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<b>Model Year Start:</b> 2023	<b>Model:</b> Prius Prime	<b>Prod Date Range:</b> [12/2022 - ]
<b>Title:</b> LIGHTING (EXT): HEADLIGHT ASSEMBLY: REASSEMBLY; 2023 - 2024 MY Prius Prius Prime [12/2022 - ]		

## REASSEMBLY

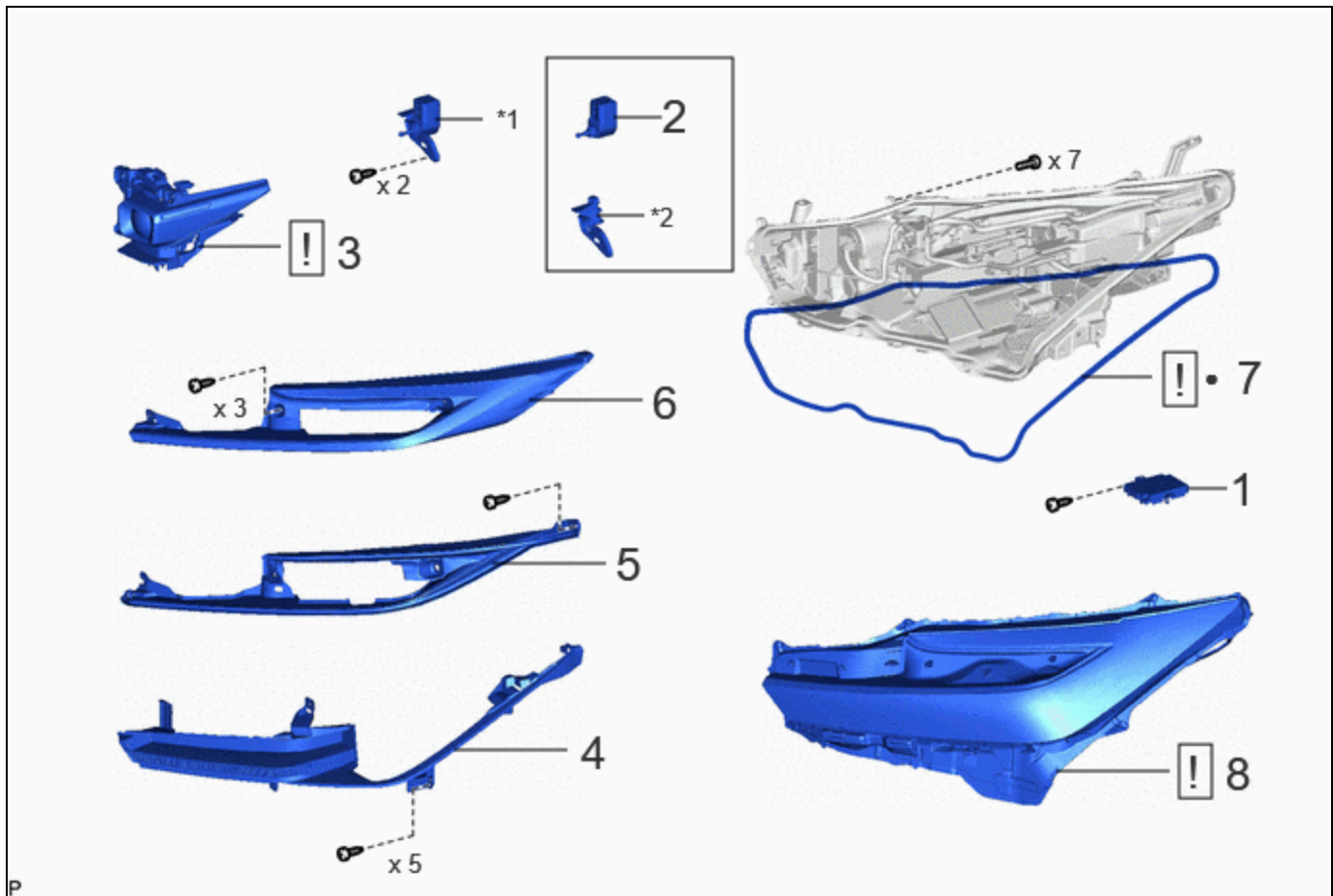
### CAUTION / NOTICE / HINT

**HINT:**




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

### CAUTION / NOTICE / HINT

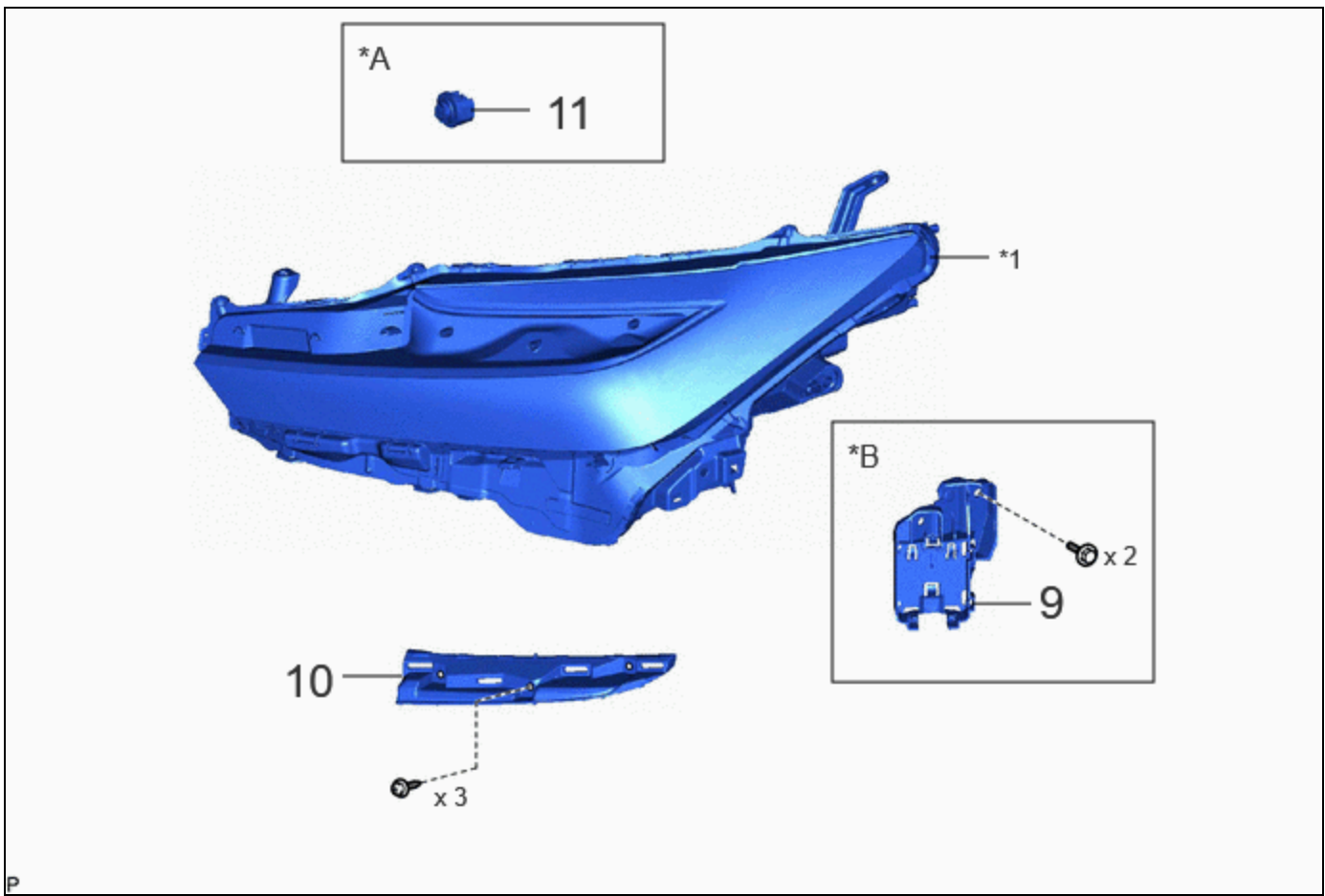
#### COMPONENTS (REASSEMBLY)






	PROCEDURE	PART NAME CODE			
1	LIGHT CONTROL LED ECU	85967D	-	-	-
2	HEADLIGHT LEVELING MOTOR	85691	-	-	-
3	HEADLIGHT UNIT	81171A	<a href="#">INFO</a>	-	-

PROCEDURE	PART NAME CODE			
4 INNER LENS ASSEMBLY	-	-	-	-
5 REFLECTOR	-	-	-	-
6 INNER LENS ASSEMBLY	-	-	-	-
7 HEADLIGHT LENS GASKET	81132B	<a href="#">INFO</a>	-	-
8 HEADLIGHT LENS	81186	<a href="#">INFO</a>	-	-

*1 HEADLIGHT LEVELING MOTOR WITH BRACKET	*2 HEADLIGHT LEVELING MOTOR BRACKET
• Non-reusable part	-




PROCEDURE	PART NAME CODE			
9 FRONT SIDE RADAR SENSOR BRACKET	88215C	-	-	-
10 HEADLIGHT BRACKET	53246B	-	-	-
11 HEADLIGHT FRONT TURN SIGNAL LED	8113A	-	-	-

*A	w/ Front Turn Signal LED Socket	*B	w/ Front Side Radar
*1	HEADLIGHT UNIT SUB-ASSEMBLY	-	-

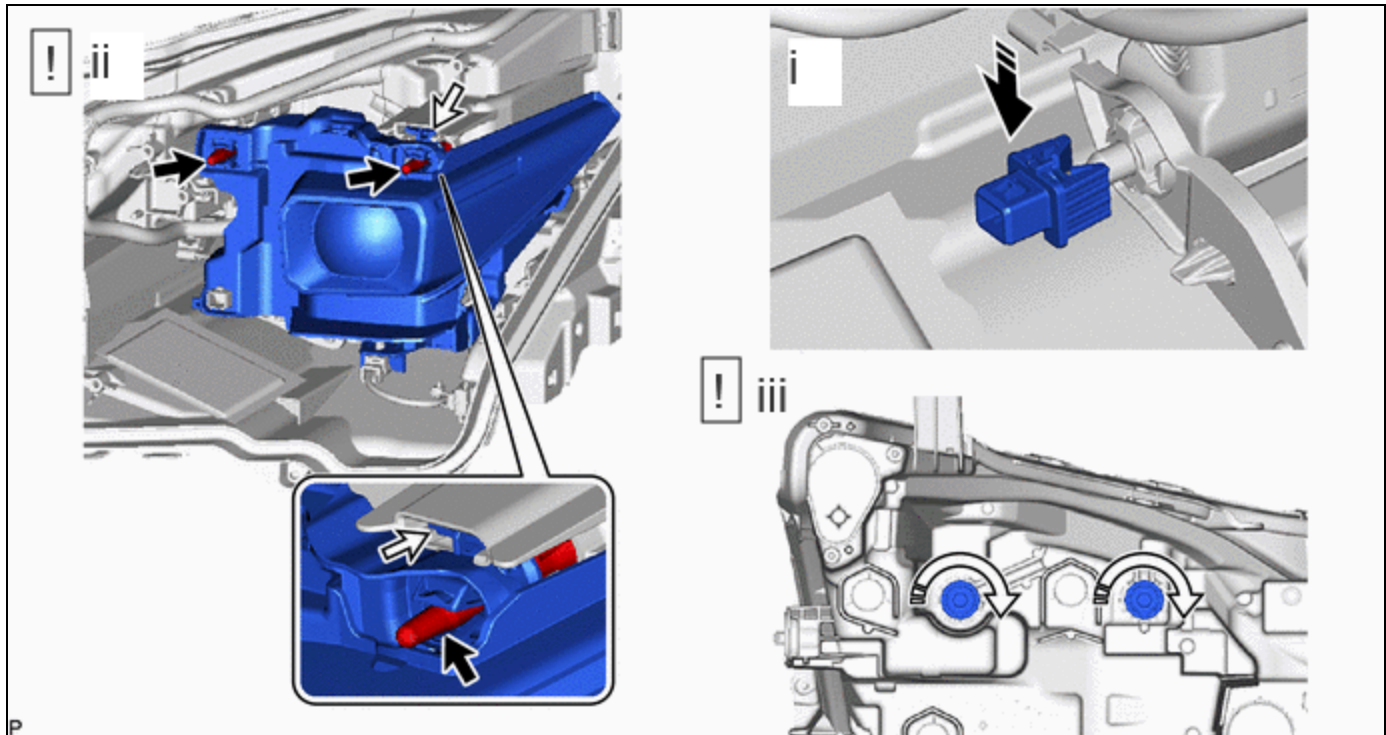
## PROCEDURE





1. INSTALL LIGHT CONTROL LED ECU
2. INSTALL HEADLIGHT LEVELING MOTOR
3. INSTALL HEADLIGHT UNIT

	<p><b>NOTICE:</b></p> <ul style="list-style-type: none"> <li>• Make sure to wear clean rubber gloves when performing this procedure.</li> <li>• Do not allow dirt or foreign matter to get on the headlight unit or other components.</li> <li>• Prevention of static electricity is required during this procedure.</li> <li>• Use static electricity countermeasures SST (desktop anti-static mat set) and observe all precautions to prevent damage to the system by electrostatic discharge (ESD).</li> <li>• Do not touch the headlight unit with bare hands.</li> <li>• Do not allow metallic surfaces to become dirty, as such surfaces become damaged even if they are only lightly wiped with a soft cloth.</li> <li>• If there are any fingerprints or foreign matter on the headlight unit or other components, wipe them off with a soft cloth.</li> <li>• Do not use solvent to clean components. Only clean them with a dry cloth.</li> </ul>
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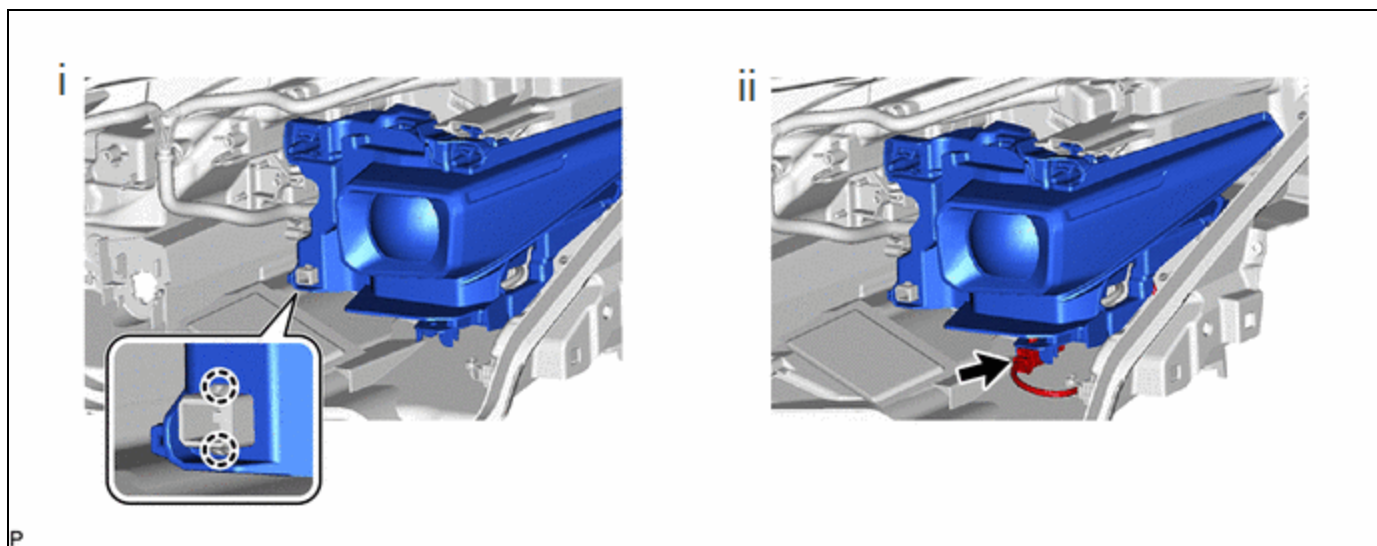
**SST: 09890-47010**

- 09891-04010
- 09891-04020
- 09891-04030
- 09891-04040



	Adjustment Aiming Screws		Adjustment Aiming Rail
	Install in this Direction		Turn in this Direction

- (1) Install the pivot collar as shown in the illustration.
- (2) Temporarily install the headlight unit assembly to the 2 adjustment aiming rails and 2 adjustment aiming screws as shown in the illustration.
- (3) Hold the headlight unit assembly LH with one hand to prevent it from tipping over, alternately tighten the 2 adjustment aiming screws in the direction indicated by the arrow shown in the illustration, and align the dimensions with the recorded values at removal.




- (1) Engage the 2 claws to connect the pivot collar.
- (2) Connect the connector to install the headlight unit.

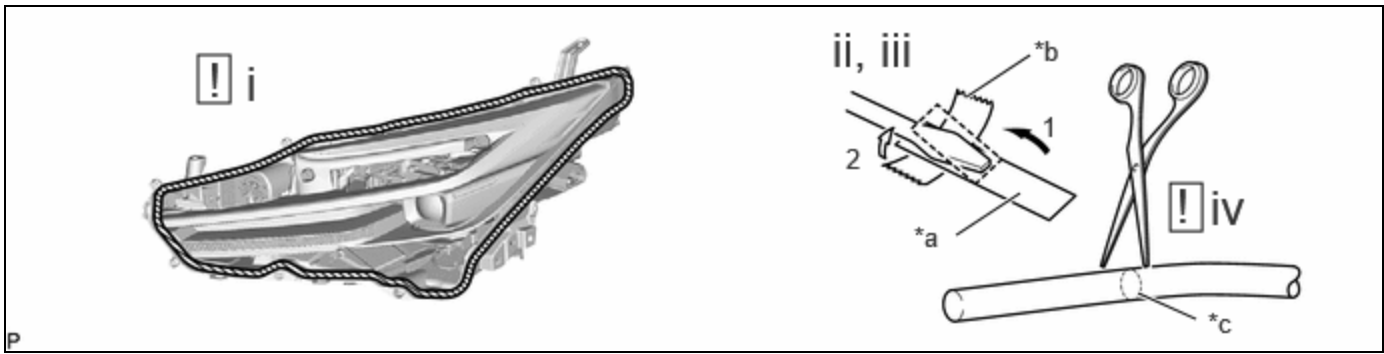
**4. INSTALL INNER ASSEMBLY**

**5. INSTALL REFLECTOR**

**6. INSTALL INNER LENS ASSEMBLY**

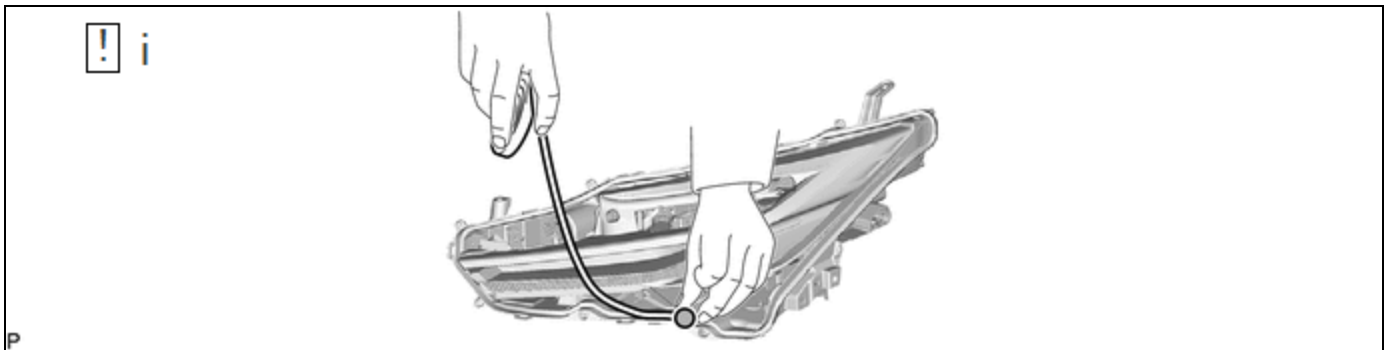
**7. INSTALL HEADLIGHT LENS GASKET**

	<p><b>NOTICE:</b></p> <ul style="list-style-type: none"> <li>• The headlight lens gasket must not be reused.</li> <li>• Make sure to wear clean rubber gloves when performing this procedure.</li> <li>• Do not touch the inner surface of the lens and metallic surfaces as much as possible, or they may become dirty.</li> <li>• Do not allow metallic surfaces to become dirty, as such surfaces become damaged even if they are only lightly wiped with a soft cloth.</li> <li>• If there are any fingerprints or foreign matter on the headlight unit or other components, wipe them off with a soft cloth.</li> <li>• Do not use solvent to clean components. Only clean them with a dry cloth.</li> </ul>
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*a	Release Paper	*b	Tape
*c	90°	-	-
	Cleaning Area	-	-

- (1) Clean the installation groove of the headlight lens.
- (2) Partially remove the release paper from a new headlight lens gasket, and cut off a piece of it.
- (3) Fold the release paper over the tip of a screwdriver and secure it in place with tape as indicated by the arrows, in the order shown in the illustration.
- (4) Using scissors, cut the end of the headlight lens gasket at a 90° angle.

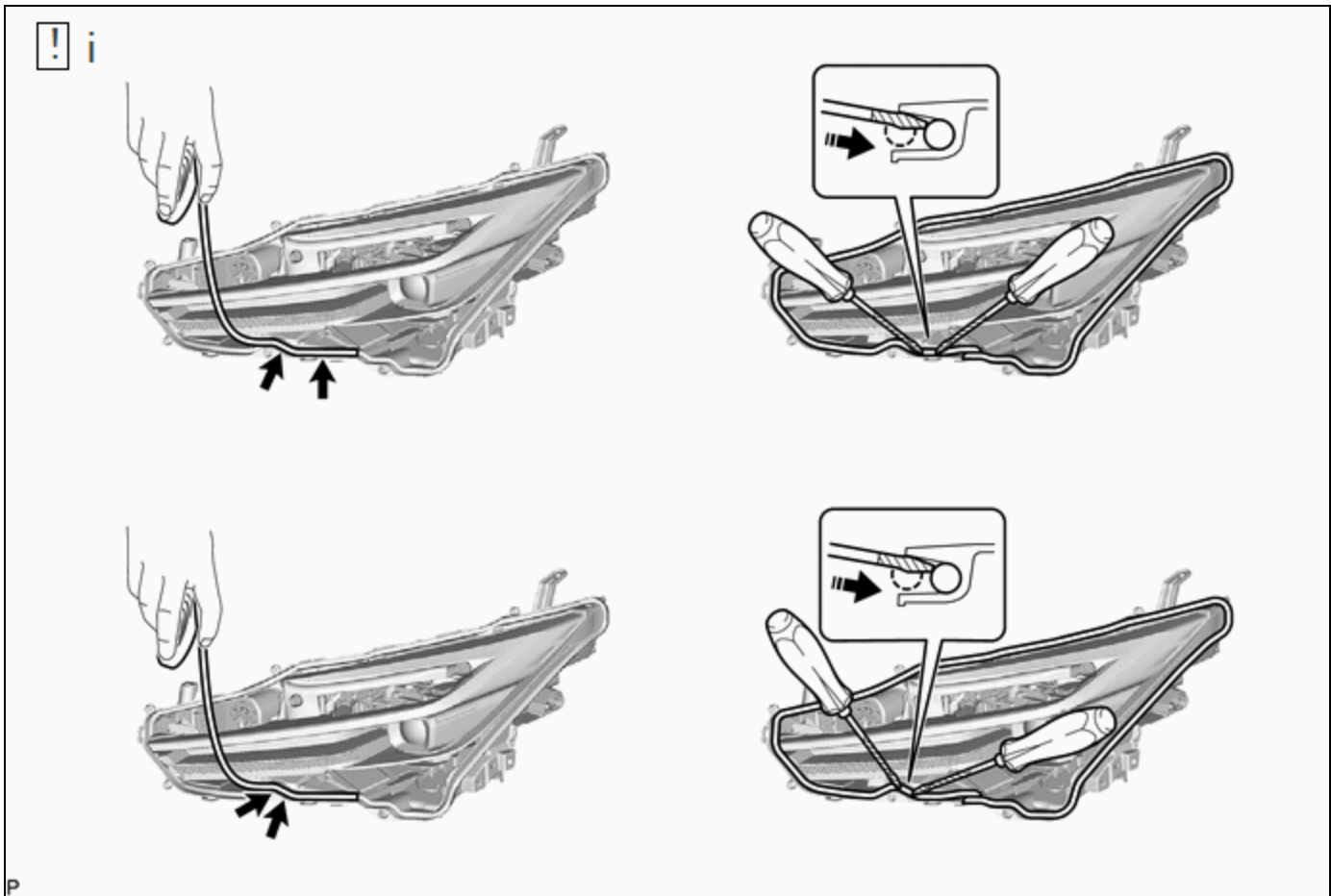


	Starting Position	-	-
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- (1) Starting from the position shown in the illustration and moving clockwise, temporarily install the headlight lens gasket as shown in the illustration.

**NOTICE:**

Gently install the headlight lens gasket without pulling it.



	Straight Groove		Press in this Direction
	Release Paper	-	-

(1) Repeat the following until the headlight lens gasket reaches the starting position.

1. Using 2 screwdrivers with their tips wrapped with release paper, completely press the headlight lens gasket into the straight groove to install it.

**NOTICE:**

- Gently install the headlight lens gasket without pulling it.
- If the headlight lens gasket is pulled while it is installed, it will not be installed properly.

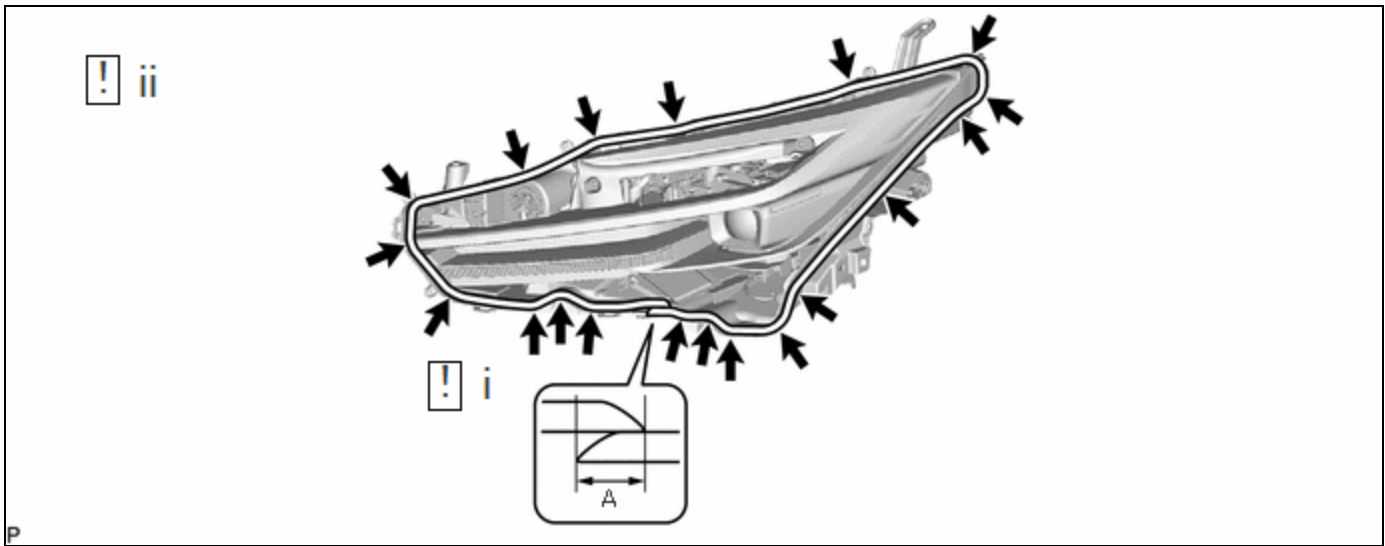
2. Temporarily install the headlight lens gasket to the straight groove.

3. Temporarily install it to the corner groove.

**NOTICE:**

- Gently install the headlight lens gasket without pulling it.
- If the headlight lens gasket is pulled while it is installed, it will not be installed properly.

4. Completely press it into the groove.



	Corner Groove	-	-
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(1) Using scissors, cut the headlight lens gasket at a 45° angle at the starting position so that the headlight lens gasket overlaps itself 10 mm (0.394 in.) or more.

Standard Dimension:

AREA	DIMENSION	-	-
A	10 mm (0.394 in.) or more	-	-

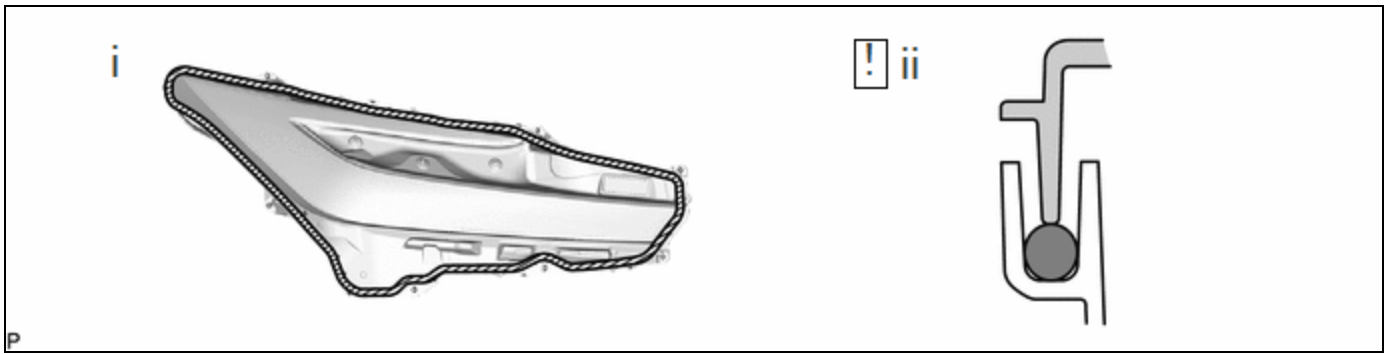
(2) Check the installation condition of the headlight lens gasket.





**NOTICE:**

- Make sure the headlight lens gasket is not protruding and is installed properly.
- Make sure there is no gap between the ends of the headlight lens gasket.
- Make sure to thoroughly check the corners as the headlight lens gasket is likely to be improperly installed in the corners.

**8. INSTALL HEADLIGHT LENS**

	<p><b>NOTICE:</b></p> <ul style="list-style-type: none"> <li>• Make sure to wear clean rubber gloves when performing this procedure.</li> <li>• Do not allow dirt or foreign matter to get on the headlight lens.</li> <li>• Do not touch the inner surface of the lens and metallic surfaces as much as possible, or they may become dirty.</li> <li>• Do not allow metallic surfaces to become dirty, as such surfaces become damaged even if they are only lightly wiped with a soft cloth.</li> <li>• If there are any fingerprints or foreign matter on the back of the headlight lens, wipe them off with a soft cloth.</li> <li>• Do not use solvent to clean components. Only clean them with a dry cloth.</li> </ul>
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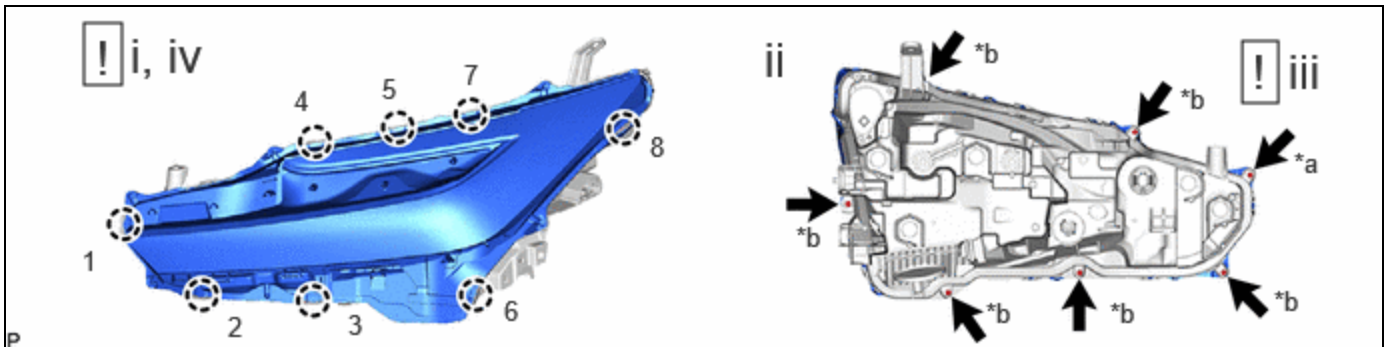


	Cleaning Area		Headlight Lens Gasket
	Headlight Lens		Headlight Housing

- (1) Clean the sealing surface of the headlight lens.
- (2) Temporarily install the headlight lens to the headlight housing.

**NOTICE:**

- Temporarily install the headlight lens in the middle of the headlight lens gasket as shown in the illustration.
- Check that the entire circumference of the headlight lens is positioned above the middle of the headlight lens gasket.



*a	"TORX" Screw	*b	Screw
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- (1) Engage the 8 claws in the order shown in the illustration to install the headlight lens.

**NOTICE:**

- Make sure all of the claws are engaged.
- (2) Install the 6 screws.
  - (3) Using a T20H "TORX" driver, install the "TORX" screw.
  - (4) Check the installation condition of the headlight lens gasket.

**NOTICE:**

- Make sure the headlight lens gasket is not protruding and completely contacts the headlight lens.

**9. INSTALL FRONT SIDE RADAR SENSOR BRACKET (w/ Front Side Radar)**

**10. INSTALL HEADLIGHT BRACKET**

**11. INSTALL HEADLIGHT FRONT TURN SIGNAL LED (w/ Front Turn Signal LED Socket)**



