


# HID Headlamp Housing Paint Bubble / Poor Appearance

**Service Category** Vehicle Exterior

**Section** Lighting (ext)

**Market** USA

Lexus Supports  
ASE Certification 

## Applicability

YEAR(S)	MODEL(S)	ADDITIONAL INFORMATION
2011 – 2013	IS F, IS250, IS250C, IS350, IS350C	

### REVISION NOTICE

September ##, 2013 Rev1:

- Applicability has been updated to include additional 2013 model year Lexus vehicles.
- The Production Change Information, Warranty Information, Parts Information, and Repair Procedure sections have been updated.

Any previous printed versions of this bulletin should be discarded.

## Introduction

Some 2011 – 2013 model year IS 250/350/250C/350C and IS F vehicles equipped with HID (High Intensity Discharge) headlights may exhibit a paint bubbling/wrinkling condition on top of the LED strip within one or both of the headlight housings. Newly designed headlight units have been developed to address this condition. Follow the procedure in this bulletin to install the updated headlight units.

## Production Change Information

This bulletin applies to vehicles produced **BEFORE** the Production Change Effective VINs shown below.

MODEL	PLANT	ENGINE	DRIVETRAIN	PRODUCTION CHANGE EFFECTIVE VIN
IS 250	Tahara	4GR-FSE	2WD	JTHBF5C2#C5160946
			4WD	JTHCF5C2#C5054034
	TMK		2WD	JTHBF5C2#C2102829
			4WD	JTHCF5C2#C2035980
IS 350	Tahara	2GR-FSE	2WD	JTHBE5C2#C5029025
			4WD	JTHCE5C2#C5002374

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### Production Change Information (Continued)

MODEL	PLANT	ENGINE	DRIVETRAIN	PRODUCTION CHANGE EFFECTIVE VIN
IS 250C	TMK	4GR-FSE	2WD	JTHFF2C2#D2528759
IS 350C		2GR-FSE		JTHFE2C2#D2509743
IS F	Tahara	2UR-GSE		JTHBP5C2#D5011225

### Warranty Information

OP CODE	DESCRIPTION	TIME	OFF	T1	T2
BD9097	R & R Headlight Units, Transfer Components, & Aim Headlights	2.6	81145-53540	99	15
			81145-53541		
			81145-53542		
			81145-53543		
			81185-53540		
			81185-53541		
			81185-53542		
			81185-53543		
			81145-53670		
			81145-53671		
			81145-53672		
			81145-53673		
			81145-53543		
			81185-53670		
81185-53671					
81185-53672					
81185-53673					

#### APPLICABLE WARRANTY

- This repair is covered under the Lexus Comprehensive 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

**NOTE**

- If the headlight assembly does not have visible paint bubbles and only one headlight needs to be replaced (for collision damage repairs, etc.), use the part number for the headlight that the vehicle is currently equipped with. Updated parts are not compatible with prior part numbers.
- If either headlight assembly has visible paint bubbles, replace the headlights in pairs with the NEW part numbers.

MODEL	PART NUMBER		PART NAME	QTY
	PREVIOUS	NEW		
IS 250/350	81145-53540	81145-53544	Unit, Headlamp, RH	1
	81145-53541			
	81145-53542			
	81145-53543			
	81185-53540	81185-53544	Unit, Headlamp, LH	1
	81185-53541			
	81185-53542			
	81185-53543			
IS 250C/350C	81145-53670	81145-53674	Unit, Headlamp, RH	1
	81145-53671			
	81145-53672			
	81145-53673			
	81145-53543	81145-53544	Unit, Headlamp, LH	1
	81185-53670	81185-53674		
	81185-53671			
	81185-53672			
	81185-53673			
	81185-53543	81185-53544		

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### Parts Information (Continued)

MODEL	PART NUMBER		PART NAME	QTY
	PREVIOUS	NEW		
IS F	81145-53670	81145-53674	Unit, Headlamp, RH	1
	81145-53671			
	81145-53672			
	81145-53673			
	81185-53670	81185-53674	Unit, Headlamp, LH	1
	81185-53671			
	81185-53672			
	81185-53673			

### Required Tools & Equipment

SPECIAL SERVICE TOOLS (SST)	PART NUMBER	QTY
Plastic Pry Tool Set*	<a href="#">00002-06020-02</a>	1

\* Essential SST.

**NOTE**

Additional SSTs may be ordered by calling 1-800-933-8335.

REQUIRED MATERIAL	QUANTITY
Protective Tape	As Needed

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### Repair Procedure

1. Confirm vehicle has the headlight housing paint bubble condition (see Figure 1 for an example).  
If a poor appearance is found, continue to step 2. If not, this bulletin does **NOT** apply.

Figure 1.



2. Replace both headlight units.
  - A. Remove both headlights.

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

*Vehicle Exterior – Lighting (ext) – “Lighting: Headlight Assembly: Removal”*

- [2011](#) / [2012](#) / [2013](#) IS 250/350
- [2011](#) / [2012](#) / [2013](#) IS 250C/350C
- [2011](#) / [2012](#) / [2013](#) IS F

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### Repair Procedure (Continued)

B. Disassemble the headlight assemblies.

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

*Vehicle Exterior – Lighting (ext) – “Lighting (ext): Headlight Assembly: Disassembly”*

- [2011](#) / [2012](#) / [2013](#) IS 250/350
- [2011](#) / [2012](#) / [2013](#) IS 250C/350C
- [2011](#) / [2012](#) / [2013](#) IS F

C. Reassemble the headlight assemblies using the new headlight units.

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

*Vehicle Exterior – Lighting (ext) – “Lighting: Headlight Assembly: Reassembly”*

- [2011](#) / [2012](#) / [2013](#) IS 250/350
- [2011](#) / [2012](#) / [2013](#) IS 250C/350C
- [2011](#) / [2012](#) / [2013](#) IS F

D. Install the completed headlight assemblies with the new headlight units.

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

*Vehicle Exterior – Lighting (ext) – “Lighting: Headlight Assembly: Installation”*

- [2011](#) / [2012](#) / [2013](#) IS 250/350
- [2011](#) / [2012](#) / [2013](#) IS 250C/350C
- [2011](#) / [2012](#) / [2013](#) IS F

E. Adjust the headlight assemblies.

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

*Vehicle Exterior – Lighting (ext) – “Lighting (ext): Headlight Assembly: Adjustment”*

- [2011](#) / [2012](#) / [2013](#) IS 250/350
- [2011](#) / [2012](#) / [2013](#) IS 250C/350C
- [2011](#) / [2012](#) / [2013](#) IS F

3. Confirm headlight operation.