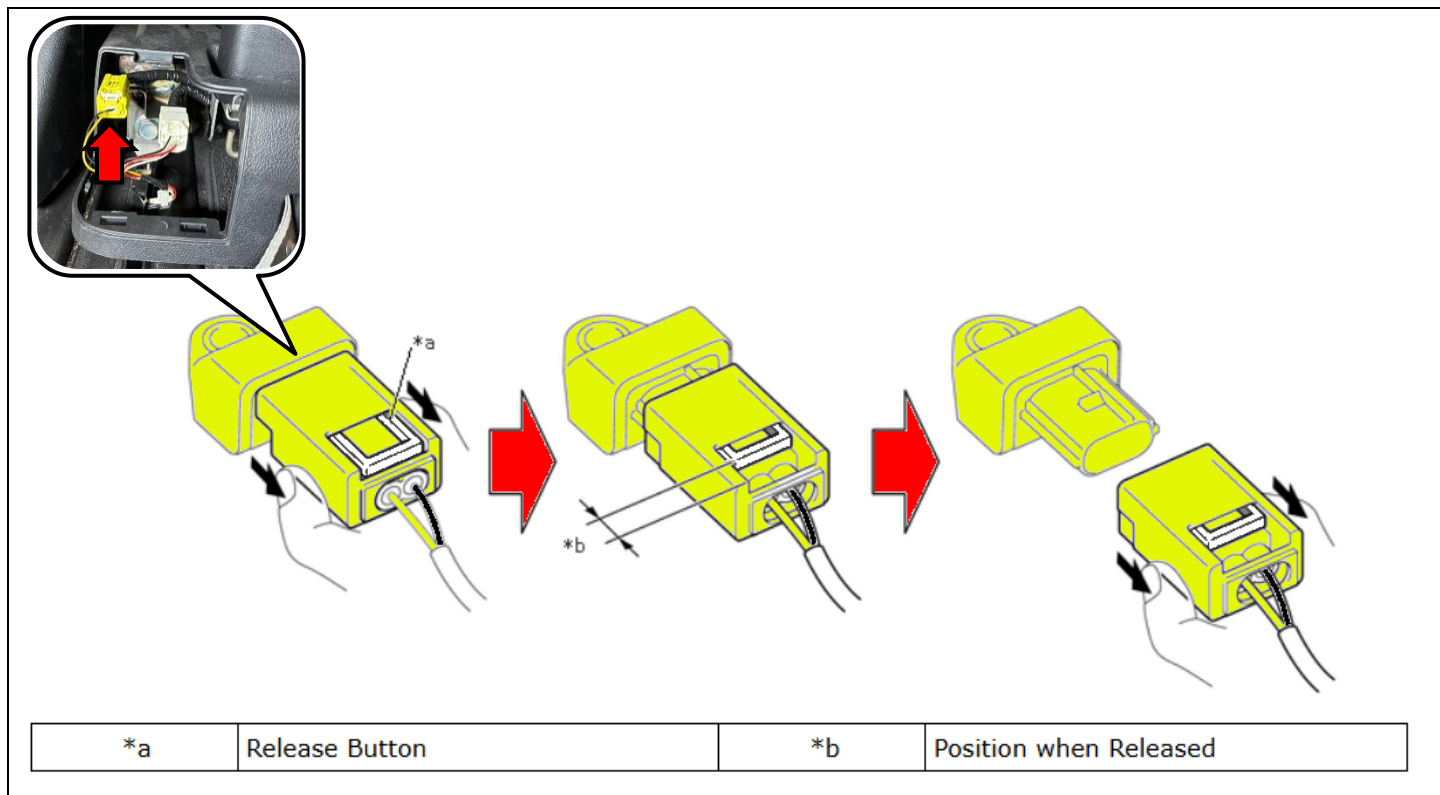
- g. Disconnect the yellow rear seat airbag assembly connector under the driver side rear No. 1 seat assembly
- Push down the release button and slide the sides of the connector in the direction shown by the arrows in the illustration below. **(At this time, the connector cannot be disconnected yet.)**

HINT: Check that the position of the release button is as shown in the illustration below.

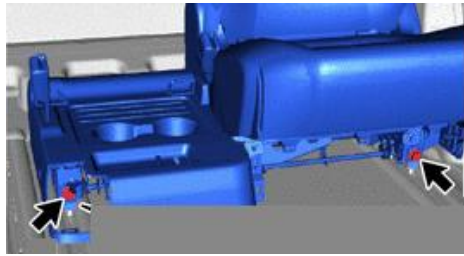
- Push down the release button and slide the connector again to disconnect the airbag connector.

NOTE:

- When disconnecting any airbag connector, take care not to damage the airbag wire harness.
- Pushing down on the top of the connector will prevent the lock from being released, so hold the sides of the connector.

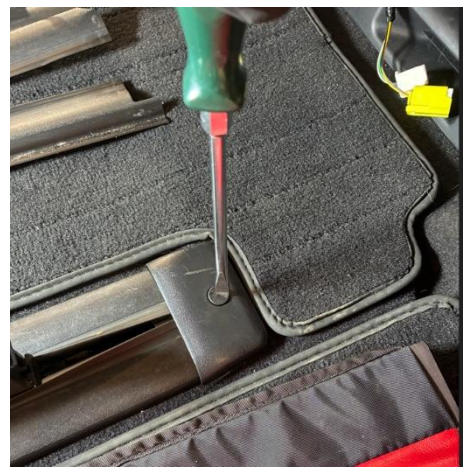


- h. Disconnect the white connector.



- i. Remove the (2) bolts on the front side of the driver side rear No. 1 seat assembly.

NOTE: Be sure not to damage the airbag connector or harness when removing the seat bolt.



5. REMOVE THE DRIVER SIDE AND PASSENGER SIDE OUTBOARD SEAT TRACK LOWER RAILS

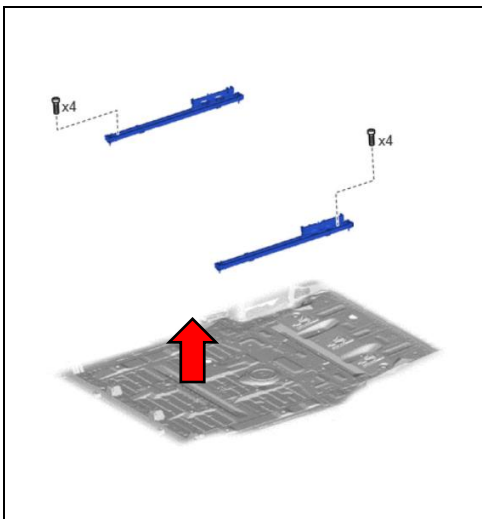
- a. Remove the (2) driver side floor carpet mouldings.
- b. Repeat process for passenger side.



- c. Remove the (2) driver side seat track lower rail outer protectors.
- d. Pull up from the inside beginning at the front and slowly work your way to the rear to remove the protector.
- e. Repeat process for passenger side.



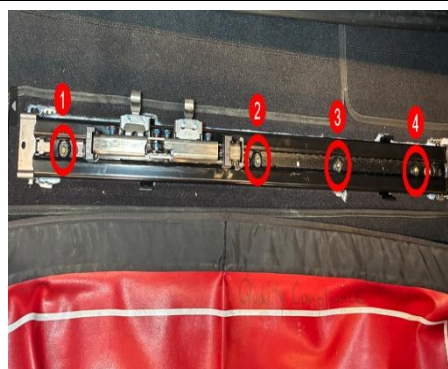
NOTE: Keep these organized by rail in a safe location, as they will be reinstalled in a later step.



- f. Slide the rail so that its position allows for access to all four bolts.
- g. Using a T50 "TORX" socket and hand ratchet, remove the driver side outboard seat track lower rail assembly bolts, then remove the rail assembly from the vehicle.

NOTE: "T50 TORX" bolts must be removed by hand to avoid damage to the cage holding the nut under the rail.

- h. Using a paint marker, mark it with an "X".
- i. Repeat the process for the passenger side outboard rail assembly.



- j. Install the **NEW** driver side outboard seat track lower rail assembly.
- k. Slide the rails so that all four bolt holes are accessible.
- l. Hand-tighten the bolts.

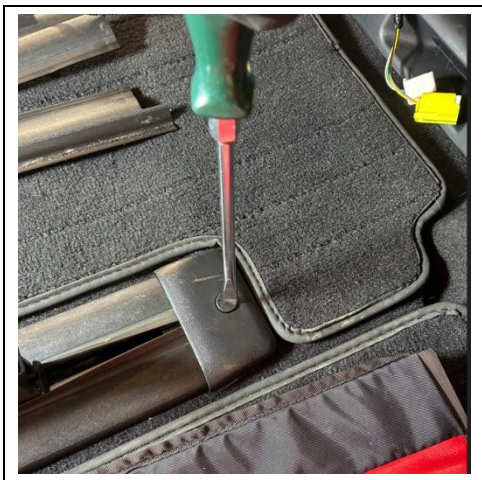
Note: Do not use an impact wrench while tightening the rail bolts as this will result in damage to the nut cage under the floor.

m. Torque the bolts in sequence, starting from the front, working towards the rear (1-4).

n. Repeat the process for the passenger side outboard seat track lower rail assembly.

Torque:

39 N·m {29 ft·lbf}

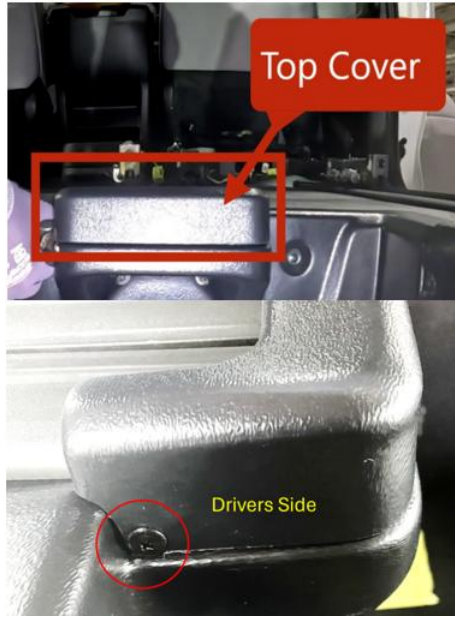


6. REMOVE THE DRIVER SIDE CENTER UPPER RAIL ASSEMBLY

- a. Remove the (2) floor carpet moldings.



- b. Remove the (2) seat track lower rail outer protectors.
- c. Pull up from the inside, beginning at the front, and slowly work your way to the rear to remove the protector.



- d. Remove the two screws holding the top cover



- e. Remove the top upper 3 screws along the top of the panel.

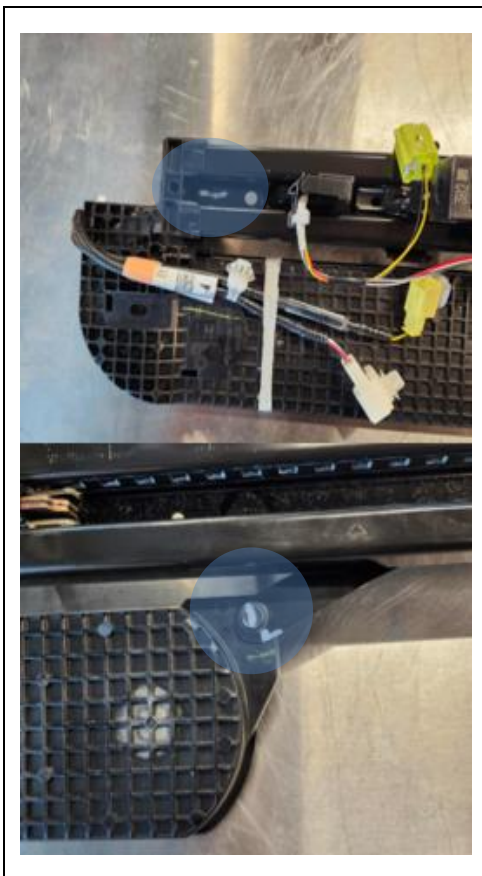


- f. Gently pull the panel backwards.



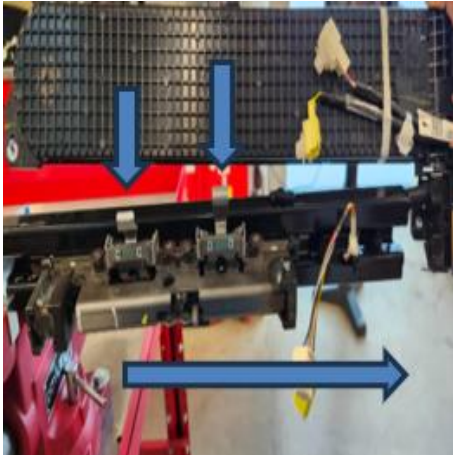
g. Pushing down on the 2 side tabs of the upper rail ,slide the rail towards the back and stop once you see the two hooks of the rail at which point you can push down and out to separate from the wiring harness.

h. Mark the removed rail to avoid re-using the defective part.



7. TRANSFER UPPER RAIL FROM KIT PROVIDED.

a. Remove the (2) screws holding the harness to the rail



b. Push tabs down and slide the rail towards the open end.



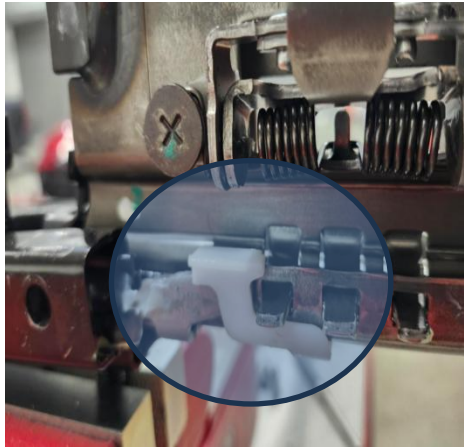
c. Remove Wire harness and continue removing upper rail.



8. INSTALL UPPER RAIL ON VEHICLE

(Rail removed for visibility keep in mind Upper rail can be replaced while installed on the vehicle)

- a. Push wiring harness slightly to attach as shown on the picture, once engaged start pushing the upper rail into the lower rail assembly.



- b. Pay close attention to the white tabs make sure they are lined up before pushing rail in



- c. Push down on front lever and slide rail in slowly until it stops.



- d. When the rail stops make sure that the black plastic guide is on the inside of the rail on both sides before pushing it forward. **Failure to follow this step will damage the guide.**



- e. Once confirmed the plastic guide is on the inside of the rail on both sides tap the rail forward into position.



- f. With the upper rail fully seated on the lower rail proceed to install previously removed screws holding the plastic panel in place.

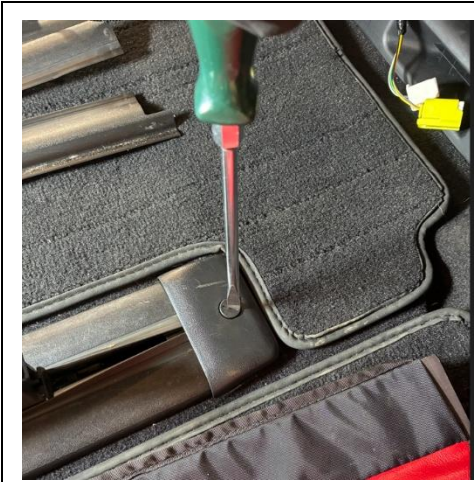


9. REINSTALL THE SEAT TRACK LOWER RAIL OUTER PROTECTORS & TOP COVER

- a. Reinstall all (6) seat track lower rail outer protectors.
- b. Install by pressing firmly, starting from the front, working towards the rear.



- c. Re install top cover.



10. REINSTALL THE FLOOR CARPET MOULDINGS

- a. Reinstall all (6) floor carpet mouldings.

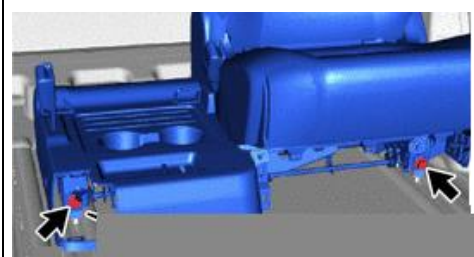


11. REISNTALL 2ND ROW SEATS

- a. Prepare by making sure that all (4) seat track rails are locked in place in parallel with each other.
- b. Reinstall the driver's side rear No. 1 seat assembly into the vehicle.

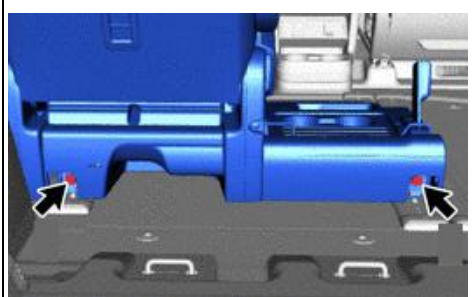
NOTE:

- Be sure that the airbag wire harness has been cleared from the seat assembly before attempting to reinstall the seat.



- c. Hand-tighten the (2) bolts on the front side of the driver's side rear No. 1 seat assembly.

NOTE: Be sure not to damage the airbag connector or harness when installing the seat bolt.



- d. Install the (2) bolts on the rear side of the driver side rear No. 1 seat assembly.



- e. Torque all (4) bolts.

Torque:

65 N·m {48 ft·lbf}

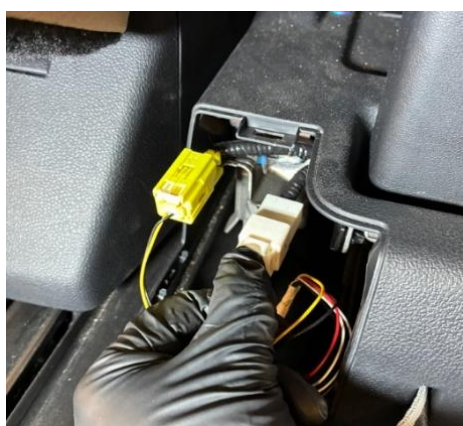
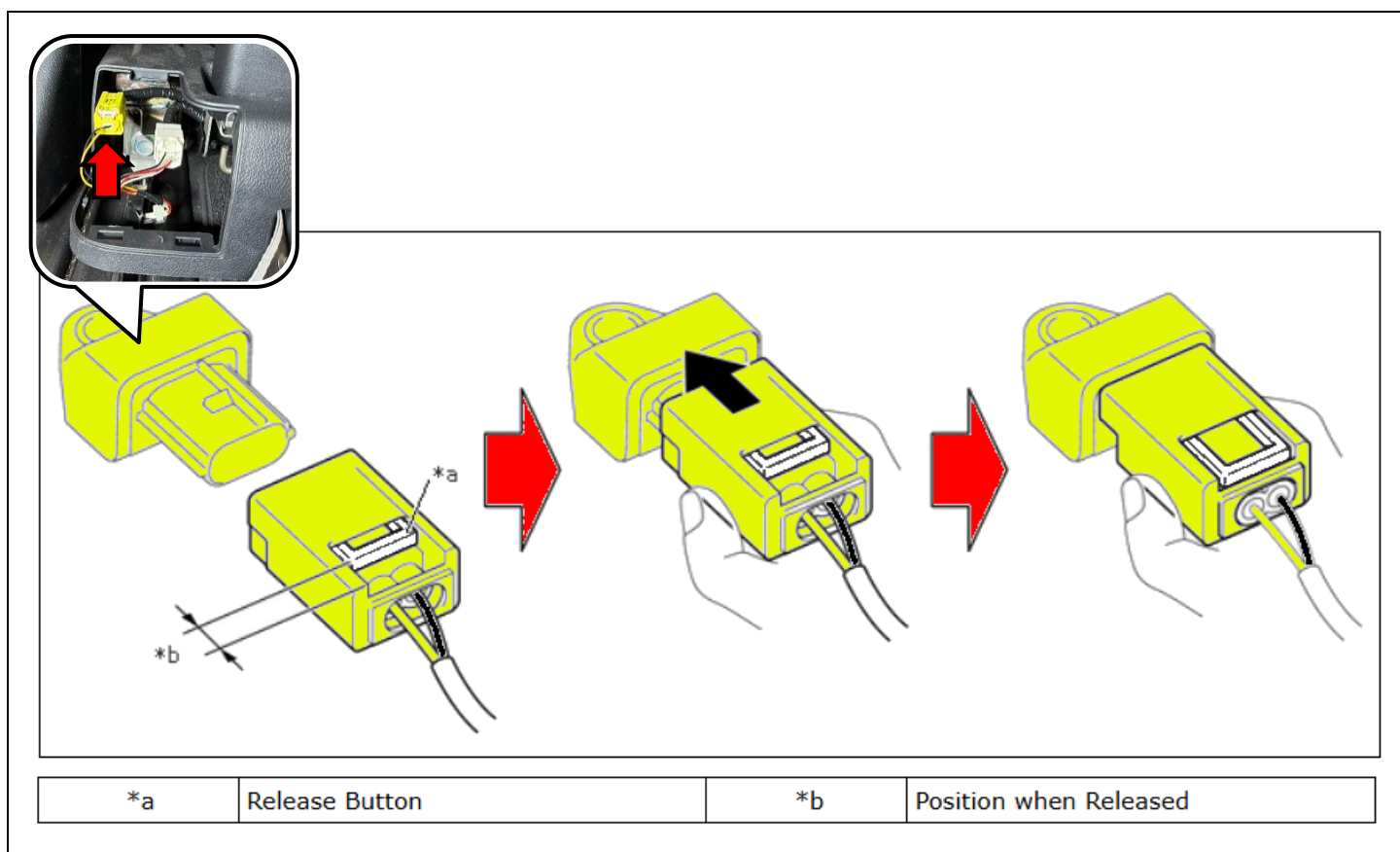
f. Reinstall the airbag connector.

HINT:

- Before connecting the connector, check that the position of the release button is as shown in the illustration.
- While holding the sides of the connector, slide the connector in the direction shown by the arrow in the illustration until a click sound is heard to connect the airbag connector, and check that the release button is in its original position.

NOTE:

- Slide the connector in straight to connect it. Be careful not to pry the connector.
- To prevent deformation of the connector and possible damage to the partial engagement prevention mechanism, do not press down on the top surface of the connector when connecting it. Be sure to hold the connector by the sides.



g. Reconnect the white connector.



h. Reinstall seat covers.



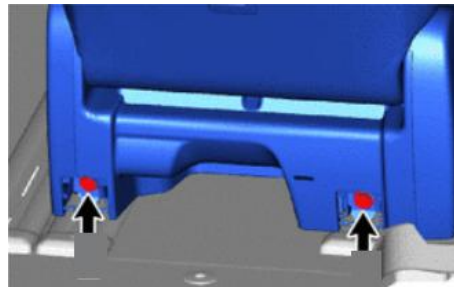
i. Reinstall the passenger's side rear No. 1 seat assembly into the vehicle.

NOTE:

- Be sure that the airbag wire harness has been cleared from the seat assembly before attempting to reinstall the seat.

j. Hand-tighten the (2) bolts on the front side of the passenger side rear No. 1 seat assembly.

NOTE: Be sure not to damage the airbag connector or harness when installing the seat bolt.



k. Install the (2) bolts on the rear side of the passenger side rear No. 1 seat assembly.



l. Torque all (4) bolts.

Torque:

65 N·m {48 ft·lbf}

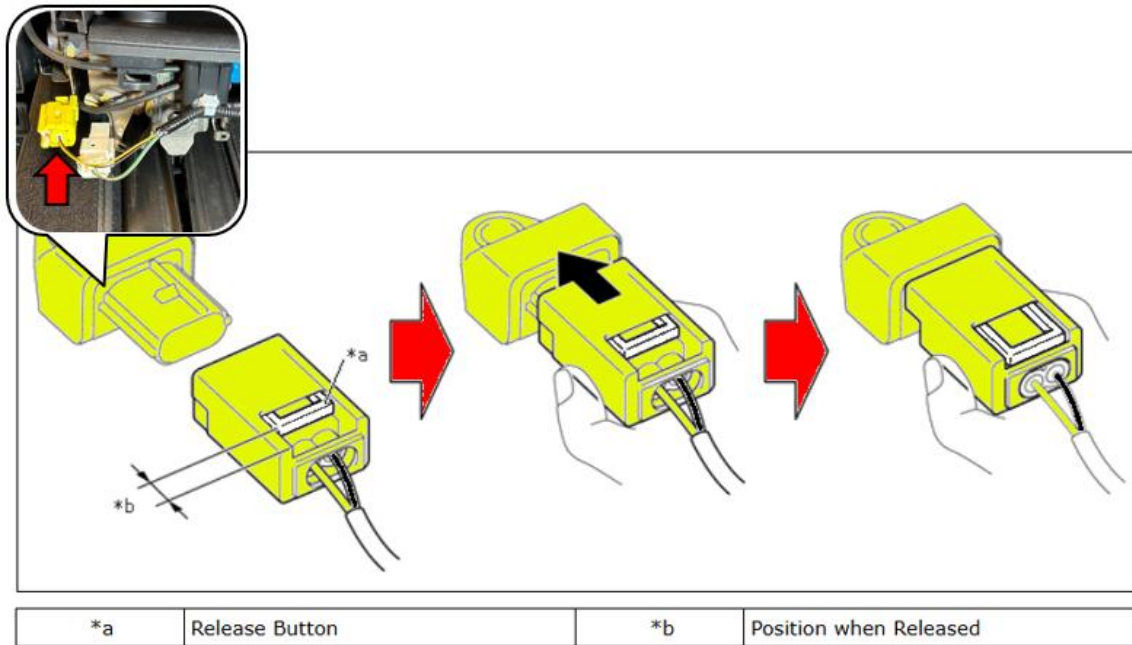
m. Reinstall the airbag connector.

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- To prevent deformation of the connector and possible damage to the partial engagement prevention mechanism, do not press down on the top surface of the connector when connecting it. Be sure to hold the connector by the sides.



n. Reconnect the white connector.



o. Reinstall the airbag wire harness clips.

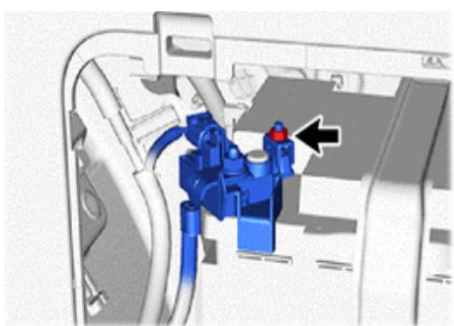


- p. Reinstall the seat covers.



12. REINSTALL HEADRESTS

- a. Reinstall both headrests.



13. CONNECT 12V BATTERY.

- a. Connect negative battery terminal.
- b. If equipped with power doors, initialize power doors by manually opening and closing left, right and rear door.
- c. Test for correct function of sunroof & auto up/down windows, if needed perform initialization procedure.



14. CHECK SRS WARNING LIGHT

- a. Turn the ignition switch to ON and check that the SRS warning light turns on.
- b. Turn the ignition switch off. Wait for at least 2 seconds, then turn the ignition switch to ON. The SRS warning light comes on for approximately 6 seconds, a diagnosis of the airbag system is performed, and then the light turns off.

NOTE: If the SRS warning light remains on for longer than 6 seconds after the ignition switch has been turned to ON, there may be a malfunction in the SRS airbag system.

◀ VERIFY REPAIR QUALITY ▶

- Confirm that the SRS warning light turns off after approximately 6 seconds.
- Confirm all seat covers and trim panels are correctly installed.
- Confirm seats slide smoothly on new rails.

VI. 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.***