

Paint Blistering Due to Corrosion on Lower Door Sill

Service Category Vehicle Exterior

Section Body Structure

Market USA

Toyota Supports
 ASE Certification 

Applicability

YEAR(S)	MODEL(S)	ADDITIONAL INFORMATION
2016 - 2019	Tacoma	

Introduction

Some 2016 – 2019 model year Tacoma vehicles may exhibit corrosion or paint blistering on the front and/or rear lower door sill(s). Follow the Repair Procedure in this bulletin to address this condition.

Production Change Information

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

MODEL	PLANT	DRIVE TYPE	ENGINE	PRODUCTION CHANGE EFFECTIVE VIN	
Tacoma	TMMBC	2WD	2GR	3TMAZ5CN#KM080613	
				3TMBZ5DN#KM017695	
				3TMEZ5CN#KM080603	
		4WD		3TMCZ5AN#KM193397	
				3TMDZ5BN#KM056347	
				3TMGZ5AN#KM193312	
	TMMTX	2WD		2GR	5TFAZ5CN#KX072538
					5TFBZ5DN#KX004494
					5TFEZ5CN#KX074813
					5TFRZ5CN#KX072541
					5TFRX5GN#KX134021
					5TFAX5GN#KX134013
		4WD	2GR	5TFCZ5AN#KX168231	
				5TFSZ5AN#KX168233	
				5TFDZ5BN#KX039331	
				5TFGZ5AN#KX168342	
2TR	5TFSX5EN#KX064091				

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Warranty Information

OP CODE	DESCRIPTION	TIME	OFF	T1	T2
BD1818	Sublet to Body Shop to Repaint Door Sill(s)*, Apply Clear Tape and Sealer, and Install Door Sill Protector (if equipped). (One Door)	0.5	61132-040## 61131-040## 61612-040##	69	99
Combo A	Each Additional Door	0.4	61611-040##		

*Use typical body shop sublet type "ZZ Other" for repainting of front and/or rear lower door sill(s).

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

CAB TYPE	PART NUMBER		PART NAME	QTY
	PREVIOUS	NEW		
C Cab	N/A	58745-04010	Protector, Quarter Panel, FR RH (Flange Tape for Front Doors)	2
D Cab	N/A	58745-04020	Protector, Quarter Panel, FR RH (Flange Tape for Front Doors)	2
	N/A	58747-04010	Protector, Quarter Panel, RR RH (Flange Tape for Rear Doors)	2
C Cab	PT747-35160-AA		Door Sill Protectors, Front*	1
	PT747-35160-AB		Door Sill Protectors, Rear*	
D Cab	PT747-35161-AA		Door Sill Protectors, Front*	
	PT747-35161-AB		Door Sill Protectors, Rear*	

*Only order replacement door sill protectors if vehicle had them originally.

Required Tools & Equipment

SPECIAL SERVICE TOOLS (SST)	PART NUMBER	QTY
Plastic Pry Tool Kit*	00002-06020-01	1

*Essential SST.

NOTE

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

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Required Tools & Equipment (continued)

REQUIRED TOOLS & MATERIAL	QUANTITY
Rubbing Alcohol or Equivalent	1
Shop Rags	1
Masking Tape	1
Ruler (mm)	1
Personal Protective Equipment	1
3M™ Urethane Seam Sealer Gray (P/N 08361) or Equivalent	1

Repair Procedure

- Confirm the condition exists.
Is corrosion or paint blistering present on the surface of ANY lower door sill?
 - YES** — Proceed to step 2.
 - NO** — This bulletin does NOT apply. Continue diagnosis using the applicable Repair Manual.

Figure 1.



1	Door Scuff Plate
2	Door Sill Protector

Figure 2.



Figure 3.



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Repair Procedure (continued)

2. Sublet the vehicle to a body shop to repaint the door sill(s).
 - A. If the vehicle has door sill protectors installed, remove the door sill protectors on the affected door BEFORE painting. A NEW door sill protector MUST be ordered and installed AFTER the vehicle has been repainted.
 - B. If burrs are present on top of the flange, sand down the burrs BEFORE repainting.
 - C. Repaint the lower door sills following the paint manufacturer's system specifications.
 - D. AFTER repainting, continue to step 3.

3. Install the NEW door sill protector (if equipped) by following the accessory installation instructions.

4. Apply clear flange tape.
 - A. With the door sill repainted, remove the plastic door scuff plate and kick panel. Remove the lower half of the door open trim weatherstrip to allow for easier installation.
 - B. With a clean rag and rubbing alcohol, remove ANY debris or dirt from the outer, upper, and inner portions of the lower door sill flange (upper rocker flange). On the C Cab, be sure to clean between the flange and the striker, as shown.
 - C. If the door sill protector is installed, align the clear flange tape flush against the door sill protector. Be sure NOT to allow ANY gaps. Do NOT overlap the protector and the clear flange tape.

Figure 4.



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Repair Procedure (continued)

- D. If the vehicle is NOT equipped with a door sill protector, ensure the clear flange tape is aligned to the flange with the following procedure:
- (1) With a ruler, measure 6 mm, or ¼ in., from the outside of the flange, as the clear flange tape will cover both the pinch weld flange and part of the sill area.
 - (2) Mark this distance with the flat side of a small piece of masking tape. Mark this distance in AT LEAST three locations along the lower door sill to help align the clear flange tape.
- E. After the paint has dried, lightly apply the clear flange tape on the outward facing side of the flange.
- (1) For D Cab front and rear doors, the tape should be applied to the flange, starting just AFTER the first spot weld where the sealer was applied as shown.
 - (2) For C Cab, use the same starting location as the D Cab front door.

- F. Whet out (press out air bubbles) the front side of the flange, starting from the bottom and working up. Do NOT allow ANY air bubbles or wrinkles, especially on the front side of the flange.

In hard-to-reach areas, place a shop rag over a plastic pry tool to whet out the clear flange tape. Be sure NOT to scratch ANY painted surfaces.

- G. Continue to whet out the top and down the back side of the flange, making sure NO air bubbles or wrinkles are present.

Figure 5.



Figure 6.



Figure 7.



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Repair Procedure (continued)

5. Apply the 3M sealer (P/N 08361) or equivalent to the specified location (bowl area) on the lower sill flange as shown.

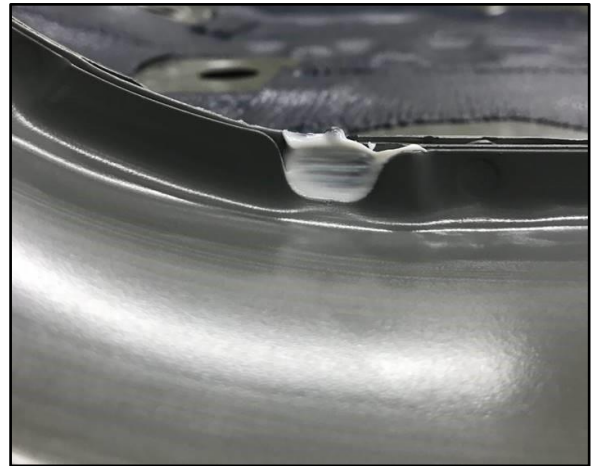
NOTE

Ensure the sealer does NOT dry on the visible portion of the sill AFTER the door open trim weatherstrip is installed.

Figure 8.



Figure 9.



6. Remove the masking tape.
7. Reinstall the door open trim weatherstrip.
8. Reinstall the door scuff plate.