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Model Year Start: 2023	Model: Prius Prime	Prod Date Range: [12/2022 -]
Title: M20A-FXS (FUEL): FUEL INJECTOR (for Port Injection): INSTALLATION; 2023 - 2024 MY Prius Prius Prime [12/2022 -]		

INSTALLATION

CAUTION / NOTICE / HINT

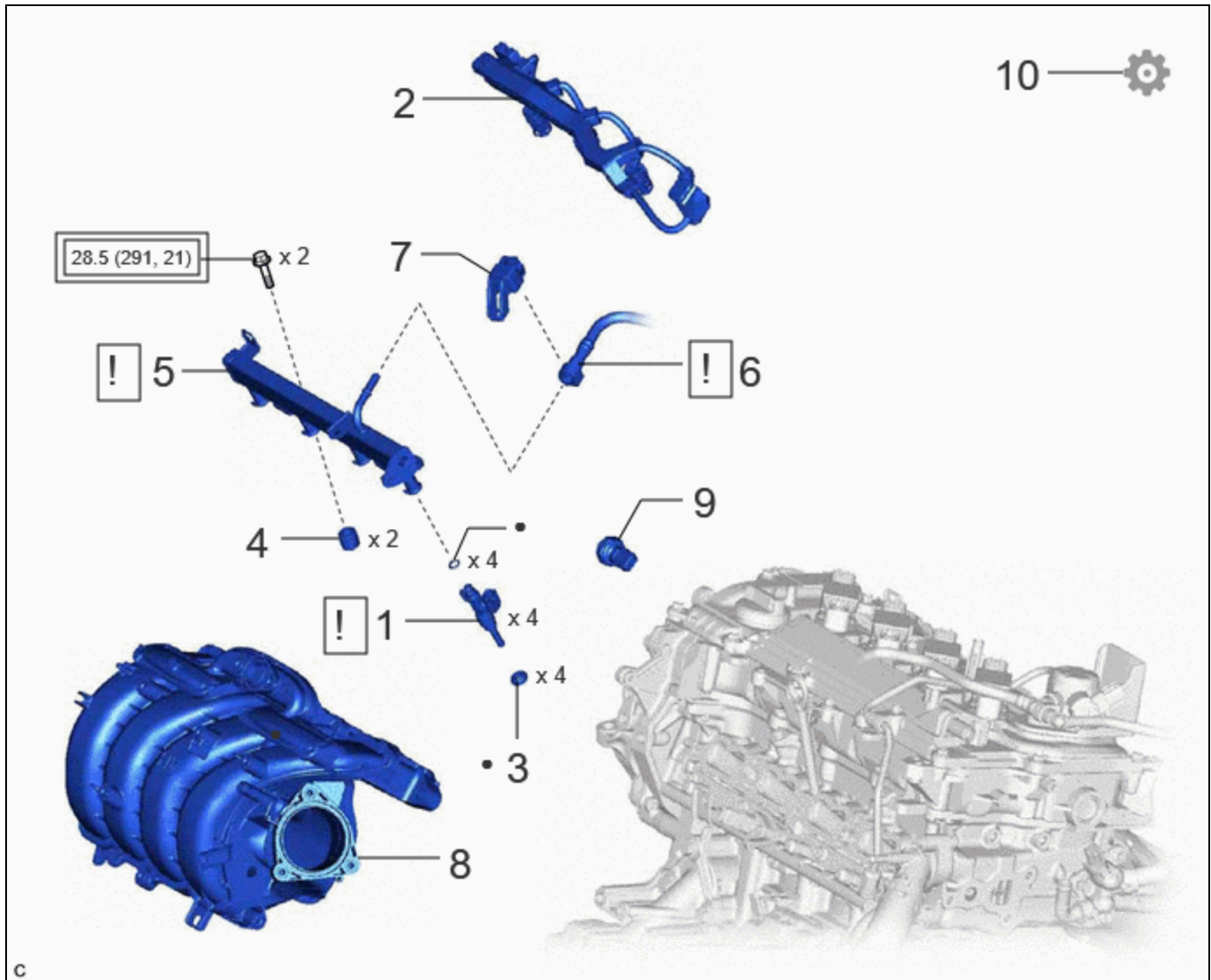
NOTICE:




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	PORT FUEL INJECTOR ASSEMBLY	23250F	INFO	-	-
2	NO. 5 ENGINE WIRE	82125N	-	-	-
3	INJECTOR VIBRATION INSULATOR	23291	-	-	-
4	FUEL DELIVERY SPACER	23891	-	-	-
5	FUEL DELIVERY PIPE SUB-ASSEMBLY	23807	INFO	-	-
6	FUEL TUBE SUB-ASSEMBLY	23910A	INFO	-	-
7	FUEL PIPE CLAMP	23841K	-	-	-
8	INTAKE MANIFOLD	17111	-	-	-
9	NO. 2 FUEL PRESSURE SENSOR	89458H	-	-	-
10	PERFORM INITIALIZATION	-	-	-	INFO

	Tightening torque for "Major areas involving basic vehicle performance such as moving/turning/stopping": N*m (kgf*cm, ft.*lbf)	• Non-reusable part
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PROCEDURE

1. INSTALL PORT FUEL INJECTOR ASSEMBLY



*a	Claw	*b	Stopper
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(1) Apply a light coat of spindle oil or gasoline to 4 new O-rings, and install one to each port fuel injector assembly.

NOTICE:

Check that there is no damage or foreign matter on the groove of the port fuel injector assembly when installing the O-ring to each port fuel injector assembly.

(2) Install the 4 port fuel injector assemblies to the fuel delivery pipe sub-assembly.

NOTICE:

- Make sure that the claw of the port fuel injector assembly is located between the stoppers as shown in the illustration.
- Check that the port fuel injector assembly installation holes of the fuel delivery pipe sub-assembly are not damaged and are free of foreign matter.

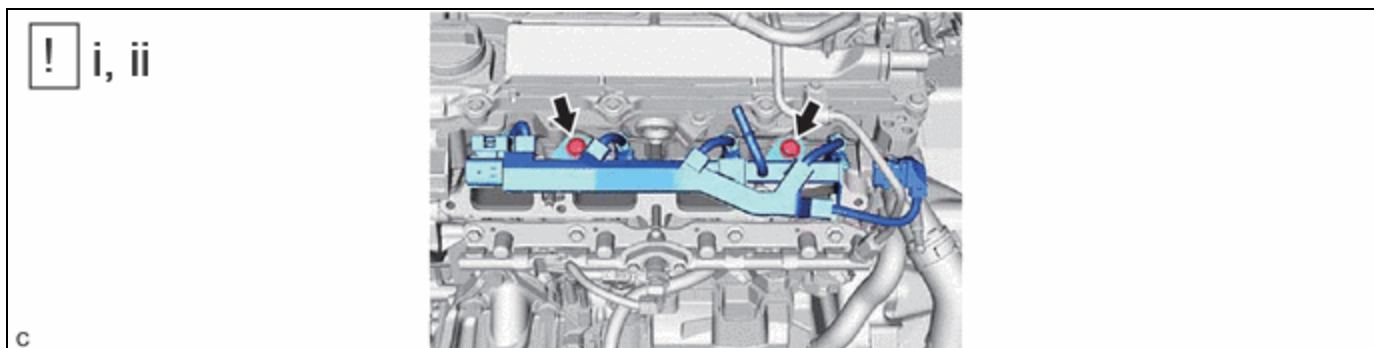
- Make sure that the O-ring is not damaged, twisted or moved out of place when installing the port fuel injector assembly.

2. INSTALL NO. 5 ENGINE WIRE

3. INSTALL INJECTOR VIBRATION INSULATOR

4. INSTALL FUEL DELIVERY SPACER

5. INSTALL FUEL DELIVERY PIPE SUB-ASSEMBLY



- (1) Place the fuel delivery pipe sub-assembly with the 4 port fuel injector assemblies onto the cylinder head sub-assembly.

NOTICE:

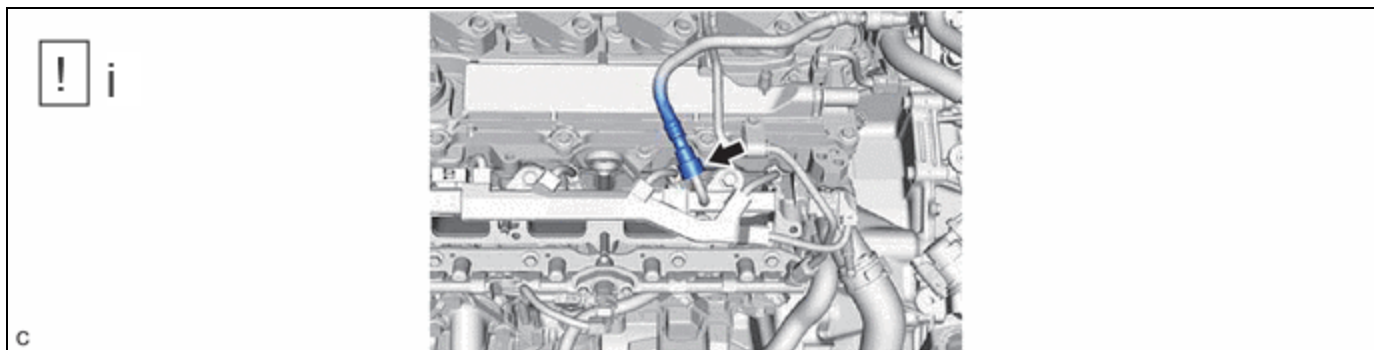
Be careful not to drop the port fuel injector assemblies when installing the fuel delivery pipe sub-assembly.

- (2) Install the fuel delivery pipe sub-assembly with the port fuel injector assemblies with the 2 bolts.

Torque:

28.5 N·m {291 kgf·cm, 21 ft·lbf}

6. CONNECT FUEL TUBE SUB-ASSEMBLY



- (1) Connect the fuel tube sub-assembly to the fuel delivery pipe sub-assembly.

Click here [INFO](#)

7. INSTALL FUEL PIPE CLAMP

8. INSTALL INTAKE MANIFOLD

Click here [INFO](#)

9. INSTALL NO. 2 FUEL PRESSURE SENSOR

Click here [INFO](#)

10. PERFORM INITIALIZATION

(a) Perform "Inspection After Repair" after replacing a port fuel injector assembly.

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