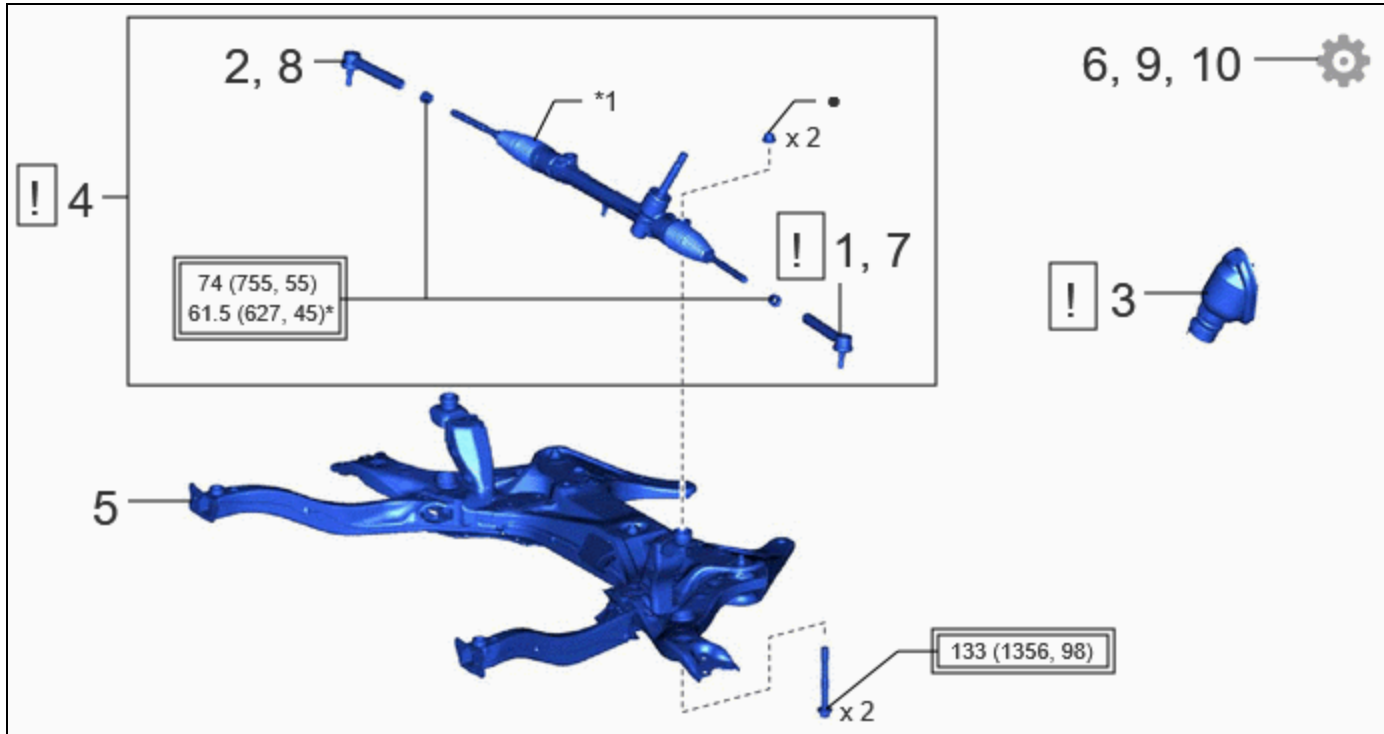


Last Modified: 12-04-2024	6.11:8.1.0	Doc ID: RM1000000029PO4
Model Year Start: 2023	Model: Prius Prime	Prod Date Range: [12/2022 -]
Title: STEERING GEAR / LINKAGE: STEERING GEAR: INSTALLATION; 2023 - 2024 MY Prius Prius Prime [12/2022 -]		






INSTALLATION


CAUTION / NOTICE / HINT

COMPONENTS (INSTALLATION)



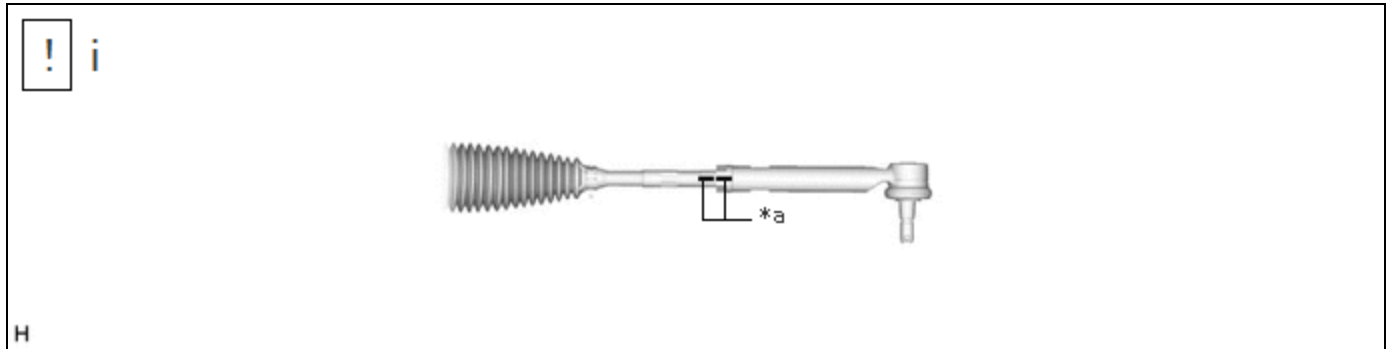
PROCEDURE		PART NAME CODE	!	📄	⚙️
1	TEMPORARILY TIGHTEN TIE ROD END SUB-ASSEMBLY LH	45047	INFO	-	-
2	TEMPORARILY TIGHTEN TIE ROD END SUB-ASSEMBLY RH	45046	-	-	-
3	NO. 1 STEERING COLUMN HOLE COVER SUB-ASSEMBLY	45025D	INFO	-	-
4	STEERING LINK ASSEMBLY	-	INFO	-	-
5	FRONT SUSPENSION CROSSMEMBER SUB-ASSEMBLY	51201	-	-	-
6	INSPECT AND ADJUST FRONT WHEEL ALIGNMENT	-	-	-	INFO
7	FULLY TIGHTEN TIE ROD END SUB-ASSEMBLY LH	45047	INFO	-	-

PROCEDURE		PART NAME CODE			
8	FULLY TIGHTEN TIE ROD END SUB-ASSEMBLY RH	45046	-	-	-
9	END POSITION INITIAL SETTING	-	-	-	
10	PERFORM INITIALIZATION	-	-	-	

*1	STEERING GEAR ASSEMBLY	-	-
	Tightening torque for "Major areas involving basic vehicle performance such as moving/turning/stopping": N*m (kgf*cm, ft.*lbf)	-	• Non-reusable part
*	For use with SST	-	-

PROCEDURE

1. TEMPORARILY TIGHTEN TIE ROD END SUB-ASSEMBLY LH



*a	Matchmark	-	-
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(1) Temporarily install the lock nut and tie rod end sub-assembly LH to the steering gear assembly until the matchmarks are aligned.

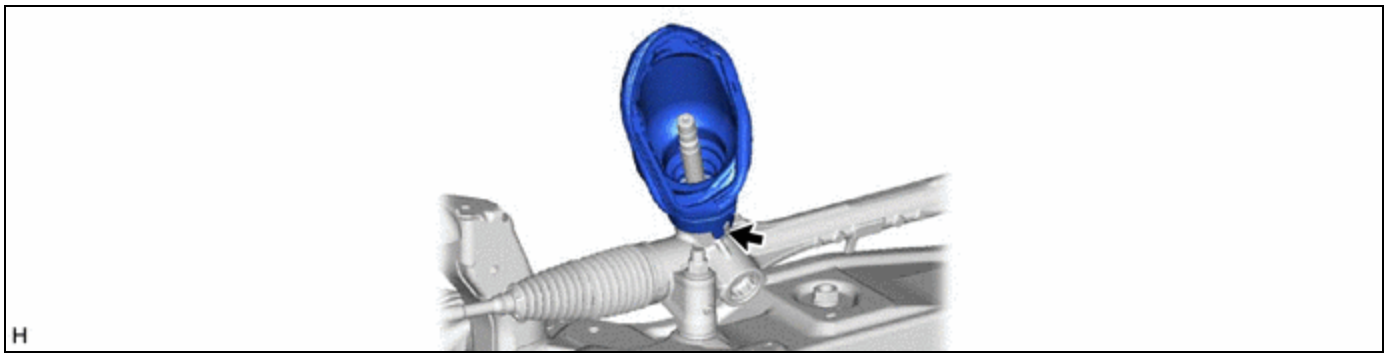
HINT:

After adjusting the toe-in, tighten the lock nut.

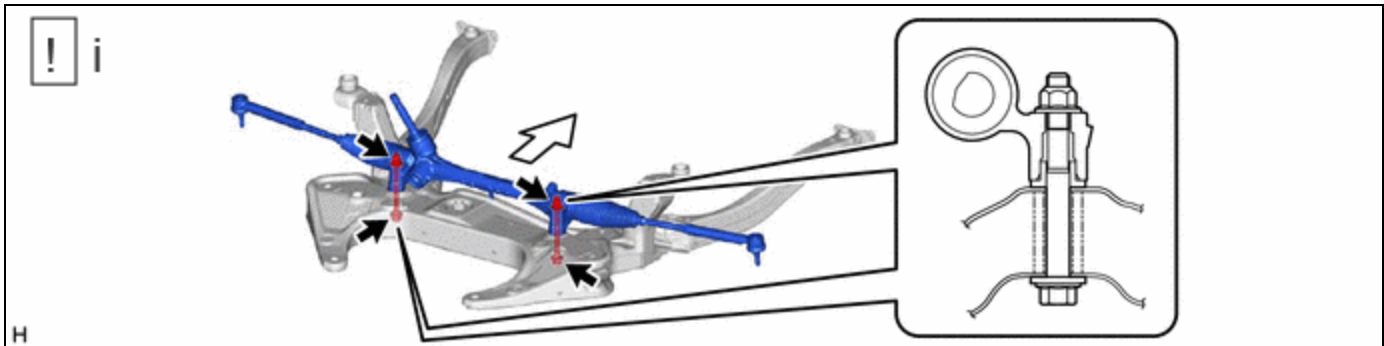
2. TEMPORARILY TIGHTEN TIE ROD END SUB-ASSEMBLY RH

3. INSTALL NO. 1 STEERING COLUMN HOLE COVER SUB-ASSEMBLY

	<p>HINT:</p> <p>Check that the No. 1 steering column hole cover sub-assembly is securely installed.</p>
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4. INSTALL STEERING LINK ASSEMBLY



	Front of the Vehicle	-	-
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(1) Install the steering link assembly to the front suspension crossmember sub-assembly with the 2 bolts and 2 new nuts.

Torque:

133 N·m {1356 kgf·cm, 98 ft·lbf}

NOTICE:

- Because the nut has its own stopper, do not turn the nut. Tighten the bolt with the nut secured.
- Make sure to tighten the bolts starting from the left side of the vehicle.

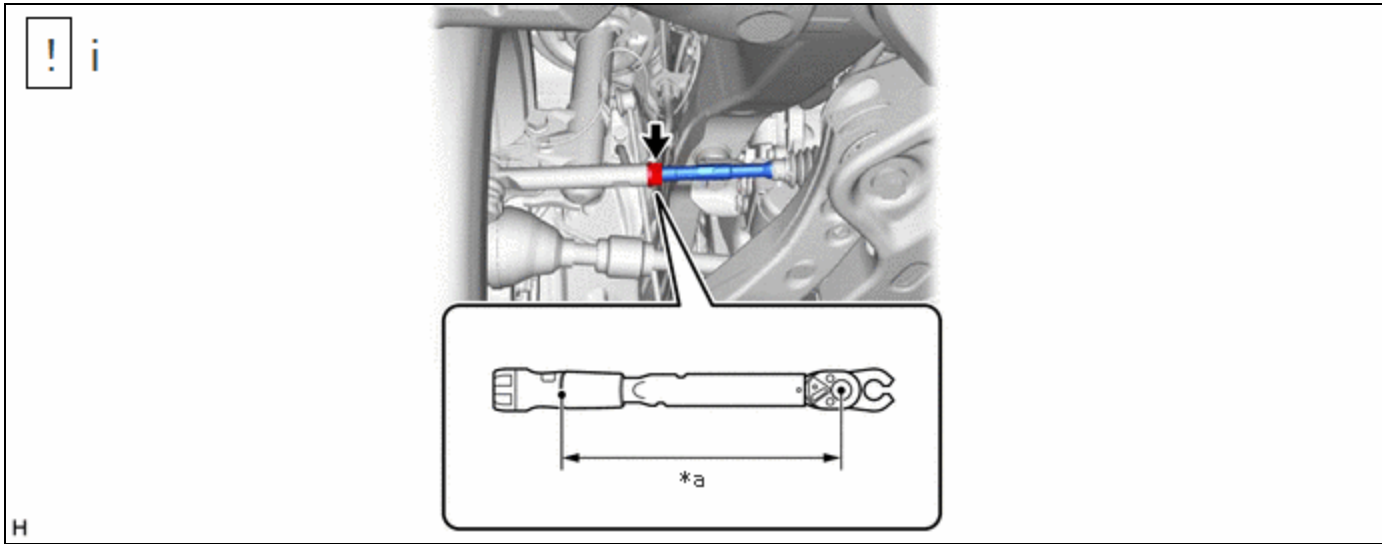
5. INSTALL FRONT SUSPENSION CROSSMEMBER SUB-ASSEMBLY

Click here [INFO](#)

6. INSPECT AND ADJUST FRONT WHEEL ALIGNMENT

Click here [INFO](#)

7. FULLY TIGHTEN TIE ROD END SUB-ASSEMBLY LH



*a	Torque Wrench Fulcrum Length	-	-
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(1) Using SST, tighten the tie rod end sub-assembly lock nut.

SST: 09612-24014

09617-24011

Torque:

Specified tightening torque :

74 N·m {755 kgf·cm, 55 ft·lbf}

HINT:

- Calculate the torque wrench reading when changing the fulcrum length of the torque wrench.
- [Click here](#) **INFO**
- When using SST (fulcrum length of 52 mm (2.05 in.)) + torque wrench (fulcrum length of 255 mm (10.04 in.)): 61.5 N*m (627 kgf*cm, 45 ft.*lbf)

8. FULLY TIGHTEN TIE ROD END SUB-ASSEMBLY RH

9. PERFORM END POSITION INITIAL SETTING

Click here **INFO**

10. PERFORM INITIALIZATION

Parking Assist Monitor System	INFO
Panoramic View Monitor System	INFO
Advanced Park	INFO

