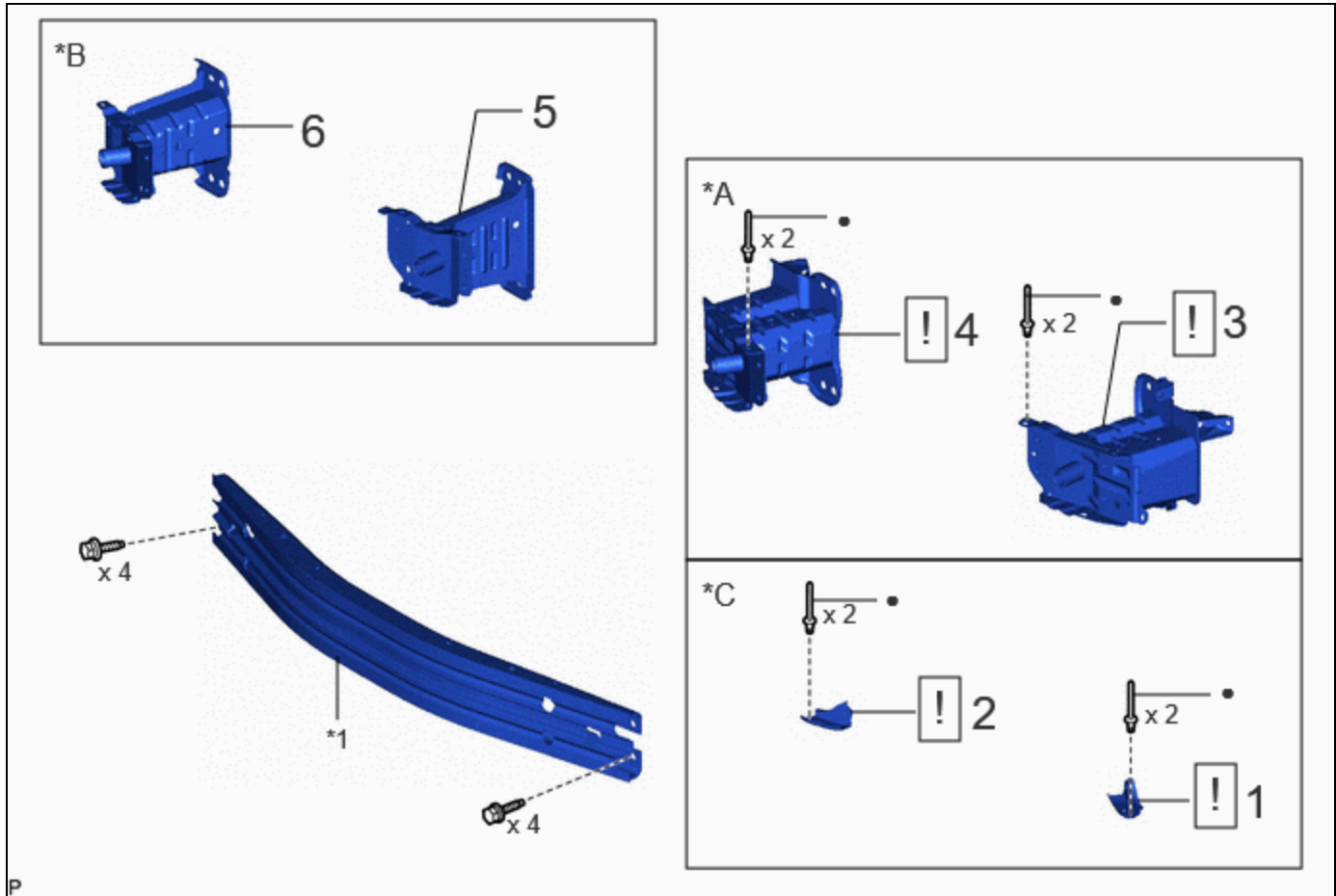


<b>Last Modified:</b> 12-04-2024	6.11:8.1.0	<b>Doc ID:</b> RM1000000029LCS
<b>Model Year Start:</b> 2023	<b>Model:</b> Prius Prime	<b>Prod Date Range:</b> [12/2022 - ]
<b>Title:</b> EXTERIOR PANELS / TRIM: FRONT BUMPER: REASSEMBLY; 2023 - 2024 MY Prius Prius Prime [12/2022 - ]		

## REASSEMBLY

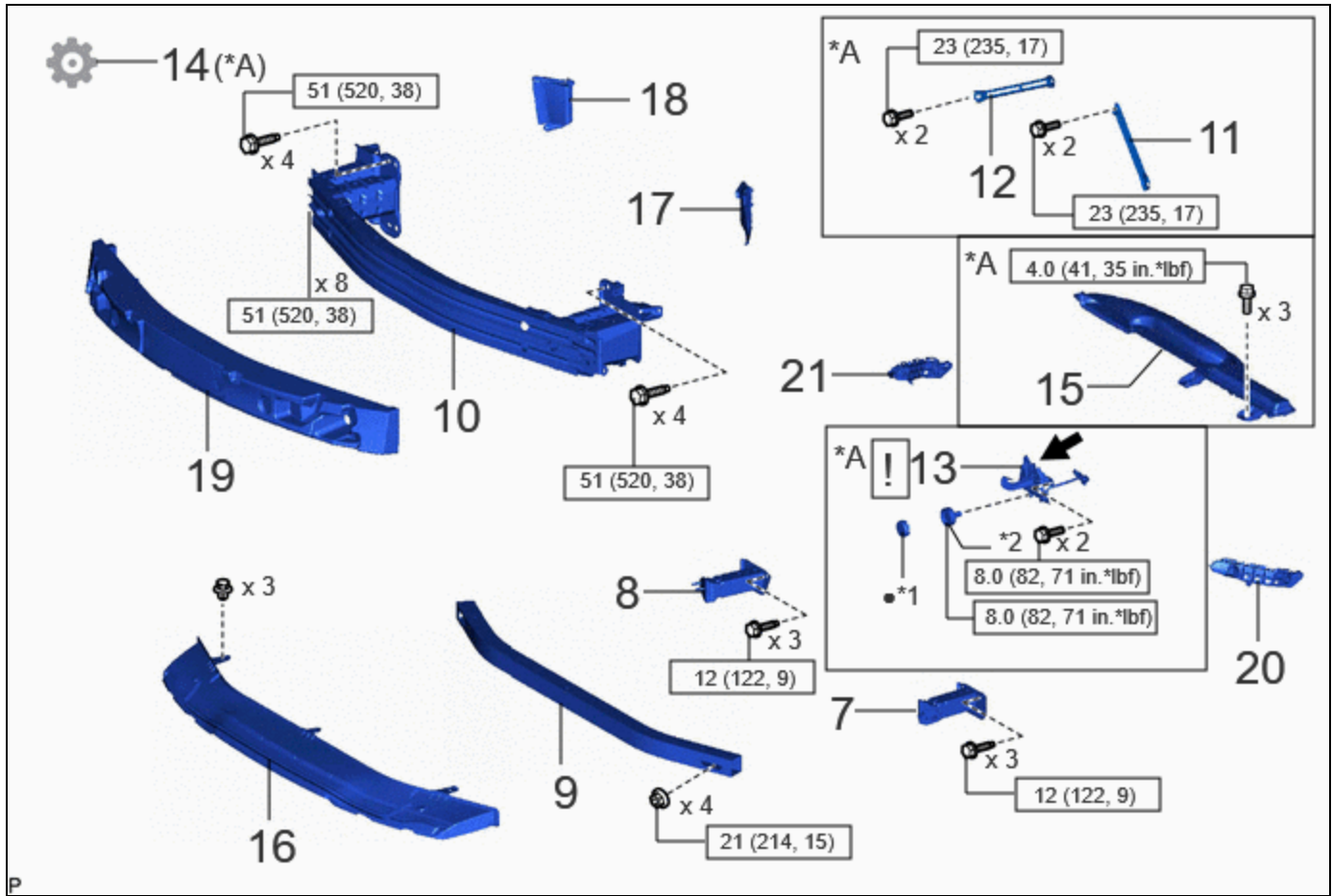
### CAUTION / NOTICE / HINT

#### COMPONENTS (REASSEMBLY)








PROCEDURE		PART NAME CODE			
1	NO. 2 FRONT BUMPER SPACER	52422C	<a href="#">INFO</a>	-	-
2	NO. 1 FRONT BUMPER SPACER	52421B	<a href="#">INFO</a>	-	-
3	FRONT SIDE MEMBER BRACKET SUB-ASSEMBLY LH	57014A	<a href="#">INFO</a>	-	-
4	FRONT SIDE MEMBER BRACKET SUB-ASSEMBLY RH	57013C	<a href="#">INFO</a>	-	-
5	FRONT SIDE MEMBER BRACKET SUB-ASSEMBLY LH	57014A	-	-	-
6	FRONT SIDE MEMBER BRACKET SUB-ASSEMBLY RH	57013C	-	-	-

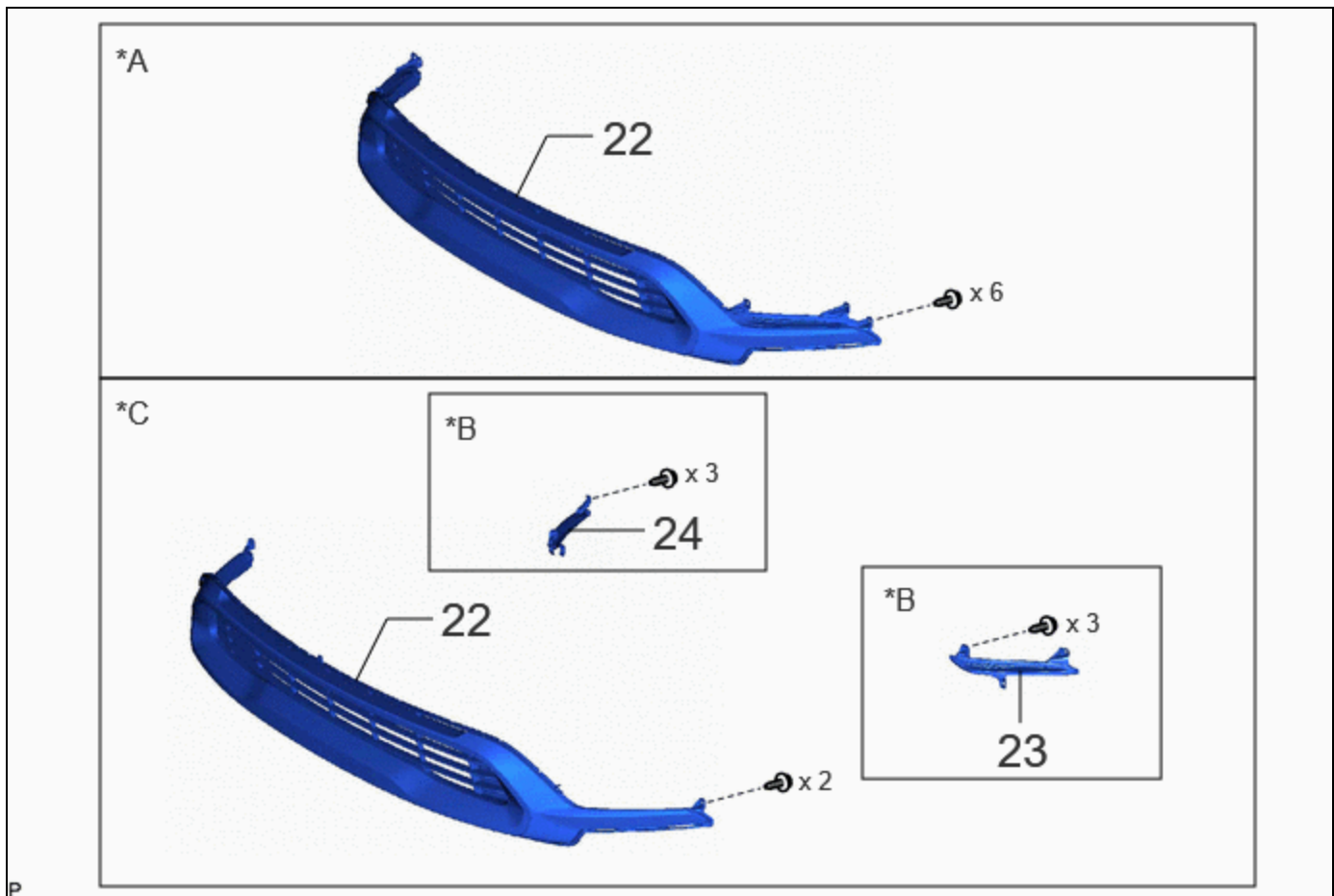
*A	for Type A	*B	for Type B
*C	w/ Bracket	-	-
*1	FRONT BUMPER REINFORCEMENT SUB-ASSEMBLY	-	-
•	Non-reusable part	-	-






PROCEDURE		PART NAME CODE	!	📄	⚙️
7	FRONT BUMPER EXTENSION SUB-ASSEMBLY LH	52103A	-	-	-
8	FRONT BUMPER EXTENSION SUB-ASSEMBLY RH	52102B	-	-	-
9	NO. 2 FRONT BUMPER REINFORCEMENT	52132A	-	-	-
10	FRONT BUMPER REINFORCEMENT	-	-	-	-
11	UPPER RADIATOR MOUNTING BRACKET LH	53254A	-	-	-
12	UPPER RADIATOR MOUNTING BRACKET RH	53253D	-	-	-
13	HOOD LOCK ASSEMBLY	53510	INFO	-	-
14	ADJUST HOOD SUB-ASSEMBLY	53301	-	-	INFO
15	INLET NO. 1 AIR CLEANER	17751	-	-	-
16	FRONT BUMPER LOWER ABSORBER	52618	-	-	-

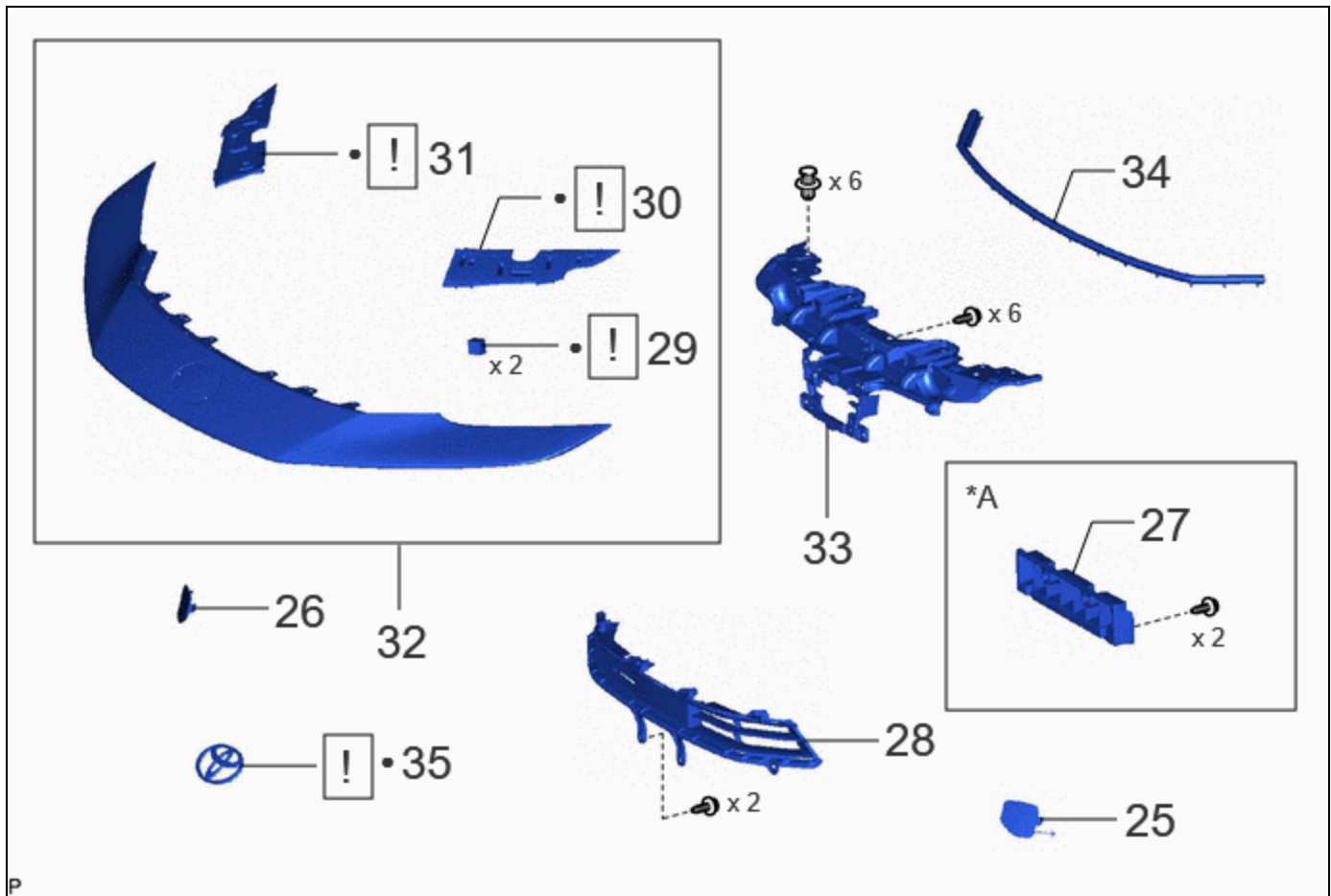
PROCEDURE		PART NAME CODE			
17	FRONT RADIATOR SIDE AIR GUIDE PLATE LH	16695A	-	-	-
18	FRONT RADIATOR SIDE AIR GUIDE PLATE RH	16691A	-	-	-
19	FRONT BUMPER ENERGY ABSORBER	52611	-	-	-
20	FRONT BUMPER SIDE SUPPORT LH	52116A	-	-	-
21	FRONT BUMPER SIDE SUPPORT RH	52115A	-	-	-




*A	w/ Bracket	-	-
*1	HOOD LOCK NUT CAP	*2	HOOD LOCK BOLT
•	Non-reusable part	-	-
	N*m (kgf*cm, ft.*lbf): Specified torque		MP grease






PROCEDURE	PART NAME CODE			
22 NO. 1 LOWER RADIATOR GRILLE	53112E	-	-	-
23 FOG LIGHT COVER LH	81482C	-	-	-
24 FOG LIGHT COVER RH	81481E	-	-	-

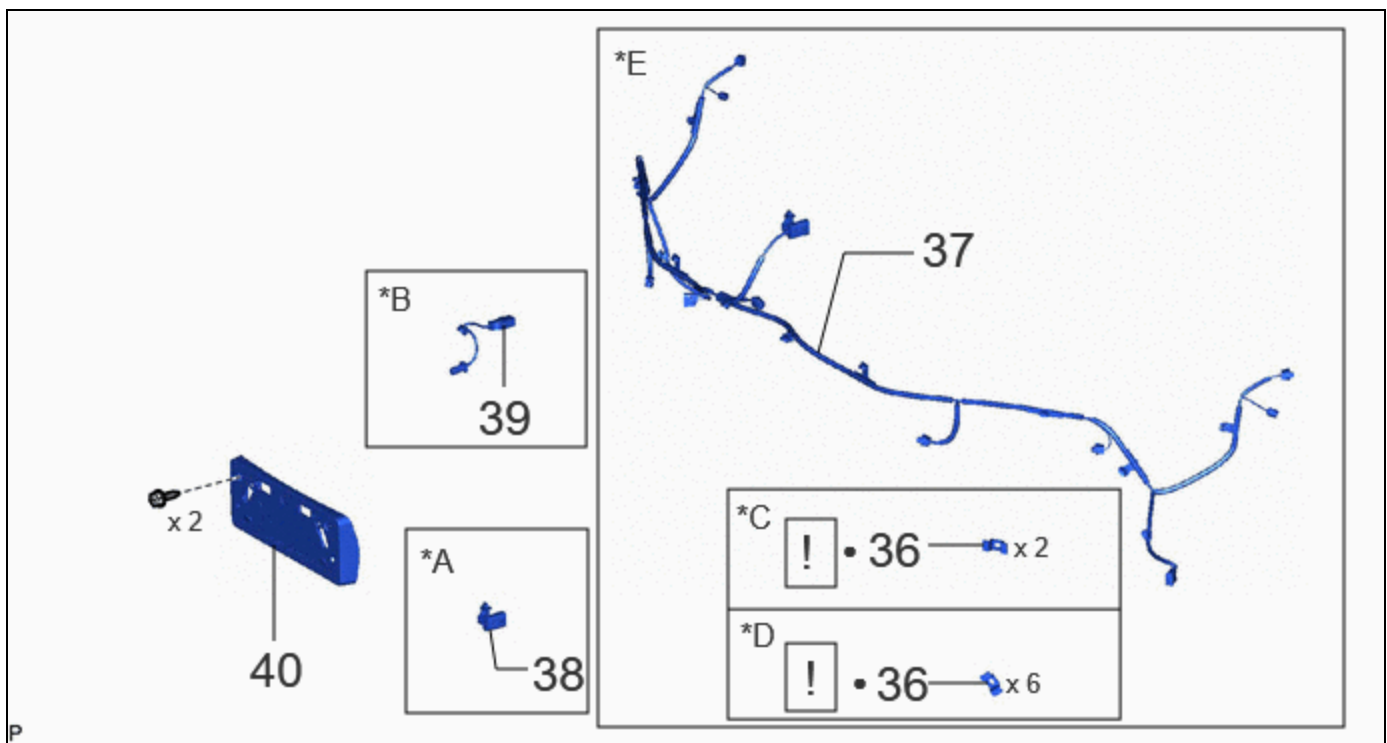
*A	for Integrated Type	*B	w/o LED Illumination Light
*C	for Separate Type	-	-






PROCEDURE	PART NAME CODE			
25 FRONT BUMPER HOLE COVER LH	52128C	-	-	-
26 FRONT BUMPER HOLE COVER RH	52127D	-	-	-
27 FRONT BUMPER MOUNTING BRACKET	52147B	-	-	-
28 RADIATOR GRILLE GARNISH	53141H	-	-	-
29 FRONT BUMPER PAD	52421A	<a href="#">INFO</a>	-	-
30 FRONT BUMPER END RETAINER LH	52538	<a href="#">INFO</a>	-	-

PROCEDURE		PART NAME CODE			
31	FRONT BUMPER END RETAINER RH	52537	INFO	-	-
32	FRONT BUMPER BAR	52111E	-	-	-
33	RADIATOR INNER GRILLE	53114A	-	-	-
34	HOOD TO FRONT END PANEL SEAL	53395E	-	-	-
35	RADIATOR GRILLE (OR FRONT PANEL) EMBLEM	75311	INFO	-	-

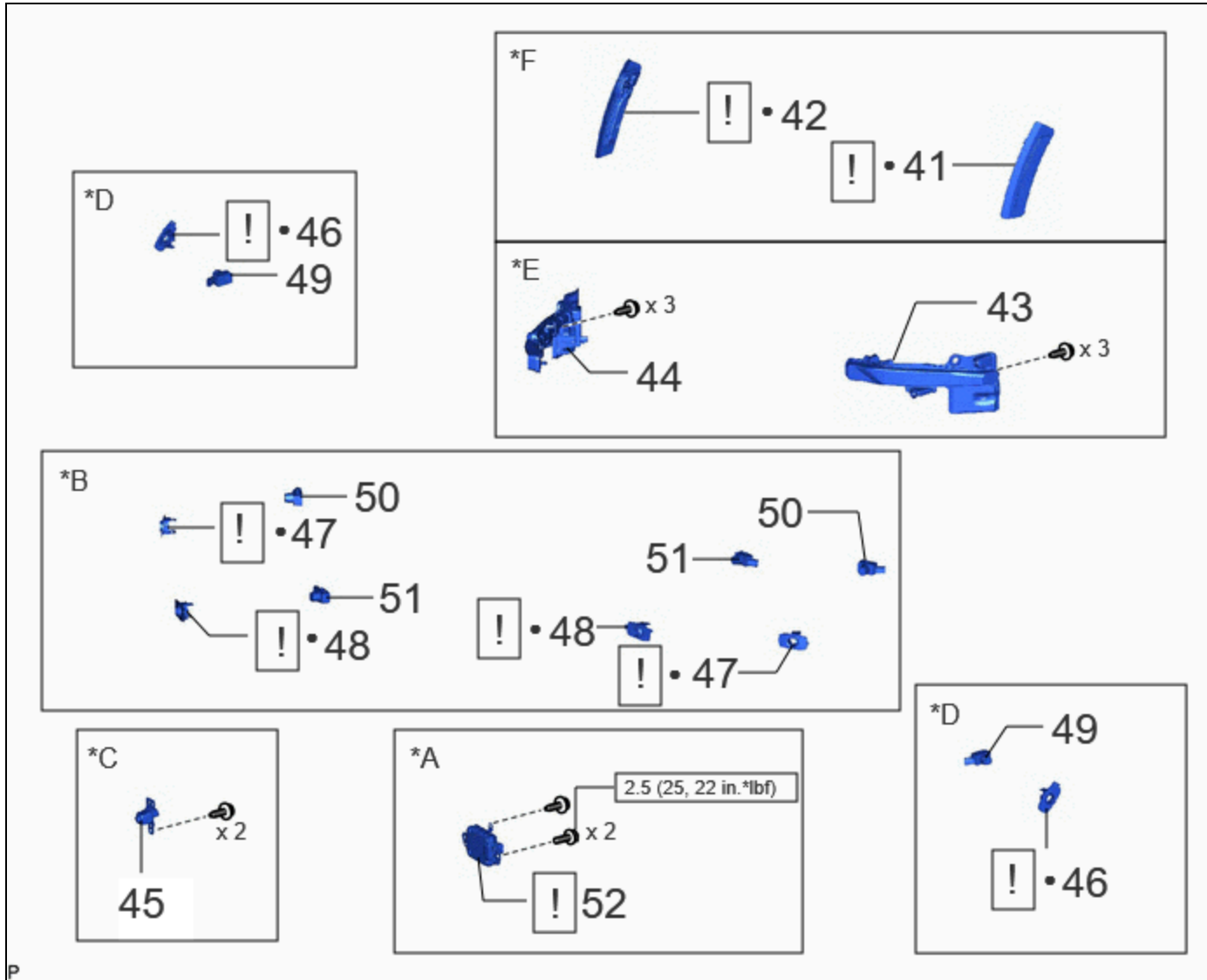
*A	w/ Front bumper mounting bracket	-	-
•	Non-reusable part	-	-







PROCEDURE		PART NAME CODE			
36	FRONT ULTRASONIC SENSOR CLIP	89348X	INFO	-	-
37	NO. 3 ENGINE ROOM WIRE	82113	-	-	-
38	CONNECTOR COVER	82821A	-	-	-
39	PARKING ASSIST WIRE	86797B	-	-	-
40	FRONT BUMPER EXTENSION MOUNTING BRACKET	52114A	-	-	-


*A	w/ Connector Cover	*B	w/ Panoramic View Monitor System
*C	w/o Side Marker Light	*D	w/ Side Marker Light

*E	w/ Wire Harness	-	-
•	Non-reusable part	-	-



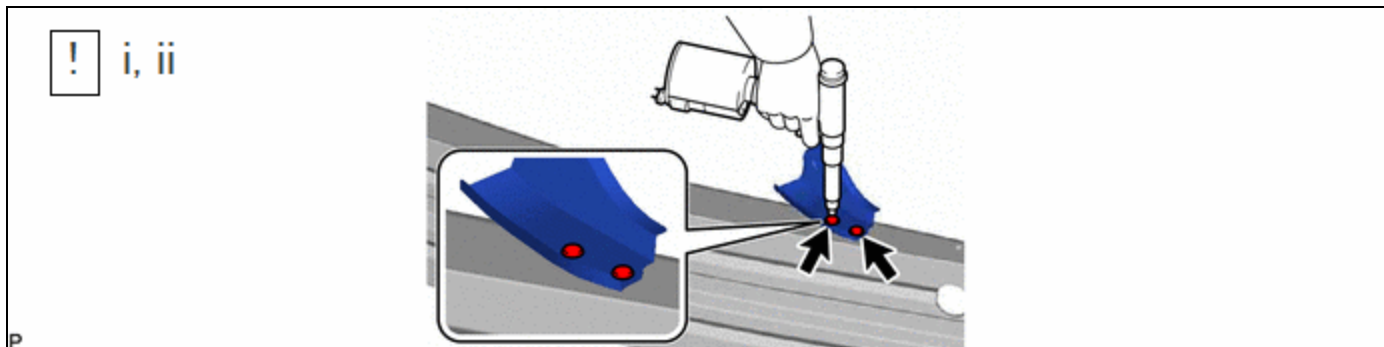
PROCEDURE		PART NAME CODE			
41	FRONT MARKER LIGHT ASSEMBLY LH	81720	<a href="#">INFO</a>	-	-
42	FRONT MARKER LIGHT ASSEMBLY RH	81710	<a href="#">INFO</a>	-	-
43	LED ILLUMINATION LIGHT LH	8122A	-	-	-
44	LED ILLUMINATION LIGHT RH	8121A	-	-	-
45	FRONT TELEVISION CAMERA ASSEMBLY	86790B	-	-	-
46	FRONT SIDE ULTRASONIC SENSOR RETAINER	89C48F	<a href="#">INFO</a>	-	-
47	FRONT CORNER ULTRASONIC SENSOR RETAINER	89C48D	<a href="#">INFO</a>	-	-
48	FRONT CENTER ULTRASONIC SENSOR RETAINER	89C48E	<a href="#">INFO</a>	-	-

PROCEDURE		PART NAME CODE			
49	FRONT SIDE ULTRASONIC SENSOR	89341M	-	-	-
50	FRONT CORNER ULTRASONIC SENSOR	89341K	-	-	-
51	FRONT CENTER ULTRASONIC SENSOR	89341L	-	-	-
52	MILLIMETER WAVE RADAR SENSOR ASSEMBLY	88211B		-	-

*A	w/ Pre-collision System	*B	w/ Parking Support Brake System
*C	w/ Panoramic View Monitor System	*D	w/ Advanced Park
*E	w/ LED Illumination Light	*F	w/ Side Marker Light
	N*m (kgf*cm, ft.*lbf): Specified torque	•	Non-reusable part

## PROCEDURE

### 1. INSTALL NO. 2 FRONT BUMPER SPACER (w/ Bracket)



- (1) Install a No. 3 nose piece to an air riveter and insert the mandrel section of a new 6.4 mm diameter rivet into the nose piece.
- (2) Press the rivets perpendicularly to the installation holes. Using the air riveter, install the No. 2 front bumper spacer with the 2 rivets.

#### NOTICE:

- When installing the rivets to the panel surface, do not tilt the riveter.
- Do not leave a gap between the rivet head portion and the panel.

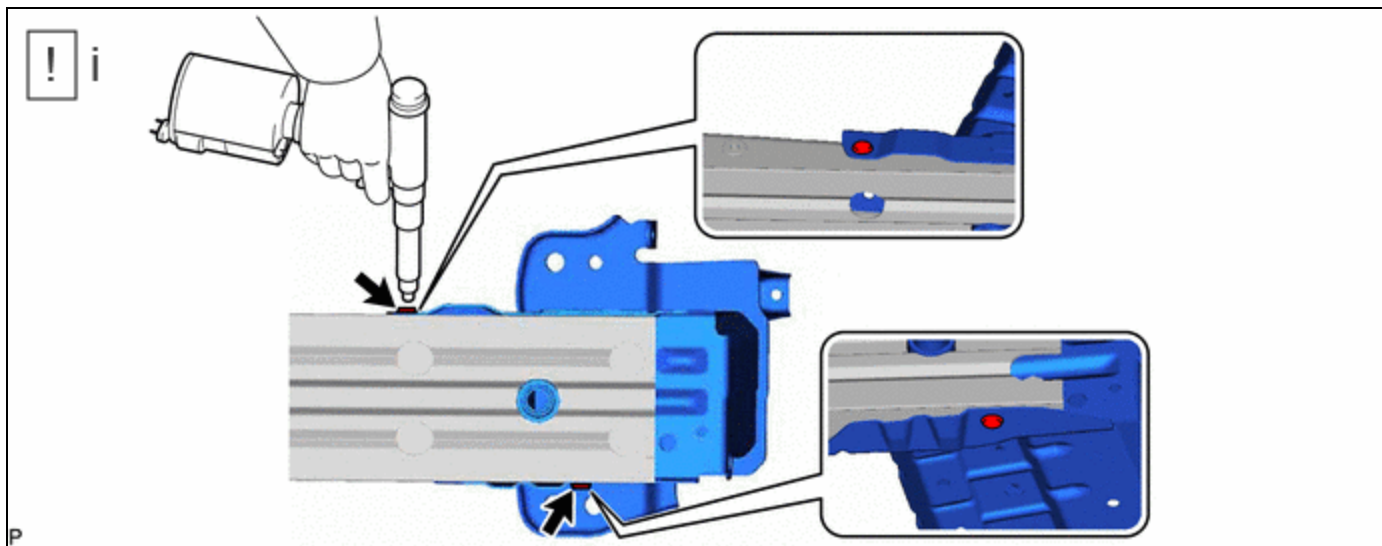
#### HINT:

Pull the trigger again to cut off the rivet if it is not cut off.

### 2. INSTALL NO. 1 FRONT BUMPER SPACER (w/ Bracket)

- (a) Use the same procedure as for the LH side.

### 3. INSTALL FRONT SIDE MEMBER BRACKET SUB-ASSEMBLY LH (for Type A)



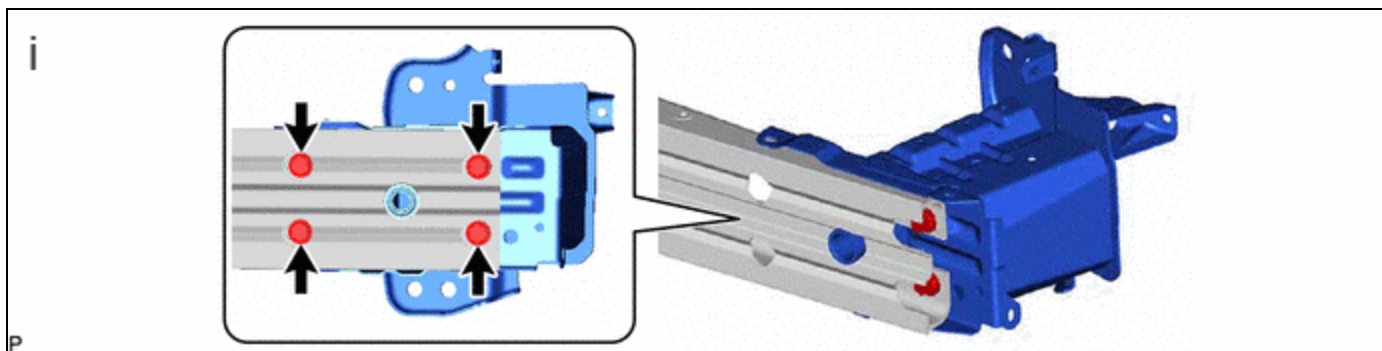
- (1) Install a No. 3 nose piece to an air riveter and insert the mandrel section of a new 6.4 mm diameter rivet into the nose piece.
- (2) Press the rivets perpendicularly to the installation holes. Using the air riveter, install the front side member bracket sub-assembly LH with the 2 rivets.

**NOTICE:**

- When installing the rivets to the panel surface, do not tilt the riveter.
- Do not leave a gap between the rivet head portion and the panel.

**HINT:**

Pull the trigger again to cut off the rivet if it is not cut off.



- (1) Temporarily install the front side member bracket sub-assembly LH with the 4 bolts.

**4. INSTALL FRONT SIDE MEMBER BRACKET SUB-ASSEMBLY RH (for Type A)**

- (a) Use the same procedure as for the LH side.

**5. INSTALL FRONT SIDE MEMBER BRACKET SUB-ASSEMBLY LH (for Type B)**

**Torque:**

**51 N·m {520 kgf·cm, 38 ft·lbf}**

**6. INSTALL FRONT SIDE MEMBER BRACKET SUB-ASSEMBLY RH (for Type B)**

- (a) Use the same procedure as for the LH side.

**7. INSTALL FRONT BUMPER EXTENSION SUB-ASSEMBLY LH**

**Torque:**

**12 N·m {122 kgf·cm, 9 ft·lbf}**



**8. INSTALL FRONT BUMPER EXTENSION SUB-ASSEMBLY RH**

(a) Use the same procedure as for the LH side.

**9. INSTALL NO. 2 FRONT BUMPER REINFORCEMENT**

**Torque:**

**21 N·m {214 kgf·cm, 15 ft·lbf}**

**10. INSTALL FRONT BUMPER REINFORCEMENT**

**Torque:**

**51 N·m {520 kgf·cm, 38 ft·lbf}**

**11. INSTALL UPPER RADIATOR MOUNTING BRACKET LH (w/ Bracket)**


**Torque:**

**23 N·m {235 kgf·cm, 17 ft·lbf}**

**12. INSTALL UPPER RADIATOR MOUNTING BRACKET RH (w/ Bracket)**

(a) Use the same procedure as for the LH side.

**13. INSTALL HOOD LOCK ASSEMBLY (w/ Bracket)**

	Click here <a href="#">INFO</a>
---	---------------------------------

**14. ADJUST HOOD SUB-ASSEMBLY (w/ Bracket)**

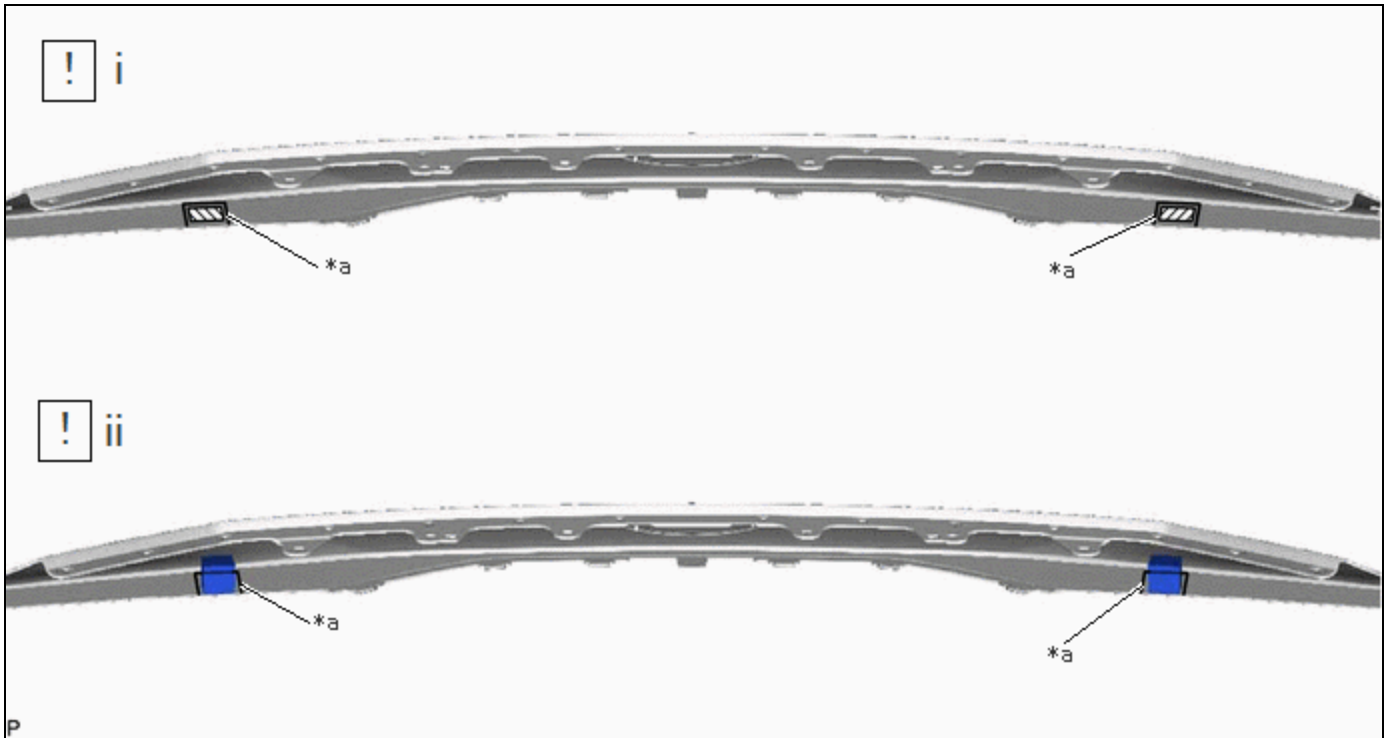
Click here [INFO](#)


**15. INSTALL INLET NO. 1 AIR CLEANER (w/ Bracket)**

Click here [INFO](#)

**16. INSTALL FRONT BUMPER LOWER ABSORBER****17. INSTALL FRONT RADIATOR SIDE AIR GUIDE PLATE LH****18. INSTALL FRONT RADIATOR SIDE AIR GUIDE PLATE RH****19. INSTALL FRONT BUMPER ENERGY ABSORBER****20. INSTALL FRONT BUMPER SIDE SUPPORT LH****21. INSTALL FRONT BUMPER SIDE SUPPORT RH****22. INSTALL NO. 1 LOWER RADIATOR GRILLE****23. INSTALL FOG LIGHT COVER LH (for Separate Type)****24. INSTALL FOG LIGHT COVER RH (for Separate Type)****25. INSTALL FRONT BUMPER HOLE COVER LH****26. INSTALL FRONT BUMPER HOLE COVER RH****27. TEST FRONT BUMPER MOUNTING BRACKET (w/ Front bumper mounting bracket)****28. INSTALL RADIATOR GRILLE GARNISH**

**29. INSTALL FRONT BUMPER PAD**



*a	Scribed Line	-	-
	Cleaning Area	-	-

(1) Clean the front bumper bar surface.

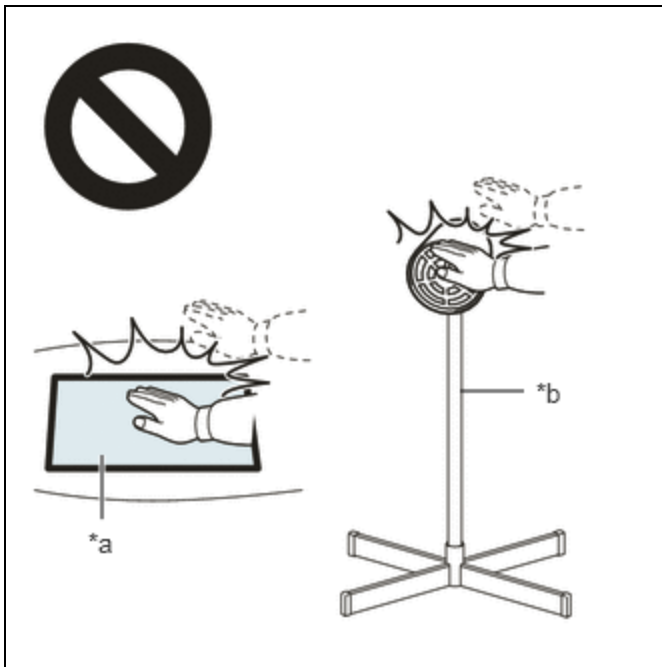
- Using a heat light, heat the double-sided tape remaining on the front bumper bar and 2 front bumper pads.

**Heating Temperature**

AREA	TEMPERATURE	AREA	TEMPERATURE
Front Bumper Bar	20 to 30 °C (68 to 86 °F)	Front Bumper Pad	20 to 30 °C (68 to 86 °F)

**CAUTION:**

- Do not touch the heat light and heated parts, touching the heat light may result in burns.
- Touching heated parts for a long time may result in burns.



*a	Heated Part
*b	Heat Light

**NOTICE:**

Do not heat the front bumper bar excessively.

2. Remove any remaining double-sided tape from the front bumper bar.
  3. Wipe off any tape adhesive residue with cleaner.
- (2) Install 2 new front bumper pads.
1. Using a heat light, heat the front bumper bar surface.
  2. Remove the release paper from the 2 front bumper pads.

**HINT:**

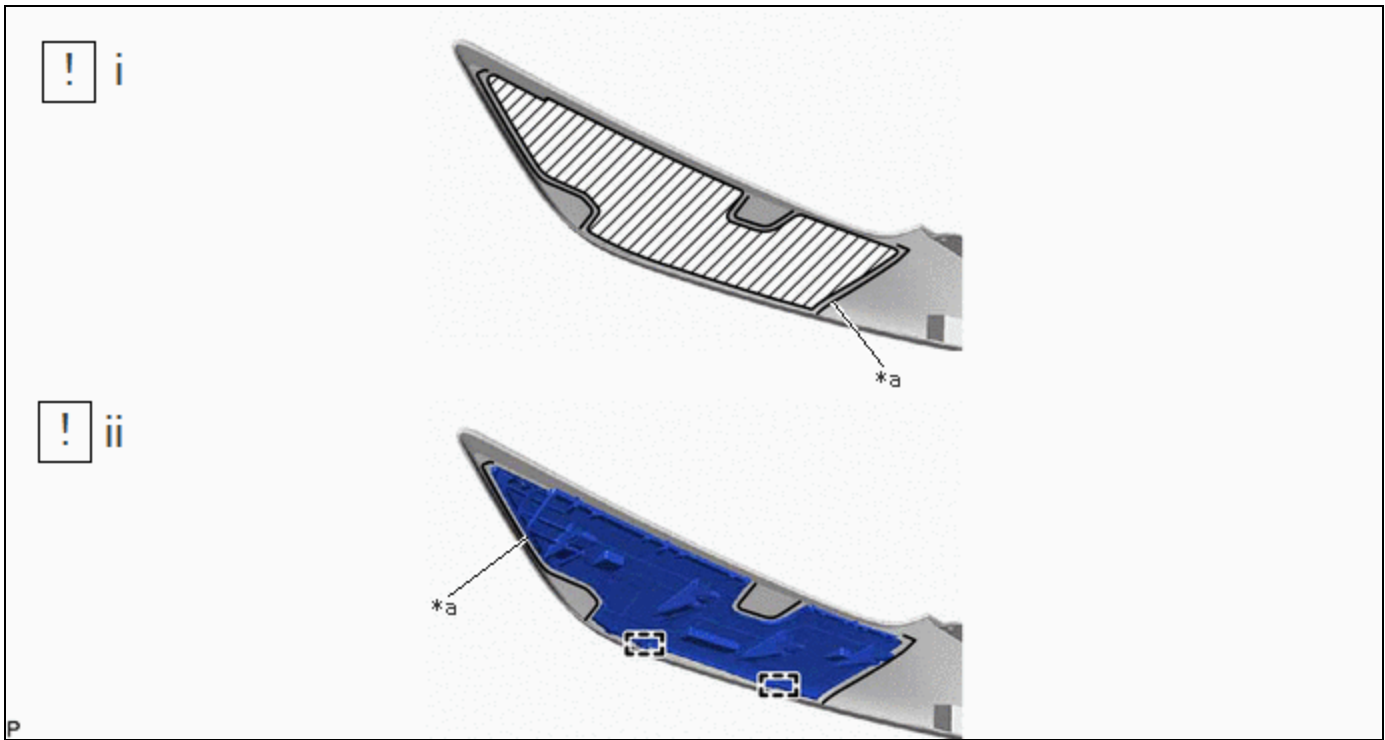
After removing the release paper, keep the exposed adhesive free from foreign matter.


3. Install the 2 front bumper pads as shown in the illustration.

**HINT:**

- Apply the front bumper pad along the scribed line on the front bumper bar.
- Press the front bumper pad firmly to install it.

**30. INSTALL FRONT BUMPER END RETAINER LH**



*a	Scribed Line	-	-
	Cleaning Area	-	-

(1) Clean the front bumper bar surface.

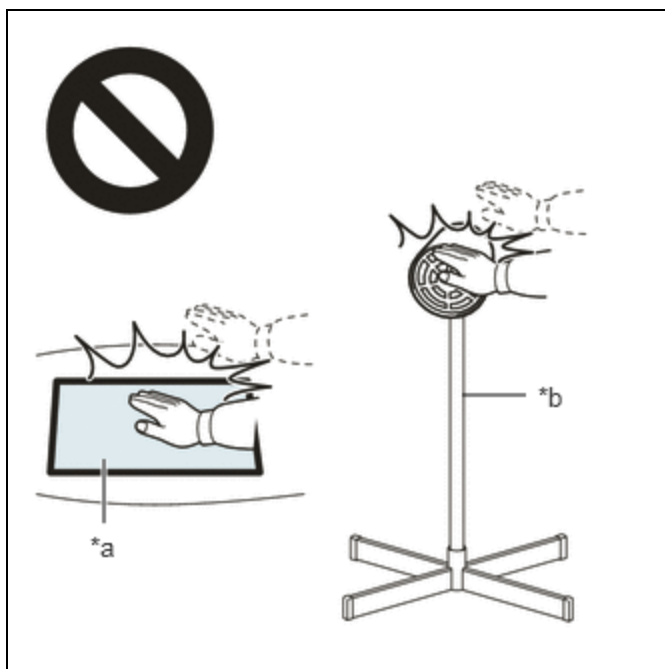
- Using a heat light, heat the double-sided tape remaining on the front bumper bar and front bumper end retainer LH.

**Heating Temperature**

AREA	TEMPERATURE	AREA	TEMPERATURE
Front Bumper Bar	20 to 30 °C (68 to 86 °F)	Front Bumper End Retainer LH	20 to 30 °C (68 to 86 °F)

**CAUTION:**

- Do not touch the heat light and heated parts, touching the heat light may result in burns.
- Touching heated parts for a long time may result in burns.



*a	Heated Part
*b	Heat Light

**NOTICE:**

Do not heat the front bumper bar excessively.

2. Remove any remaining double-sided tape from the front bumper bar.
  3. Wipe off any tape adhesive residue with cleaner.
- (2) Install new front bumper end retainer LH.
1. Using a heat light, heat the front bumper bar surface.
  2. Remove the release paper from the front bumper end retainer LH.

**HINT:**

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

3. Engage the 2 guides to install the front bumper end retainer LH as shown in the illustration.

**HINT:**

- Apply the front bumper end retainer LH along the scribed line on the front bumper bar.
- Press the front bumper end retainer LH firmly to install it.

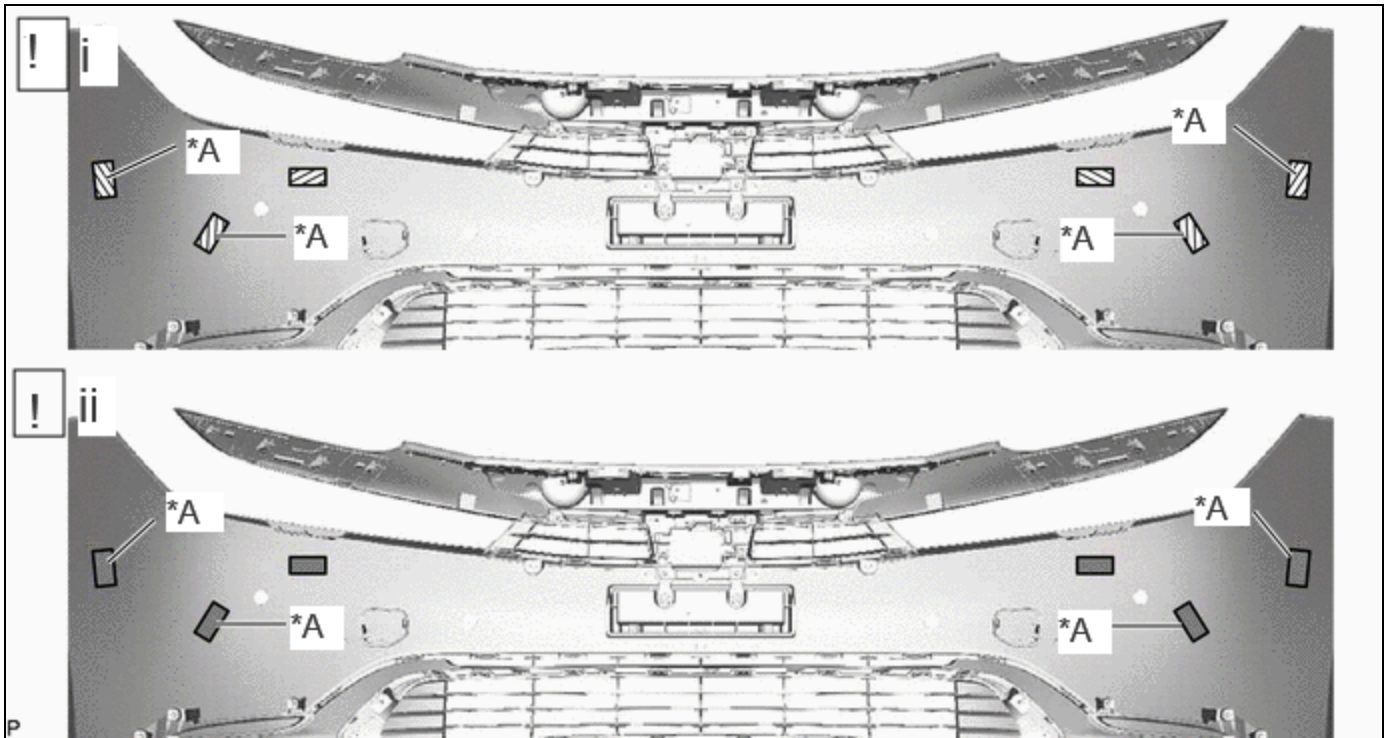
**31. INSTALL FRONT BUMPER END RETAINER RH**



- (a) Use the same procedure as for the LH side.

**32. INSTALL FRONT BUMPER BAR****33. INSTALL RADIATOR INNER GRILLE****34. INSTALL HOOD TO FRONT END PANEL SEAL****35. INSTALL RADIATOR GRILLE (OR FRONT PANEL) EMBLEM**

	Click here <a href="#" style="background-color: #0070C0; color: white; padding: 2px 5px; text-decoration: none;">INFO</a>
---	---

### 36. INSTALL FRONT ULTRASONIC SENSOR CLIP (w/ Wire Harness)



*A	w/ Side Marker Light	-	-
	Cleaning Area		Primer

(1) Clean the front bumper cover surface.

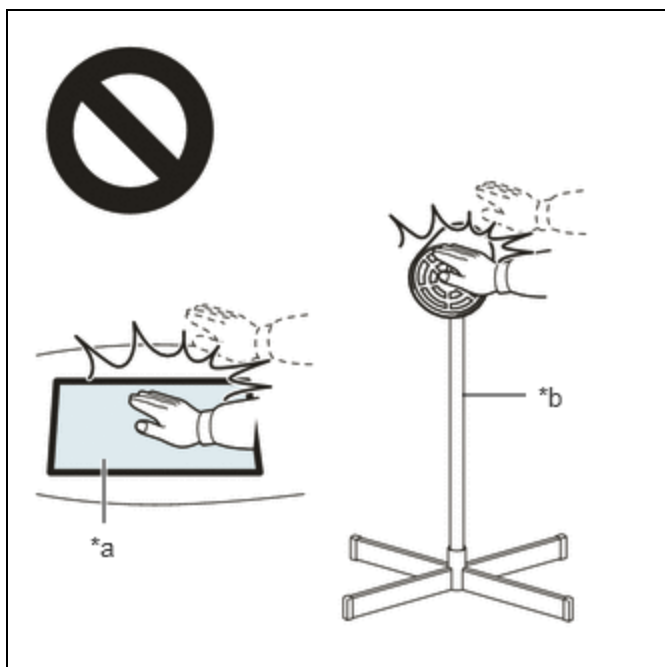
1. Using a heat light, heat the double-sided tape remaining on the front bumper cover and each front ultrasonic sensor clip.

#### Heating Temperature

AREA	TEMPERATURE	AREA	TEMPERATURE
Front Bumper Cover	20 to 30 °C (68 to 86 °F)	Front Ultrasonic Sensor Clip	20 to 30 °C (68 to 86 °F)

#### CAUTION:

- Do not touch the heat light and heated parts, touching the heat light may result in burns.
- Touching heated parts for a long time may result in burns.



*a	Heated Part
*b	Heat Light

**NOTICE:**

Do not heat the front bumper cover excessively.

2. Remove any remaining double-sided tape from the front bumper cover.
  3. Wipe off any tape adhesive residue with cleaner.
- (2) Apply primer to the installation area of each front ultrasonic sensor clip on the front bumper cover.
1. Using a brush or felt, apply primer or equivalent to the installation area of each front ultrasonic sensor clip.

**NOTICE:**

- Replace the brush or felt if it is dirty or has become hardened.
- Do not apply primer to the painted side.
- Do not touch the front bumper cover until the primer has dried.

2. Let the primer dry sufficiently.

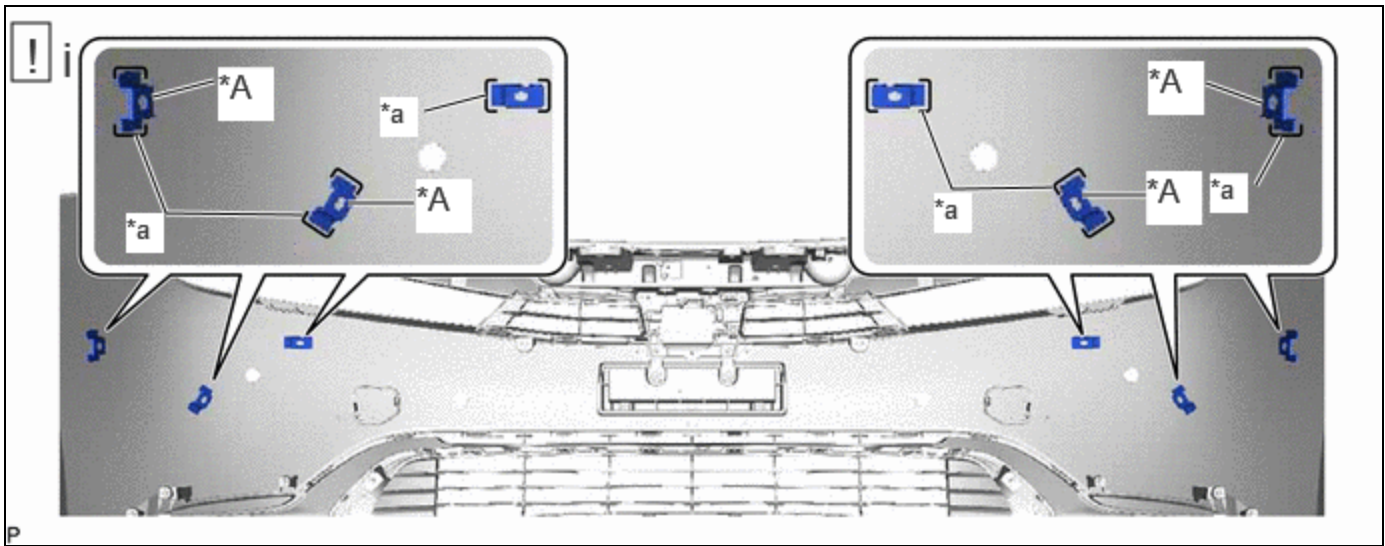
**NOTICE:**

Do not touch applied surfaces until the primer is dry.

Recommended drying time:

10 minutes or more (at 23°C (73°F))

3. Confirm that the primer has completely dried by touching the front bumper cover. Then remove the tape.



*A	w/ Side Marker Light	-	-
*a	Scribed Line	-	-

- (1) Install each new front ultrasonic sensor clip.
  1. Using a heat light, heat the front bumper cover surface.
  2. Remove the release paper from each front ultrasonic sensor clip.

**HINT:**

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

3. Install each front ultrasonic sensor clip as shown in the illustration.

**HINT:**

- Apply the front ultrasonic sensor clip along the scribed line on the front bumper cover.
- Press the front ultrasonic sensor clip firmly to install it.


**37. INSTALL NO. 3 ENGINE ROOM WIRE (w/ Wire Harness)**

**38. INSTALL CONNECTOR COVER (w/ Connector Cover)**

**39. INSTALL PARKING ASSIST WIRE (w/ Panoramic View Monitor System)**

**40. INSTALL FRONT BUMPER EXTENSION MOUNTING BRACKET**

**41. INSTALL FRONT MARKER LIGHT ASSEMBLY LH (w/ Side Marker Light)**

	Click here <a href="#" style="background-color: #0056b3; color: white; padding: 2px 5px; text-decoration: none;">INFO</a>
---	---

**42. INSTALL FRONT MARKER LIGHT ASSEMBLY RH (w/ Side Marker Light)**

- (a) Use the same procedure as for the LH side.

**43. INSTALL LED ILLUMINATION LIGHT LH (w/ LED Illumination Light)**


**44. INSTALL LED ILLUMINATION LIGHT RH (w/ LED Illumination Light)**

**45. INSTALL FRONT TELEVISION CAMERA ASSEMBLY (w/ Panoramic View Monitor System)**


Click here [INFO](#)



**46. INSTALL FRONT SIDE ULTRASONIC SENSOR RETAINER (w/ Advanced Park)**

	Click here <a href="#">INFO</a>
---	---------------------------------

**47. INSTALL FRONT CORNER ULTRASONIC SENSOR RETAINER (w/ Parking Support Brake System)**

	Click here <a href="#">INFO</a>
---	---------------------------------

**48. INSTALL FRONT CENTER ULTRASONIC SENSOR RETAINER (w/ Parking Support Brake System)**


	Click here <a href="#">INFO</a>
---	---------------------------------

**49. INSTALL FRONT SIDE ULTRASONIC SENSOR (w/ Advanced Park)**

**50. INSTALL FRONT CORNER ULTRASONIC SENSOR (w/ Parking Support Brake System)**

**51. INSTALL FRONT CENTER ULTRASONIC SENSOR (w/ Parking Support Brake System)**

**52. INSTALL MILLIMETER WAVE RADAR SENSOR ASSEMBLY (w/ Pre-collision System)**

	Click here <a href="#">INFO</a>
---	---------------------------------

