



**Technical Service  
Information Bulletin**

April 28, 2000

Title:

**SEAT HEATER REPLACEMENT  
PROCEDURE**

Models:

'95 - '00 LS 400

**REVISÉD**  
**BO002-00**  
**BODY**

**TSB Revision Notice:**  
The information updated in this TSB is red and underlined.

**Introduction** The seat heater installation method for the LS 400 has been changed. When changing the seat heater, please follow the replacement procedure provided in this bulletin.

**Applicable Vehicles** • 1995 through 2000 model year **LS 400**

**Parts Information:**  
'95 - '97 MY

PAD WITH HEATER	NEW PART NUMBER		PART NAME	QTY
	PAD	HEATER		
71515-50050	71511-50060	87510-50210	Front Seat Cushion, RH	1
71516-50050	71512-50060		Front Seat Cushion, LH	1
71555-50060	71551-50100	87510-50220	Front Seatback, RH	1
71555-50070	71551-50120		Front Seatback, LH	1
71556-50010	71552-50060			

**Parts Information:**  
'98 - '00 MY

COVER WITH HEATER	PART NUMBER		PART NAME	QTY
	COVER	HEATER		
71071-50260-**	71071-50160-**	87510-50210	Front Seat Cushion, RH	1
71072-50260-**	71072-50160-**		Front Seat Cushion, LH	1
71073-50520-**	71073-50430-**	87510-50220	Front Seatback, RH	1
71074-50290-**	71074-50190-**		Front Seatback, LH	1

**Warranty Information**

OPCODE	DESCRIPTION	TIME	OPN	T1	T2
EL9011	Seat Heater	2.0	87510-502*0	87	71

**Applicable Warranty\*:**  
This repair is covered under the Lexus Basic Warranty. This warranty is in effect for 48 months or 50,000 miles, whichever occurs first, from the vehicle's in-service date.

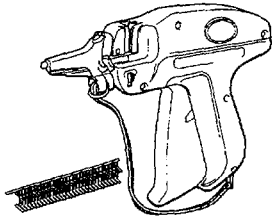
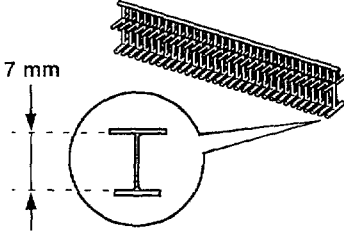
\* Warranty application is limited to correction of a problem based upon a customer's specific complaint.



**Required Tools and Material**

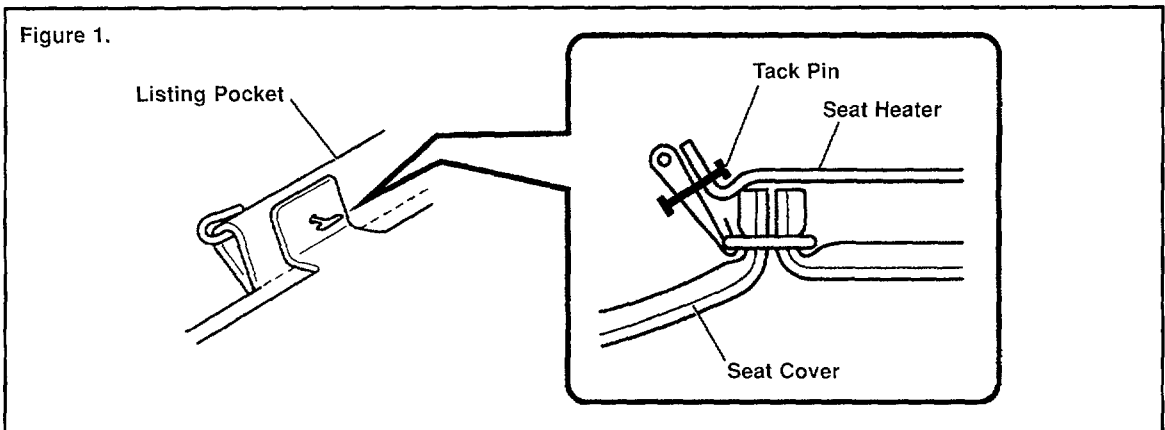
- Tacker
- Tacks
- Hog Ring Pliers

**NOTE:**  
**Special Service Tools can be ordered through the Lexus SST program by calling 1-800-933-8335.**

ESSENTIAL SPECIAL SERVICE TOOLS			
TOOL NUMBER	TOOL NAME	SUPPLIER	QTY
00002-17750	Seat Heater Attachment Tool 	OTC	1
00002-16500	Fasteners 	OTC	10,000 pieces
00002-01775	Seat Heater Attachment Kit	OTC	1 Set
00002-01780	Seat Heater Tool Replacement Needles	OTC	3

**How to use the Tacker:**

As shown below, drive in a tack pin with the tacker and fix the seat heater to the seat cover.



**Repair Information**

- For installation/removal of the seat and disassembly/assembly of the seat cushion assembly, refer to the 2000 model year LS 400 Repair Manual (pages BO-100 through 104).
- Care should be taken during the operation to protect the seat cover from scratches, dirt or accidental cuts.

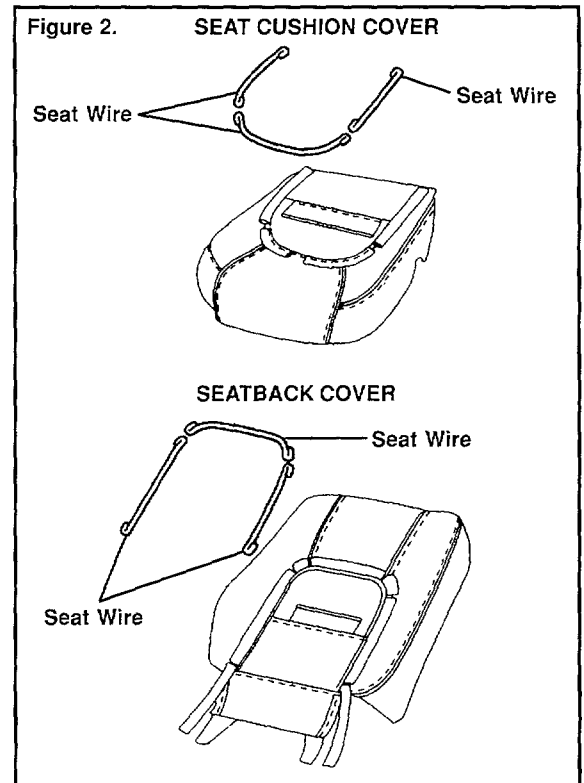
**'95 - '97 LS 400 Repair Procedure**

- 1. Turn the seat cover inside out.**
- 2. Remove the seat heater.**

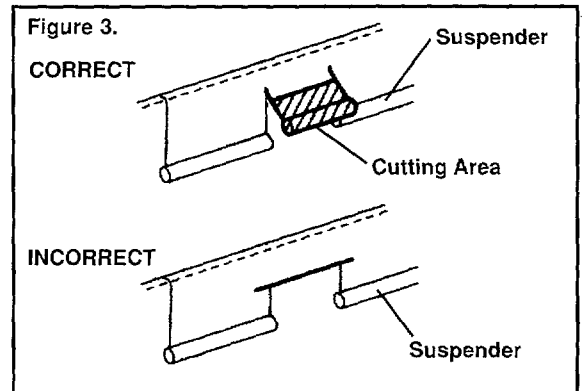
Remove the 6 seat wires from the front seat cushion cover and front seatback cover, as shown in Figure 2.

- 3. Make a slit in the seat cover.**

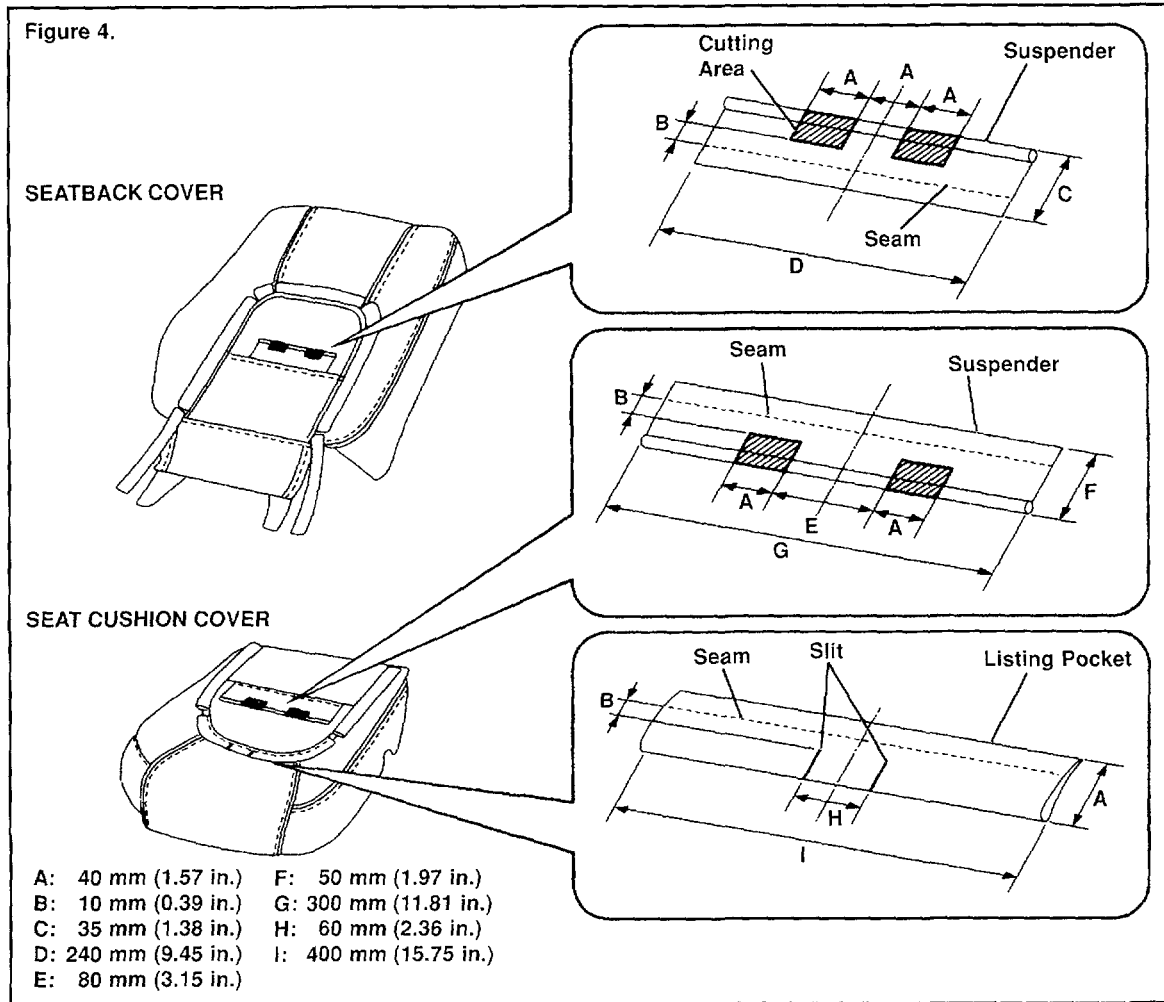
Make slits in the listing pocket (refer to Figure 1) of the seat cushion cover and in the listing pocket and suspender of the seatback cover as shown in Figure 4.



**Hint:**  
When making slits in the suspender, carefully avoid excessive cutting in the lateral direction. (See Figure 3.)



'95 - '97 LS 400  
Repair  
Procedure  
(Continued)



4. Seat cushion cover: Install the new seat heater.

Refer to Figure 5 on the following page.

- Align the new seat heater by placing the marked side (part number) against the seat cushion cover.
- For part A, position the front seat heater by aligning the V-slits of the front seat heater with the fold line of the listing pocket.
- For part B, position the front seat heater by aligning the V-slits of the front seat heater with the tape of the front seat cushion cover.
- For part C, position the front seat heater by aligning the V-slits of the front seat heater with the V-slit of the seat cushion cover.
- Using a tackers, attach tack pins to the front seat heater as shown in the illustration.

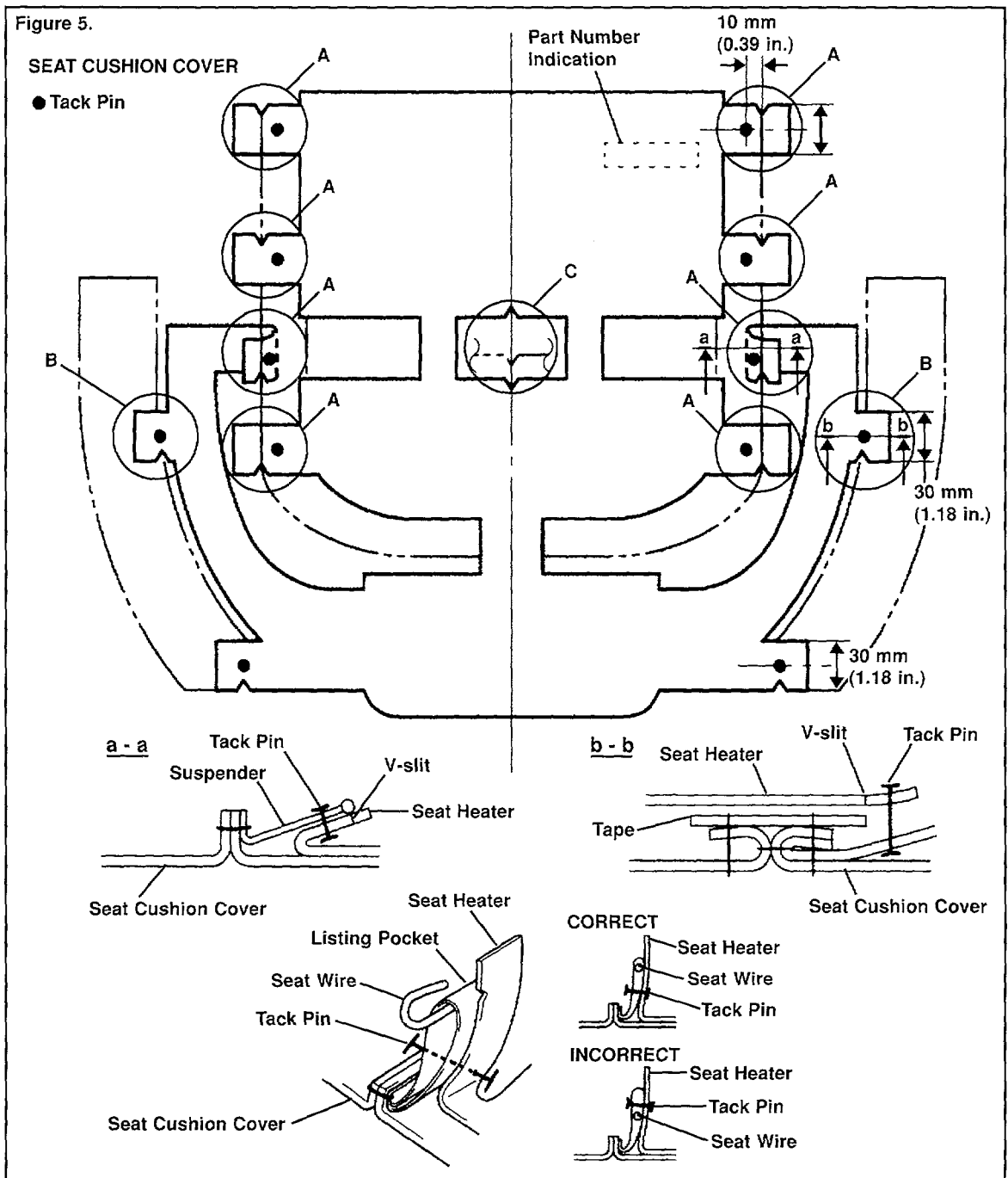
**NOTICE:**

- Do not substitute other metal parts in place of tack pins.
- Insufficient distance between the heater and cover may result in damage to the heater.

**HINT:**

- Attach tack pins on the seam side so that the wire can be threaded through the hole from the fold side.
- Sewing thread can be substituted for tack pins. However, allow a distance of 6-7 mm (0.24-0.28 in.) between both sewn parts of the heater and cover.

'95 - '97 LS 400  
Repair  
Procedure  
(Continued)



**5. Seatback cover: Install the new seat heater.**

Refer to Figure 6 on the following page.

- A. Face the marked side (part number) to the seat cushion pad.
- B. For part A, position the front seat heater by aligning the end of the front seat heater's fin with the fold line of the listing pocket.
- C. For part B, position the front seat heater by aligning the V-slits of the front seat heater with the fold line of the listing pocket.
- D. For part C, position the front seat heater by aligning the V-slits of the front seat heater with the V-slit of the seatback cover.
- E. Using a tacker, attach tack pins to the front seat heater as shown in the illustration.

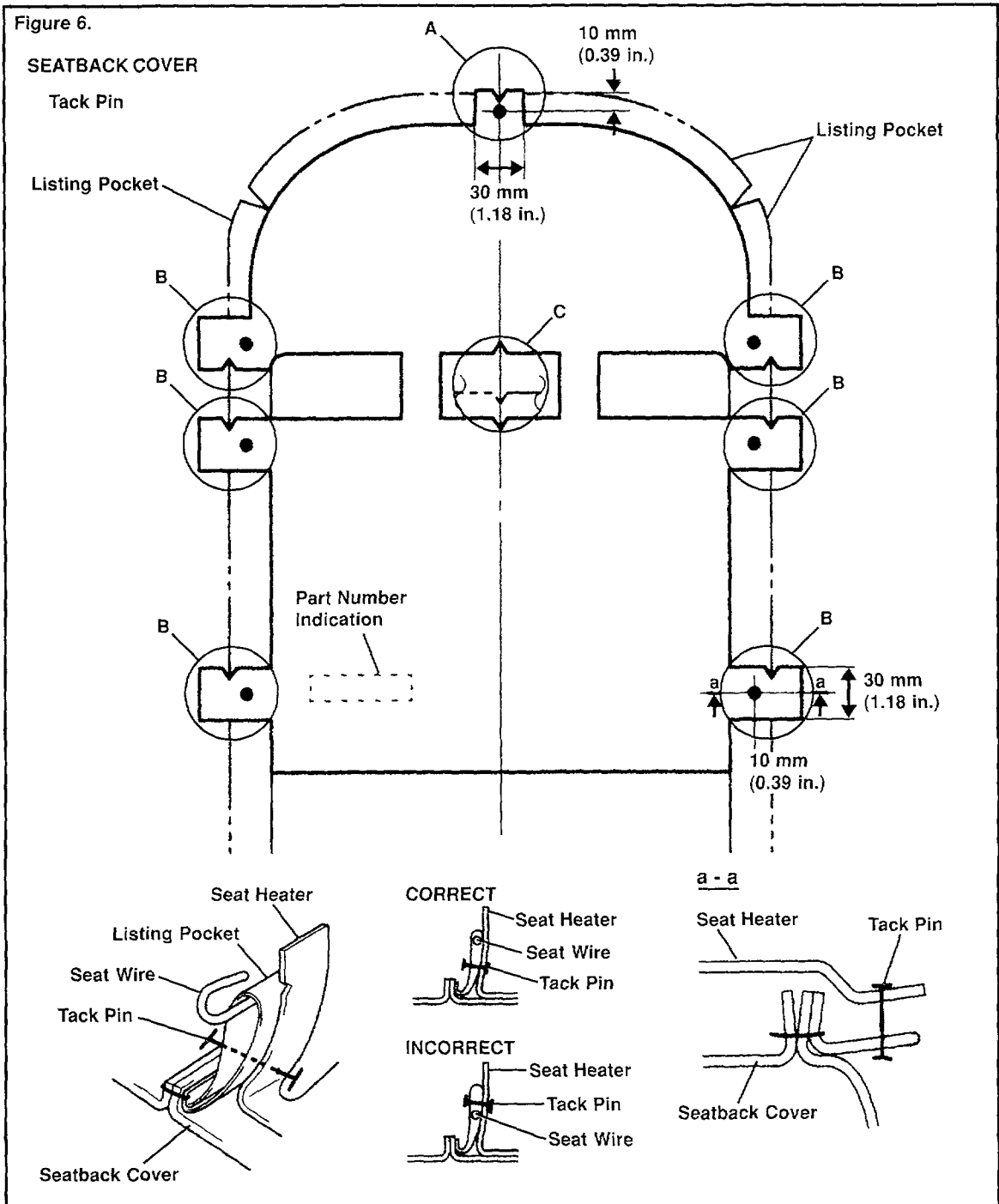
'95 - '97 LS 400  
 Repair  
 Procedure  
 (Continued)

**NOTICE:**

- Do not substitute other metal parts in place of tack pins.
- Insufficient distance between the heater and cover may result in damage to the heater.

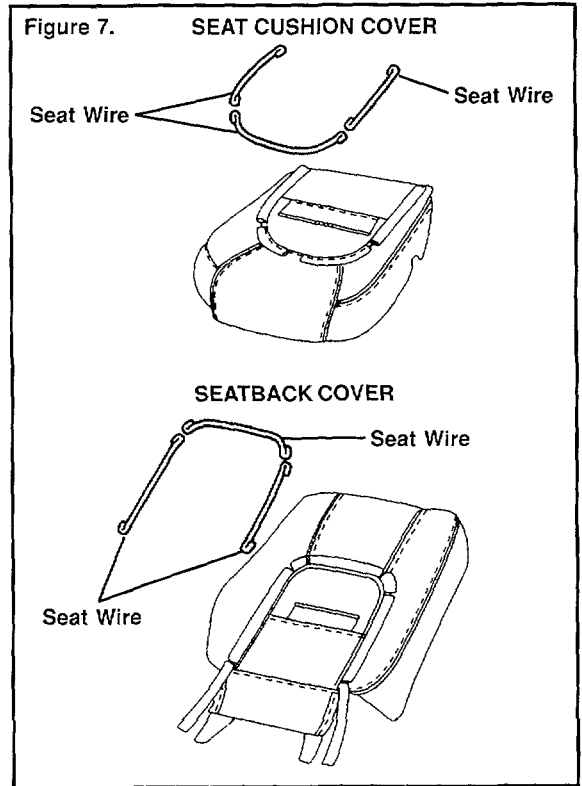
**HINT:**

- Attach tack pins on the seam side so that the wire can be threaded through the hole from the fold side.
- Sewing thread can be substituted for tack pins. However, allow a distance of 6-7 mm (0.24-0.28 in.) between both sewn parts of the heater and cover.



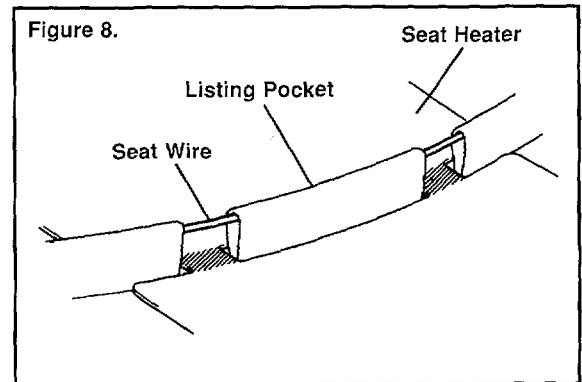
'95 - '97 LS 400  
Repair  
Procedure  
(Continued)

F. Install the 6 seat wires to the front seat cushion cover and front seatback cover, as shown in Figure 7.



**Hint:**  
Pass the wire over the seat heater as shown in Figure 8.

5. Reverse the seat cover back to its original position.



'98 - '00 LS 400  
Repair  
Procedure

1. Turn the seat cover inside out.

2. Remove the seat heater.

Remove the 2 seat wires from the seat cushion cover and the seatback cover. (Figure 9.)

A. Seat cushion cover:

Cut the 12 tack pins that are fastened to the front seat heater, then remove the front seat heater.

B. Seatback cover:

Cut the 7 tack pins that are fastened to the seat heater, then remove the front seat heater.

3. Seat cushion cover:  
Install the new seat heater.

Install a new front seat heater as shown in Figure 10 on the following page.

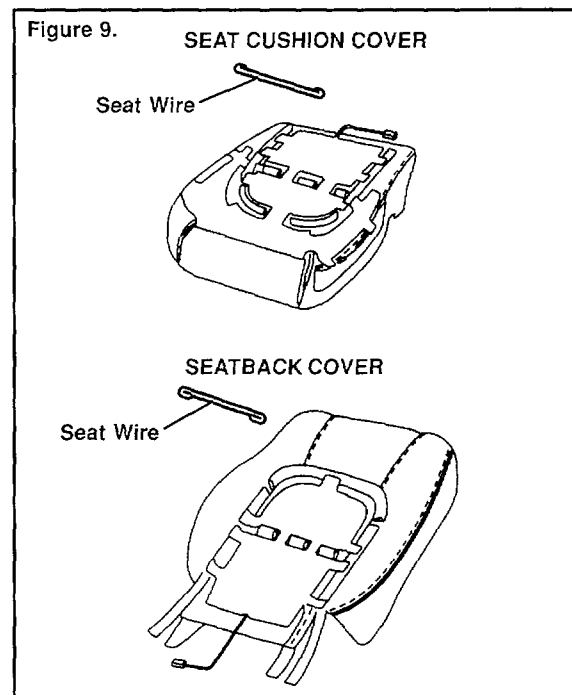
A. Set the seat heater, marked side (part number) to the seat cushion cover.

B. For part A, position the front seat heater by aligning the V-slits of the front seat heater with the fold line of the listing pocket.

C. For part B, position the front seat heater by aligning the V-slits of the front seat heater with the tape of the front seat cushion cover.

D. For part C, position the front seat heater by aligning the v-slits of the front seat heater with the V-slit of the seat cushion cover.

E. Using a tacker, attach tack pins to the front seat heater as shown in the illustration.



**NOTICE:**

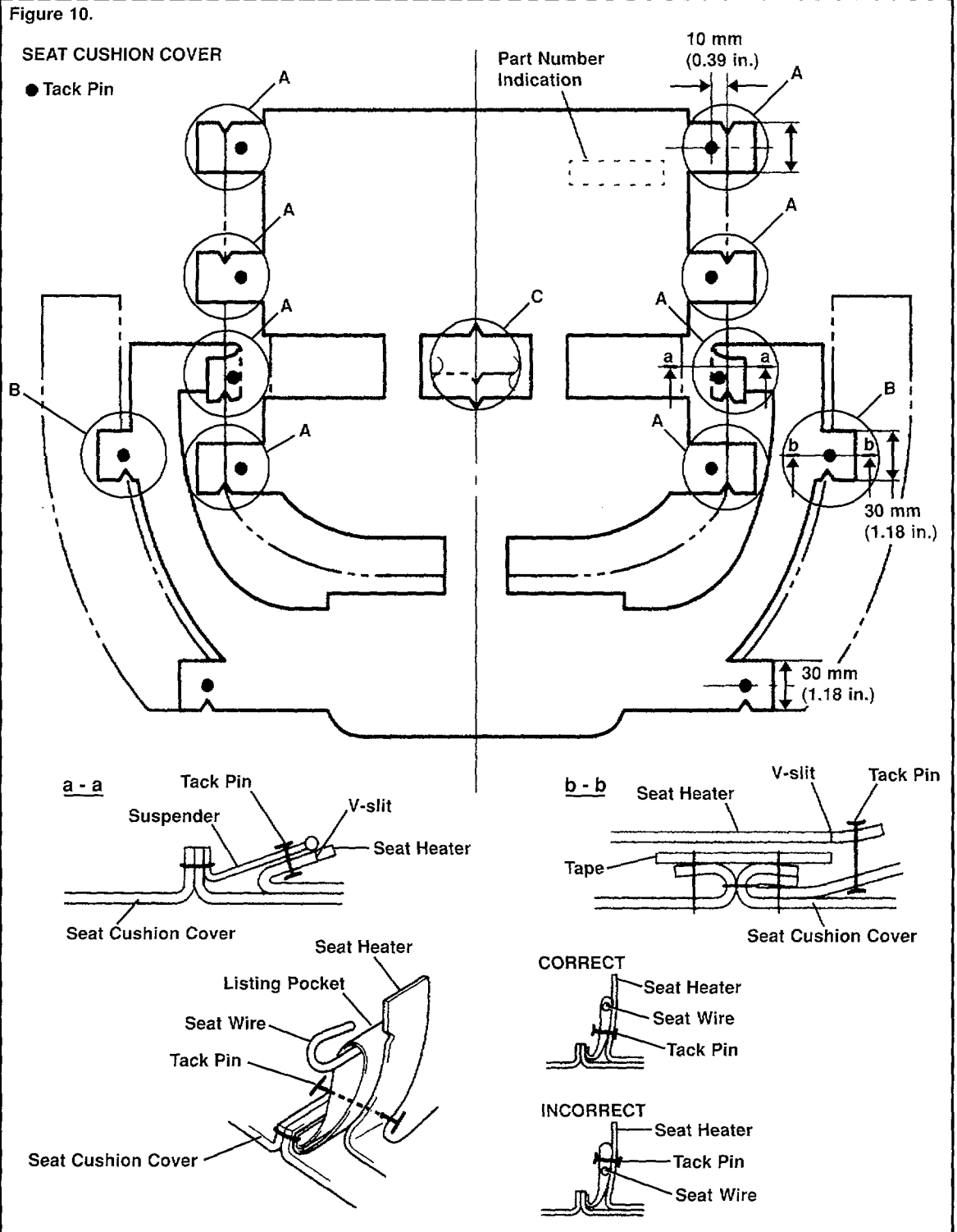
- Do not substitute other metal parts for tack pins.
- Insufficient distance between the heater and cover may result in damage to the heater.

**HINT:**

- Attach tack pins on the seam side so that the wire can be passed through the hole from the fold side.
- Sewing thread can be substituted for tack pins. However, allow a distance of 6-7 mm (0.24-0.28 in.) between both sewn parts of the heater and cover.



'98 - '00 LS 400  
Repair  
Procedure  
(Continued)



'98 - '00 LS 400  
Repair  
Procedure  
(Continued)

**4. Seatback cover:**

**Install the new seat heater.**

Install a new front seat heater as shown in Figure 11 on the following page.

- A. Face the marked side (part number) to the seatback cover.
- B. For part A, position the front seat heater by aligning the end of the front seat heater's fin with the fold line of the listing pocket.
- C. For part B, position the front seat heater with the fold line of the listing pocket.
- D. For part C, position the front seat heater by aligning the V-slits of the front seat heater with the V-slit of the seatback cover.
- E. Using a tacker, attach tack pins to the front seat heater as shown in the illustration.

**NOTICE:**

- Do not substitute other metal parts for tack pins.
- Insufficient distance between the heater and cover may result in damage to the heater.

**HINT:**

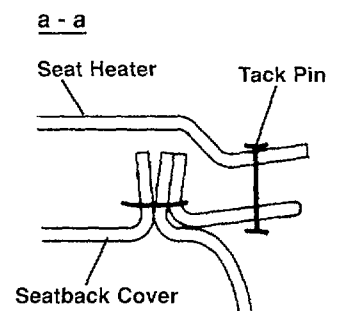
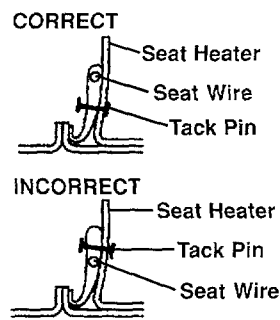
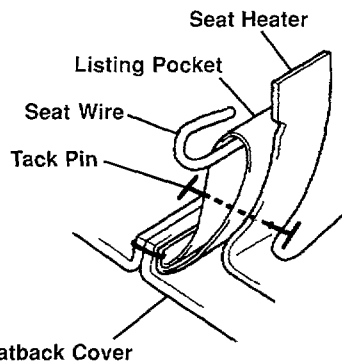
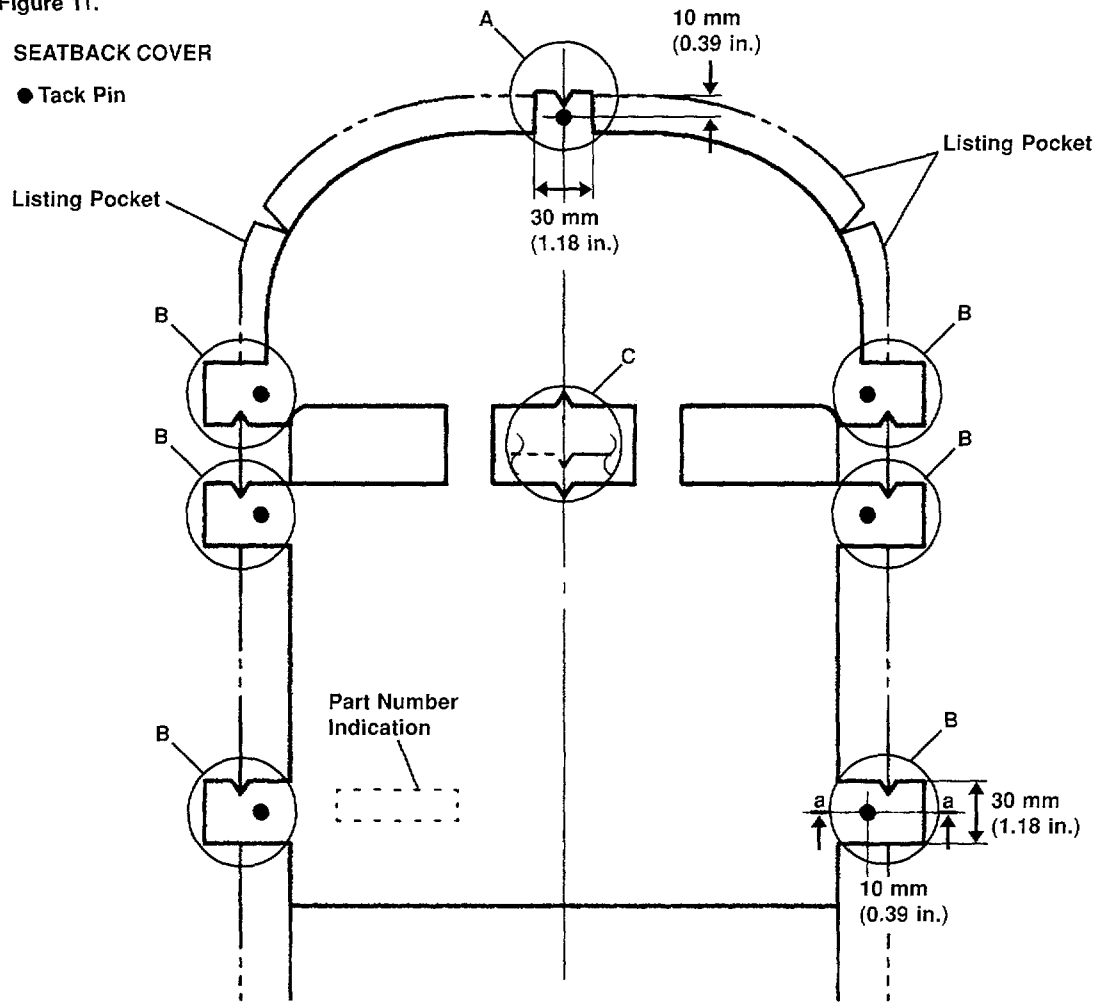
- Attach tack pins on the seam side so that the wire can be passed through the hole from the fold side.
- Sewing thread can be substituted for tack pins. However, allow a distance of 6-7 mm (0.24-0.28 in.) between both sewn parts of the heater and cover.

'98 - '00 LS 400  
Repair  
Procedure  
(Continued)

Figure 11.

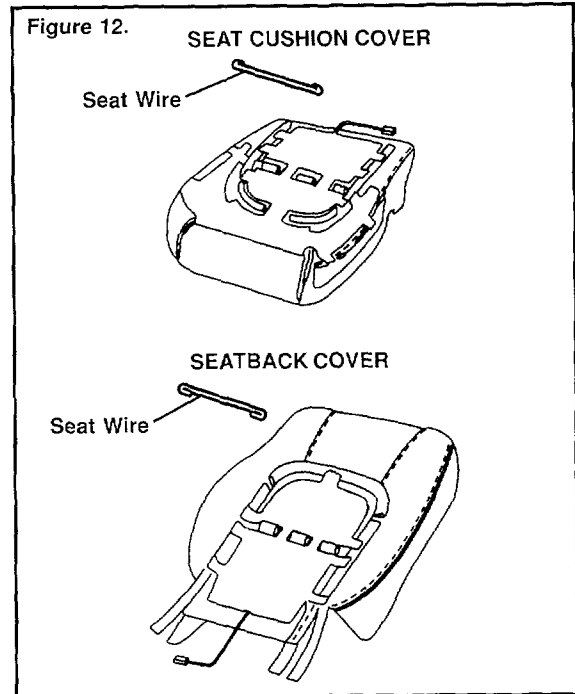
SEATBACK COVER

● Tack Pin

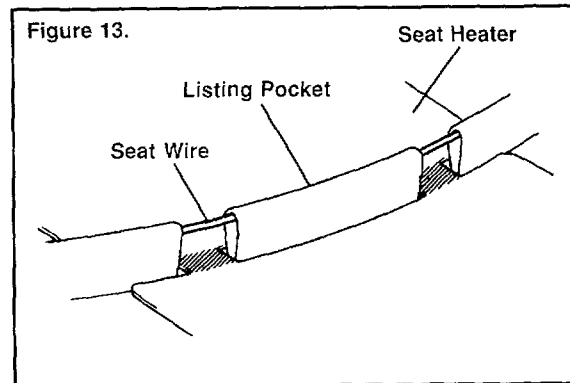


'98 - '00 LS 400  
Repair  
Procedure  
(Continued)

F. Install the 2 seat wires to the front seat cushion cover and front seatback cover, as shown in Figure 12.



**Hint:**  
Pass the wire over the seat heater as shown in Figure 13.



5. Reverse the seat cover back to its original position.