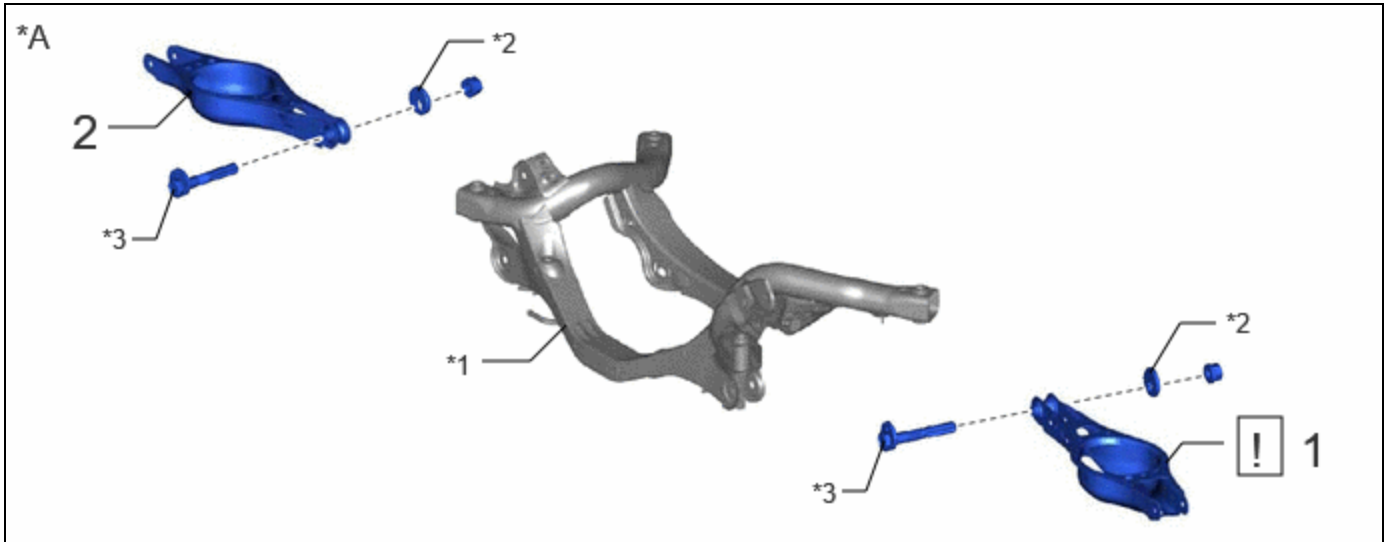


Last Modified: 12-04-2024	6.11:8.1.0	Doc ID: RM10000002BCP7
Model Year Start: 2023	Model: Prius Prime	Prod Date Range: [03/2023 -]
Title: REAR SUSPENSION: REAR SUSPENSION MEMBER (for 2WD): INSTALLATION; 2023 - 2024 MY Prius Prius Prime [03/2023 -]		

INSTALLATION

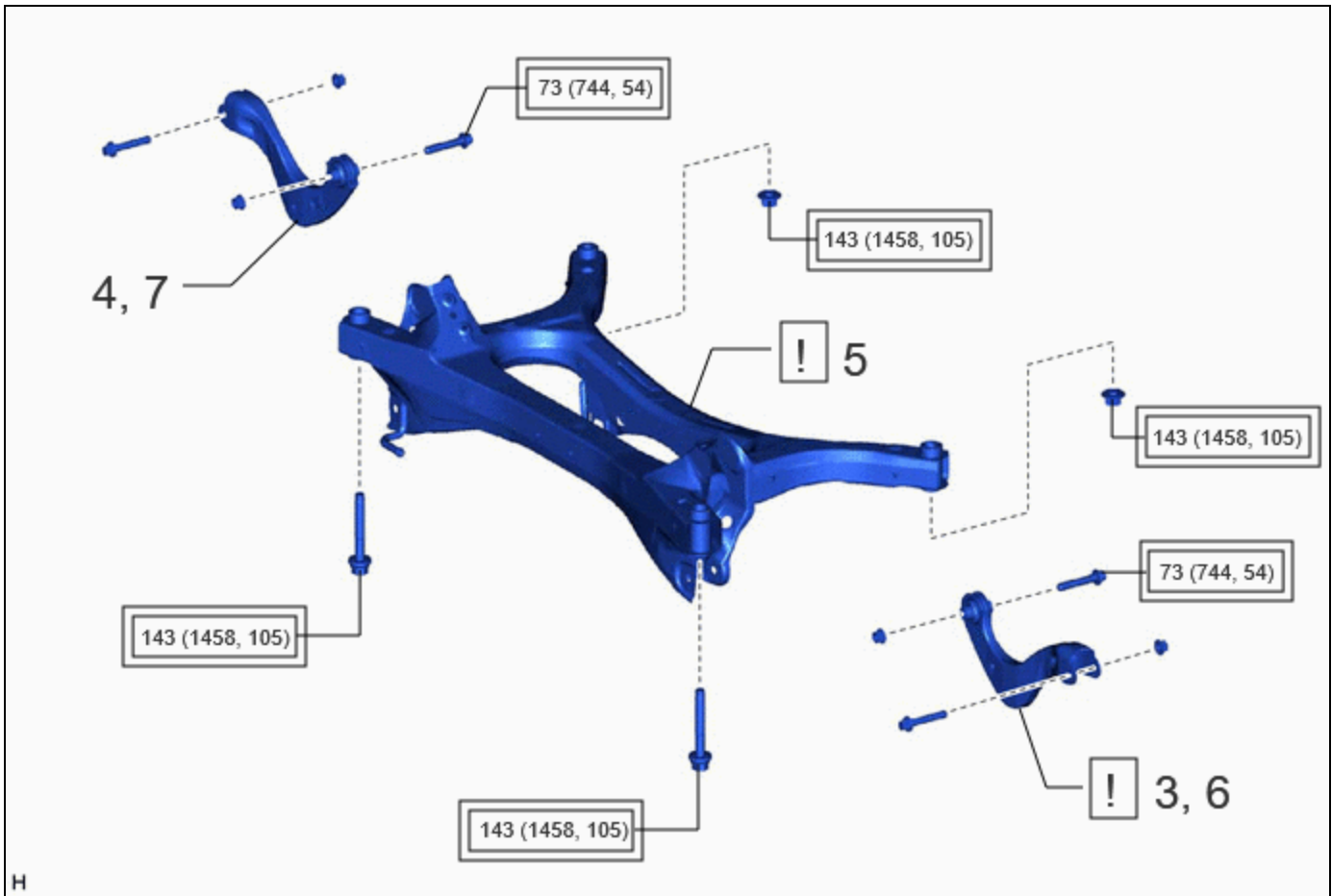
CAUTION / NOTICE / HINT




COMPONENTS (INSTALLATION)




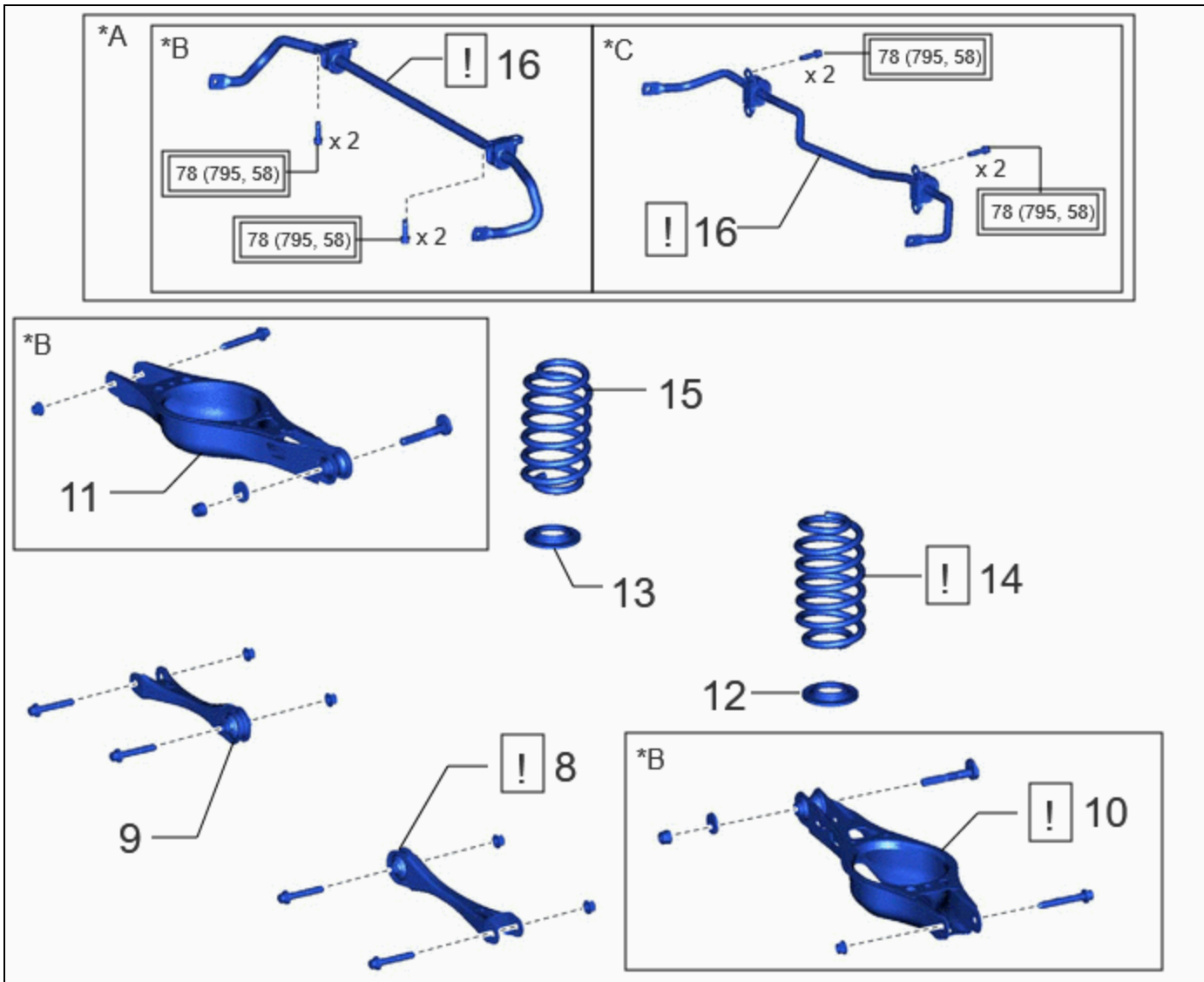
PROCEDURE		PART NAME CODE			
1	REAR NO. 2 SUSPENSION ARM ASSEMBLY LH	48740F	INFO	-	-
2	REAR NO. 2 SUSPENSION ARM ASSEMBLY RH	48730F	-	-	-

*A	for PHEV Model	-	-
*1	REAR SUSPENSION MEMBER SUB-ASSEMBLY	*2	NO. 2 CAMBER ADJUST CAM
*3	REAR SUSPENSION TOE ADJUST CAM SUB-ASSEMBLY	-	-




PROCEDURE	PART NAME CODE			
3 INSTALL REAR UPPER CONTROL ARM ASSEMBLY LH	48790	INFO	-	-
4 INSTALL REAR UPPER CONTROL ARM ASSEMBLY RH	48770A	-	-	-
5 REAR SUSPENSION MEMBER SUB-ASSEMBLY	51206A	INFO	-	-
6 TEMPORARILY INSTALL REAR UPPER CONTROL ARM ASSEMBLY LH	48790	INFO	-	-
7 TEMPORARILY INSTALL REAR UPPER CONTROL ARM ASSEMBLY RH	48770A	-	-	-

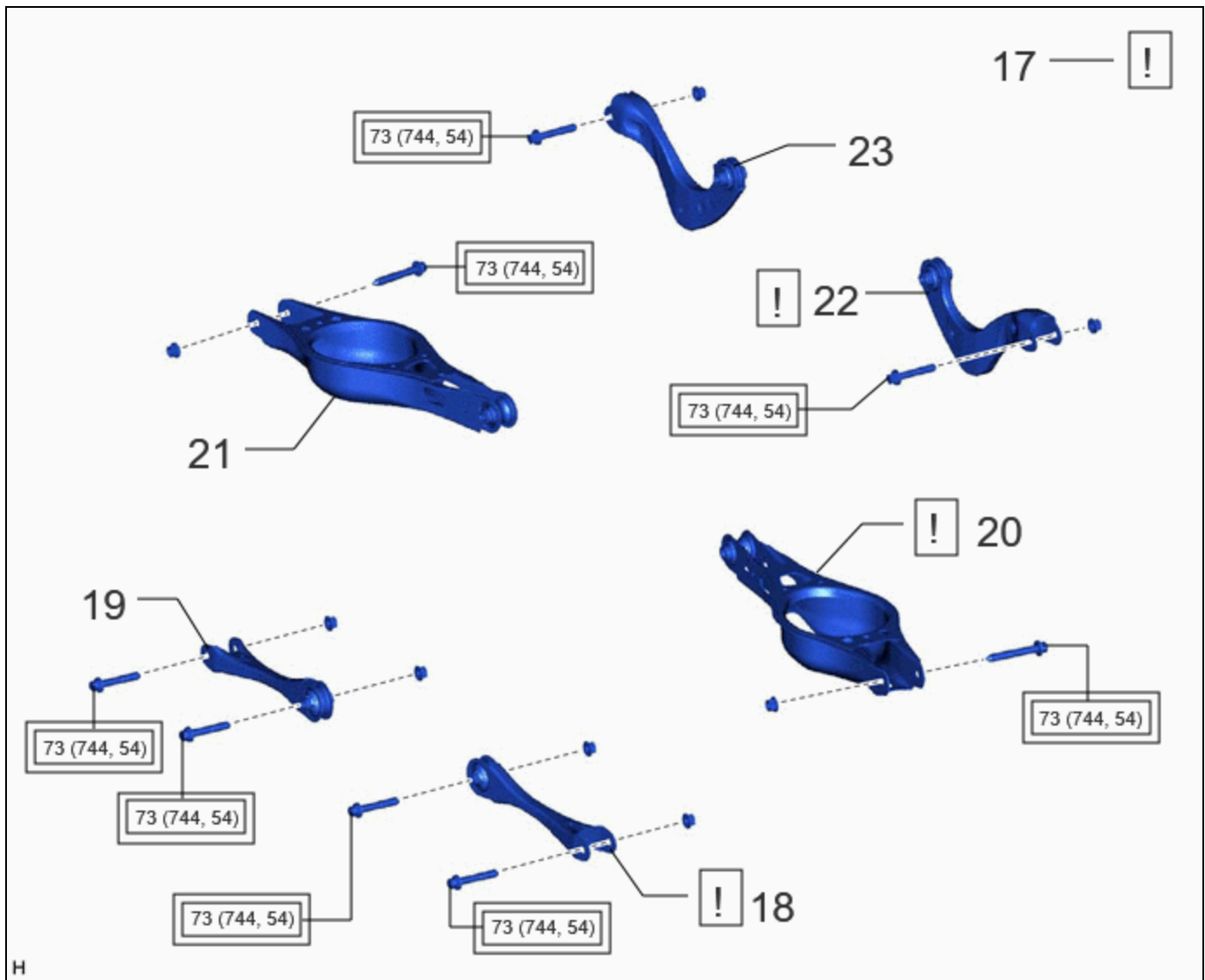
	Tightening torque for "Major areas involving basic vehicle performance such as moving/turning/stopping": N*m (kgf*cm, ft.*lbf)	-
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PROCEDURE		PART NAME CODE			
8	REAR NO. 1 SUSPENSION ARM ASSEMBLY LH	48720A	INFO	-	-
9	REAR NO. 1 SUSPENSION ARM ASSEMBLY RH	48710A	-	-	-
10	REAR NO. 2 SUSPENSION ARM ASSEMBLY LH	48740F	INFO	-	-
11	REAR NO. 2 SUSPENSION ARM ASSEMBLY RH	48730F	-	-	-
12	REAR LOWER COIL SPRING INSULATOR LH	48258C	-	-	-
13	REAR LOWER COIL SPRING INSULATOR RH	48258B	-	-	-
14	REAR COIL SPRING LH	48231B	INFO	-	-
15	REAR COIL SPRING RH	48231A	-	-	-
16	REAR STABILIZER BAR	48812	INFO	-	-

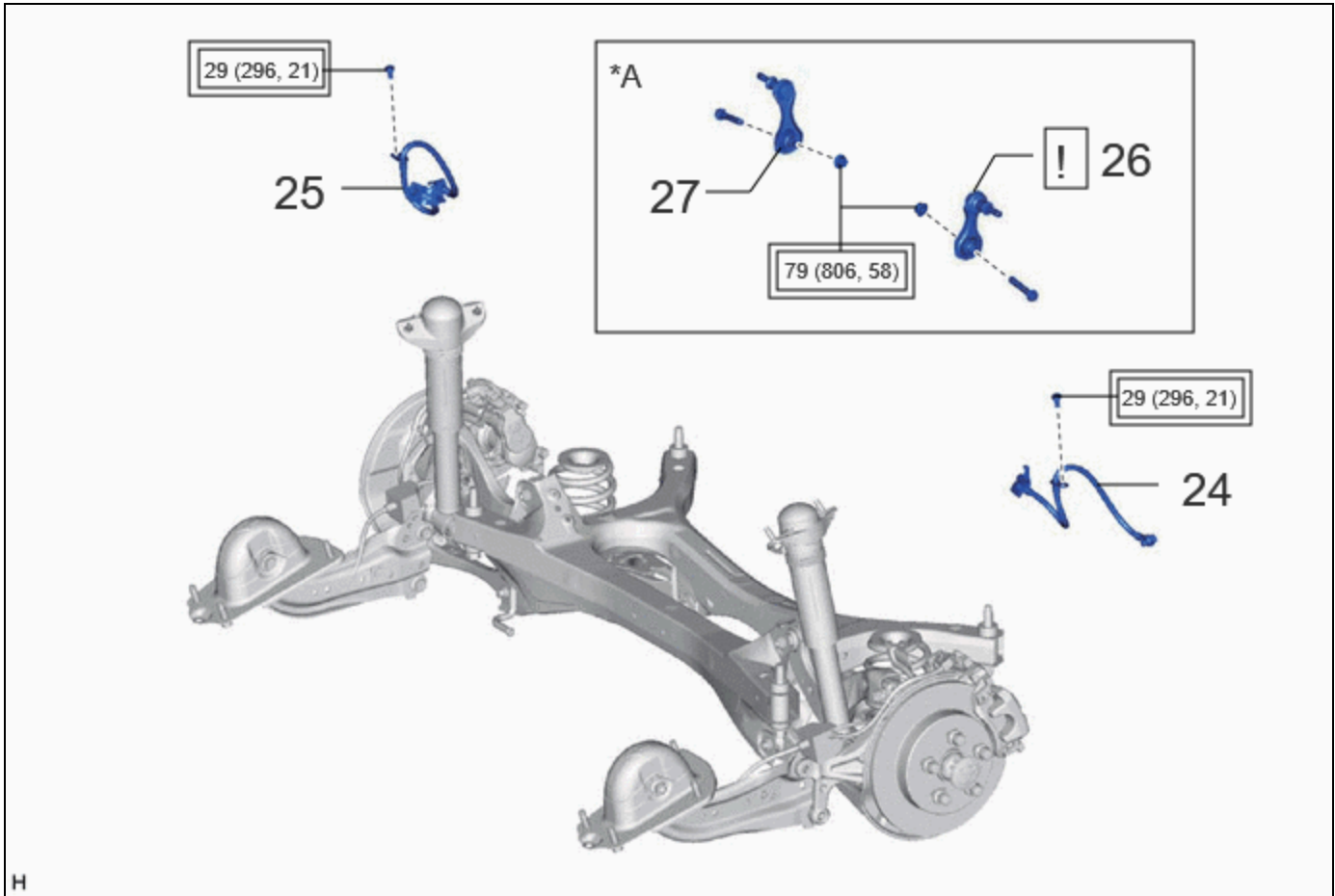
*A	w/ Stabilizer Bar	*B	for HEV Model
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*C	for PHEV Model	-	-
	Tightening torque for "Major areas involving basic vehicle performance such as moving/turning/stopping": N*m (kgf*cm, ft.*lbf)	-	-




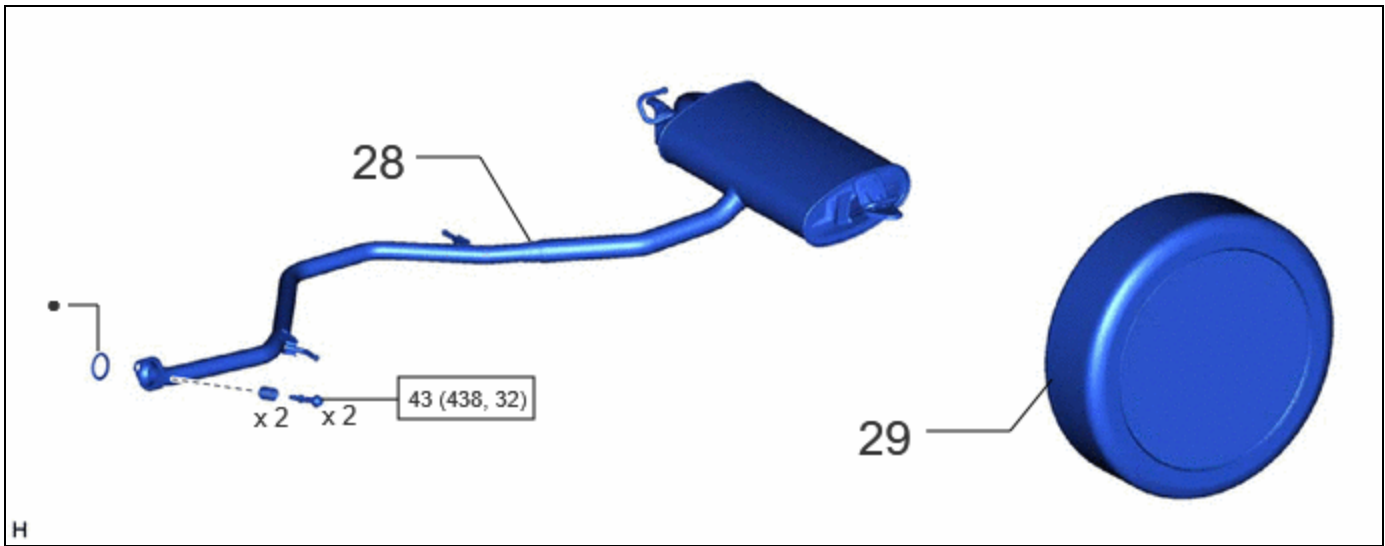
PROCEDURE		PART NAME CODE			
17	STABILIZE SUSPENSION	-	INFO	-	-
18	REAR NO. 1 SUSPENSION ARM ASSEMBLY LH	48720A	INFO	-	-
19	REAR NO. 1 SUSPENSION ARM ASSEMBLY RH	48710A	-	-	-
20	REAR NO. 2 SUSPENSION ARM ASSEMBLY LH	48740F	INFO	-	-
21	REAR NO. 2 SUSPENSION ARM ASSEMBLY RH	48730F	-	-	-
22	REAR UPPER CONTROL ARM ASSEMBLY LH	48790	INFO	-	-
23	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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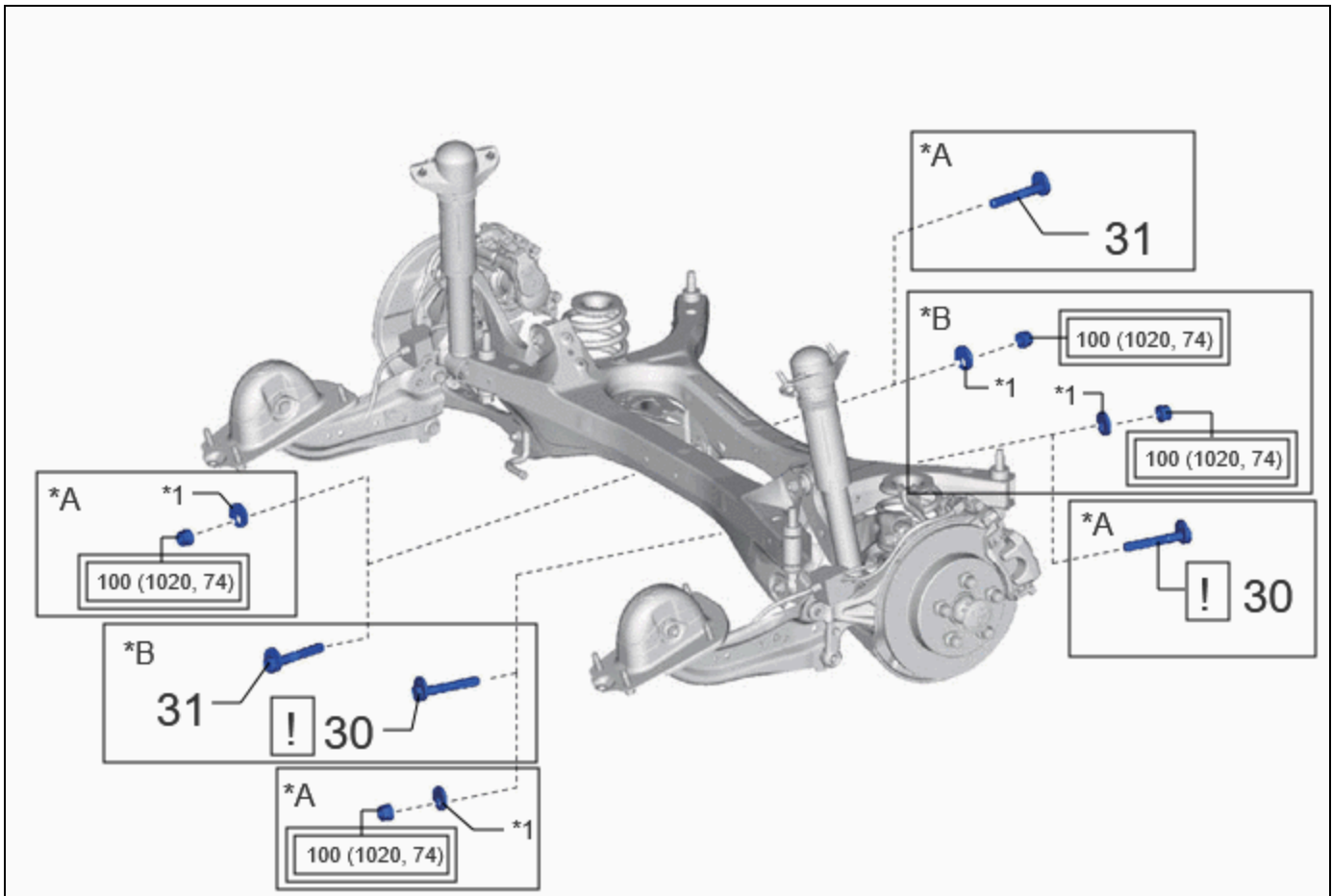
PROCEDURE		PART NAME CODE			
24	REAR FLEXIBLE HOSE LH	47319F	-	-	-
25	REAR FLEXIBLE HOSE RH	47318F	-	-	-
26	REAR STABILIZER LINK ASSEMBLY LH	48840A	INFO	-	-
27	REAR STABILIZER LINK ASSEMBLY RH	48830D	-	-	-

*A	w/ Stabilizer Bar	-	-
	Tightening torque for "Major areas involving basic vehicle performance such as moving/turning/stopping": N*m (kgf*cm, ft.*lbf)	-	-



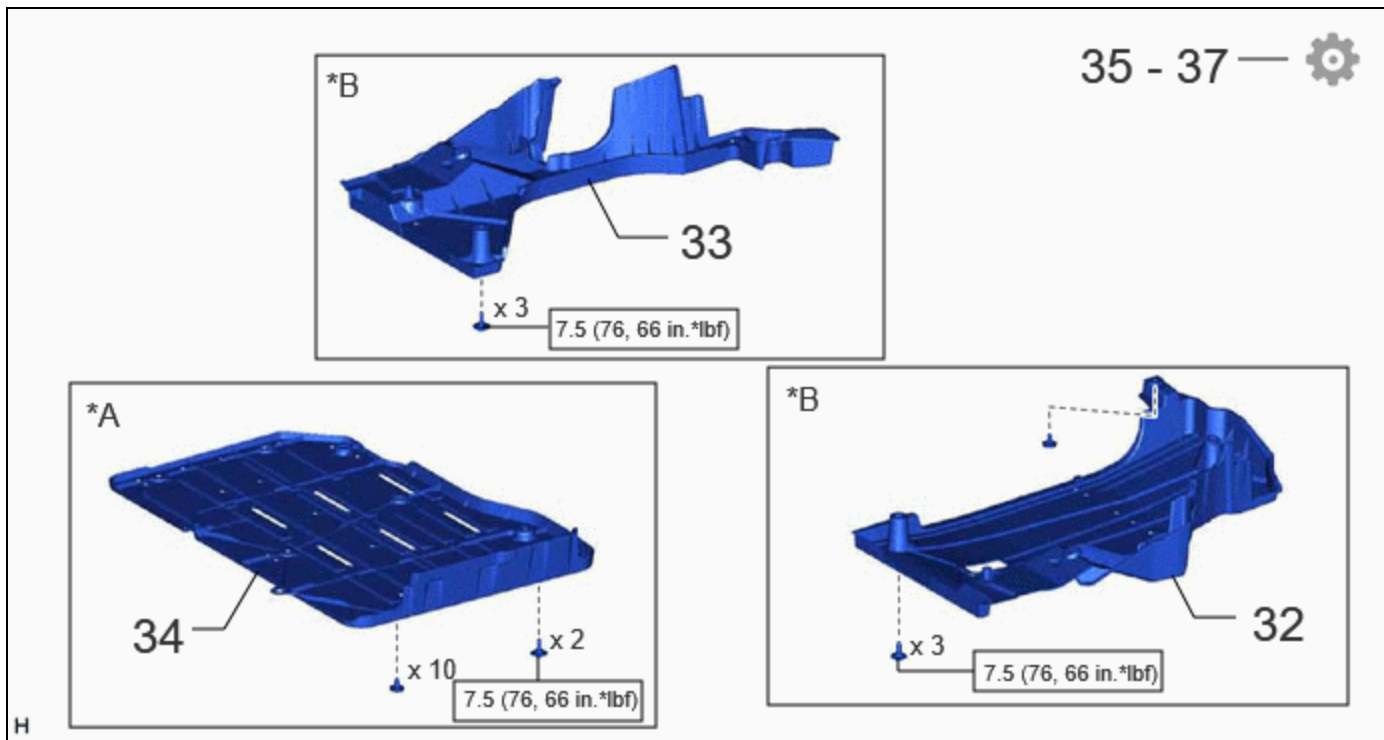
	PROCEDURE	PART NAME CODE			
28	TAIL EXHAUST PIPE ASSEMBLY	17430	-	-	-
29	REAR WHEEL	-	-	-	-

	N*m (kgf*cm, ft.*lbf): Specified torque	<ul style="list-style-type: none"> Non-reusable part
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PROCEDURE		PART NAME CODE			
30	REAR SUSPENSION TOE ADJUST CAM SUB-ASSEMBLY (for LH Side)	48409	INFO	-	-
31	REAR SUSPENSION TOE ADJUST CAM SUB-ASSEMBLY (for RH Side)	48409	-	-	-

*A	for HEV Model	*B	for PHEV Model
*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			
32	REAR FLOOR SIDE MEMBER COVER LH	57628E	-	-	-
33	REAR FLOOR SIDE MEMBER COVER RH	57627G	-	-	-
34	BATTERY BOX COVER	58219K	-	-	-
35	INSPECT FOR EXHAUST GAS LEAK	-	-	-	INFO
36	INSPECT AND ADJUST REAR WHEEL ALIGNMENT	-	-	-	INFO
37	PERFORM INITIALIZATION	-	-	-	INFO

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


PROCEDURE

1. TEMPORARILY INSTALL REAR NO. 2 SUSPENSION ARM ASSEMBLY LH (for PHEV Model)

	Click here INFO
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2. TEMPORARILY INSTALL REAR NO. 2 SUSPENSION ARM ASSEMBLY RH (for PHEV Model)

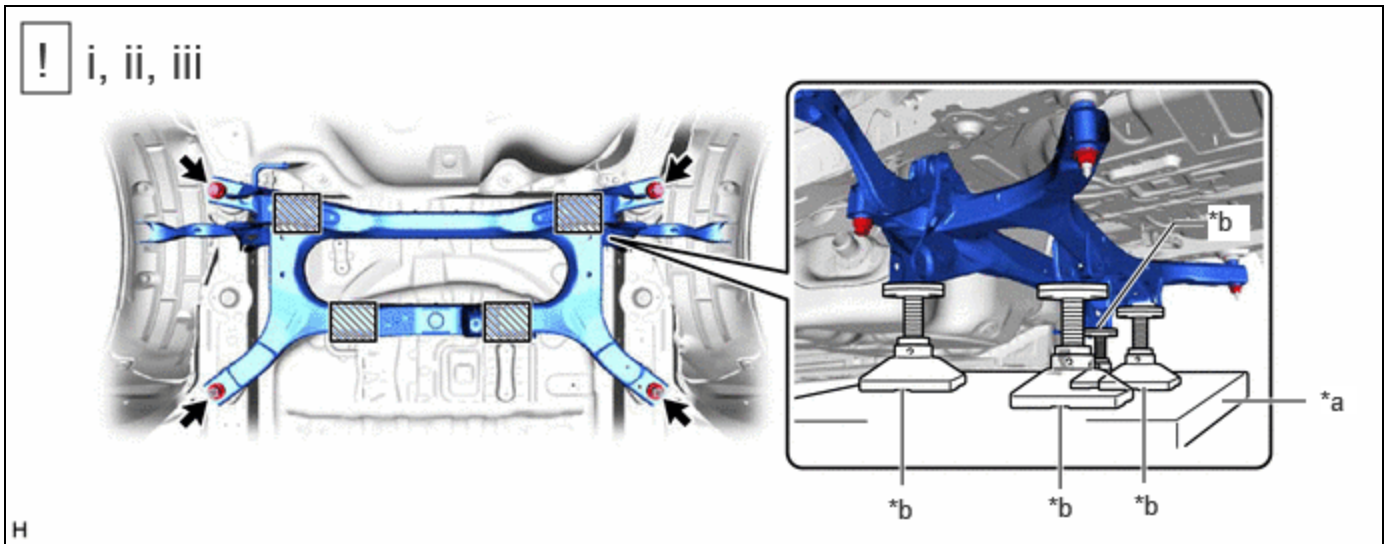
3. INSTALL REAR UPPER CONTROL ARM ASSEMBLY LH


	Click here INFO
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4. INSTALL REAR UPPER CONTROL ARM ASSEMBLY RH

5. INSTALL REAR SUSPENSION MEMBER SUB-ASSEMBLY

(a) for HEV Model

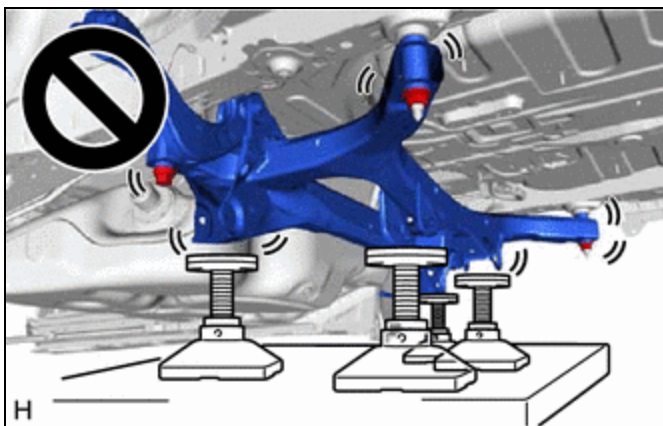


	*a	*b	
	Engine Lifter	Attachment	
	Attachment Placement Location	-	-

(1) Using an engine lifter and 4 attachments or equivalent tools, support the rear suspension member sub-assembly as shown in the illustration.

CAUTION:

- The rear suspension member sub-assembly is a very heavy component. Make sure that it is supported securely.
- If the rear suspension member sub-assembly is not securely supported, it may drop, resulting in serious injury.



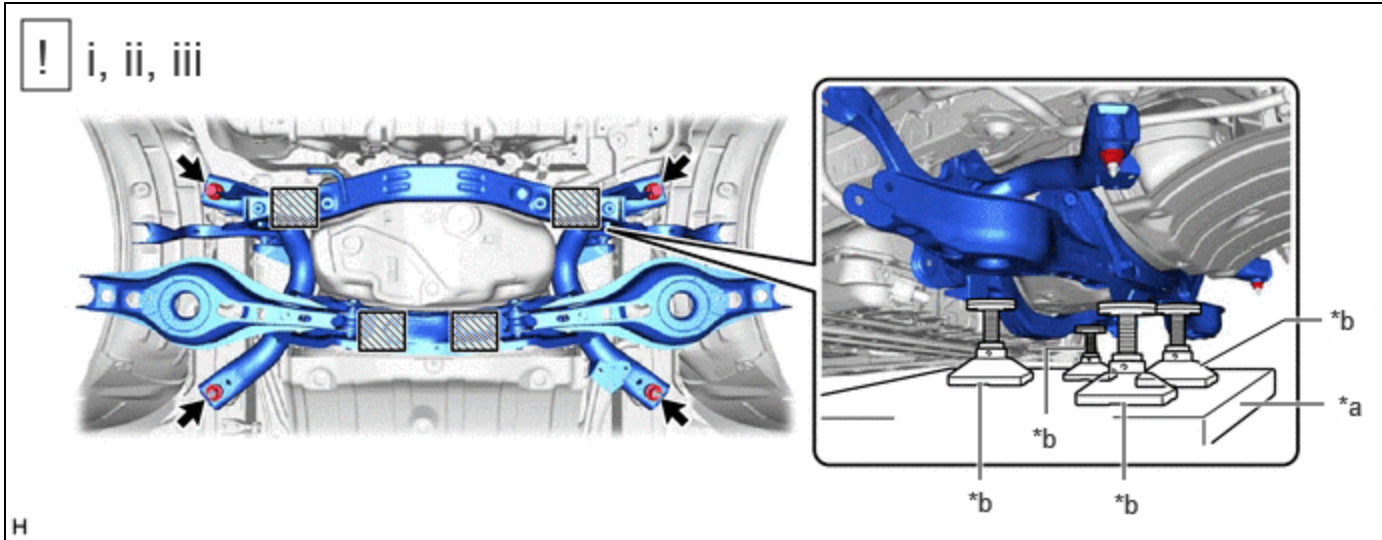
NOTICE:

- Use attachments or equivalent tools to keep the rear suspension member sub-assembly level.
 - Keep supporting the rear suspension member sub-assembly until the installation has been completed.
- (2) Raise the rear suspension member sub-assembly until there is no clearance between the rear suspension member sub-assembly and vehicle.
 - (3) Install the rear suspension member sub-assembly with the 2 bolts and 2 nuts.

Torque:

143 N·m {1458 kgf·cm, 105 ft·lbf}

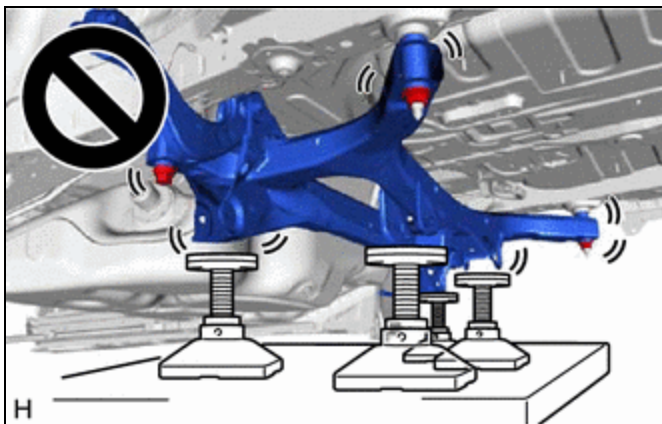
(b) for PHEV Model



(1) Using an engine lifter and 4 attachments or equivalent tools, support the rear suspension member sub-assembly as shown in the illustration.

CAUTION:

- The rear suspension member sub-assembly is a very heavy component. Make sure that it is supported securely.
- If the rear suspension member sub-assembly is not securely supported, it may drop, resulting in serious injury.

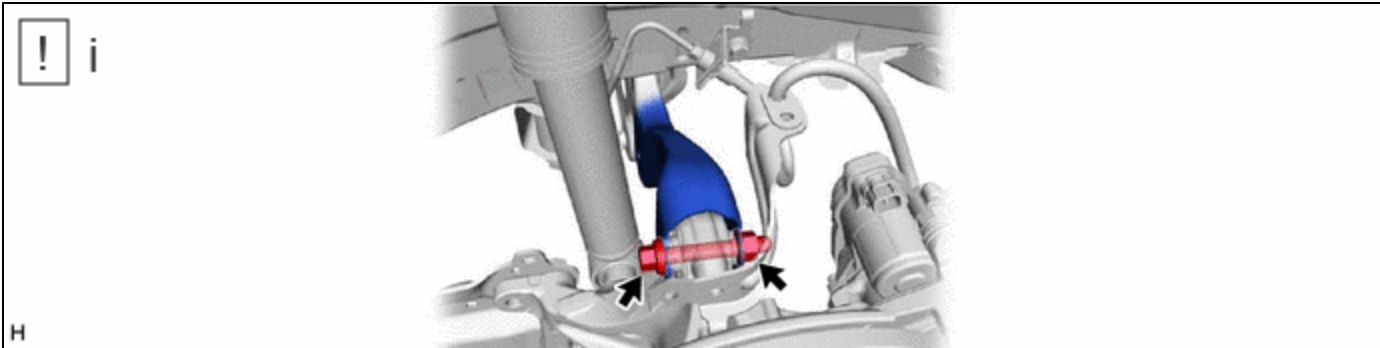


NOTICE:

- Use attachments or equivalent tools to keep the rear suspension member sub-assembly level.
 - Keep supporting the rear suspension member sub-assembly until the installation has been completed.
- (2) Raise the rear suspension member sub-assembly until there is no clearance between the rear suspension member sub-assembly and vehicle.
 - (3) Install the rear suspension member sub-assembly with the 2 bolts and 2 nuts.

Torque:

143 N·m {1458 kgf·cm, 105 ft·lbf}


6. 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.

7. TEMPORARILY INSTALL REAR UPPER CONTROL ARM ASSEMBLY RH**8. TEMPORARILY INSTALL REAR NO. 1 SUSPENSION ARM ASSEMBLY LH**

	<p>for HEV Model: Click here INFO</p> <p>for PHEV Model: Click here INFO</p>
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9. TEMPORARILY INSTALL REAR NO. 1 SUSPENSION ARM ASSEMBLY RH**10. TEMPORARILY INSTALL REAR NO. 2 SUSPENSION ARM ASSEMBLY LH (for HEV Model)**

	<p>Click here INFO</p>
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11. TEMPORARILY INSTALL REAR NO. 2 SUSPENSION ARM ASSEMBLY RH (for HEV Model)**12. INSTALL REAR LOWER COIL SPRING INSULATOR LH****13. INSTALL REAR LOWER COIL SPRING INSULATOR RH****14. INSTALL REAR COIL SPRING LH**



Click here [INFO](#)

15. INSTALL REAR COIL SPRING RH

16. INSTALL REAR STABILIZER BAR (w/ Stabilizer Bar)



for HEV Model: Click here [INFO](#)

for PHEV Model: Click here [INFO](#)

17. STABILIZE SUSPENSION



Click here [INFO](#)

18. INSTALL REAR NO. 1 SUSPENSION ARM ASSEMBLY LH



for HEV Model: Click here [INFO](#)

for PHEV Model: Click here [INFO](#)

19. INSTALL REAR NO. 1 SUSPENSION ARM ASSEMBLY RH

20. INSTALL REAR NO. 2 SUSPENSION ARM ASSEMBLY LH



for HEV Model: Click here [INFO](#)

for PHEV Model: Click here [INFO](#)

21. INSTALL REAR NO. 2 SUSPENSION ARM ASSEMBLY RH

22. INSTALL REAR UPPER CONTROL ARM ASSEMBLY LH



Click here [INFO](#)

23. INSTALL REAR UPPER CONTROL ARM ASSEMBLY RH

24. INSTALL REAR FLEXIBLE HOSE LH

Click here [INFO](#)

25. INSTALL REAR FLEXIBLE HOSE RH

26. INSTALL REAR STABILIZER LINK ASSEMBLY LH (w/ Stabilizer Bar)

	Click here INFO
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27. INSTALL REAR STABILIZER LINK ASSEMBLY RH (w/ Stabilizer Bar)

28. INSTALL TAIL EXHAUST PIPE ASSEMBLY


for M20A-FXS: Click here [INFO](#)

for 2ZR-FXE: Click here [INFO](#)

29. INSTALL REAR WHEEL

Click here [INFO](#)

30. INSTALL REAR SUSPENSION TOE ADJUST CAM SUB-ASSEMBLY (for LH Side)

	for HEV Model: Click here INFO for PHEV Model: Click here INFO
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31. INSTALL REAR SUSPENSION TOE ADJUST CAM SUB-ASSEMBLY (for RH Side)

32. INSTALL REAR FLOOR SIDE MEMBER COVER LH (for HEV Model)

Click here [INFO](#)

33. INSTALL REAR FLOOR SIDE MEMBER COVER RH (for HEV Model)

Click here [INFO](#)

34. INSTALL BATTERY BOX COVER (for PHEV Model)

Click here [INFO](#)

35. INSPECT FOR EXHAUST GAS LEAK

for M20A-FXS: Click here [INFO](#)

for 2ZR-FXE: Click here [INFO](#)

36. INSPECT AND ADJUST REAR WHEEL ALIGNMENT

Click here [INFO](#)

37. PERFORM INITIALIZATION

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

