



TOYOTA Technical Service BULLETIN

April 30, 2007

Title: **BENT REAR TAIL GATE**

Models:
'05 – '07 Tacoma

T S B

BODY
B0004-07

Introduction To improve tail gate loading and unloading performance, new parts are available to reinforce the rear tail gate. When replacing a bent tail gate, use the following repair information to reinforce the rear tail gate.

Applicable Vehicles

- **2005 – 2007** model year **Tacoma** vehicles.

Parts Information

CURRENT PART NUMBER	PART NAME	QTY
65711-04010	Tail Gate Reinforcement No. 1 (RH)	1
65712-04020	Tail Gate Reinforcement No. 2 (LH)	1
90080-11178	Bolt (Includes Attached Washer)	10

Required Tools and Materials

TOOLS & MATERIALS	PART NUMBER	QTY
Drill	–	1
10 mm Drill Bit	–	1
3M™ Rust (inhibitor) Fighter – I Amber or equivalent	08891 (Wand) 08892 (Aerosol)	1
3M™ Body Aplicator Gun (P/N 08997)**		1

****NOTE:**

When using the 3M™ Rust (inhibitor) Fighter – I Amber Wand application (P/N 08891), the 3M™ Body Applicator Gun (P/N 08997) is required.

Warranty Information

OP CODE	DESCRIPTION	TIME	OFF	T1	T2
BD7027	R & R Rear Body Tail Gate Assembly	1.4	65701-04020	9A	13

Use typical body shop sublet claim practice for claiming preparation and painting of tail gate.

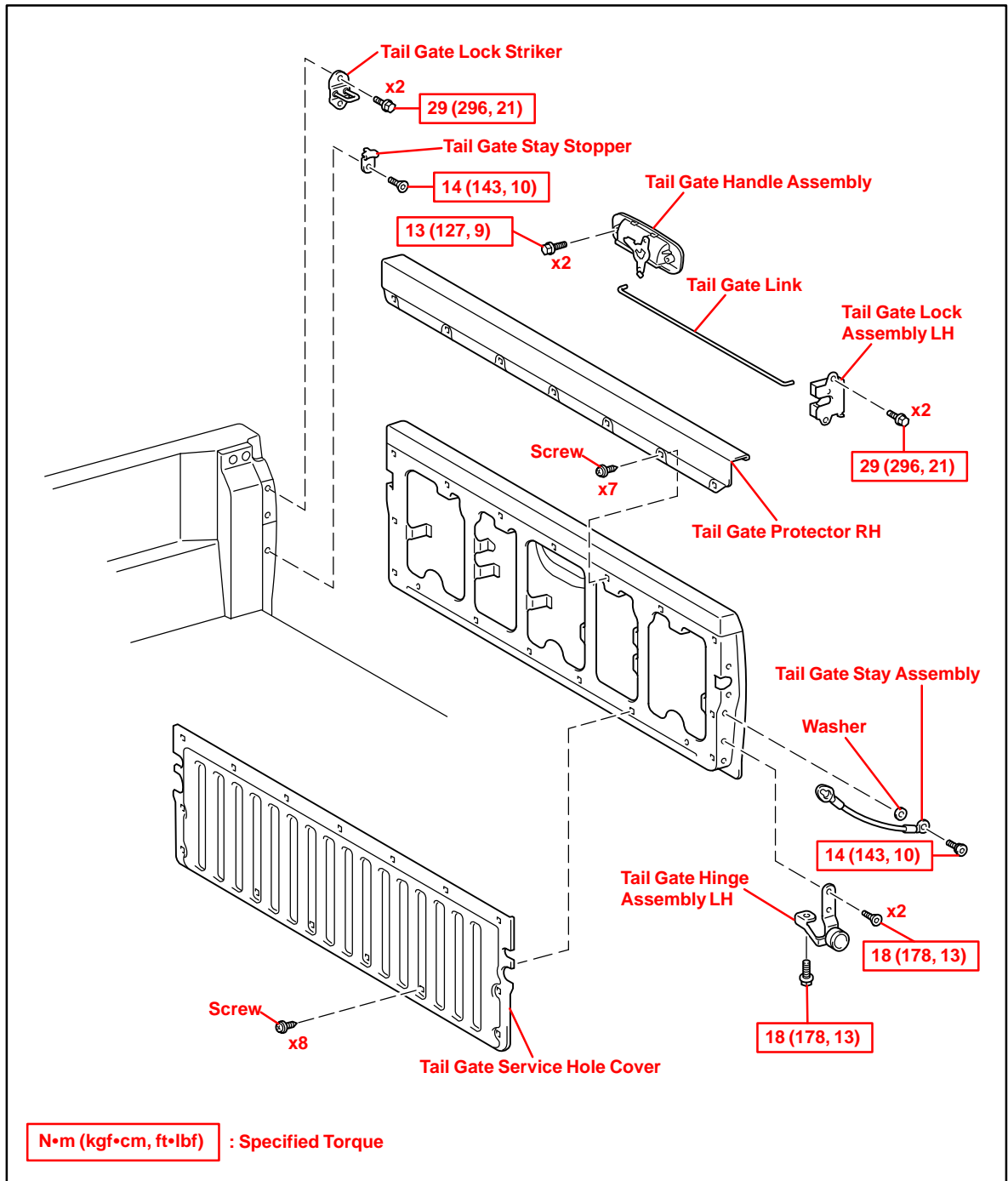
Applicable Warranty*:

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 correction of a problem based upon a customer's specific complaint.



Tail Gate Components



**Repair
Procedure****NOTE:**

For more information on installation of the tail gate reinforcement, refer to the Technical Information System (TIS), 2007 model year Tacoma Repair Manual:

- *Vehicle Exterior – Door/Hatch – “Engine Hood / Door: Tail Gate: Components”*
- *Vehicle Exterior – Door/Hatch – “Engine Hood / Door: Tail Gate: Disassembly”*

1. Remove all components from the old tail gate.

HINT:

When removing the protector, close the tail gate and use caution NOT to bend the protector. Start by lifting up on the ends and work towards the center.

2. Add reinforcements to the NEW tail gate.

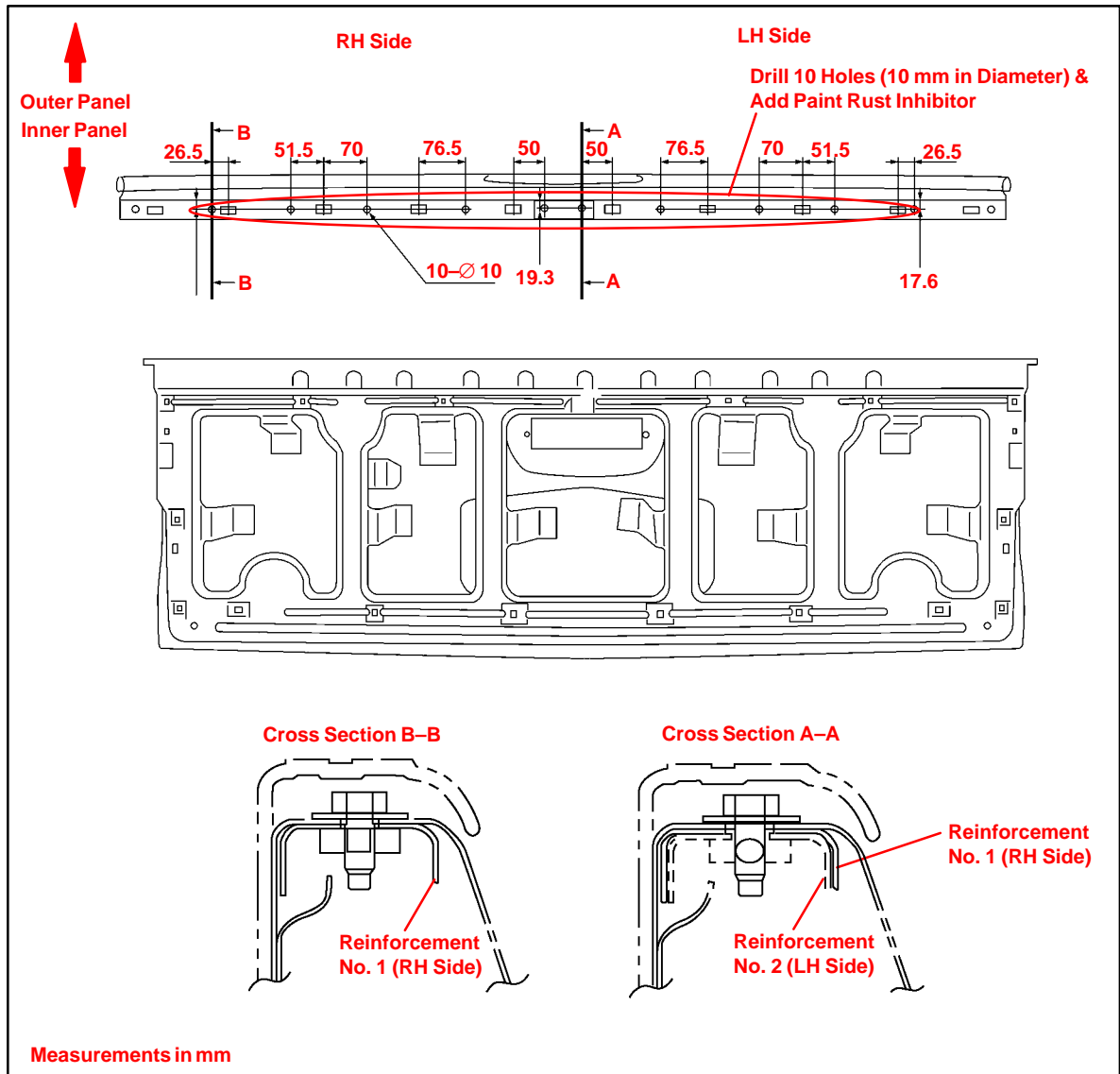
NOTE:

Illustrations referenced for the reinforcements are performed on a bench. Repair can be performed on a bench or while installed on the vehicle.

- A. Drill 10 NEW holes (10 mm in diameter). Refer to the following illustration.
- B. Remove any metal shavings from the tail gate with a vacuum.

Repair Procedure
(Continued)

- C. Apply paint rust inhibitor to the “NEWLY drilled holes” by following the directions on the label described by the manufacturer.

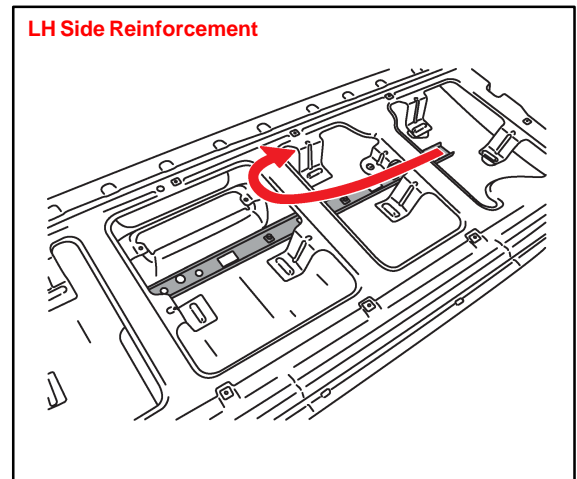


**Repair
Procedure**
(Continued)

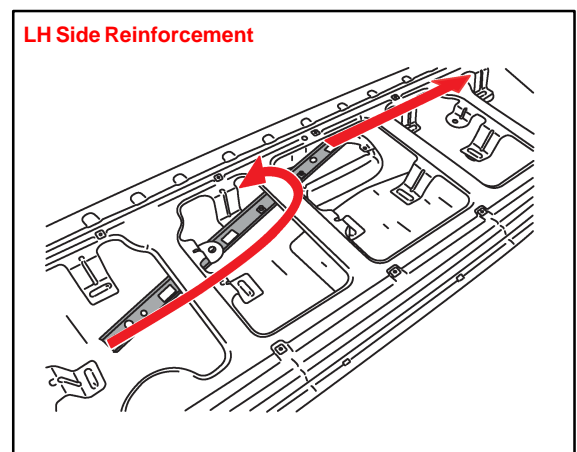
NOTE:

The procedure is the same for **BOTH** the LH and RH side.

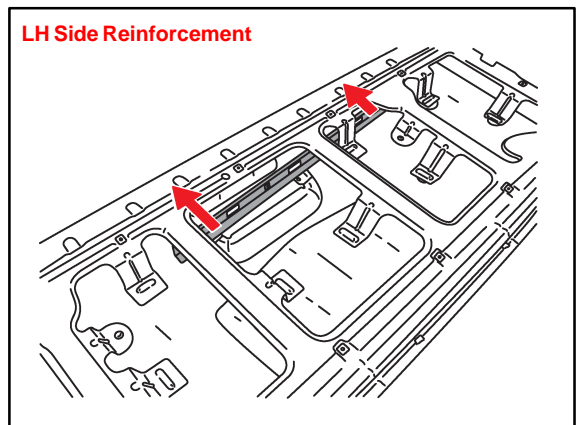
3. Start by sliding the reinforcement No. 1 RH into the rear tail gate as shown in the illustration.



4. Slide the edge of the reinforcement No. 1 RH behind the pillar towards the top of the tail gate.



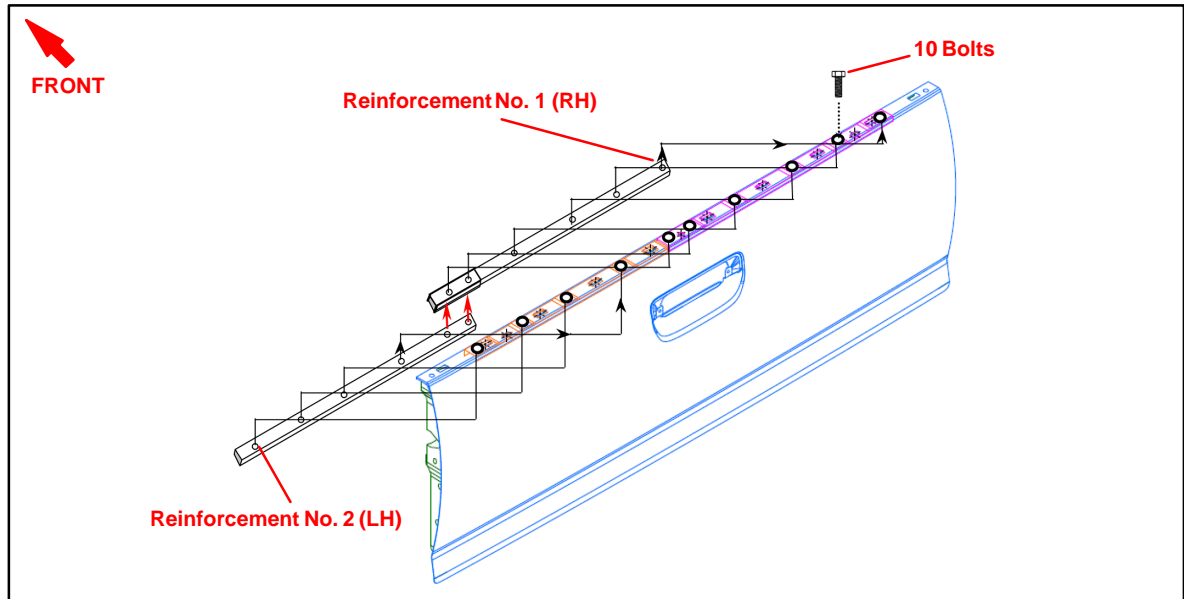
5. Place the reinforcement No. 1 RH behind the pillar on the top side of the tail gate and temporarily tighten with 4 bolts, leaving the center 2 holes open.



**Repair
Procedure**
(Continued)

6. Repeat steps 3–5 for the LH side.
7. Install the remaining 6 bolts.
8. Completely tighten the 10 bolts.

Torque: 8 N•m (81.6 kgf•cm, 5.9 ft•lbf)



9. Send tail gate to body shop for painting.

10. Reassemble the tail gate.

Refer to TIS:

- 2005 model year Tacoma Repair Manual, *Vehicle Exterior – Door/Hatch – “Tail Gate: Reassembly”*
- 2006 or 2007 model year Tacoma Repair Manual, *Vehicle Exterior – Door/Hatch – “Engine Hood / Door: Tail Gate: Reassembly”*