

TECHNICAL INSTRUCTIONS

FOR

SAFETY RECALL 20TA13

HEADLAMP ADJUSTMENT PLUGS INSTALLED IN INCORRECT LOCATIONS

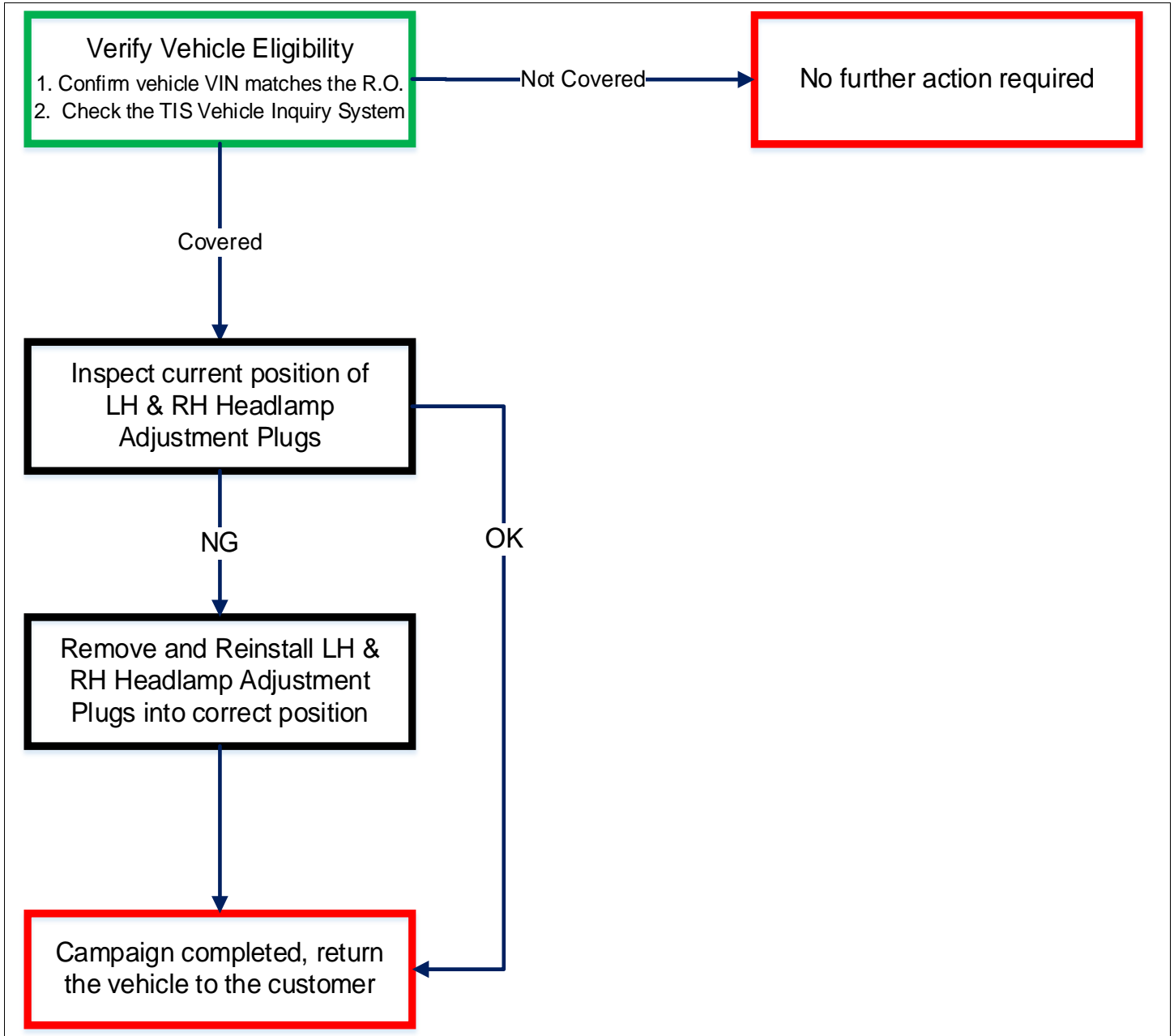
CERTAIN 2020 SUPRA

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

1. TOOLS & EQUIPMENT

- Flathead Screwdriver
- Trim tool

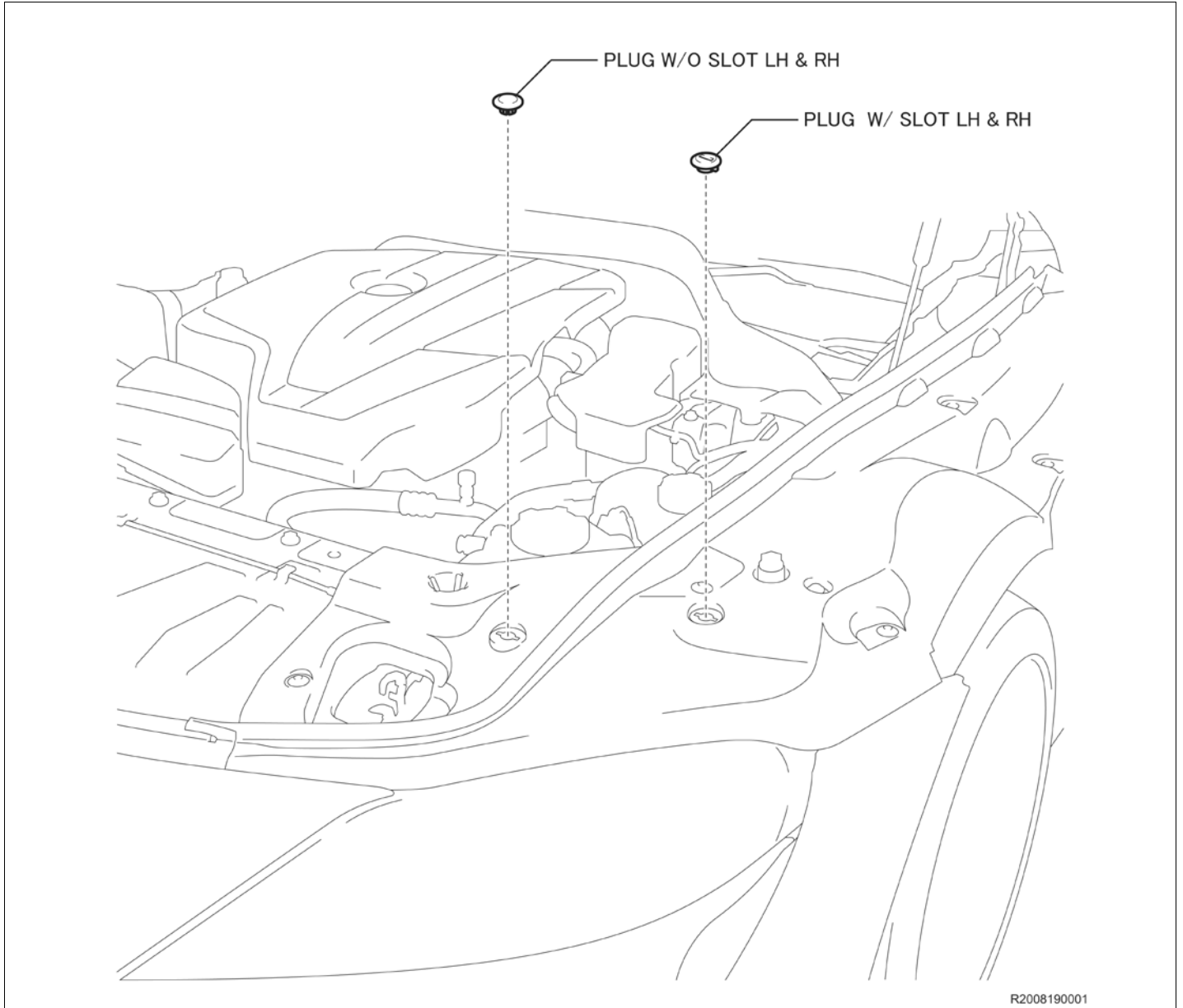
2. MATERIALS

- Protective Tape
- Protective Eyewear

IV. BACKGROUND

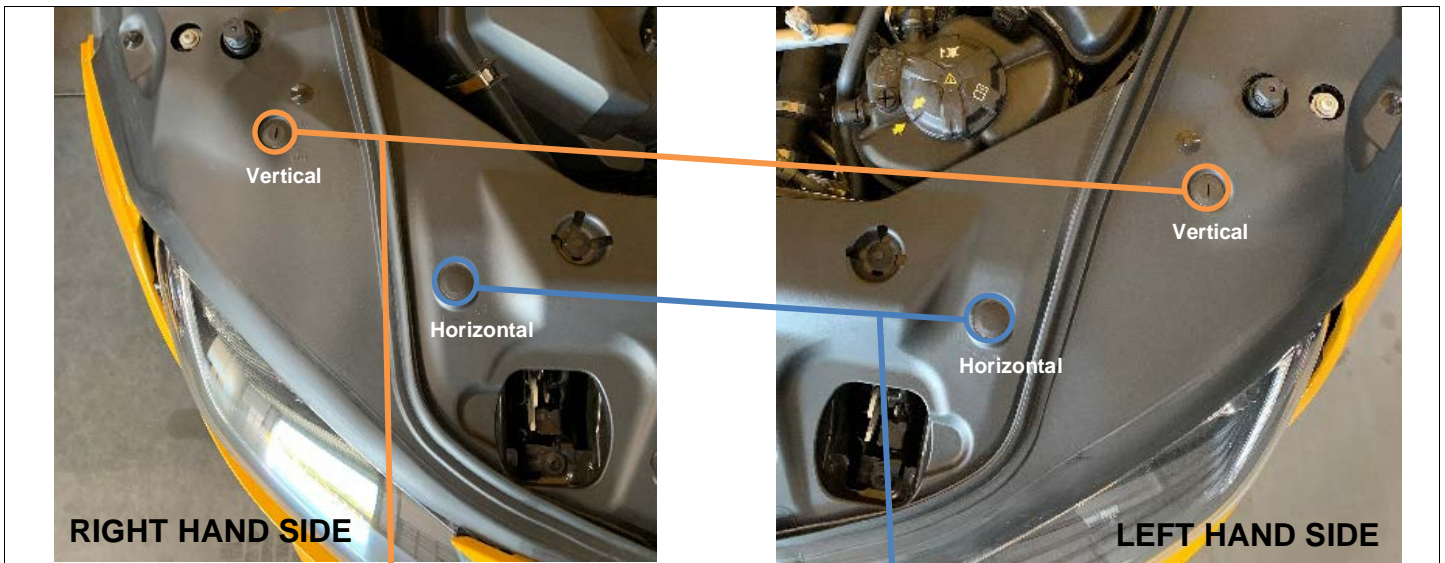
The plug which covers the headlamp's horizontal adjustment mechanism may have been inserted into the space for the vertical plug, and vice-versa. This can enable horizontal adjustment of the headlamp beam and may not meet a Federal requirement.

V. COMPONENTS



Left side of vehicle shown

VI. CONFIRM CURRENT POSITION OF PLUGS



VERTICAL ADJUSTMENT PLUG	
GOOD	NOT GOOD
Plug <i>WITH</i> slot	Plug <i>WITHOUT</i> slot

HORIZONTAL ADJUSTMENT PLUG	
GOOD	NOT GOOD
Plug <i>WITHOUT</i> slot	Plug <i>WITH</i> slot

1. CONFIRM THE LH & RH PLUGS ARE INSTALLED IN THE CORRECT LOCATIONS

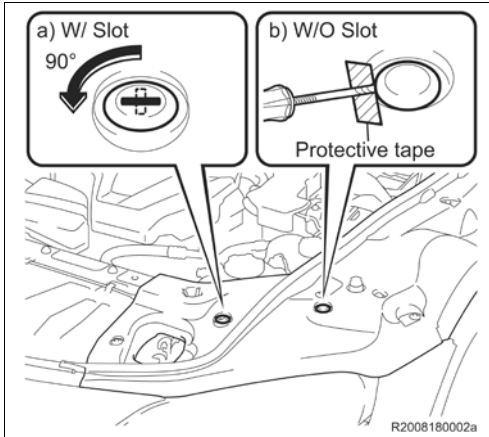
- a. The vertical adjustment plugs should have a slot. The horizontal adjustment plugs should not have a slot.

Are the plugs installed in the correct locations?

YES – No further action required. Campaign complete.

NO – Proceed to section VII.

VII. INSTALL THE HEADLIGHT ADJUSTMENT PLUGS IN CORRECT LOCATIONS

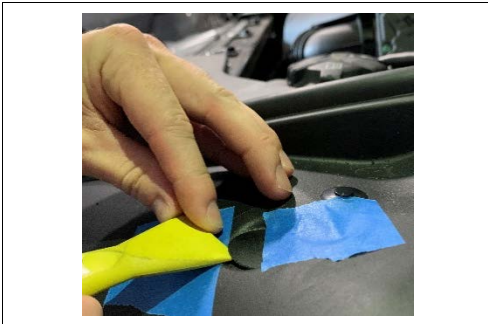


1. REMOVE PLUGS WITH SLOT

- Using a screwdriver, turn the slotted plug 90 degrees counterclockwise.

NOTE:

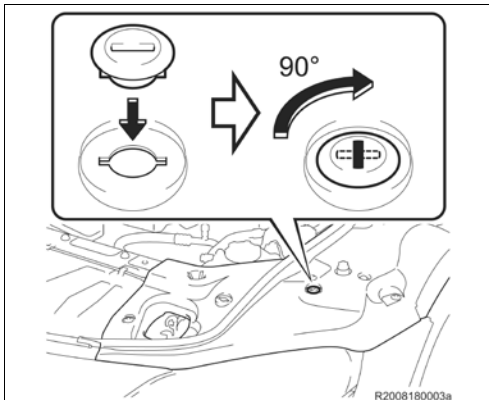
- Make sure the screwdriver is fully inserted before turning the plug
- DO NOT damage the plugs and surrounding parts



2. REMOVE PLUGS WITHOUT SLOT

- Apply protective tape in front of the plug.
- Apply tape on top of the plug to prevent it from falling into the engine bay.
- Insert the trim tool underneath the plug and pry upwards.

NOTE: DO NOT damage the plugs and surrounding parts.

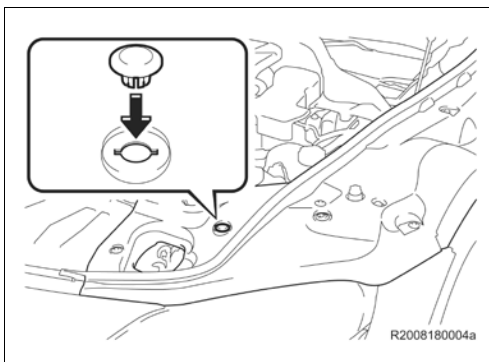


3. INSTALL PLUGS WITH SLOT

- Insert the plug in the **outboard hole** (vertical adjustment) and rotate 90 degrees clockwise.



Make sure you installed the plug with slot in the outboard hole.



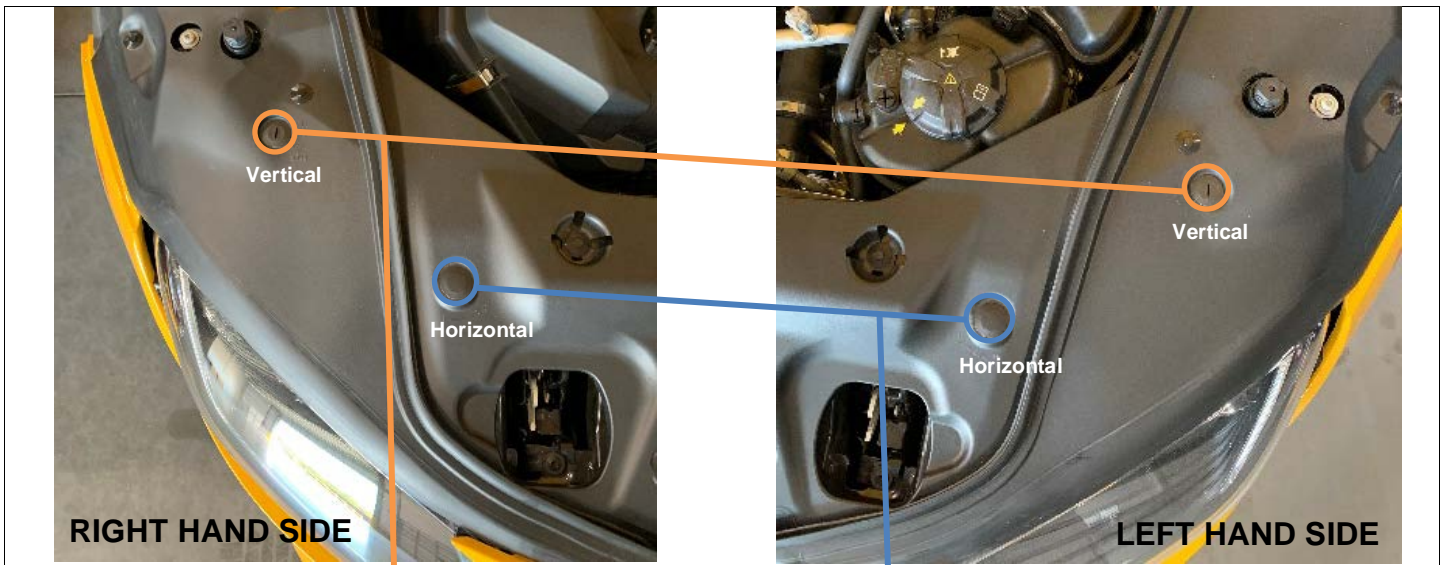
4. INSTALL THE PLUGS WITHOUT SLOT

- Insert the plug in the **inboard hole** (horizontal adjustment) and press in firmly.



Make sure you installed the plug without slot in the inboard hole.

VIII. CONFIRM REPAIR



VERTICAL ADJUSTMENT PLUG	
GOOD	NOT GOOD
Plug <i>WITH</i> slot	Plug <i>WITHOUT</i> slot

HORIZONTAL ADJUSTMENT PLUG	
GOOD	NOT GOOD
Plug <i>WITHOUT</i> slot	Plug <i>WITH</i> slot

1. CONFIRM THE LH & RH PLUGS ARE INSTALLED IN THE CORRECT LOCATIONS

- b. The vertical adjustment plugs should have a slot. The horizontal adjustment plugs should not have a slot.

Are the plugs installed in the correct locations?

YES – No further action required. Campaign complete.

NO – Return to section VII.

◀ VERIFY REPAIR QUALITY ▶

- Confirm that all four plugs are fully seated
- Confirm there is no damage on the plugs and any of the parts surrounding them

IX. APPENDIX

A. CAMPAIGN DESIGNATION DECORDER

19TA01

19

Year Campaign
is Launched

19 = 2019
20 = 2020
21 = 2021
22 = 2022
23 = 2023
Etc...

T

Vehicle Make

T = Toyota
L = Lexus

A

Field Action Category and Phase

A = Safety Recall Remedy
B = Safety Recall Interim
C = Special Service Campaign
D = Limited Service Campaign
E = Customer Support Program
F = Emissions Recall
(May use other characters in unique cases)

01

Field Action Sequence

01 = 1st Field Action of the year
02 = 2nd Field Action of the year
03 = 3rd Field Action of the year
(The sequence is unique for each Field Action category)
(May use other characters in unique cases)

Examples:

19TA01 = Launched in 2019, Toyota, Safety Recall Remedy Phase, 1st Safety Recall Launched in 2019
20TC02 = Launched in 2020, Special Service Campaign, 2nd Special Service Campaign Launched in 2020
21TE05 = Launched in 2021, Customer Support Program, 5th Customer Support Program Launched in 2021