



**Technical Service
Information Bulletin**

February 16, 2005

Title: **AUDIO DOOR REPLACEMENT**

Models: **'02 – '05 SC 430**

**BODY
B0002-05**

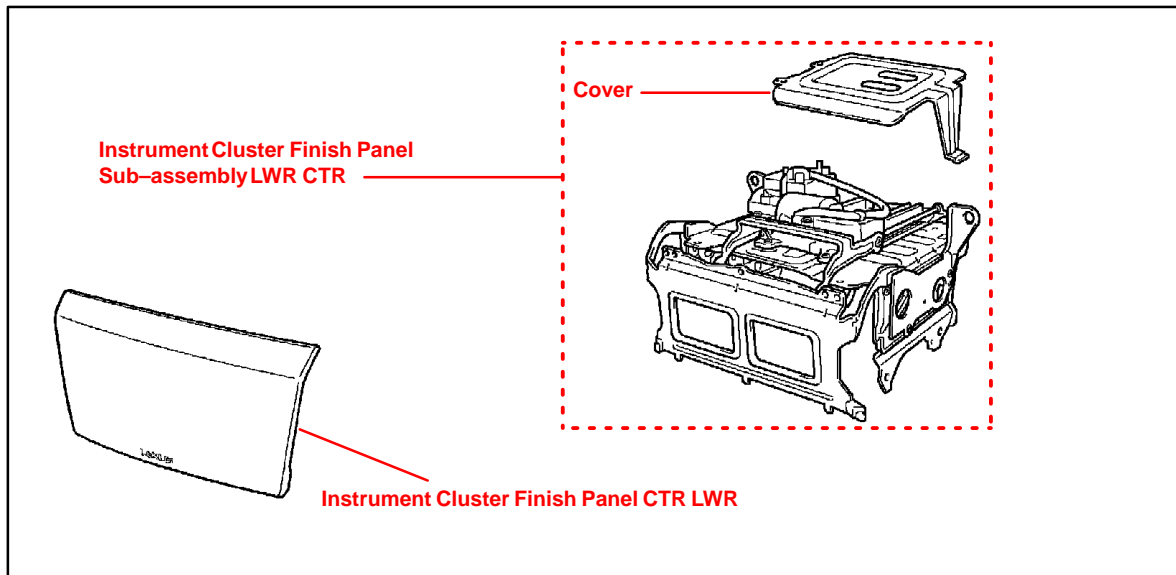
Introduction The audio system door can be replaced separately without having to replace the complete lower sub-assembly. The following repair procedure has been developed.

- Applicable Vehicles**
- **2002 – 2005** model year **SC 430** vehicles.

Parts Information

PREVIOUS PART NUMBER	CURRENT PART NUMBER	INTERIOR COLOR	PART NAME	QTY
N/A	55413-24170-B0	Ecru Brown	Panel, Instrument Cluster Finish, CTR LWR	1
	55413-24170-E0	Saddle		

Components



Warranty Information

OP CODE	DESCRIPTION	TIME	OFP	T1	T2
BD4022	R & R Audio Door	0.6	55406-24010-##	9A	99

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.

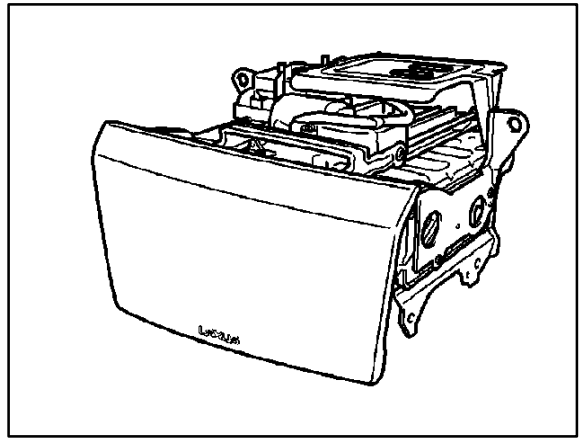
* Warranty application is limited to correction of a problem based upon a customer's specific complaint.



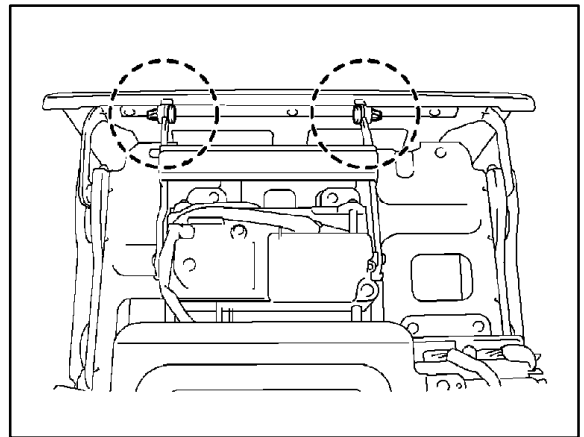
Repair Procedure

NOTE:

Refer to the procedure for removing the radio receiver assembly from the instrument cluster finish panel sub-assembly LWR CTR found in the Technical Information System (TIS), applicable model year SC 430 Repair Manual: *Audio & Visual System: Radio Receiver Assy: Replacement (SC 430)*.



1. Replace Instrument Cluster Finish Panel CTR LWR (Audio Door).
 - A. Remove the 2 clips shown in the illustration.
 - B. Remove the 3 screws from the backside of the instrument cluster finish panel CTR LWR and then remove the instrument cluster finish panel CTR LWR.

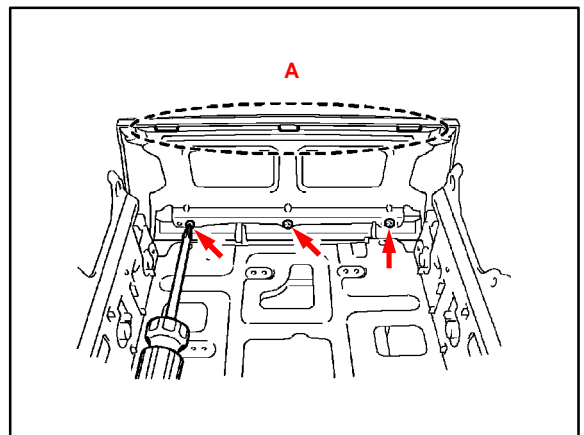


NOTE:

Be careful not to damage the 3 positioning ribs in area A.

- C. Install a new instrument cluster finish panel CTR LWR onto the original instrument cluster finish panel sub-assembly LWR CTR.
- D. Tighten the 3 screws.

**Torque: 0.69 to 0.71 N•m
(6.83 to 7.24 kgf•cm,
0.49 to 0.52 ft•lbf)**



**Repair
Procedure**
(Continued)

- E. Fully close the audio system finish panel by sliding the motor.

NOTE:

Do not close the audio system finish panel door by holding and sliding the door.

- F. Install the 2 new clips from inward to outward in the areas B.

- 2. Reinstall and Inspect.
 - A. After assembling the instrument cluster finish panel sub-assembly LWR CTR, visually check the appearance to make sure that the instrument cluster finish panel CTR LWR is centered.
 - B. Check that the audio system finish panel operates properly.

