

<b>Last Modified:</b> 12-04-2024	6.11:8.1.0	<b>Doc ID:</b> RM1000000029UVT
<b>Model Year Start:</b> 2023	<b>Model:</b> Prius Prime	<b>Prod Date Range:</b> [12/2022 - ]
<b>Title:</b> M20A-FXS (EMISSION CONTROL): EGR VALVE: INSTALLATION; 2023 - 2024 MY Prius Prius Prime [12/2022 - ]		

## INSTALLATION

### CAUTION / NOTICE / HINT

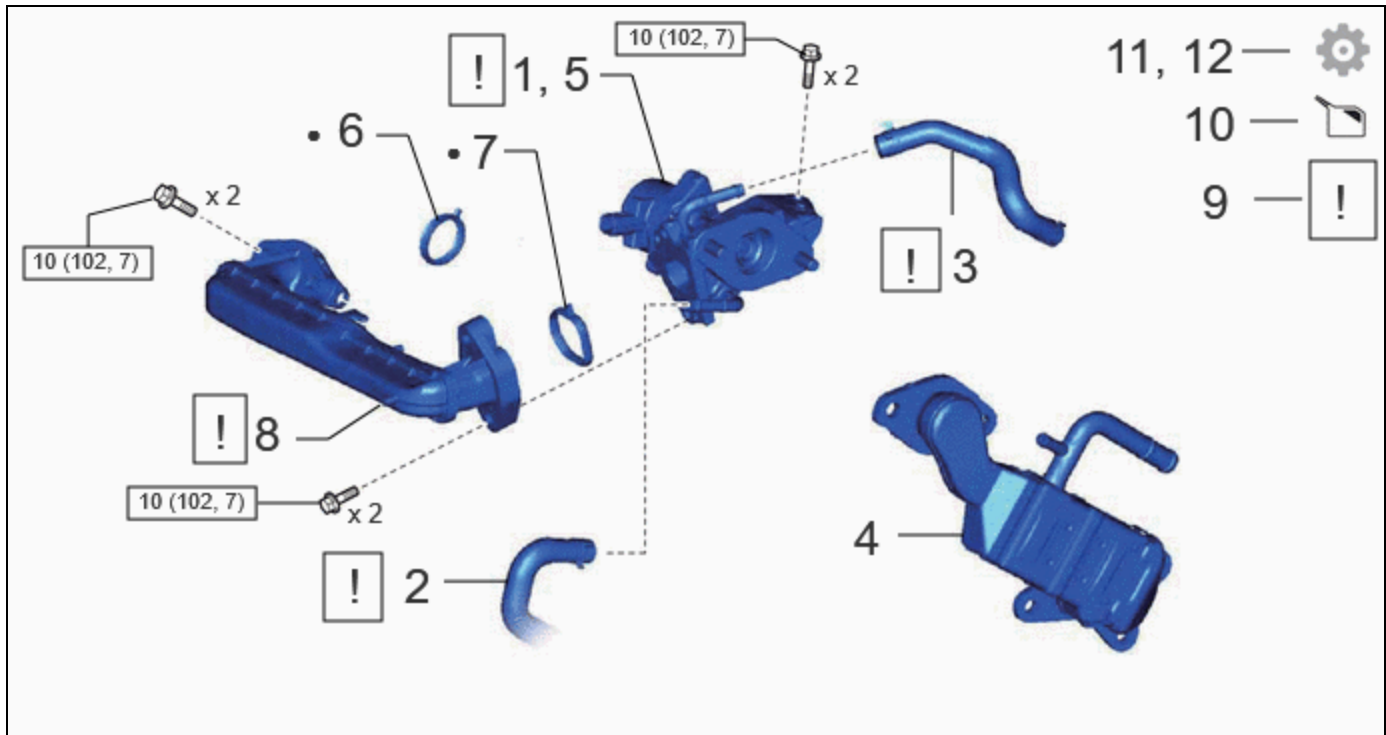
**NOTICE:**

This procedure includes the installation of small-head bolts. Refer to Small-Head Bolts of Basic Repair Hint to identify the small-head bolts.




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### CAUTION / NOTICE / HINT

#### COMPONENTS (INSTALLATION)



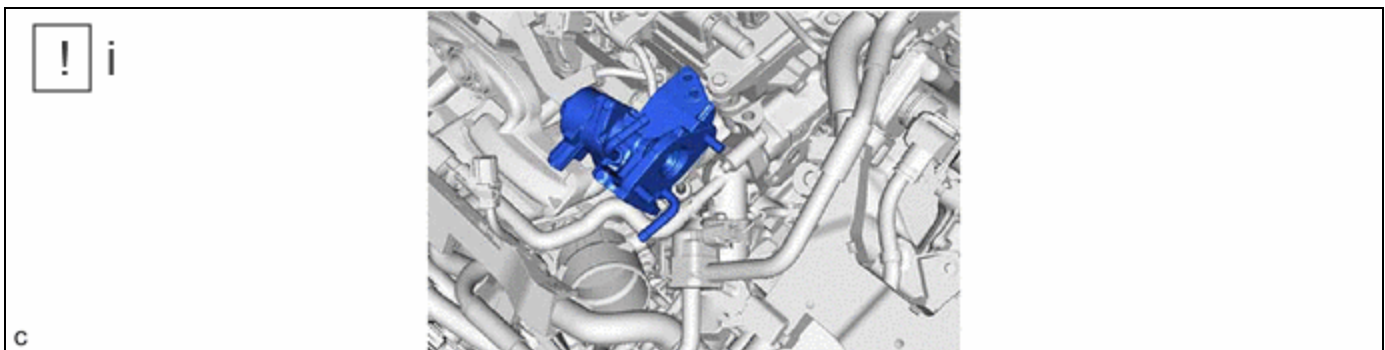
	PROCEDURE	PART NAME CODE			
1	SET EGR VALVE ASSEMBLY	25620	<a href="#">INFO</a>	-	-
2	NO. 8 WATER BY-PASS HOSE	16296	<a href="#">INFO</a>	-	-
3	NO. 4 WATER BY-PASS HOSE	16281	<a href="#">INFO</a>	-	-
4	EGR COOLER ASSEMBLY	25680	-	-	-

PROCEDURE		PART NAME CODE			
5	INSTALL EGR VALVE ASSEMBLY	25620	INFO	-	-
6	EGR INLET GASKET	25628	-	-	-
7	EGR VALVE ADAPTER GASKET	25629	-	-	-
8	NO. 1 EGR PIPE SUB-ASSEMBLY	25601	INFO	-	-
9	ADD ENGINE COOLANT	-	-	INFO	-
10	INSPECT FOR COOLANT LEAK	-	INFO	-	-
11	INSPECT FOR EXHAUST GAS LEAK	-	-	-	INFO
12	PERFORM INITIALIZATION	-	-	-	INFO

	N*m (kgf*cm, ft.*lbf): Specified torque	<ul style="list-style-type: none"> <li>• Non-reusable part</li> </ul>
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## PROCEDURE

### 1. SET EGR VALVE ASSEMBLY

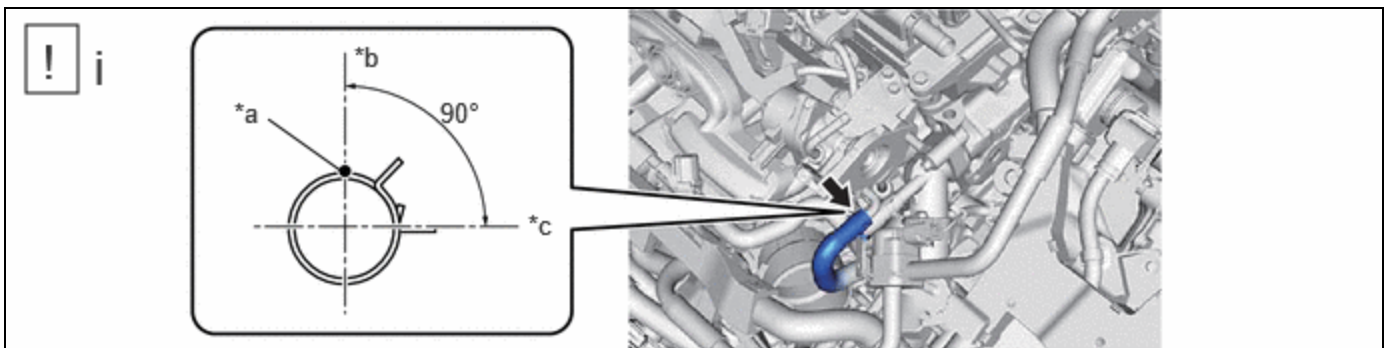


(1) Set the EGR valve assembly to the camshaft housing.

**HINT:**

At this time, do not install the parts with bolts.

### 2. CONNECT NO. 8 WATER BY-PASS HOSE



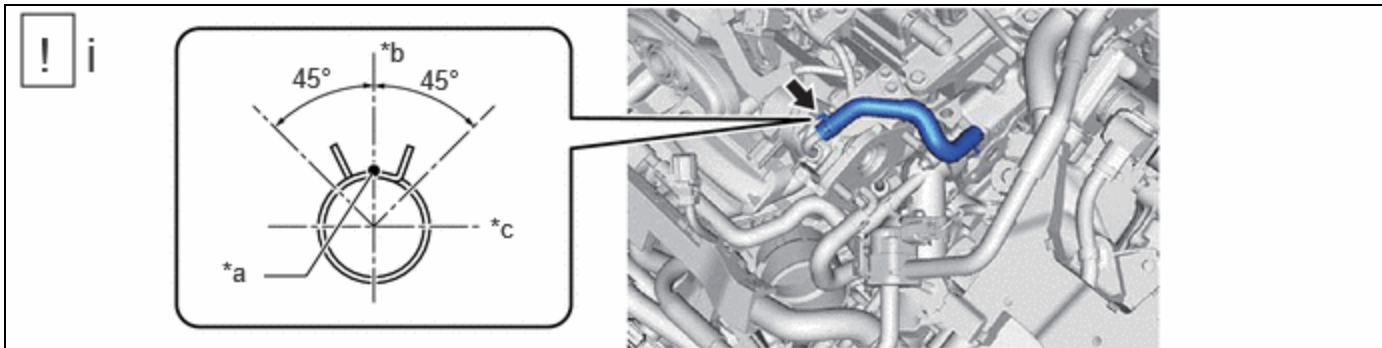
*a	Paint Mark	*b	Upper Side of Vehicle
*c	Left Side of Vehicle	-	-

(1) Connect the No. 8 water by-pass hose to the EGR valve assembly and slide the clip to secure it.

**HINT:**

Engage the clip within the area shown in the illustration.

**3. INSTALL NO. 4 WATER BY-PASS HOSE**



*a	Paint Mark	*b	Upper Side of Vehicle
*c	Left Side of Vehicle	-	-

(1) Connect the No. 4 water by-pass hose to the EGR valve assembly and slide the clip to secure it.

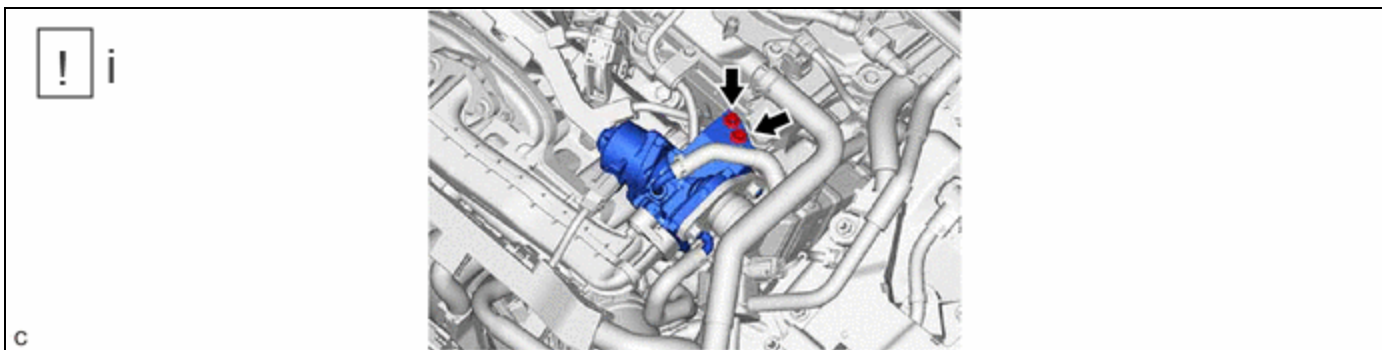
**HINT:**

Engage the clip within the area shown in the illustration.

**4. INSTALL EGR COOLER ASSEMBLY**

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**5. INSTALL EGR VALVE ASSEMBLY**



(1) Using the 8 mm socket wrench, install the EGR valve assembly with the 2 bolts.

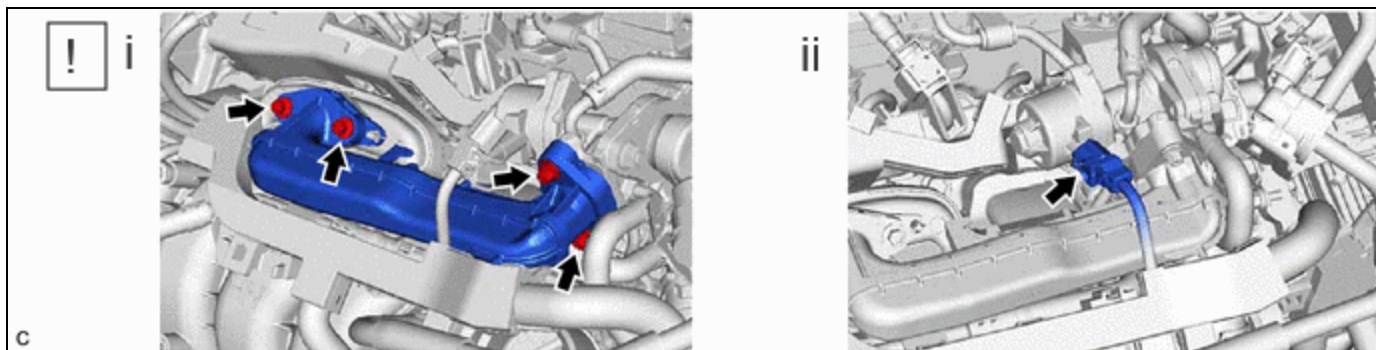
**Torque:**

**10 N·m {102 kgf·cm, 7 ft·lbf}**

**6. INSTALL EGR INLET GASKET**

**7. INSTALL EGR VALVE ADAPTER GASKET**

**8. INSTALL NO. 1 EGR PIPE SUB-ASSEMBLY**



- (1) Using an 8 mm socket wrench, install the No. 1 EGR pipe sub-assembly to the intake manifold and EGR valve assembly with the 4 bolts.

**Torque:**

**10 N·m {102 kgf·cm, 7 ft·lbf}**

- (2) Connect the EGR valve assembly connector.

## 9. ADD ENGINE COOLANT (for Engine)

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## 10. INSPECT FOR COOLANT LEAK



## 11. INSPECT FOR EXHAUST GAS LEAK

- (a) If gas is leaking, tighten the areas necessary to stop the leak. Replace damaged parts as necessary.

**HINT:**

Perform "Inspection After Repairs" after repairing or replacing the exhaust system.

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## 12. PERFORM INITIALIZATION

- (a) Perform "Inspection After Repair" after replacing the EGR valve assembly.

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