

# **COLLISION REPAIR INFORMATION**

## **FOR THE TOYOTA DEALER**

TITLE: SIENNA SLIDING DOOR HINGE REPLACEMENT PAGE 1

SECTION: REFINISH BULLETIN #138

MODELS: 2004 SIENNA

DATE: April 2004

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The Power Sliding Door on 2004 Sienna vehicles may become inoperative and require the replacement of a new improved **Center Sliding Door Hinge Assembly**.

**Hinge location**



The replacement Center Sliding Door Hinge Assembly is supplied as an unfinished new part. The anti-corrosive zinc finish must be painted before the new hinge is installed on the vehicle. The procedure required to prepare and paint the replacement hinge is outlined below:

### **Center Sliding Door Hinge Assembly Paint Process**

1. Clean part with wax and grease remover.
2. Scuff part with gray Scotch-Brite pad.
3. Clean again with wax and grease remover.
4. Apply two coats of epoxy primer.
5. Allow epoxy primer to dry according to paint manufacturer specifications.
6. Apply basecoat (body color) with hardener following paint manufacturer specifications. Clear coat is not required.
7. Allow basecoat to air-dry overnight, or bake for 20 minutes at 140°F.
8. Attach painted door hinge to vehicle.

**PLEASE ROUTE THIS BULLETIN TO YOUR COLLISION REPAIR CENTER MANAGER AND COLLISION REPAIR TECHNICIANS**