

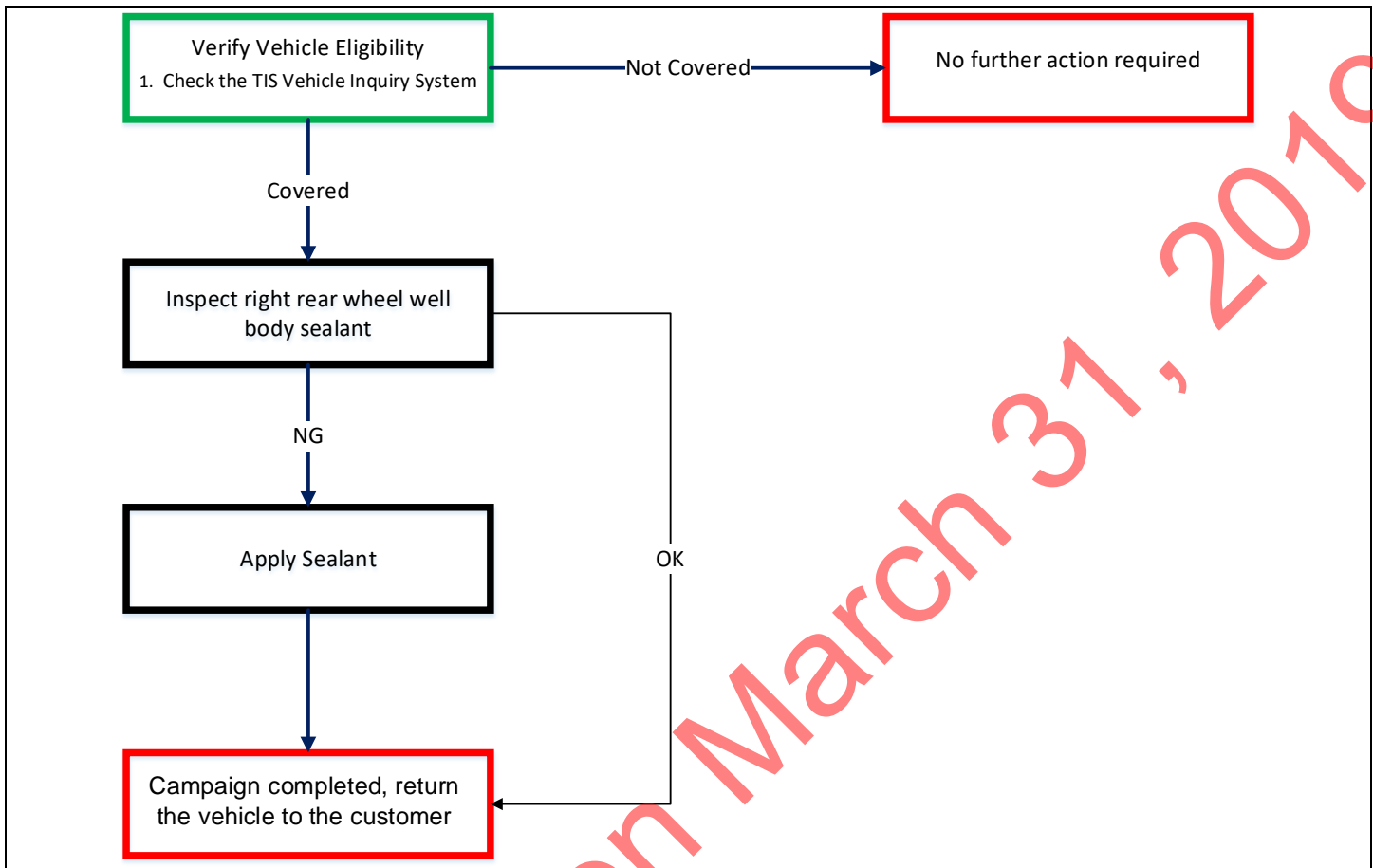
TECHNICAL INSTRUCTIONS
FOR
LIMITED SERVICE CAMPAIGN H0T
REAR WHEEL ARCH SEALER GAP
CERTAIN 2018 CAMRY

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 recall repair are required to currently hold at least one of the following certification levels:

- Certified Technician (any level)
- Expert Technician (any level)
- Master Technician
- Master Diagnostic Technician

It is the dealership's responsibility to select technicians with the above certification level or greater to perform this recall 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

- Check the TIS Vehicle Inquiry System to confirm the VIN is involved in this Limited Service Campaign, and that the Campaign has not already been completed prior to dealer shipment or by another dealer.
- TMS warranty will not reimburse dealers for repairs completed on vehicles that are not affected or were completed by another dealer.

III. PREPARATION

A. PARTS

No parts will be needed.

B. TOOLS & EQUIPMENT

- Techstream
- Standard Hand Tools
- Torque Wrench

C. SST – Special Service Tools

No SST's will be needed for this issue.

D. MATERIALS

- Masking tape
- 3M Flexclear Body Seam Sealer 08405*
- Spatula

*Note: The 3M Flexclear Body Seam Sealer 08405 will need to be ordered outside the Toyota parts system.

IV. BACKGROUND

In the subject vehicles, the inner portion of the right rear fender arch may have an improper sealer application. In these vehicles, water and salt may enter and cause rust spots, paint blistering, or perforation of the rear fender arch. This condition is most likely to occur in areas with heavy road salt application.

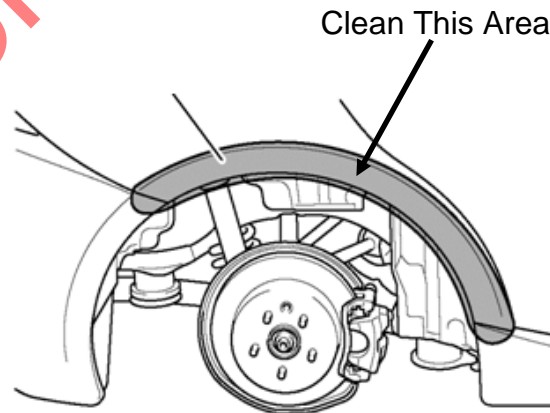
V. INSPECTION PROCESS



1. LIFT VEHICLE AND REMOVE RIGHT REAR WHEEL



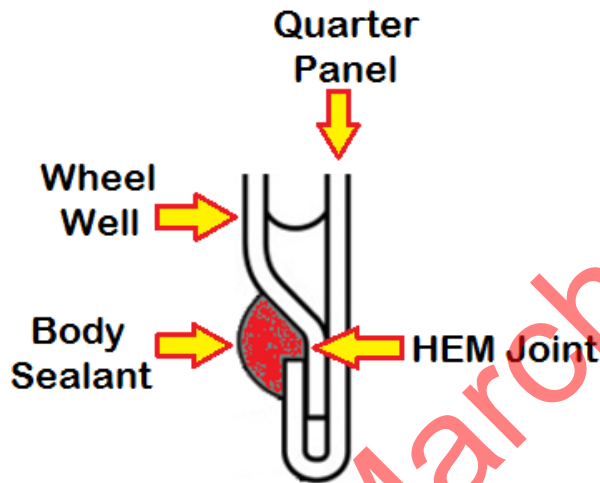
2. CLEAN WHEEL ARCH
 - a. Using water and a cloth, clean the inside edge of the wheel well in the area as shaded below.



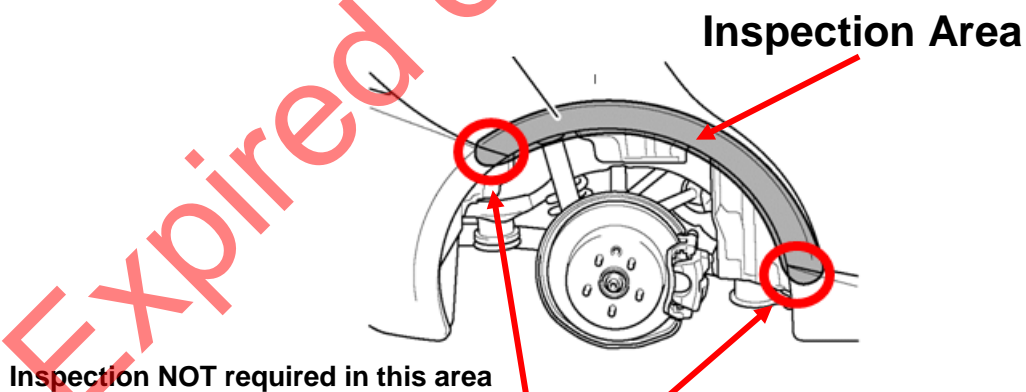
3. INSPECT WHEEL WELL BODY SEALANT

- a. Using a light, visually inspect the body sealant application along the inner wheel well. The sealant should thoroughly cover the hem joint of the quarter panel and wheel well. Identify any areas that the sealant fails to thoroughly cover the hem joint. In some cases, it may be necessary to use your fingernail to feel for the edge of the exposed quarter panel.

Note: Take your time when inspecting the wheel arch. It can be difficult to find misapplied sealant.



Note: The area shaded in gray below needs to be inspected. The two areas at the end of the wheel arch (circled in red below) does NOT need to be inspected. This area has a different application process that is not affected by this issue.



INSPECTION CRITERIA:

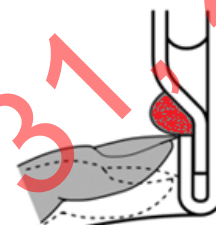
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Inspection Process

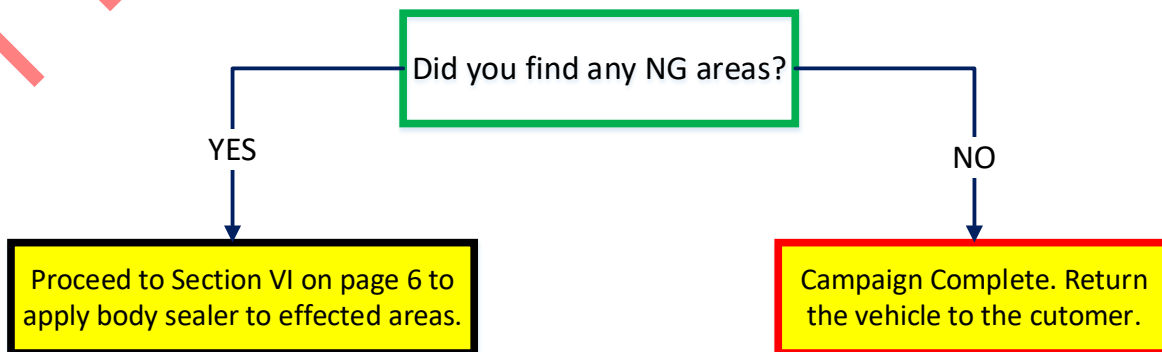


Examples of misapplied sealant:

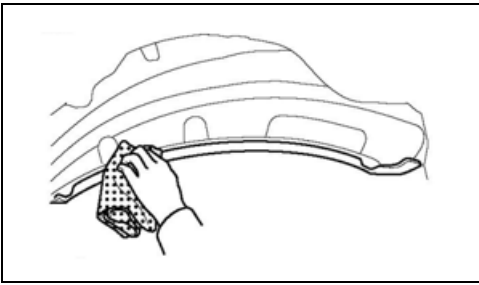


4. INSPECTION RESULTS

- a. After completing the wheel arch sealer inspection, use the following chart to determine the next step.

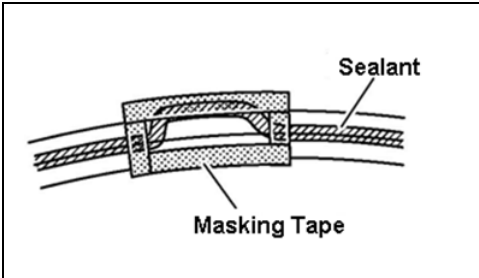


VI. APPLICATION OF BODY SEALER



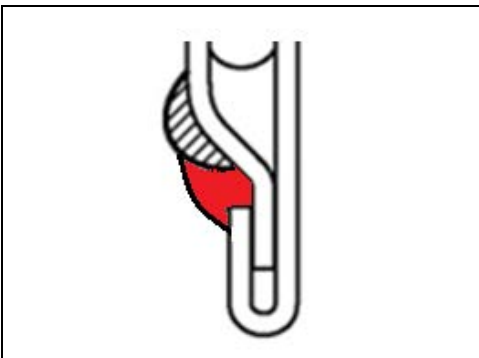
1. CLEAN THE AFFECTED AREAS

- a. Using a degreaser, thoroughly clean ALL the affected areas that were found to have improper sealant application.



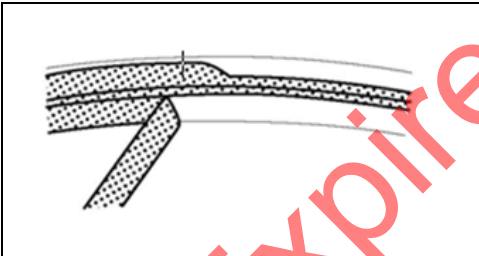
2. APPLY TAPE

- a. Apply masking tape around all 4 edges of the affected areas to prevent the sealant from getting onto unaffected areas of the body panels.



3. APPLY SEAM SEALER

- a. Apply seam sealer to the affected areas. Use a spatula to spread the seam sealer into place as shown in red.
Standard: 3M Flexclear Body Seam Sealer 08405



4. REMOVE TAPE

- a. Immediately remove the masking tape after applying the sealant.

5. INSTALL WHEEL

- a. Torque: 76 ft.lbs {103 N·m, 1050 kgf·cm}

◀ VERIFY REPAIR QUALITY ▶

- If sealant was applied, make sure that it is not visible from the exterior.

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

10. APPENDIX

A. PARTS DISPOSAL

As required by Federal Regulations, 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 DECORDER

