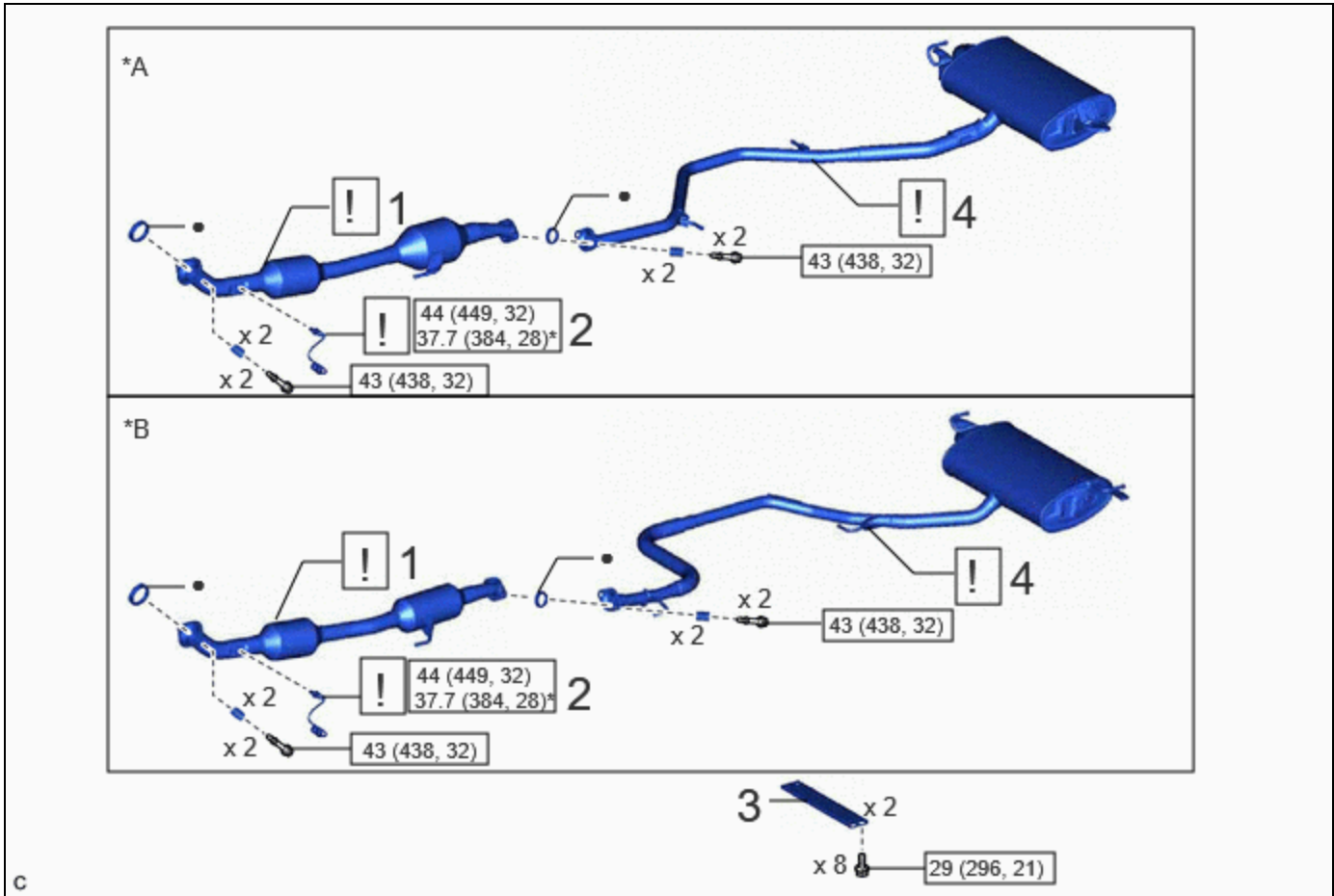


Last Modified: 12-04-2024	6.11:8.1.0	Doc ID: RM100000002B2J4
Model Year Start: 2023	Model: Prius Prime	Prod Date Range: [03/2023 -]
Title: M20A-FXS (INTAKE / EXHAUST): EXHAUST PIPE: INSTALLATION; 2023 - 2024 MY Prius Prius Prime [03/2023 -]		

INSTALLATION

CAUTION / NOTICE / HINT

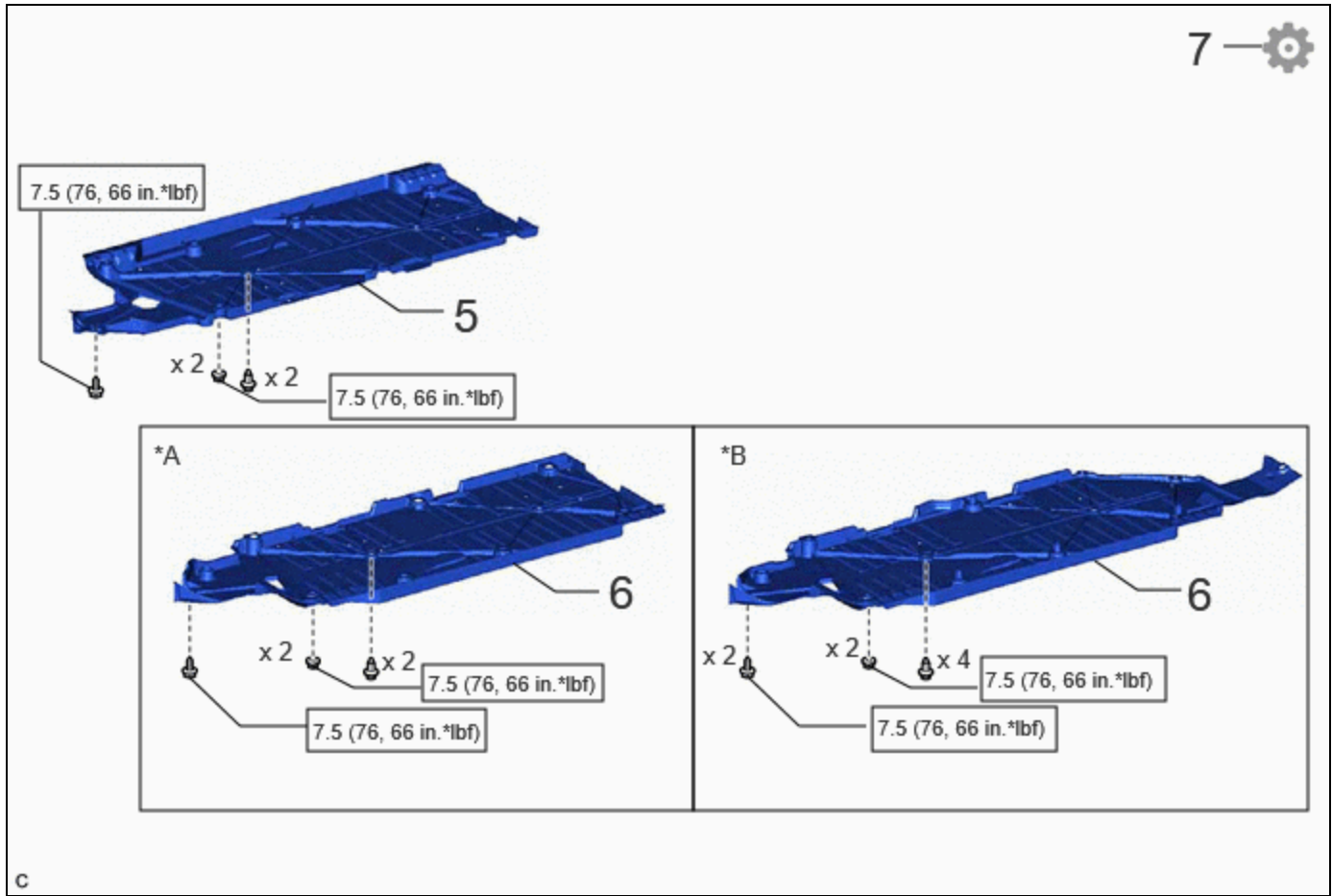
COMPONENTS (INSTALLATION)



PROCEDURE		PART NAME CODE	!	📄	⚙️
1	FRONT EXHAUST PIPE ASSEMBLY	17410	INFO	-	-
2	AIR FUEL RATIO SENSOR	89467C	INFO	-	-
3	FRONT FLOOR CENTER BRACE	57533B	-	-	-
4	TAIL EXHAUST PIPE ASSEMBLY	17430	INFO	-	-

*A	for HEV Model	*B	for PHEV Model
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□	N*m (kgf*cm, ft.*lbf): Specified torque	•	Non-reusable part
*	For use with SST	-	-

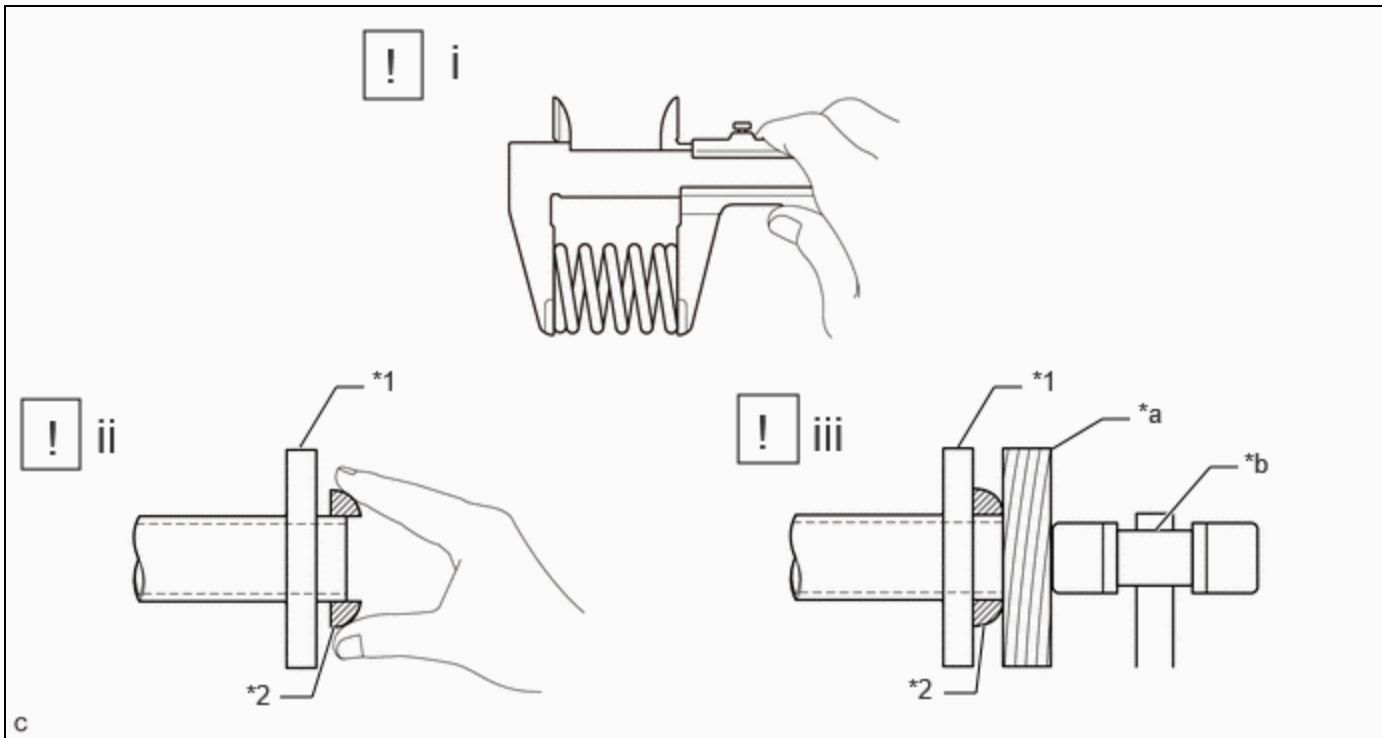


PROCEDURE		PART NAME CODE			
5	FRONT FLOOR COVER RH	58165C	-	-	-
6	FRONT FLOOR COVER LH	58166A	-	-	-
7	INSPECT FOR EXHAUST GAS LEAK	-	-	-	INFO

*A	for HEV Model	*B	for PHEV Model
□	N*m (kgf*cm, ft.*lbf): Specified torque	-	-

PROCEDURE

1. INSTALL FRONT EXHAUST PIPE ASSEMBLY



*1	Exhaust Manifold	*2	Gasket
*a	Wooden Block	*b	Plastic Hammer

(1) Using a vernier caliper, measure the free length of the compression springs.

Standard Length	43 mm (1.69 in.)
Minimum Free Length	41.5 mm (1.63 in.)

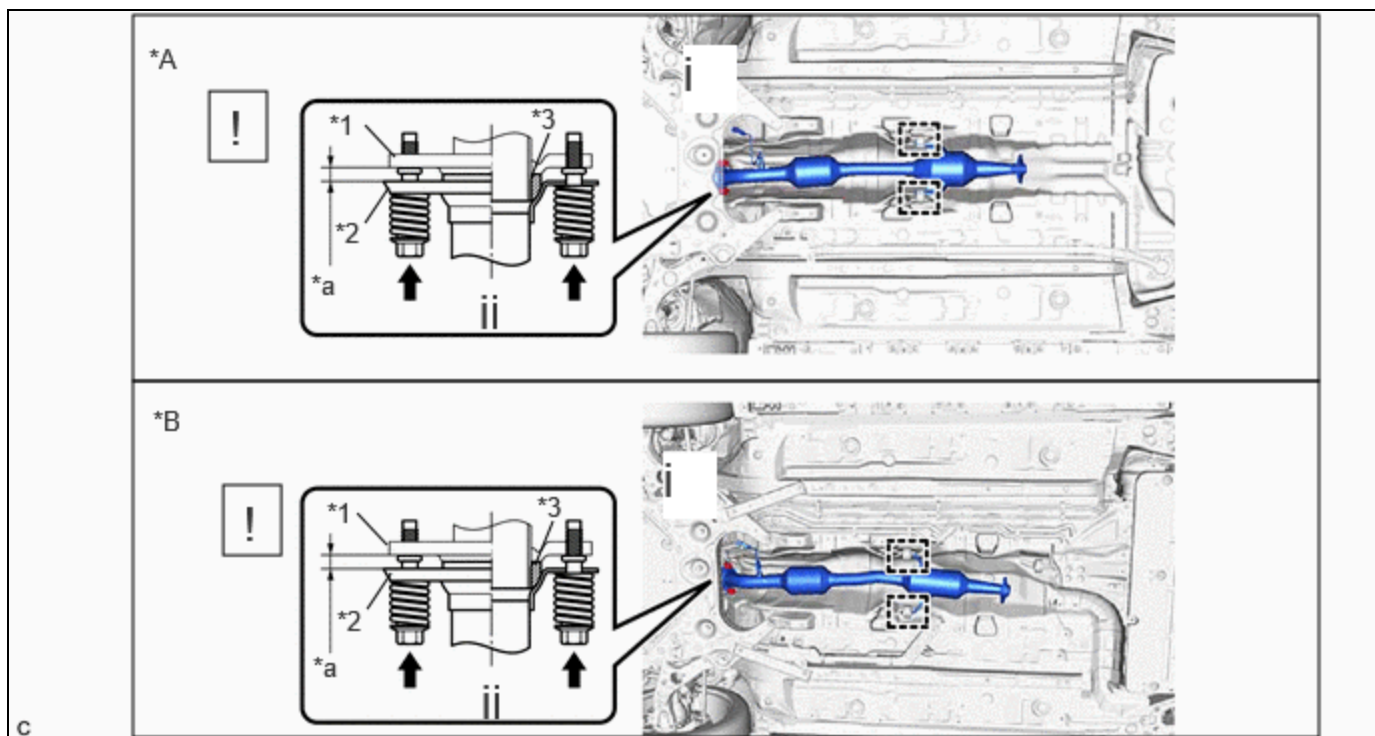
If the free length is less than the minimum, replace the compression spring.

(2) Temporarily install a new gasket to the exhaust manifold.

(3) Using a plastic hammer and wooden block, tap in the gasket until its surface is flush with the exhaust manifold.

NOTICE:

- Be careful with the installation direction of the gasket.
- Do not reuse the gasket.
- Do not damage the gasket.
- Do not push in the gasket by using the exhaust pipes when connecting them.



*A	for HEV Model	*B	for PHEV Model
*1	Exhaust Manifold	*2	Front Exhaust Pipe Assembly
*3	Gasket	-	-
*a	Space between Flanges: 8.5 mm (0.335 in.)	-	-

- (1) Connect the front exhaust pipe assembly to the 3 exhaust pipe supports.
- (2) Install the front exhaust pipe assembly to the exhaust manifold with the 2 compression springs and 2 bolts.

Torque:

43 N·m {438 kgf·cm, 32 ft·lbf}

- (3) After installation, check that the space between the flanges of the exhaust manifold and front exhaust pipe assembly is consistent front-to-rear and left-to-right.

2. INSTALL AIR FUEL RATIO SENSOR

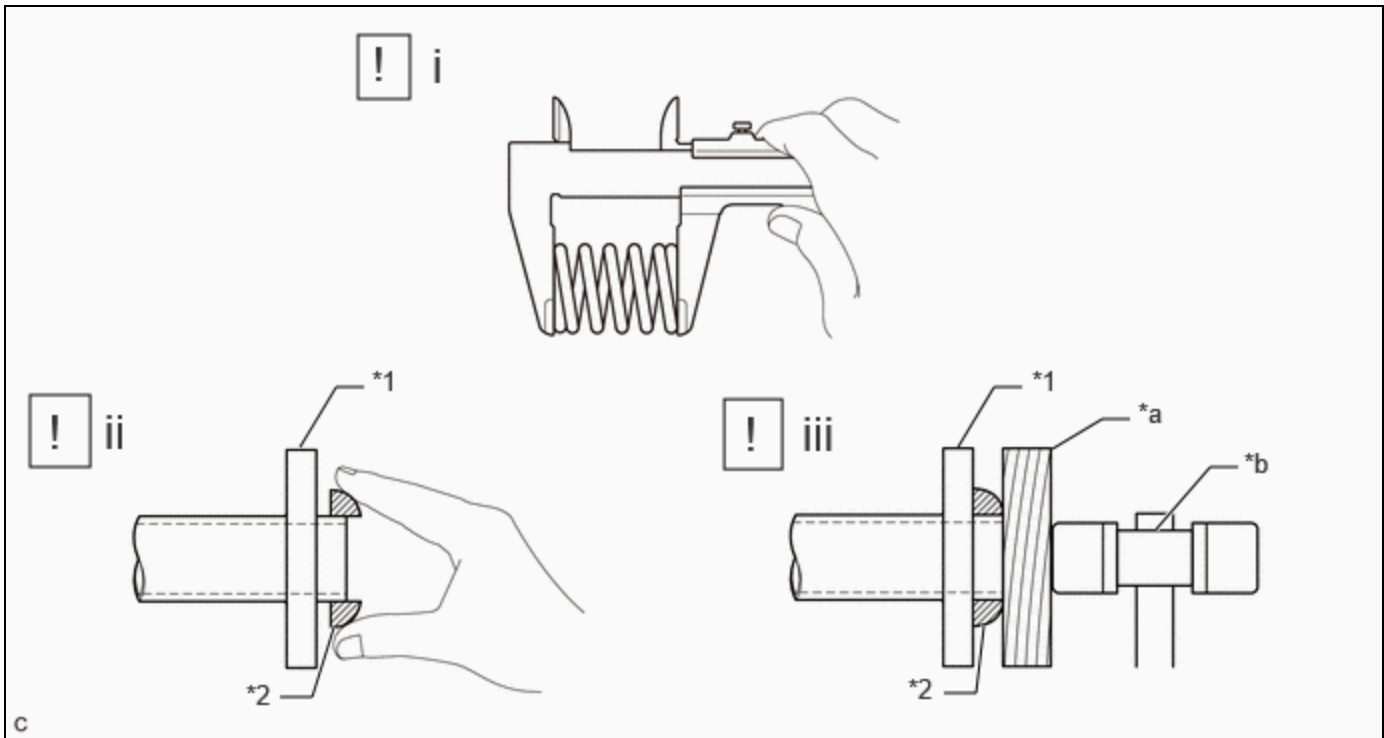
Click here [INFO](#)

3. INSTALL FRONT FLOOR CENTER BRACE

Torque:

27 N·m {275 kgf·cm, 20 ft·lbf}

4. INSTALL TAIL EXHAUST PIPE ASSEMBLY



*1	Front Exhaust Pipe Assembly	*2	Gasket
*a	Wooden Block	*b	Plastic Hammer

(1) Using a vernier caliper, measure the free length of the compression springs.

Standard Length	40 mm (1.57 in.)
Minimum Free Length	38.5 mm (1.52 in.)

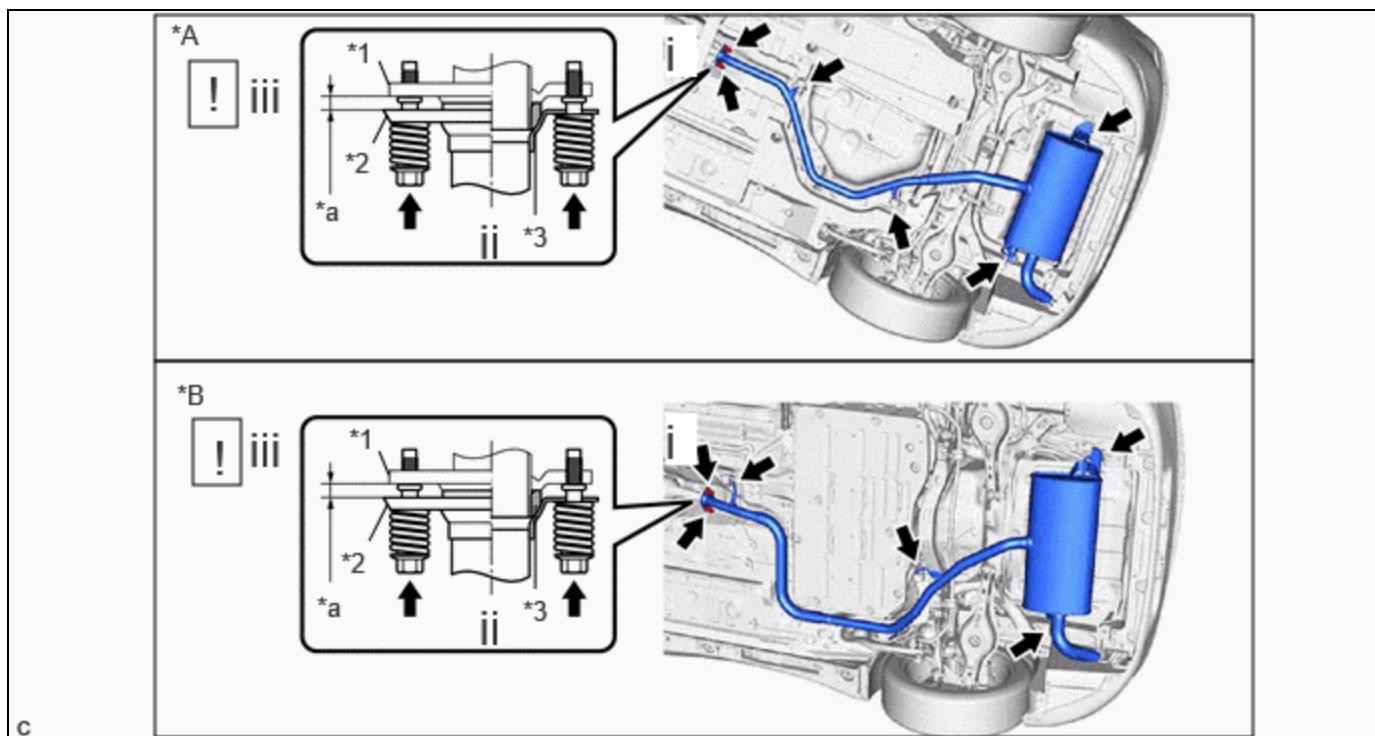
If the free length is less than the minimum, replace the compression spring.

(2) Temporarily install a new gasket to the front exhaust pipe assembly.

(3) Using a plastic hammer and wooden block, tap in the gasket until its surface is flush with the front exhaust pipe assembly.

NOTICE:

- Be careful with the installation direction of the gasket.
- Do not reuse the gasket.
- Do not damage the gasket.
- Do not push in the gasket by using the exhaust pipes when connecting them.



*A	for HEV Model	*B	for PHEV Model
*1	Front Exhaust Pipe Assembly	*2	Tail Exhaust Pipe Assembly
*3	Gasket	-	-
*a	Space between Flanges: 6.5 mm (0.256 in.)	-	-

(1) Connect the tail exhaust pipe assembly to the 3 exhaust pipe supports.

(2) Install the tail exhaust pipe assembly to the front exhaust pipe assembly with the 2 compression springs and 2 bolts.

Torque:

43 N·m {438 kgf·cm, 32 ft·lbf}

(3) After installation, check that the space between the flanges of the tail exhaust pipe assembly and front exhaust pipe assembly is consistent front-to-rear and left-to-right.

5. INSTALL FRONT FLOOR COVER RH

Torque:

Bolt :

7.5 N·m {76 kgf·cm, 66 in·lbf}

Nut :

7.5 N·m {76 kgf·cm, 66 in·lbf}

6. INSTALL FRONT FLOOR COVER LH

Torque:

Bolt :

7.5 N·m {76 kgf·cm, 66 in·lbf}

Nut :

7.5 N·m {76 kgf·cm, 66 in·lbf}

7. INSPECT FOR EXHAUST GAS LEAK

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

(a) Perform "Inspection After Repair" after repairing an exhaust gas leak.

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