

Last Modified: 12-04-2024	6.11:8.1.0	Doc ID: RM100000002924X
Model Year Start: 2023	Model: Prius Prime	Prod Date Range: [12/2022 -]
Title: DOOR / HATCH: FRONT DOOR: REASSEMBLY; 2023 - 2024 MY Prius Prius Prime [12/2022 -]		

REASSEMBLY

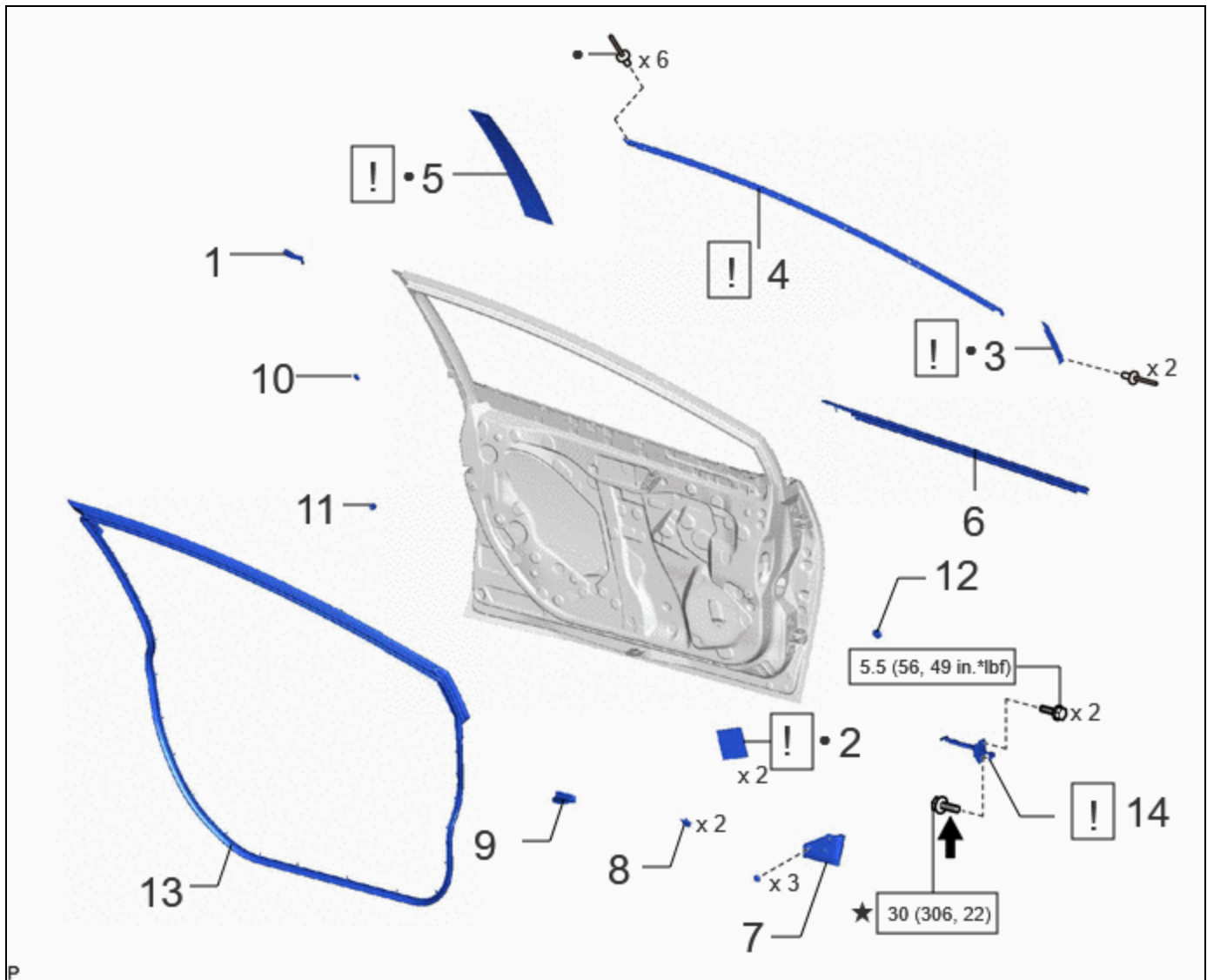
CAUTION / NOTICE / HINT




HINT:



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

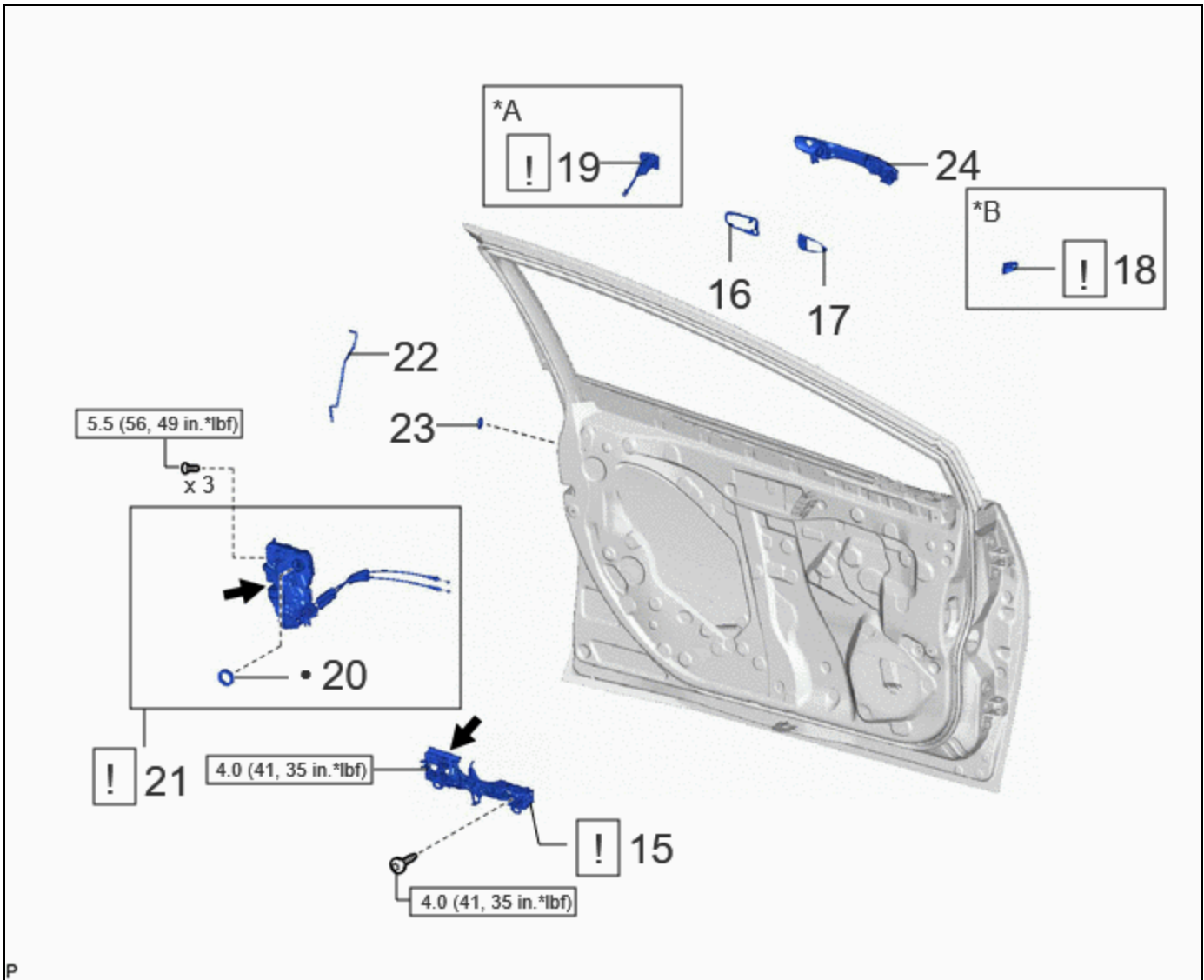
CAUTION / NOTICE / HINT

COMPONENTS (REASSEMBLY)





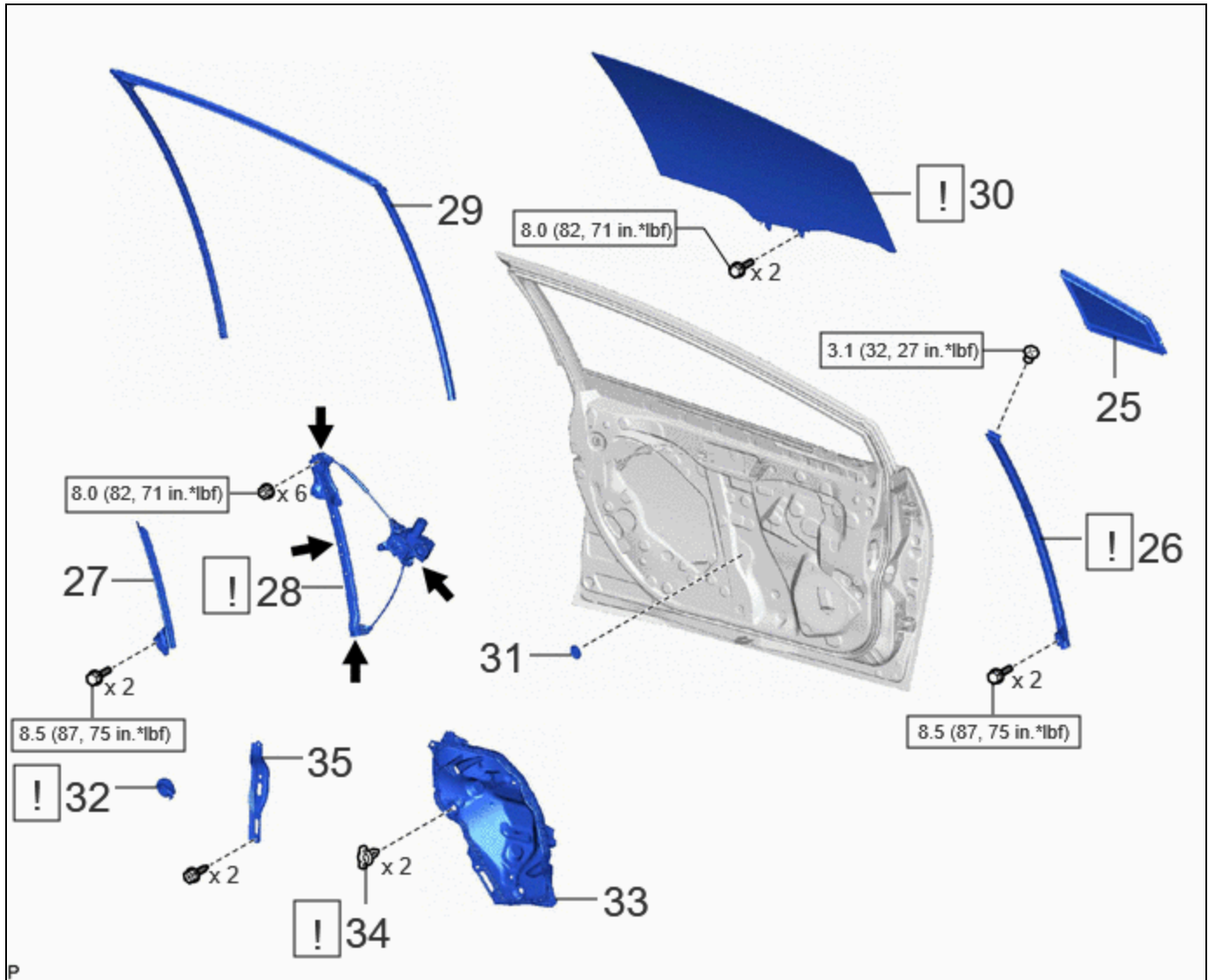
	PROCEDURE	PART NAME CODE			
1	FRONT DOOR REAR OUTSIDE SEAL	67852D	-	-	-
2	FRONT DOOR SILENCER PAD	67811	INFO	-	-
3	FRONT DOOR WINDOW FRAME FRONT MOULDING	75752C	INFO	-	-
4	FRONT DOOR WINDOW FRAME UPPER MOULDING	75754A	INFO	-	-
5	FRONT DOOR WINDOW FRAME REAR MOULDING	75756C	INFO	-	-
6	FRONT DOOR BELT MOULDING ASSEMBLY	75720	-	-	-
7	NO. 3 FRONT DOOR WEATHERSTRIP	67866A	-	-	-
8	DOOR DUST PROOF SEAL	67837F	-	-	-
9	NO. 2 FRONT DOOR SERVICE HOLE COVER	67834	-	-	-
10	DOOR WINDOW FRAME MOULDING CLIP	75792	-	-	-
11	FRONT DOOR PANEL CUSHION	67001A	-	-	-
12	HOLE PLUG	-	-	-	-
13	FRONT DOOR WEATHERSTRIP	67862	-	-	-
14	FRONT DOOR CHECK ASSEMBLY	68610	INFO	-	-




	N*m (kgf*cm, ft.*lbf): Specified torque		• Non-reusable part
	Toyota Genuine Adhesive 1324, Three Bond 1324 or equivalent	-	-
★	Precoated part	-	-








PROCEDURE		PART NAME CODE			
15	FRONT DOOR OUTSIDE HANDLE FRAME SUB-ASSEMBLY	69202A	INFO	-	-
16	FRONT DOOR REAR OUTSIDE HANDLE PAD	69242E	-	-	-
17	FRONT DOOR FRONT OUTSIDE HANDLE PAD	69241H	-	-	-
18	FRONT DOOR OUTSIDE HANDLE COVER	69217F	INFO	-	-
19	FRONT DOOR LOCK CYLINDER ASSEMBLY	-	INFO	-	-
20	DOOR LOCK WIRING HARNESS SEAL	69318C	-	-	-
21	FRONT DOOR LOCK WITH MOTOR ASSEMBLY WITH CABLE	-	INFO	-	-
22	FRONT DOOR LOCK OPEN ROD	69312	-	-	-
23	HOLE PLUG	-	-	-	-
24	FRONT DOOR OUTSIDE HANDLE ASSEMBLY	69220	-	-	-

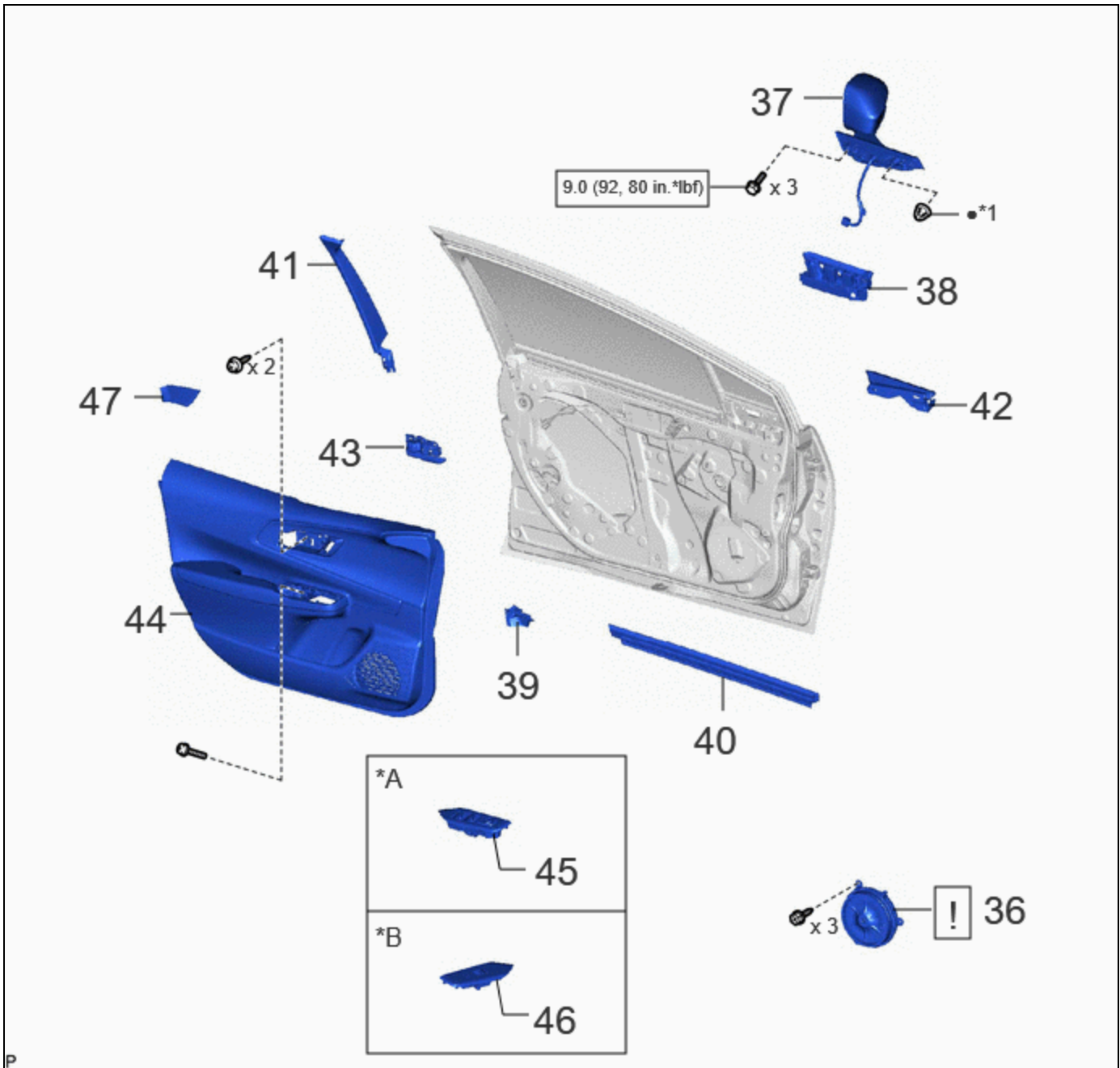
*A	for Driver Side	*B	for Front Passenger Side
	N*m (kgf*cm, ft.*lbf): Specified torque	•	Non-reusable part
	MP grease	-	-






PROCEDURE		PART NAME CODE			
25	FRONT DOOR FIX WINDOW GLASS	68126	-	-	-
26	FRONT DOOR FRONT LOWER FRAME SUB-ASSEMBLY	67402F	INFO	-	-
27	FRONT DOOR REAR LOWER FRAME SUB-ASSEMBLY	67404F	-	-	-
28	FRONT DOOR WINDOW REGULATOR ASSEMBLY	-	INFO	-	-


PROCEDURE		PART NAME CODE			
29	FRONT DOOR GLASS RUN	68151C	-	-	-
30	FRONT DOOR GLASS SUB-ASSEMBLY	68102	INFO	-	-
31	HOLE PLUG	-	-	-	-
32	SIDE AIR BAG PRESSURE SENSOR	8983AA	INFO	-	-
33	FRONT DOOR SERVICE HOLE COVER	67832	-	-	-
34	FRONT DOOR WEATHERSTRIP CLIP	67869B	INFO	-	-
35	FRONT DOOR TRIM BRACKET	67626	-	-	-

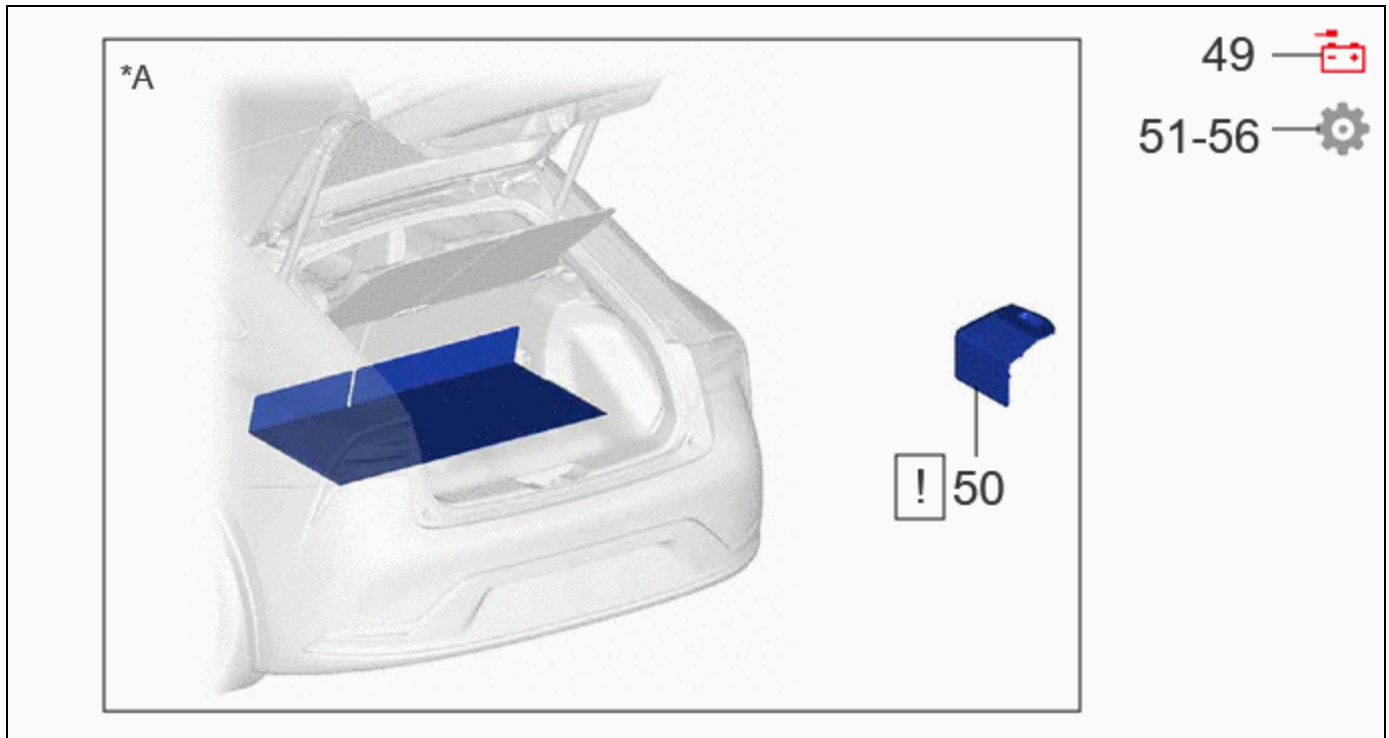
	N*m (kgf*cm, ft.*lbf): Specified torque		MP grease
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PROCEDURE		PART NAME CODE			
36	FRONT NO. 1 SPEAKER ASSEMBLY	86160	INFO	-	-
37	OUTER REAR VIEW MIRROR ASSEMBLY	87940	-	-	-
38	NO. 3 FRONT DOOR SERVICE HOLE COVER	67836C	-	-	-
39	FRONT DOOR PANEL PROTECTOR	67856B	-	-	-
40	FRONT DOOR INNER GLASS WEATHERSTRIP	68172A	-	-	-
41	DOOR FRAME GARNISH	67664C	-	-	-
42	FRONT DOOR LOWER FRAME BRACKET GARNISH	67492A	-	-	-

PROCEDURE		PART NAME CODE			
43	FRONT DOOR INSIDE HANDLE SUB-ASSEMBLY	69206B	-	-	-
44	FRONT DOOR TRIM BOARD SUB-ASSEMBLY	67602	-	-	-
45	MULTIPLEX NETWORK MASTER SWITCH ASSEMBLY WITH FRONT DOOR UPPER ARMREST BASE PANEL	-	-	-	-
46	POWER WINDOW REGULATOR SWITCH ASSEMBLY WITH FRONT DOOR UPPER ARMREST BASE PANEL	-	-	-	-
47	FRONT DOOR TRIM UPPER COVER	67782B	-	-	-

*A	for Driver Side	*B	for Front Passenger Side
*1	HOOK	-	-
	N*m (kgf*cm, ft.*lbf): Specified torque	•	Non-reusable part



PROCEDURE		PART NAME CODE			
48	CONNECT CABLE TO NEGATIVE AUXILIARY BATTERY TERMINAL	-	-	-	-

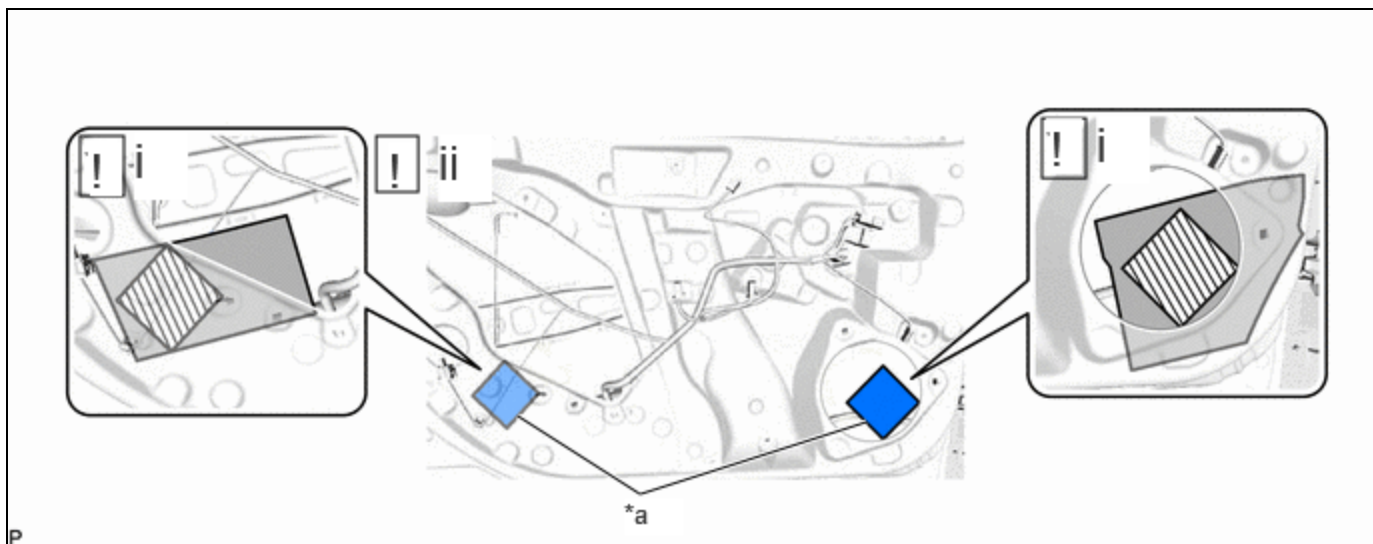
PROCEDURE		PART NAME CODE			
49	BATTERY SERVICE HOLE COVER ASSEMBLY	58440	INFO	-	-
50	INITIALIZATION AFTER RECONNECTING AUXILIARY BATTERY TERMINAL	-	-	-	INFO
51	INITIALIZE POWER WINDOW CONTROL SYSTEM	-	-	-	INFO
52	POWER WINDOW OPERATION	-	-	-	INFO
53	INSPECT SRS WARNING LIGHT	-	-	-	INFO
54	PERFORM CALIBRATION	-	-	-	INFO
55	CHECK DOOR LOCK OPERATION	-	-	-	INFO



*A	for M20A-FXS	-	-
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PROCEDURE

1. INSTALL FRONT DOOR REAR OUTSIDE SEAL

2. INSTALL FRONT DOOR SILENCER PAD



*a	Front Door Silencer Pad	-	-
	Cleaning Area		Front Door Silencer Pad Installation Area


- (1) Clean the front door panel surface.
 1. Remove any remaining butyl tape from the front door panel.
 2. Wipe off any tape adhesive residue with cleaner.
- (2) Install the 2 front door silencer pads.
 1. Remove the release paper from 2 new front door silencer pads.

HINT:


After removing the release paper, keep the exposed adhesive free from foreign matter.

2. Install the 2 front door silencer pads as shown in the illustration.


3. INSTALL FRONT DOOR WINDOW FRAME FRONT MOULDING

	<p>Click here INFO</p>
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4. INSTALL FRONT DOOR WINDOW FRAME UPPER MOULDING

	<p>Click here INFO</p>
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5. INSTALL FRONT DOOR WINDOW FRAME REAR MOULDING

	<p>Click here INFO</p>
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6. INSTALL FRONT DOOR BELT MOULDING ASSEMBLY

Click here [INFO](#)

7. INSTALL NO. 3 FRONT DOOR WEATHERSTRIP

8. INSTALL DOOR DUST PROOF SEAL

9. INSTALL NO. 2 FRONT DOOR SERVICE HOLE COVER

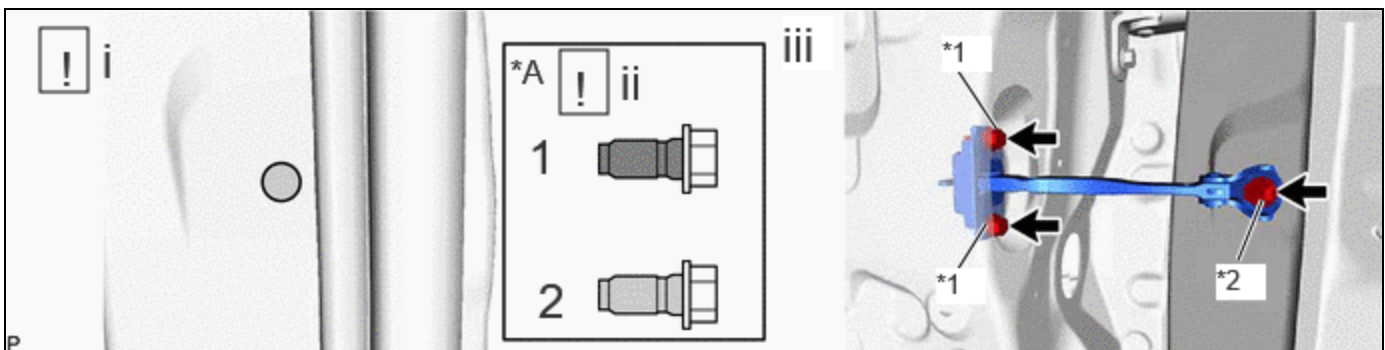
10. INSTALL DOOR WINDOW FRAME MOULDING CLIP

11. INSTALL FRONT DOOR PANEL CUSHION



12. INSTALL HOLE PLUG

13. INSTALL FRONT DOOR WEATHERSTRIP

14. INSTALL FRONT DOOR CHECK ASSEMBLY



*A	When reusing the bolt	-	-
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*1	Bolt (A)	*2	Bolt (B)
	Cleaning Area		Adhesive

- (1) Clean the bolt holes in the vehicle body.
- (2) When reusing the bolt:
 - 1. Clean the threads of the bolt.
 - 2. Apply adhesive to the threads of the bolt.

Adhesive:

Toyota Genuine Adhesive 1324, Three Bond 1324 or equivalent

- (3) Install the front door check assembly with the 3 bolts.

Torque:

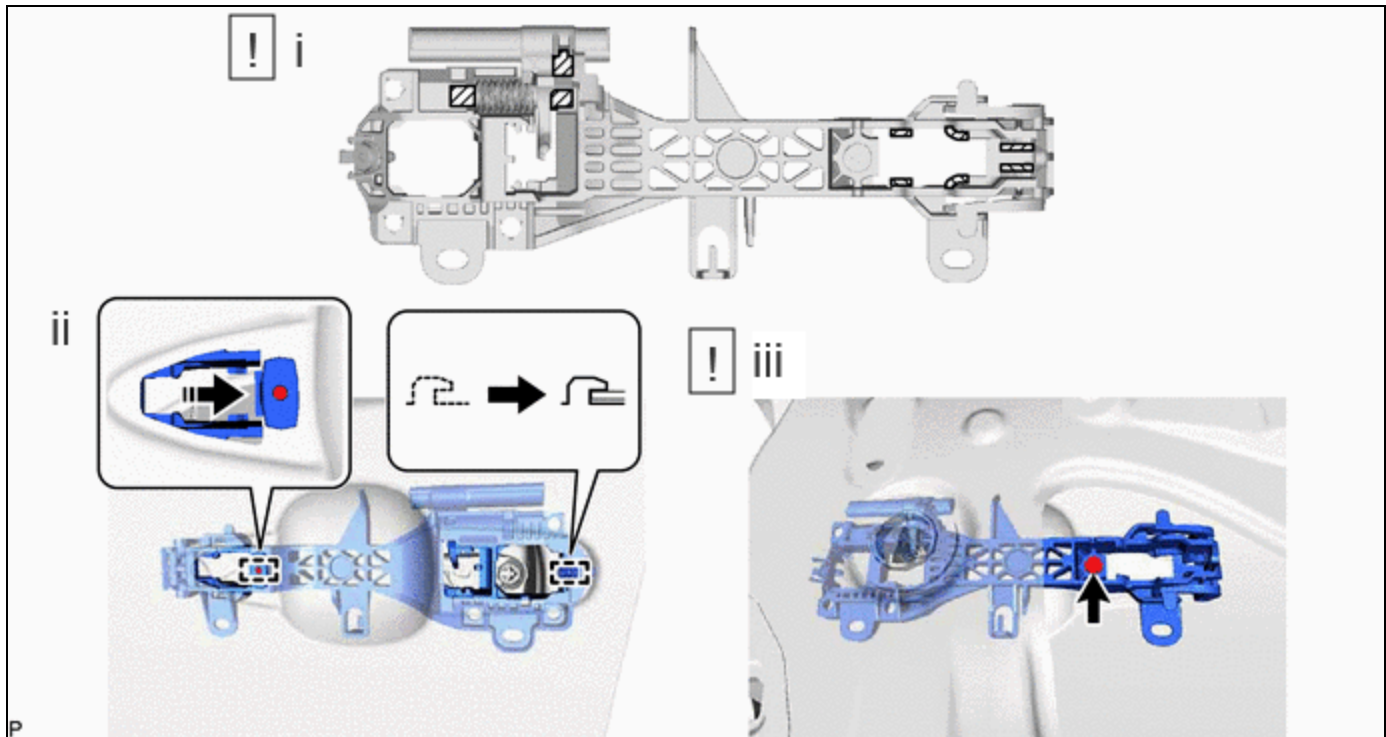
Bolt (A) :


5.5 N·m {56 kgf·cm, 49 in·lbf}

Bolt (B) :

30 N·m {306 kgf·cm, 22 ft·lbf}

15. INSTALL FRONT DOOR OUTSIDE HANDLE FRAME SUB-ASSEMBLY



	MP grease	-	-
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- (1) Apply MP grease to the sliding parts on the front door outside handle frame sub-assembly.
- (2) Engage the 2 guides as shown in the illustration.
- (3) Using a T30 "TORX" socket wrench, install the front door outside handle frame sub-assembly with the screw.

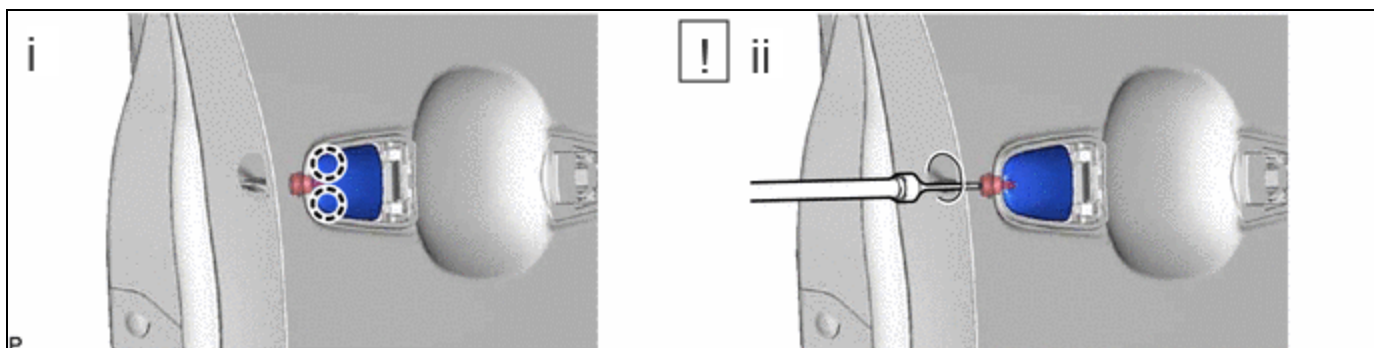
Torque:

4.0 N·m {41 kgf·cm, 35 in·lbf}

16. INSTALL FRONT DOOR REAR OUTSIDE HANDLE PAD

17. INSTALL FRONT DOOR FRONT OUTSIDE HANDLE PAD

18. INSTALL FRONT DOOR OUTSIDE HANDLE COVER (for Front Passenger Side)



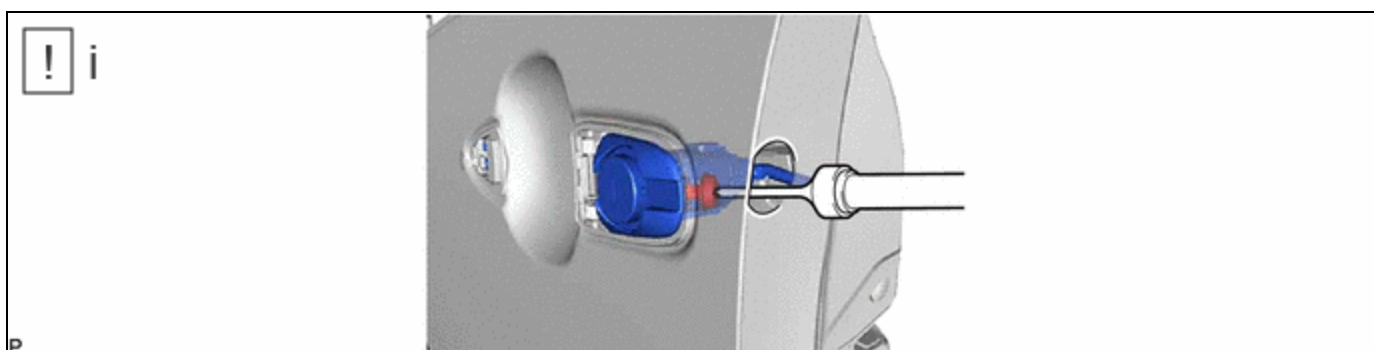
(1) Engage the 2 claws.

(2) Using a T30 "TORX" socket wrench, install the front door outside handle cover RH with the screw.

Torque:

4.0 N·m {41 kgf·cm, 35 in·lbf}

19. INSTALL FRONT DOOR LOCK CYLINDER ASSEMBLY (for Driver Side)



(1) Using a T30 "TORX" socket wrench, install the front door lock cylinder assembly with the screw.

Torque:

4.0 N·m {41 kgf·cm, 35 in·lbf}

20. INSTALL DOOR LOCK WIRING HARNESS SEAL

21. INSTALL FRONT DOOR LOCK WITH MOTOR ASSEMBLY WITH CABLE

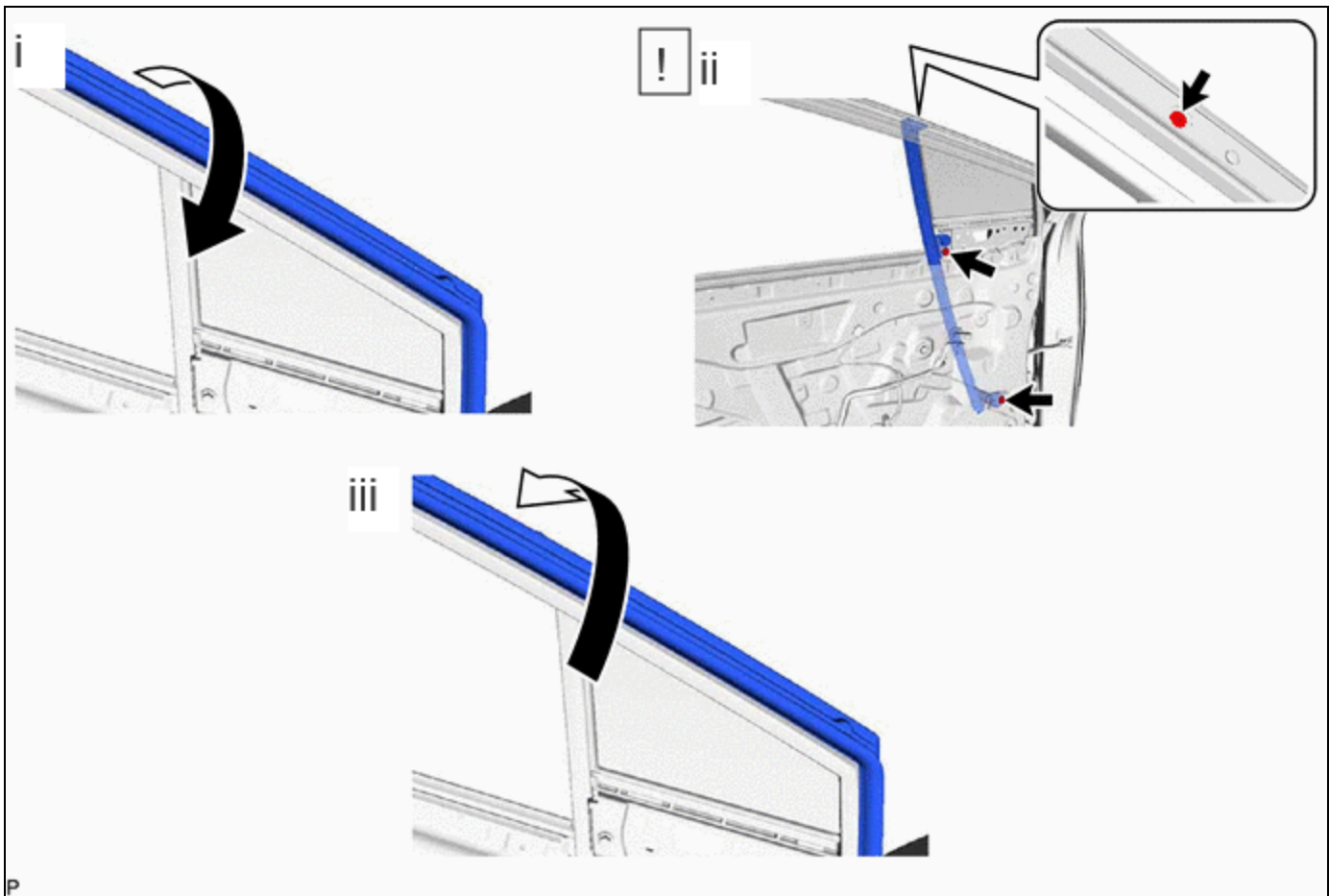


22. INSTALL FRONT DOOR LOCK OPEN ROD

23. INSTALL HOLE PLUG

24. INSTALL FRONT DOOR OUTSIDE HANDLE ASSEMBLY

25. INSTALL FRONT DOOR FIX WINDOW GLASS

26. INSTALL FRONT DOOR FRONT LOWER FRAME SUB-ASSEMBLY

(1) Lift up the front door weatherstrip as shown in the illustration.

(2) Install the front door front lower frame sub-assembly with the screw and 2 bolts.

Torque:**Bolt :**

8.5 N·m {87 kgf·cm, 75 in·lbf}

Screw :

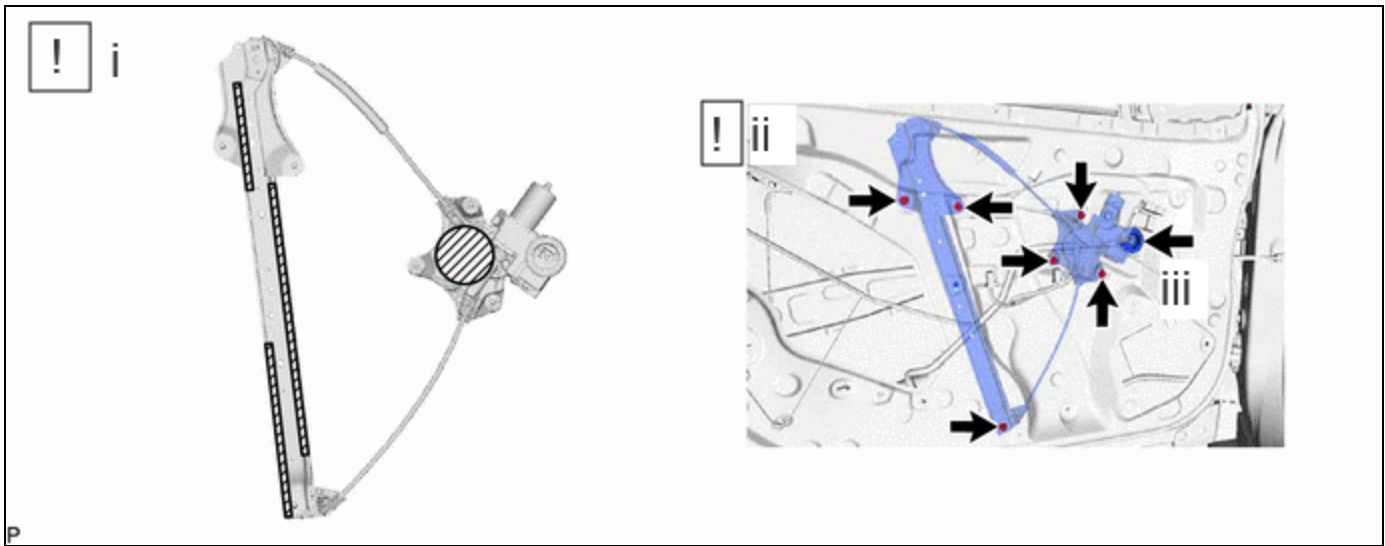
3.1 N·m {32 kgf·cm, 27 in·lbf}

(3) Install the front door weatherstrip to the original position.

27. INSTALL FRONT DOOR REAR LOWER FRAME SUB-ASSEMBLY**Torque:**

8.5 N·m {87 kgf·cm, 75 in·lbf}

28. INSTALL FRONT DOOR WINDOW REGULATOR ASSEMBLY



	MP grease	-	-
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- (1) Apply MP grease to the sliding parts of the front door window regulator assembly.
- (2) Install the front door window regulator assembly with the 6 nuts.

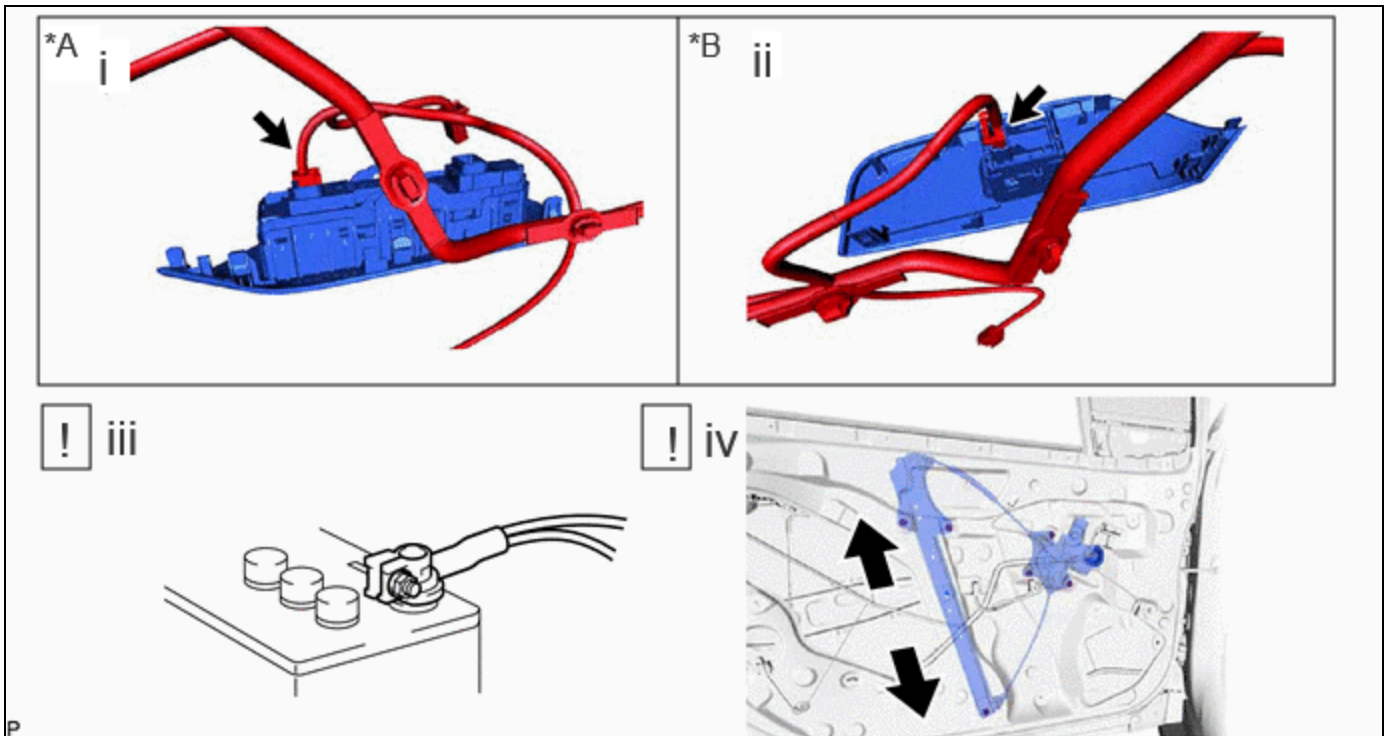
Torque:

8.0 N·m {82 kgf·cm, 71 in·lbf}

- (3) Connect the connector.

29. INSTALL FRONT DOOR GLASS RUN

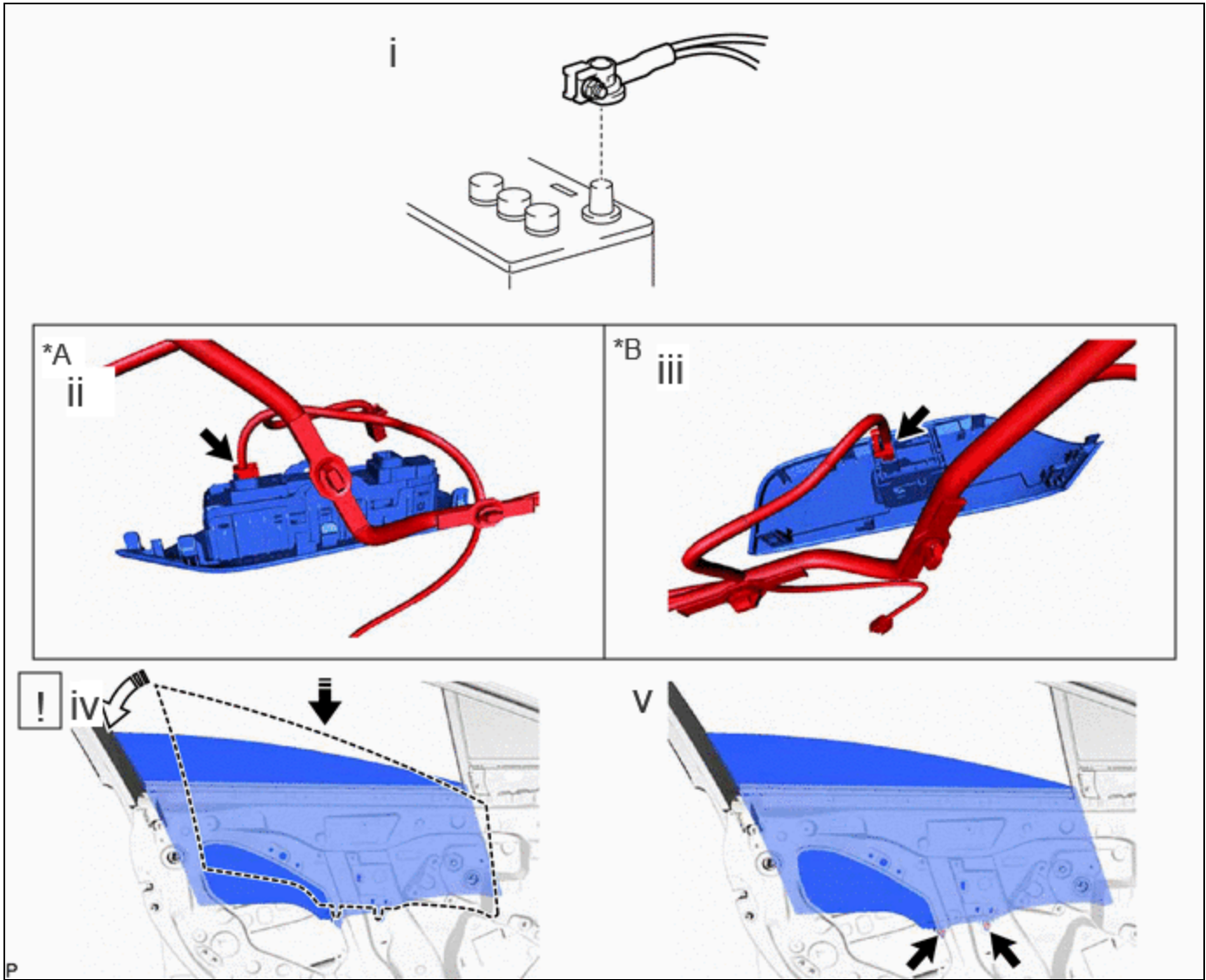
30. INSTALL FRONT DOOR GLASS SUB-ASSEMBLY



*A	for Driver Side	*B	for Front Passenger Side
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- (1) for Driver Side:

1. Connect the multiplex network master switch assembly.
- (2) for Front Passenger Side:
 1. Connect the power window regulator switch assembly.
- (3) Connect the cable to the negative (-) auxiliary battery terminal and turn the ignition switch to ON.
- (4) Move the front door window regulator assembly so that the door glass bolt holes can be seen and turn the ignition switch off.



*A	for Driver Side	*B	for Front Passenger Side
	Install in this Direction (1)		Install in this Direction (2)

- (1) Disconnect the cable from the negative (-) auxiliary battery terminal.
- (2) for Driver Side:
 1. Disconnect the multiplex network master switch assembly.
- (3) for Front Passenger Side:
 1. Disconnect the power window regulator switch assembly.
- (4) Insert the front door glass sub-assembly into the front door panel as shown in the illustration.

(5) Install the front door glass sub-assembly with the 2 bolts.

Torque:

8.0 N·m {82 kgf·cm, 71 in·lbf}

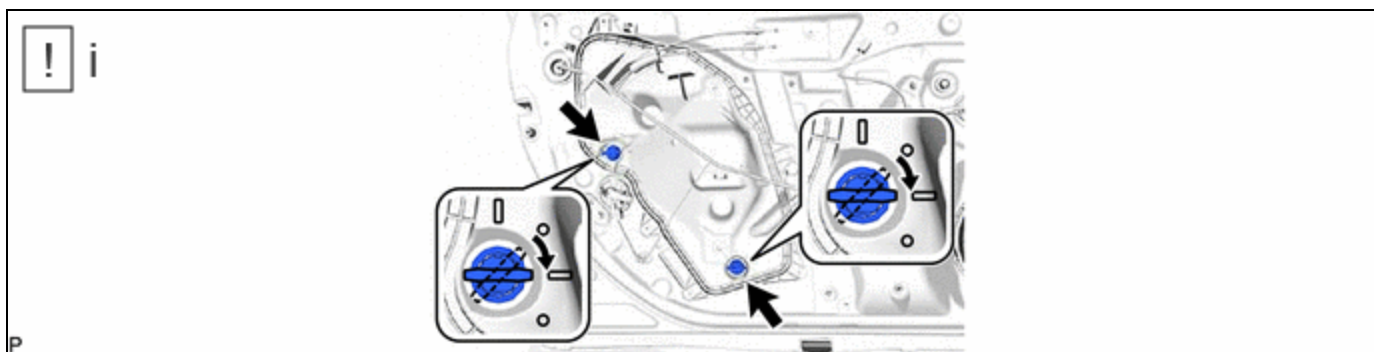
31. INSTALL HOLE PLUG

32. INSTALL SIDE AIR BAG PRESSURE SENSOR

	Click here INFO
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33. INSTALL FRONT DOOR SERVICE HOLE COVER


34. INSTALL FRONT DOOR WEATHERSTRIP CLIP



(1) Insert the 2 front door weatherstrip clips and turn them 45 degrees as shown in the illustration to install them.

35. INSTALL FRONT DOOR TRIM BRACKET

36. INSTALL FRONT NO. 1 SPEAKER ASSEMBLY

	INFO
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37. INSTALL OUTER REAR VIEW MIRROR ASSEMBLY

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38. INSTALL NO. 3 FRONT DOOR SERVICE HOLE COVER

39. INSTALL FRONT DOOR PANEL PROTECTOR

40. INSTALL FRONT DOOR INNER GLASS WEATHERSTRIP

41. INSTALL DOOR FRAME GARNISH

42. INSTALL FRONT DOOR LOWER FRAME BRACKET GARNISH

43. INSTALL FRONT DOOR INSIDE HANDLE SUB-ASSEMBLY

44. INSTALL FRONT DOOR TRIM BOARD SUB-ASSEMBLY

45. INSTALL MULTIPLEX NETWORK MASTER SWITCH ASSEMBLY WITH FRONT DOOR UPPER ARMREST BASE PANEL (for Driver Side)**46. INSTALL POWER WINDOW REGULATOR SWITCH ASSEMBLY WITH FRONT DOOR UPPER ARMREST BASE PANEL (for Front Passenger Side)****47. INSTALL FRONT DOOR TRIM UPPER COVER****48. CONNECT CABLE TO NEGATIVE AUXILIARY BATTERY TERMINAL**


for M20A-FXS:

Click here [INFO](#)

for 2ZR-FXE:

Click here [INFO](#)

49. INSTALL BATTERY SERVICE HOLE COVER ASSEMBLY (for M20A-FXS)

	Click here INFO
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50. INITIALIZATION AFTER RECONNECTING AUXILIARY BATTERY TERMINAL**HINT:**

When disconnecting and reconnecting the battery, there is an automatic learning function that completes learning when the respective system is used.

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51. INITIALIZE POWER WINDOW CONTROL SYSTEM

Click here [INFO](#)

52. INSPECT POWER WINDOW OPERATION

Click here [INFO](#)

53. INSPECT SRS WARNING LIGHT

Click here [INFO](#)

54. PERFORM CALIBRATION

(a) w/ Parking Support Brake System:

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55. CHECK DOOR LOCK OPERATION

Click here [INFO](#)

