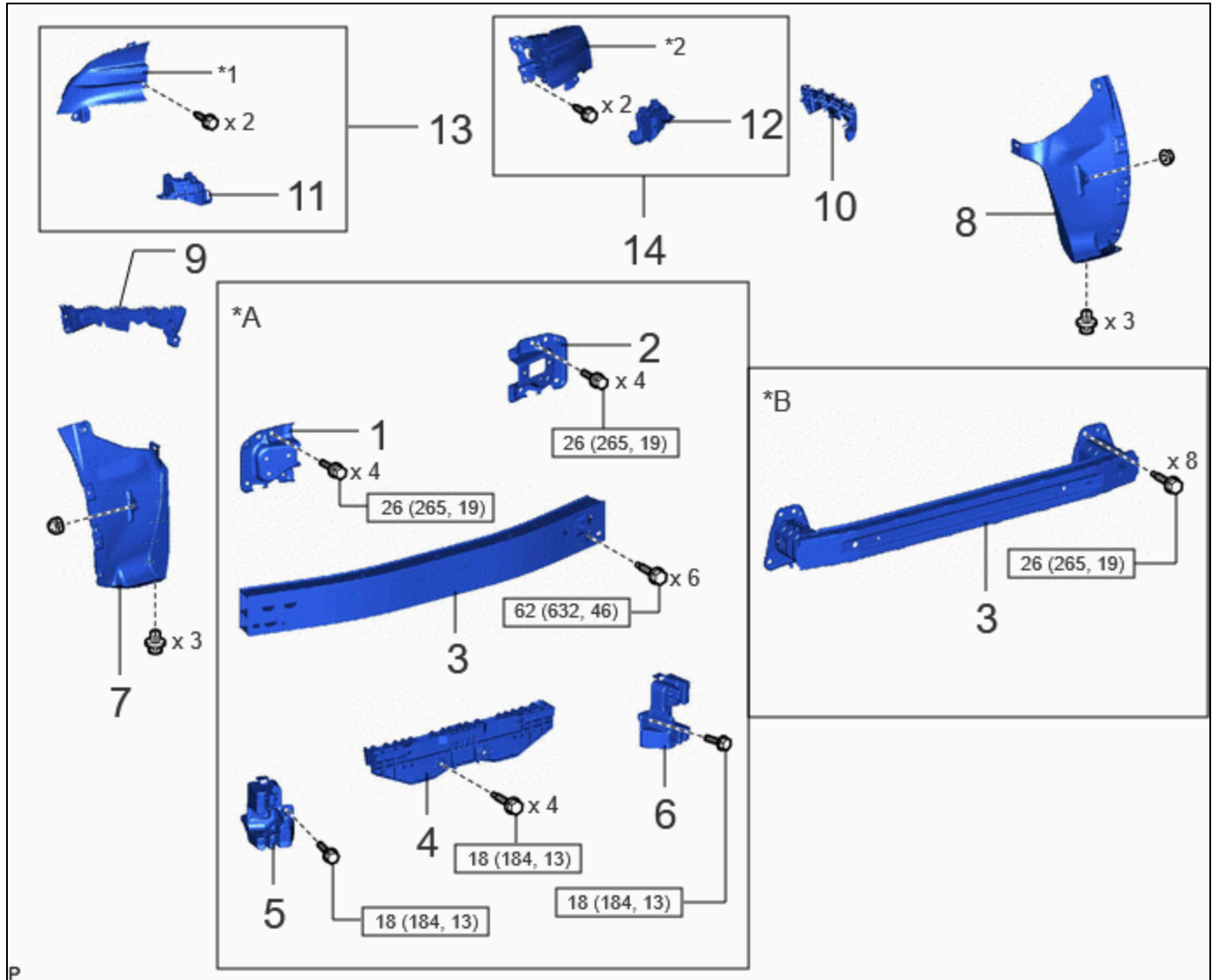


<b>Last Modified:</b> 12-04-2024	6.11:8.1.0	<b>Doc ID:</b> RM1000000029LCU
<b>Model Year Start:</b> 2023	<b>Model:</b> Prius Prime	<b>Prod Date Range:</b> [12/2022 - ]
<b>Title:</b> EXTERIOR PANELS / TRIM: REAR BUMPER: REASSEMBLY; 2023 - 2024 MY Prius Prius Prime [12/2022 - ]		




## REASSEMBLY


### CAUTION / NOTICE / HINT

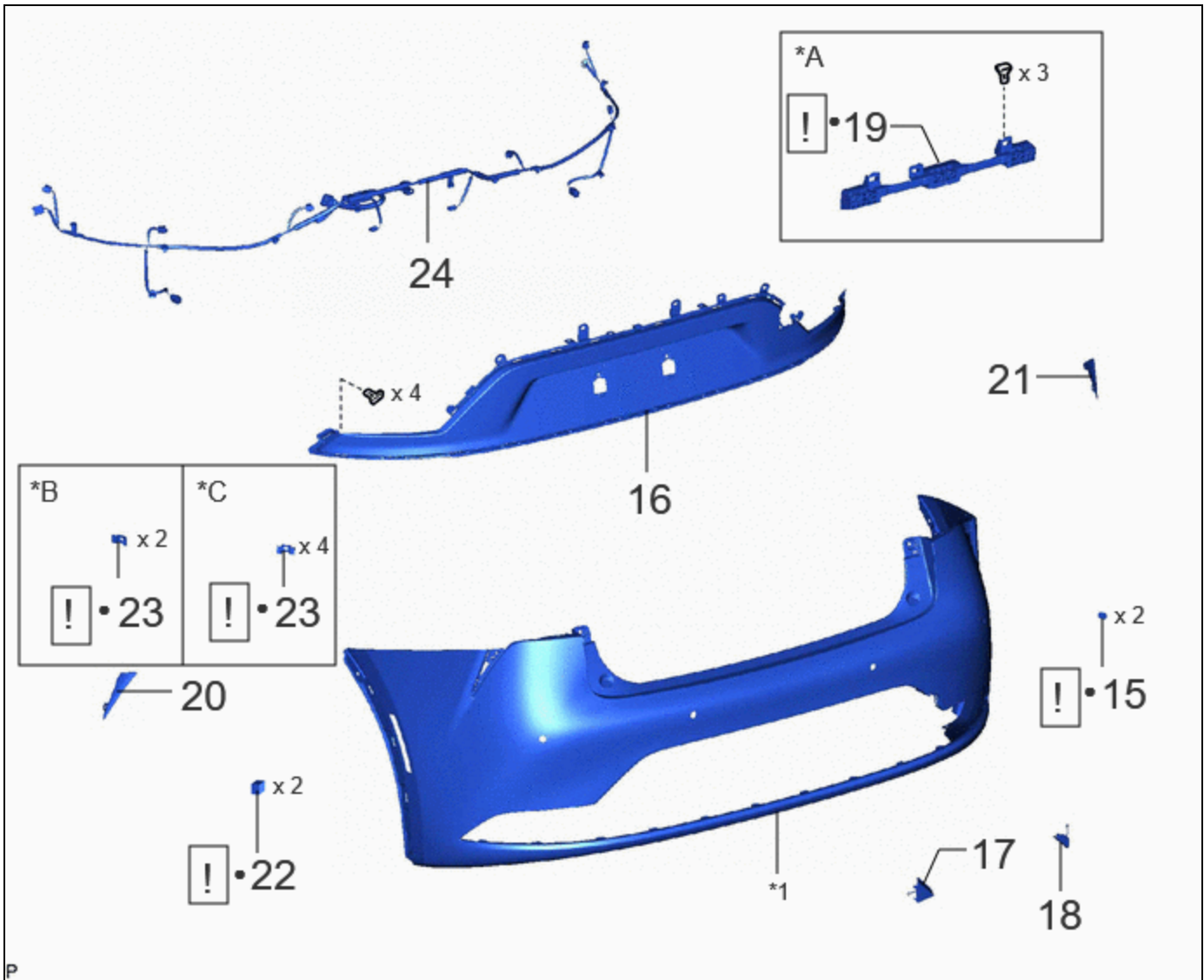
#### COMPONENTS (REASSEMBLY)



PROCEDURE		PART NAME CODE			
1	REAR BUMPER ARM LH	52182	-	-	-
2	REAR BUMPER ARM RH	52181	-	-	-

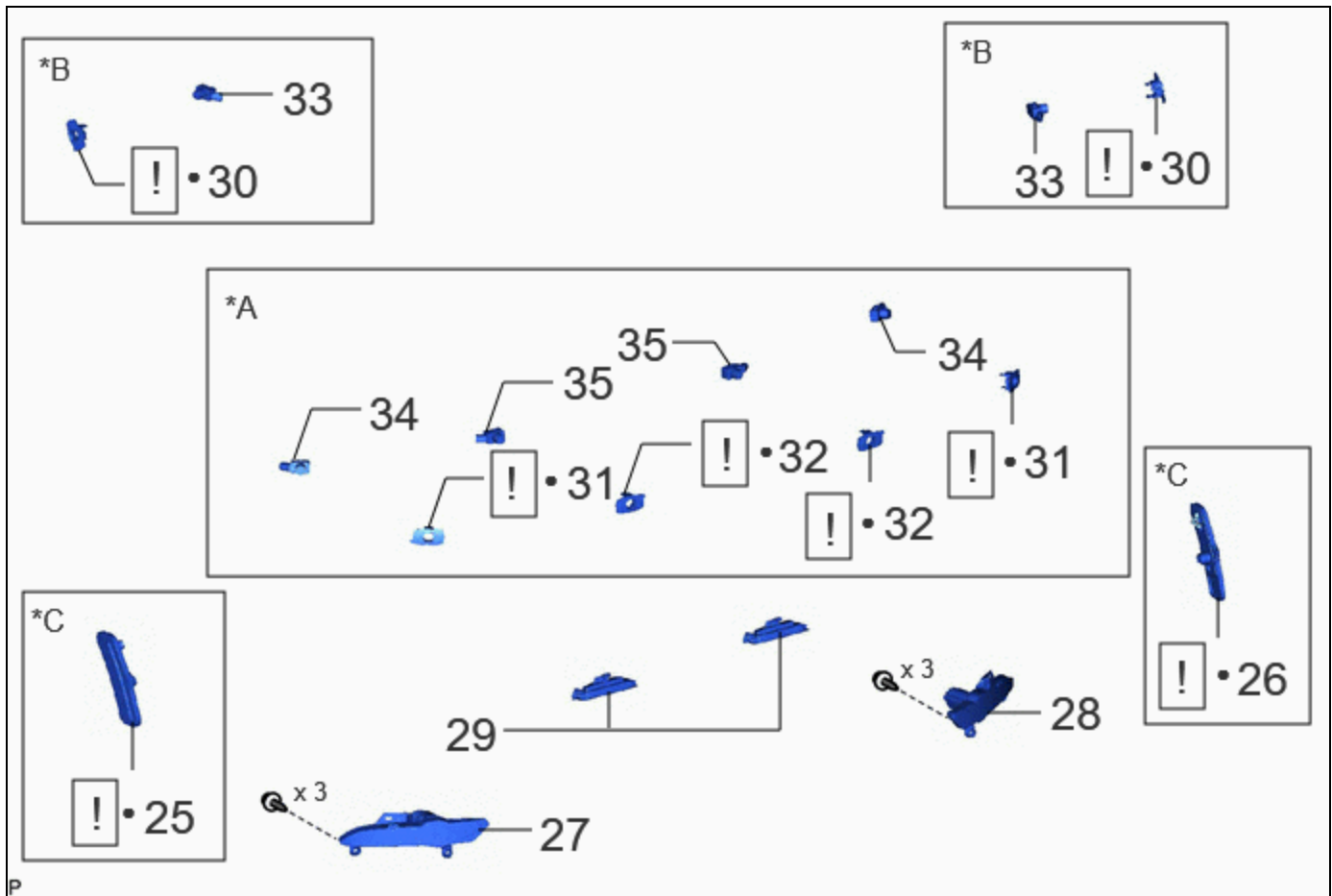
PROCEDURE		PART NAME CODE			
3	REAR BUMPER REINFORCEMENT SUB-ASSEMBLY	52023	-	-	-
4	REAR BUMPER ENERGY ABSORBER	52615	-	-	-
5	REAR BUMPER ARM REINFORCEMENT LH	52188A	-	-	-
6	REAR BUMPER ARM REINFORCEMENT RH	52187A	-	-	-
7	REAR BUMPER SIDE SEAL LH	52592	-	-	-
8	REAR BUMPER SIDE SEAL RH	52591	-	-	-
9	REAR BUMPER SIDE RETAINER LH	52576	-	-	-
10	REAR BUMPER SIDE RETAINER RH	52575	-	-	-
11	REAR BUMPER UPPER RETAINER LH	52563D	-	-	-
12	REAR BUMPER UPPER RETAINER RH	52562E	-	-	-
13	REAR COMBINATION LIGHT ASSEMBLY LH	-	-	-	-
14	REAR COMBINATION LIGHT ASSEMBLY RH	-	-	-	-

*A	for Type A	*B	for Type B
*1	REAR COMBINATION LIGHT SUB-ASSEMBLY LH	*2	REAR COMBINATION LIGHT SUB-ASSEMBLY RH
	N*m (kgf*cm, ft.*lbf): Specified torque	-	-






PROCEDURE		PART NAME CODE			
15	SEAL TAPE	-	INFO	-	-
16	REAR BUMPER CENTER GUARD	52453	-	-	-
17	REAR BUMPER LOWER COVER	52169C	-	-	-
18	REAR BUMPER COVER	52151H	-	-	-
19	NO. 2 REAR BUMPER ENERGY ABSORBER	52614A	INFO	-	-
20	REAR BUMPER CORNER EXTENSION LH	52166B	-	-	-
21	REAR BUMPER CORNER EXTENSION RH	52165D	-	-	-
22	REAR BUMPER PAD	52461F	INFO	-	-
23	REAR ULTRASONIC SENSOR CLIP	89348Y	INFO	-	-
24	NO. 3 LUGGAGE ROOM WIRE	82183	-	-	-

*A	w/ No. 2 Rear Bumper Energy Absorber	*B	w/o Side Marker Light
*C	w/ Side Marker Light	-	-
*1	REAR BUMPER COVER	-	-
•	Non-reusable part	-	-



PROCEDURE		PART NAME CODE			
25	REAR SIDE MARKER LIGHT ASSEMBLY LH	81760	<a href="#">INFO</a>	-	-
26	REAR SIDE MARKER LIGHT ASSEMBLY RH	81750	<a href="#">INFO</a>	-	-
27	BACK-UP LIGHT ASSEMBLY LH	81680	-	-	-
28	BACK-UP LIGHT ASSEMBLY RH	81670	-	-	-
29	LICENSE PLATE LIGHT SUB-ASSEMBLY	81204A	-	-	-
30	REAR SIDE ULTRASONIC SENSOR RETAINER	89C48C	<a href="#">INFO</a>	-	-
31	REAR CORNER ULTRASONIC SENSOR RETAINER	89C48A	<a href="#">INFO</a>	-	-
32	REAR CENTER ULTRASONIC SENSOR RETAINER	89C48B	<a href="#">INFO</a>	-	-
33	REAR SIDE ULTRASONIC SENSOR	89342B	-	-	-
34	REAR CORNER ULTRASONIC SENSOR	89342	-	-	-

PROCEDURE		PART NAME CODE			
35	REAR CENTER ULTRASONIC SENSOR	89342A	-	-	-

*A	w/ Parking Support Brake System	*B	w/ Advanced Park
*C	w/ Side Marker Light	-	-
•	Non-reusable part	-	-

## PROCEDURE

### 1. INSTALL REAR BUMPER ARM LH (for Type A)

**Torque:**

**26 N·m {265 kgf·cm, 19 ft·lbf}**

### 2. INSTALL REAR BUMPER ARM RH (for Type A)

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

### 3. INSTALL REAR BUMPER REINFORCEMENT SUB-ASSEMBLY

**Torque:**

**for Type A: :**

**62 N·m {632 kgf·cm, 46 ft·lbf}**

**for Type B: :**

**26 N·m {265 kgf·cm, 19 ft·lbf}**

### 4. INSTALL REAR BUMPER ENERGY ABSORBER (for Type A)

**Torque:**

**18 N·m {184 kgf·cm, 13 ft·lbf}**

### 5. INSTALL REAR BUMPER ARM REINFORCEMENT LH (for Type A)

**Torque:**

**18 N·m {184 kgf·cm, 13 ft·lbf}**

### 6. INSTALL REAR BUMPER ARM REINFORCEMENT RH (for Type A)

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

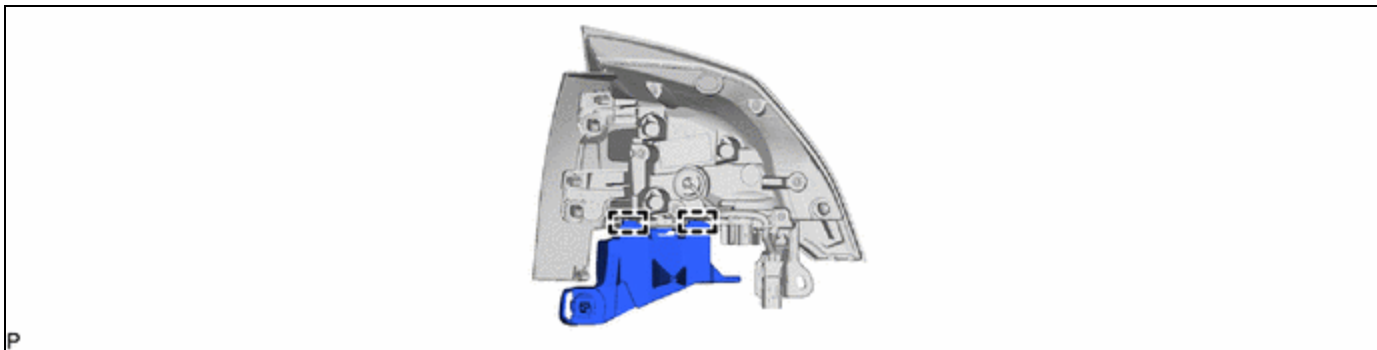
### 7. INSTALL REAR BUMPER SIDE SEAL LH

### 8. INSTALL REAR BUMPER SIDE SEAL RH

### 9. INSTALL REAR BUMPER SIDE RETAINER LH

### 10. INSTALL REAR BUMPER SIDE RETAINER RH

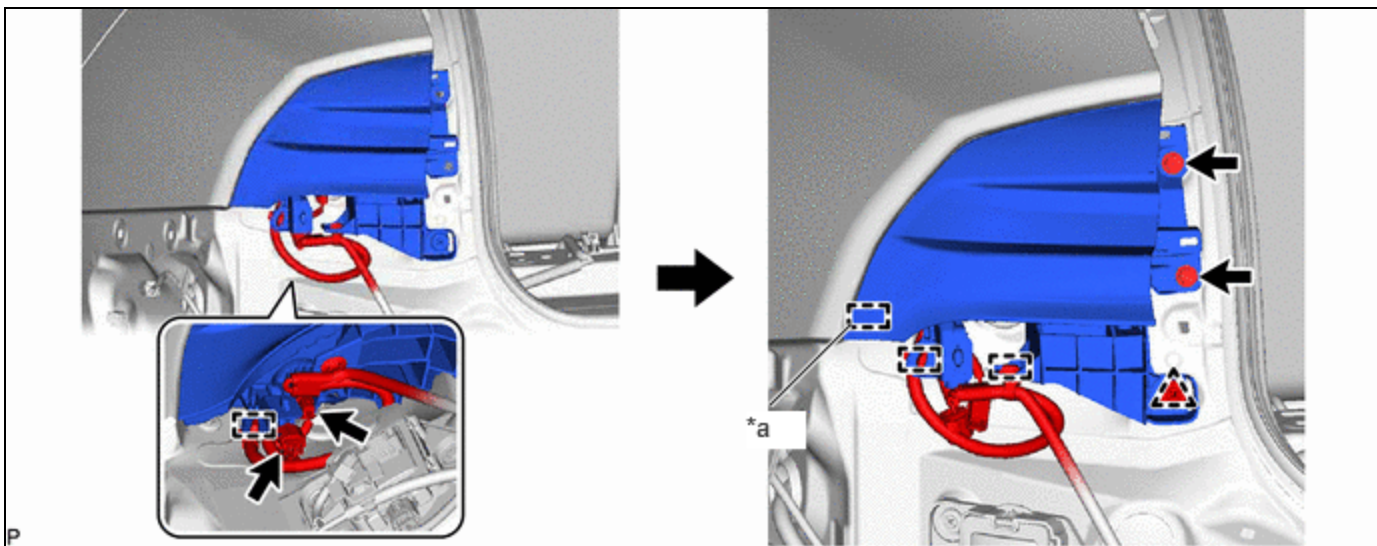
### 11. INSTALL REAR BUMPER UPPER RETAINER LH



**12. INSTALL REAR BUMPER UPPER RETAINER RH**

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

**13. INSTALL REAR COMBINATION LIGHT ASSEMBLY LH**

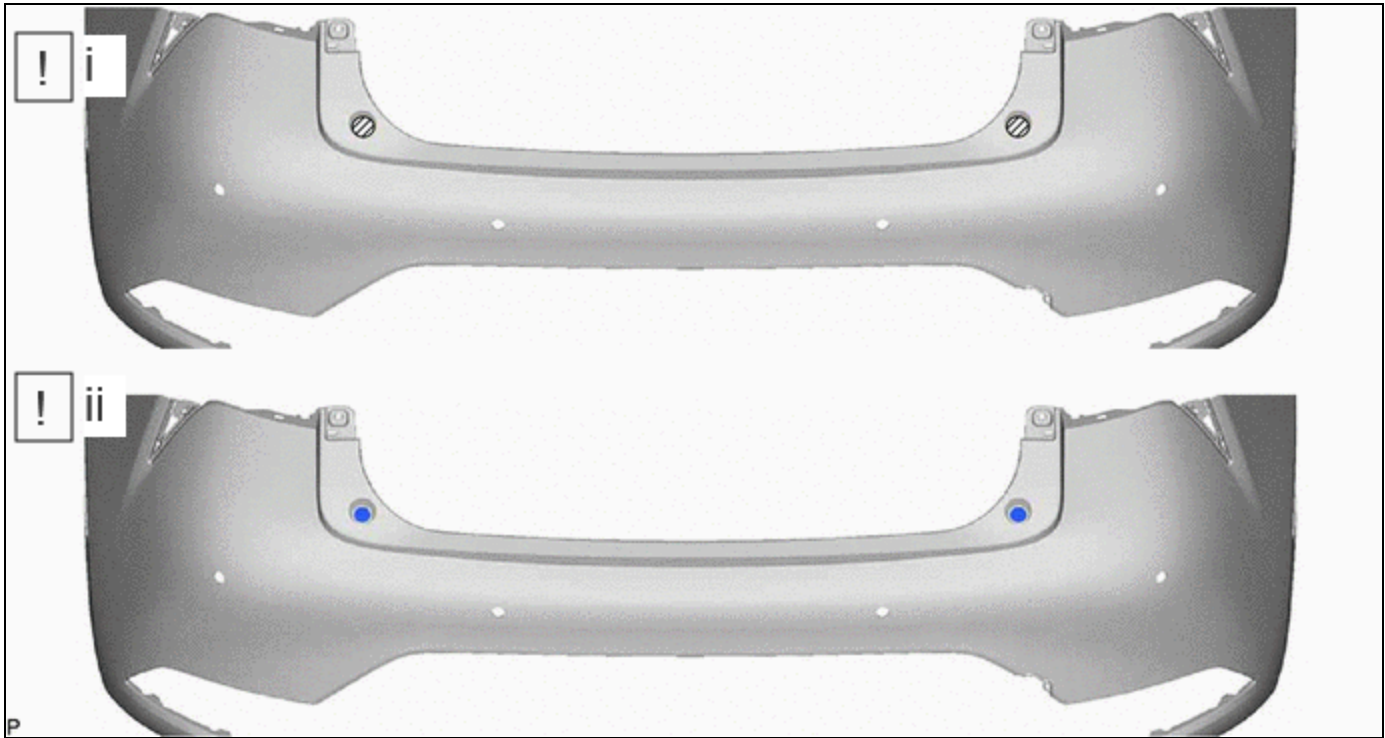



*a	Pin	-	-
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**14. INSTALL REAR COMBINATION LIGHT ASSEMBLY RH**

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

**15. INSTALL SEAL TAPE**



	Cleaning Area	-	-
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(1) Clean the rear bumper cover surface.

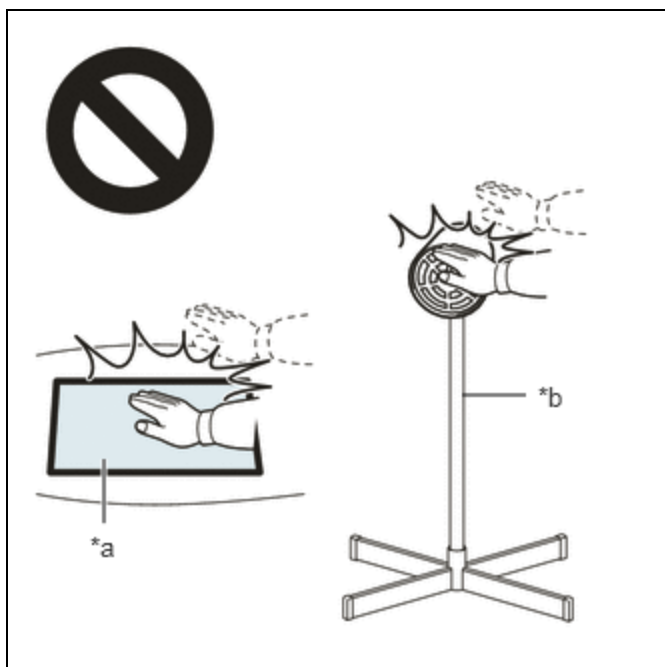
1. Using a heat light, heat the double-sided tape remaining on the rear bumper cover and 2 seal tapes.

**Heating Temperature**

AREA	TEMPERATURE	AREA	TEMPERATURE
Rear Bumper Cover	20 to 30 °C (68 to 86 °F)	Seal Tape	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 rear bumper cover excessively.

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

**HINT:**

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

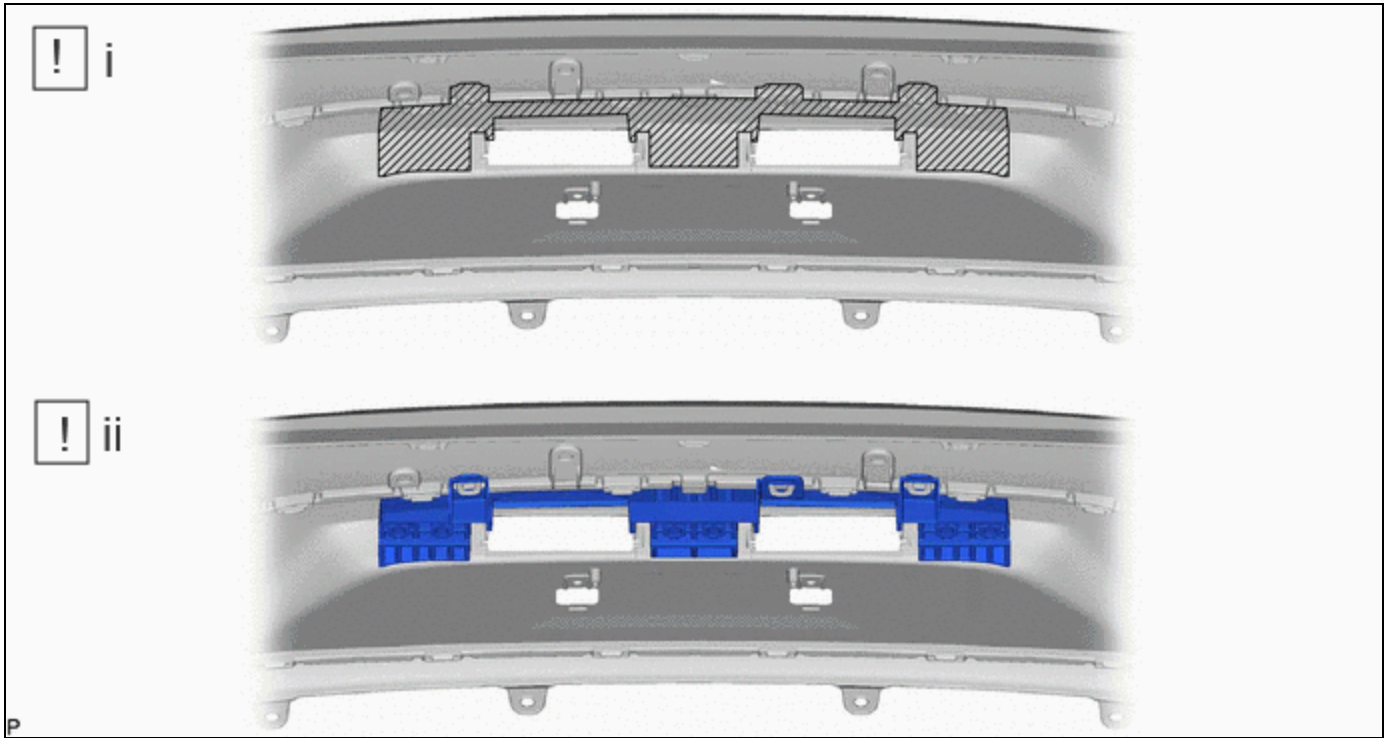
3. Install the 2 seal tapes as shown in the illustration.


**HINT:**

- Apply the seal tape along the scribed line on the rear bumper cover.
- Press the seal tape firmly to install it.

**16. INSTALL REAR BUMPER CENTER GUARD****17. INSTALL REAR BUMPER LOWER COVER****18. INSTALL REAR BUMPER COVER****19. INSTALL NO. 2 REAR BUMPER ENERGY ABSORBER (w/ No. 2 Rear Bumper Energy Absorber)**





	Cleaning Area	-	-
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(1) Clean the rear bumper cover surface.

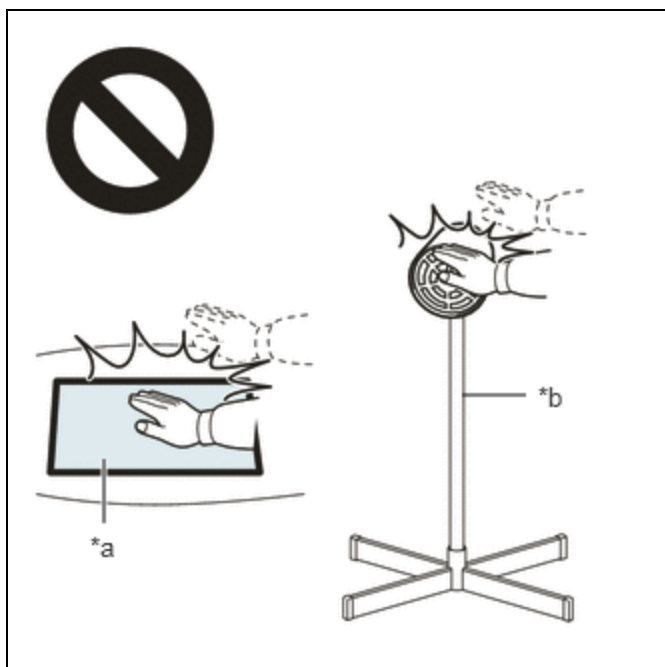
1. Using a heat light, heat the double-sided tape remaining on the rear bumper cover and No. 2 rear bumper energy absorber.

**Heating Temperature**

AREA	TEMPERATURE	AREA	TEMPERATURE
Rear Bumper Cover	20 to 30 °C (68 to 86 °F)	No. 2 Rear Bumper Energy Absorber	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 rear bumper cover excessively.

2. Remove any remaining double-sided tape from the rear bumper cover.
  3. Wipe off any tape adhesive residue with cleaner.
- (2) Install new No. 2 rear bumper energy absorber.
1. Using a heat light, heat the rear bumper cover surface.
  2. Remove the release paper from the No. 2 rear bumper energy absorber.

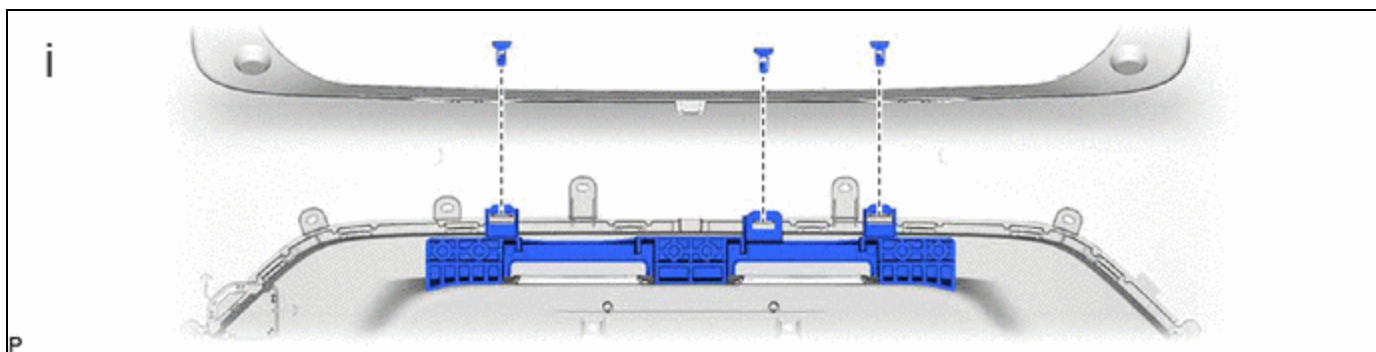
**HINT:**

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

3. Install the No. 2 rear bumper energy absorber as shown in the illustration.

**HINT:**

- Apply the No. 2 rear bumper energy absorber along the scribed line on the rear bumper cover.
- Press the No. 2 rear bumper energy absorber firmly to install it.

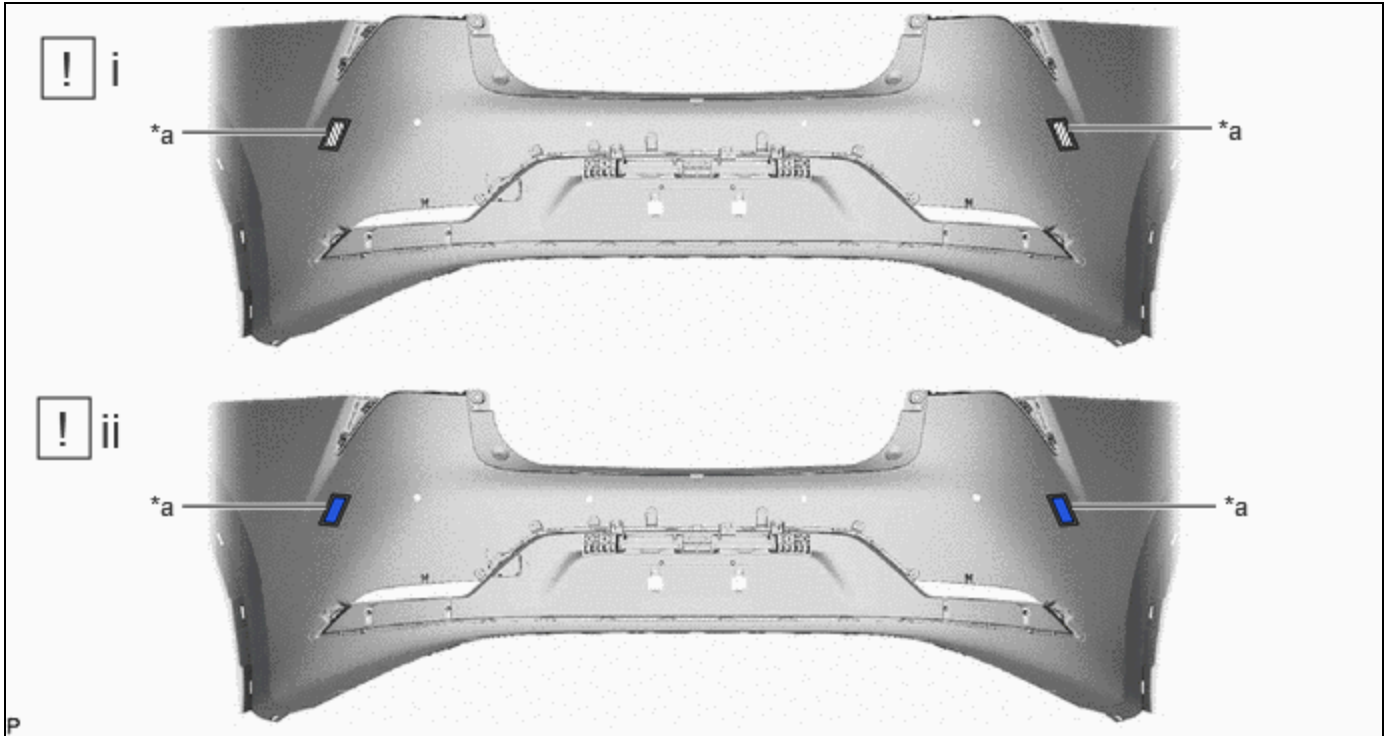



- (1) Install the 3 clips.

**20. INSTALL REAR BUMPER CORNER EXTENSION LH**

**21. INSTALL REAR BUMPER CORNER EXTENSION RH**

**22. INSTALL REAR BUMPER PAD**



*a	Scribed Line	-	-
	Cleaning Area	-	-

(1) Clean the rear bumper cover surface.

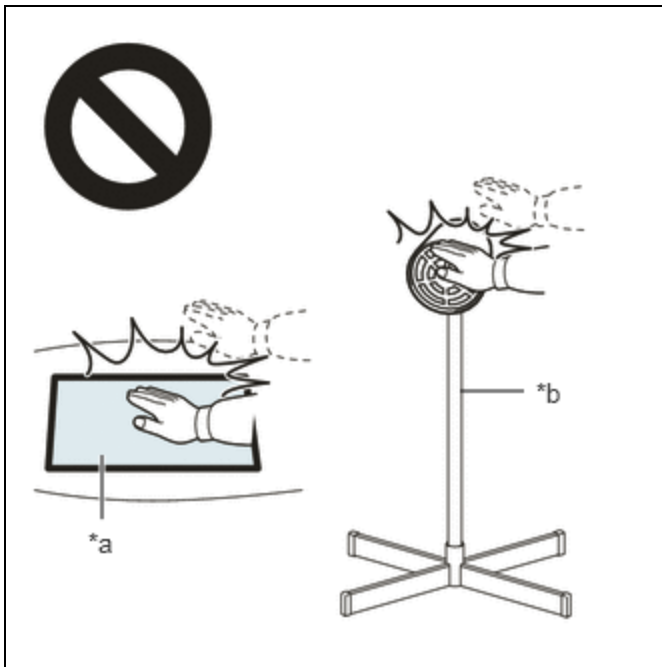
- Using a heat light, heat the double-sided tape remaining on the rear bumper cover and 2 rear bumper pads.

**Heating Temperature**

AREA	TEMPERATURE	AREA	TEMPERATURE
Rear Bumper Cover	20 to 30 °C (68 to 86 °F)	Rear 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 rear bumper cover excessively.

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

**HINT:**

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

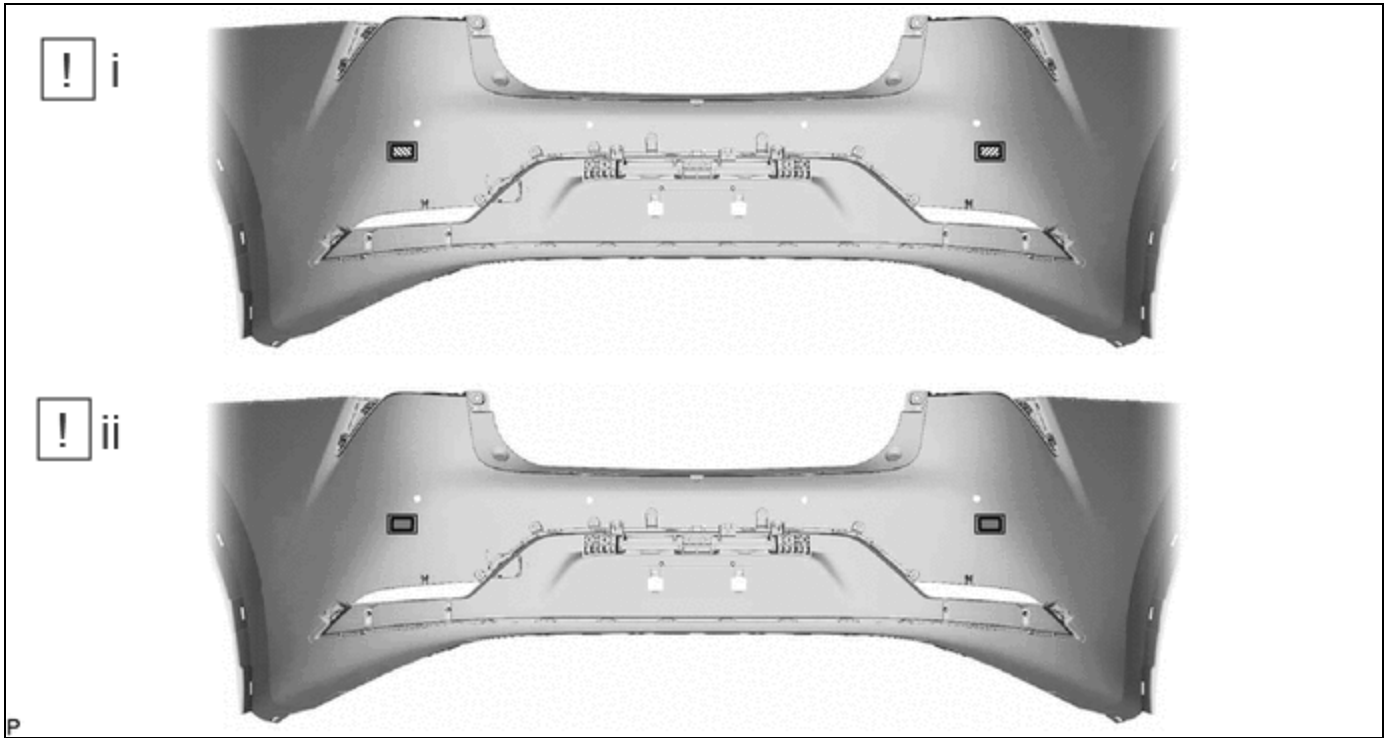
3. Install the 2 rear bumper pads as shown in the illustration.



**HINT:**

- Apply the rear bumper pad along the scribed line on the rear bumper cover.
- Press the rear bumper pad firmly to install it.

**23. INSTALL REAR ULTRASONIC SENSOR CLIP**

(a) w/o Side Marker Light:



	Cleaning Area		Primer
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(1) Clean the rear bumper cover surface.

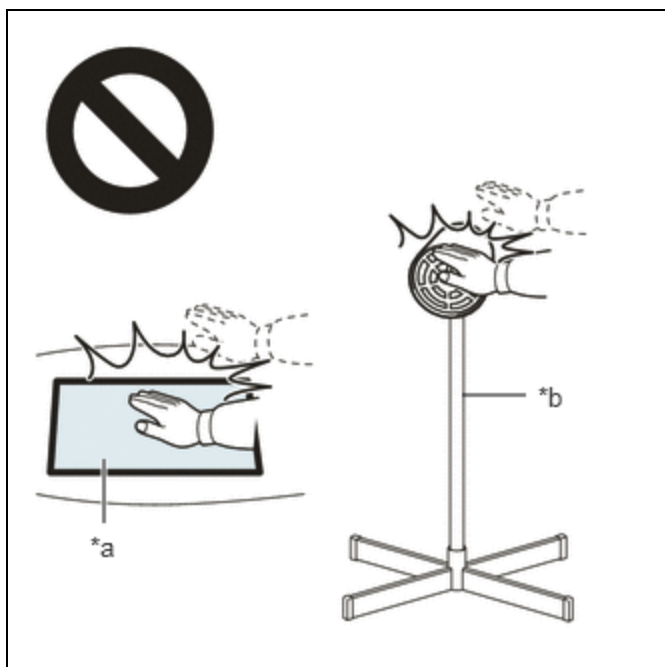
- Using a heat light, heat the double-sided tape remaining on the rear bumper cover and 2 rear ultrasonic sensor clips.

**Heating Temperature**

AREA	TEMPERATURE	AREA	TEMPERATURE
Rear Bumper Cover	20 to 30 °C (68 to 86 °F)	Rear 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 rear bumper cover excessively.

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

**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.

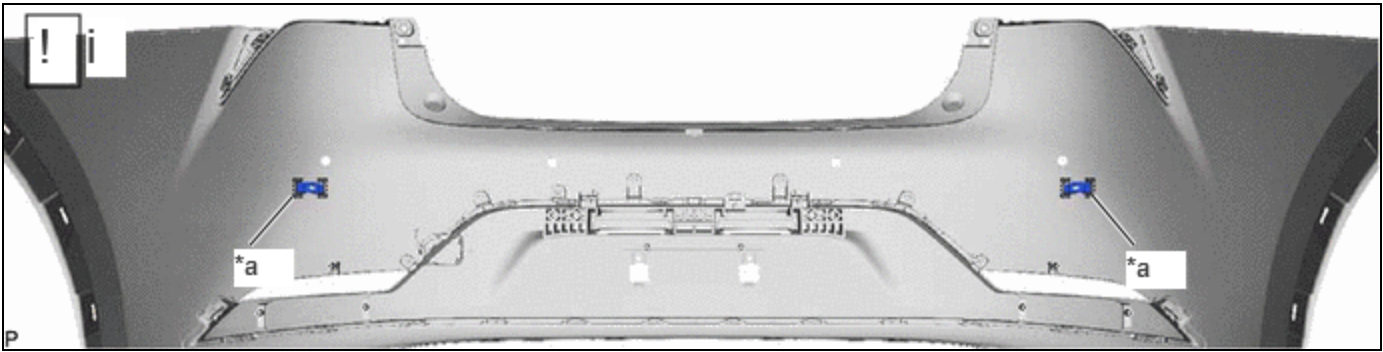
**NOTICE:**

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

**HINT:**

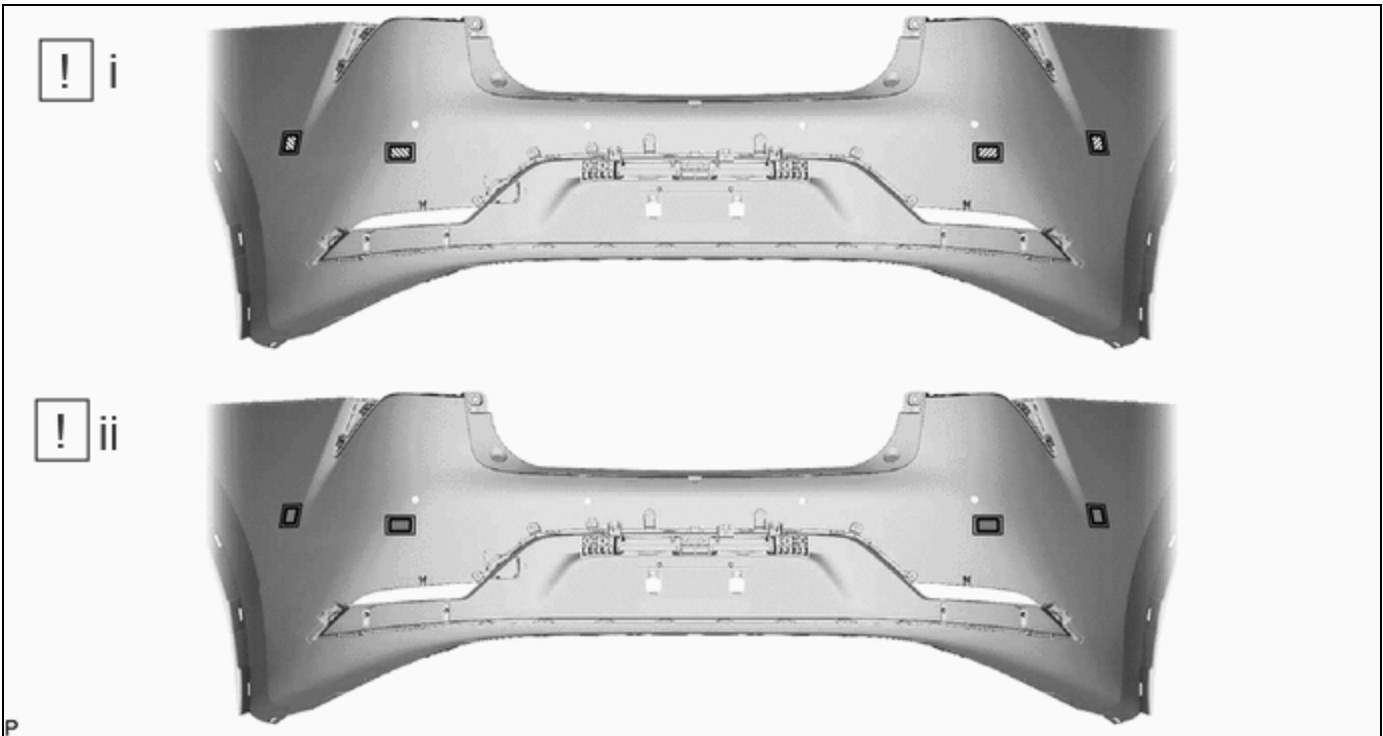
After removing the release paper, keep the exposed adhesive free from foreign matter.



3. Install the 2 rear ultrasonic sensor clips as shown in the illustration.

**HINT:**

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

(c) w/ Side Marker Light:



	Cleaning Area		Primer
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- (1) Clean the rear bumper cover surface.

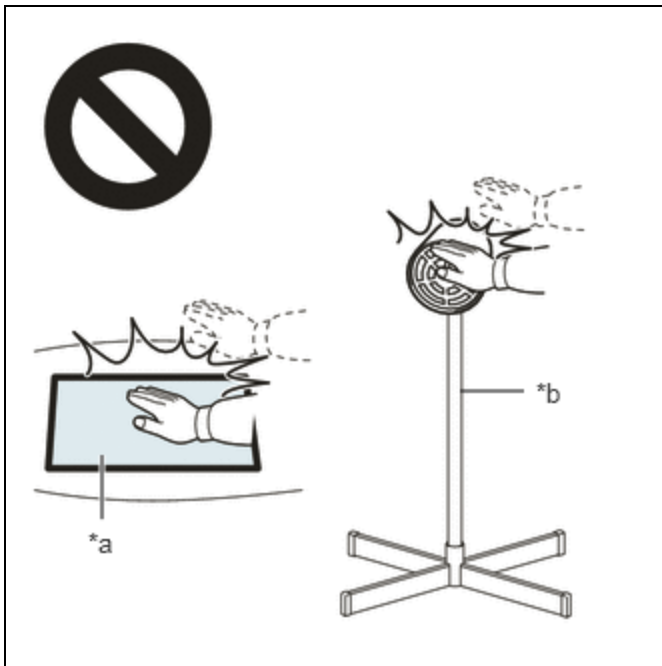
- Using a heat light, heat the double-sided tape remaining on the rear bumper cover and 4 rear ultrasonic sensor clips.

**Heating Temperature**

AREA	TEMPERATURE	AREA	TEMPERATURE
Rear Bumper Cover	20 to 30 °C (68 to 86 °F)	Rear 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 rear bumper cover excessively.

- Remove any remaining double-sided tape from the rear bumper cover.
  - Wipe off any tape adhesive residue with cleaner.
- (2) Apply primer to the installation area of the 4 rear ultrasonic sensor clips on the front bumper cover.
- Using a brush or felt, apply primer or equivalent to the installation area of the 4 rear ultrasonic sensor clips.

**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.

- Let the primer dry sufficiently.

**NOTICE:**

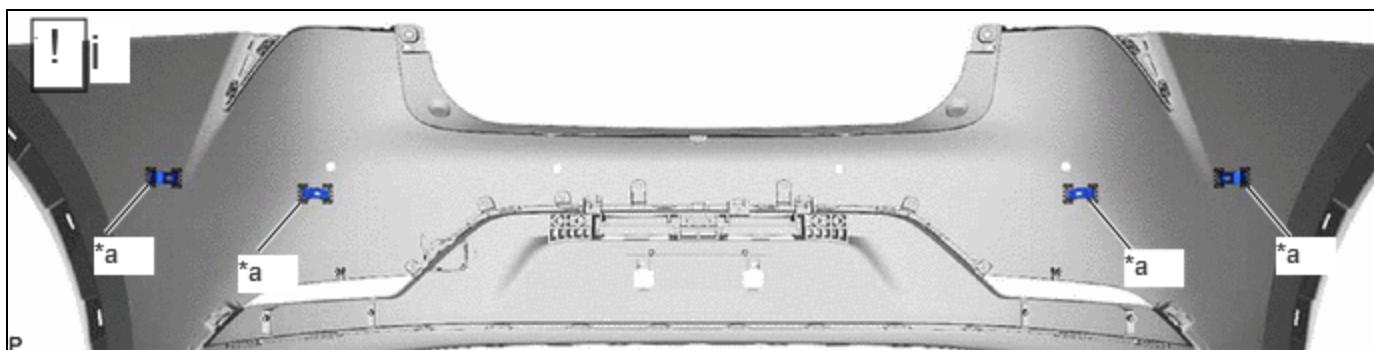
Do not touch applied surfaces until the primer is dry.

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	Scribed Line	-	-
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- (1) Install 4 new rear ultrasonic sensor clips.

1. Using a heat light, heat the front bumper cover surface.
2. Remove the release paper from the 4 rear ultrasonic sensor clips.

**HINT:**

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

3. Install the 4 rear ultrasonic sensor clips as shown in the illustration.

**HINT:**

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

**24. INSTALL NO. 3 LUGGAGE ROOM WIRE**

**25. INSTALL REAR SIDE MARKER LIGHT ASSEMBLY LH (w/ Side Marker Light)**

	<a href="#">Click here</a> 
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**26. INSTALL REAR SIDE MARKER LIGHT ASSEMBLY RH (w/ Side Marker Light)**


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

**27. INSTALL BACK-UP LIGHT ASSEMBLY LH**

**28. INSTALL BACK-UP LIGHT ASSEMBLY RH**

**29. INSTALL LICENSE PLATE LIGHT SUB-ASSEMBLY**

**30. INSTALL REAR SIDE ULTRASONIC SENSOR RETAINER (w/ Advanced Park)**

	<a href="#">Click here</a> 
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**31. INSTALL REAR CORNER ULTRASONIC SENSOR RETAINER (w/ Parking Support Brake System)**

	Click here <a href="#">INFO</a>
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**32. INSTALL REAR CENTER ULTRASONIC SENSOR RETAINER (w/ Parking Support Brake System)**

	Click here <a href="#">INFO</a>
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**33. INSTALL REAR SIDE ULTRASONIC SENSOR (w/ Advanced Park)**

**34. INSTALL REAR CORNER ULTRASONIC SENSOR (w/ Parking Support Brake System)**

**35. INSTALL REAR CENTER ULTRASONIC SENSOR (w/ Parking Support Brake System)**

