

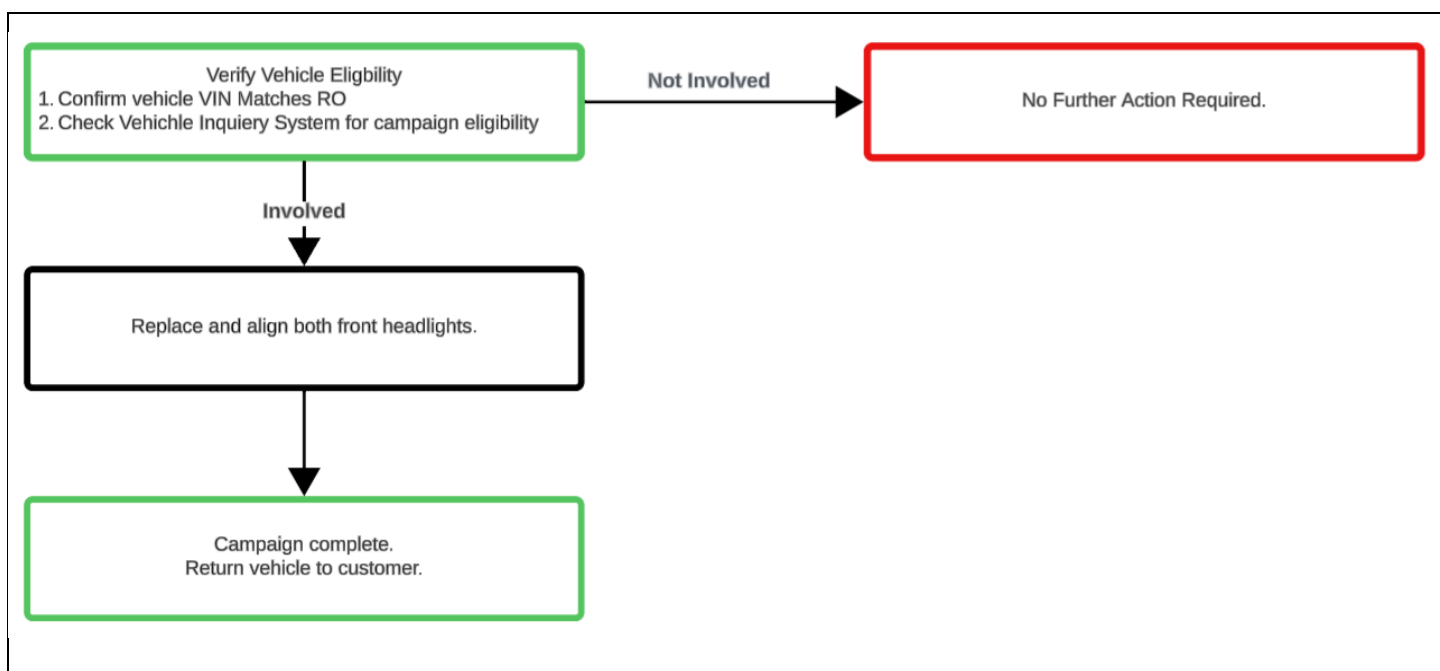
**TECHNICAL INSTRUCTIONS  
FOR  
CAMPAIGN 26TA05  
HEADLIGHT OPTICAL MARK  
CERTAIN 2026 MODEL YEAR COROLLA**

**The repair quality of covered vehicles is extremely important to Toyota. All dealership technicians performing this repair are required to 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 have completed all of the following courses:**

**TIC206B – Electrical Repair 2**

**Always check which technicians can perform the repair by logging on to <https://toyotacertification.com>  
The dealership is responsible for selecting technicians who have completed the above courses to perform this repair. Carefully review your resources, the technician’s skill level, and ability before assigning technicians to this repair. It is important to consider technician days off and vacation schedules to ensure properly trained technicians are 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.

#### NOTICE:

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
81110-02Q70	HEADLAMP ASSY, RH	1
81150-02Q70	HEADLAMP ASSY, LH	1

### B. TOOLS & EQUIPMENT

• Standard Hand Tools	• Torque Wrench	• Tape Measure
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### C. MATERIALS

• Protective Glasses	• Protective Gloves	• Protective Tape
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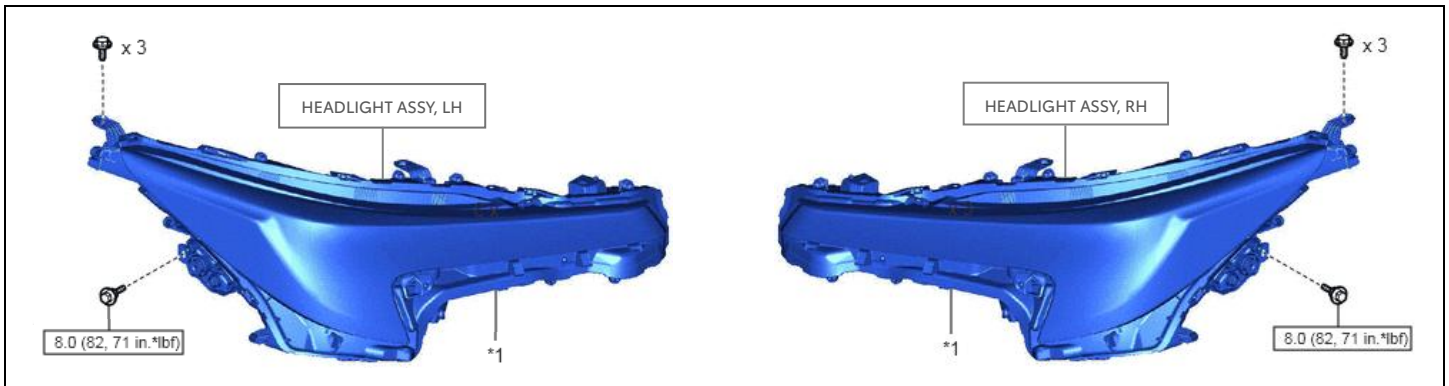
## IV. WORK PROCEDURE TABLE OF CONTENTS

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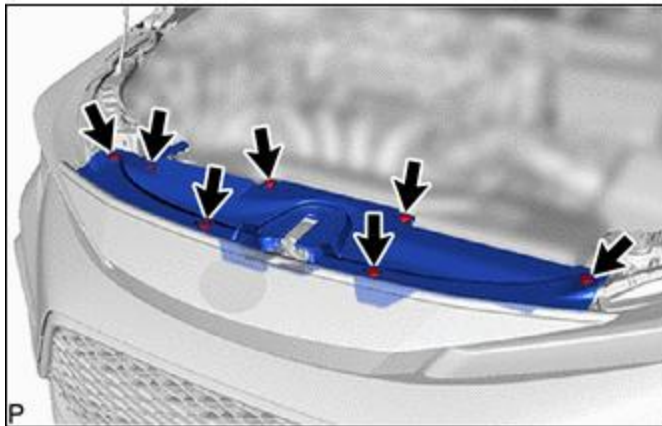
## V. BACKGROUND

The headlamps on the subject vehicles may be missing a marking that is used to aim the headlamps (if needed) during service and do not comply with a federal safety standard. If a headlamp is not aimed correctly during service, it could increase the glare for an oncoming vehicle driver or reduce the visibility for driver of the subject vehicle, increasing the risk of a crash.

## VI. COMPONENTS

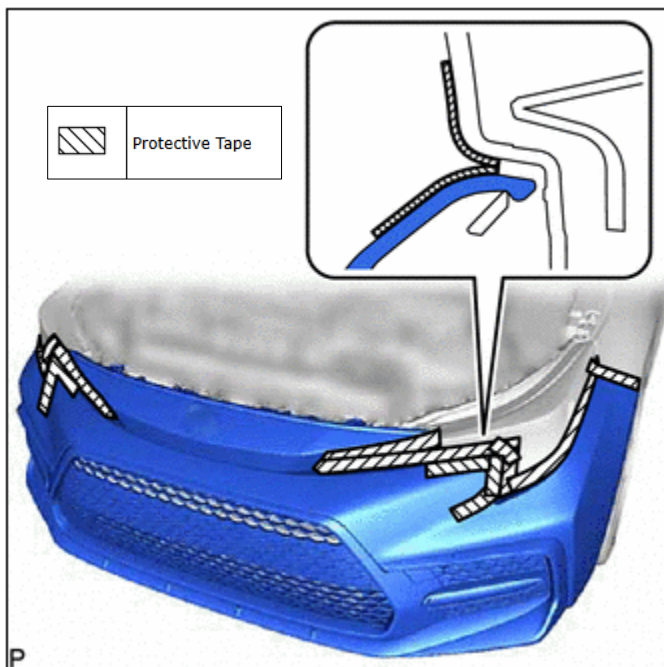


## VII. REMOVE FRONT BUMPER ASSEMBLY



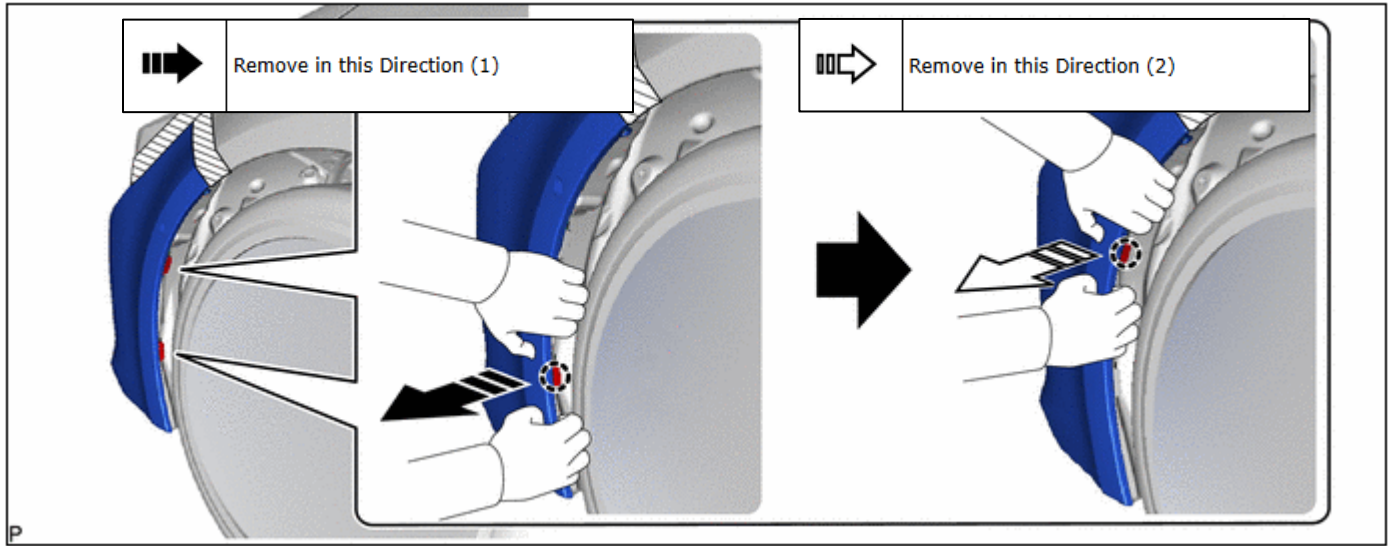
### 1. REMOVE RADIATOR SUPPORT OPENING COVER

- a) Disengage the 7 clips to remove the radiator support opening cover.



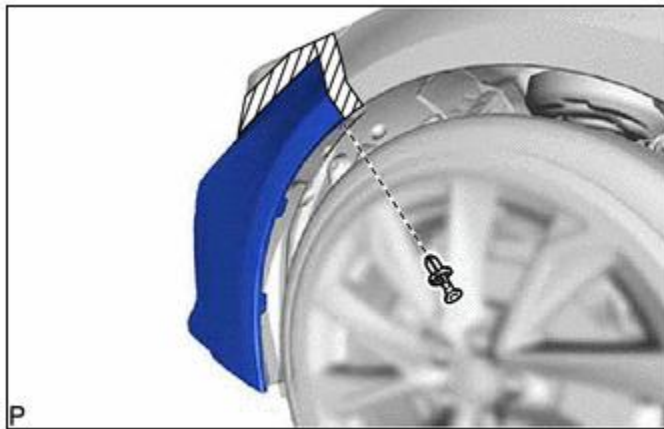
### 2. REMOVE FRONT BUMPER ASSEMBLY

- a) Apply protective tape around the front bumper assembly as shown in the illustration.



b) As shown in the illustration above, pull the front bumper assembly horizontally to release each claw and disengage the front fender liner retainer.

*HINT: Use the same procedure for the RH side and LH side.*

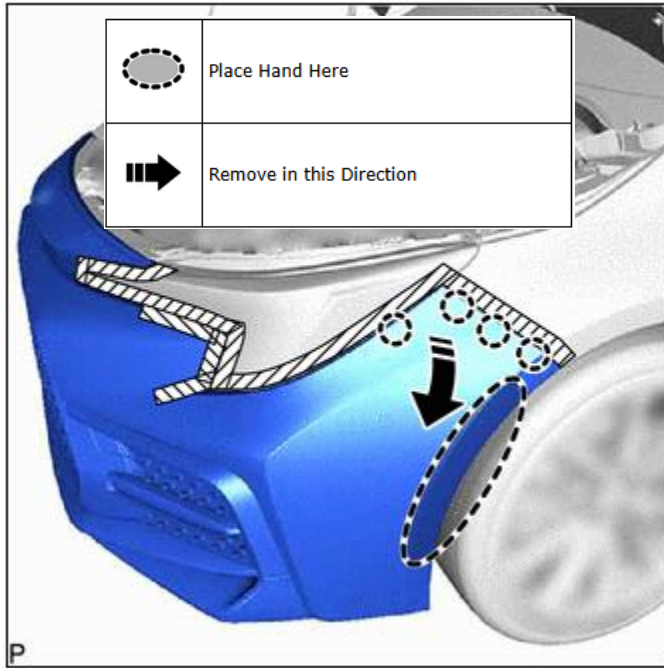


c) Remove the clip

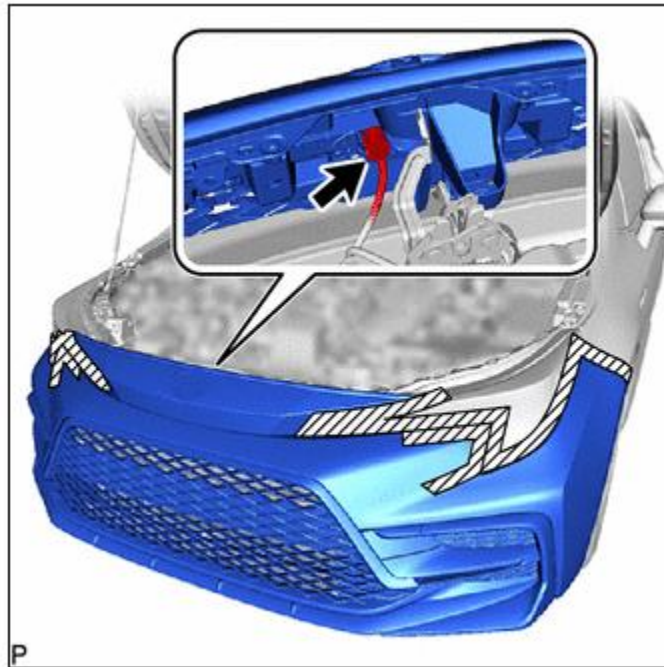
*HINT: Use the same procedure for the RH side and LH side.*



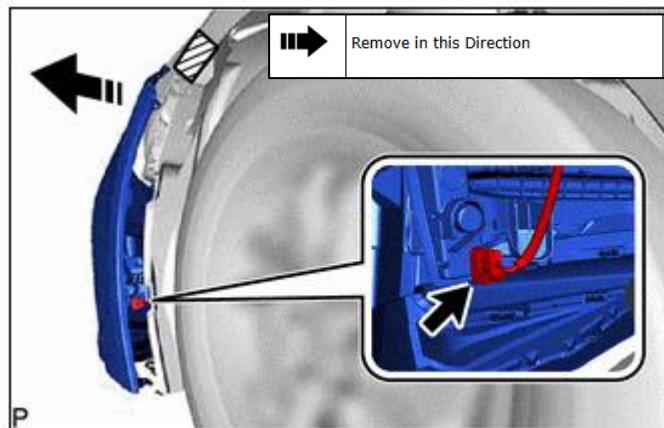
d) Remove the 10 screws.



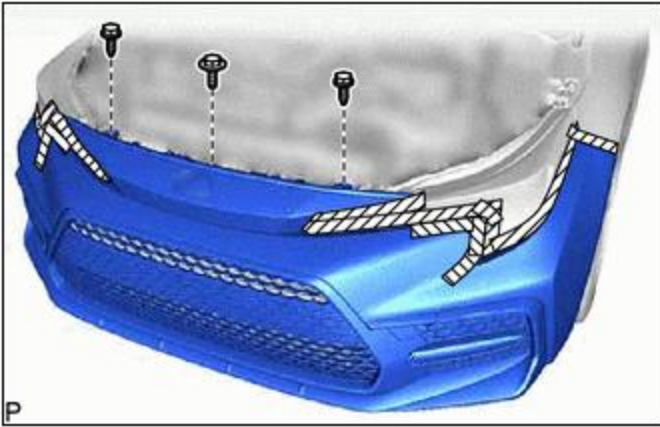
e) Disengage the 4 claws as shown in the illustration.  
 HINT: Use the same procedure for the RH side and LH side.



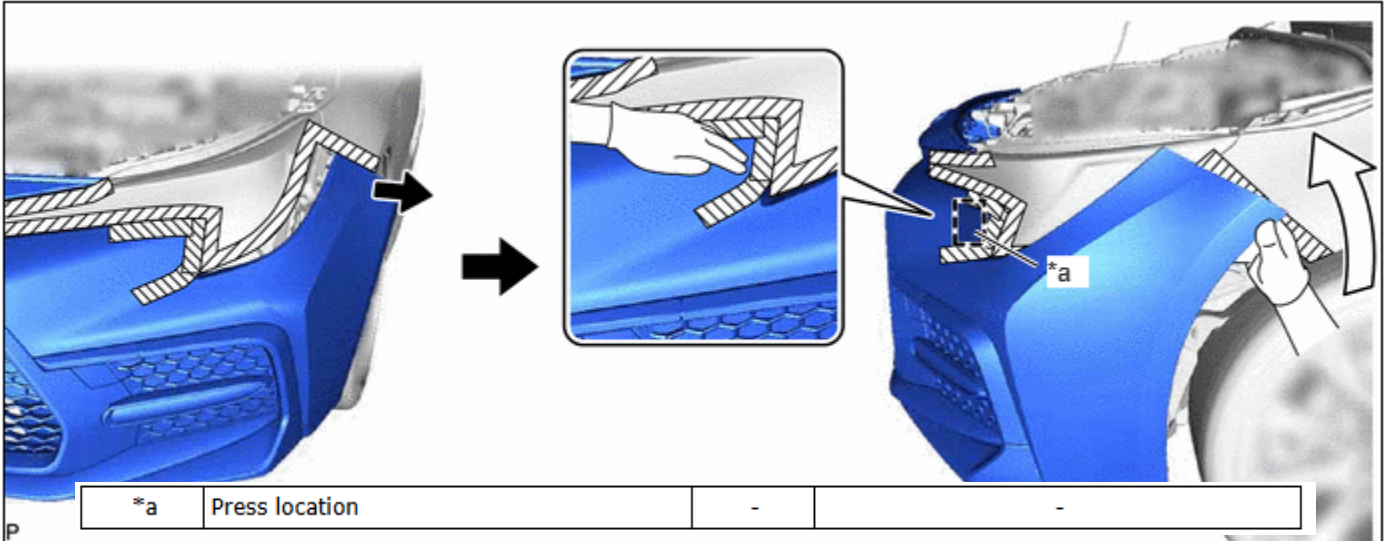
f) w/ Pre-collision System:  
 i. Disconnect the connector.



g) W/ Illumination:  
 i. Pull back the side of the front bumper assembly as shown in the illustration and disconnect the connector.



h) Remove the bolt and 2 screws.

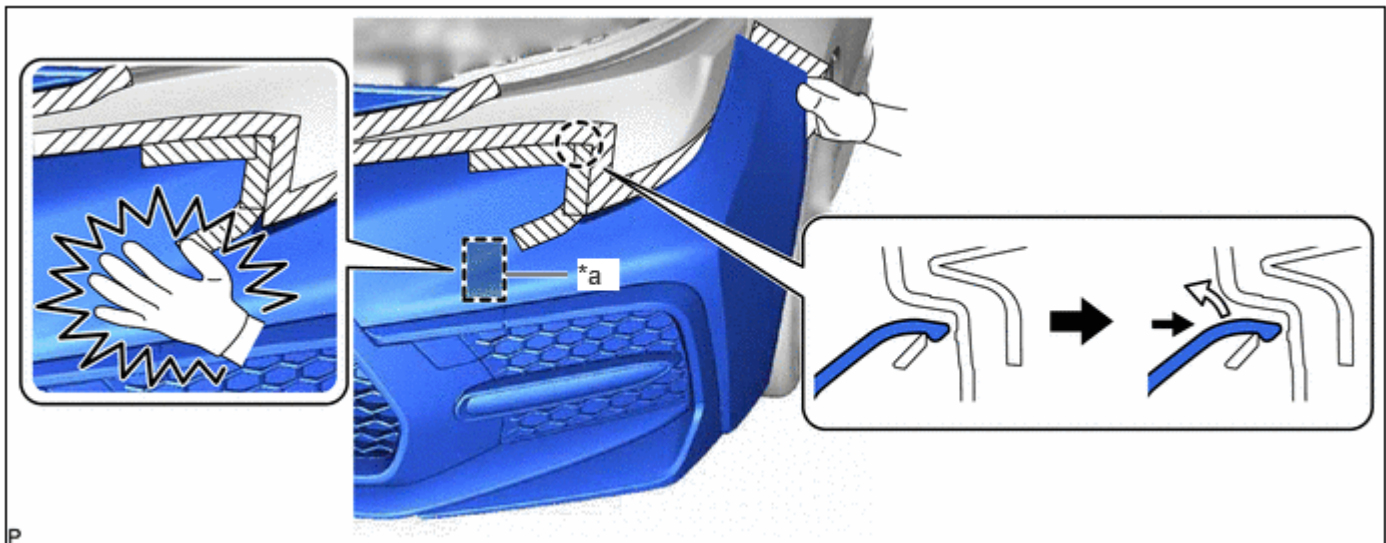


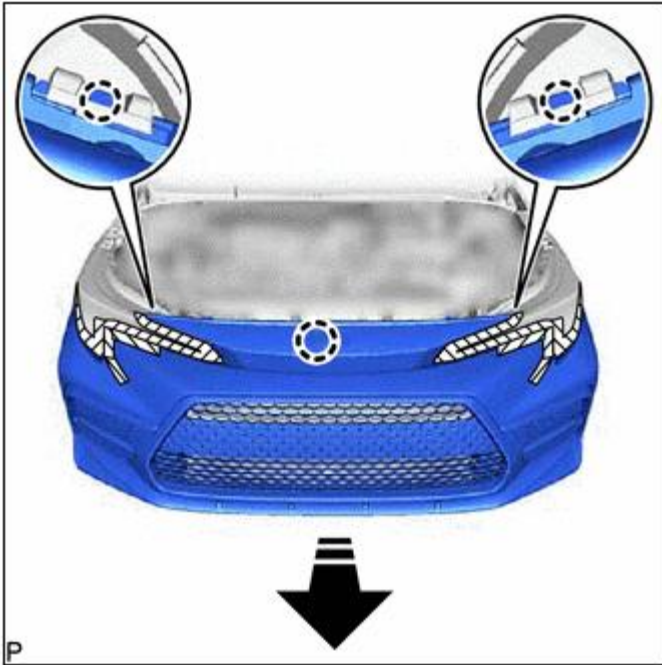
i) Disengage the claw of the front bumper assembly as shown in the illustration above.

**NOTICE:** If the front bumper assembly is moved in the direction forward of the vehicle, the claw may be damaged.

- i. Pull the end portion of the front bumper assembly away from the vehicle.
- ii. While pressing the location shown in the illustration, move the end portion of the front bumper assembly in the direction indicated by the arrow.
- iii. Using your hand, strike the location shown in the illustration below to disengage the claw.

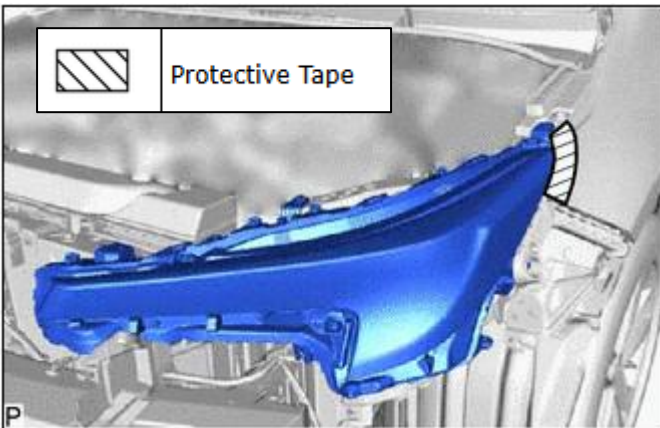
**HINT:** Use the same procedure for the RH side and LH side.





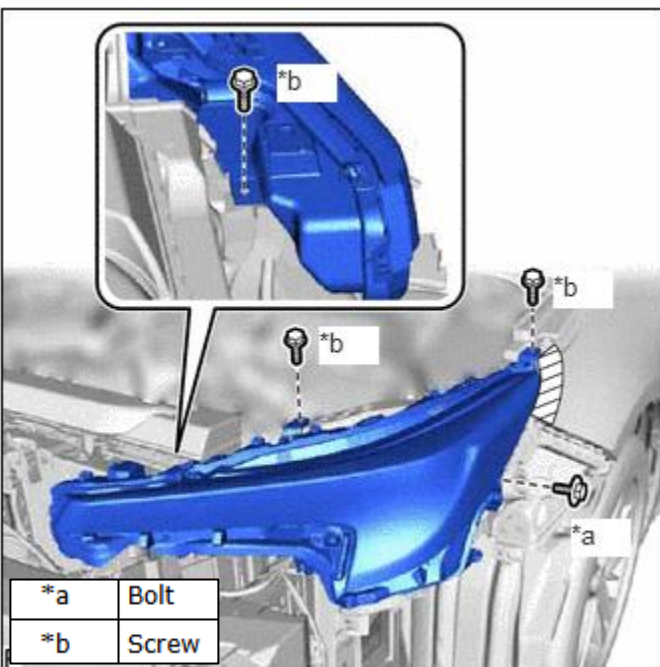
j) Disengage the 3 claws as shown in the illustration to remove the front bumper assembly.

## VIII. REMOVE HEADLIGHTS

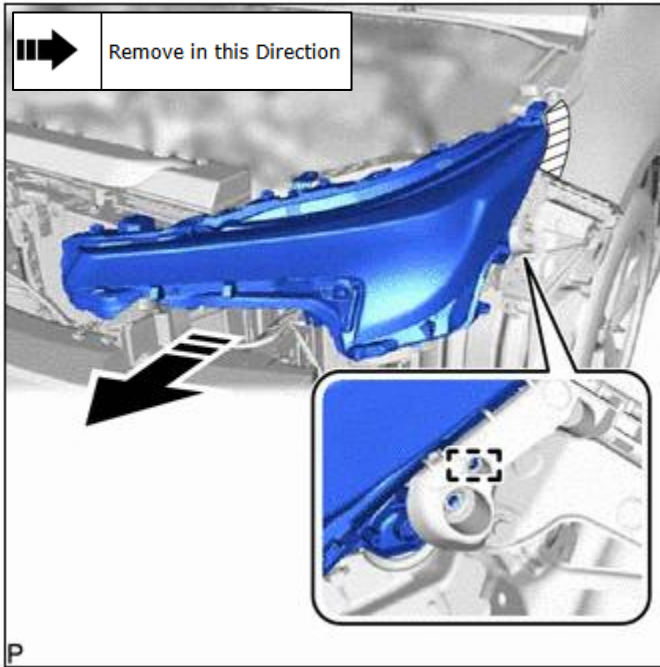


### 1. REMOVE HEADLIGHT ASSEMBLY

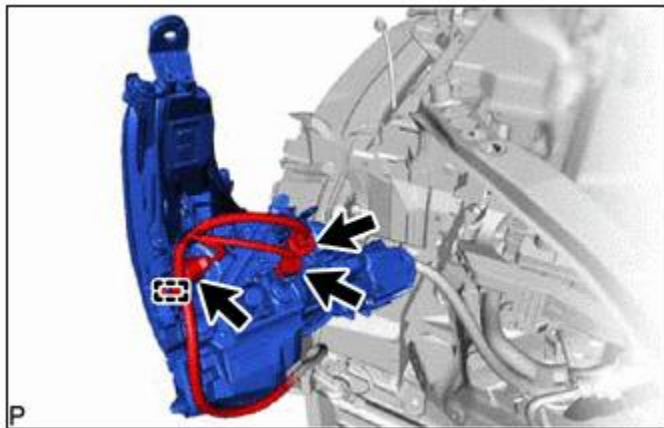
a) Apply protective tape around the headlight assembly as shown in the illustration.



b) Remove the bolt and 3 screws.



c) Disengage the guide to separate the headlight assembly as shown in the illustration.



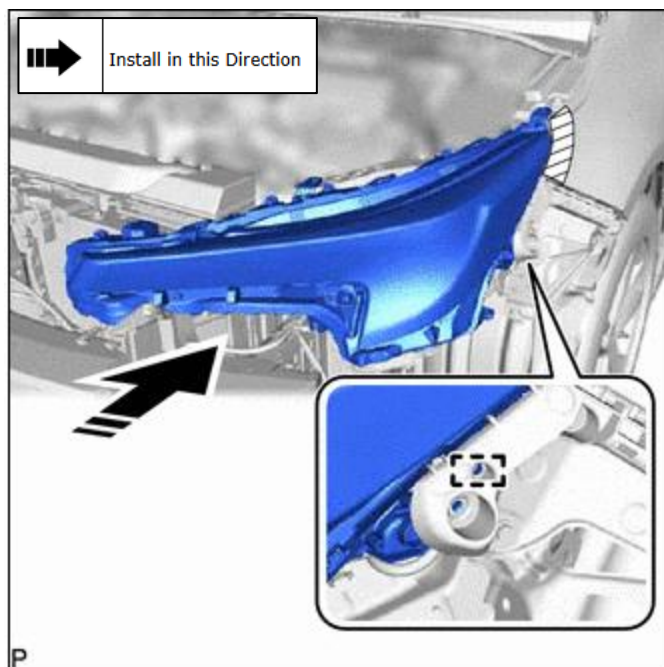
d) Disengage each clamp.

e) Disconnect each connector to remove the headlight assembly.

**HINT:** Use the same procedure for the RH side and LH side.

f) Drill a hole in each removed headlight to damage the assembly prior to discarding.

## IX. INSTALL NEW HEADLIGHTS

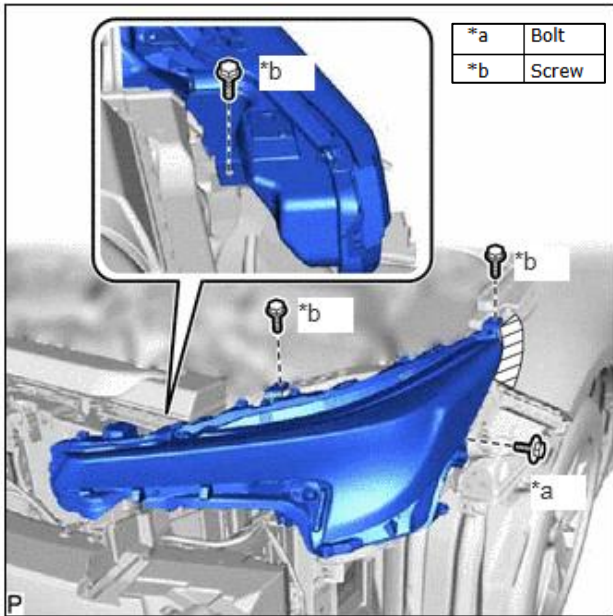


### 1. INSTALL NEW HEADLIGHT ASSEMBLY

a) Connect each connector.

b) Engage each clamp.

c) Engage the guide to temporarily install the headlight assembly as shown in the illustration.

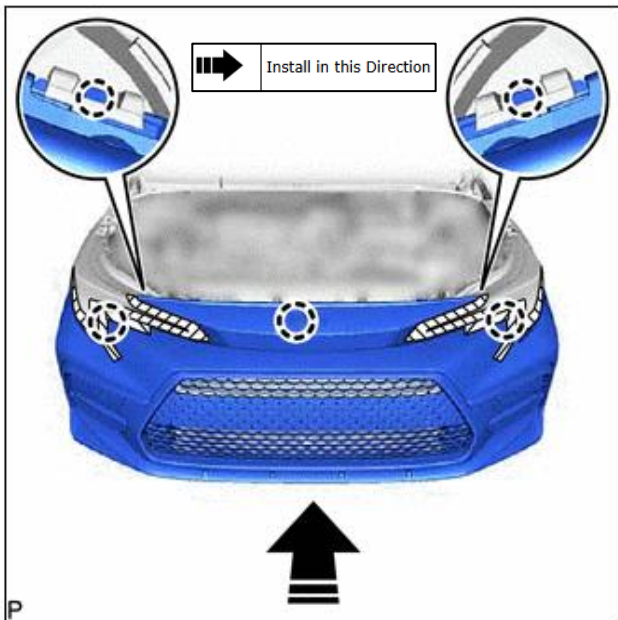


d) Install the headlight assembly with the bolt and 3 screws

**Torque: Bolt: 8.0 N·m {82 kgf·cm, 71 in·lbf}**

e) Remove the protective tape.

## X. REINSTALL FRONT BUMPER ASSEMBLY

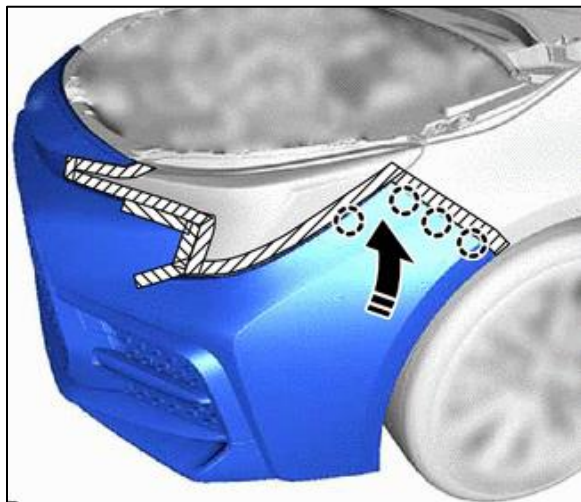


### 1. INSTALL FRONT BUMPER ASSEMBLY

- a) Move the front bumper assembly into position and engage the 5 claws as shown in the illustration.
- b) Install the bolt and 2 screws.
- c) W/ Illumination:
  - i. Pull back the side of the front bumper assembly and connect the connector.

**NOTICE:** Do not apply excessive force when pulling back the front bumper assembly.

**HINT:** Use the same procedure for the RH side and LH side.

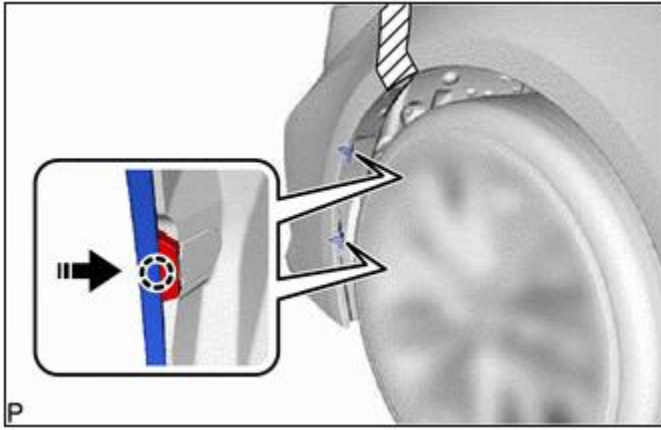


- c) w/ Pre-collision System:
  - a) Connect the connector.

d) Engage the 4 claws as shown in the illustration.

**HINT:** Use the same procedure for the RH side and LH side.

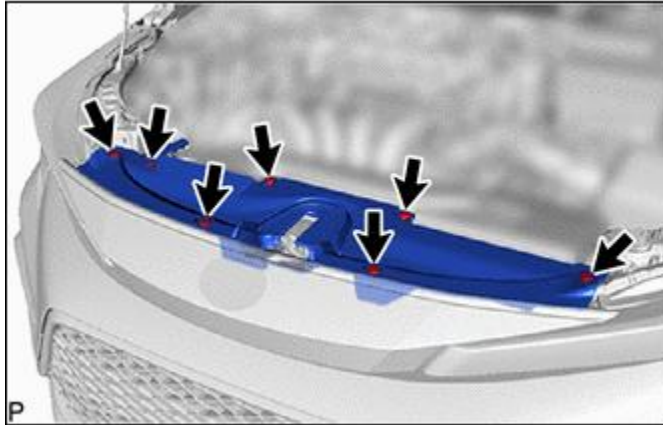
e) Install the 10 screws.



f) Engage the 2 claws as shown in the illustration.

**HINT:** Use the same procedure for the RH side and LH side.

g) Install the front bumper assembly with the 2 clips



## 2. INSTALL RADITAOR SUPPORT OPENING COVER

a) Install the radiator support opening cover with the 7 clips.

## XI. ADJUST HEADLIGHTS

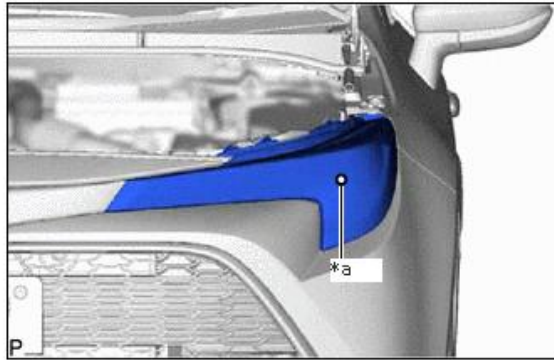
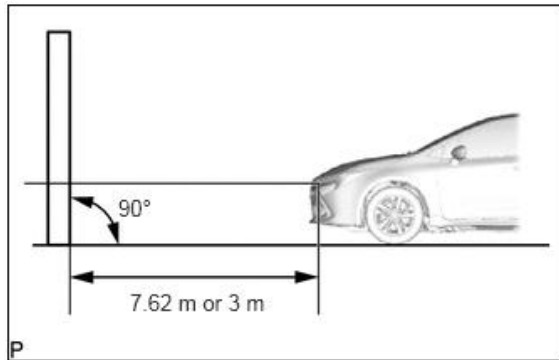
### 1. PREPARE VEHICLE FOR HEADLIGHT AIM ADJUSTMENT

- a. Prepare the vehicle
  - Ensure that there is no damage or deformation to the vehicle body around the headlights.
  - Inflate the tires to the appropriate pressure.
  - Unload the trunk and vehicle, ensuring that the spare tire, tools and jack are in their original positions.
  - Sit a person of average weight (68 kg, 150 lb) in the driver's seat.

### 2. PREPARE FOR HEADLIGHT AIMING (Using a headlight aim test machine)

- a. Adjust the headlight aim in accordance with the headlight aim test machine instructions.

### 3. PREPARE FOR HEADLIGHT AIMING (Using a screen)



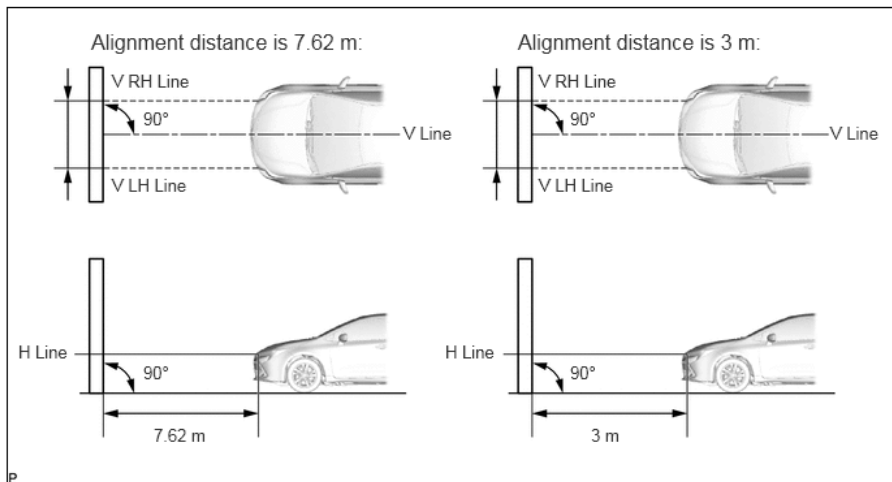
Prepare the vehicle:

- Place the vehicle in a location that is dark enough to clearly observe the cutoff line. The cutoff line is a distinct line, below which light from the headlights can be observed and above which it cannot.
- Place the vehicle at a 90° angle to the wall.
- Create a 7.62 m (25 ft.) distance between the vehicle (center marks of the headlights) and the wall.
- Make sure that the vehicle is on a level surface.
- Position the front wheels straight ahead.
- Bounce the vehicle up and down to settle the suspension.

#### NOTICE:

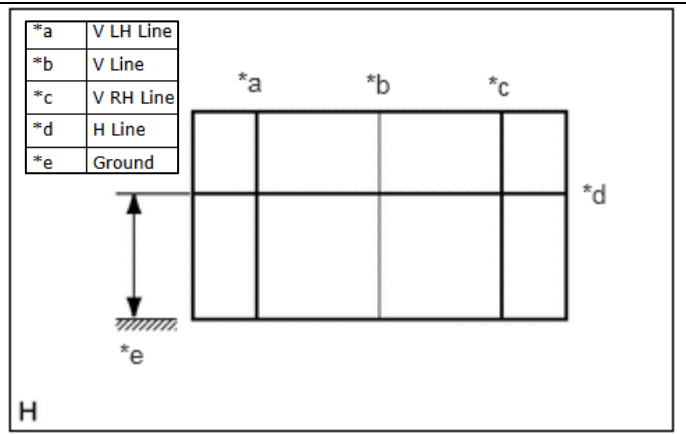
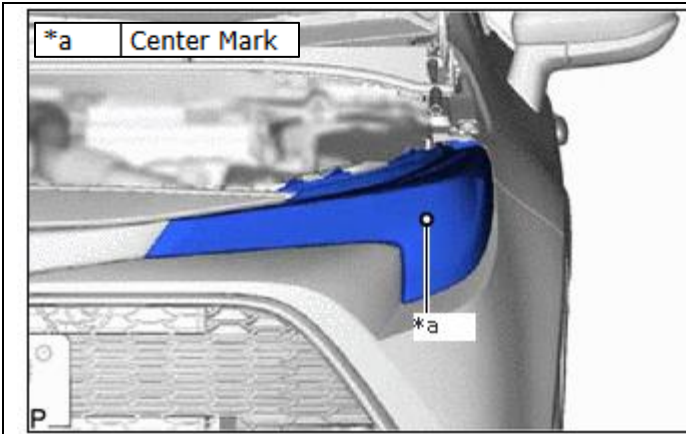
A distance of 7.62 m (25 ft.) between the vehicle (center marks of the headlights) and the wall is necessary for proper aim adjustment. If sufficient space is not available, secure a distance of exactly 3 m (9.84 ft.) to allow for checking and adjustment of headlight aim. (The size of the target zone will change with the distance, so follow the instructions in the illustration.)

- Prepare a piece of thick white paper (approximately 2 m (6.56 ft.) (height) x 4 m (13.1 ft.) (width)) to use as a screen.
- Draw a vertical line down the center of the screen (V line).
- Set the screen as shown in the illustration.



#### HINT:

- Stand the screen perpendicular to the ground.
- Align the V line on the screen with the center of the vehicle.



e. Draw base lines (H, V LH, and V RH lines) on the screen as shown in the illustration.

**HINT:**

- The base lines differ for "low beam inspection" and "high beam inspection".
  - Mark the headlight center marks on the screen.
- i. H Line (Headlight height): Draw a horizontal line across the screen so that it passes through the center marks. The H line should be at the same height as the center marks of the headlights.
  - ii. V LH Line, V RH Line (Center mark position of left-hand (LH) and right-hand (RH) headlights): Draw 2 vertical lines so that they intersect the H line at each center mark (aligned with the center marks of the headlights).

**4. INSPECT HEADLIGHT AIMING**

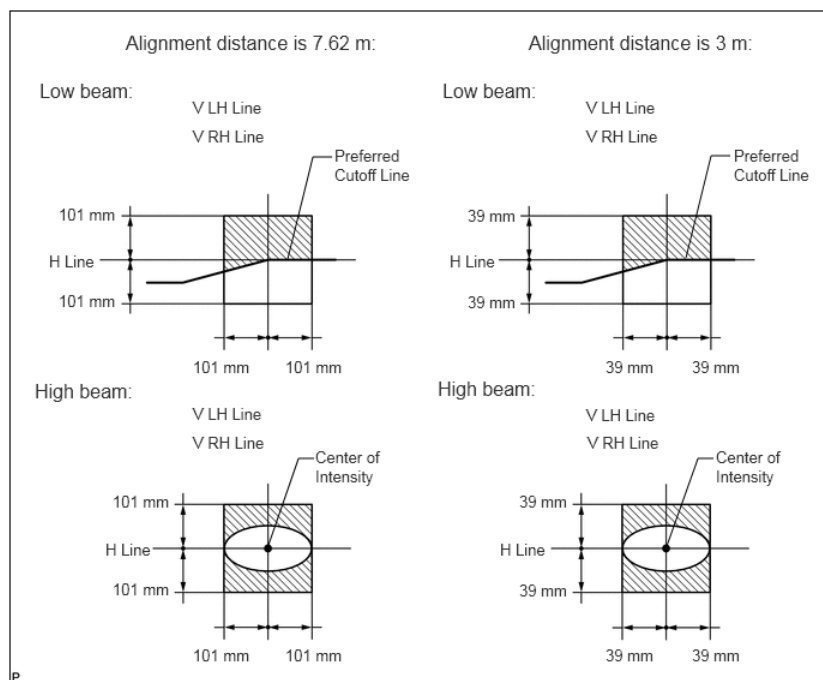
a) Cover the headlight on the opposite side to prevent light from the headlight that is not being inspected from affecting the headlight aiming inspection

**NOTICE:** Do not keep the headlight covered for more than 3 minutes. The headlight lens is made of synthetic resin, which may melt or be damaged due to excessive heat.

**HINT:** When checking the aim of the high beam, cover the low beam.

b) Start the Engine.

c) Turn on the headlights and check the aiming of each beam.

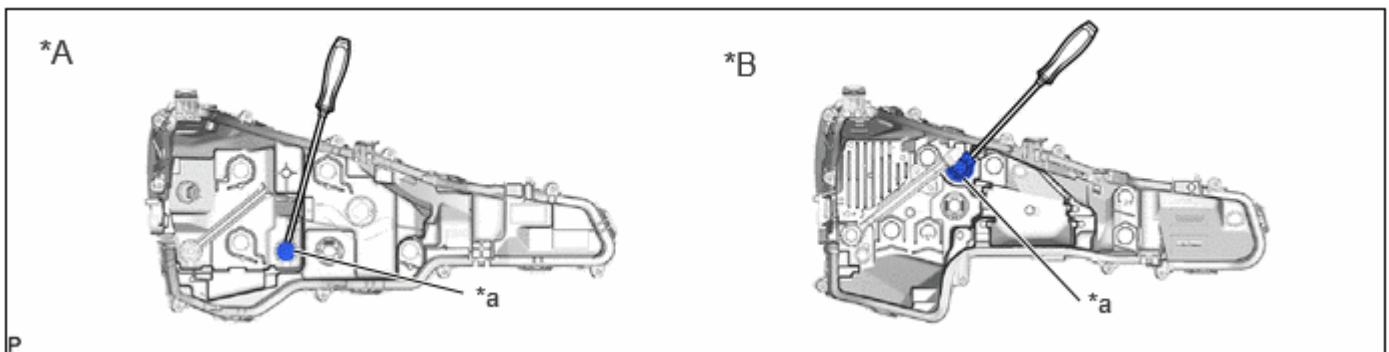


**HINT:**

- Since the low beam headlight and the high beam headlight are a unit, if the aim on the low beam is correct, the high beam should also be correct. However, check both beams just to make sure.
- If the alignment distance is 7.62 m (25 ft.): The low beam cutoff line should be between 101 mm (3.97 in.) above or below the H line as well as 101 mm (3.97 in.) left or right of the V LH or RH line (SAE J599).
- If the alignment distance is 3 m (9.84 ft.): The low beam cutoff line should be between 39 mm (1.56 in.) above or below the H line as well as 39 mm (1.56 in.) left or right of the V LH or RH line (SAE J599).
- If the alignment distance is 7.62 m (25 ft.): The high beam center of intensity should be within 101 mm (3.97 in.) above or below the H line as well as 101 mm (3.97 in.) left and right of the V LH or RH line (SAE J599).
- If the alignment distance is 3 m (9.84 ft.): The high beam center of intensity should be within 39 mm (1.56 in.) above or below the H line as well as 39 mm (1.56 in.) left or right of the V LH or RH line (SAE J599).

**5. ADJUST HEADLIGHT AIMING**

a) Adjust the aim vertically: Adjust the aim of each headlight to the specified range by turning each aiming screw with a screwdriver.



*A	for Bulb Type Turn Signal Light	*B	for LED Type Turn Signal Light
*a	Aiming Screw	-	-

**NOTICE:** The final turn of the aiming screw should be made in the clockwise direction. If the screw is tightened excessively, loosen it and then retighten it, so that the final turn of the screw is in the clockwise direction.

**HINT:**

- Since the low beam headlight and the high beam headlight are a unit, if the aim on the low beam is correct, the high beam should also be correct. However, check both beams just to make sure.
- If it is not possible to correctly adjust headlight aim, check the headlight unit and headlight unit lens installation.
- Confirm the direction of rotation of the aiming screw by observing it while it is being adjusted. Due to the position of the screwdriver, the direction of rotation of the adjusting screw can be different than the direction of rotation of the screwdriver being used to adjust it.

**◀ VERIFY REPAIR QUALITY ▶**

- Confirm all lighting on the vehicle is operational.
- Confirm there are no new DTCs introduced during the repair.

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

## XII. 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 DECODER

