


# HID Headlamp Housing Paint Bubble / Poor Appearance

Service  
Category Vehicle Exterior

Section Lighting (ext)

Market USA

Lexus Supports  
ASE Certification 

## Applicability

YEAR(S)	MODEL(S)	ADDITIONAL INFORMATION
2011 – 2013	IS F, IS250, IS250C, IS350, IS350C	

### REVISION NOTICE

December 3, 2013 Rev2:

- The Production Change Information section has been updated.

September 24, 2013 Rev1:

- Applicability has been updated to include additional 2013 model year Lexus vehicles.
- The Production Change Information, Warranty Information, Parts Information, and Repair Procedure sections have been updated.

Any previous printed versions of this bulletin should be discarded.

## Introduction

Some 2011 – 2013 model year IS 250/350/250C/350C and IS F vehicles equipped with HID (High Intensity Discharge) headlights may exhibit a paint bubbling/wrinkling condition on top of the LED strip within one or both of the headlight housings. Newly designed headlight units have been developed to address this condition. Follow the procedure in this bulletin to install the updated headlight units.

## Production Change Information

This bulletin applies to vehicles produced **BEFORE** the Production Change Effective VINs shown below.

MODEL	PLANT	ENGINE	DRIVETRAIN	PRODUCTION CHANGE EFFECTIVE VIN
IS 250	Tahara	4GR-FSE	2WD	JTHBF5C2#D5193665
			AWD	JTHCF5C2#D5064017
	TMK		2WD	JTHBF5C2#D2103197
			AWD	JTHCF5C2#D2036074

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### Production Change Information (Continued)

MODEL	PLANT	ENGINE	DRIVETRAIN	PRODUCTION CHANGE EFFECTIVE VIN
IS 350	Tahara	2GR-FSE	2WD	JTHBE5C2#D5032058
			AWD	JTHCE5C2#D5003209
IS 250C	TMK	4GR-FSE	2WD	JTHFF2C2#D2528759
IS 350C		2GR-FSE		JTHFE2C2#D2509743
IS F	Tahara	2UR-GSE		JTHBP5C2#D5011225

### Warranty Information

OP CODE	DESCRIPTION	TIME	OFF	T1	T2
BD9097	R & R Headlight Units, Transfer Components, & Aim Headlights	2.6	81145-53540 81145-53541 81145-53542 81145-53543 81185-53540 81185-53541 81185-53542 81185-53543 81145-53670 81145-53671 81145-53672 81145-53673 81145-53543 81185-53670 81185-53671 81185-53672 81185-53673	99	15

#### APPLICABLE WARRANTY

- This repair is covered under the Lexus Comprehensive Warranty. This warranty is in effect for 48 months or 50,000 miles, whichever occurs first, from the vehicle's in-service date.
- Warranty application is limited to occurrence of the specified condition described in this bulletin.

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### Parts Information

**NOTE**

- If the headlight assembly does not have visible paint bubbles and only one headlight needs to be replaced (for collision damage repairs, etc.), use the part number for the headlight that the vehicle is currently equipped with. Updated parts are not compatible with prior part numbers.
- If either headlight assembly has visible paint bubbles, replace the headlights in pairs with the NEW part numbers.

MODEL	PART NUMBER		PART NAME	QTY
	PREVIOUS	NEW		
IS 250/350	81145-53540	81145-53544	Unit, Headlamp, RH	1
	81145-53541			
	81145-53542			
	81145-53543			
	81185-53540	81185-53544	Unit, Headlamp, LH	1
	81185-53541			
	81185-53542			
	81185-53543			
IS 250C/350C	81145-53670	81145-53674	Unit, Headlamp, RH	1
	81145-53671			
	81145-53672			
	81145-53673			
	81145-53543	81145-53544	Unit, Headlamp, LH	1
	81185-53670	81185-53674		
	81185-53671			
	81185-53672			
	81185-53673			
	81185-53543	81185-53544		
IS F	81145-53670	81145-53674	Unit, Headlamp, RH	1
	81145-53671			
	81145-53672			
	81145-53673			
	81185-53670	81185-53674	Unit, Headlamp, LH	1
	81185-53671			
	81185-53672			
	81185-53673			



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### Required Tools & Equipment

SPECIAL SERVICE TOOLS (SST)	PART NUMBER	QTY
Plastic Pry Tool Kit*	<a href="#">00002-06020-02</a>	1

\* Essential SST.

#### NOTE

Additional SSTs may be ordered by calling 1-800-933-8335.

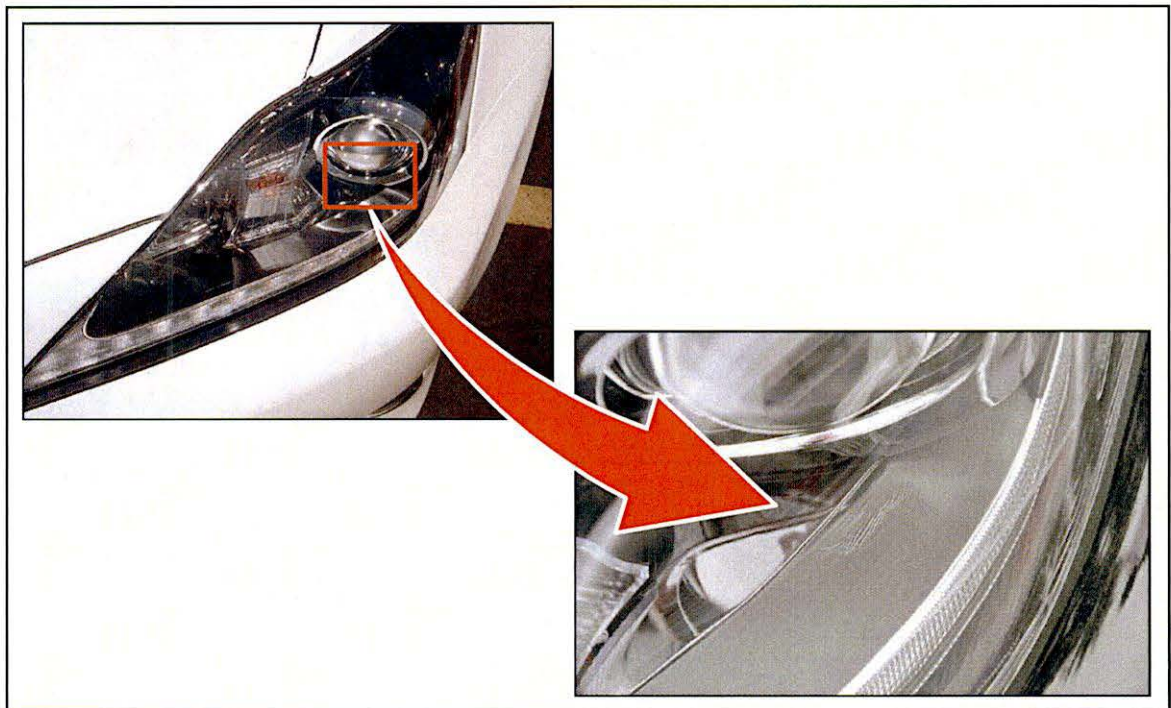
REQUIRED MATERIAL	QUANTITY
Protective Tape	As Needed

### Repair Procedure

1. Confirm vehicle has the headlight housing paint bubble condition (see Figure 1 for an example).

If a poor appearance is found, continue to step 2. If not, this bulletin does **NOT** apply.

**Figure 1.**



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### Repair Procedure (Continued)

#### 2. Replace both headlight units.

##### A. Remove both headlights.

Refer to the Technical Information System (TIS), applicable model and model year Repair Manual:

*Vehicle Exterior – Lighting (ext) – “Lighting: Headlight Assembly: Removal”*

- [2011](#) / [2012](#) / [2013](#) IS 250/350
- [2011](#) / [2012](#) / [2013](#) IS 250C/350C
- [2011](#) / [2012](#) / [2013](#) IS F

##### B. Disassemble the headlight assemblies.

Refer to TIS, applicable model and model year Repair Manual:

*Vehicle Exterior – Lighting (ext) – “Lighting (ext): Headlight Assembly: Disassembly”*

- [2011](#) / [2012](#) / [2013](#) IS 250/350
- [2011](#) / [2012](#) / [2013](#) IS 250C/350C
- [2011](#) / [2012](#) / [2013](#) IS F

##### C. Reassemble the headlight assemblies using the new headlight units.

Refer to TIS, applicable model and model year Repair Manual:

*Vehicle Exterior – Lighting (ext) – “Lighting: Headlight Assembly: Reassembly”*

- [2011](#) / [2012](#) / [2013](#) IS 250/350
- [2011](#) / [2012](#) / [2013](#) IS 250C/350C
- [2011](#) / [2012](#) / [2013](#) IS F

##### D. Install the completed headlight assemblies with the new headlight units.

Refer to TIS, applicable model and model year Repair Manual:

*Vehicle Exterior – Lighting (ext) – “Lighting: Headlight Assembly: Installation”*

- [2011](#) / [2012](#) / [2013](#) IS 250/350
- [2011](#) / [2012](#) / [2013](#) IS 250C/350C
- [2011](#) / [2012](#) / [2013](#) IS F

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### Repair Procedure (Continued)

E. Adjust the headlight assemblies.

Refer to TIS, applicable model and model year Repair Manual:

*Vehicle Exterior – Lighting (ext) – “Lighting (ext): Headlight Assembly: Adjustment”*

- [2011](#) / [2012](#) / [2013](#) IS 250/350
- [2011](#) / [2012](#) / [2013](#) IS 250C/350C
- [2011](#) / [2012](#) / [2013](#) IS F

3. Confirm headlight operation.