



Technical Service BULLETIN

April 7, 2004

Title:

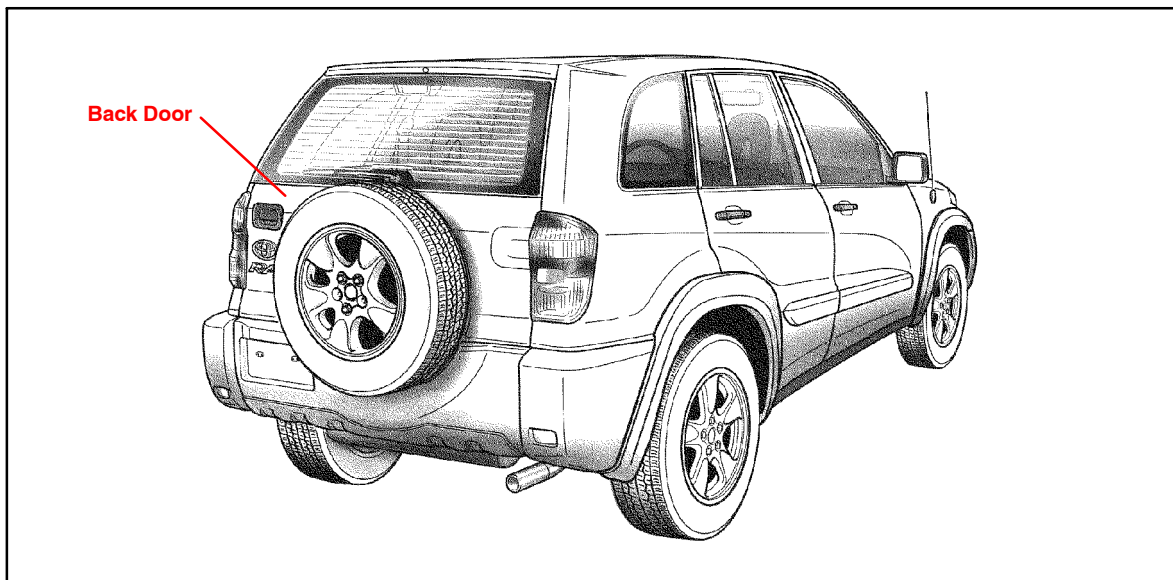
BACK DOOR RATTLE

Models:

'04 RAV4

NVH
NV005-04

Introduction The following procedure has been developed to reduce the possibility of rattles from the back door of the 2004 model year RAV4.



Applicable Vehicles

- **2004** model year **RAV4** vehicles produced **BEFORE** the Production Change Effective VINs shown below.

Production Change Information

MODEL	PLANT	DRIVETRAIN	PRODUCTION CHANGE EFFECTIVE VIN
RAV4	Tahara	2WD	JTEGH20V#20080113
		4WD	JTEHH20V#20184277
	Nagakusa	2WD	JTEGH20V#26010512
		4WD	JTEHH20V#26068540

Warranty Information

OP CODE	DESCRIPTION	TIME	OFF	T1	T2
BD4002	Drill Four Spot Welds and Plug Weld, Refinish Inside of Back Door Inside Panel	2.4	67005-423#0	91	68
Combo A	R & R Back Door Trim Board	0.6			

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.



Toyota Supports ASE Certification

**Required
Tools &
Material**

TOOLS & MATERIAL	SNAP-ON® PART NUMBER	QUANTITY
Snap-on® Spot Weld Drill Bit Kit (YA2550-2 Cutter)	YA2550	1

NOTE:

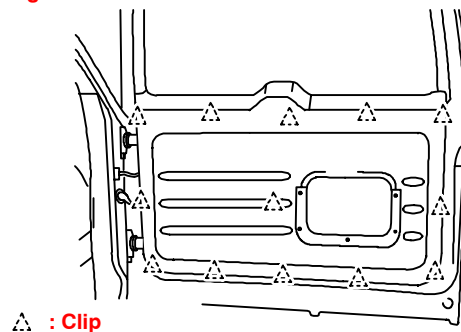
For parts information and availability, contact Snap-on® directly at www.snapon.com or contact your local Snap-on® dealer.

**Repair
Procedure****Re-weld Spare Tire Mounting Reinforcement Spot Weld Points LH and/or RH.**

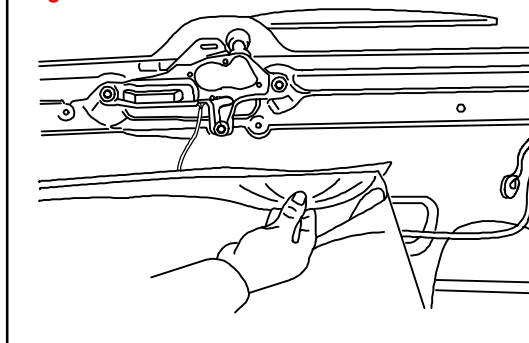
1. Disconnect the battery negative terminal.
2. Remove the spare tire cover and the spare tire.
3. Remove the back spare tire bracket.
 - A. Remove the four bolts and the back spare tire bracket.
4. Remove the wiper arm.
 - A. Remove the wiper arm head cap, the nut and the rear wiper arm.
5. Using a screwdriver, remove the back door trim board.

NOTE:

Tape the screwdriver tip before use.

Figure 1

6. Remove the rear wiper motor.
 - A. Remove the moisture barrier.
 - B. Disconnect the connector, then unfasten the three bolts.
 - C. Remove the rear wiper motor.
 - D. Remove the wire harness.
7. Apply a protective cover to the inside of the back door glass to avoid any damage during welding.

Figure 2

**Repair
Procedure**
(Continued)

8. Drill out the four spare tire mounting reinforcement spot welds (3/8 inch diameter holes, 1.7 mm [0.067 inch] in depth) using a Snap-on® Spot Weld Cutter (Snap-on® P/N YA2550-2) as shown in Figure 3 below.
 - A. Drill one hole at the top of the upper spot-welding point as shown in Figure 4.A below.
 - B. Drill the other hole at the bottom of the lower spot-welding point as shown in Figure 4.B below.
 - C. Repeat procedure for opposite side.

NOTE:

Drill slowly and carefully to confirm the hole depth. Be sure not to penetrate the spare tire mounting reinforcement.

Figure 3

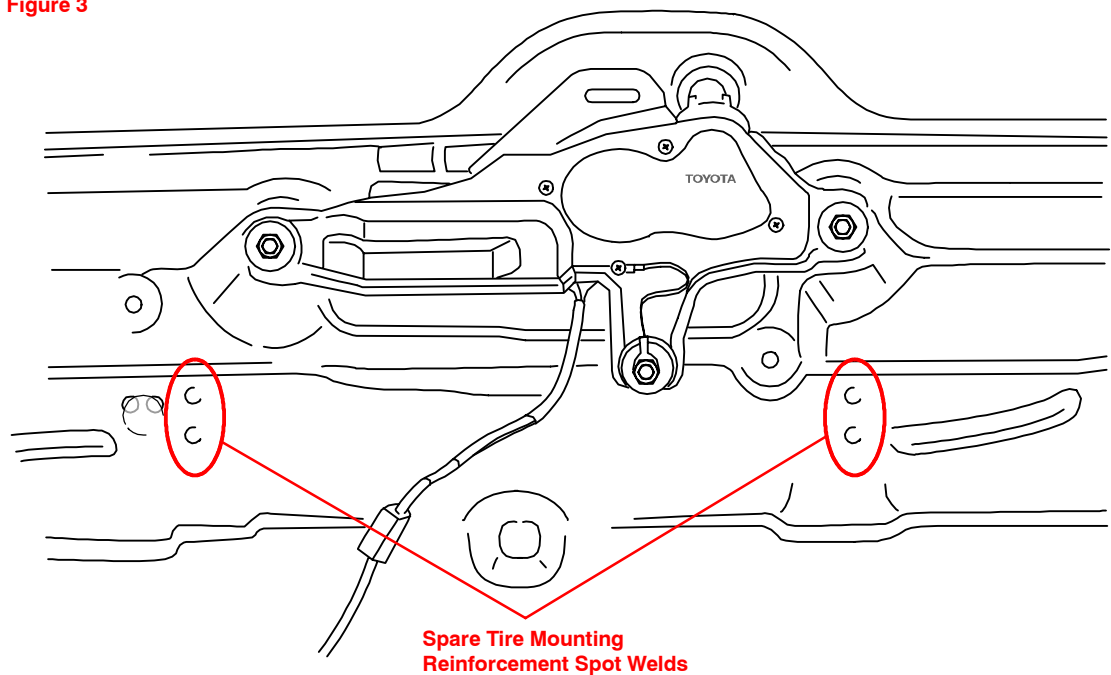
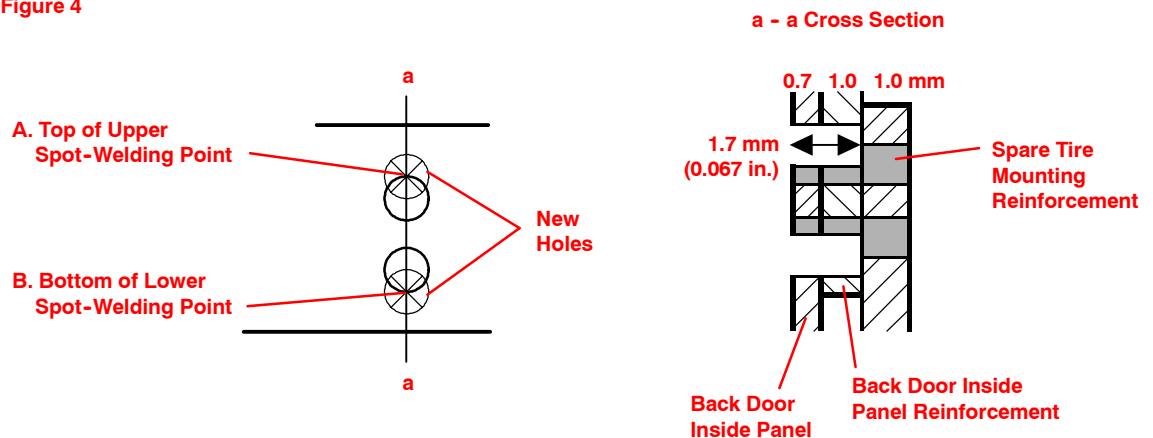
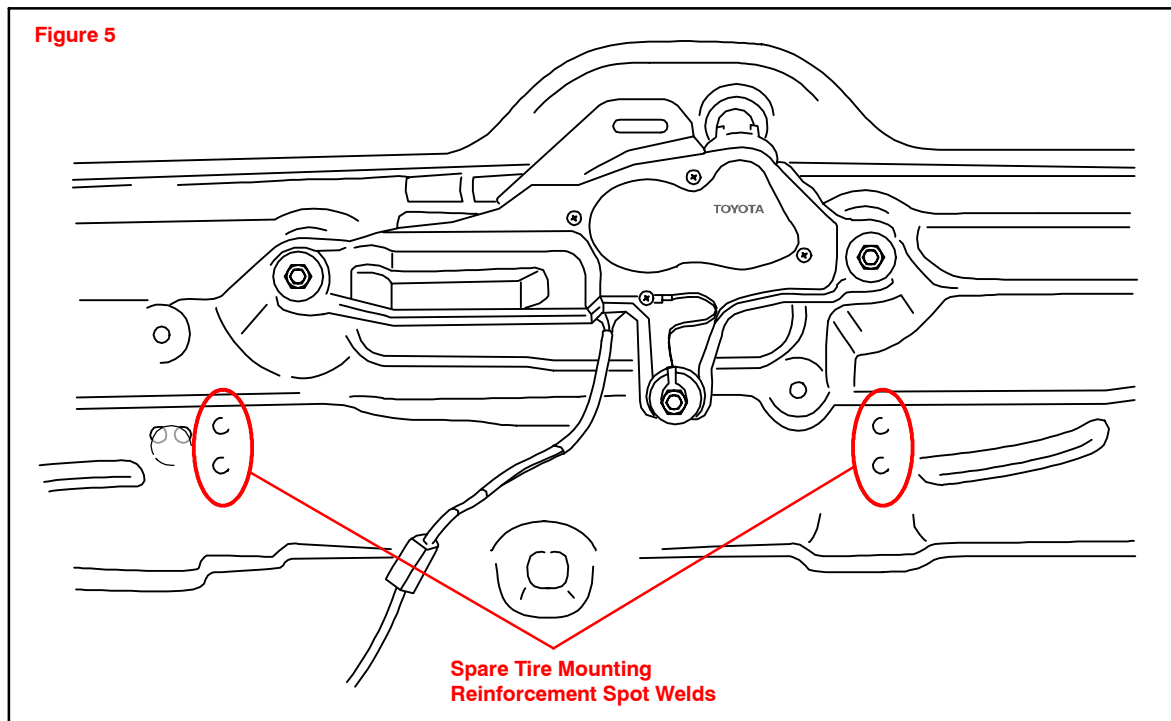


Figure 4

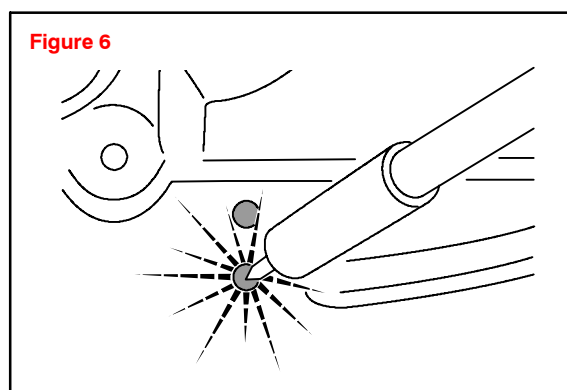


**Repair
Procedure**
(Continued)

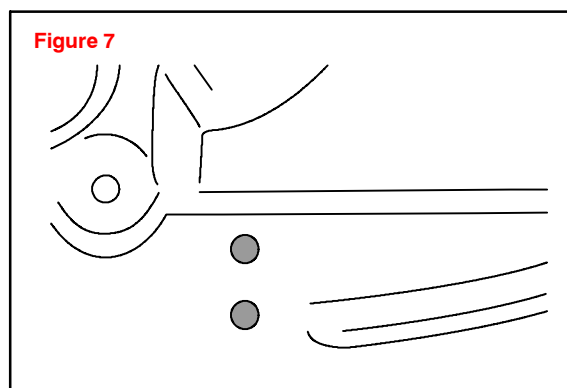
9. Remove paint around the upper and lower spot-welding points, and remove paint in one place for ground connection point.



10. Plug-weld the four holes using a plug welding machine. (Use an electrode of 0.6 mm [0.024 in.] in diameter).



11. Smooth the four welded points using a grinder.
12. Touch-up (paint) the position where paint has been removed.
13. Apply primer (rust preventive paint) on the reverse side of the welded points.
14. Remove the protective cover from the back door glass inside.



**Repair
Procedure**
(Continued)

15. Reinstall the rear wiper motor.
 - A. Reinstall the wire harness.
 - B. Reinstall the rear wiper motor with the three bolts.
Torque: 5.5 N•m (55 kgf•cm, 49 in.•lbf)
 - C. Reinstall the grommet.
 - D. Connect the connector.
16. Reinstall the service hole cover.
17. Reinstall the back door trim board.
18. Reconnect the battery negative terminal.
19. Reinstall the wiper arm.
 - A. Reinstall the wiper arm and hand tighten the nut.
 - B. Operate the wiper once and turn the wiper switch OFF.
- C. Adjust the installation position of the wiper arm to the position as shown in Figure 9.
A: Approx. 6.2 mm (0.244 in.)
- D. Torque the nut.
Torque: 5.5 N•m (55 kgf•cm, 49 in.•lbf)
- E. Reinstall the wiper arm head cap.
20. Reinstall the back spare tire bracket with the four bolts.
Torque: 28 N•m (285 kgf•cm, 21 ft•lbf)
21. Reinstall the spare tire cover and the spare tire.

Figure 8

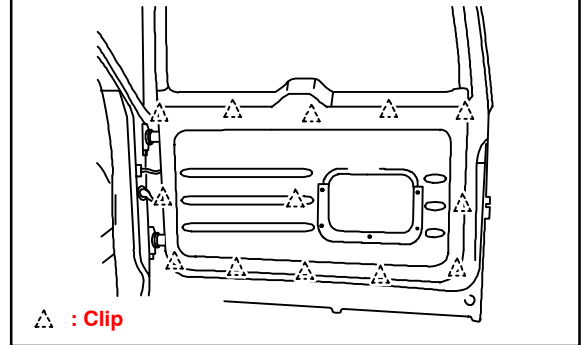


Figure 9

