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**Date:** January 18<sup>th</sup>, 2007

**To:** All Rampvan Dealers

**Subject:** NHTSA Toyota Sienna Rampvan rear axle beam mounting (Recall Number 07V-546)

I am writing to inform you that The Braun Corporation recently initiated a recall that concerns 2004-2007 Toyota Sienna Rampvan rear axle beam mounting. We will soon be notifying all vehicle owners we have record of, and that are affected by this recall, via U. S. Postal Service First Class Mail. The letter being sent to customers will contain the NHTSA required notification documents as well as information the recipient will need to know in order to have their vehicle inspected/repaired. In taking this action, The Braun Corporation is hoping to lessen the burden on our dealers in contacting the persons affected by this action.

We will be using a registration company to supply us with the name and address information for end users affected by this recall. However, you may be asked to research your company customer records for end user information in the event registration information cannot be found. If you are contacted by Braun regarding this, please provide this information to us and we will be happy to mail this information directly to the owner of the vehicle.

Please remember it is a violation of Federal law for a dealer to deliver a new motor vehicle or any new or used item of motor vehicle equipment covered by the notification under a sale or lease until the defect or noncompliance is remedied. In other words, if you have a Toyota Rampvan vehicle affected by this recall in your possession, it must be inspected and if necessary repaired before you can sell the vehicle. Note: Any Toyota Rampvan converted by Braun after August 10<sup>th</sup> 2007 is not affected by this recall.

In taking this action, Braun continues to place the safety of our customers at the top of our priorities. We are also committed to support our dealer partners in their effort to service their customers. It is our hope that the steps outlined in this letter will serve to reaffirm that commitment and acknowledge the value we place in our working relationship. Should you have any questions with regard to the matters outlined above, feel free to contact The Braun Corporation's Product Support Department.

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Rick Nelson, Director of Product Support

# Safety Recall Notice

## Service Bulletin 34238

January 2008

Instructions for Rear Axle Beam Assembly  
Evaluation and Securement  
Applicable for **2004-2007 Toyota Sienna  
Side Entry Rampvan® Conversions**

**THE BRAUN CORPORATION®**  
"Providing Access to the World"®

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**⚠ CAUTION**

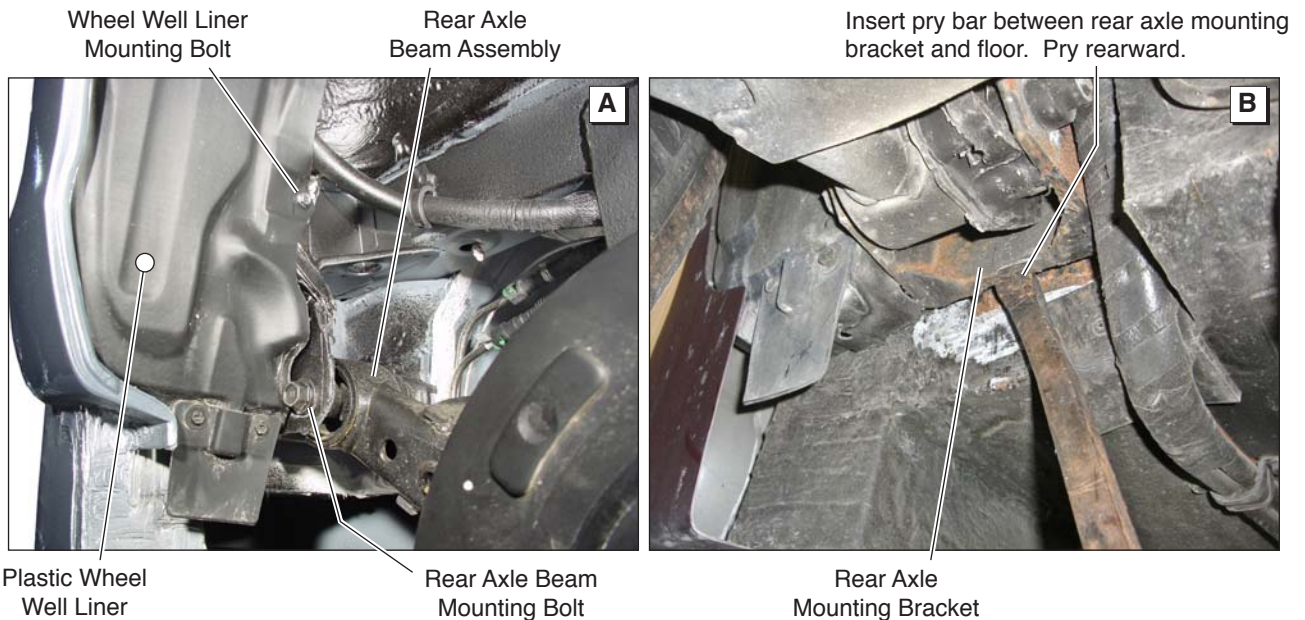
**Evaluate rear axle beam assembly mounting brackets and secure as detailed in this bulletin if required. Failure to do so may result in property damage.**

**Introduction:** In event of a rear suspension squeak in a Toyota Sienna Side Entry Rampvan® - refer to this bulletin. A suspension mounting bracket located just ahead of the driver side rear wheel could potentially loosen due to a stress fracture or broken weld. Movement of the bracket could result in squeaks or potentially a rough ride. Excessive tire wear may be visible.

This bulletin outlines the procedures required to examine the mounting bracket area and procedures for resecurement if needed. Review all procedures before beginning.

**Note:** For clarity, some photos appearing in this bulletin depict Rampvan® components during conversion processes. Infield vehicle components will be covered with debris, under coating and seam sealer.

### Evaluation



1. Raise and support the vehicle. A 4-point (pad) hoist is recommended in order to properly support the vehicle (pressure must be off rear wheels). Position pads at the four jacking points. **Do not** contact the lowered floor pan or lowered

door assemblies. Doing so may result in damage.

2. Remove the driver side rear tire to expose the wheel well. See Photo A. Remove the plastic wheel well liner. See Photo A.

3. Insert a pry bar between rear axle beam mounting bracket and the lowered floor pan. See Photo B. Attempt to pry the axle beam bracket rearward. The course of action to be taken is based on this procedure (details on next page).

# Toyota Sienna Rampvan® Rear Axle Beam Bulletin 34238

## Evaluation

### Action to be Taken:

If there is no movement of the rear axle or mounting brackets, and squeaking is not detected, no further action is required. **Disregard** the remainder of this bulletin. Reassemble (evaluation complete).

If there is **any movement** of the rear axle assembly mounting brackets, the mounting bracket(s) **must be resecured** as detailed in this bulletin. Review all procedures before beginning.

If movement is not visible but squeaking is detected, further examination is required. **Carefully** remove under coating and seam sealer from the mounting bracket area (see Photos C and D). Once brackets and welds are exposed, insert pry bar and attempt to move the mounting brackets again. If there is no

movement, no further action is required. **Disregard** the remainder of this bulletin. Apply under coating thoroughly over the exposed areas. Reassemble. If there is **any movement** of the rear axle assembly mounting brackets, the mounting bracket(s) **must be resecured** as detailed in this bulletin.

**Foldout Ramp Conversions:** Foldout Rampvan® conversions require evaluation and potential resecurement procedures of the driver side rear axle mounting brackets **only**.

**Infloor Ramp Conversions:** Inspection and evaluation procedures **must** be performed on driver side and passenger side rear axle mounting brackets. Perform resecurement procedures as required.

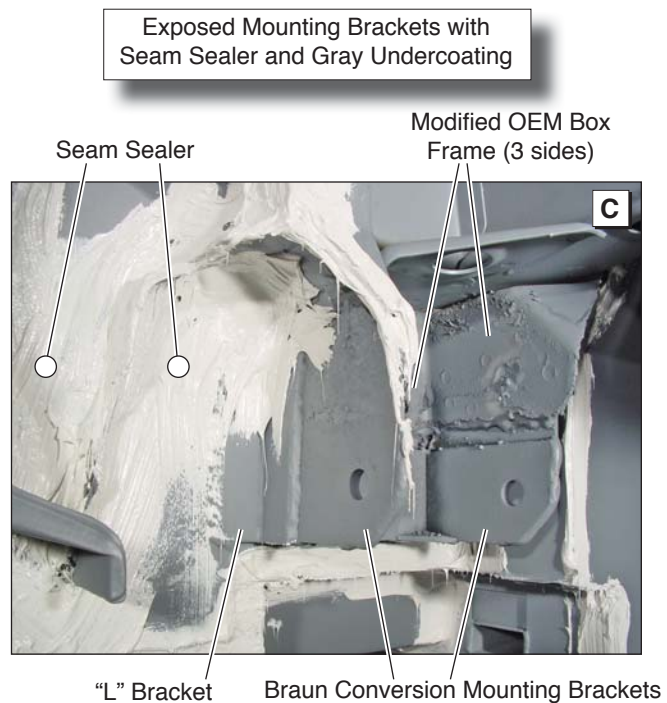
## Mounting Bracket Resecurement - Welding

If **any movement** of the rear axle mounting brackets is detected, the mounting bracket(s) **must be resecured** as specified in this bulletin. Re-weld the mounting brackets as detailed in this section (pages 2, 3 and 4). Then, bolt the brackets as detailed on pages 6 and 7. **Note:** Some procedures are exclusive to the type of conversion (foldout ramp vs infloor ramp). Disregard procedures that do not apply.

### Mounting Bracket Welding Specifications

**Note:** Photo C depicts the exposed mounting bracket area with seam sealer and gray under coating. Photo D depicts the mounting bracket area without seam sealer or under coating (exposing welds).

**“L” Reinforcement Bracket:** In event the “L” bracket identified in Photos C and D is not present, the bracket **must be replaced**. The “L” bracket **must** be welded into position as shown. There **must be solid penetrating welds** along both vertical edges of the bracket (see Photos D and E). **Note:** Specified welds have been highlighted in yellow in Photo E.



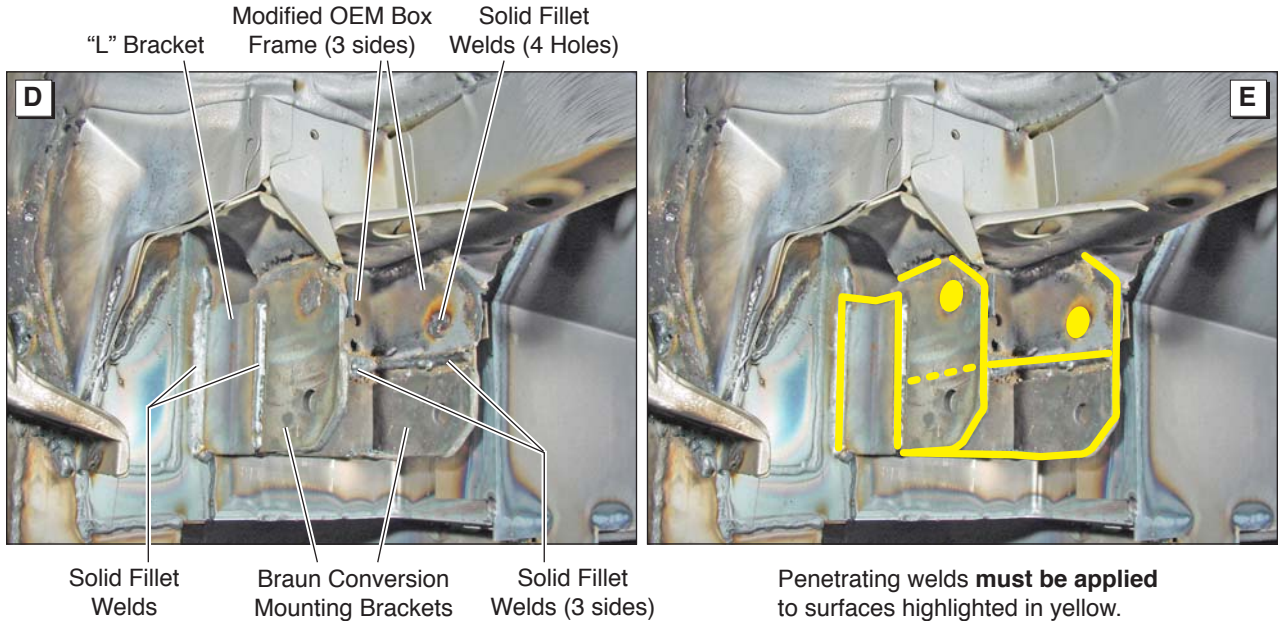
**OEM Box Frame-to-Conversion Brackets:** Conversion mounting brackets fit around the modified OEM box frame in a U-shape as shown in Photos C, D and E (3 sides). The holes identified in Photo D must be filled with weld (4 holes). There **must be solid penetrating welds** along the bottom horizontal edges of the modified OEM box frame.

# Toyota Sienna Rampvan® Rear Axle Beam Bulletin 34238

## Mounting Bracket Resecurement - Welding

Exposed Bare Metal  
Mounting Brackets and Welds

Mounting Bracket Welds  
Highlighted in Yellow



## Welding Precautions

### **⚠ DANGER**

Shield fuel system components before grinding, welding or working with any other source of ignition. Failure to do so may result in serious bodily injury, death and/or property damage.

### Safety First

Shield (cover) non-shielded fuel lines and other fuel system components with light flexible metal protective wrap (or substitute) before grinding or welding.

- Remove or adequately shield any electrical or electronic components which can be damaged by excessive temperatures created by the welding operation.
- Protect all wiring and electrical components from damage that can be caused by welding flash (sparks).
- Make sure that the welder ground clamp is of an adequate size and placed as close as possible to the area being welded. Never use a vehicle suspension component as a welding ground point. Ground to the vehicle body.

To avoid damaging the OEM and the Braun electrical systems or components during welding procedures, practice the following precautionary measures:

- Prior to any welding, disconnect all negative (ground) cable(s) from all battery(ies).

After the welding is complete, carefully inspect any electrical wiring or components in the weld area for degradation or damage.

# Toyota Sienna Rampvan® Rear Axle Beam Bulletin 34238

## Mounting Bracket Resecurement - Welding

If **any movement** of the rear axle mounting brackets was detected during evaluation procedures, the mounting bracket(s) **must be resecured**. Re-weld the mounting brackets as detailed in this section (Mounting Bracket Welding Specifications provided on pages 2 and 3). Review the welding precautions published on page 3 before beginning welding procedures. Then, bolt the brackets as detailed on pages 6 and 7.

1. Support rear axle beam assembly. Loosen and remove the axle beam assembly mounting hardware. Position the assembly clear of mounting bracket area.
2. Shield (cover) non-shielded fuel lines and other fuel system components with light flexible metal protective wrap (or substitute) **before** grinding or welding. See Photo F.
3. **Carefully** remove under coating and seam sealer from the weld areas. **Carefully** remove questionable weld(s). **Ensure** surfaces to be welded are free of weld slag and grinding debris.

Cover (shield) non-shielded fuel system components.



Fuel Line

Fuel Lines Fuel Tank

4. **Note: Review Welding Precautions** on page 3 of this bulletin **before welding**.

Apply fillet welds along the edges of brackets as specified on pages 2 and 3 and shown in Photos D and E (page 3). Ensure integrity of welds.

Proceed with the Mounting Bolt Retrofit procedures (**brackets must be bolted**).

**Infloor Conversion:** Driver side procedures depicted. If resecurement procedures are required for the passenger side axle mounting bracket, repeat procedures for the passenger side mounting bracket (mirror image).

### **⚠ DANGER**

Shield fuel system components before grinding, welding or working with any other source of ignition. Failure to do so may result in serious bodily injury, death and/or property damage.

5. Clean affected surfaces (be sure welding and grinding debris is removed). Under coating will be applied over affected areas following mounting bolt retrofit procedures.

# Toyota Sienna Rampvan® Rear Axle Beam Bulletin 34238

## Mounting Bracket Resecurement - Mounting Bolt Retrofit

**Mounting Bolts:** Install mounting bolts through the rear vertical face of the lowered floor pan and rear axle mounting brackets as specified in this section (detailed on pages 5-7). **Note:** Some procedures are exclusive to the type of conversion (foldout ramp vs infloor ramp). **Disregard** procedures that do not apply.

**Foldout Ramp Conversions:** Foldout Rampvan® conversions require a mounting bolt to be installed through the driver side rear axle mounting brackets **only**.

**Infloor Ramp Conversions:** Mounting bolts must be installed through the driver side and/or passenger side rear axle mounting brackets of Infloor conversions (per evaluation). If mounting bracket movement was detected during inspection and evaluation procedures, welding and bolt retrofit procedures **must** be performed accordingly.

**Note:** One bolt kit is supplied (bolt, soap dish washer and five body washers). If bolt retrofit procedures are required for driver and passenger side brackets, contact The Braun Corporation Product Support department at 1-800-THE LIFT® for additional parts.



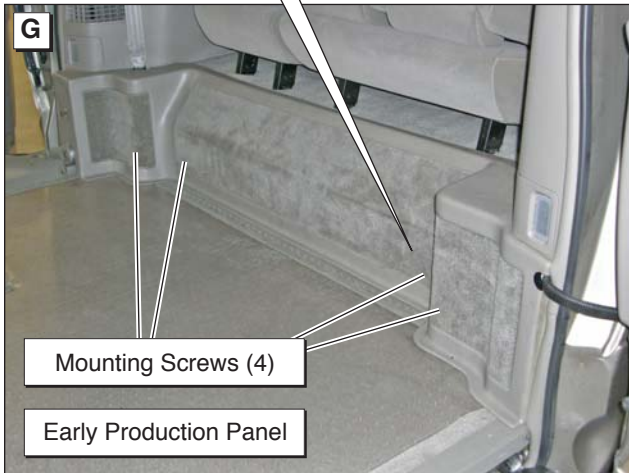
**Carefully** loosen corners of carpet to expose mounting screws.

Detail

Screws are inserted through carpet (black headed screws can be found using bright light).



Detail



G

Mounting Screws (4)  
Early Production Panel



H

Mounting Screws (2)  
Newer Production Panel

1. Remove the molded plastic panel secured to the rear vertical face of the lowered floor pan. **Note:** Two types of panels may be present (mounting hardware varies per type). Approximate mounting screw locations depicted above.

Earlier production panels are secured with four self-tapping screws (see Photo G). **Carefully** loosen the corners of the carpet to expose mounting screws (see Photo G Detail).

Newer production panels are secured with two self-tapping screws (see Photo H). Screws are inserted through the carpet (see Photo H Detail). The black headed screws can be located using a bright shop light.

# Toyota Sienna Rampvan® Rear Axle Beam Bulletin 34238

## Mounting Bracket Resecurement - Mounting Bolt Retrofit

- Locate bolt mounting holes. The soap dish body washer (32354) will be positioned against the rear lowered floor panel. The rear axle mounting plate securement bolt will be routed through the soap dish washer from the interior.

Locate **driver side** mounting bolt hole. The mounting hole location is exclusive for foldout ramp and infloor conversions. Locate hole centers as specified. Photos with dimensions are provided for each (see Photo I for foldout ramp conversions and Photo J for infloor conversions).

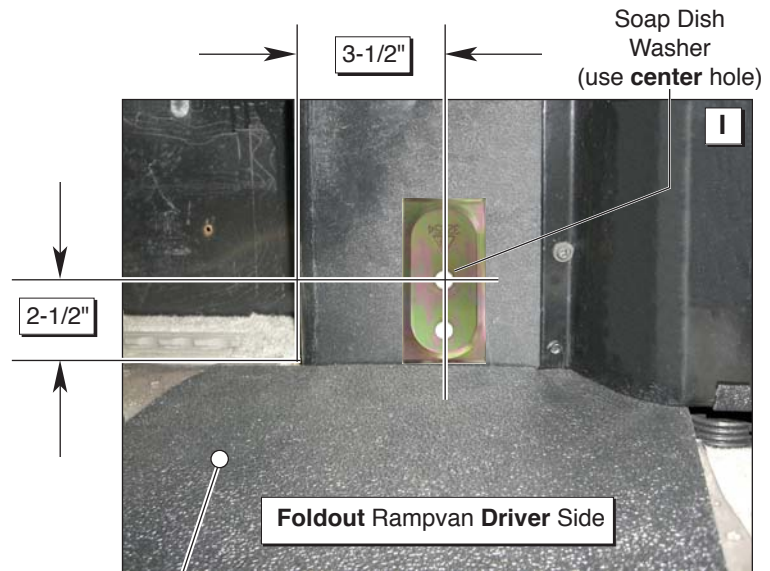
- Drill mounting bolt holes.

**Caution:** Provide protection on the vehicle floor. **Hot metal shavings** from drilling **will melt carpet**.

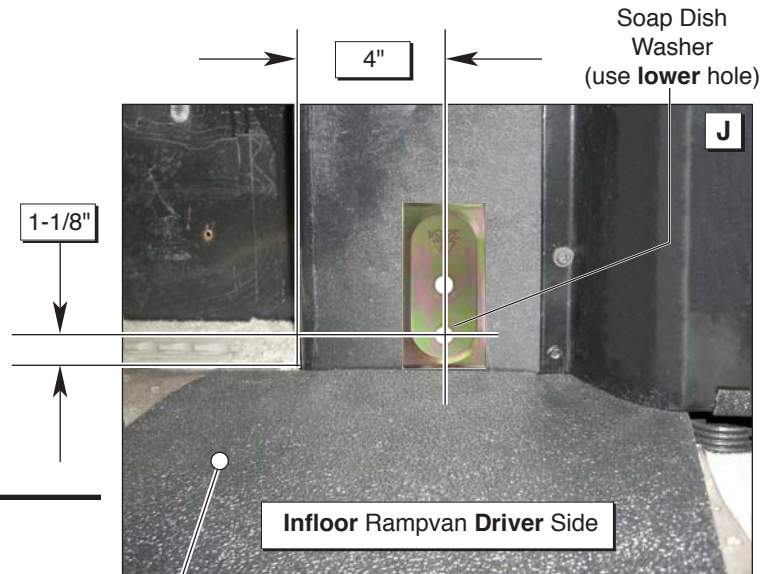
Center punch and **carefully** drill a pilot hole (1/8" to 1/4" diameter).

**Caution:** Be aware of depth. **Do not** drill into OEM axle components.

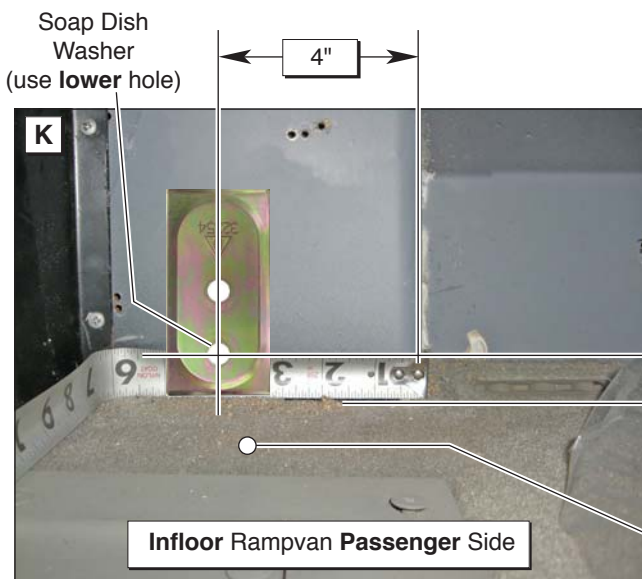
**Carefully** drill a 1/2" diameter mounting hole (watch depth).



**Caution:** Provide carpet protection.



**Caution:** Provide carpet protection.



### Infloor Only

- Locate and drill the **passenger side** mounting bolt hole (**Infloor conversion only**). Locate the hole as specified in Photo K at left. Repeat pilot hole and mounting hole drilling procedures (detailed above in Step 2). Follow same precautions.

**Caution:** Provide carpet protection.

# Toyota Sienna Rampvan® Rear Axle Beam Bulletin 34238

## Mounting Bracket Resecurement - Mounting Bolt Retrofit



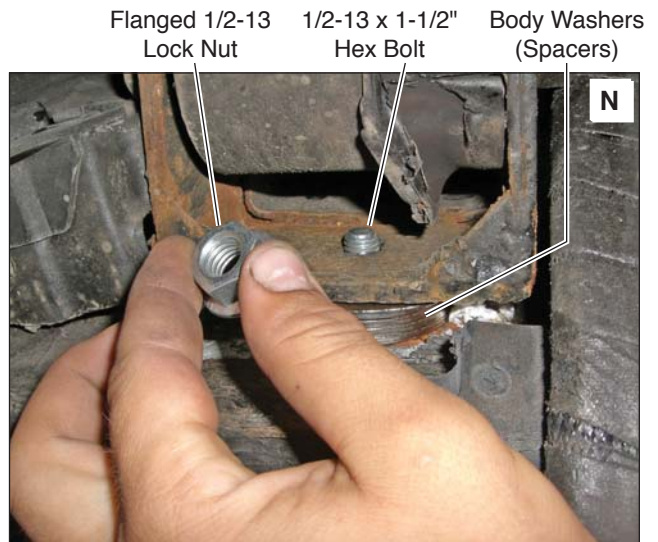
Soap Dish Washer  
1/2-13 x 1-1/2" Hex Bolt



Insert body washers in gap. Body Washers (Spacers) Rear Axle Mounting Bracket

- The 1/2-13 x 1-1/2" long hex bolt is to be inserted through the soap dish washer from the interior. See Photo L. There is a gap (space) between the lowered floor pan and the rear axle mounting bracket. Five 2-1/2" diameter flat body washers are supplied for use as spacers. Insert the required number of washers to fill the space.

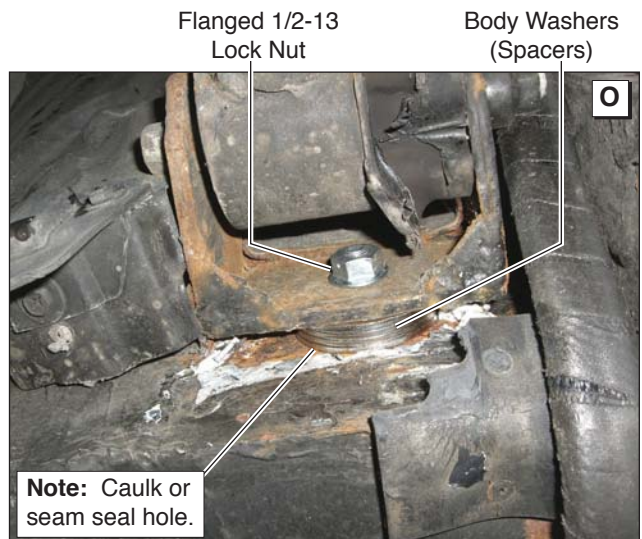
Insert the mounting bolt through the soap dish washer, floor pan, spacer washers and axle mounting bracket. See Photos L, M, N and O. **Note:** Apply caulk or seam seal to seal the mounting hole.



Flanged 1/2-13 Lock Nut 1/2-13 x 1-1/2" Hex Bolt Body Washers (Spacers)

Secure the bolt with the 1/2-13 flanged lock nut (see Photos N and O). Secure the nut with a wrench from below while an assistant tightens the bolt from above. Tighten securely. **Torque Specifications:** 57-80 foot pounds.

**Infloor Conversion:** Driver side bolt installation depicted in these photos. If a mounting bolt retrofit is required for the passenger side axle mounting bracket, repeat procedures for the passenger side mounting bracket (mirror image).



Flanged 1/2-13 Lock Nut Body Washers (Spacers)

**Note:** Caulk or seam seal hole.

## Toyota Sienna Rampvan® Rear Axle Beam Bulletin 34238

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### Mounting Bracket Resecurement - Reassemble

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6. Clean affected surfaces (be sure welding and grinding debris is removed). Apply under coating thoroughly over affected areas following welding and mounting bolt retrofit procedures.
7. Reposition rear axle beam assembly and secure using the previously removed mounting hardware. Tighten securely. **Torque Specifications:** 100 foot pounds.
8. Mount tire and wheel assembly. Tighten securely (follow OEM manual procedures). Lower vehicle.
9. Reposition and resecure the molded plastic panel secured to the rear vertical face of the lowered floor pan. Refer to page 4. **Note:** Corners of the carpet on early production panels will need to be re-glued after installing screws. See Photo G Detail.
10. Test drive vehicle. If there are any problems or this information is not fully understood, contact The Braun Corporation Product Support department at 1-800-THE LIFT®.