

Headlamp Assembly Appearance Concern

Service Category Vehicle Exterior

Section Lighting (ext)

Market USA

Toyota Supports
 ASE Certification 

Applicability

YEAR(S)	MODEL(S)	ADDITIONAL INFORMATION
2005 – 2011	Tacoma	

REVISION NOTICE

April 10, 2014 Rev1:

- The Introduction and the Repair Procedure sections have been updated.

Any previous printed versions of this bulletin should be discarded.

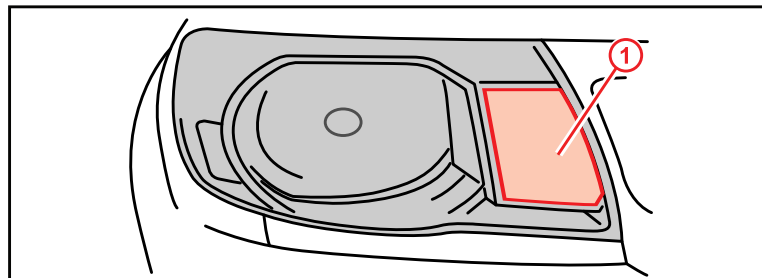
Introduction

Some 2005 – 2011 model year Tacoma vehicles may experience a condition where the inner Daytime Running Light (DRL)/turn signal lens becomes distorted and bubbled in appearance. In addition, the inner lens may appear cracked or separated. Updated Headlamp Assemblies have been developed to address this condition. The updated Headlamp Assemblies have cosmetic changes, so it is recommended to replace both the left and right assemblies together.

NOTE

This condition should NOT be confused with normal yellow-orange color that occurs over time as the inner lens ages. Additionally this Service Bulletin does NOT address conditions with the outer headlamp lens.

Figure 1.



1	Appearance Concern Area in DRL/Turn Signal Lens
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Headlamp Assembly Appearance Concern

Warranty Information

OP CODE	DESCRIPTION	TIME	OFF	T1	T2
BD1120	R & R Headlamp Assembly (Both Sides)	2.2	81110-04163	99	13
Combo A	Headlamp Adjust (Both Sides)	0.3	81150-04163 81110-04173 81150-04173		

APPLICABLE WARRANTY

- This repair is covered under the Toyota Comprehensive 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		
81110-04163	81110-04200	Headlamp Assy, RH	1
81150-04163	81150-04200	Headlamp Assy, LH	1
81110-04173	81110-04210*	Headlamp Assy, RH (Sport/Off Road/X Runner)	1
81150-04173	81150-04210*	Headlamp Assy, LH (Sport/Off Road/X Runner)	1

* Headlamp trim is "smoked" color.

Headlamp Assembly Appearance Concern

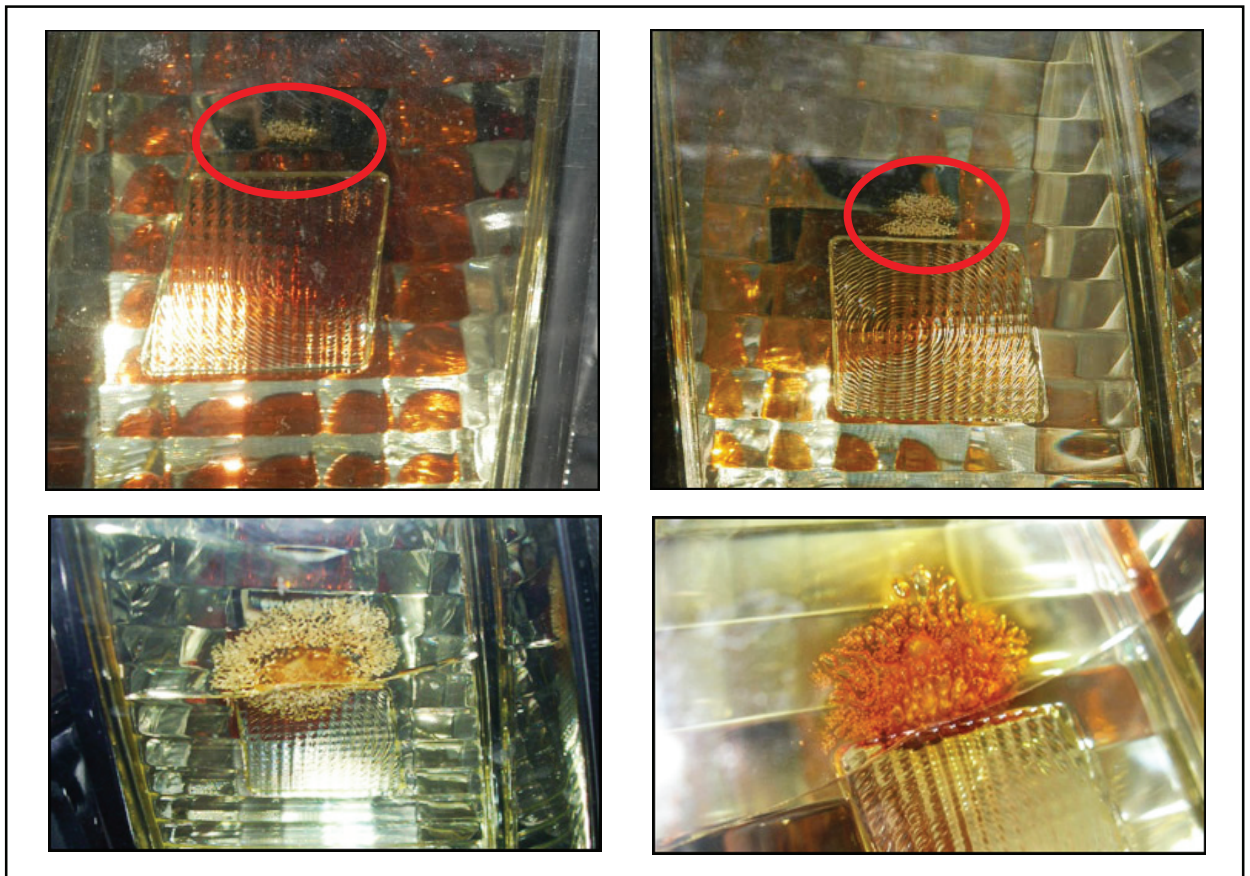
Repair Procedure

NOTE

If the vehicle is being repaired due to damage resulting from an accident, this Service Bulletin and part numbers listed do NOT apply. Follow normal parts order and repair procedures.

1. Determine if the inner DRL/turn signal lens portion of the Headlamp Assembly has cracked, bubbled, deformed, or distorted appearance.

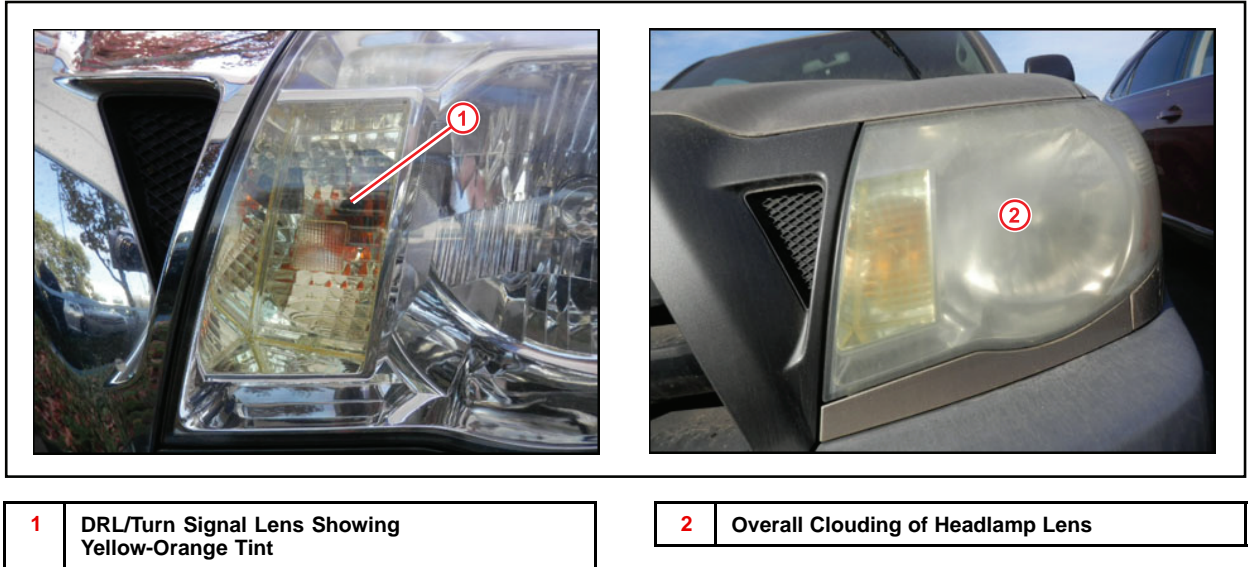
Figure 2. Headlamp Inner DRL/Turn Signal Lenses Requiring Replacement



Headlamp Assembly Appearance Concern

Repair Procedure (Continued)

Figure 3. Headlamp Inner DRL/Turn Signal Lenses and/or Headlamp Lens Conditions NOT COVERED in this Service Bulletin



2. Are the inner lenses cracked, bubbled, or deformed?

YES – Go to step 3.

NO – This bulletin does NOT apply.

NOTE

As the inner lens ages it will change from clear to yellow-orange color. If the lenses are a yellow-orange color, NO repair is necessary.

3. Replace headlamps.

Refer to the Technical Information System (TIS), applicable model and model year Repair Manual:

- [2005](#) / [2006](#) / [2007](#) / [2008](#) / [2009](#) / [2010](#) / [2011](#) Tacoma:
Vehicle Exterior – Lighting – “Headlight Assembly: Repair”

4. Confirm headlamp operation.