

Front Bumper Cover Gap at Fender

Service Category Vehicle Exterior

Section Exterior Panels/Trim

Market USA

Toyota Supports
 ASE Certification 

Applicability

YEAR(S)	MODEL(S)	ADDITIONAL INFORMATION
2014 - 2020	4Runner	

REVISION NOTICE

October 16, 2020 Rev2:

- The Repair Procedure section has been updated.

June 26, 2020 Rev1:

- The Production Change Information section has been updated.
- Any previous printed versions of this bulletin should be discarded.

Introduction

Some 2014 – 2020 model year 4Runner vehicles may exhibit a gap due to disengagement of the front bumper cover clips and the fender retainer near the headlamp assembly. 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	DRIVETRAIN	PRODUCTION CHANGE EFFECTIVE VIN
4Runner	Tahara	4WD	JTEBU5JR#L5790365
			JTEBU5JR#L5790414
		2WD	JTEZU5JR#L5221445
			JTEZU5JR#L5221461

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Warranty Information

OP CODE	DESCRIPTION	TIME	OFF	T1	T2
BD1920	Remove the Front Bumper Cover and Replace the Retainers. Apply 3M™ Dual Lock™ Fasteners on the Front Bumper Cover and Retainers and Reinstall the Front Bumper Cover.	1.0	52115-35152 52116-35152	62	99

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
PREVIOUS	NEW		
52115-35152	52115-35153	Support, Front Bumper Side, RH	1
52116-35152	52116-35153	Support, Front Bumper Side, LH	1
67069-35010		Garnish Set	1

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Repair Procedure

1. Confirm the condition exists.
Does the vehicle exhibit a gap due to disengagement of the front bumper cover clips and the fender retainer near the headlamp assembly?
 - **YES** — Continue to step 2.
 - **NO** — This bulletin does NOT apply. Continue diagnosis using the applicable Repair Manual.

Figure 1.



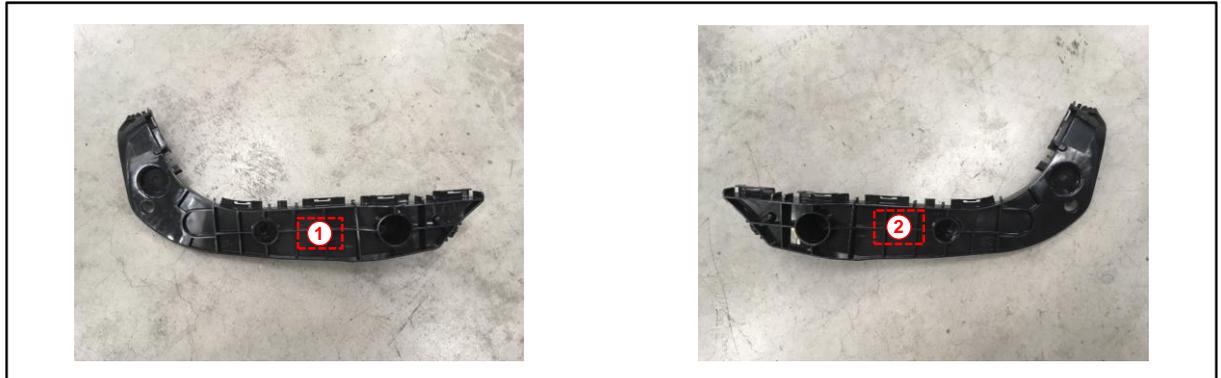
2. Remove the front bumper cover.
Refer to TIS, applicable model and model year Repair Manual:
 - [2014](#) / [2015](#) / [2016](#) / [2017](#) / [2018](#) / [2019](#) / [2020](#) 4Runner:
Vehicle Exterior – Exterior Panels/Trim – “Exterior Panels/Trim: Front Bumper: Removal”

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Repair Procedure (continued)

3. Remove the old retainers and Install the NEW retainers.

Figure 2. Retainers

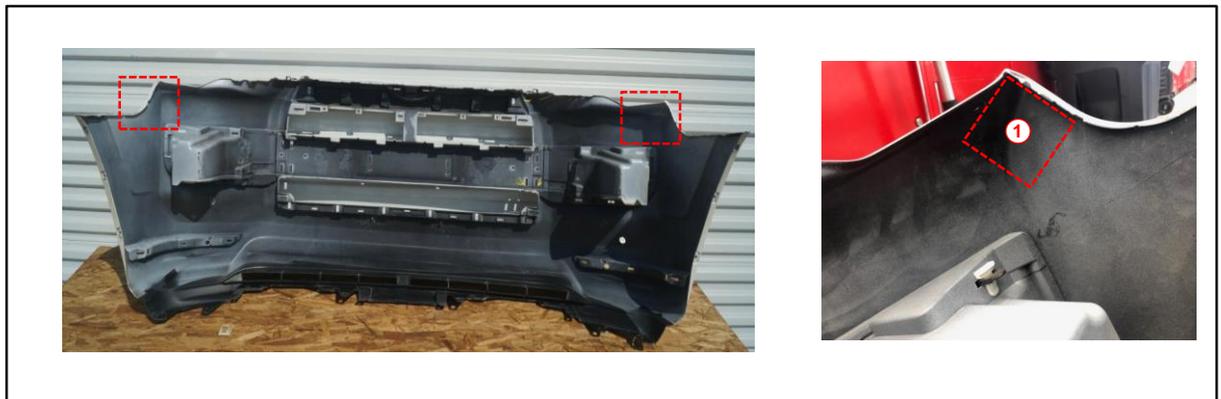


1	Left-hand Side Retainer (Part No. 52116-35153)
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2	Right-hand Side Retainer (Part No. 52115-35153)
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<p>NOTE You MUST order the garnish set (part no. 67069-35010) BEFORE continuing to step 4.</p>

Figure 3. Primer Application and Dual Lock™ Fastener Installation Areas on the Front Bumper Cover



1	Along the Side Wall
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Repair Procedure (continued)

- Using 3M™ PAC Cleaner No. 300, clean ALL front bumper cover and retainer surfaces where the Dual Lock™ Fasteners will be installed.

NOTE

- Use one cleaner pack to clean ALL surfaces.
- Ensure ALL debris and contaminants are removed.

Figure 4. Front Bumper Cover and Retainer Cleaning Surfaces



1 Clean Using 3M™ PAC Cleaner No. 300

NOTE

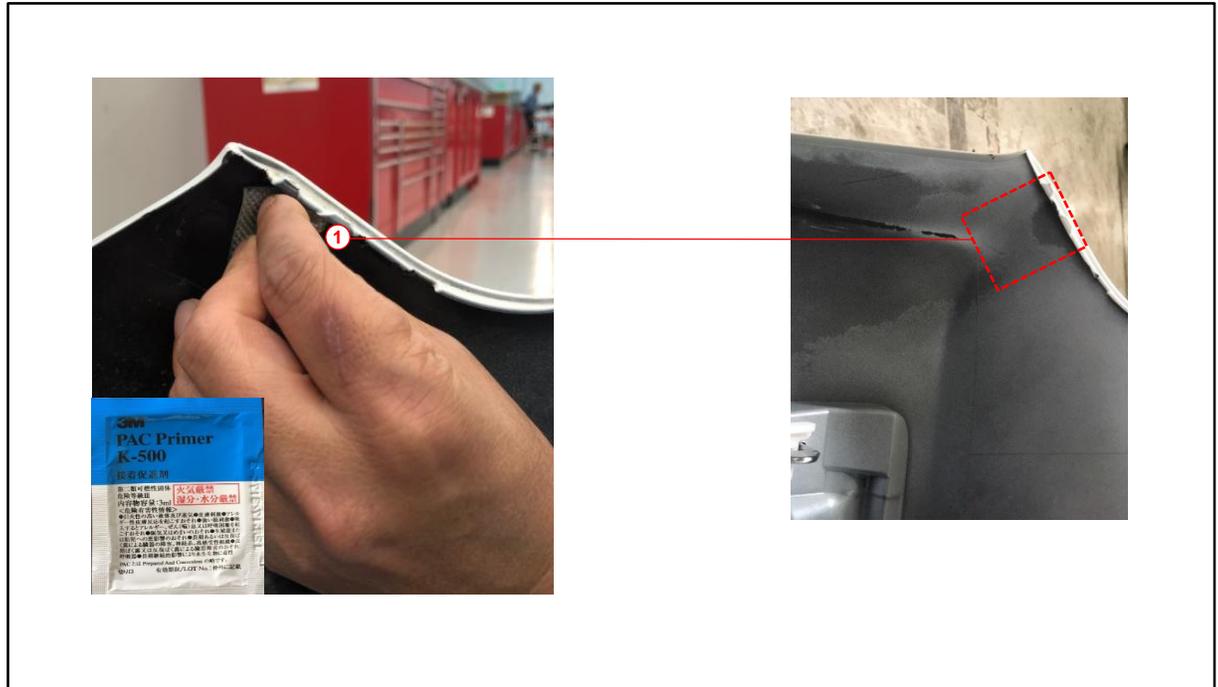
Refer to the instruction video link: [Cleaning Example](#).

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Repair Procedure (continued)

5. Apply 3M™ PAC Primer K-500 to the surface on each side of the front bumper cover where the Dual Lock™ Fasteners will be installed and allow it to dry for AT LEAST two minutes and a MAXIMUM of four minutes.

Figure 5.



1	Apply 3M™ PAC Primer K-500
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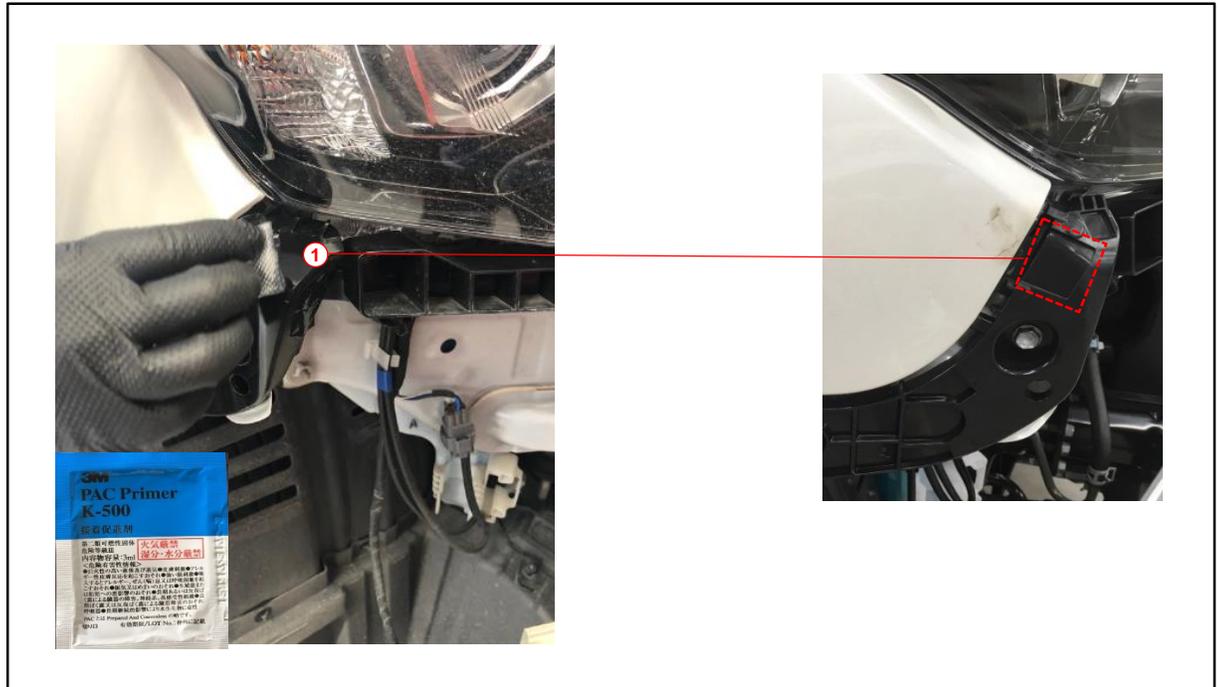
NOTE
Ensure the primer is completely dry BEFORE continuing to step 6.

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Repair Procedure (continued)

6. Apply 3M™ PAC Primer K-500 to the retainer surface on each side where the Dual Lock™ Fasteners will be installed and allow it to dry for AT LEAST two minutes and a MAXIMUM of four minutes.

Figure 6.



1	Apply 3M™ PAC Primer K-500
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NOTE

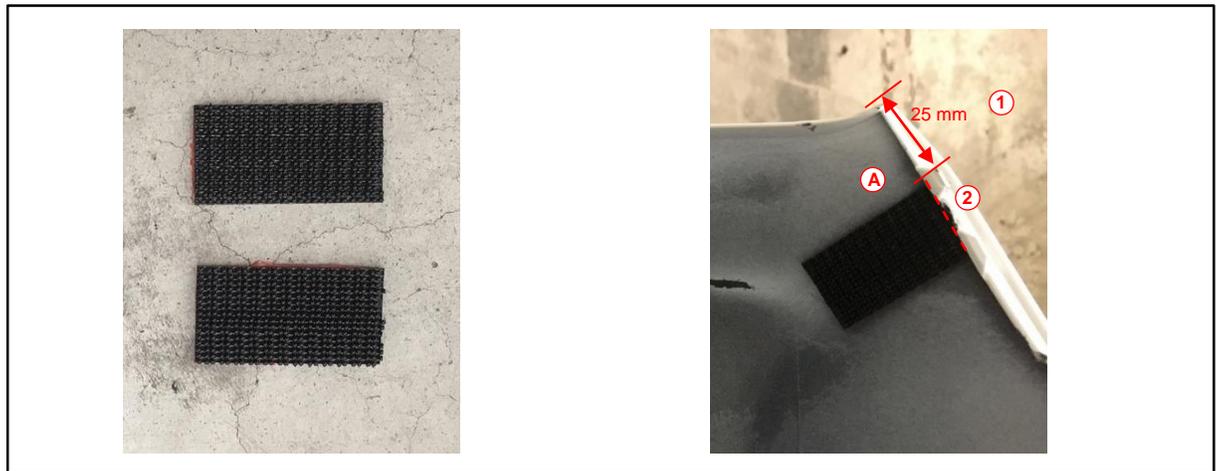
- Refer to the instruction video link: [Primer Application Example](#).
- Ensure the primer is completely dry BEFORE continuing to step 7.

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Repair Procedure (continued)

- Apply the larger Dual Lock™ Fasteners (35 mm x 20 mm) to each side of the front bumper cover.

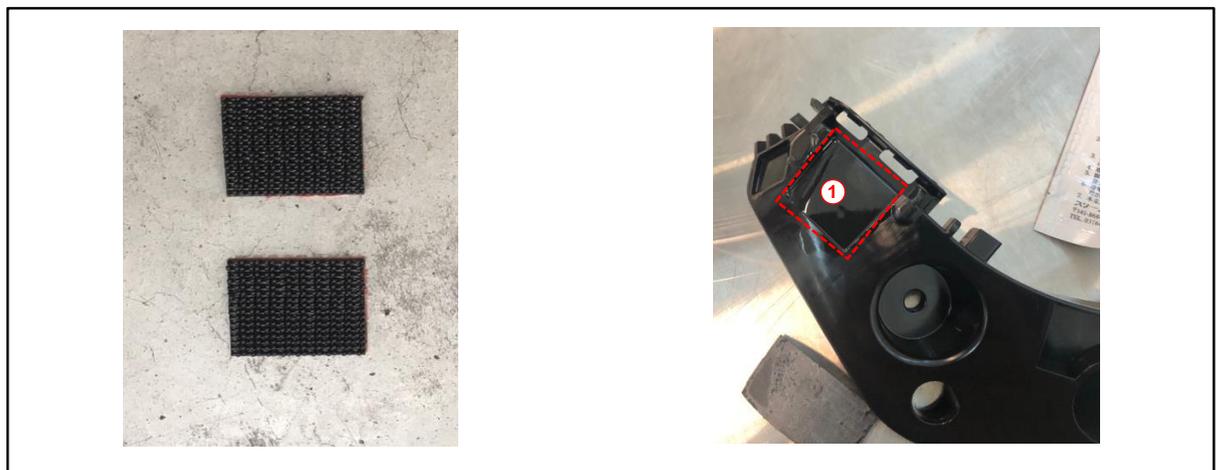
Figure 7.



A	Front Bumper Cover Side Wall
1	Apply Along the Shape
2	Apply Along the Line

- Apply the smaller Dual Lock™ Fasteners (25 mm x 20 mm) to both side retainers. Paste the Dual Lock™ Fasteners inside the cut-out area.

Figure 8.



1	Cut-out Area on the New Retainer
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Repair Procedure (continued)

- Confirm proper Dual Lock™ Fastener adhesion. Press hard on ALL corners of the Dual Lock™ Fastener. In case of retainer, hold for 10 – 15 seconds on each corner to achieve adhesion.

Figure 9.



A	Retainer
1	Press

B	Front Bumper Cover Side Wall
1	Press

NOTE

- Refer to the instruction video link: [Dual Lock™ Fastener Application](#).
- Make sure the bottom of each Dual Lock™ Fastener is completely pasted on the front bumper cover and retainer surfaces.

- Insert the washer from the set on each side bumper flange around the wheel arch during the front bumper cover reinstallation.

Figure 10.



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Repair Procedure (continued)

11. Reinstall the front bumper cover.

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

- [2014](#) / [2015](#) / [2016](#) / [2017](#) / [2018](#) / [2019](#) / [2020](#) 4Runner:
Vehicle Exterior – Exterior Panels/Trim – “Exterior Panels/Trim: Front Bumper: Installation”

NOTE

The bumper needs to be fully installed with radiator grill and top cover, all clips engaged before continuing to step 12.

12. Press on the area where the fasteners are installed to ensure the Dual Lock™ Fasteners are properly engaged AFTER the front bumper cover installation has been completed.

NOTE

Refer to the instruction video link:
[Proper Dual Lock™ Fastener Engagement.](#)

Figure 11.



1	Press
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13. Visually confirm the overall front bumper cover condition has improved.