

Section : Wind noise/
Squeak/ Rattle
Ref. No. : WS-3002
Date : Dec., 2003
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Area Application : USA/CANADA, Europe, Australia, G.C.C Countries,
General

Model Name : RAV4

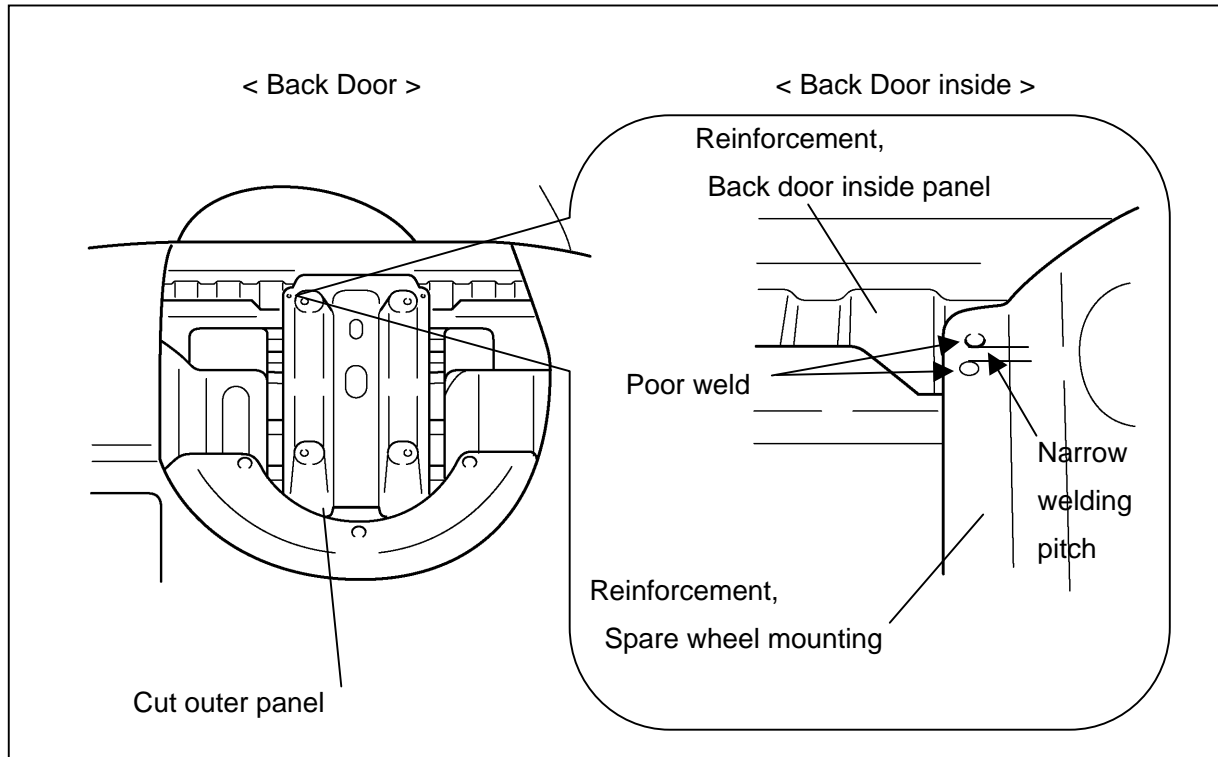
Model Code : ACA20, ACA21, ACA26, CLA20, CLA21, ZCA25, ZCA26

Subject : Back Door Rattle

This is to inform you of a field fix which has been developed to prevent the rattle noise from the back door area while driving.

Cause:

This rattle generated from the poor welding points that resulted from a shunt current due to the narrow welding pitch.



Field Fix Method

Re-welding of the affected welding 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.**

Remove the 4 bolts and the back spare tire bracket.

- 4. Remove the wiper arm.**

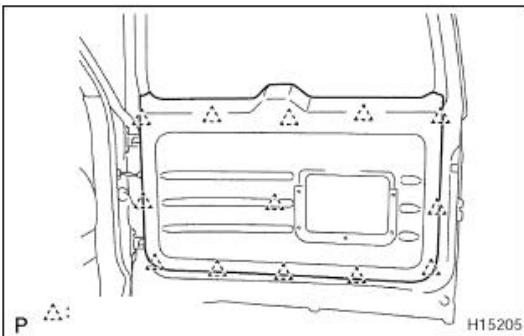
Remove the wiper arm head cap, the nut and the rear wiper arm.

- 5. Remove the back door trim board.**

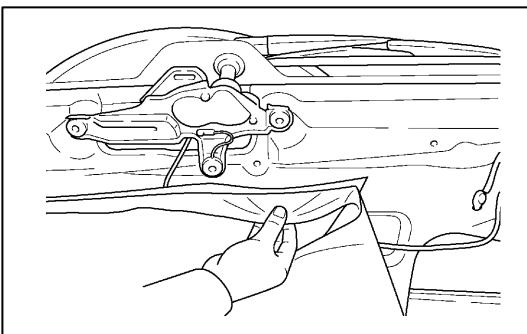
Using a screwdriver, remove the back door trim board.

HINT:

Tape the screwdriver tip before use.



- 6. Remove the service hole cover.**



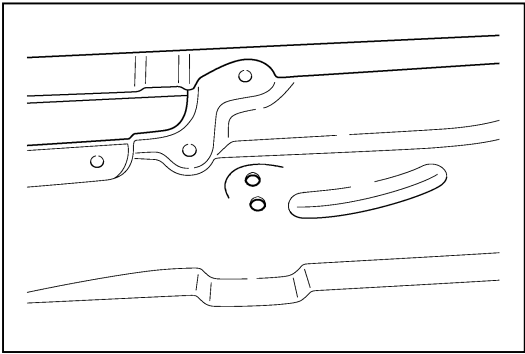
- 7. Remove the rear wiper motor.**

- (a) Remove the grommet.**
- (b) Disconnect the connector, then unfasten the 3 bolts.**
- (c) Remove the rear wiper motor.**
- (d) Remove the wire harness.**

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8. Apply a protective cover to the back door glass inside to avoid any damage during the welding.

9. Drill two holes of 8mm in diameter and 1.7mm in depth using spot-cutter (SST P/N 09060-10060) as shown in the illustration below.

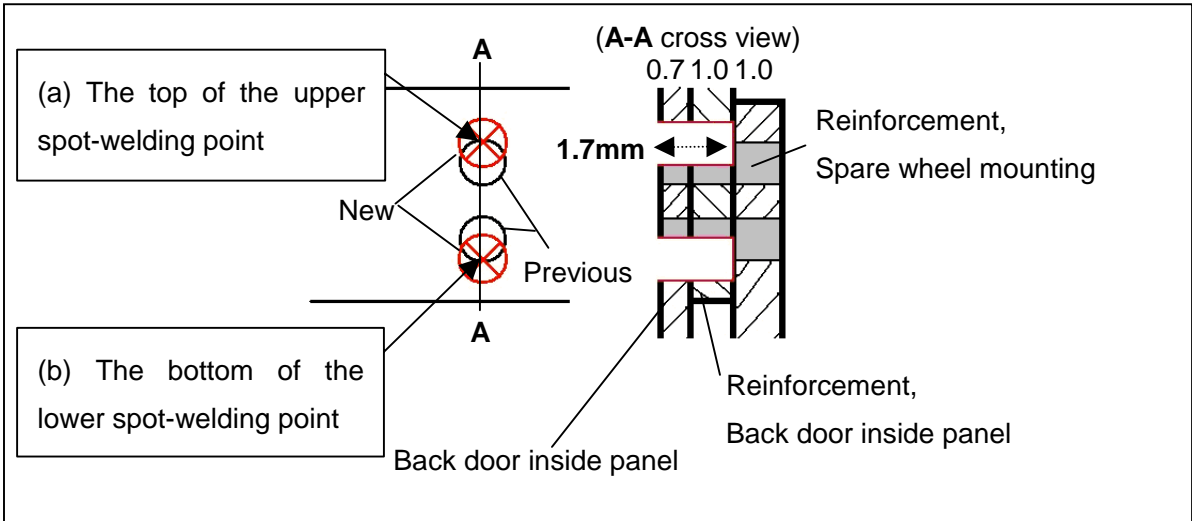


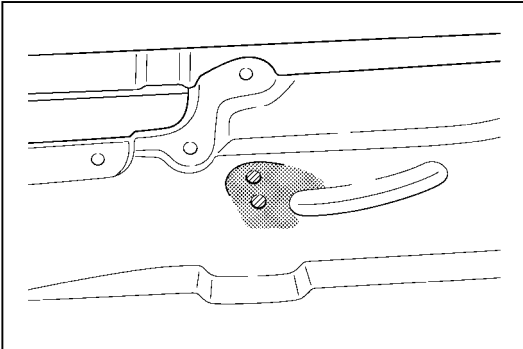
(a) Drill one hole at the top of the upper spot-welding point as shown in the illustration below.

(b) Drill the other hole at the bottom of the lower spot-welding point as shown in the illustration below.

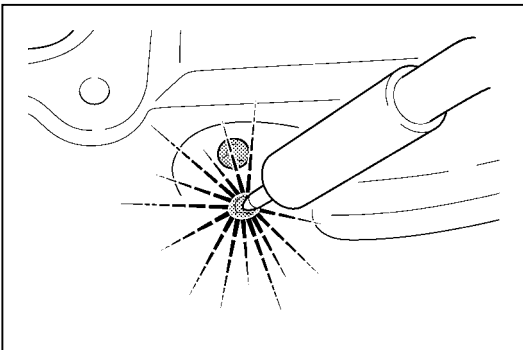
HINT:

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

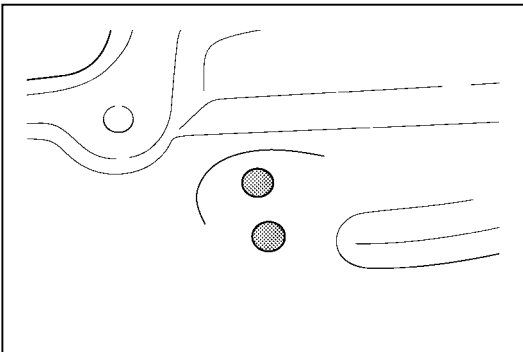




10. Remove paint around the upper and lower spot-welding points, and remove paint in one place for earth connection point.



11. Plug-weld the two holes using a plug welding machine. (Use a electrode of 0.6mm in diameter)



12. Smooth the two welded points using a grinder.

13. Touch-up (paint) the position where paint has been removed.

14. Apply primer (rust preventive paint) on the reverse side of the welded points.

15. Remove the protective cover from the back door glass inside.

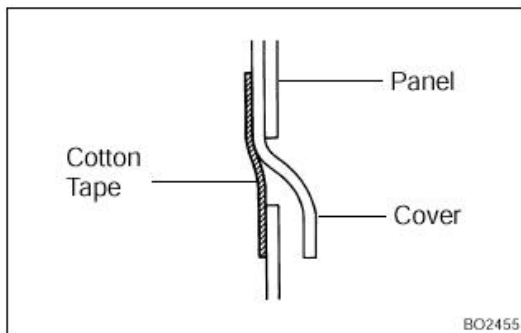
16. Reinstall the rear wiper motor.

- (a) Reinstall the wire harness.
- (b) Reinstall the rear wiper motor with the 3 bolts.
Torque: 5.5 N-m (55 kgf-cm, 49 in.-lbf)
- (c) Reinstall the grommet.
- (d) Connect the connector.

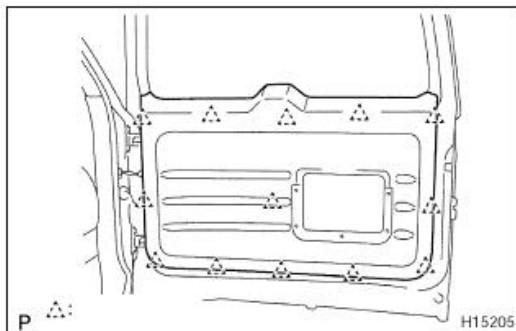
17. Reinstall the service hole cover.

HINT:

Pull out the links through the service hole cover.



18. Reinstall the back door trim board.



19. Reconnect the battery negative terminal.

20. Reinstall the wiper arm.

- (a) Reinstall the wiper arm and torque the nut by hand.
- (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 the illustration.
A: Approx. 6.2 mm (0.244 in.)
- (d) Torque the nut.

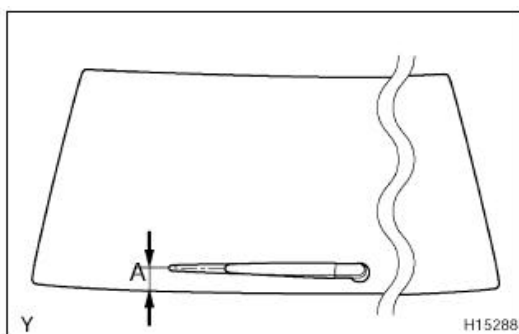
Torque: 5.5 N-m (55 kgf-cm, 49 in.-lbf)

- (e) Reinstall the wiper arm head cap.

21. Reinstall the back spare tire bracket with the 4 bolts.

Torque: 28 N-m (285 kgf-cm, 21 ft-lbf)

22. Reinstall the spare tire cover and the spare tire.



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Production Effective:

Model	VIN (Reference only)	Production Date	Body Type	Power Train	Plant	
ACA20	JTEYH20V600038363	10th July, 2002	3 Door	4WD	TAHARA	
ACA21	JTEHH20V420184277		15th July, 2002			5 Door
	JTEHH20V926068540					
CLA20	JTEYG20V200009462	10th July, 2002	3 Door		2WD	TAHARA
CLA21	JTEHG20V000025112		15th July, 2002			
	JTEHG20V506011672					
ZCA25	JTEXR20V300014580	10th July, 2002	3 Door	2WD		TAHARA
ZCA26	JTEGR20VX00032381		5 Door		TOYOTA Industries Nagakusa	
ACA26	JTEGH20V820080113					
	JTEGH20V626010512					