

Section : Body

Ref. No. : B-2012

Date : Jun., 2002

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Area Application : Others (Thailand)

Model Name : HIACE

Model Code : RZH153R

**Subject : SUPPLEMENTAL FOR REPAIR MANUAL (Slide Door)**

This Service Bulletin is to inform you of the slide door repair procedures for HIACE due to change from August 2002 model.

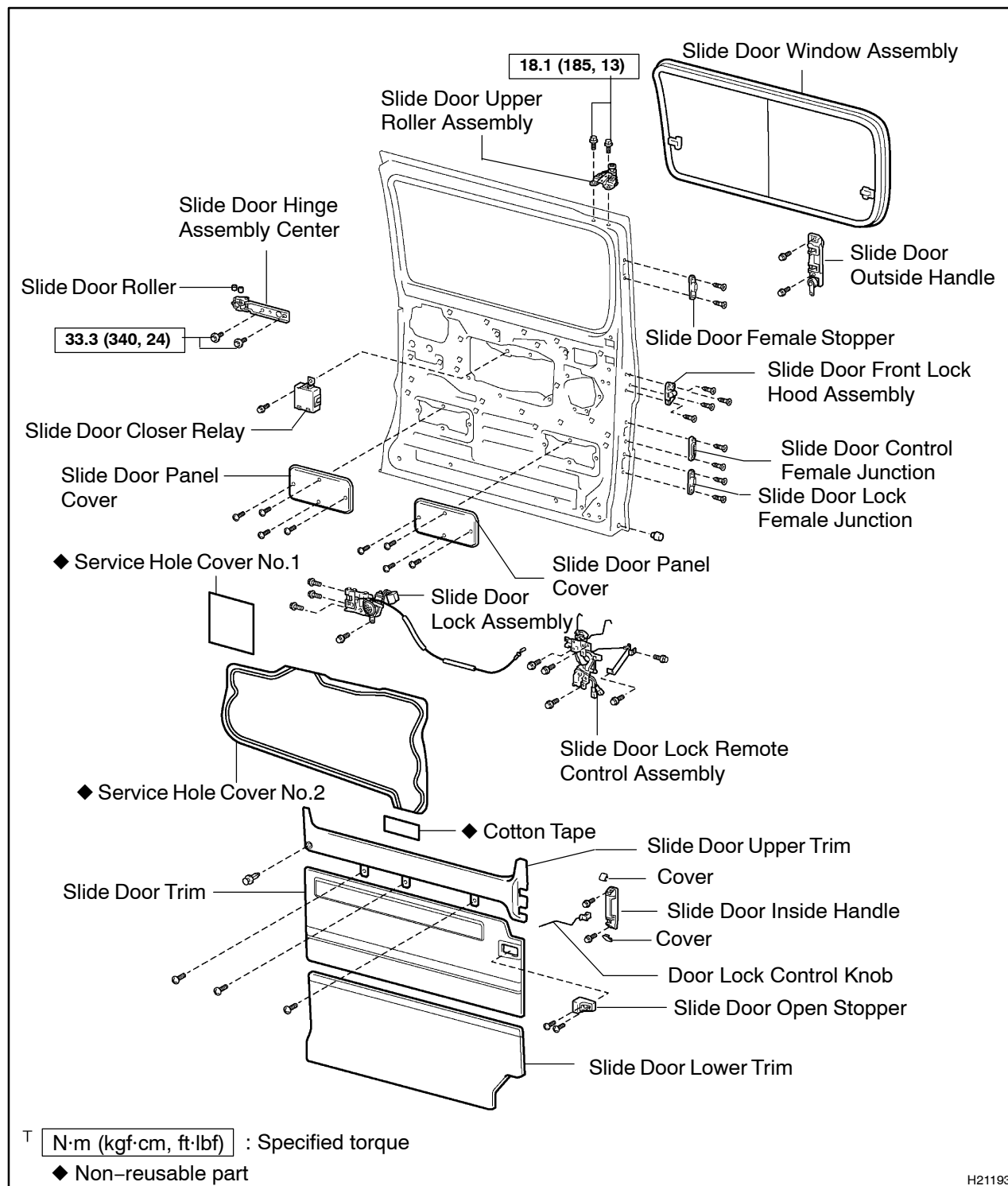
For all the other procedures, please refer to the following Repair Manual.

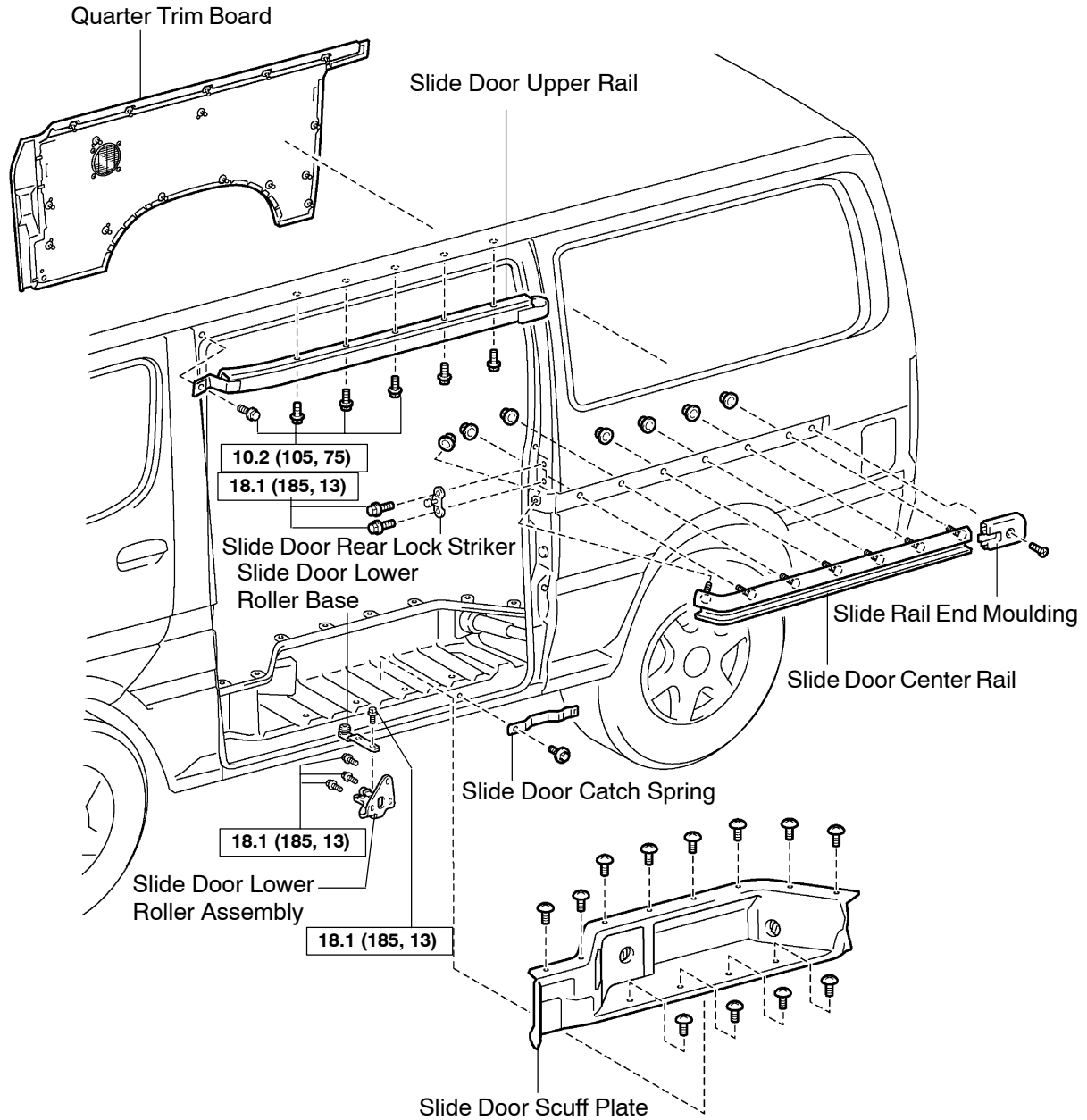
Pub. No.	Publication Name
RM156E	HIACE Repair Manual
RM471E	HIACE Repair Manual Supplement
RM670E	HIACE Repair Manual Supplement
RM709E	HIACE Repair Manual Supplement

Production Effective :

Frame No.	Production Date
---	From August, 2002

## SLIDE DOOR COMPONENTS

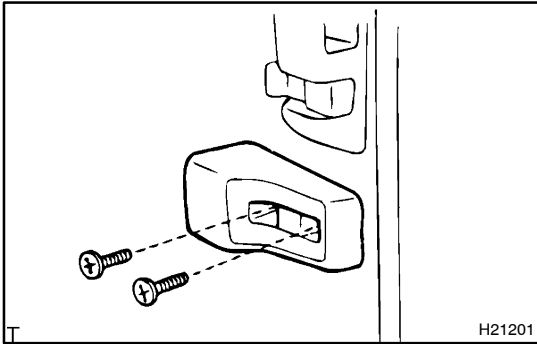




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N·m (kgf·cm, ft·lbf) : Specified torque

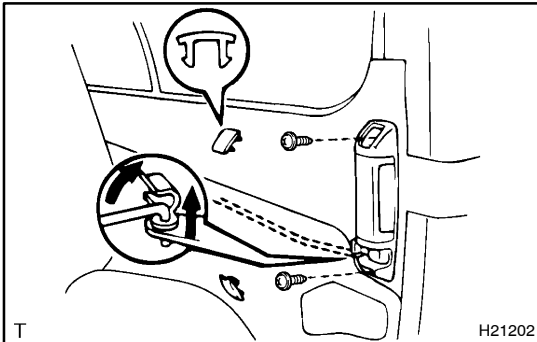
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## DISASSEMBLY

### 1. REMOVE SLIDE DOOR OPEN STOPPER

Remove the 2 screws and slide door open stopper.



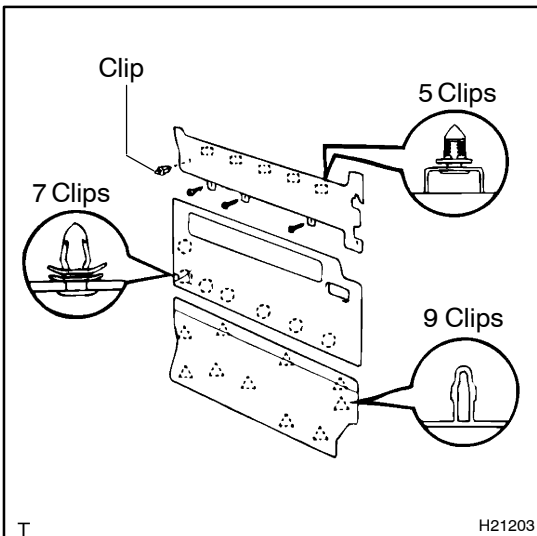
### 2. REMOVE SLIDE DOOR INSIDE HANDLE

(a) Using a screwdriver, remove the 2 covers.

HINT:

Tape the screwdriver tip before use.

(b) Remove the 2 screws and slide door inside handle, and then disconnect the link.



### 3. REMOVE DOOR TRIMS

(a) Using a screwdriver, pry out the slide door lower trim.

HINT:

Tape the screwdriver tip before use.

(b) Using a screwdriver, pry out the slide door trim.

HINT:

Tape the screwdriver tip before use.

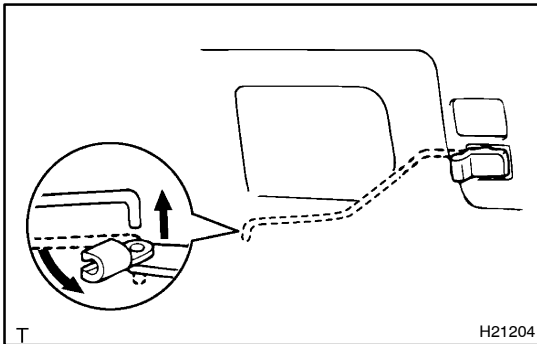
(c) Remove the 3 screws and clip.

(d) Using a screwdriver, pry out the slide door upper trim.

HINT:

Tape the screwdriver tip before use.

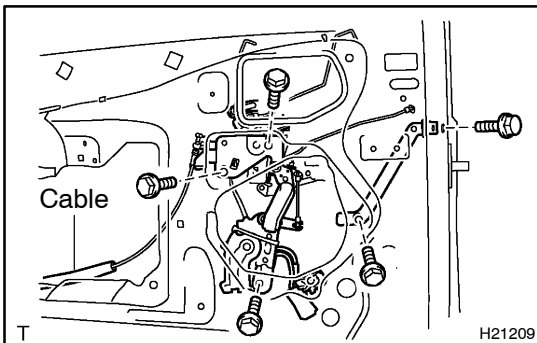
### 4. REMOVE SERVICE HOLE COVERS

**5. REMOVE DOOR LOCK CONTROL KNOB**

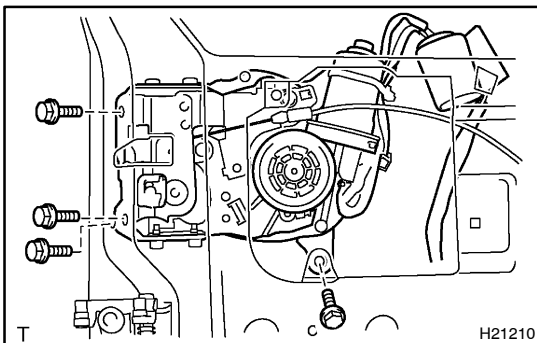
- (a) Disconnect the link from the slide door lock remote control assembly and door lock control knob.

**6. REMOVE SLIDE DOOR OUTSIDE HANDLE**

- (a) Disconnect the 2 links from the slide door lock remote control assembly.
- (b) Remove the 2 bolts and slide door outside handle.

**7. REMOVE SLIDE DOOR LOCK REMOTE CONTROL ASSEMBLY**

- (a) Remove the 5 bolts.
- (b) Disconnect the connectors.
- (c) Remove the slide door lock remote control assembly, and then disconnect the cable from the slide door lock assembly.

**8. REMOVE SLIDE DOOR LOCK ASSEMBLY**

- (a) Remove the 4 bolts.
- (b) Remove the slide door lock assembly, and then disconnect the connector.

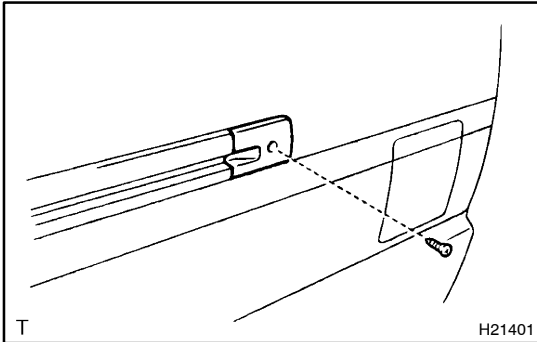
**9. REMOVE SLIDE DOOR CLOSER RELAY**

- (a) Disconnect the connectors.
- (b) Remove the bolt and slide door closer relay.

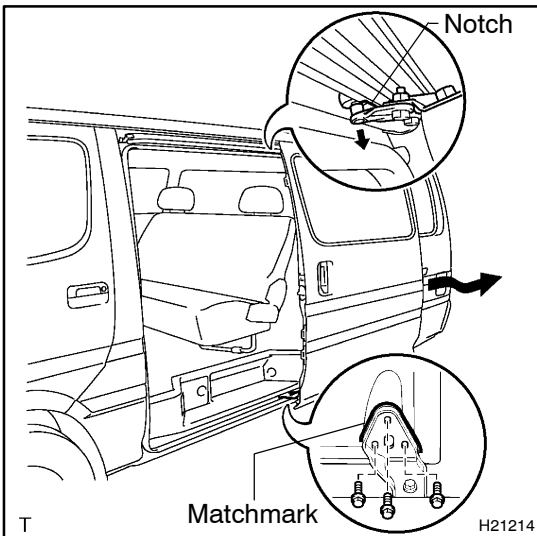
**10. REMOVE SLIDE DOOR PANEL COVERS**

Remove the 8 screws and 2 slide door panel covers.

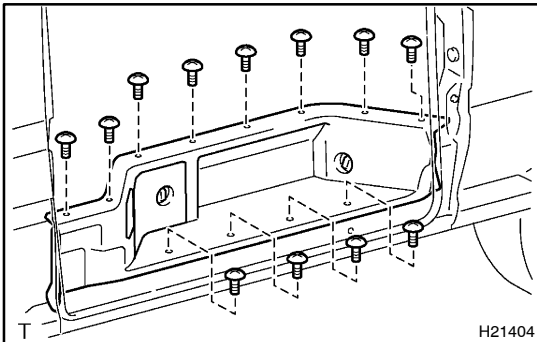
**11. REMOVE SLIDE DOOR WINDOW ASSEMBLY**  
(See page BO-41 in Pub No. RM156E)



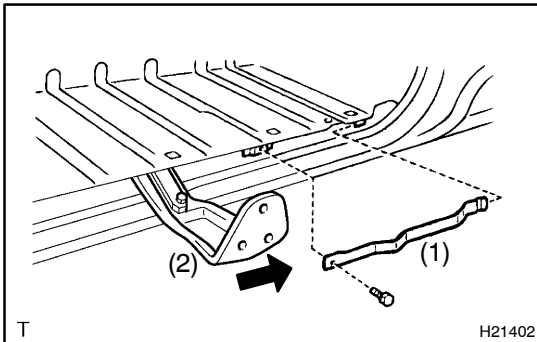
- 12. REMOVE SLIDE DOOR PANEL ASSEMBLY**  
(a) Remove the screw and slide rail end moulding.



- (b) As shown in the illustration, place a matchmark on the slide door panel assembly.  
(c) Remove the 3 bolts.  
**Torque: 18.1 N·m (185 kgf·cm, 13 ft·lbf)**  
(d) Align the slide door upper roller with the notch on the slide door upper rail.  
(e) Pull out the slide door upper roller, and slide the slide door panel assembly rearward. Then remove the slide door panel assembly.



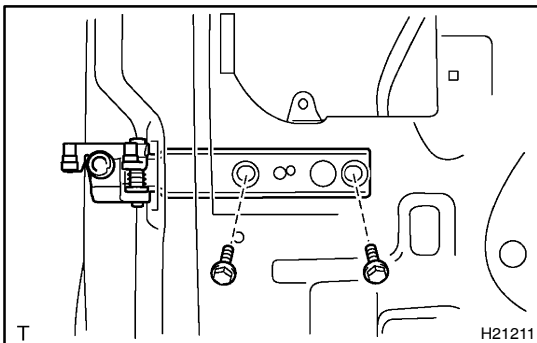
- 13. REMOVE SLIDE DOOR SCUFF PLATE**  
(a) Remove the 12 screws.  
(b) Remove the slide door scuff plate, and then disconnect the connector.



**14. REMOVE SLIDE DOOR LOWER ROLLER ASSEMBLY**

- (a) Remove the bolt and slide door catch spring.
- (b) Remove the slide door lower roller assembly.
- (c) Remove the bolt and slide lower roller base.

**Torque: 18.1 N·m (185 kgf·cm, 13 ft·lbf)**



**15. REMOVE SLIDE DOOR HINGE ASSEMBLY CENTER**

- (a) Remove the 2 bolts and slide door hinge assembly center.

**Torque: 33.3 N·m (340 kgf·cm, 24 ft·lbf)**

- (b) Remove the 2 slide door rollers.

**16. REMOVE SLIDE DOOR UPPER ROLLER ASSEMBLY**

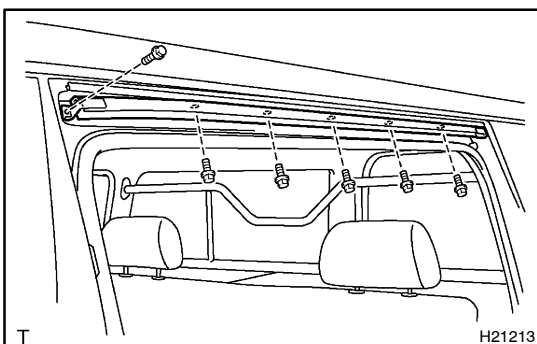
- (a) Remove the 2 bolts and slide door upper roller assembly.

**Torque: 18.1 N·m (185 kgf·cm, 13 ft·lbf)**

**17. REMOVE SLIDE DOOR FEMALE STOPPERS**

**18. REMOVE SLIDE DOOR FRONT LOCK HOOD ASSEMBLY**

**19. REMOVE SLIDE DOOR CONTROL FEMALE JUNCTION**

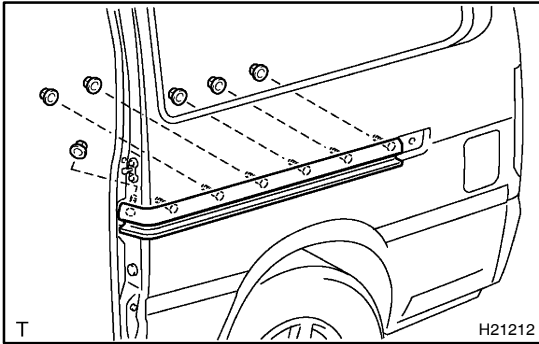


**20. REMOVE SLIDE DOOR UPPER RAIL**

Remove the 6 bolts and slide door upper rail.

**Torque: 10.2 N·m (105 kgf·cm, 75 ft·lbf)**

**21. REMOVE QUARTER TRIM BOARD (See page BO-41 in Pub No. RM156E)**



## 22. REMOVE SLIDE DOOR CENTER RAIL

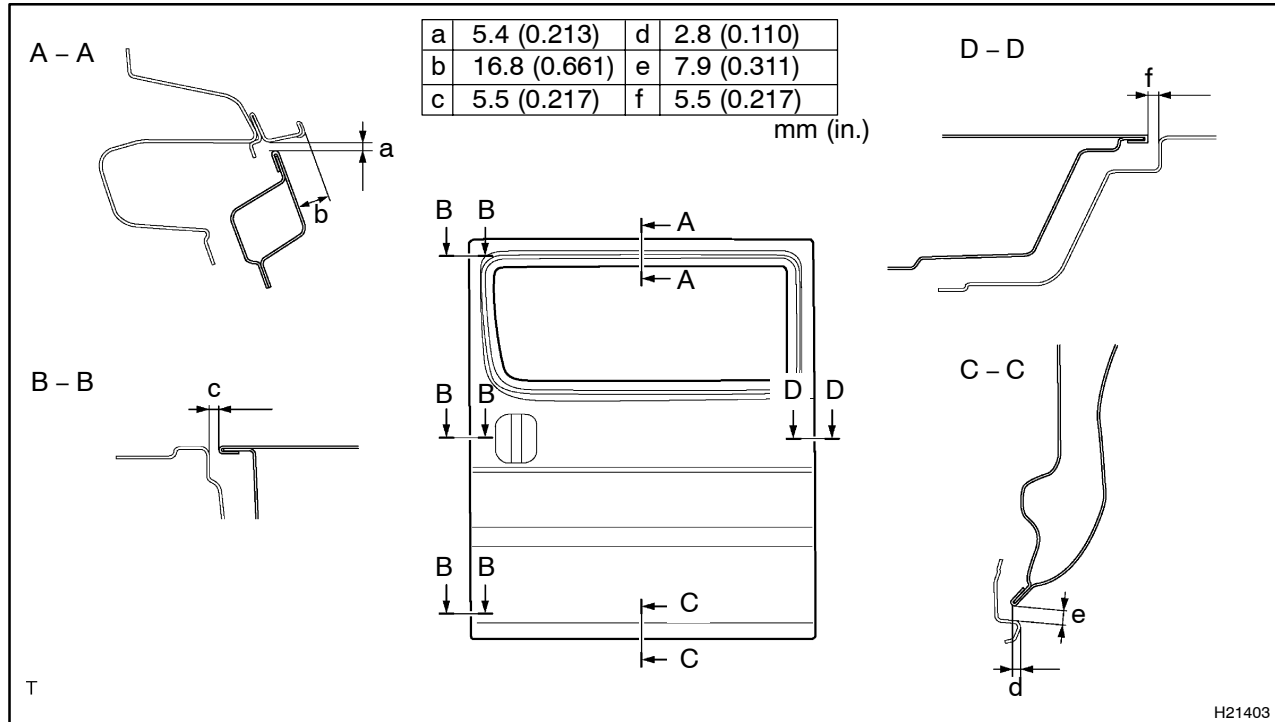
Remove the 6 nuts and slide door center rail.



## ADJUSTMENT

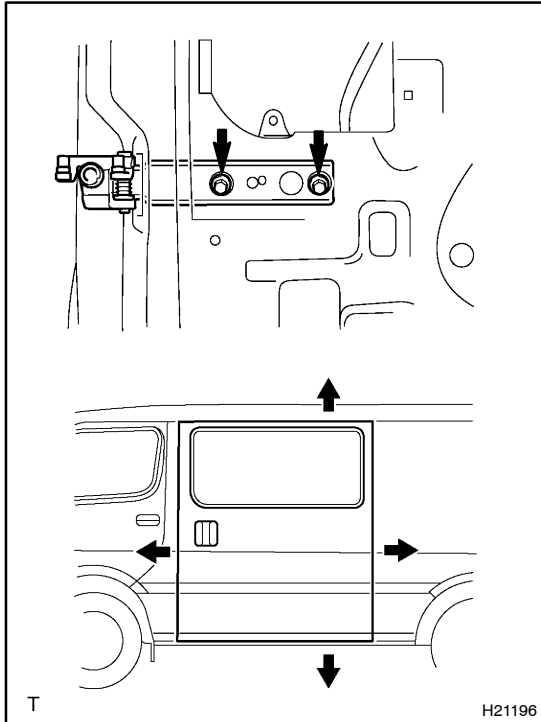
### 1. INSPECT SLIDE DOOR

Check that the clearance is within the standard value.

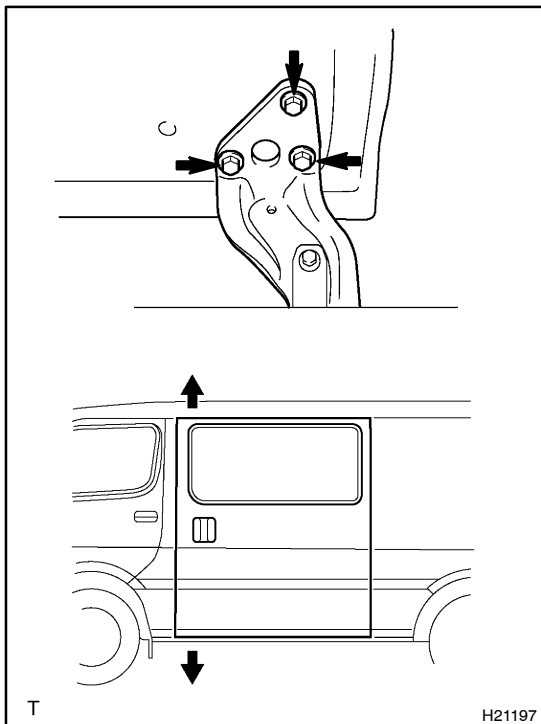


### 2. ADJUST REAR SIDE OF DOOR IN VERTICAL AND HORIZONTAL DIRECTIONS

- Remove the 2 bolts slide door rear lock striker.
- Remove the door trims. (See page 3)



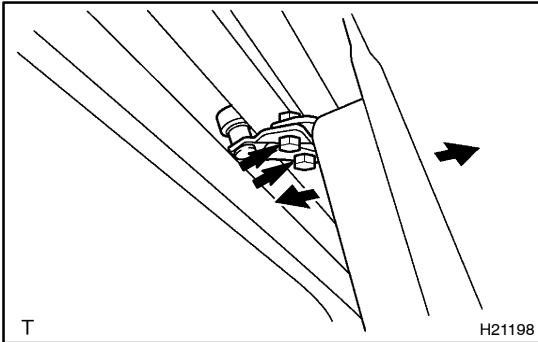
- (c) Loosen the 2 bolts to adjust the slide door.  
**Torque: 33.3 N·m (340 kgf·cm, 24 ft·lbf)**



### 3. ADJUST FRONT SIDE OF DOOR IN VERTICAL DIRECTIONS

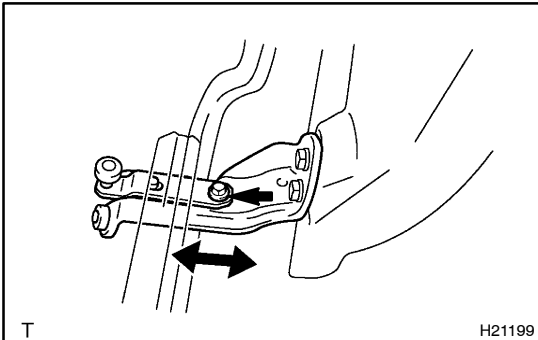
Loosen the 3 bolts to adjust slide door.

**Torque: 18.1 N·m (185 kgf·cm, 13 ft·lbf)**

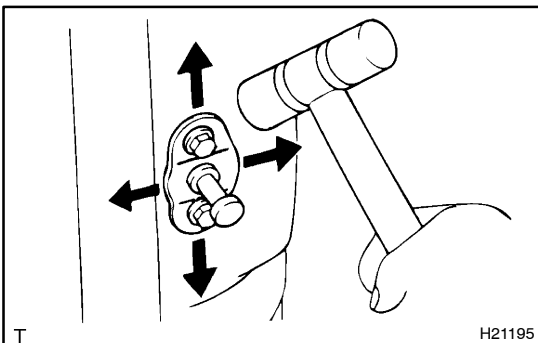


#### 4. ADJUST DOOR IN HORIZONTAL

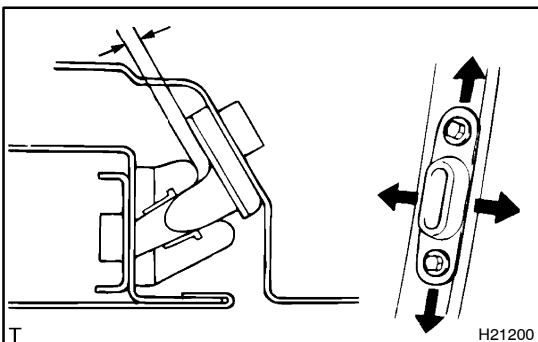
- (a) Loosen the 2 bolts to adjust slide door.  
**Torque: 18.1 N·m (185 kgf·cm, 13 ft·lbf)**



- (b) Loosen the bolt to adjust slide door.  
**Torque: 18.1 N·m (185 kgf·cm, 13 ft·lbf)**

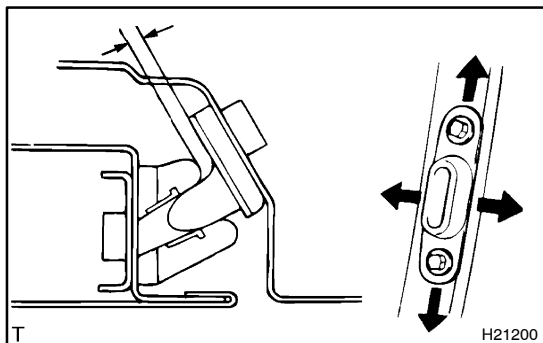


- (c) Check that the door fit and door lock linkage are adjusted correctly.  
(d) Using a plastic-faced hammer, tap the side door rear lock striker to adjust slide door.  
**Torque: 18.1 N·m (185 kgf·cm, 13 in·lbf)**



#### 5. ADJUST SLIDE DOOR FEMALE STOPPERS

- (a) Loosen the 2 bolts.  
(b) With the door closed, adjust the slide door female stoppers so that they may be placed 3.0 mm (0.12 in.) above the race.

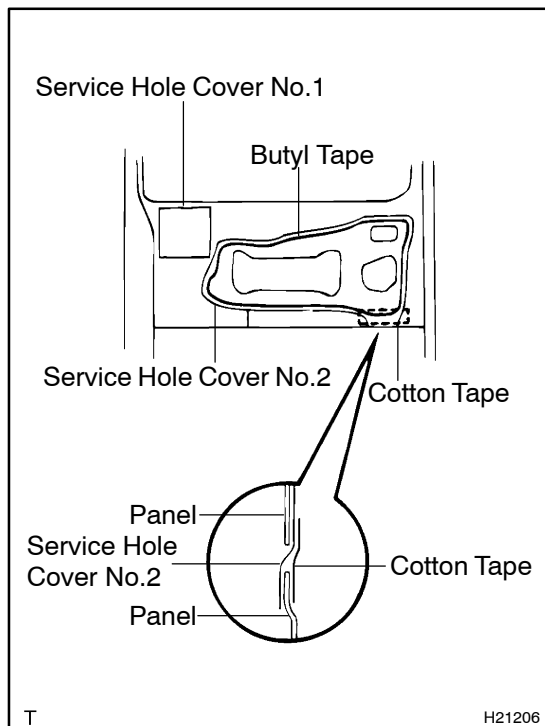


## 6. ADJUST SLIDE DOOR LOCK FEMALE JUNCTION

- (a) Loosen the 2 bolts.
- (b) With the door closed, adjust the slide door lock female junction so that they may be placed 3.0 mm (0.12 in.) above the race.

## REASSEMBLY

The installation is in the reverse order of the removal. However, when there is a special point concerning the installation, it is indicated.



## INSTALL SERVICE HOLE COVERS

- (a) Install the service hole cover No.2 with butyl tape.  
**Adhesive: Part No. 08850-00065 or equivalent**
- (b) Insert the lower edge of the cover into the panel slit.
- (c) Cover the panel slit with the cotton tape.

### NOTICE:

**Do not apply the tape over the trim clip seating position.**

- (d) Install the service hole cover No.1.