

Last Modified: 12-04-2024	6.11:8.1.0	Doc ID: RM100000002BCTJ
Model Year Start: 2023	Model: Prius Prime	Prod Date Range: [03/2023 -]
Title: REAR SUSPENSION: REAR LOWER ARM (for PHEV Model): INSTALLATION; 2023 - 2024 MY Prius Prime [03/2023 -]		

INSTALLATION

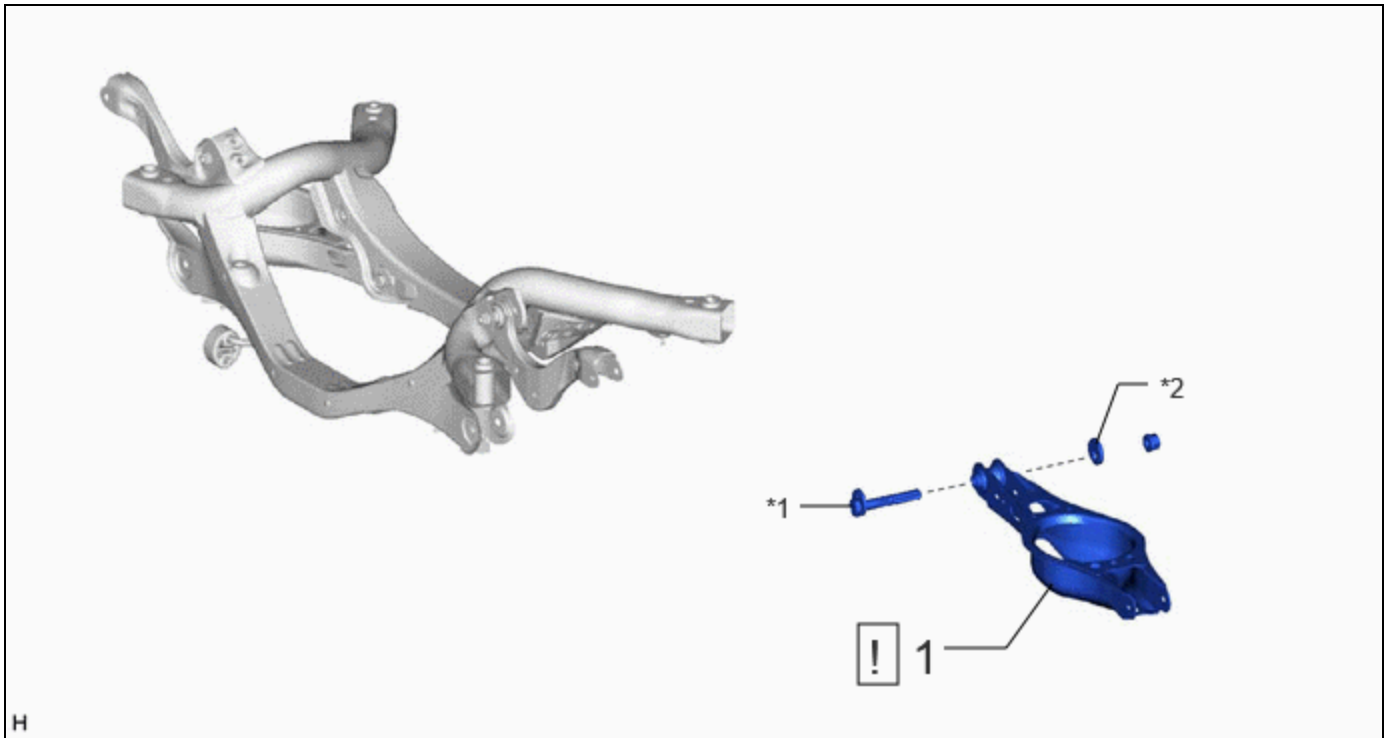
CAUTION / NOTICE / HINT

HINT:

- Use the same procedure for the RH side and LH side.
- The following procedure is for the LH side.

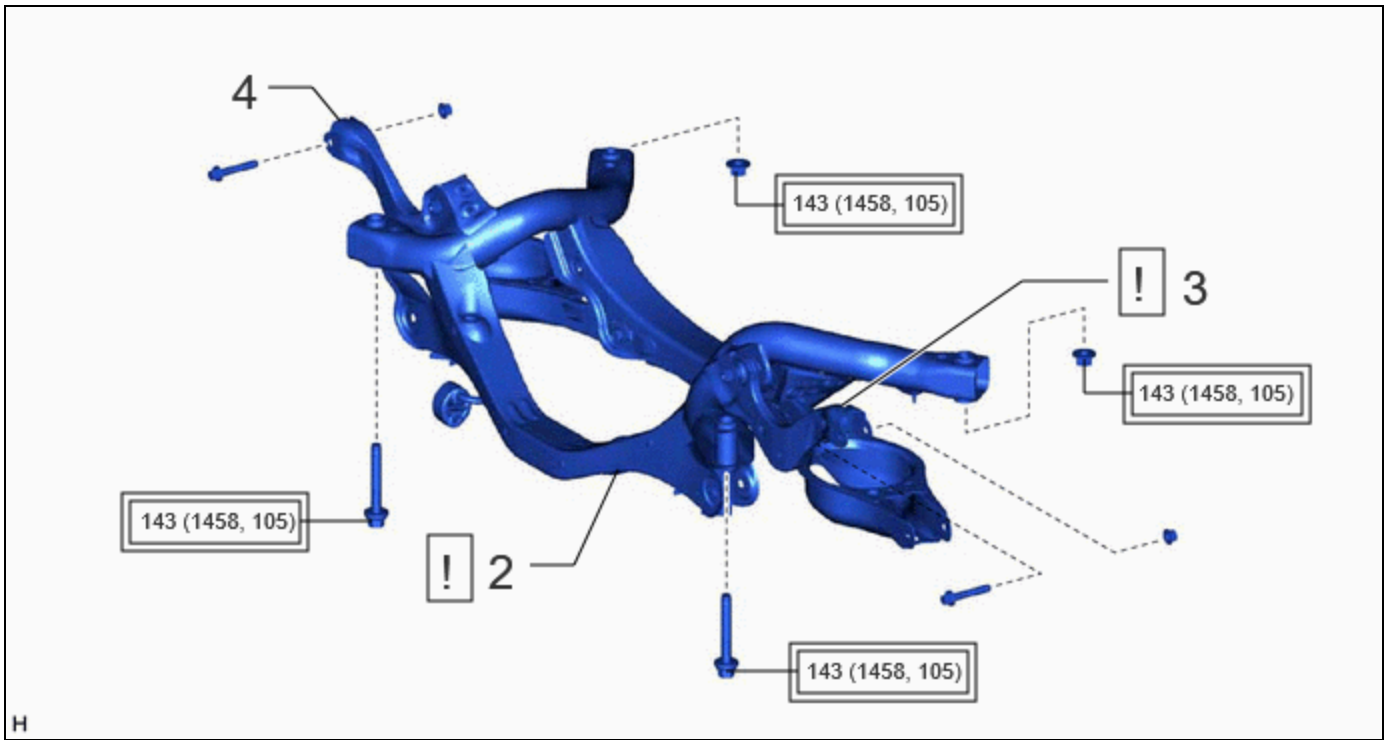
CAUTION / NOTICE / HINT

COMPONENTS (INSTALLATION)



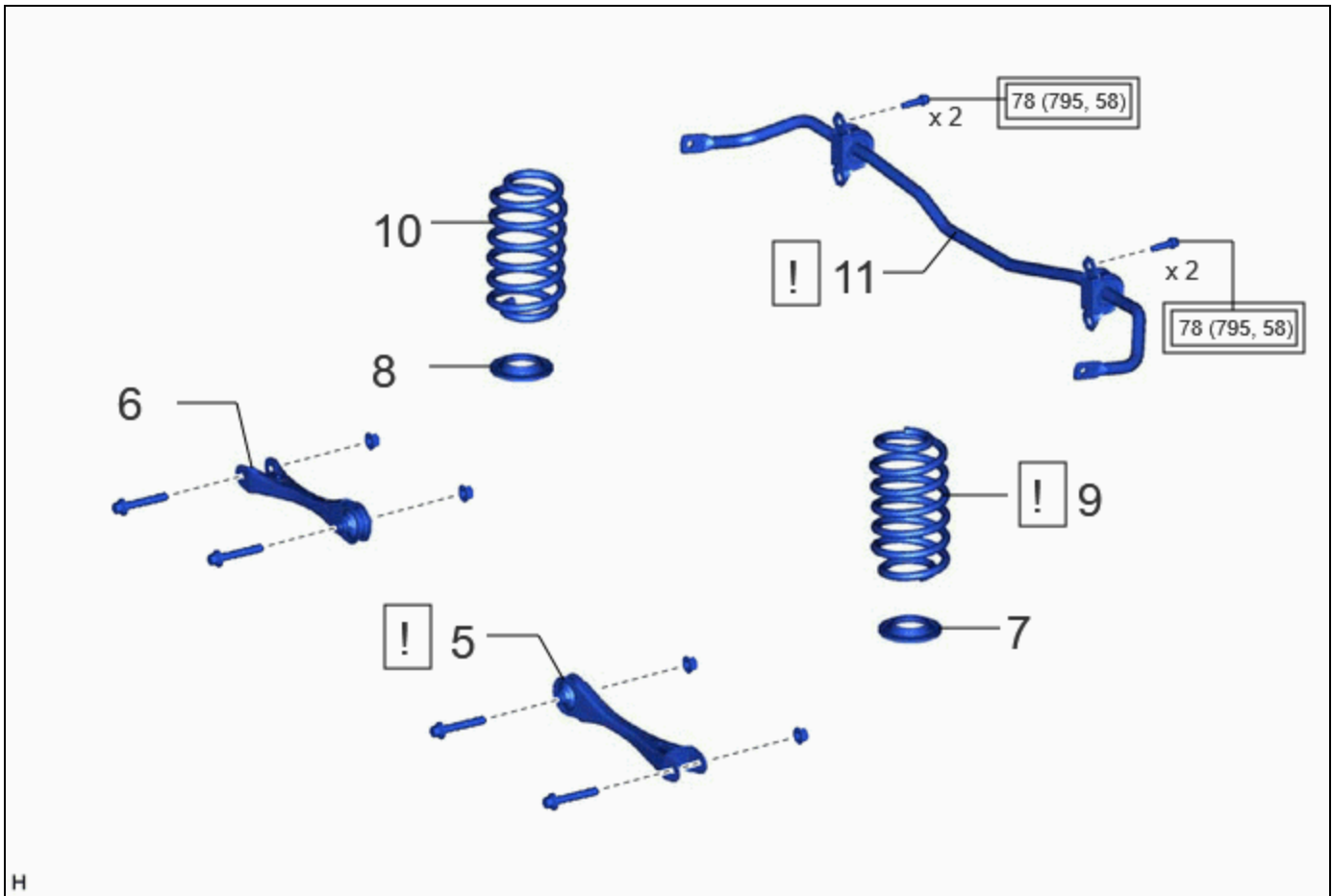
PROCEDURE		PART NAME CODE			
1	TEMPORARILY INSTALL REAR NO. 2 SUSPENSION ARM ASSEMBLY	48740F	INFO	-	-

*1	REAR SUSPENSION TOE ADJUST CAM SUB-ASSEMBLY	*2	NO. 2 CAMBER ADJUST CAM
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	PROCEDURE	PART NAME CODE			
2	REAR SUSPENSION MEMBER SUB-ASSEMBLY	51206A	INFO	-	-
3	REAR UPPER CONTROL ARM ASSEMBLY LH	48790	INFO	-	-
4	REAR UPPER CONTROL ARM ASSEMBLY RH	48770A	-	-	-

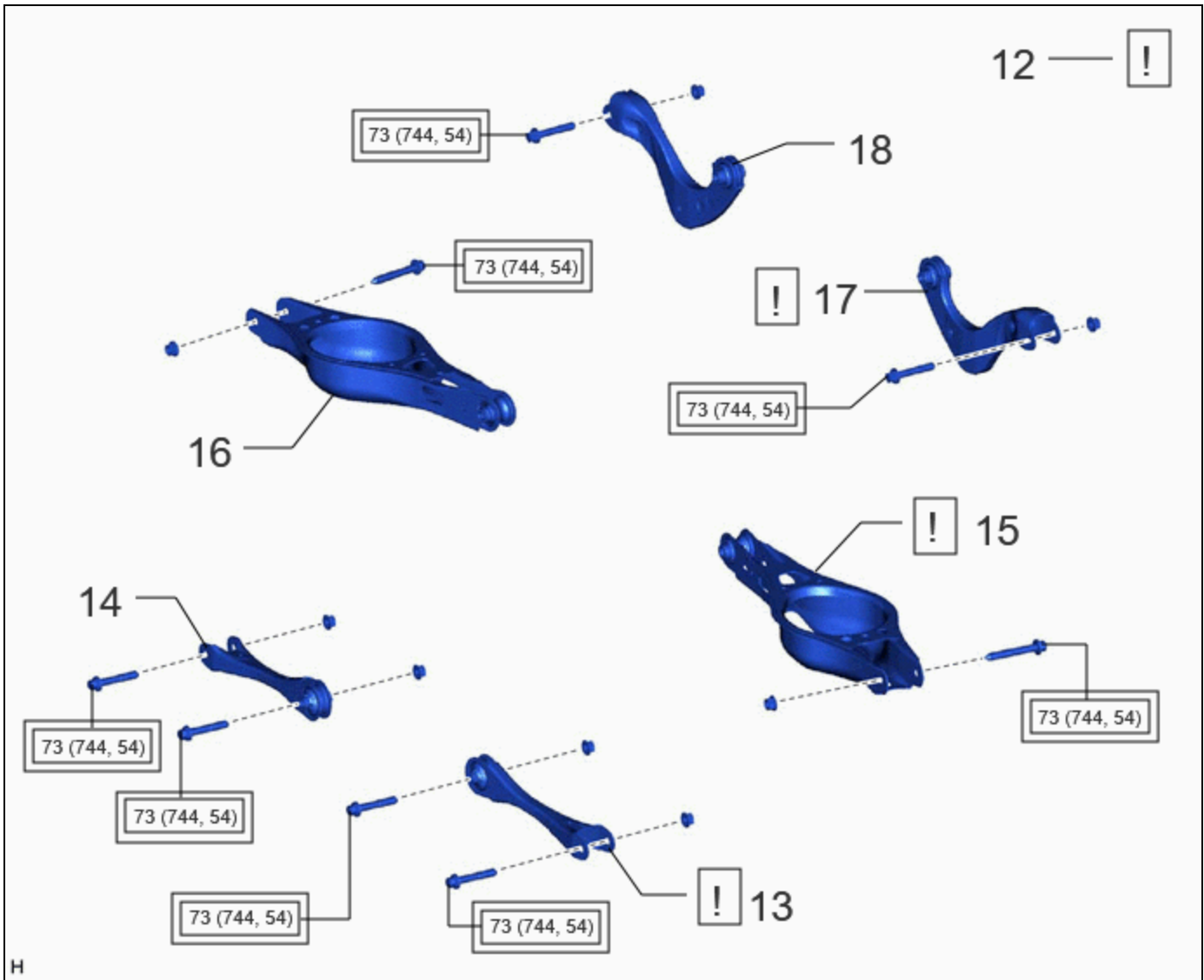
	Tightening torque for "Major areas involving basic vehicle performance such as moving/turning/stopping": N*m (kgf*cm, ft.*lbf)	-	-
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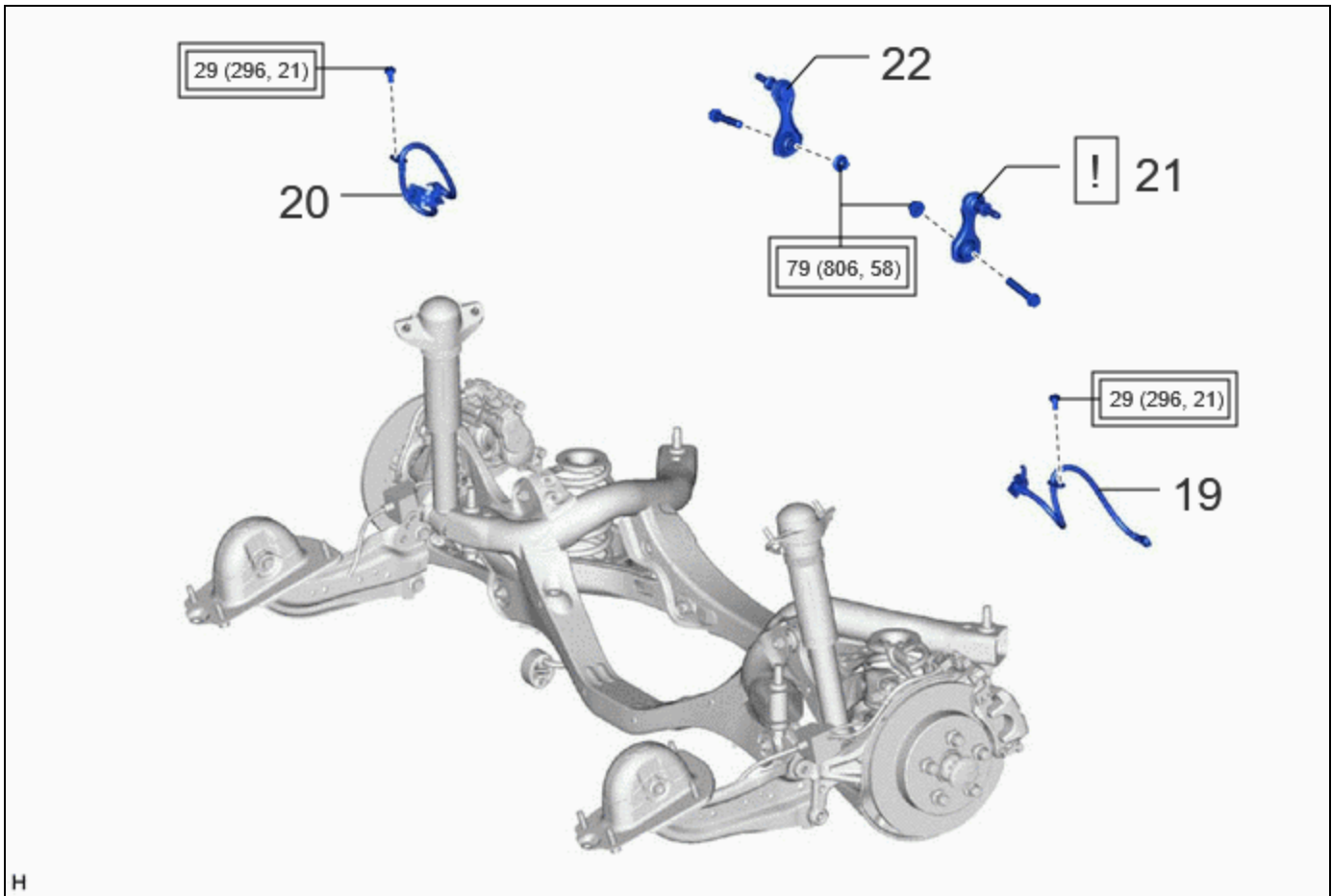
PROCEDURE		PART NAME CODE			
5	REAR NO. 1 SUSPENSION ARM ASSEMBLY LH	48720A	INFO	-	-
6	REAR NO. 1 SUSPENSION ARM ASSEMBLY RH	48710A	-	-	-
7	REAR LOWER COIL SPRING INSULATOR LH	48258C	-	-	-
8	REAR LOWER COIL SPRING INSULATOR RH	48258B	-	-	-
9	REAR COIL SPRING LH	48231B	INFO	-	-
10	REAR COIL SPRING RH	48231A	-	-	-
11	REAR STABILIZER BAR	48812	INFO	-	-

	Tightening torque for "Major areas involving basic vehicle performance such as moving/turning/stopping": N*m (kgf*cm, ft.*lbf)	-	-
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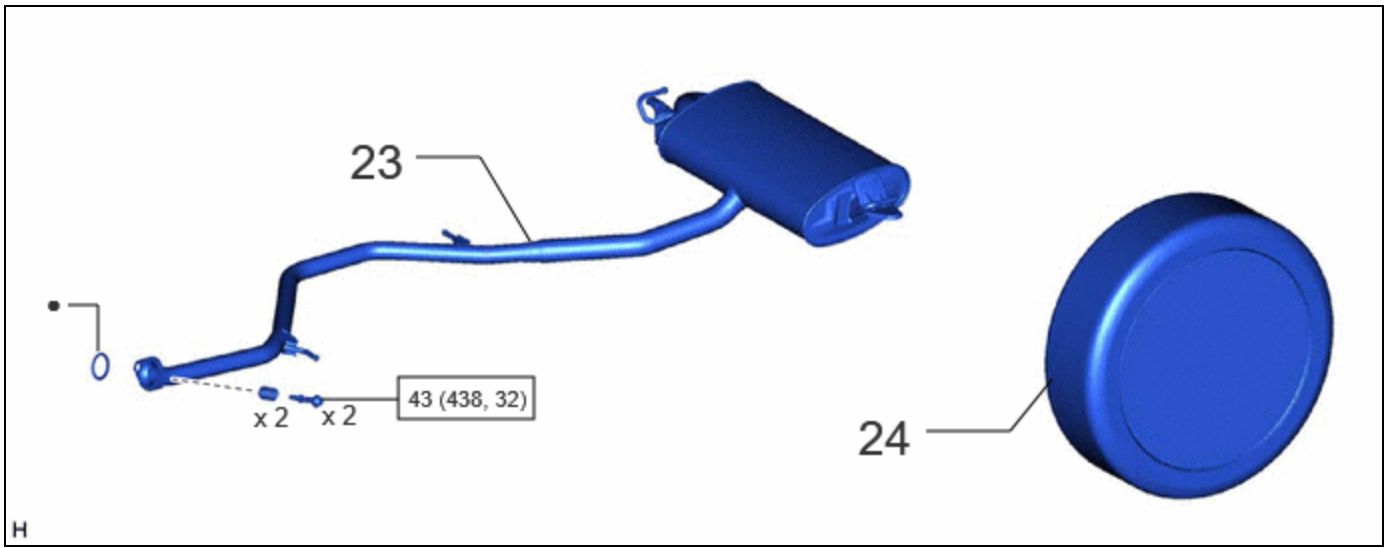
PROCEDURE		PART NAME CODE			
12	STABILIZE SUSPENSION	-	INFO	-	-
13	REAR NO. 1 SUSPENSION ARM ASSEMBLY LH	48720A	INFO	-	-
14	REAR NO. 1 SUSPENSION ARM ASSEMBLY RH	48710A	-	-	-
15	REAR NO. 2 SUSPENSION ARM ASSEMBLY LH	48740F	INFO	-	-
16	REAR NO. 2 SUSPENSION ARM ASSEMBLY RH	48730F	-	-	-
17	REAR UPPER CONTROL ARM ASSEMBLY LH	48790	INFO	-	-
18	REAR UPPER CONTROL ARM ASSEMBLY RH	48770A	-	-	-

	Tightening torque for "Major areas involving basic vehicle performance such as moving/turning/stopping": N*m (kgf*cm, ft.*lbf)	-	-
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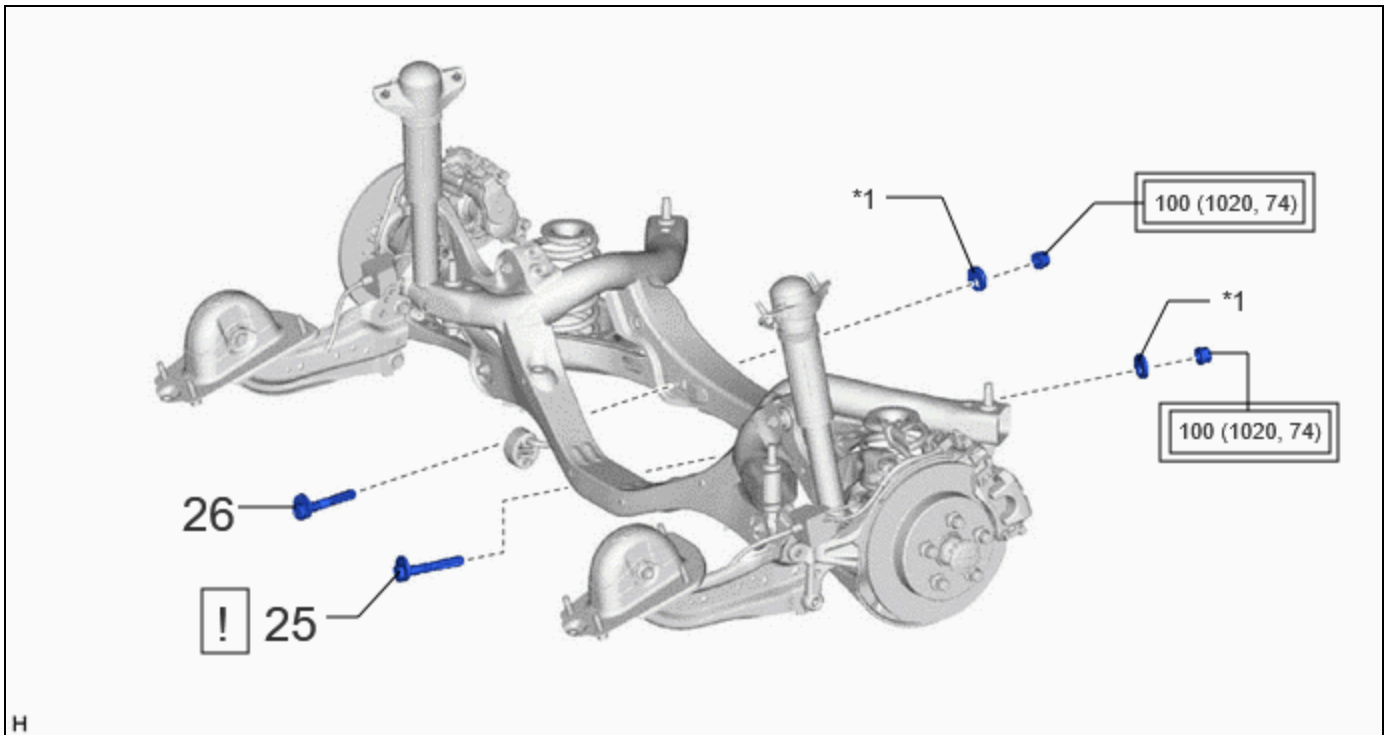
PROCEDURE		PART NAME CODE			
19	REAR FLEXIBLE HOSE LH	47319F	-	-	-
20	REAR FLEXIBLE HOSE RH	47318F	-	-	-
21	REAR STABILIZER LINK ASSEMBLY LH	48840A	INFO	-	-
22	REAR STABILIZER LINK ASSEMBLY RH	48830D	-	-	-




	Tightening torque for "Major areas involving basic vehicle performance such as moving/turning/stopping": N*m (kgf*cm, ft.*lbf)	-	-
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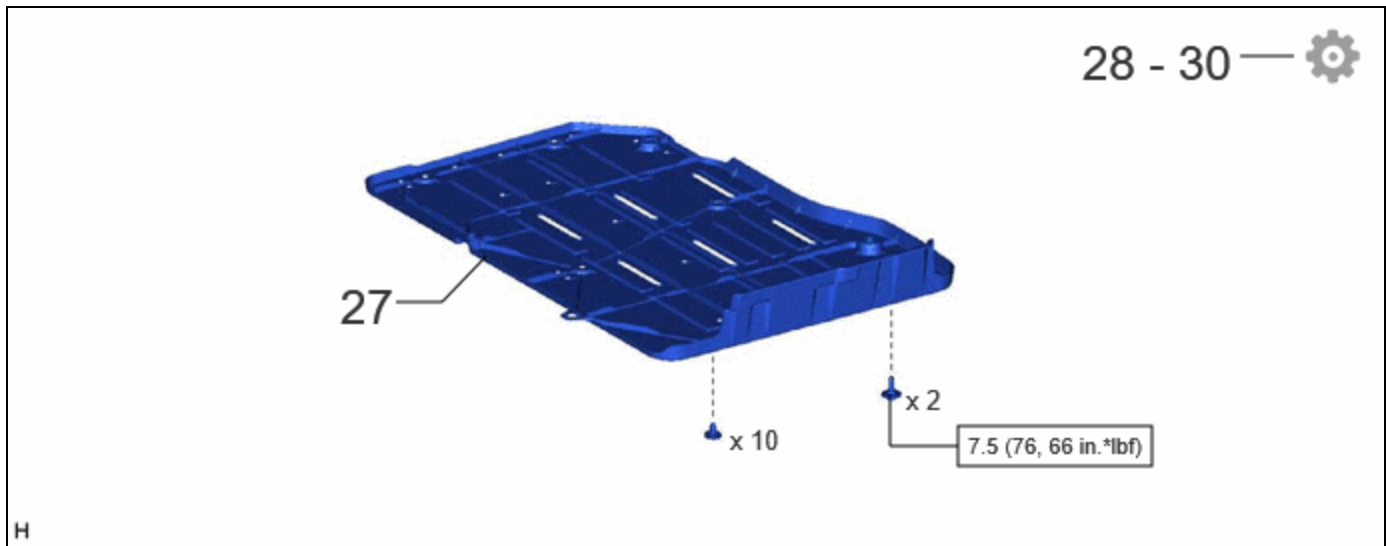
PROCEDURE		PART NAME CODE			
23	TAIL EXHAUST PIPE ASSEMBLY	17430	-	-	-
24	REAR WHEEL	-	-	-	-




	N*m (kgf*cm, ft.*lbf): Specified torque		Non-reusable part
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PROCEDURE		PART NAME CODE			
25	REAR SUSPENSION TOE ADJUST CAM SUB-ASSEMBLY (for LH Side)	48409	INFO	-	-
26	REAR SUSPENSION TOE ADJUST CAM SUB-ASSEMBLY (for RH Side)	48409	-	-	-

*1	NO. 2 CAMBER ADJUST CAM	-	-
	Tightening torque for "Major areas involving basic vehicle performance such as moving/turning/stopping": N*m (kgf*cm, ft.*lbf)	-	-

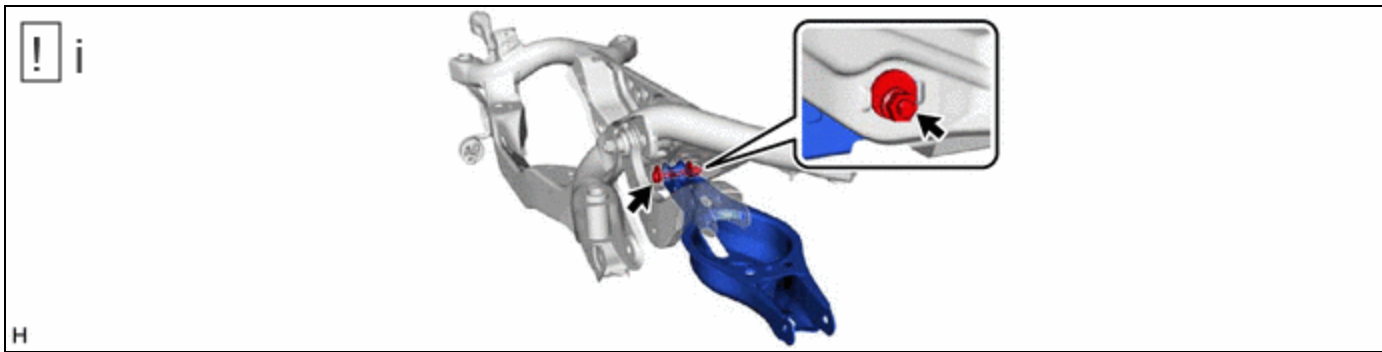


PROCEDURE		PART NAME CODE			
27	BATTERY BOX COVER	58219K	-	-	-
28	INSPECT FOR EXHAUST GAS LEAK	-	-	-	INFO
29	INSPECT AND ADJUST REAR WHEEL ALIGNMENT	-	-	-	INFO
30	PERFORM INITIALIZATION	-	-	-	INFO

	N*m (kgf*cm, ft.*lbf): Specified torque	-	-
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PROCEDURE

1. TEMPORARILY INSTALL REAR NO. 2 SUSPENSION ARM ASSEMBLY

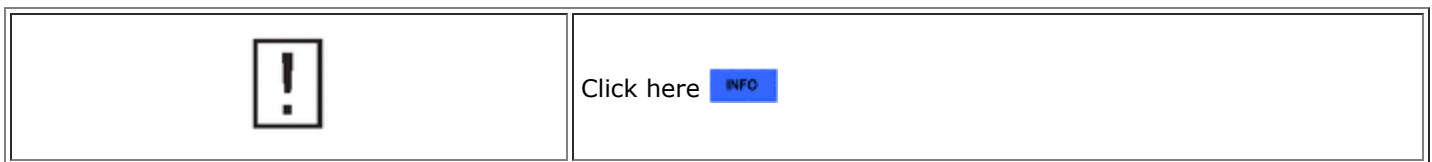


- (1) Temporarily install the rear No. 2 suspension arm assembly to the rear suspension member sub-assembly with the No. 2 camber adjust cam, rear suspension toe adjust cam sub-assembly and nut.

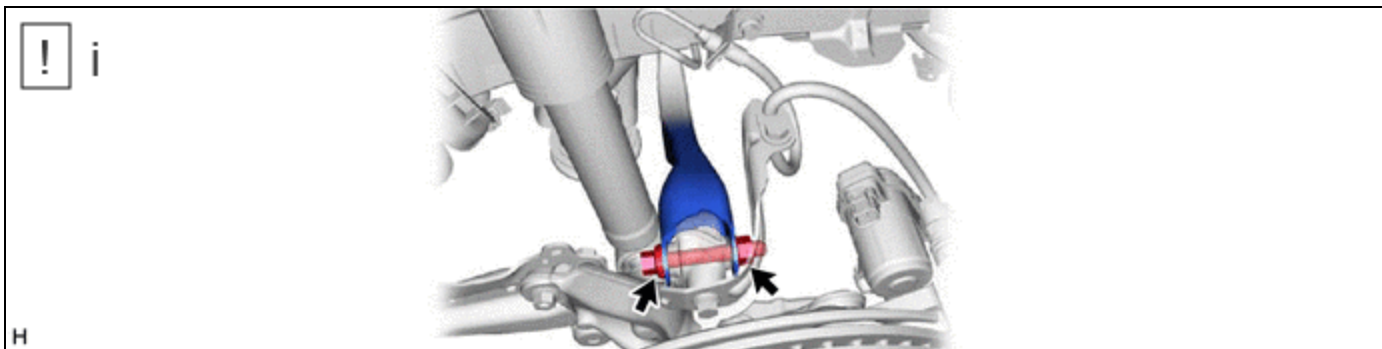
NOTICE:

- Insert the rear suspension toe adjust cam sub-assembly from the front of the vehicle.
- When tightening the nut, keep the rear suspension toe adjust cam sub-assembly from rotating.

2. INSTALL REAR SUSPENSION MEMBER SUB-ASSEMBLY



3. TEMPORARILY INSTALL REAR UPPER CONTROL ARM ASSEMBLY LH



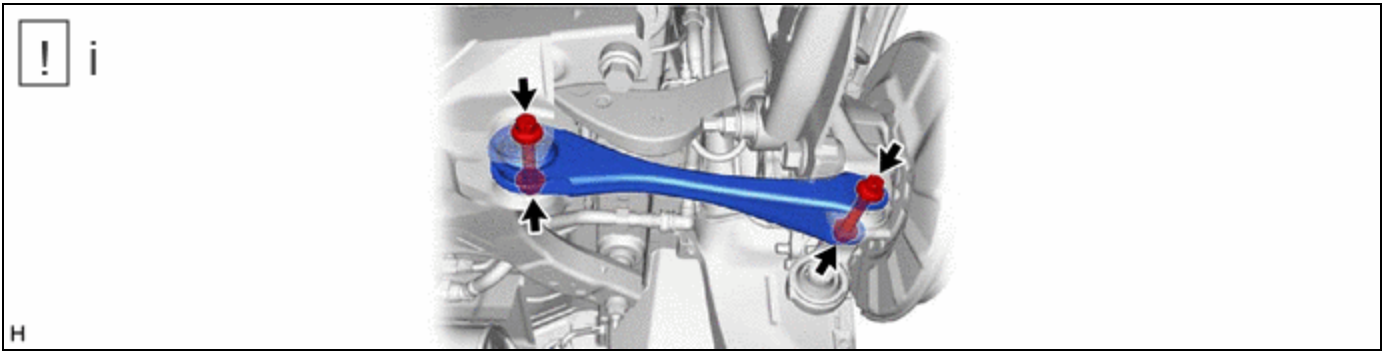
- (1) Temporarily install the rear upper control arm assembly LH to the rear axle carrier sub-assembly LH with the bolt and nut.

NOTICE:

- Insert the bolt with the threaded end facing the rear of the vehicle.
- Because the nut has its own stopper, do not turn the nut. Tighten the bolt with the nut secured.

4. TEMPORARILY INSTALL REAR UPPER CONTROL ARM ASSEMBLY RH

5. TEMPORARILY INSTALL REAR NO. 1 SUSPENSION ARM ASSEMBLY LH



(1) Temporarily install the rear No. 1 suspension arm assembly to the rear axle carrier sub-assembly and rear suspension member sub-assembly with the 2 bolts and 2 nuts.

NOTICE:


- Because the nut has its own stopper, do not turn the nut. Tighten the bolt with the nut secured.
- Insert the bolt with the threaded end facing the rear of the vehicle.

6. TEMPORARILY INSTALL REAR NO. 1 SUSPENSION ARM ASSEMBLY RH

7. INSTALL REAR LOWER COIL SPRING INSULATOR LH

8. INSTALL REAR LOWER COIL SPRING INSULATOR RH

9. INSTALL REAR COIL SPRING LH

	Click here INFO
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10. INSTALL REAR COIL SPRING RH

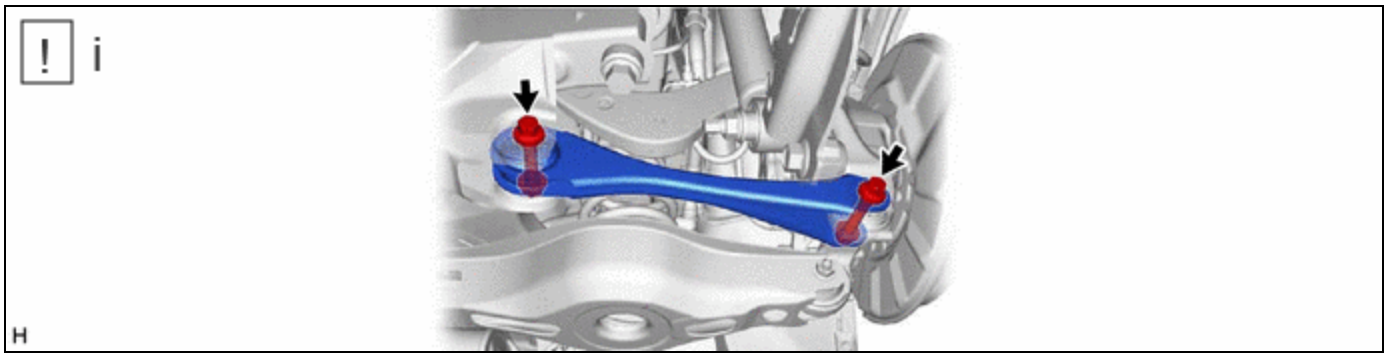
11. INSTALL REAR STABILIZER BAR

	Click here INFO
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12. STABILIZE SUSPENSION

	Click here INFO
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13. INSTALL REAR NO. 1 SUSPENSION ARM ASSEMBLY LH



(1) Install the rear No. 1 suspension arm assembly with the 2 bolts.

Torque:

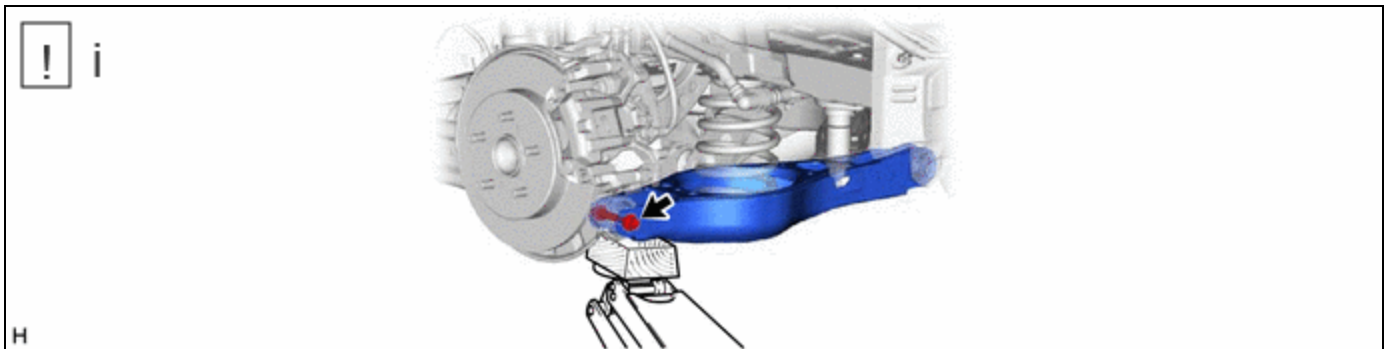
73 N·m {744 kgf·cm, 54 ft·lbf}

NOTICE:

Because the nut has its own stopper, do not turn the nut. Tighten the bolt with the nut secured.

14. INSTALL REAR NO. 1 SUSPENSION ARM ASSEMBLY RH

15. INSTALL REAR NO. 2 SUSPENSION ARM ASSEMBLY LH



(1) Install the rear No. 2 suspension arm assembly (rear axle carrier sub-assembly side) with the bolt.

Torque:

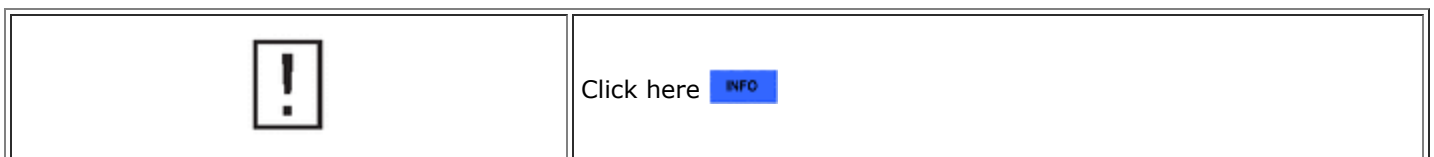
73 N·m {744 kgf·cm, 54 ft·lbf}

NOTICE:

Because the nut has its own stopper, do not turn the nut. Tighten the bolt with the nut secured.

16. INSTALL REAR NO. 2 SUSPENSION ARM ASSEMBLY RH

17. INSTALL REAR UPPER CONTROL ARM ASSEMBLY LH

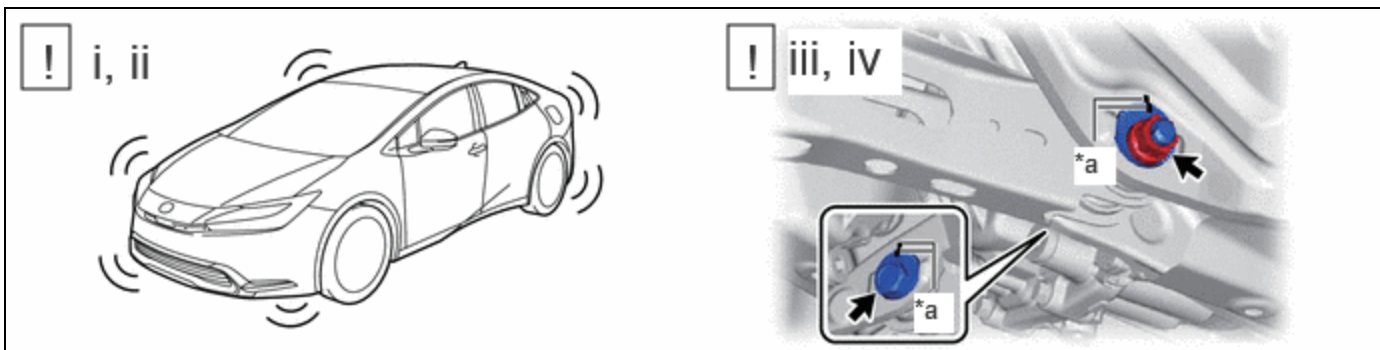


18. INSTALL REAR UPPER CONTROL ARM ASSEMBLY RH

19. INSTALL REAR FLEXIBLE HOSE LH

Click here [INFO](#)

20. INSTALL REAR FLEXIBLE HOSE RH

21. INSTALL REAR STABILIZER LINK ASSEMBLY LHClick here [INFO](#)**22. INSTALL REAR STABILIZER LINK ASSEMBLY RH****23. INSTALL TAIL EXHAUST PIPE ASSEMBLY**Click here [INFO](#)**24. INSTALL REAR WHEEL**Click here [INFO](#)**25. INSTALL REAR SUSPENSION TOE ADJUST CAM SUB-ASSEMBLY (for LH Side)**

*a	Matchmark	-	-
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- (1) Lower the vehicle to the ground.
- (2) Bounce the vehicle up and down at the corners to stabilize the rear suspension.
- (3) Align the matchmarks on the No. 2 camber adjust cam, rear suspension toe adjust cam sub-assembly and rear suspension member sub-assembly.
- (4) Fully tighten the nut.

Torque:**100 N·m {1020 kgf·cm, 74 ft·lbf}****NOTICE:**

- Hold the rear suspension toe adjust cam sub-assembly while rotating the nut.
- Make sure that the vehicle is unloaded when fully tightening the nut.

26. INSTALL REAR SUSPENSION TOE ADJUST CAM SUB-ASSEMBLY (for RH Side)**27. INSTALL BATTERY BOX COVER**Click here [INFO](#)**28. INSPECT FOR EXHAUST GAS LEAK**Click here [INFO](#)**29. INSPECT AND ADJUST REAR WHEEL ALIGNMENT**Click here [INFO](#)

30. PERFORM INITIALIZATION

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

