

Abnormal Hood Fluttering and/or Vibration While Driving 25 mph or Higher

Service Category Vehicle Exterior

Section Body Structure

Market USA

Toyota Supports
ASE Certification 

Applicability

YEAR(S)	MODEL(S)	ADDITIONAL INFORMATION
2024	GX550	

Introduction

Some 2024 model year GX 550 vehicles may exhibit an abnormal hood fluttering and/or vibration while driving 25 mph or higher. The mastic between the outer panel and the hood brace may have separated. 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
GX 550	Tahara	V35AFTS	JTJTBCDX#R5020717

Warranty Information

OP CODE	DESCRIPTION	TIME	OFP	T1	T2
BD2501	Hood Foam Reinforcement	2.0	53301-60820	9B	14

APPLICABLE WARRANTY

- This repair is covered under the Lexus Basic 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

PART NUMBER	PART NAME	QTY
53393-60060	Urethane Block	1
90467-07229	Hood Insulator Clips	10

Required Tools & Equipment

REQUIRED TOOLS & MATERIAL	QTY
3M™ Manual Cartridge Applicator (08571)	1
3M™ Mixing Nozzle (8193)	3
3M™ NVH Dampening Material 200 ML Cartridge (04274)	1
Urethane Foam (53393-60060)	1
Fastener Removal Tool	1
Automotive Fender Stand	1
Nitrile Gloves	5 Pair
Painter's Tape	1 Roll
Scissors	1
Ruler	1
Disposable Engine Cover or Equivalent	As Needed
Flat Head Screwdriver	1
Disposable Shop Towels	As Needed
Borescope	1 (Optional)

Repair Procedure

1. Confirm the condition exists.

Does the vehicle exhibit an abnormal hood fluttering and/or vibration while driving 25 mph or higher?

- **YES** — Continue to step 2.
- **NO** — This bulletin does NOT apply. Continue diagnosis using the applicable Repair Manual.

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Repair Procedure (continued)

2. Protect the engine bay.
Cover the engine bay with disposable engine covers or an equivalent protective material.

Figure 1. Example of Engine Covered with Equivalent Protective Material



3. Use a fastener remover tool to remove the ten hood insulator clips, then remove the hood insulator.

NOTE

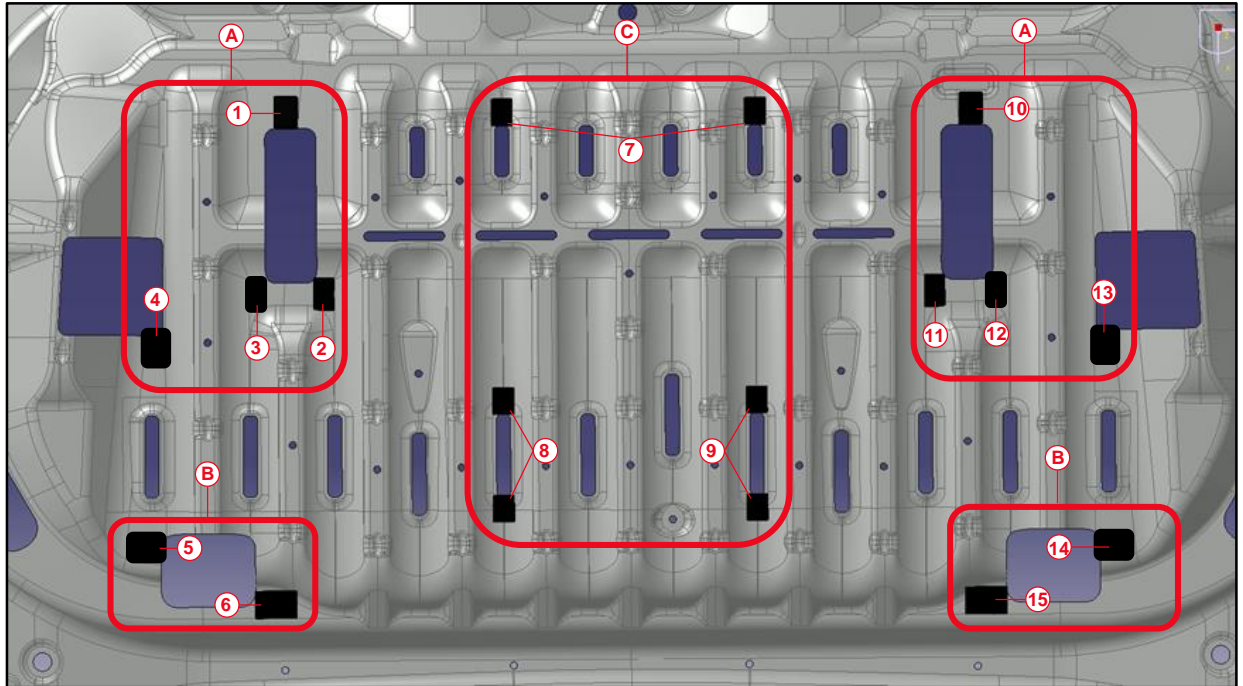
Clips are NOT reusable. Dispose of clips after they are removed.

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Repair Procedure (continued)

4. Prepare the hood for urethane foam installation.

Figure 2. Hood Location for Urethane Foam



A	Section A
B	Section B
C	Section C
1	AL1
2	AL2

3	AL3
4	AL4
5	BL1
6	BL2
7	C1

8	C2
9	C3
10	AR1
11	AR2
12	AR3

13	AR4
14	BR1
15	BR2

NOTE

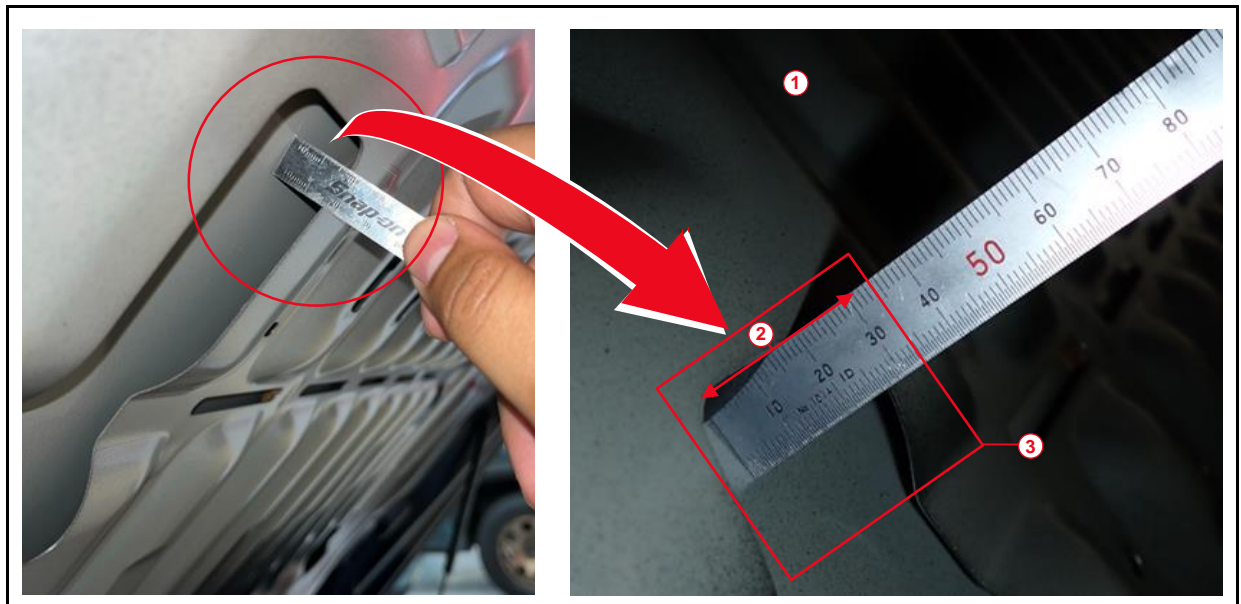
- Urethane foam blocks for Section A and Section B will need 3M™ NVH Dampening Material added to the block before it is added in between the outer hood panel and hood brace.
- Section C does NOT receive 3M™ NVH Dampening Material before installation.

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Repair Procedure (continued)

5. Section A Prep.
 - A. Starting with AL1, use a ruler to measure the clearance between the outer hood panel and hood brace. Add 2 mm to the measured clearance to determine the height. Refer to Figure 3 for measuring assistance.
 - B. Cut a urethane foam block to the determined height using scissors.
 - C. Ensure the newly cut blocks fit properly and snugly between the hood panel and the hood brace.
 - D. Label the block (e.g., AL1).

Figure 3. Measurement Method for Internal Clearance



1	Hood Brace
2	Clearance

3	Hood Inner Opening Hole
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6. Section C Prep.
 - A. Using the AL1 block as a template, cut three additional blocks from the urethane foam block.
 - B. Label these three blocks C1, C2, and C3, and then set these blocks aside.
 - C. Set aside block AL1.
7. Continue Section A and B Prep.
 - A. Repeat steps 5A – 5D to prepare blocks AL2 – AL4, AR1 – AR4, BL1 – BL2, and BR1 – BR2.
 - B. Set these blocks aside with block AL1.

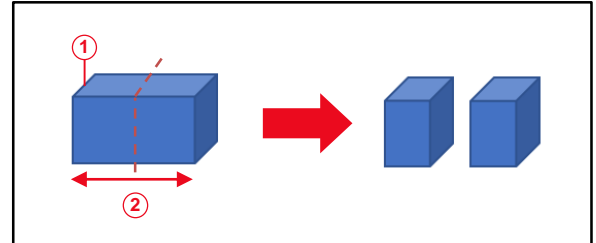
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Repair Procedure (continued)

8. Section C installation

- Use scissors to cut the C1 urethane foam block in half lengthwise.
- Place the two halves at their corresponding locations between the outer hood and hood brace. See Figure 2.
- Repeat these steps for C2 and C3.

Figure 4. Urethane Foam Block Cutting Matrix

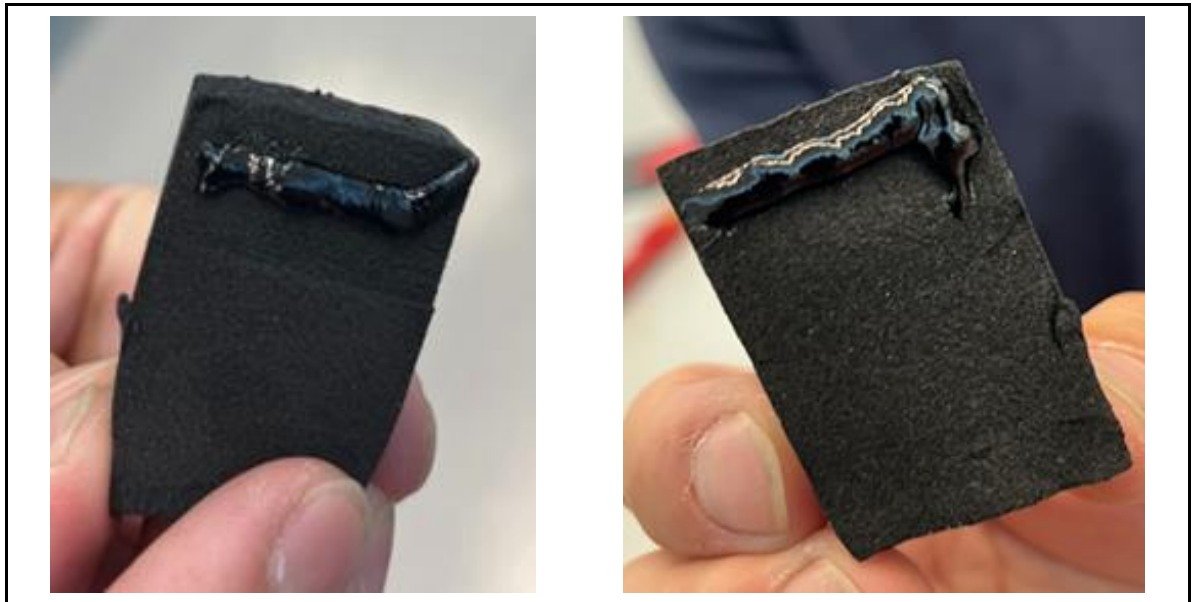


1	C1 Urethane Foam Block
2	Lengthwise

9. Section A and Section B Installation

- Apply a bead of 3M™ NVH Dampening Material from end to end on both sides of each individual urethane foam block (AL1 – AL4, AR1 – AR4, BL1 – BL2, and BR1 – BR2).

Figure 5. Urethane Foam Block with 3M™ NVH Dampening Material



- Immediately insert each block into its corresponding location between the outer hood and hood brace. See Figure 2.

NOTE

The urethane foam blocks must be inserted parallel to the hood. Ensure the integrity of each block is NOT compromised. If the block needs to be adjusted once inserted, use a flat head screwdriver to adjust the block. Cover the screwdriver head with painter's tape to protect the E-coat paint.

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Repair Procedure (continued)

10. Once each urethane foam block is in the correct location and position, allow the 3M™ NVH Dampening Material to cure for 1 hour.

11. Remove the hood.

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

- [2024](#) GX 550:

Vehicle Exterior – Door / Hatch – Hood – Disassembly

NOTE

Perform ONLY steps 3 – 6.

12. Place the removed hood on a fender stand.

Figure 6. Hood on Fender Stand



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Repair Procedure (continued)

13. Inject 3M™ NVH Dampening Material into the areas highlighted in Figure 7.

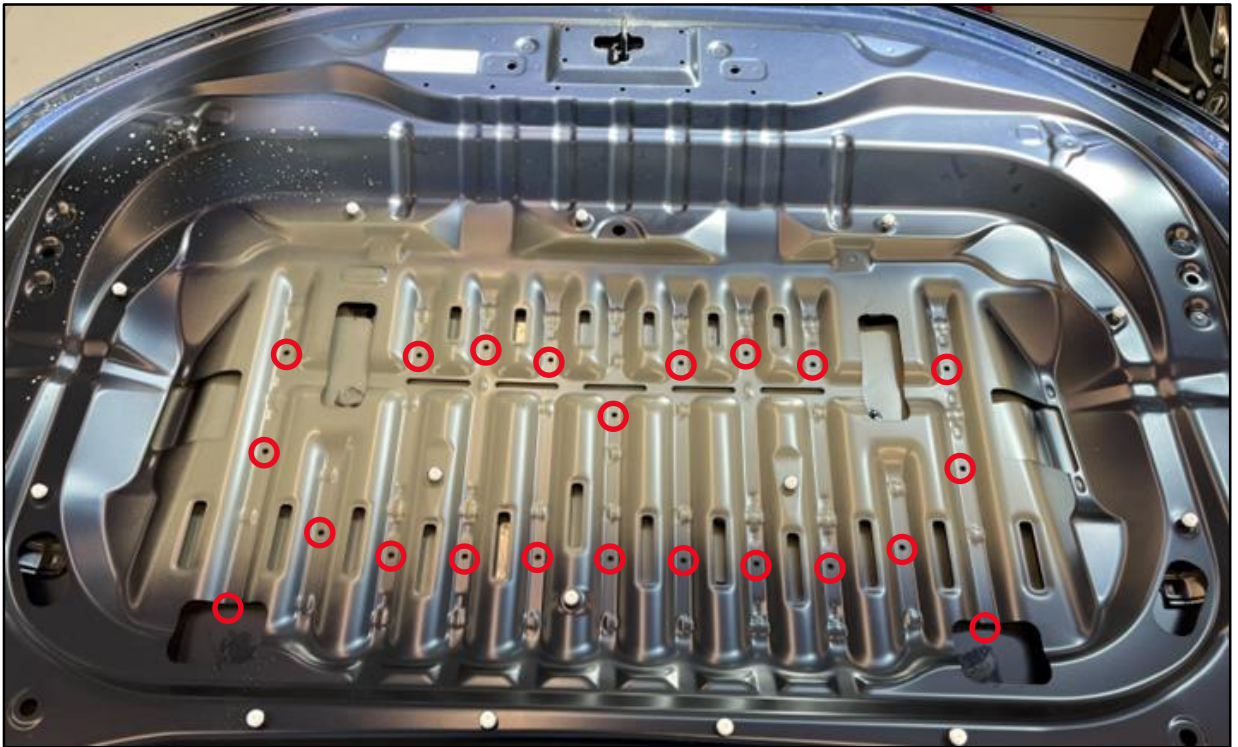
NOTE

- If using a manual caulking gun, pull the trigger 8-9 times. For an automatic caulking gun, ensure the bead forms a “kiss” approximately 25 mm in diameter (about the size of a quarter). Ensure the sealant contacts both the brace and the inner layer of the hood. Refer to Figure 8.
- It is recommended to practice applying the sealant on a blank surface to understand the proper technique before applying to the hood.

NOTICE

Do NOT use too much sealant, as it could negatively affect the appearance of the outer hood.

Figure 7. 3M™ NVH Dampening Material Injection Locations



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Repair Procedure (continued)

Figure 8. 3M™ NVM Dampening Material Approximately 25 mm



14. Allow the hood to fully cure for 24 hours, starting from the time the final application of sealing material is added.
15. Reassemble the hood.
Refer to TIS, applicable model and model year Repair Manual:
 - [2024](#) GX 550:
Vehicle Exterior – Door / Hatch – Hood – Reassembly
16. Reinstall the hood insulator using NEW clips.
17. Test-drive the vehicle to confirm the condition has been addressed.