

## **TECHNICAL INSTRUCTIONS**

**FOR**

### **SAFETY RECALL 25TA16**

**Upper 3<sup>rd</sup> Row Center Seatbelt Anchor Bolt May be Cross Threaded**

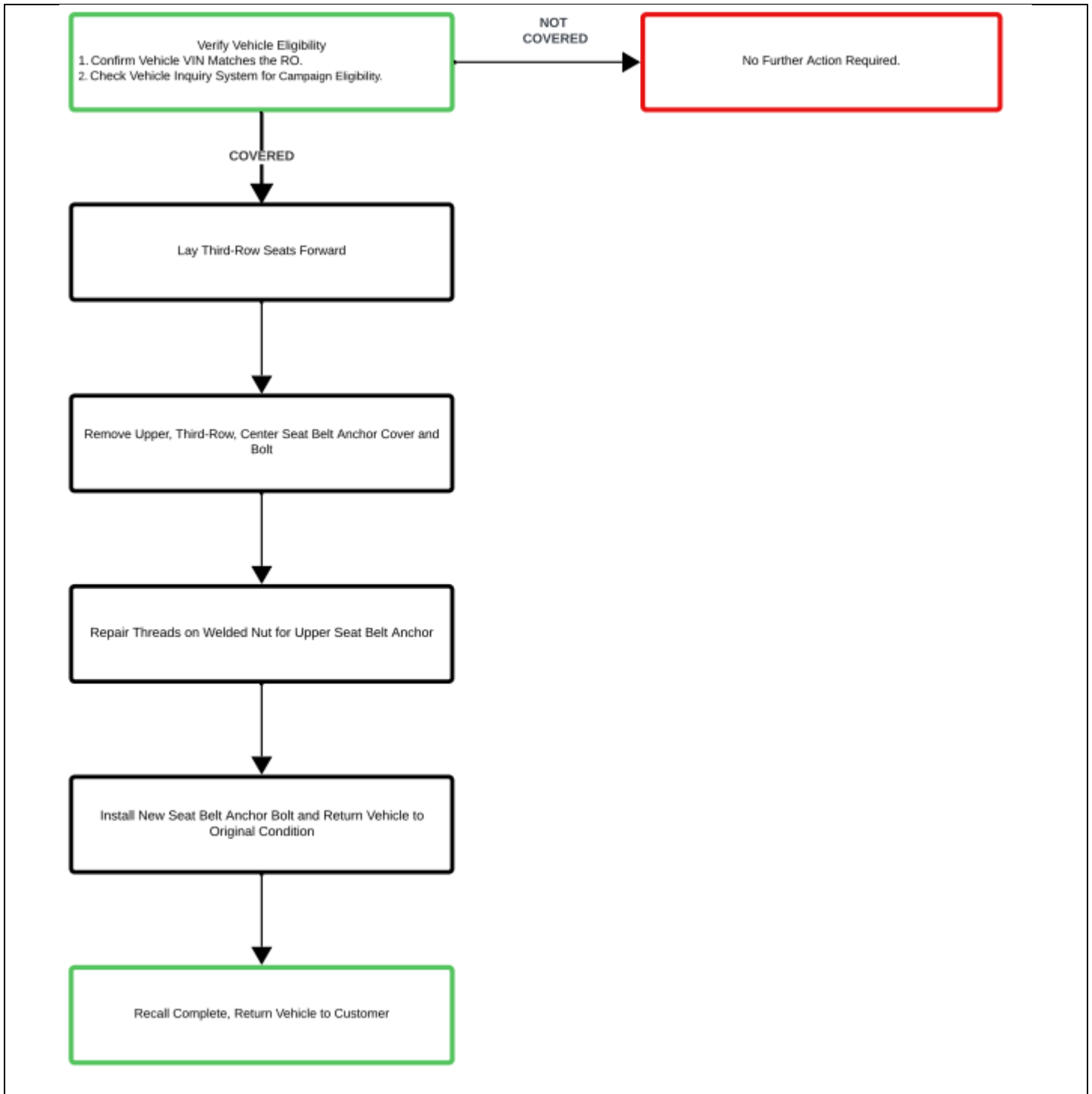
**Certain 2024- 2025 Model Year Highlander and Highlander HV**

**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 repair are required to currently hold the flowing certification:**

**- Toyota Master Diagnostic Technician Certification**

**It is the dealership’s responsibility to select technicians that hold the above certification 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	Part Description	Quantity
90105-A0088	Seat Belt Anchor Bolt	1

### B. TOOLS & EQUIPMENT

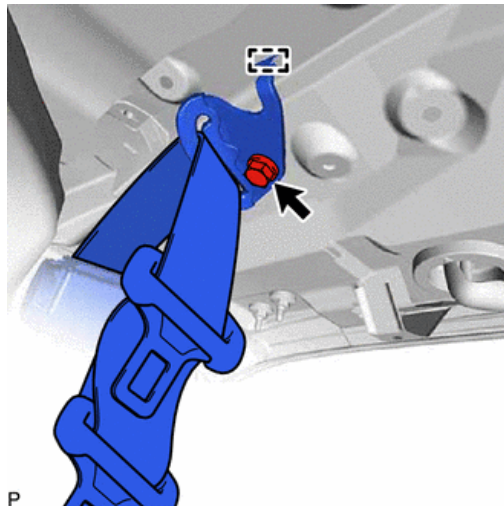
• 3/8" 14mm Socket	• 3/8" Ratchet	• 7/16" x 20NF Bottoming Tap and Tap holder
• 3/8 "Torque Wrench	• Clip & trim removal tools	• Measuring Tape
• Tape for Marking Tap		

## IV. WORK PROCEDURE TABLE OF CONTENTS

BACKGROUND .....	SECTION V.
REPAIR PROCEDURE .....	SECTION VI.
APPENDIX .....	SECTION VII.

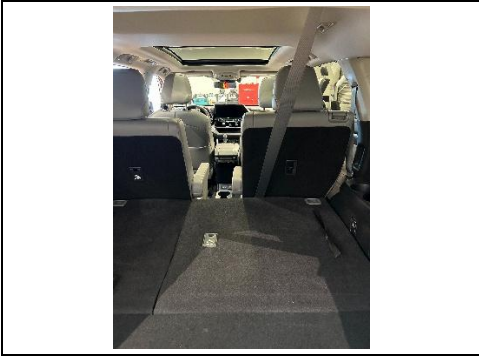
## V. BACKGROUND

The third-row center upper seat belt anchor bolt may have been cross-threaded during the manufacturing process and can cause the vehicle not to comply with federal safety standards. A cross threaded seat belt anchor bolt can affect seat belt performance and increase the risk of injury during certain collisions.



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## VI. REPAIR PROCEDURE



### 1. Prepare the Vehicle

- a) If third-row seat backs are upright, fold seats forward
- b) Place a cover over the rear cargo area and seats to catch potential shaving from thread cleaning procedure.

### 2. Remove the Third-Row, Center, Upper Seat belt Anchor cover

- a) Locate the third-row, center, upper seat belt anchor cover.
- b) Carefully remove the seat belt anchor cover, using a trim removal tool, if necessary, by gently prying down on the cover.

#### **NOTICE:**

**Before working inside the vehicle, ensure your hands and all tools being used are cleaned, to avoid leaving marks in the customer vehicle, especially on the headliner.**

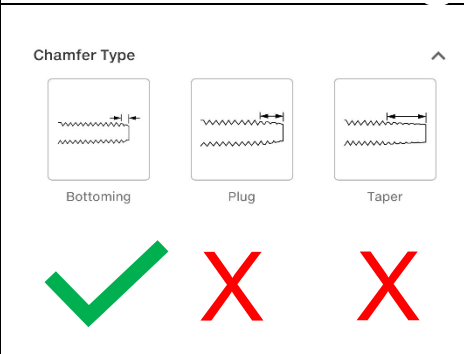
**HINT:** If the seat belt is connected to the lower anchor point, there is no need to disconnect it to complete this repair.





### 3. Remove Seat Belt Anchor Bolt

- a) Using a 14mm socket, remove the upper seat belt anchor bolt.
- b) Slide seat belt anchor down the seat belt and place out of the way.



### 4. Ensure Proper Tap is Being Used

- a) Ensure tap being used to complete the repair is a 7/16"x20 NF **BOTTOMING** tap
- b) Use of an improper tap, such as a taper tap, could result in incomplete repair of the welded nut threads, or damage to the vehicle roof, as an improper type of tap may not have enough complete cutting threads to reach all the way through the welded nut without contacting the vehicle roof



### 5. Use Tap to Repair Threads

- a) Using a measuring tape, mark  $\frac{3}{4}$ " back from the lead end of the tap. Once marked, wrap tape around the tap with the edge on the tap aligned with you mark and  $\frac{3}{4}$ " of threads exposed. This ensures the tap is not driven too deep, as damage to the vehicle's roof could be the result
- b) Insert a 7/16"x20NM tap into the welded nut for the seat bolt anchor bolt and thread in as far as you can **BY HAND**.
- c) Using a **manual** tap driver, **carefully** begin driving tap into the welded nut to clean the threads, making sure to only repair existing threads – **DO NOT CUT NEW THREADS**.



#### NOTICE:

- **DO NOT** use power tools during this repair
- **Only drive tap the minimum depth necessary to clean all the threads, excessive depth can result in damage to the vehicle's roof**
- **EXTREME** care must be taken to ensure threads are not further damaged and new threads are not cut
- **If the welded nut is further damaged, new threads are cut, or threads are too damaged to repair IMMEDIATELY contact Quality Compliance at [quality\\_compliance@toyota.com](mailto:quality_compliance@toyota.com). DO NOT ATTEMPT FURTHER REPAIR.**

**HINT:** Due to the damage being repaired, some resistance should be expected when driving the tap. If excessive resistance is present, **DO NOT** continue. Remove tap, ensure tap is being driven straight and new threads are not being cut, and try again. A small amount of cutting oil can be applied to the tap to aid the repair.



Example: Body panel damage due to a tap being run too deep



## 6. Reinstall Seat belt Anchor

- Place seat belt anchor in proper position and install new seat belt anchor bolt **BY HAND**.
- Once the seat belt anchor bolt is hand tight, torque bolt to 42 nm.

### NOTICE:

If seat belt anchor bolt cannot be properly torqued after repair is complete, **IMMEDIATELY** contact Quality Compliance at [quality\\_compliance@toyota.com](mailto:quality_compliance@toyota.com). **DO NOT ATTEMPT FURTHER REPAIR.**



## 7. Reinstall Seat Belt Anchor Plastic Cover and Return Vehicle to Original Condition

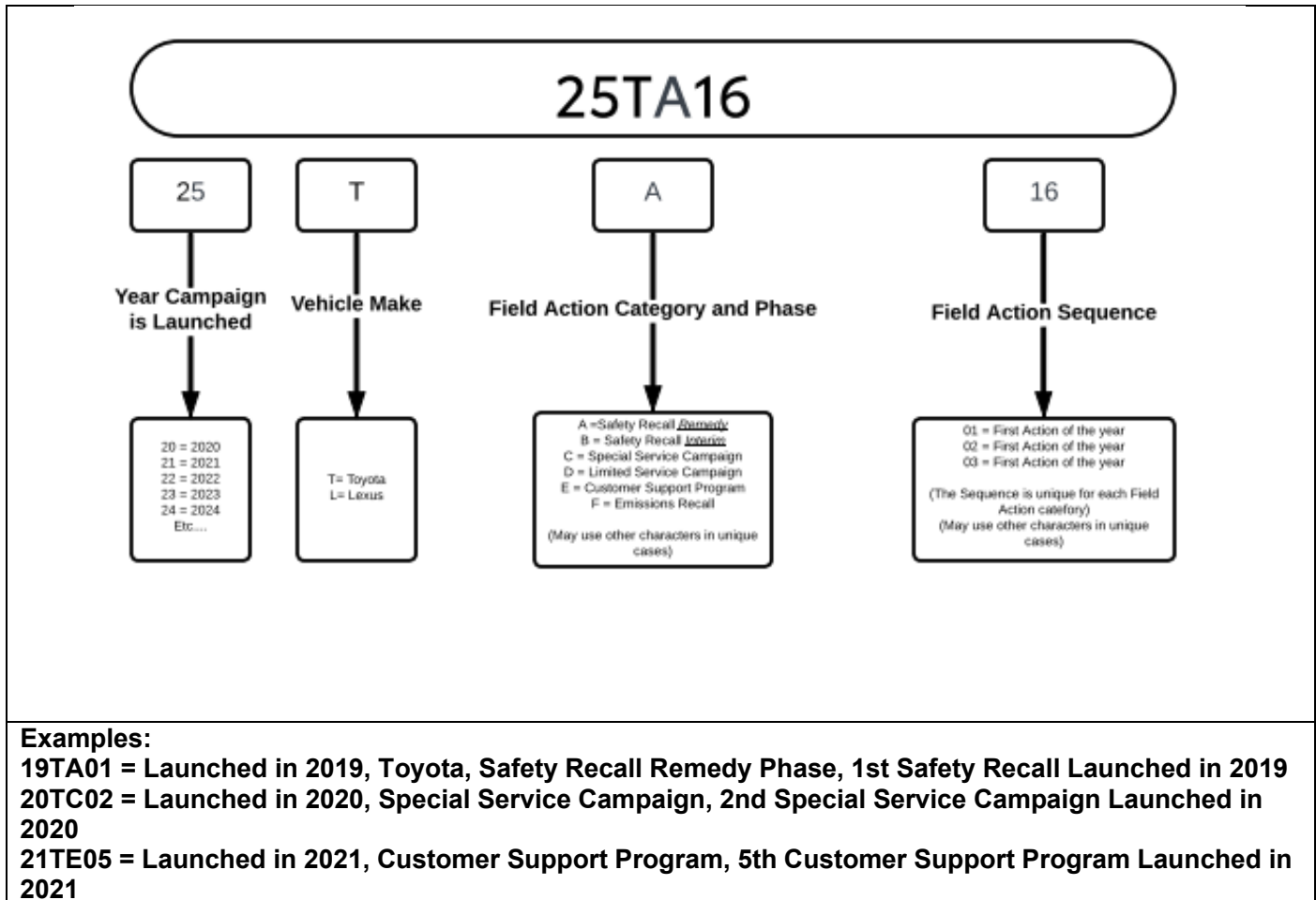
- Place cover back over seat belt anchor and press firmly upward to reinstall.
- Confirm there are no dirt smudges on head liner.
- Put rear seat and seat belt to the original condition present when vehicle arrived.

## ◀ VERIFY REPAIR QUALITY ▶

- Confirm satisfactory appearance and cleanliness of the vehicle interior before returning the vehicle to the customer.
- Return the 3<sup>rd</sup> row seat to its original position for the customer.

## VII. APPENDIX

### A. CAMPAIGN DESIGNATION DECODER



### B. CAMPAIGN PARTS DISPOSAL

As required by Federal Regulations, please make sure all campaign 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.**