

Your Ultimate Source for OEM Repair Manuals

FactoryManuals.net is a great resource for anyone who wants to save money on repairs by doing their own work. The manuals provide detailed instructions and diagrams that make it easy to understand how to fix a vehicle.

Toyota Sienna 2020 Manual - Service & Repair Guide

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1180 MPa Ultra High Strength Steel	980 MPa Ultra High Strength Steel
780 MPa Ultra High Strength Steel	440 MPa High Strength Steel
390 MPa High Strength Steel	340 MPa High Strength Steel

PROHIBITION OF MODIFYING ALUMINUM FRAME PARTS

- Aluminum frame parts must not be repaired by the frame aligning machine. Replace the parts when aligning.
- Aluminum frame parts must be replaced in case that crack or deformation is found by visual inspection or measurement. Insert blind rivet nuts or bolts and tighten down with rivet tool .

REMOVING SELF-TAPPING SCREWS

HINT:

- Schematic diagram is for example purposes.
- Some parts may differ in certain details.



- (a) Remove the sealant with a wire brush attachment (1).
- (b) Completely remove the sealant from the screw head (2).
- (c) Vertically position the battery-powered drill (1) using special tool 09800-WA080 on the self-tapping screw and release the self-tapping screw.



HINT:

- Schematic diagram is for example purposes.
- Some parts may differ in certain details.



- (k) Secure the template (1) with adhesive tapes (3).
- (I) Turn the new part around.

HINT:

The X marks must not be visible from this view.



- (m) Set punch marks at the pressed through centre points (1). Provide counter support directly below the punch marks for punching.
- (n) Remove the template (2).
- (o) At the punch marks (1) drill bore holes with a diameter of approximately 3 mm (0.12 in.).
- (p) Position the new part (1) on the vehicle.



(q) Drill out the bore holes (2) to a diameter of 6.8 mm (0.27 in.).

FIX BOLTS ON THE NEW PART

(a) Single ball/double ball (version 1):



(4) Bond repair element optionally with adhesive K1, K5 or window pane adhesive at the same position.(c) Coarse threaded bolt (version 1):



- (1) Grind off any residues of the coarse threaded bolt (1), if applicable.
- (2) Spot weld coarse threaded bolt to same position.



(d) Coarse threaded bolt (version 2):





(e) If the rivet shank can be removed.

(1) Preserving cavity

HINT:

- To avoid corrosion, stop chips/swarf by means of cavity preservation.
- Follow notes on corrosion protection.



(f) If the rivet shank cannot be removed.



(1) Stop rivet shank by means of specific foaming.

NOTICE:

- Danger of injury!
- Observe notes on cavity foam.

HINT:

- To avoid corrosion and rattling noises, stopchips/swarf and rivet nut shank with cavity foam.
- Remove foam remnants with isohexane (benzine).
- (g) Set rivet nut with 09000-WA040.

HINT:

Fit rivet nut as quickly as possibly, ideally before the cavity foam hardens.