TECHNICAL INSTRUCTIONS

FOR

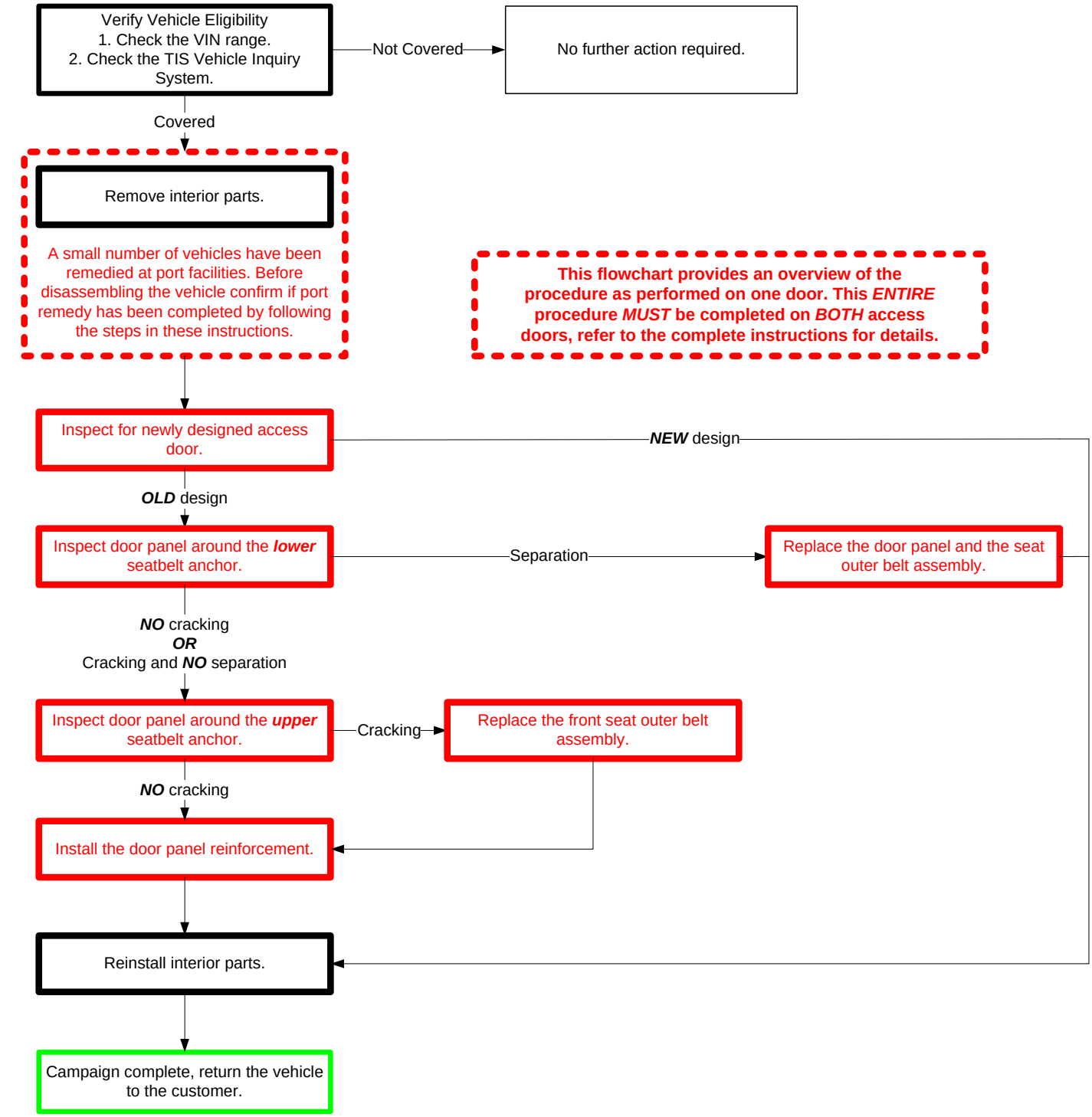
SAFETY RECALL D0C

ACCESS DOOR INNER PANEL

2007 – LATE 2013 MODEL YEAR FJ CRUISER

I. OPERATION FLOW CHART

The flow chart is for reference only. *DO NOT* use it in place of the full technical instructions. Follow *ALL* steps as outlined in the full technical instructions to confirm the campaign is completed correctly.



II. IDENTIFICATION OF AFFECTED VEHICLES

A. COVERED VIN RANGE

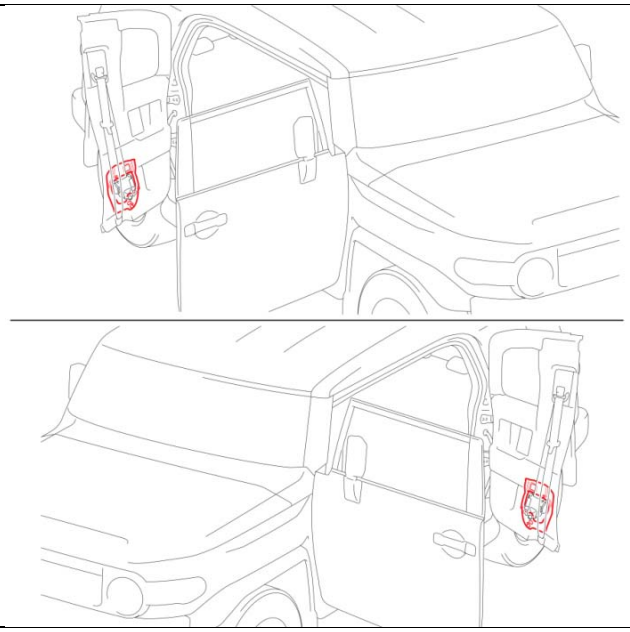
WMI	Year	VIN Range	
		VDS	Range
JTE	2007	BU11F	0001004-0101420
		ZU11F	0001005-0019076
	2008	BU11F	0101421-0107257
		BU11F	K001003-K056845
		ZU11F	0019077-0019919
		ZU11F	K001001-K007996
	2009	BU11F	K056849-K070006
		ZU11F	K007997-K008509
	2010	BU4BF	K070007-K099142
		ZU4BF	K008510-K010844
	2011	BU4BF	K092698-K116292
		ZU4BF	K010845-K011727
	2012	BU4BF	K115382-K148760
		ZU4BF	K011728-K012746
	2013	BU4BF	K148761-K166714
		ZU4BF	K012747-K013341

NOTE:

- Check the TIS Vehicle Inquiry System to confirm the VIN is involved in this Safety Recall, 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 conducted on vehicles that are not affected or were completed by another dealer.

III. BACKGROUND

The retractors for the front driver and passenger seat belts are mounted in the access door panels of the vehicle. Due to insufficient strength of the access door panel, cracks may develop in the panel if the access door Is repeatedly and forcefully closed over an extended period of time. If cracks occur in the panel around the lower retractor anchor, the seat belt retractor could become detached, which could increase the risk of injury to an occupant in the event of a crash.



IV. PREPARATION

A. TECHNICIANS

Technicians ***MUST*** be Certified level or above to perform this campaign. Maintenance level technicians ***ARE NOT*** qualified to perform this repair. Contact your region for technician training and certification.

B. PARTS

Part Number	Part Description	Quantity
04003-09135	Body Fitting Reinforcement Kit*	1

*The kit above includes the following parts.

67385-35010	Access Panel Reinforcement RH	1
67386-35010	Access Panel Reinforcement LH	1
91552-81025	Bolt	2
67187-35010	Bolt with Washer	2
67447-35030	Nut Plate	2
90269-05071	Rivet	20*

*Only 16 rivets are needed for the repair, 4 extra rivets are also provided as supplements.

Part Number	Part Description	Model Year	Note
04003-14835	Belt Assy, Outer LH	2007-2009	**All seat belt assemblies will be placed on MAC, refer to the dealer letter for details.**
04003-13235	Belt Assy, Outer RH		
04003-13535	Belt Assy, Outer LH	2010	
04003-13635	Belt Assy, Outer RH		
04003-13935	Belt Assy, Outer LH	2011-2013	
04003-14935	Belt Assy, Outer RH		

Carefully follow the inspection instructions to determine if belt replacement is necessary.

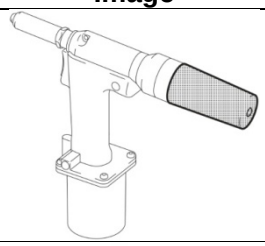
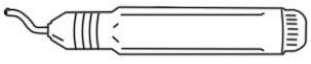
Based on the results of the inspection, the access door may require replacement in rare cases. Carefully follow the inspection instructions to determine if door replacement is needed. If door replacement in necessary, refer to the appendix SECTION XIII. for details on necessary parts.

All parts will be placed on random recovery. If any recovered parts are inspected and determined to be replaced unnecessarily, the claim will be debited.

C. TOOLS & EQUIPMENT

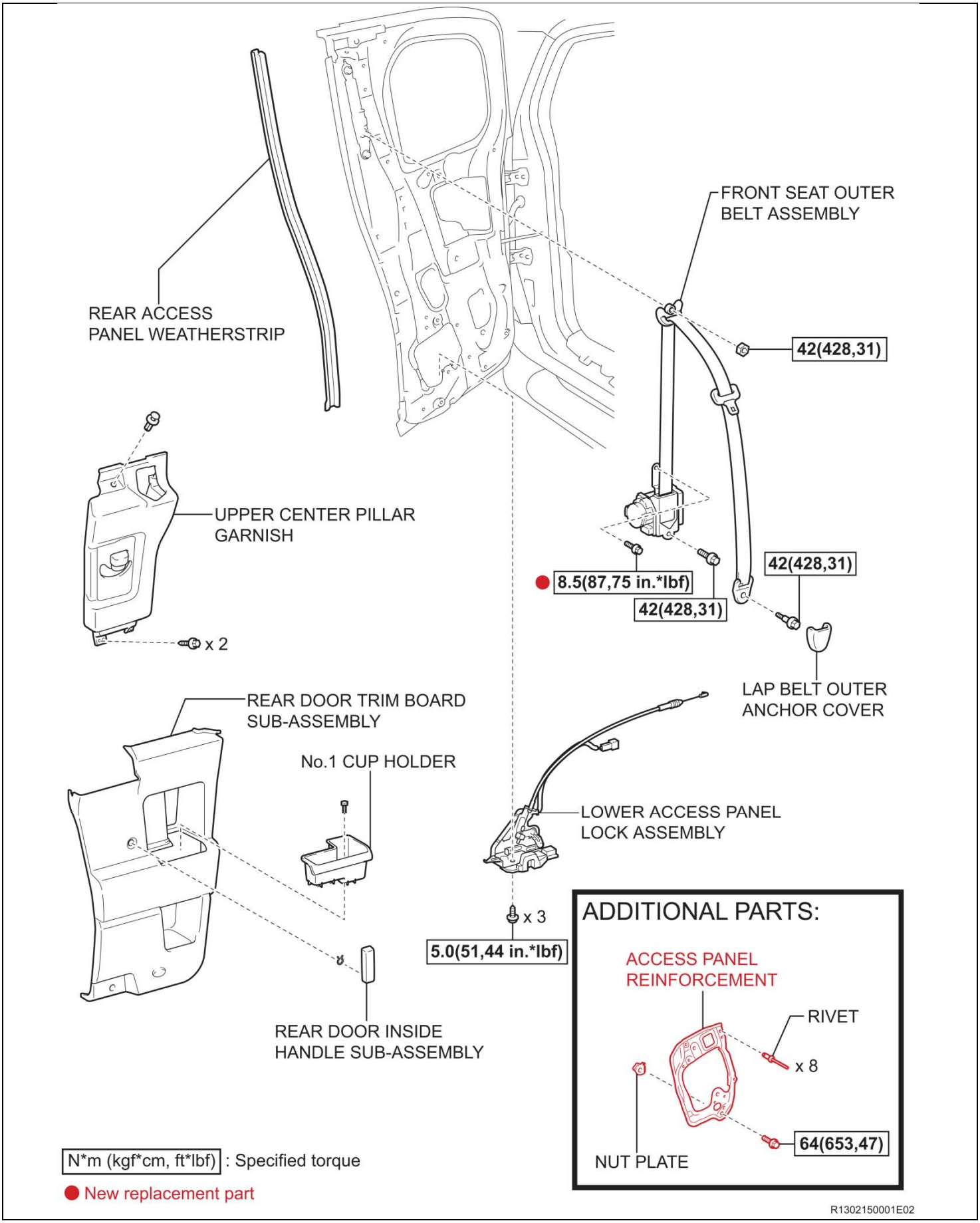
- Standard hand tools
- Torque wrench
- Techstream
- Small paint brush or cotton swab
- Molding remover set
- Vacuum
- Vinyl tape
- Rust-Oleum 7779 or equivalent (touch-up paint)
- FIPG 00295-00103, 1 tube per 3 vehicles approximately

CAMPAIGN TOOLS – These tools are provided to the dealership.

Image	Name	Quantity
	Pneumatic Rivet Gun	1
	Deburring Tool	1
	Drill Bits	13/64”(5mm): 5 5/16”(8mm): 5 25/64”(10mm): 5

NOTE: These tools *CANNOT* be ordered through the parts or tools system. Additional tools are not available at this time.

V. COMPONENTS



VI. PORT MODIFICATION CHECK

1. CONFIRM THE REMEDY HAS NOT BEEN APPLIED AT A PORT FACILITY

a) Inspect the LH access door for a round, green sticker near the certification label.

CONDITION 1	ACTION REQUIRED
Sticker present	Vehicle was remedied at the port. No further action required.

CONDITION 2	ACTION REQUIRED
Sticker ***NOT*** present	Remedy was not performed at the port. Proceed the **SECTION VII.**

VII. REMOVE INTERIOR PARTS

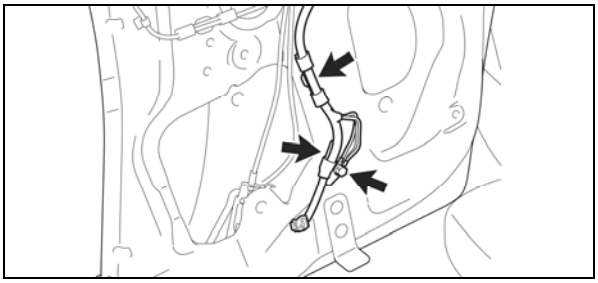
These instructions use the right side to explain the procedure. Perform *ALL* work on *BOTH* right and left sides.

1. DISCONNECT THE NEGATIVE BATTERY TERMINAL

- **Wait at least 90 seconds after disconnecting the cable from the negative battery terminal to prevent airbag and seat belt pretensioner deployment.**
- **Follow all precautions as outlined on TIS before servicing the SRS system.**

2. REMOVE THE FRONT SEAT OUTER BELT ASSEMBLY

Refer to TIS for instructions on front seat outer belt assembly removal

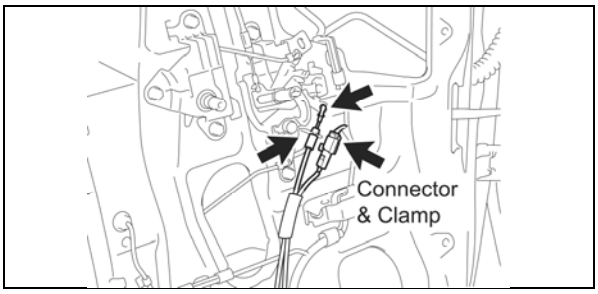


3. DISCONNECT THE DOOR WIRE HARNESS

b) Remove the ground bolt.

c) Disengage and remove the clamps.

NOTE: Squeeze the clamps from the back side to avoid breaking the clamps.

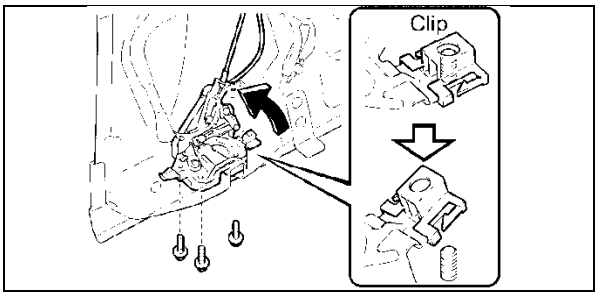


4. REMOVE THE LOWER ACCESS PANEL LOCK ASSEMBLY

a) Disconnect the connector and clamp.

b) Disconnect the control cable.

The lock assembly *MUST* be removed to prevent metal shaving from damaging the assembly.



c) Remove the three screws.

d) Hold the access panel lock and disengage the clip.

e) Remove the access panel lock.

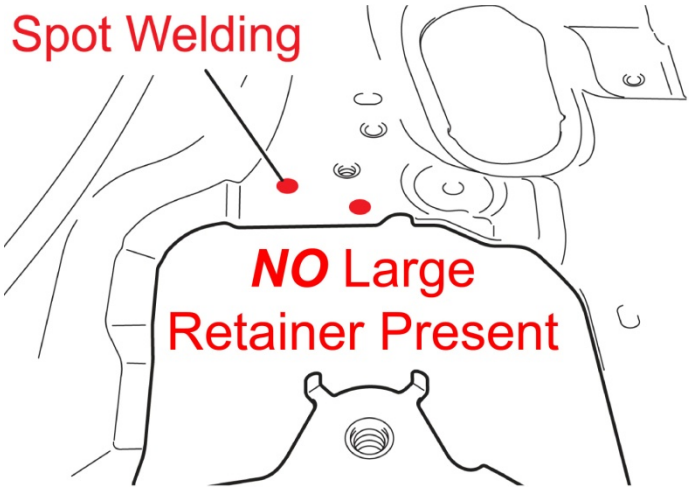
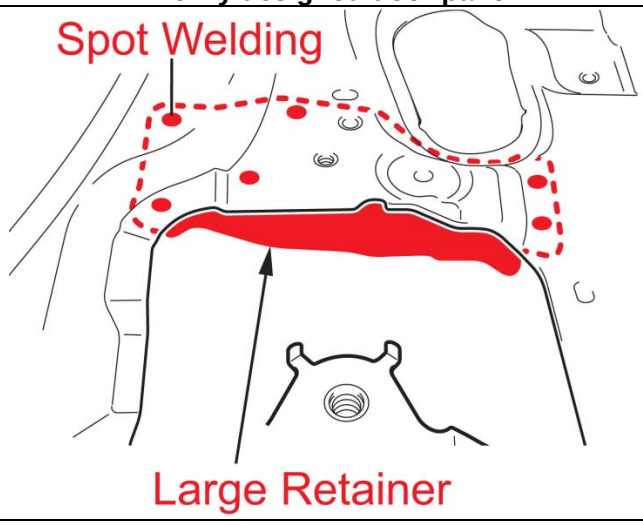
NOTE: This clip is used as a positioner during the manufacturing process. If it is damaged there is no need to replace it, remove it and reinstall the lock assembly.

VIII. INSPECT THE DESIGN OF THE DOOR PANEL

Visually inspect the door panel to determine if a newly designed door has been installed. It is not necessary to install the access panel reinforcement if a newly designed door panel is already installed. This could have occurred during sheet metal repair for accident damage.

1. INSPECT THE REAR DOOR PANEL

a) Visually inspect the inside of the door panel from the underside for a large retainer to determine if the vehicle has a newly designed door. The inspection can also be performed based on the amount of spot welds.

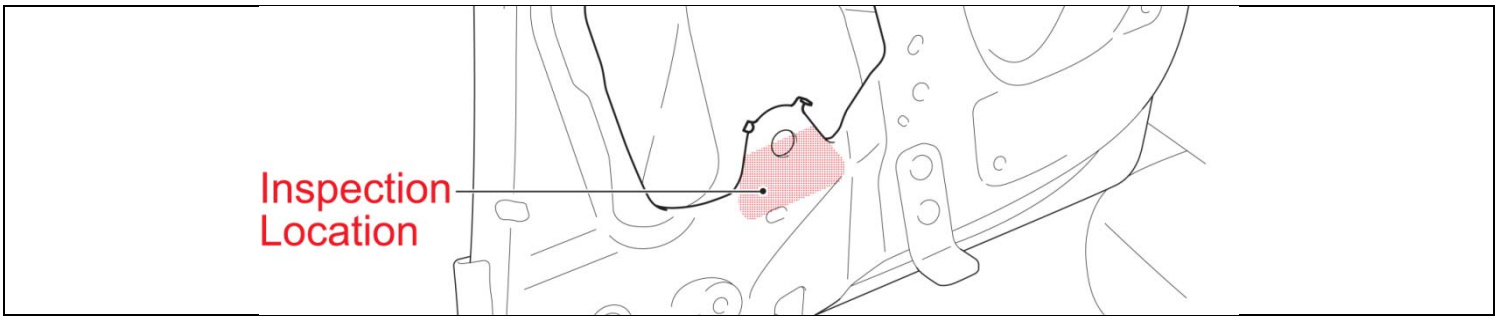
INSPECTION RESULT 1	INSPECTION RESULT 2
NOT **newly designed door panel**	**Newly designed door panel**
	
Additional inspections required. Proceed to **SECTION IX.**	It is ***NOT*** necessary to install a reinforcement or replace the seat outer belt assembly because the door is already equipped with a large retainer. Proceed to **SECTION XII.**

IX. INSPECT THE DOOR PANEL AROUND THE *LOWER* SEATBELT ANCHOR

Visually inspect the door panel around the lower seatbelt anchor to determine if any cracking or separation is found.

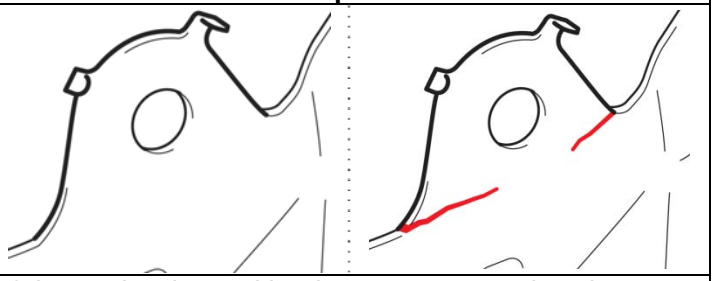
1. INSPECT THE REAR DOOR PANEL

a) Visually inspect the lower seatbelt anchor area for cracks or separation.



INSPECTION RESULT 3

No cracking or some cracking present
***NO* separation**



If the anchor is cracking but not separated or there are no cracks present, additional inspection is required. Complete **STEP 2** below then proceed to **SECTION X.**

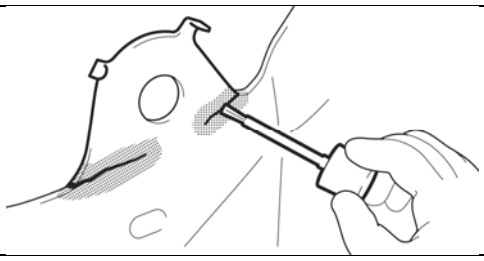
NOTE: It is only necessary to replace the door panel if the anchor is completely separated.

2. APPLY ANTI-RUST TREATMENT TO THE CRACK(S)

a) Apply touch-up paint to the crack(s) to prevent rust formation.

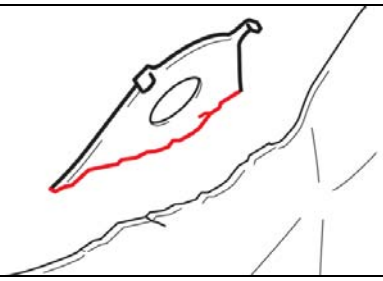
NOTE

- **Use Rust-Oleum 7779 or equivalent, touch-up paint.**
- ***ONLY* perform this step if inspection result 3 was identified.**
- **It is only necessary to apply paint if cracks are present.**
- **If the anchor separates during any of the remaining procedure, replace the door panel as outlined in inspection result 4.**



INSPECTION RESULT 4

Lower seatbelt anchor separation



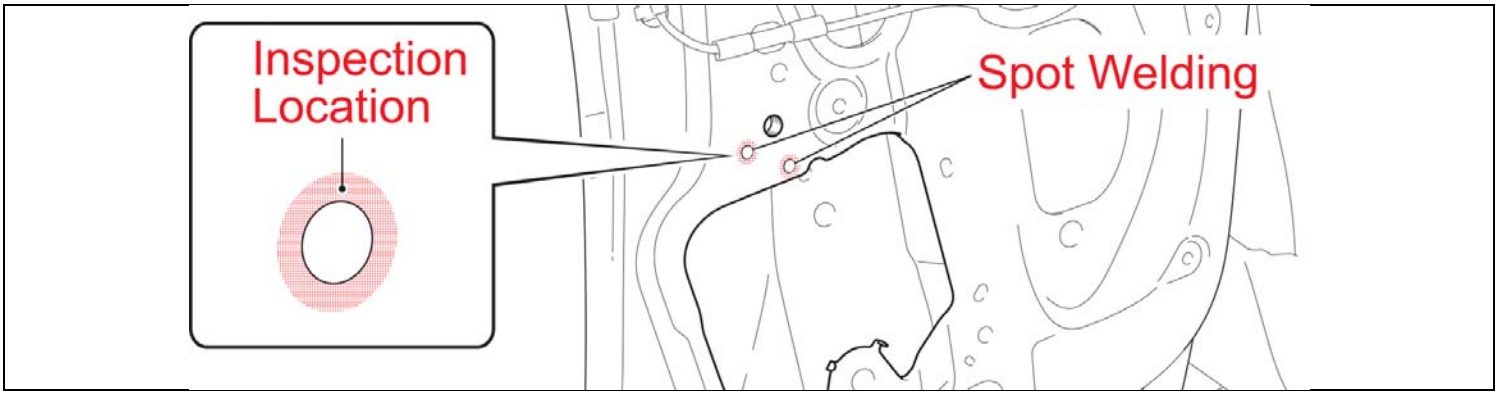
It is necessary to replace the door panel and the seat outer belt assembly. A picture of the separation ***MUST*** be taken for MAC parts release. First, replace the door panel, refer to **SECTION XIII.** for details. Then complete **SECTION XII.**

NOTE:

- **It is not necessary to install the access panel reinforcement if a newly designed door panel is installed.**
- **Confirm the new door being installed is the new design with the large retainer, *DO NOT* use an old design door for replacement.**
- **For MAC part release details, refer to the dealer letter.**

X. INSPECT THE DOOR PANEL AROUND THE *UPPER* SEATBELT ANCHOR

Visually inspect the door panel around 2 welding points near the upper seatbelt anchor to determine if any cracking is found.



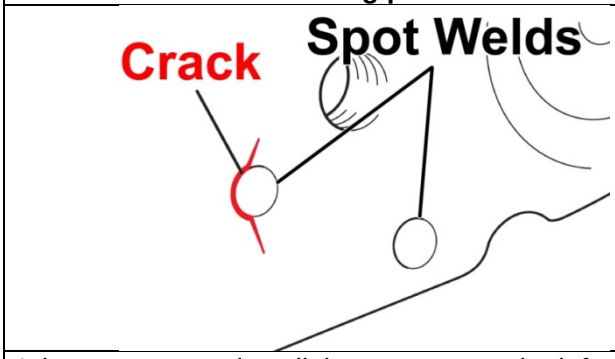
1. INSPECT THE REAR DOOR PANEL

a) Visually inspect the 2 welds near the upper seatbelt anchor for cracking.

- ***DO NOT* confuse cracking with normal wear / paint peeling caused by to the use of the seat outer belt assembly.**
- ***DO NOT* confuse cracking with welding spatter.**

INSPECTION RESULT 5

Cracking preset



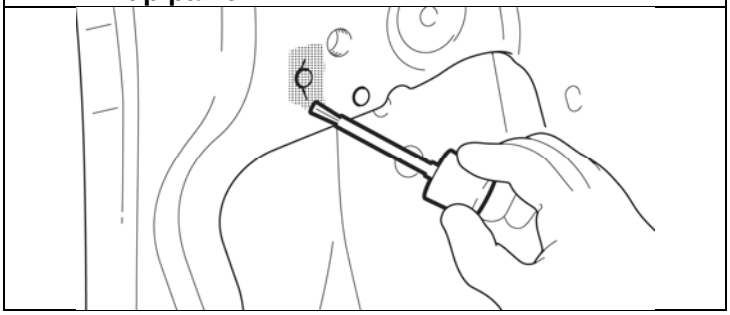
It is necessary to install the access panel reinforcement and replace the seat outer belt assembly. Complete **STEP 2** below then proceed to **SECTION XI.**

2. APPLY ANTI-RUST TREATMENT TO THE CRACK(S)

a) Apply touch-up paint to the crack(s) to prevent rust formation.

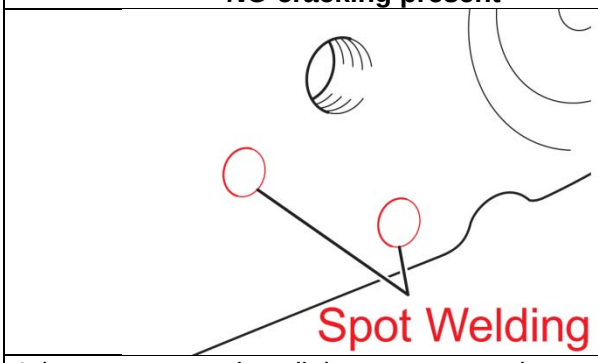
NOTE:

- **Use Rust-Oleum 7779 or equivalent, touch-up paint.**



INSPECTION RESULT 6

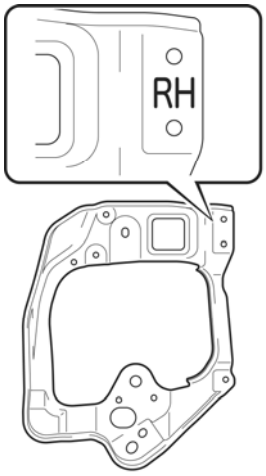
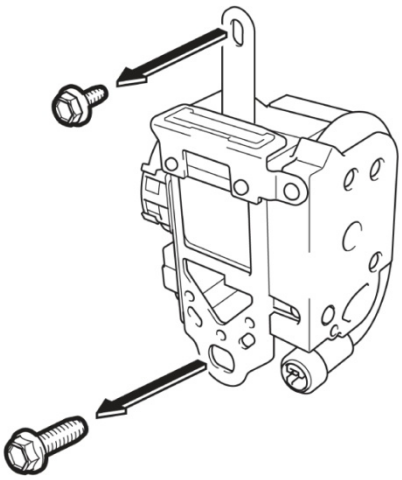
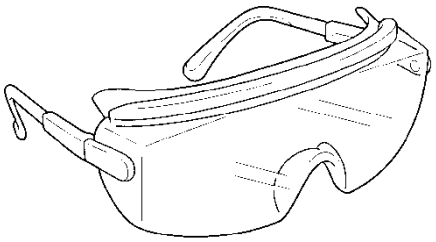
***NO* cracking present**

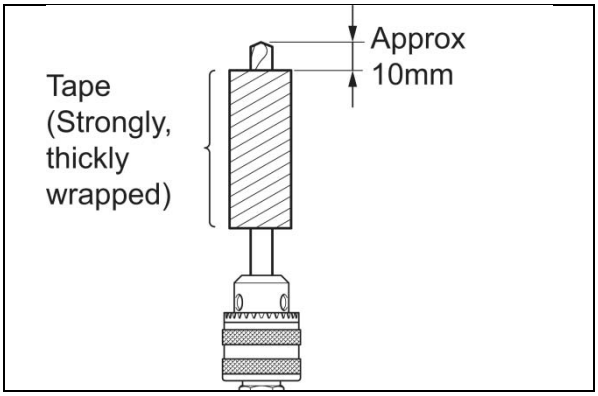


It is necessary to install the access panel reinforcement. Proceed to **SECTION XI.**

NOTE: If no cracking was found during inspections it is not necessary to replace the seat outer belt assembly.

XI. INSTALL THE ACCES PANEL REINFORCEMENT

PREPARATION NOTES		
		
The access panel reinforcement is stamped 'RH' or 'LH' to identify with the corresponding door.	**The bolts that were removed from the seatbelt will be used to hold the panel reinforcement when drilling. A *NEW* upper bolt will be used during *FINAL* installation of the seatbelt.**	**Always wear protective eyewear when drilling.**



1. WRAP THE DRILL BITS WITH TAPE

a) Wrap the drill bits with tape approximately 10mm from the tip of the bit.

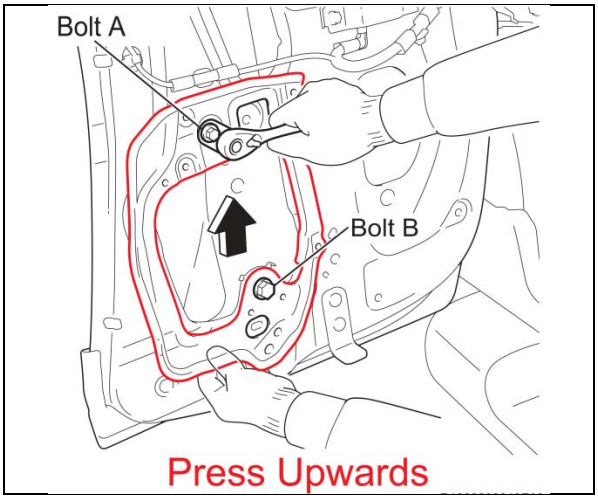
STOP **It is critical to wrap the bits with tape to prevent damage to the outer panel.**

2. APPLY PROTECTIVE MATERIALS

a) Affix tape to the highlighted holes to prevent metal shavings from getting in the holes.

NOTE:The number of holes may differ.

b) Place a shop cloth inside the door to catch metal shavings.

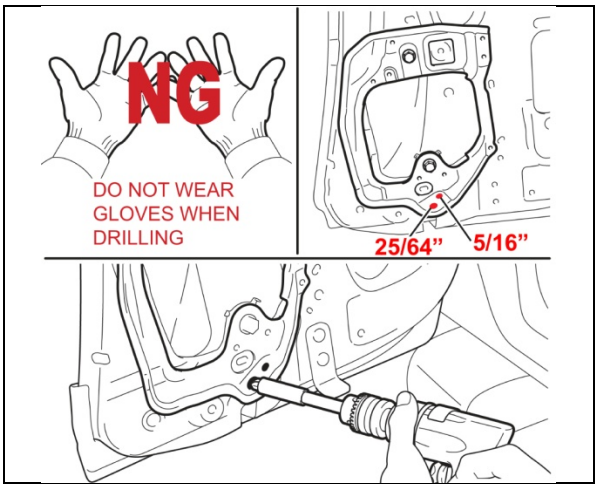


3. TEMPORARILY INSTALL THE ACCESS PANEL REINFORCEMENT

a) Press the reinforcement upwards and hold it while installing the 2 bolts. Use the bolts that were removed from the seatbelt.

Torque:
Bolt A: 75in. lbf (8.5N·m)
Bolt B: 31ft. lbf (42N·m)

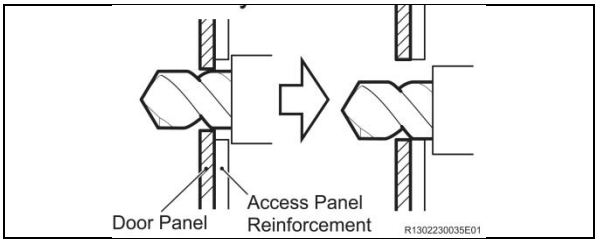
STOP **Be sure to press the panel firmly upwards while tightening the bolts to confirm close contact between the door panel and the reinforcement.**



4. DRILL THE PANEL REINFORCEMENT INSTALLATION HOLES

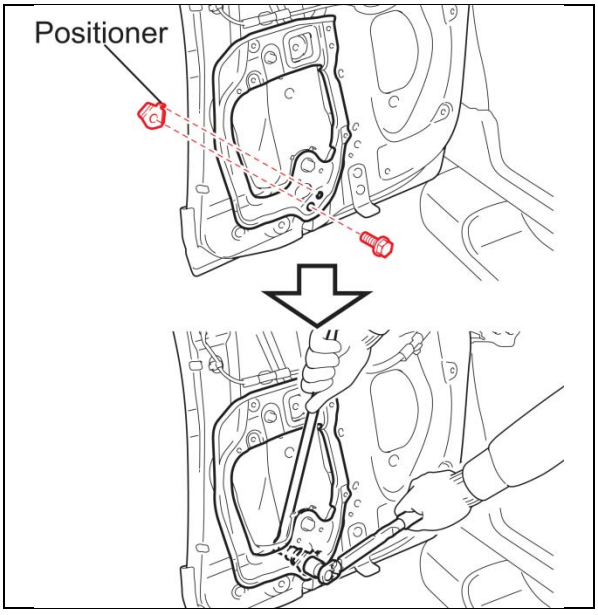
a) Drill the 2 lower holes highlighted in the illustration with the 5/16" and 25/64" drill bits that match the hole sizes.

STOP ***DO NOT*** **wear gloves when using the drill to prevent them from being caught in the drill.**



b) Continue to drill the 25/64" hole to widen it until it is approximately the same size as the hole on the reinforcement.

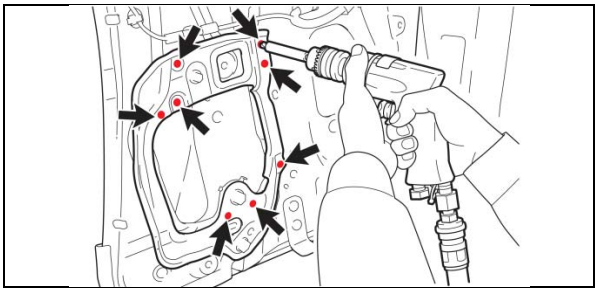
NOTE: Only widen the 25/64" hole.



c) Temporarily install the ***NEW*** nut plate and ***NEW*** bolt. Hold the nut plate with a wrench when tightening the bolt.

Torque: 47ft. lbf (64N·m)

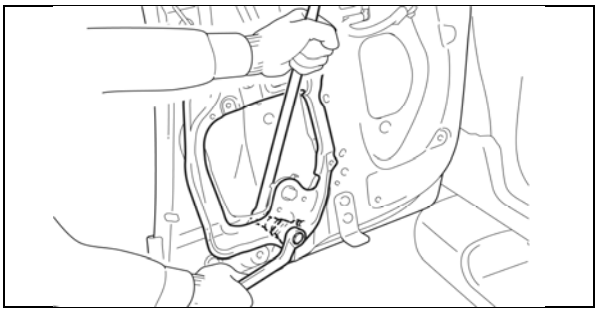
STOP
- **Failure to hold the nut plate with a wrench when tightening will damage the nut plate.**
- ***ALWAYS*** **install the nut plate to prevent misalignment when drilling the remaining holes.**



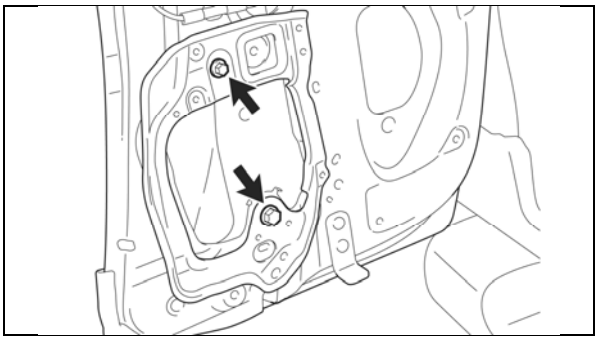
d) Use the 13/64” drill bit to drill the 8 remaining holes.

STOP

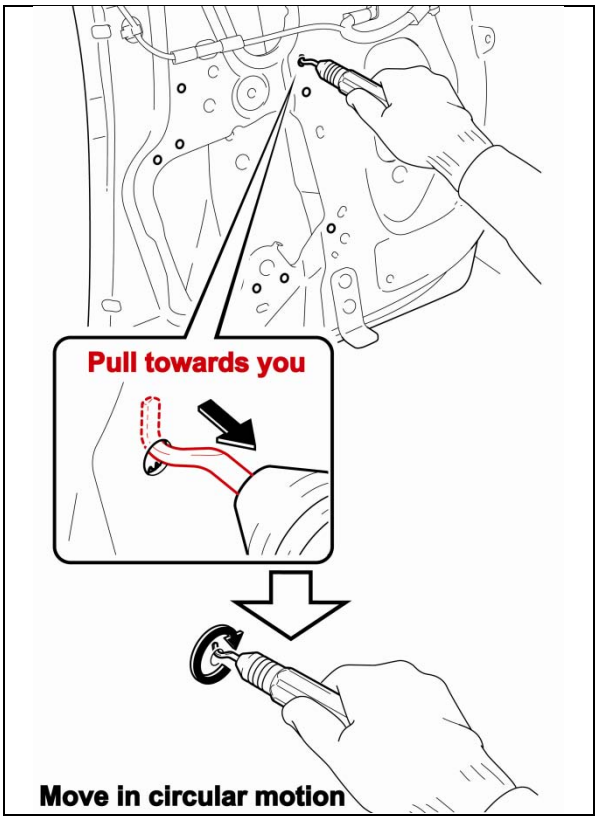
Confirm the drill bits are wrapped with enough tape to prevent the bit from damaging the outer panel.



e) Hold the nut plate with a wrench and remove the bolt.



f) Remove the 2 bolts and the panel.

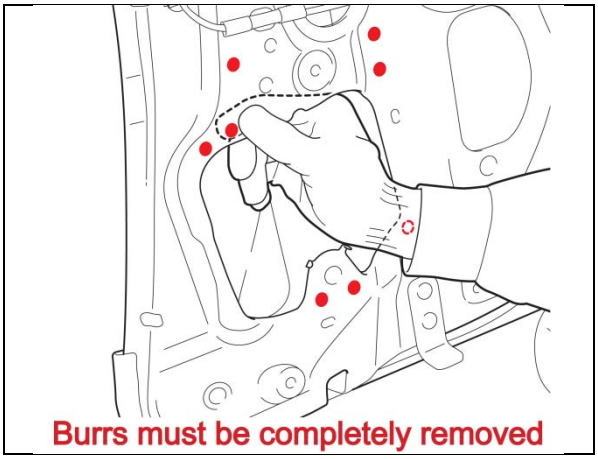


g) Remove any burrs from the back side of the drilled holes using the deburring tool.

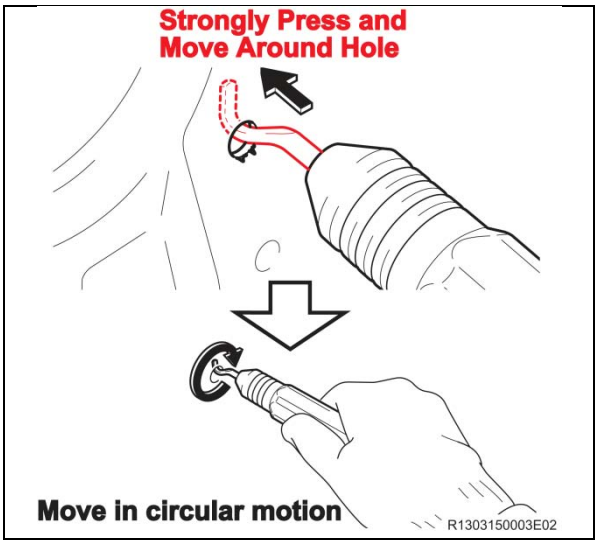
STOP

- **The burrs *MUST* be removed to ensure the panel is secured tightly with the rivets.**
- **Do not apply excessive force when using the deburring tool or the bit will fracture.**

1) Insert the tool into the hole.
2) Firmly press the blade against the edge of the hole.
3) Pull the blade towards yourself while moving it around the edge of the hole.



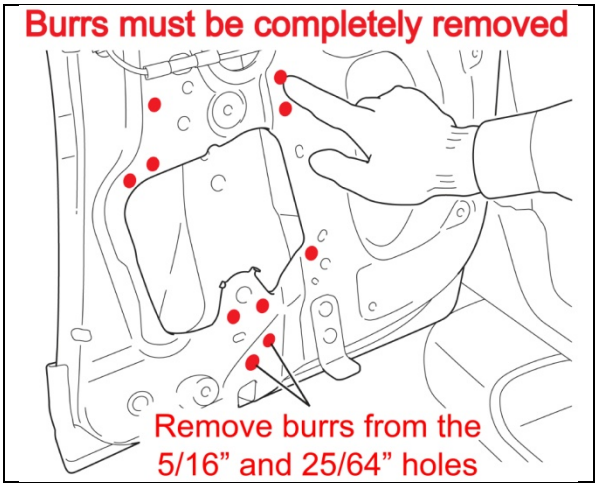
4) Confirm the burrs have been completely removed from the back side of the holes.



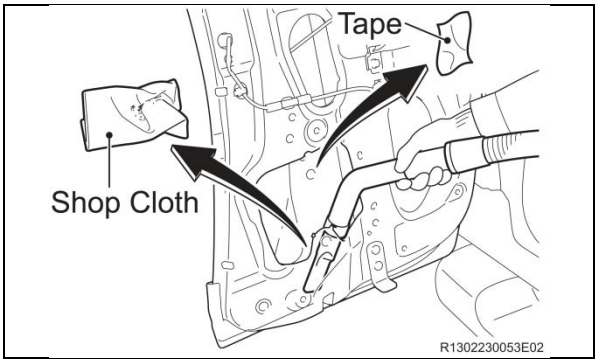
h) Remove any burrs from the front side of the drilled holes using the deburring tool.

STOP **The burrs *MUST* be removed to ensure the panel is secured tightly with the rivets.**

1) Insert the tool into the hole.
2) Firmly press the blade against the edge of the hole.
3) Push the blade towards the door panel while moving it around the edge of the hole.



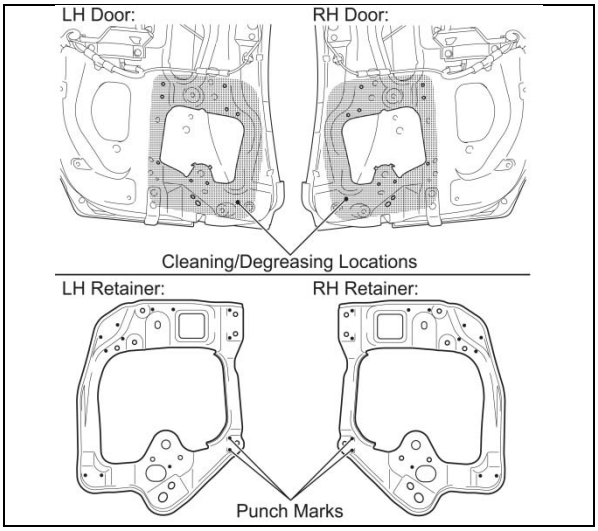
4) Confirm the burrs have been completely removed from the front side of the holes.



5. CLEAN UP THE SHAVINGS

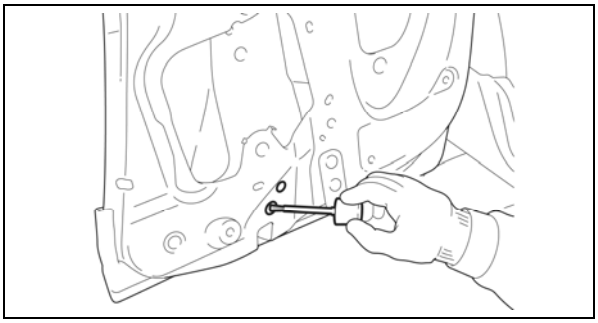
a) Remove the shop cloth and tape from the door panel.

b) Use a vacuum to remove any remaining shavings.



6. CLEAN / DEGREASE THE MATING SURFACES OF THE DOOR PANEL AND PANEL REINFORCEMENT

a) The surfaces must be clean to confirm the FIPG adheres properly.

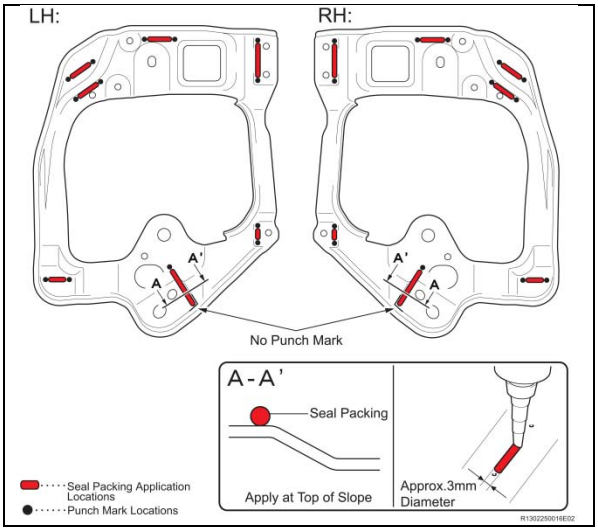


7. APPLY ANTI-RUST TREATMENT TO THE NUT PLATE INSTALLATION HOLES

a) Apply touch-up paint to the 2 nut plate installation holes.

NOTE:

- **Rivet installation holes do not require touch-up paint because FIPG will be used in later steps.**
- **If the paint on the access panel reinforcement mounting hole is peeling, apply touch-up paint to prevent rust formation.**



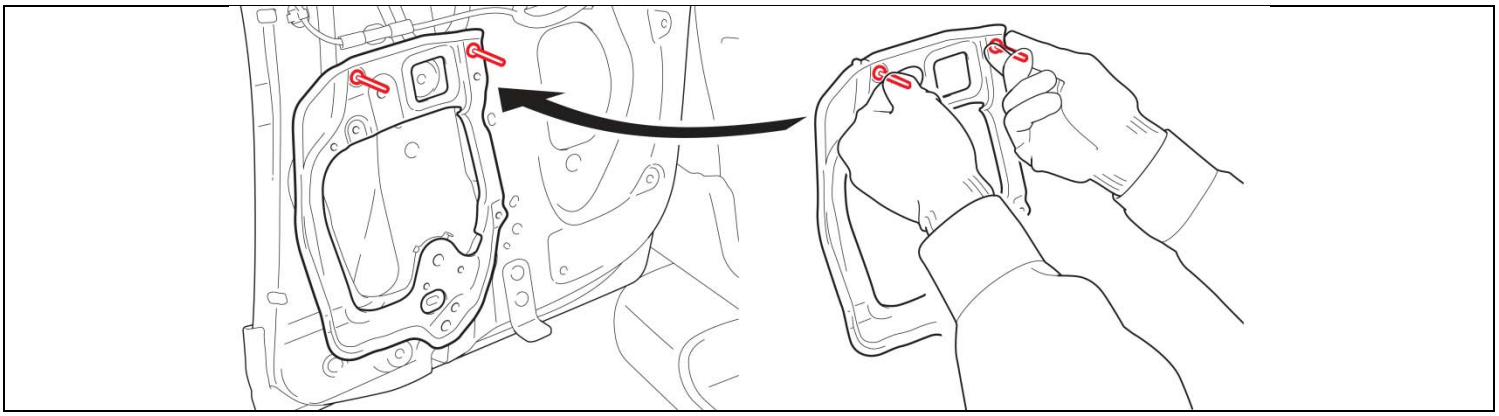
8. APPLY FIPG TO THE ACCESS PANEL REINFORCEMENT

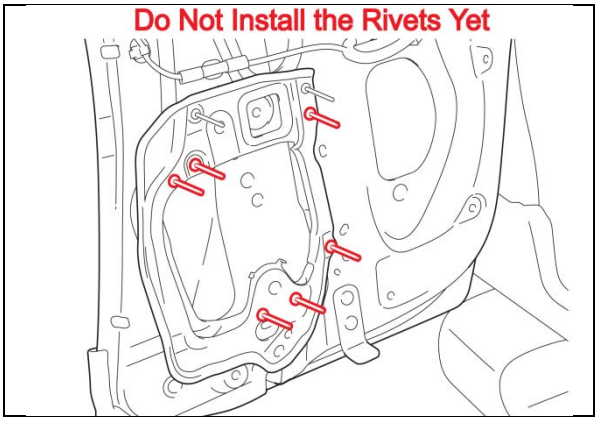
a) Apply approximately 3mm thick bead of FIPG to connect the punch marks together.

NOTE: There is one location on each panel that only has one punch mark, apply as shown in the illustration.

9. PLACE THE PANEL REINFORCEMENT

a) Set the upper right and left rivets in the reinforcement and place the reinforcement on the door.

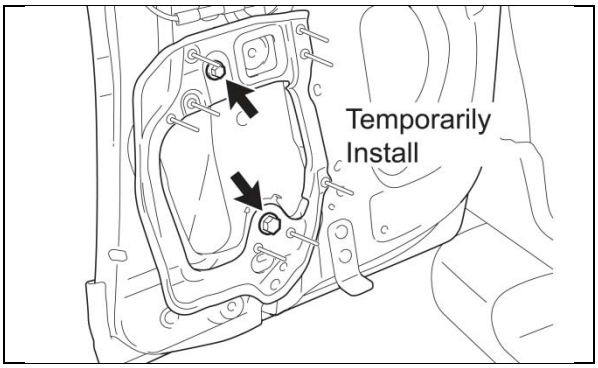




10. SET THE REMAINING RIVETS IN PLACE

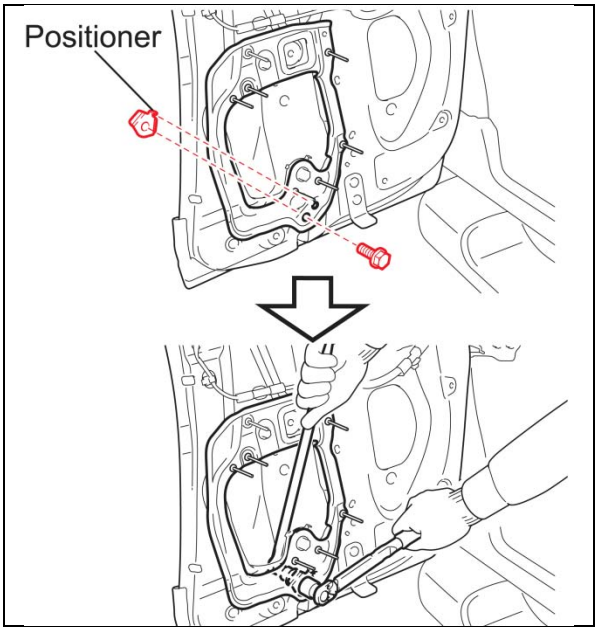
a) Set the remaining rivets in ***BY HAND ONLY.***

NOTE: 20 rivets are supplied in the kit, each panel requires 8 rivets.



b) Temporarily install the 2 bolts that were removed with the seatbelt.

- ***DO NOT* use a new upper bolt that is supplied in the kit in this step.**
- **Set all bolts and rivets in place prior to permanently installing the rivets to ensure correct alignment of the panel.**



c) Install the nut plate and bolt. Hold the nut plate with a wrench **(15mm)** when tightening the bolt.

Torque: 47ft. lbf (64N·m)

- **This is the final installation of the nut plate, confirm torque is applied correctly.**
- **Failure to hold the nut plate with a wrench when tightening will damage the nut plate.**

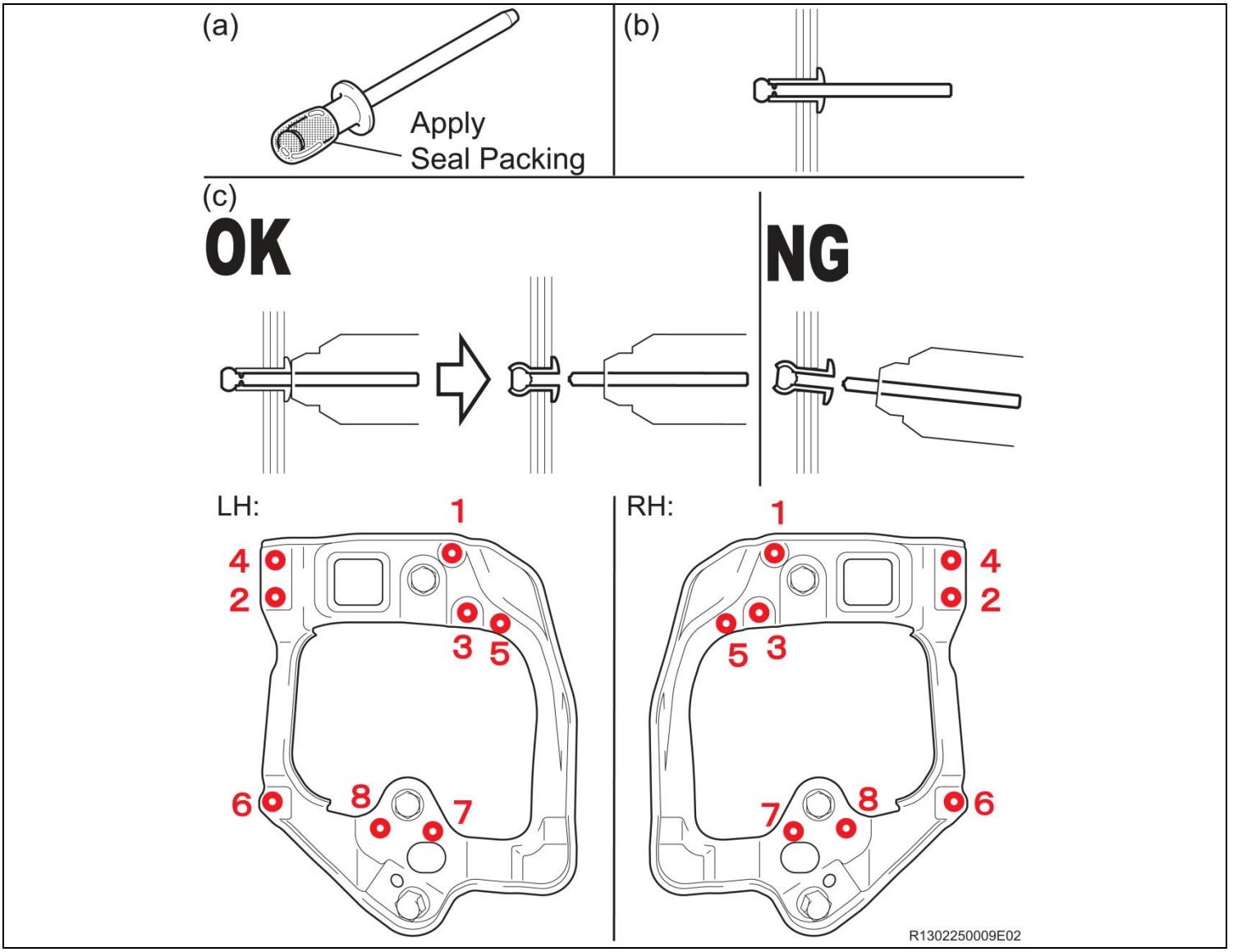
11. INSTALL THE RIVETS

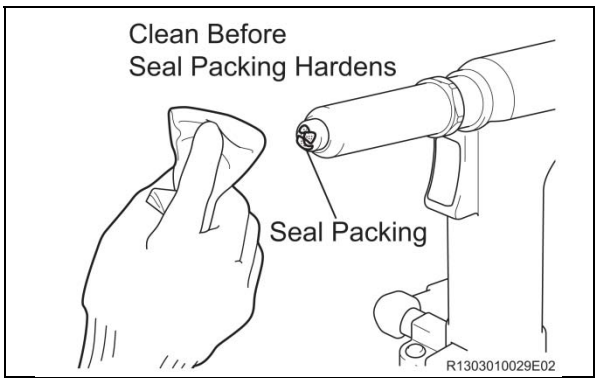
- **Perform steps a), b), c) one rivet at a time.**
- **The rivets *MUST* be installed in the order shown to confirm the panel is secured correctly.**
- **Failure to hold the riveter firmly and perpendicularly to the panel can result in gaps between the panel and door. If a rivet is installed incorrectly, a new rivet *MUST* be installed.**

a) Starting with number 1, remove the rivet and apply FIPG as shown.

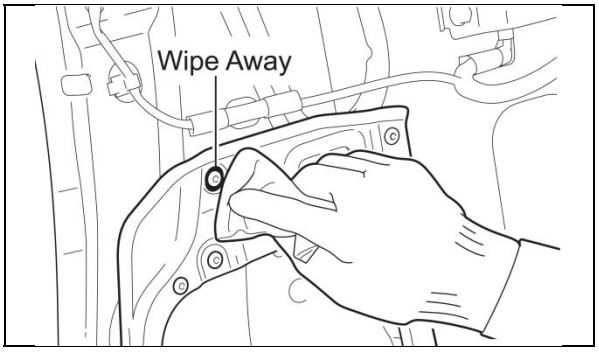
b) Place the rivet in the door panel.

c) Press the riveter firmly and perpendicularly against the panel, install the rivets in the order shown.



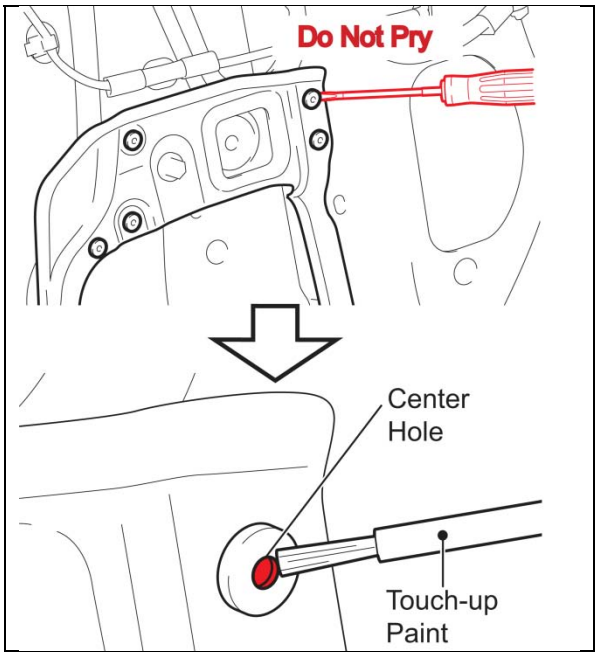


d) Clean any FIPG from the tip of the riveter before it hardens.



e) Wipe any excess FIPG from the rivets to prevent it from getting on the seatbelt.

STOP ***DO NOT*** **use brake cleaner, it can damage the FIPG seal.**



f) Confirm the installation of each rivet by pressing a flat-head screwdriver against all rivets.

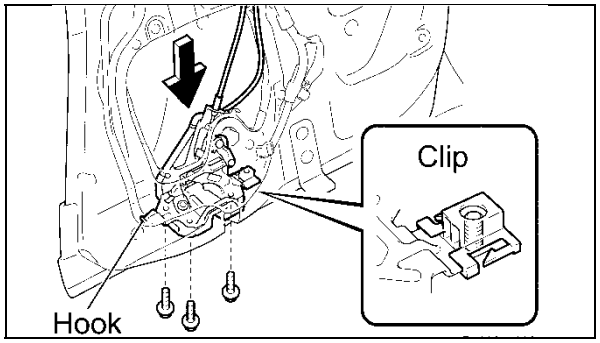
NOTE:

- ***DO NOT*** **pry on the rivet head, only press the screwdriver against the head to check for gaps.**
- **If any rivets are found to have been installed incorrectly, the rivet *MUST* be removed and a new rivet installed. Refer to APPENDIX SECTION XIII. for rivet removal instructions.**

g) Apply touch-up paint to the center of each rivet to indicate it has been checked and to prevent rust.

h) Confirm paint has been applied to all 8 rivets.

XII. INSTALL INTERIOR PARTS



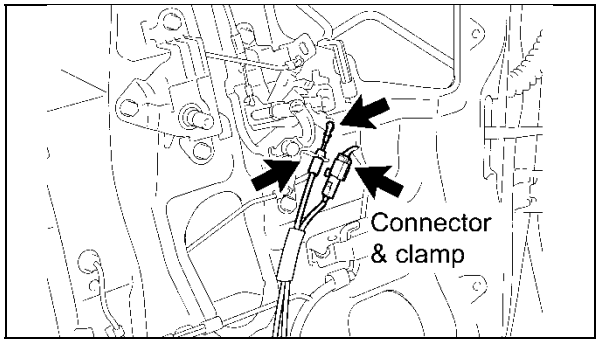
1. INSTALL THE LOWER ACCESS PANEL LOCK ASSEMBLY

a) Insert the hook on the lock assembly through the hole on the door panel and engage the clip on the stud.

NOTE: This clip is used as a positioner during the manufacturing process. If it is damaged there is no need to replace it, remove it and reinstall the lock assembly.

b) Install the lock with the 3 screws.

Torque: 44in. lbf (5N·m)

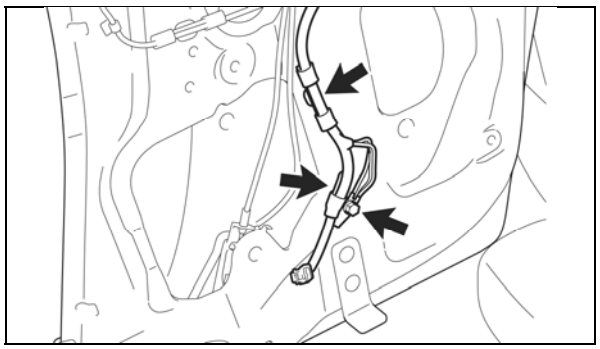


c) Connect the control cable.

d) Connect the clamp and connector.

2. INSTALL THE DOOR WIRE HARNESS

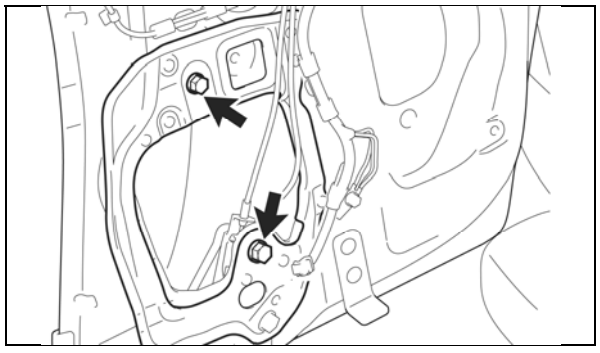
a) Confirm the harness is routed behind the control cable.



b) Engage the harness clamps.

c) Install the ground bolt.

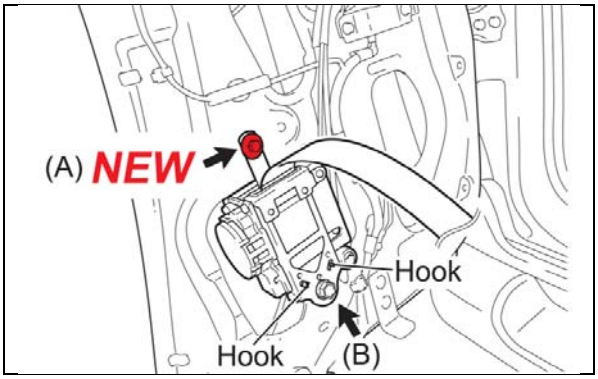
Torque: 71in. lbf (8N·m)



3. INSTALL THE FRONT SEAT OUTER BELT ASSEMBLY

If the seat belt was identified as requiring replacement during the inspection steps, a new seatbelt *MUST* be installed at this time.

a) Remove the 2 bolts and discard the upper bolt, a new upper bolt is provided in the kit.



b) Position the seatbelt so that the hooks on the door panel engage with the holes on the seatbelt bracket and loosely install the bolts.

c) Torque ***NEW*** bolt A.

Torque: 75in. lbf (8.5N·m)

d) Torque bolt B.

Torque: 31ft. lbf (42N·m)

4. INSTALL ALL REMAINING PARTS

Refer to TIS for instructions on front seat outer belt assembly installation

5. INSPECT THE SRS WARNING LIGHT

a) Turn the ignition switch on and check that the SRS warning light comes on for approximately six seconds. (primary check)

b) Check that the light goes off approximately six seconds after the ignition switch is turned on. (constant check)

NOTE: If the light remains on, the pretensioner connector may not have been properly connected.

6. INSPECT THE SEAT BELT ELR LOCK FUNCTION

a) Check that the seatbelt locks when it is pulled out quickly.

7. PERFORM SYSTEM INITIALIZATIONS

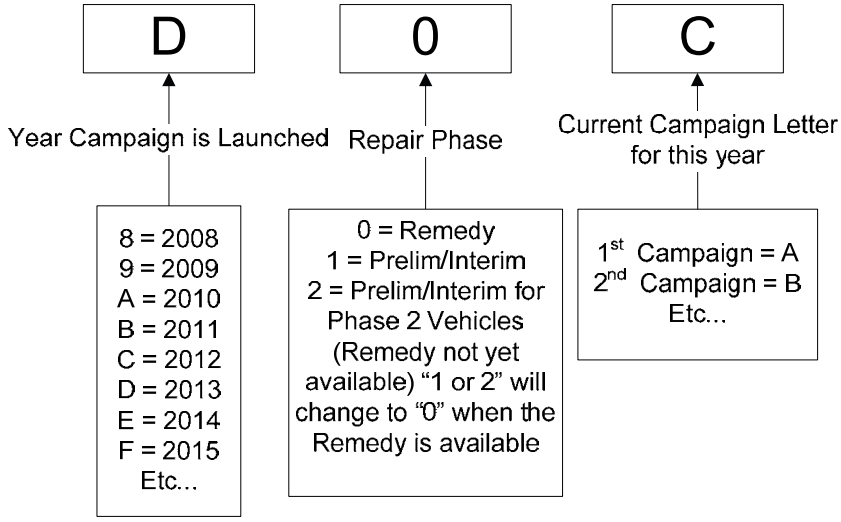
◄ VERIFY REPAIR QUALITY ►

- **Confirm the *UPPER* and *LOWER* inspections are performed correctly**
- **Confirm all holes are drilled accurately and deburred**
- **Confirm all metal shavings are cleaned from the door panel**
- **Confirm FIPG is applied in all locations on the reinforcement and on all rivets**

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

XIII. APPENDIX

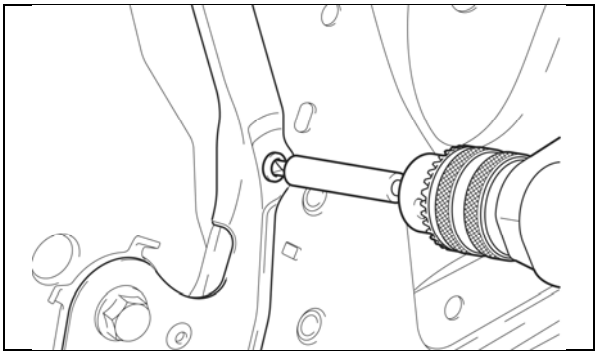
A. CAMPAIGN DESIGNATION DECODER



B. CAMPAIGN PARTS DISPOSAL

As required by Federal Regulations, please make sure all campaign 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.***

C. RIVET REMOVAL

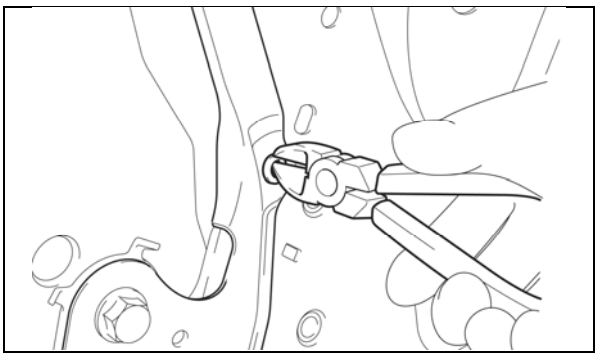


1. DRILL OUT THE CENTER OF THE RIVET

a) Drill out the center of the rivet using a 13/64” drill bit.

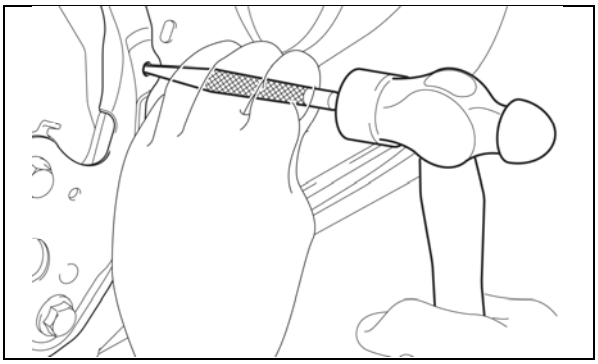
NOTE:

- **Apply protective materials to the door panel as described above in SECTION XI, STEP 2.**
- **It may be necessary to hold the back side of the rivet with pliers while drilling.**



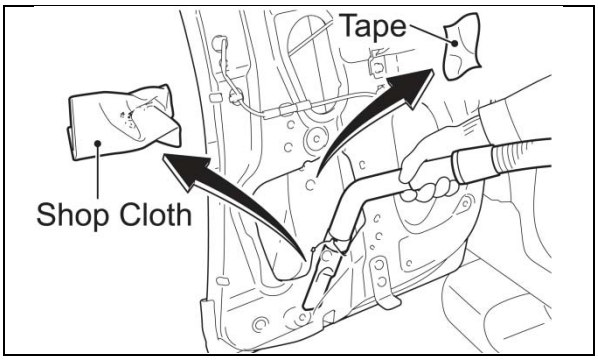
2. IF THE RIVET TURNS WITH THE DRILL BIT, CUT THE RIVET

a) Cut the rivet out if drilling is not effective.



3. PUNCH OUT THE RIVET

a) Once the head is removed, use a punch to remove the rivet.



4. CLEAN THE DOOR PANEL

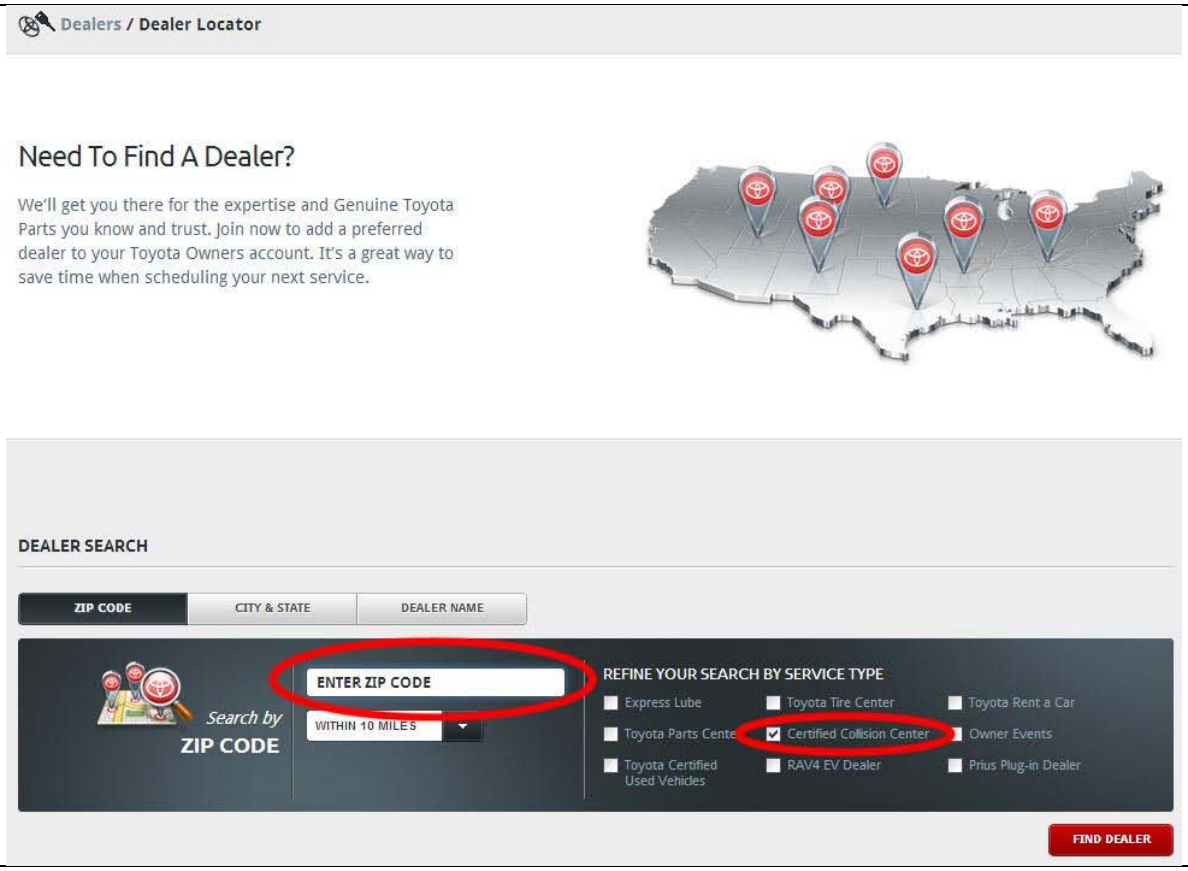
a) Remove the protective materials and clean up any remaining shavings.

D. ACCESS DOOR REPLACEMENT

1. REPLACE AND REFINISH THE DOOR

NOTE:

- **The door should be replaced and refinished by a Toyota Certified Collision Center (TCCC).**
- **To find a TCCC, refer to www.toyota.com**



PARTS FOR LH ACCESS DOOR

Part Number	Part Description	Qty	Note
67004-35222	Rear Door Panel Sub Assy. LH	1	
68104-	Glass Sub Assy., Rear Door, LH (Privacy-35082) / (Green-35092)	1	
68164-35041	Weatherstrip, Rear Door Glass, Outer LH	1	
75076-35162	Moulding Sub Assy., Rear Door, Outside LH	1	
67872-35073	Weatherstrip, Access Panel, LH	1	
75932-35010	Tape, Black Out, Outer Upper LH	1	
75934-35010	Tape, Black Out, Outer Front LH	1	
75936-35010	Tape, Black Out, Outer Rear LH	1	
04003-14835	Belt Assy, Outer LH	1	2007-2009 MY
04003-13535	Belt Assy, Outer LH	1	2010 MY
04003-13935	Belt Assy, Outer LH	1	2011-2013 MY
42661-35710	Tire Pressure Information Label	1	For 16" Wheel, 2007-2009 MY
42661-35711	Tire Pressure Information Label		For 16" Wheel, 2010-2013 MY
42661-35680	Tire Pressure Information Label		For 17" Wheel, 2007-2009 MY
42661-35681	Tire Pressure Information Label		For 17" Wheel, 2010-2013 MY
See note	Certification Label	1	This label is manufactured by the Quality Compliance group. Refer to T-SB-0144-08
01007-FMVSS Order through the MDC	Addendum Label	See note	This label is only needed if the old door has an addendum label applied.

PARTS FOR RH ACCESS DOOR

Part Number	Part Description	Qty	Note
67003-35222	Rear Door Panel Sub Assy. RH	1	
68103-	Glass Sub Assy., Rear Door, RH (Privacy-35082) / (Green-35092)	1	
68163-35041	Weatherstrip, Rear Door Glass, Outer RH	1	
75075-35162	Moulding Sub Assy., Rear Door, Outside RH	1	
67871-35073	Weatherstrip, Access Panel, RH	1	
75931-35010	Tape, Black Out, Outer Upper RH	1	
75933-35010	Tape, Black Out, Outer Front RH	1	
75935-35010	Tape, Black Out, Outer Rear RH	1	
04003-13235	Belt Assy, Outer RH	1	2007-2009 MY
04003-13635	Belt Assy, Outer RH	1	2010 MY
04003-14935	Belt Assy, Outer RH	1	2011-2013 MY

NOTE:

- **There are no labels that require replacement on the RH door.**
- **The anti-theft VIN label that is on both LH and RH doors is not available for replacement doors.**

All door replacement parts will be placed on MAC, refer to the dealer letter for details.