

Manual Slide Door Center Hinge Corrosion

Service Category Vehicle Exterior

Section Door/Hatch

Market USA

Toyota Supports
 ASE Certification 

Applicability

YEAR(S)	MODEL(S)	ADDITIONAL INFORMATION
2011 - 2018	Sienna	

Introduction

Some 2011 – 2018 model year Sienna vehicles equipped with manual doors may exhibit a condition where the slide door center hinge has corroded, causing the slide door to become difficult to operate while opening or closing. Follow the Inspection and Repair Procedures in this bulletin to address this condition.

Warranty Information

OP CODE	DESCRIPTION	TIME	OFF	T1	T2
BD1902	R & R Slide Door Center Hinge (One Side)*	0.4	68380-08040 68390-08040	97	17
Combo A	Opposite Side*	0.3			

*Use typical body shop sublettype "ZZ Other" for painting of the slide door center hinge.

APPLICABLE WARRANTY

- This repair is covered under the Toyota Basic 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 occurrence of the specified condition described in this bulletin.

Parts Information

PART NUMBER		PART NAME	QTY
PREVIOUS	NEW		
68380-08040	04009-02608	Hinge Assy, Slide Door, Center Hinge RH	1
68390-08040	04009-02708	Hinge Assy, Slide Door, Center Hinge LH	1

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Inspection Procedure

1. Does the slide door have other concerns related to the front latch or fuel lid?
 - **YES** — Diagnose and repair using the applicable Repair Manual, then continue to step 2.
 - **NO** — Continue to step 2.

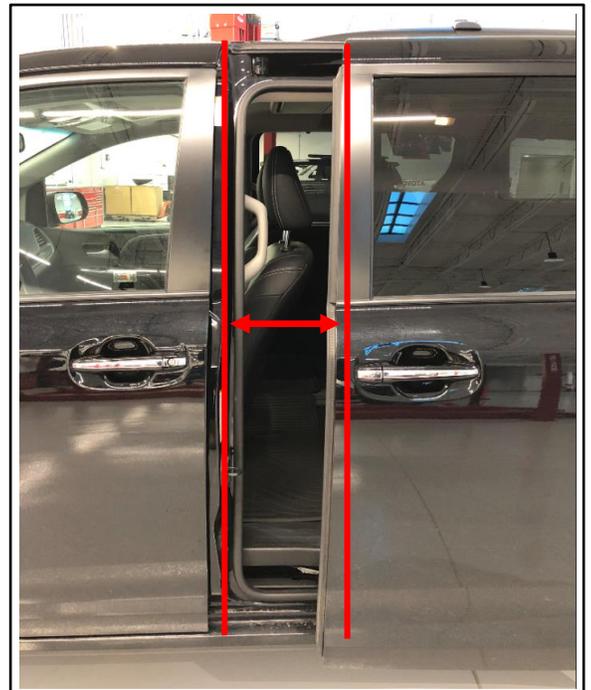
2. Scribe a line on the center hinge, as shown.

Figure 1.



3. Watch the scribe lines while manually moving the slide door forward and backward until just BEFORE the closed position and when the center hinge pivots.

Figure 2.



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Inspection Procedure (continued)

4. Confirm if the scribe lines rotate together or independently. (Refer to Figures 3 and 4 for examples of the scribe line rotation.)

Do the scribe lines rotate together when the hinge pivots, as shown in Figure 3?

- **YES** — If the scribe lines rotate together, then the pin and bushing are seized and the center hinge should be replaced. Continue to the Repair Procedure.
- **NO** — If the scribe lines rotate independently (as shown in Figure 4), then this bulletin does NOT apply. Continue diagnosis using the applicable Repair Manual.

Figure 3. NG Condition



Figure 4. OK Condition



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Repair Procedure

NOTE

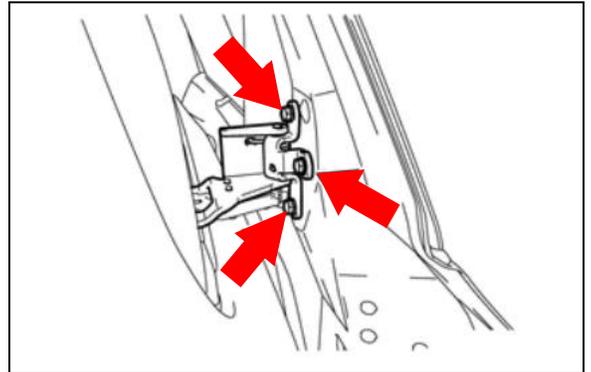
BEFORE installation of the NEW center hinge, be sure it is painted to match the exterior of the vehicle.

1. Remove the center hinge assembly.
 - A. Remove the three bolts and disconnect the center hinge.

NOTICE

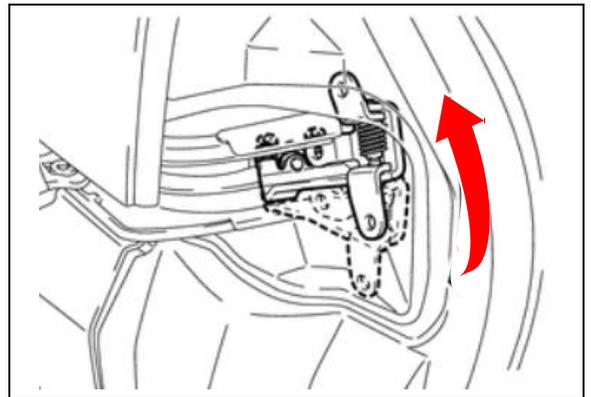
To prevent damage when removing the door, have someone hold the lower part of the door, as it will become unstable AFTER the center hinge is disconnected from the door body. The door will need to be held until the NEW center hinge is installed.

Figure 6.



- B. Move the center hinge to the front of the slide rail and remove it, as shown.

Figure 7.

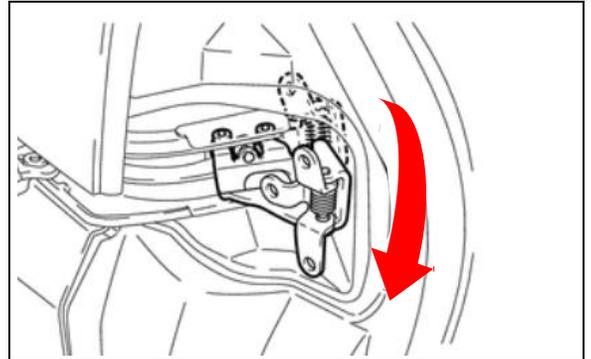


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Repair Procedure (continued)

2. Install the door center hinge assembly.
 - A. Install the NEW center hinge and move it to the rear of the slide rail, as shown.

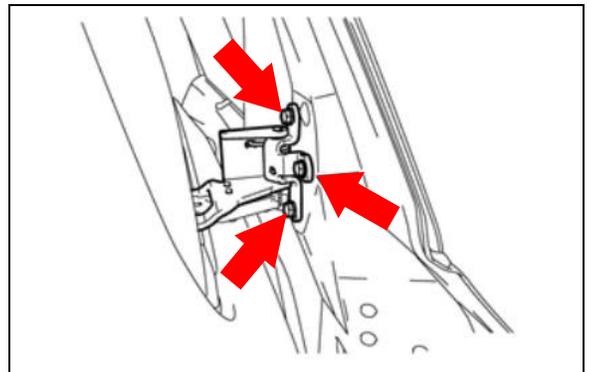
Figure 8.



- B. Install the center hinge with the three bolts.

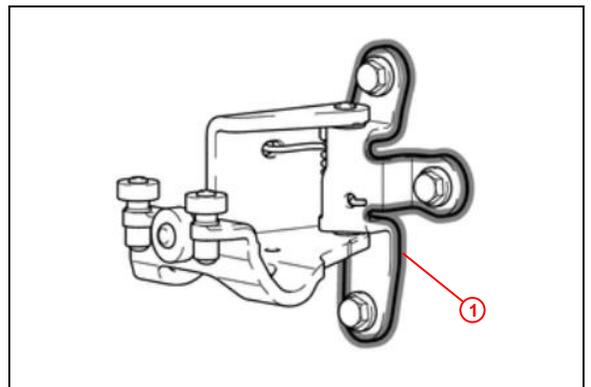
Torque: 31 N*m (316 kgf*cm, 23 ft*lbf)

Figure 9.



- C. Using a brush, apply an anti-rust coating to the center hinge, as shown.

Figure 10.



1	Anti-rust Coating
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3. Cycle the slide door to confirm the repair.