

# TECHNICAL INSTRUCTIONS

FOR

SAFETY RECALL K0G

POTENTIAL UNINTENDED OR NON-DEPLOYMENT OF PASSENGER SIDE  
FRONT SEAT AND CURTAIN SHIELD AIRBAGS

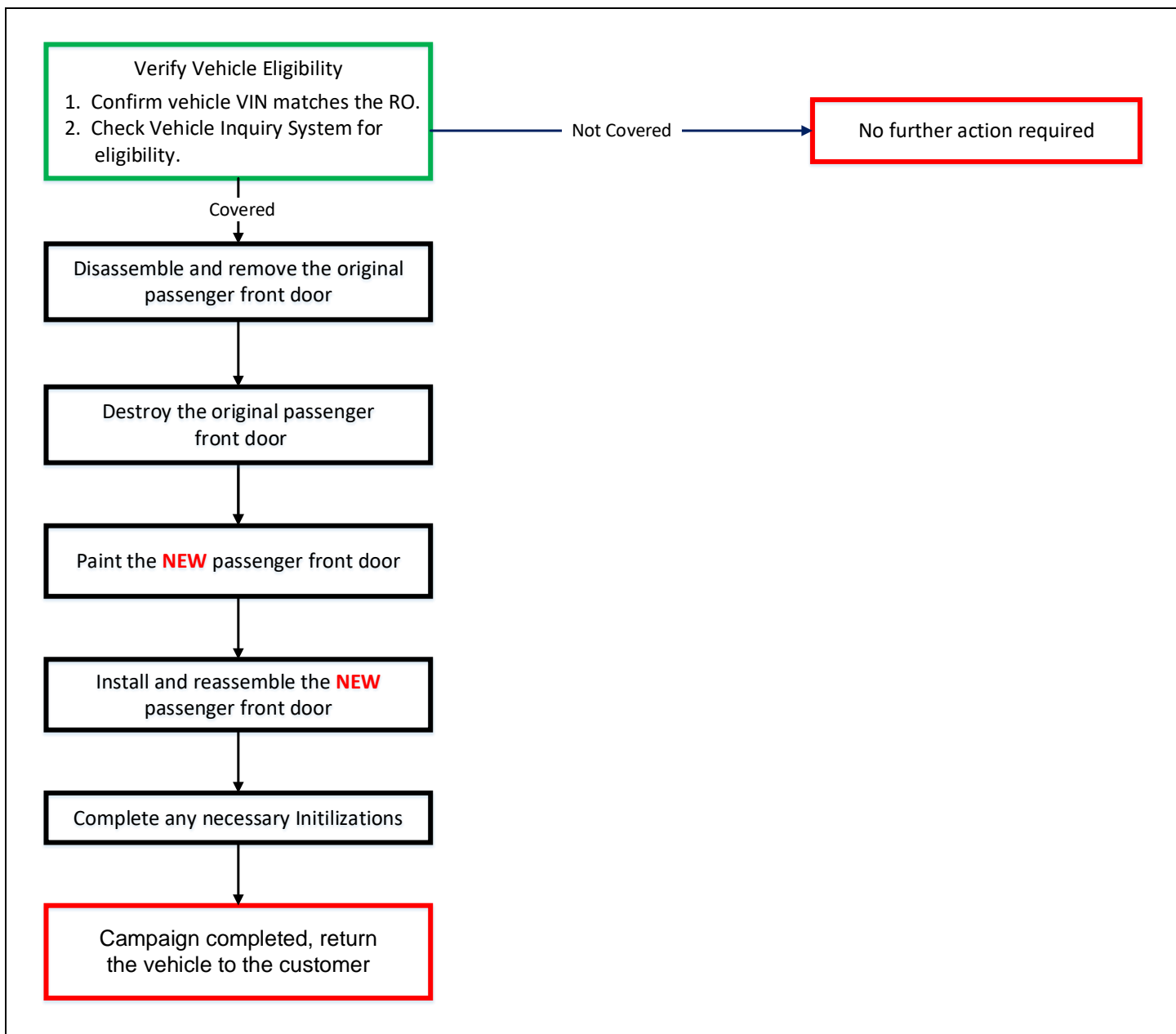
CERTAIN 2019 SIENNA

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 specialty)
- Expert Technician (any specialty)
- 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

### 1. CHECK VEHICLE FOR CAMPAIGN ELIGIBILITY

- a. Compare the vehicles VIN to the VIN listed on the Repair Order to ensure they match.
- b. Check the TIS Vehicle Inquiry System to confirm the VIN is involved in this Campaign, and that it has not already been completed.

Note: TMNA warranty will not reimburse dealers for repairs completed on vehicles that are not affected or were previously completed, even by another dealer.

## III. PREPARATION

### A. PARTS

Parts required for each vehicle:

Part Number	Part Description	Quantity
67001-08070	PANEL SUB-ASSY, FRONT DOOR, RH	1
04003-49233	BUTYL TAPE	1
68160-08020	FRONT DOOR GLASS OUTER WEATHERSTRIP ASSEMBLY	1
67831-08020	FRONT DOOR SERVICE HOLE COVER	1
75968-08010	TAPE, BLACK OUT FRONT DOOR, INNER REAR RH	1
75957-08010	TAPE, BLACK OUT FRONT DOOR, OUTER REAR RH	1
75955-08010	TAPE, BLACK OUT FRONT DOOR, OUTER UPPER RH	1
75929-08010	TAPE, BLACK OUT FRONT DOOR, INNER UPPER RH	1
90189-05003	GROMMET, SCREW (Inside Handle)	1
90901-89021	GROMMET, SCREW (Arm rest)	1
90189-04200	GROMMET, SCREW (Door Panel)	1
90189-06227	GROMMET, SCREW (Speaker)	4
67663-08010	DOOR FRAME GARNISH	1
69318-AA010	DOOR LOCK WIRE HARNESS SEAL	1
82711-1E360	CLAMP, WIRING HARNESS	1

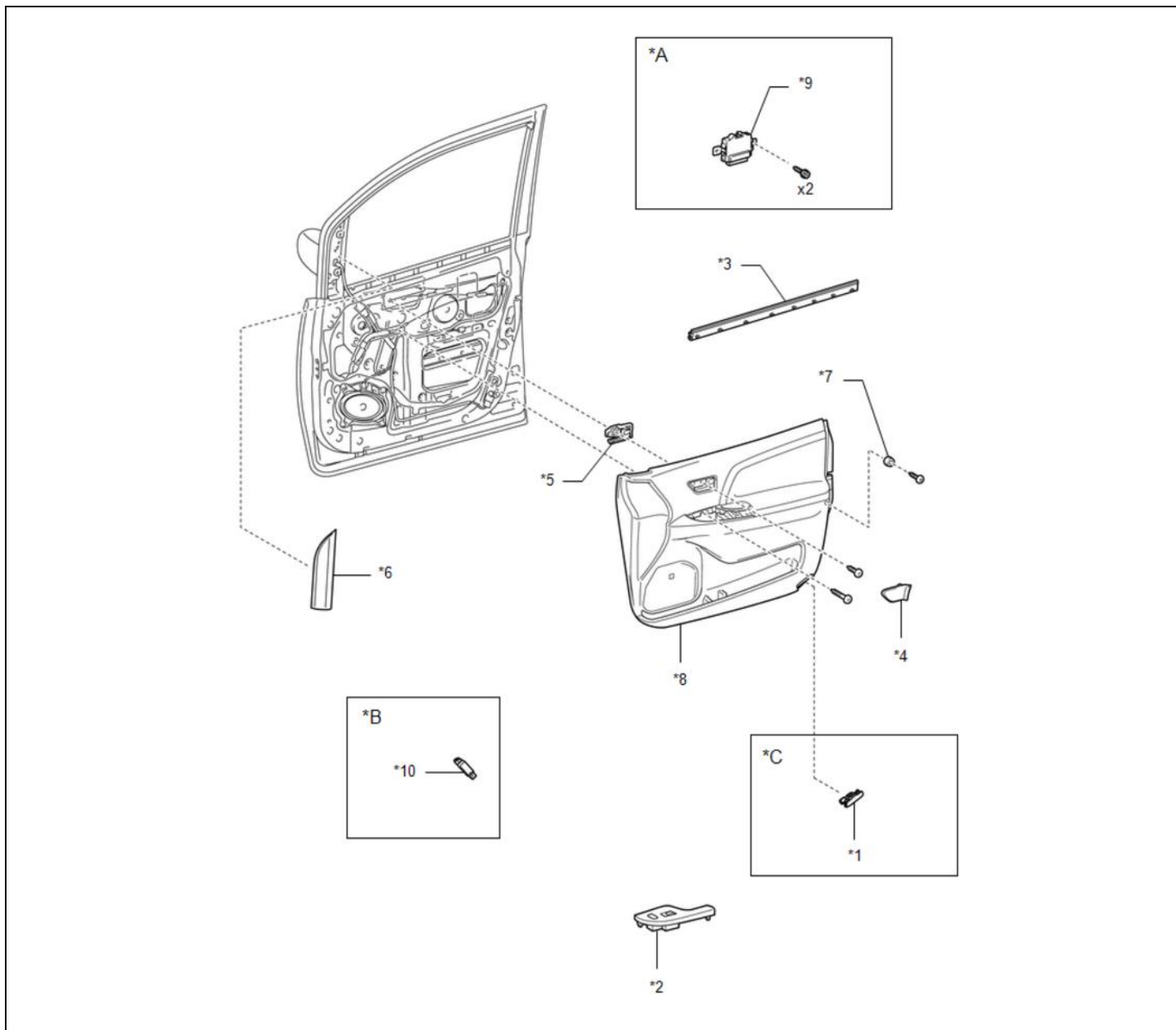
Parts that may be needed for some vehicles:

Part Number	Part Description	Quantity
90084-10049	Non-shoulder, hinge bolts for adjustment	4
PT29A-08100	Door Moulding (Bright Chrome) – trim level	1

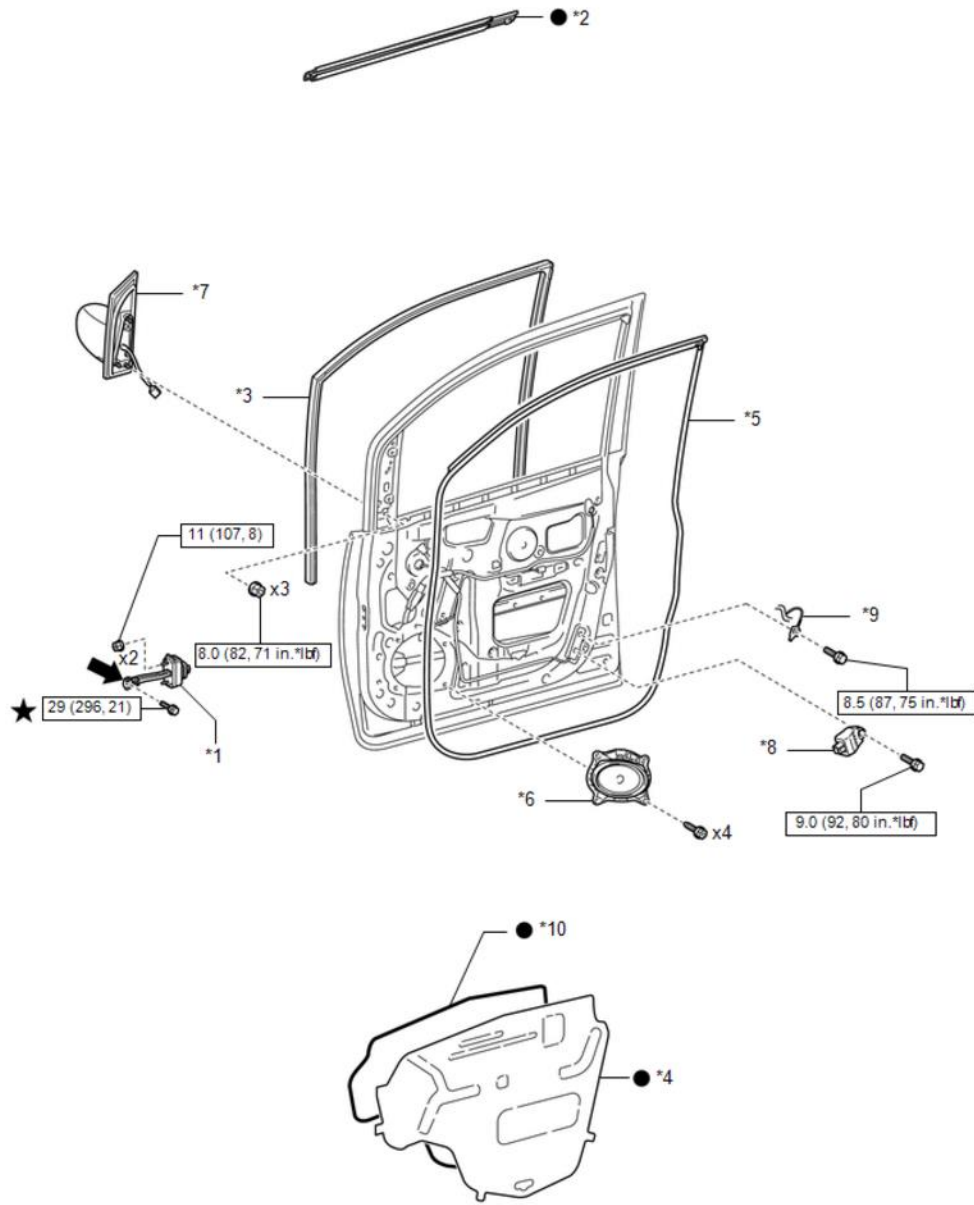
## IV. BACKGROUND

During the manufacturing process of the passenger side front doors, it is possible that a component may not have been welded properly. This could affect an airbag system sensor and lead to nondeployment or inadvertent deployment of the passenger side front seat and curtain shield airbags. This can increase the risk of a crash or injury in the event of a crash.

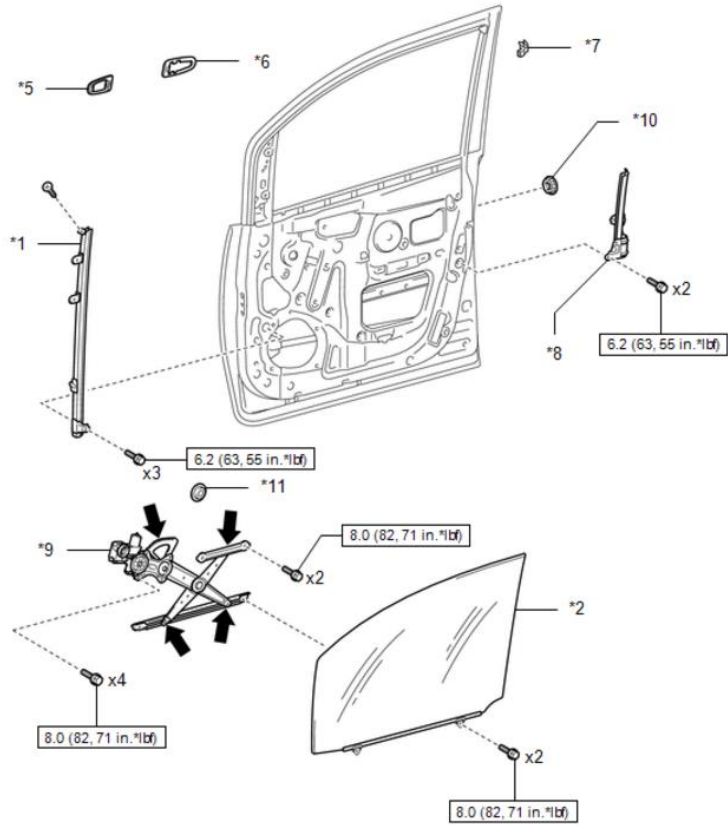
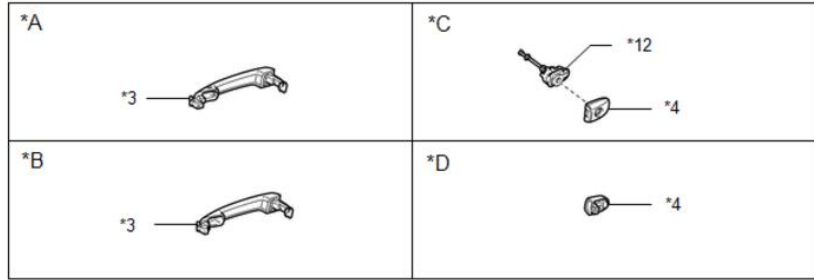
## V. COMPONENTS





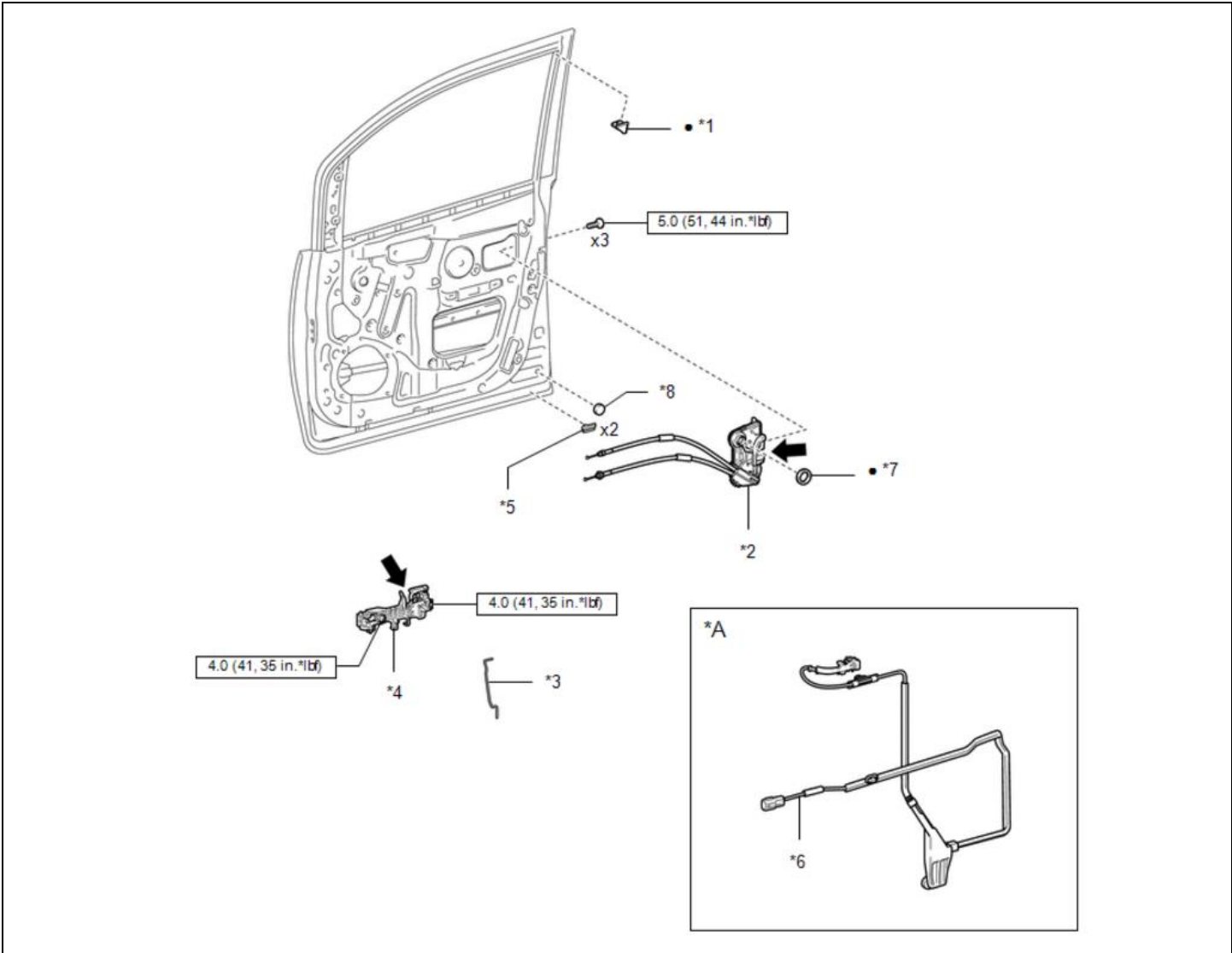
*A	w/ Memory	*B	for Driver Side with Memory
*C	for Courtesy Light	-	-
*1	COURTESY LIGHT ASSEMBLY	*2	FRONT DOOR ARMREST BASE PANEL ASSEMBLY
*3	FRONT DOOR GLASS INNER WEATHERSTRIP	*4	FRONT DOOR INSIDE HANDLE BEZEL PLUG
*5	FRONT DOOR INSIDE HANDLE SUB-ASSEMBLY	*6	FRONT DOOR LOWER FRAME BRACKET GARNISH
*7	FRONT DOOR NO. 1 STIFFENER CUSHION	*8	FRONT DOOR TRIM BOARD SUB-ASSEMBLY
*9	OUTER MIRROR CONTROL ECU ASSEMBLY	*10	SEAT MEMORY SWITCH



*1	FRONT DOOR CHECK ASSEMBLY	*2	FRONT DOOR GLASS OUTER WEATHERSTRIP ASSEMBLY
*3	FRONT DOOR GLASS RUN	*4	FRONT DOOR SERVICE HOLE COVER
*5	FRONT DOOR WEATHERSTRIP	*6	FRONT NO. 1 SPEAKER ASSEMBLY
*7	OUTER REAR VIEW MIRROR ASSEMBLY	*8	SIDE AIRBAG SENSOR
*9	GROUND WIRE	*10	BUTYL TAPE
	N*m (kgf*cm, ft.*lbf): Specified torque	•	Non-reusable part
	MP grease	★	Precoated part



*A	w/ Smart Entry and Start System	*B	w/o Smart Entry and Start System
*C	for Driver Side	*D	for Front Passenger Side
*1	FRONT DOOR FRONT LOWER FRAME SUB-ASSEMBLY	*2	FRONT DOOR GLASS SUB-ASSEMBLY
*3	FRONT DOOR OUTSIDE HANDLE ASSEMBLY	*4	FRONT DOOR OUTSIDE HANDLE COVER
*5	FRONT DOOR OUTSIDE HANDLE FRONT PAD	*6	FRONT DOOR OUTSIDE HANDLE REAR PAD
*7	FRONT DOOR PANEL PROTECTOR	*8	FRONT DOOR REAR LOWER FRAME SUB-ASSEMBLY
*9	FRONT DOOR WINDOW REGULATOR SUB-ASSEMBLY	*10	HOLE PLUG
*11	SERVICE HOLE COVER	*12	LOCK CYLINDER
	N*m (kgf*cm, ft.*lbf): Specified torque		MP grease



*A	w/ Smart Entry and Start System	-	-
*1	DOOR FRAME GARNISH	*2	FRONT DOOR LOCK ASSEMBLY
*3	FRONT DOOR LOCK OPEN ROD	*4	FRONT DOOR OUTSIDE HANDLE FRAME SUB-ASSEMBLY
*5	FRONT DOOR VENT SEAL	*6	FRONT DOOR WIRE
*7	DOOR LOCK WIRE HARNESS SEAL	*8	CUSHION
	N*m (kgf*cm, ft.*lbf): Specified torque	•	Non-reusable part
	MP grease	-	-

## VI. DISASSEMBLY AND REMOVAL

### 1. DISASSEMBLE THE ORIGINAL PASSENGER FRONT DOOR

- a. Follow the Repair Manual instructions to remove the components from the original passenger side front door. These parts will be reused, so be careful during disassembly.

[DOOR / HATCH: FRONT DOOR: DISASSEMBLY; 2018 - 2020 MY Sienna](#)  
(RM1000000018DTB)

- b. Remove the door handle nut from the original door, as it will be reused. The nut will slide forward to be removed.



- c. Pull the wire harness through the door. It is not necessary to pull the harness through the A-pillar.

### 2. REMOVE ORIGINAL DOOR

- a. Unbolt the door from the hinges.

### 3. DESTROY THE ORIGINAL DOOR

- a. Using a large hammer, damage the hinge area of the original door to ensure that this door cannot be reused again.

## VII. INSTALLATION AND ADJUSTMENT

### 1. PAINT NEW DOOR

- a. Properly paint the **NEW** door.

### 2. INSTALL NEW DOOR

- a. Install the **NEW** door onto the vehicle.
- b. Properly adjust the **NEW** door using the procedure detailed in the Repair Manual.

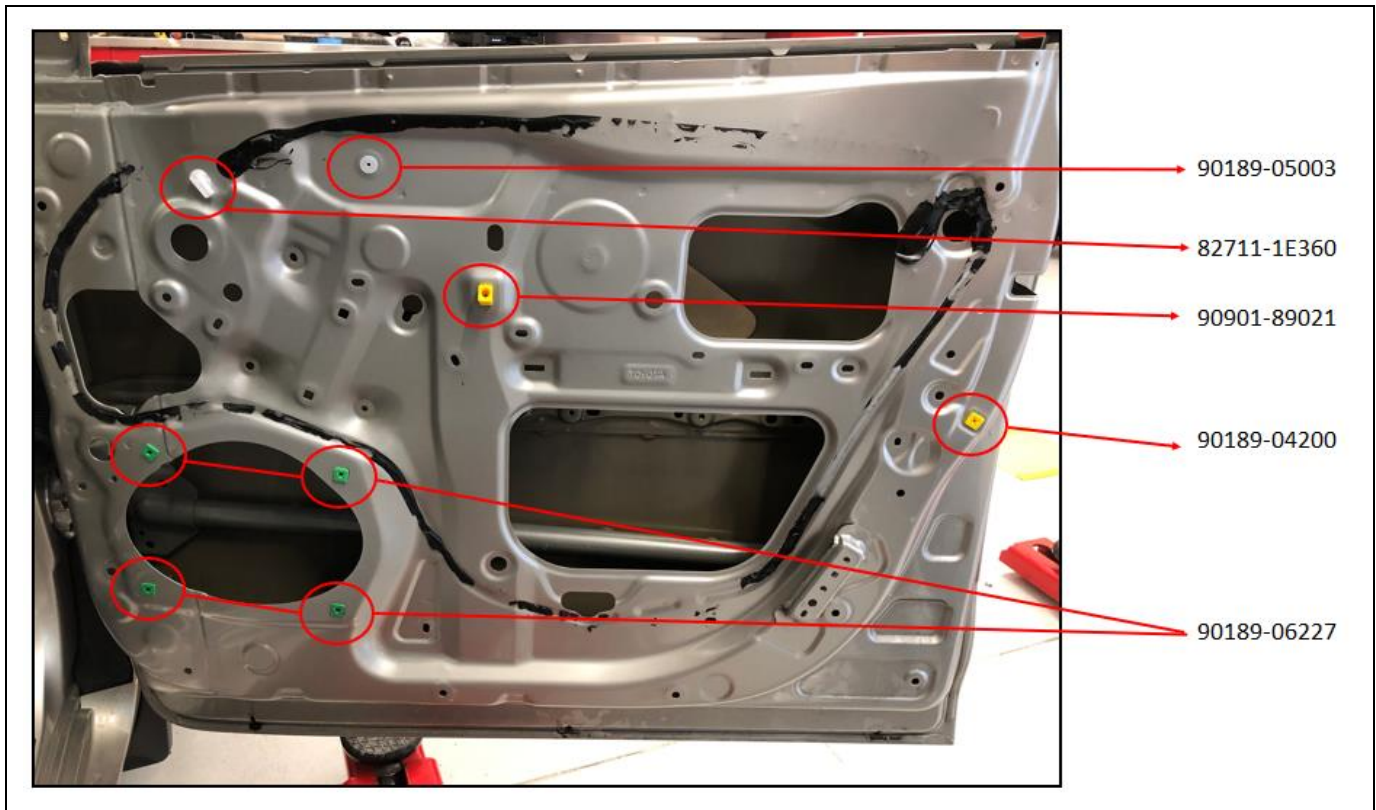
[DOOR / HATCH: FRONT DOOR: ADJUSTMENT; 2016 - 2020 MY Sienna](#)  
(RM100000000VK8E)



## VIII. REASSEMBLY

### 1. REASSEMBLE THE NEW PASSENGER SIDE FRONT DOOR

a. Install the **NEW** plastic clips as detailed in the diagram below.



b. Push the wire harness into the **NEW** door.

c. Install the door handle nut into the **NEW** door, as removed in step VI. 1b on page 8.

d. Follow the Repair Manual procedure to reassemble the **NEW** door.

[DOOR / HATCH: FRONT DOOR: REASSEMBLY; 2018 - 2020 MY Sienna](#)  
(RM1000000018DTF)

e. If originally equipped, install a **NEW** door moulding.

## IX. INITIALIZATIONS

### 1. COMPLETE NECESSARY INITIALIZATIONS

a. Follow the Repair Manual complete any necessary initializations.

[INTRODUCTION: REPAIR INSTRUCTION: INITIALIZATION; 2018 - 2020 MY Sienna](#)  
(RM1000000018R4B)

## ◀ VERIFY REPAIR QUALITY ▶

- Confirm the new door is properly adjusted.
- Confirm the window and door locks work properly.
- Confirm the original door has been properly destroyed.

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

### X. 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

