

Horn Radiator Support Bracket

Service Category Vehicle Exterior

Section Horn

Market USA

Toyota Supports
 ASE Certification 

Applicability

YEAR(S)	MODEL(S)	ADDITIONAL INFORMATION
2005 – 2014	Tacoma	

Introduction

Some 2005 – 2014 model year Tacoma vehicles used in severe off-road service conditions may exhibit a cracked Horn Mounting Bracket. Use the procedure in this bulletin to address this condition.

Warranty Information

OP CODE	DESCRIPTION	TIME	OFF	T1	T2
BD1407	Support S/A Radiator Upper (One Side)	0.7	53205-04010	62	16
Combo A	Opposite Side	0.3	53205-04011		

APPLICABLE WARRANTY

- This repair is covered under the Toyota Basic Warranty. This warranty is in effect for 36 months or 36,000 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.

Parts Information

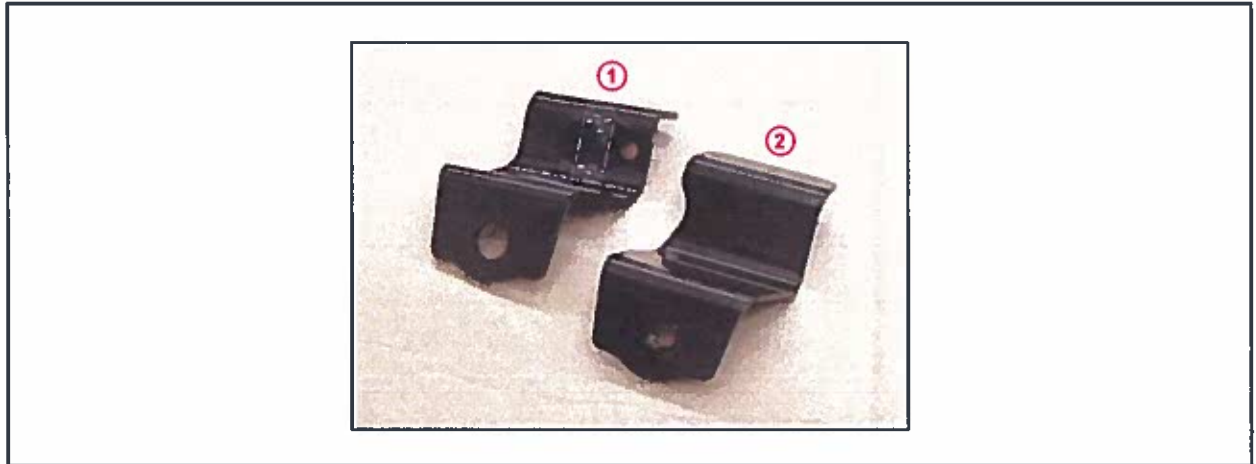
PART NUMBER	PART NAME	QTY*
53236-04010	Bracket, Horn Mounting, No. 2	1
53237-04010	Bracket, Horn Mounting, No. 3	1
90269-05025	Rivet	5

* Quantity shown for all parts is for one side only. If both horn brackets need replacing, double the quantity when ordering.

Horn Radiator Support Bracket

New Parts Identification

Figure 1. Replacement Horn Mounting Brackets



1 Horn Mounting Bracket No. 2

2 Horn Mounting Bracket No. 3

Required Tools & Equipment

REQUIRED TOOLS & MATERIAL	QUANTITY
Vise Grip	1
Drill	1
5 mm (13/64 in.) Drill Bit	1
5/16 in. Spot Weld Cutter or Drill Bit	1
Hammer	1
Center Punch	1
Rivet Gun	1
Silver Permanent Marker	1
Masking Tape	As Needed
Epoxy Panel Adhesive (3M™ Scotch-Weld™ Epoxy Adhesive DP125, or 3M™ Panel Bonding Adhesive 08115, or LORD Fusor® 380NS/383NS Adhesive, or Equivalent)	As Needed
Automotive Grade Paint Primer (Brush-on Type)	As Needed

Horn Radiator Support Bracket

Repair Procedure

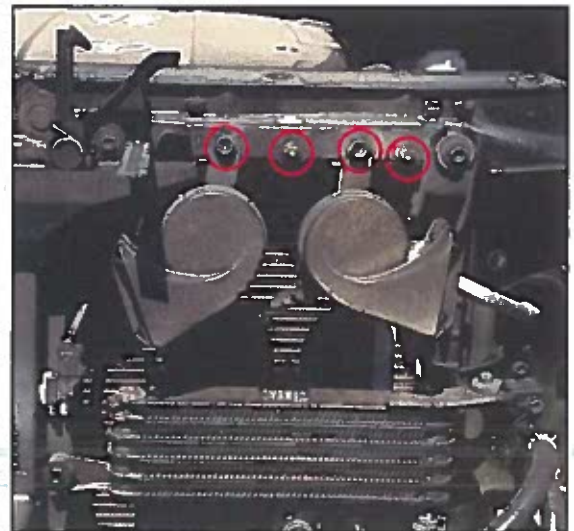
Removal of Original Horn Mounting Brackets

1. Remove radiator grille assembly per Repair Manual instructions.

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

- [2005](#) Tacoma:
Vehicle Exterior – Exterior Panels/Trim – “Front Bumper Cover: Replacement”
 - [2006](#) / [2007](#) / [2008](#) / [2009](#) / [2010](#) / [2011](#) / [2012](#) / [2013](#) / [2014](#) Tacoma:
Vehicle Exterior – Exterior Panels/Trim – “Exterior: Front Bumper: Removal”
 - [2005](#) Tacoma:
Vehicle Exterior – Door/Hatch – “Hood: Adjustment”
 - [2006](#) / [2007](#) / [2008](#) / [2009](#) / [2010](#) / [2011](#) / [2012](#) / [2013](#) / [2014](#) Tacoma:
Vehicle Exterior – Door/Hatch – “Engine Hood/Door: Hood: Disassembly”
2. Remove upper radiator support plastic cover (if applicable).
 3. Remove hood lock lever, horn, and horn cable for clearance.

Figure 2.



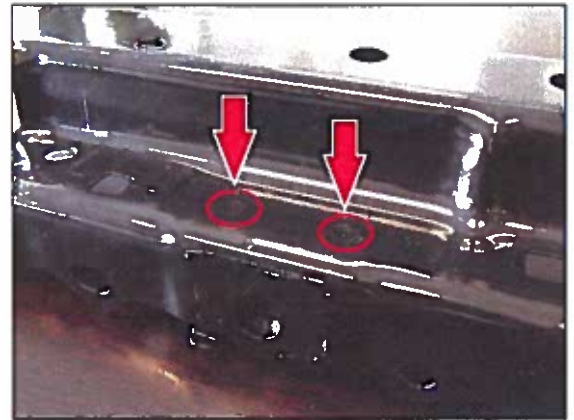
Horn Radiator Support Bracket

Repair Procedure

Removal of Original Horn Mounting Brackets (Continued)

4. Identify 4 spot welds (2 per bracket) retaining the horn mount weld nut brackets to the upper radiator support (Figure 3). If horn mount weld nut brackets are missing, proceed to Preparation for Horn Mounting Bracket Installation.

Figure 3.



5. Center punch spot welds (Figure 4), then drill using 5/16 inch spot weld cutter or equivalent drill bit (Figure 5).

Figure 4.

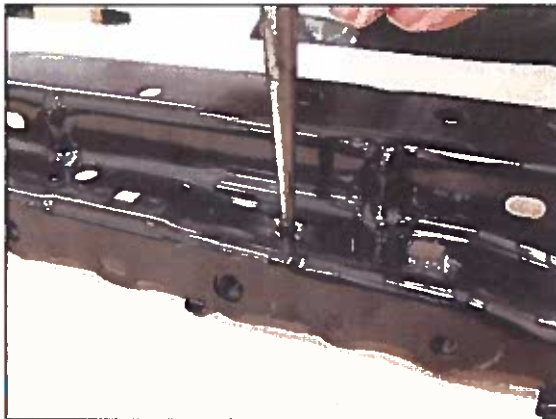
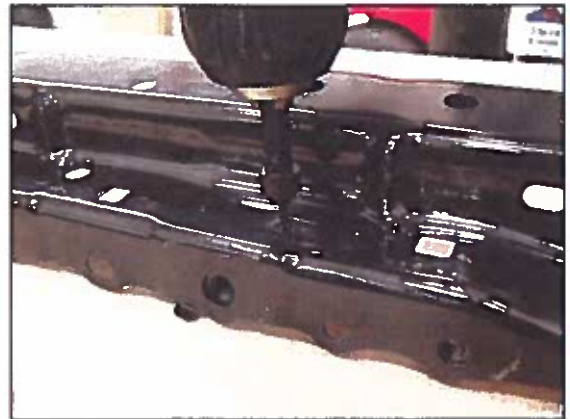


Figure 5.



Horn Radiator Support Bracket

Repair Procedure

Removal of Original Horn Mounting Brackets (Continued)

6. Remove original horn mount weld nut bracket from underside of upper radiator support and discard.



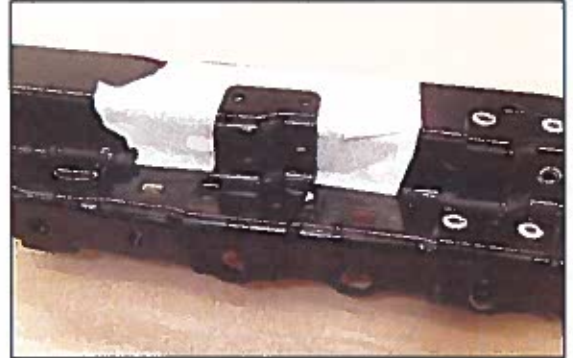
Horn Radiator Support Bracket

Repair Procedure (Continued)

Preparation for Horn Mounting Bracket Installation

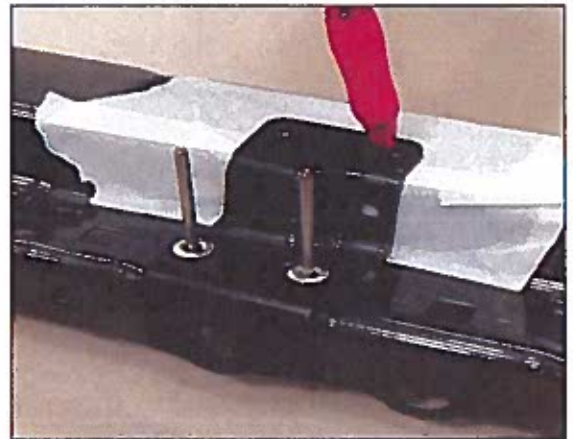
1. Remove any burrs or rough edges on the upper radiator support.
2. Apply masking tape to the upper radiator support as shown. Temporarily install and center Horn Mounting Bracket No. 2 onto the upper radiator support.

Figure 7.



3. Using the supplied rivets, align the bracket with the removed spot welds. Using the bracket as a template, mark the 3 hole locations onto the upper radiator support with a pen as shown.

Figure 8.

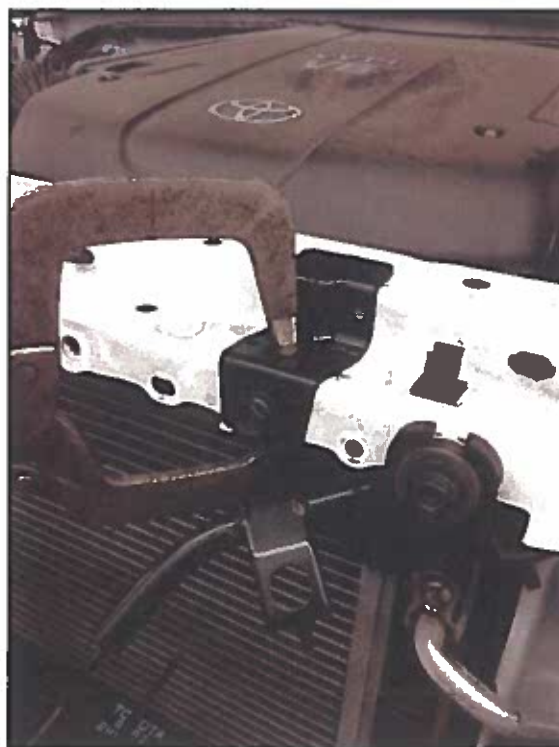


Horn Radiator Support Bracket

Repair Procedure

Preparation for Horn Mounting Bracket Installation (Continued)

4. Using a vise grip, clamp Horn Mounting Brackets No. 2 and No. 3 together. **Figure 9.**

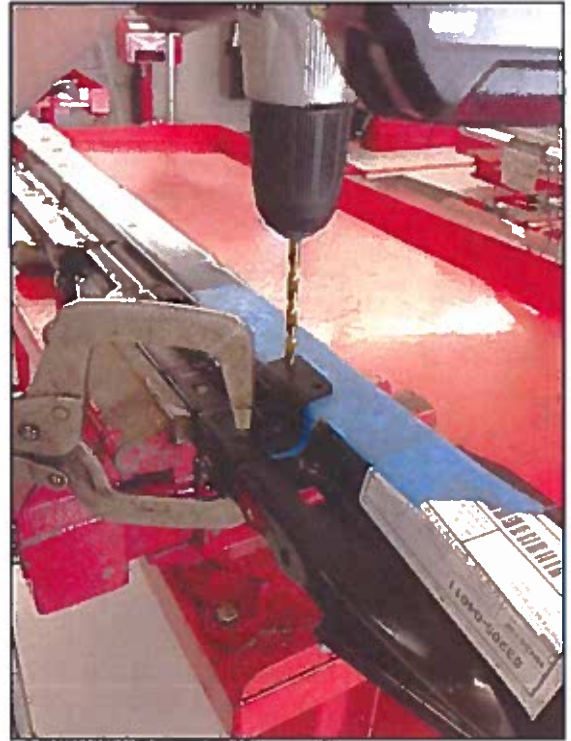


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Repair Procedure

Preparation for Horn Mounting Bracket Installation (Continued)

5. Using a 5 mm drill bit, drill 5 hole locations through Horn Mounting Bracket No. 3. **Figure 10.**



6. To prevent corrosion, use an automotive grade paint primer to coat the edges of the holes that were drilled. A brush-on type is recommended for a more accurate application.
7. Test fit all 5 rivets through Horn Mounting Bracket No. 2, upper radiator support, and Horn Mounting Bracket No. 3. **Figure 11.**



Horn Radiator Support Bracket

Repair Procedure (Continued)

Installation of Horn Mounting Brackets

1. Apply adhesive to Horn Mounting Bracket No. 2 and Horn Mounting Bracket No. 3.

- A. Dispense three 2-inch beads of epoxy panel adhesive and mix thoroughly.

Epoxy Panel Adhesive:
3M™ Scotch-Weld™ Epoxy Adhesive DP125
 or
3M™ Panel Bonding Adhesive 08115
 or
LORD Fusor® 380NS/383NS Adhesive,
 or Equivalent

Figure 12.



- B. Apply epoxy panel adhesive to the bottom side of Horn Mounting Bracket No. 2 (Figure 13) and top side of Horn Mounting Bracket No. 3 (Figure 14), and set onto the upper radiator support aligning the bracket holes to the upper radiator support holes.

Figure 13. Adhesive Applied to Bottom of Horn Mounting Bracket No. 2



Figure 14. Adhesive Applied to Top of Horn Mounting Bracket No. 3



2. Install Horn Mounting Bracket No. 2 and Horn Mounting Bracket No. 3.

- A. Align Horn Mounting Brackets No. 2 and No. 3 with the holes in the upper radiator support.
- B. Install 5 rivets into the bracket holes.
- C. Install the horn mounting bolt.
- D. Clamp Horn Mounting Bracket No. 2 and No. 3.

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Repair Procedure

Installation of Horn Mounting Brackets (Continued)

- E. Permanently install the 5 rivets making sure both Horn Mounting Brackets No. 2 and No. 3 have been secured to the upper radiator support.

Figure 15.



Figure 16. Top View of Completed Repair

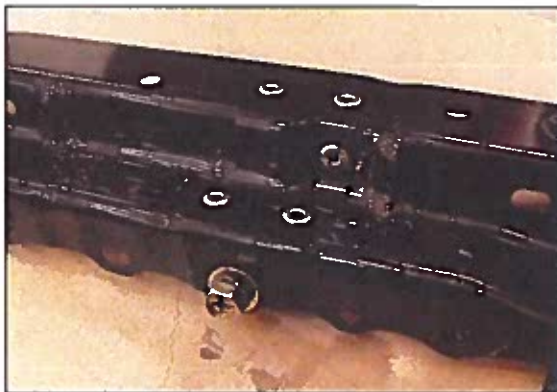
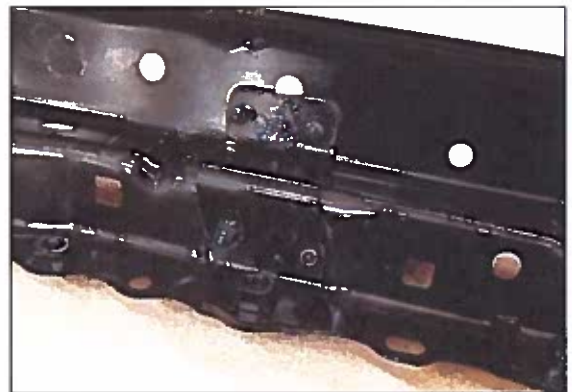


Figure 17. Underside View of Completed Repair



Horn Radiator Support Bracket

Repair Procedure

Installation of Horn Mounting Brackets (Continued)

3. If both horn brackets need replacement, repeat the process for the second Horn Mounting Bracket.
4. Reassemble in reverse order of disassembly.

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

- [2005](#) Tacoma:
Vehicle Exterior – Door/Hatch – “Hood: Adjustment”
 - [2006](#) / [2007](#) / [2008](#) / [2009](#) / [2010](#) / [2011](#) / [2012](#) / [2013](#) / [2014](#) Tacoma:
Vehicle Exterior – Door/Hatch – “Engine Hood/Door: Hood: Reassembly”
 - [2005](#) Tacoma:
Vehicle Exterior – Exterior Panels/Trim – “Front Bumper Cover: Replacement”
 - [2006](#) / [2007](#) / [2008](#) / [2009](#) / [2010](#) / [2011](#) / [2012](#) / [2013](#) / [2014](#) Tacoma:
Vehicle Exterior – Exterior Panels/Trim – “Exterior: Front Bumper: Installation”
5. Verify proper operation of the horn.

