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Model Year Start: 2023	Model: Prius Prime	Prod Date Range: [03/2023 -]
Title: M20A-FXS (EMISSION CONTROL): EGR COOLER: INSTALLATION; 2023 - 2024 MY Prius Prius Prime [03/2023 -]		

INSTALLATION

CAUTION / NOTICE / HINT

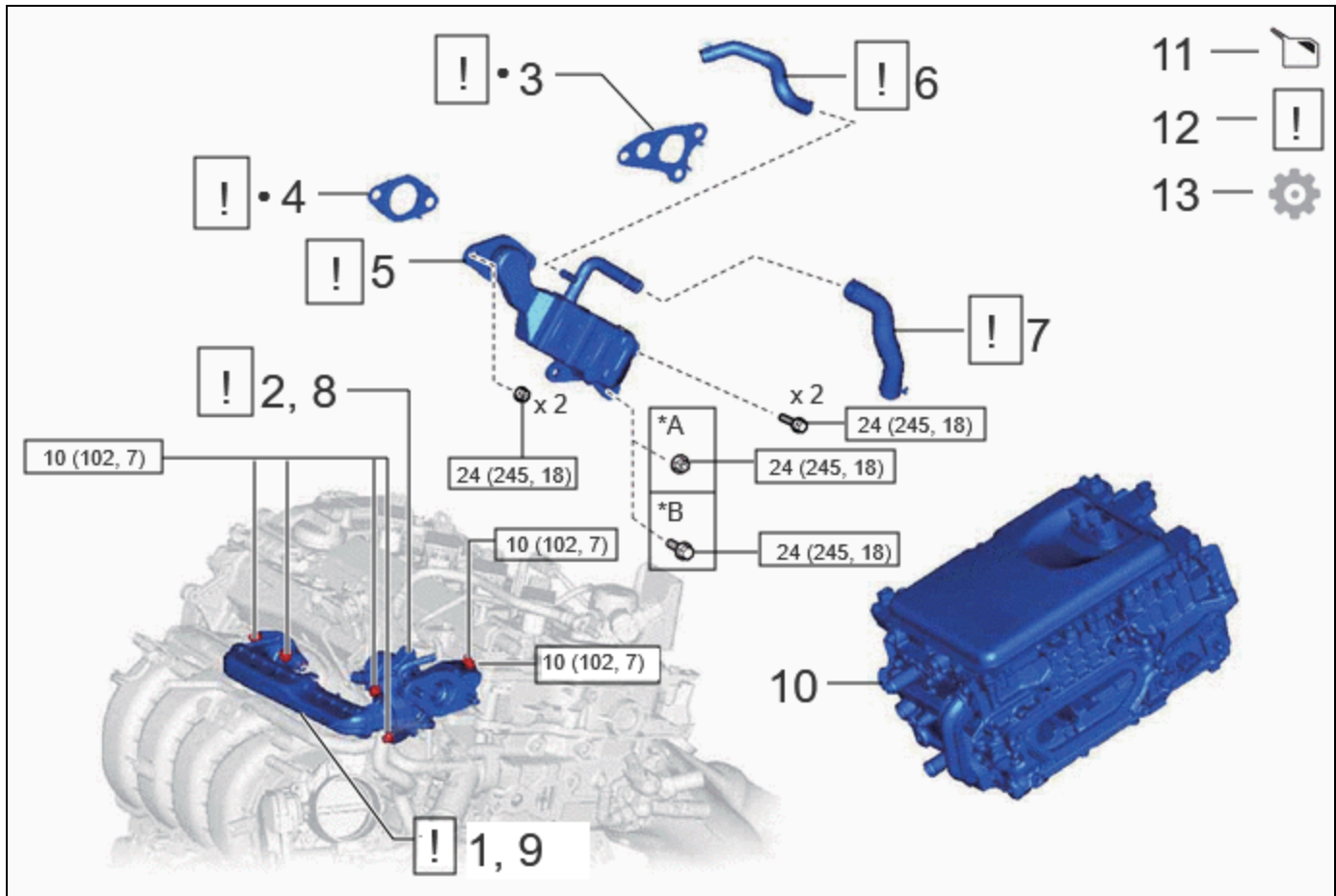
NOTICE:

This procedure includes the installation of small-head bolts. Refer to Small-Head Bolts of Basic Repair Hint to identify the small-head bolts.




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CAUTION / NOTICE / HINT

COMPONENTS (INSTALLATION)



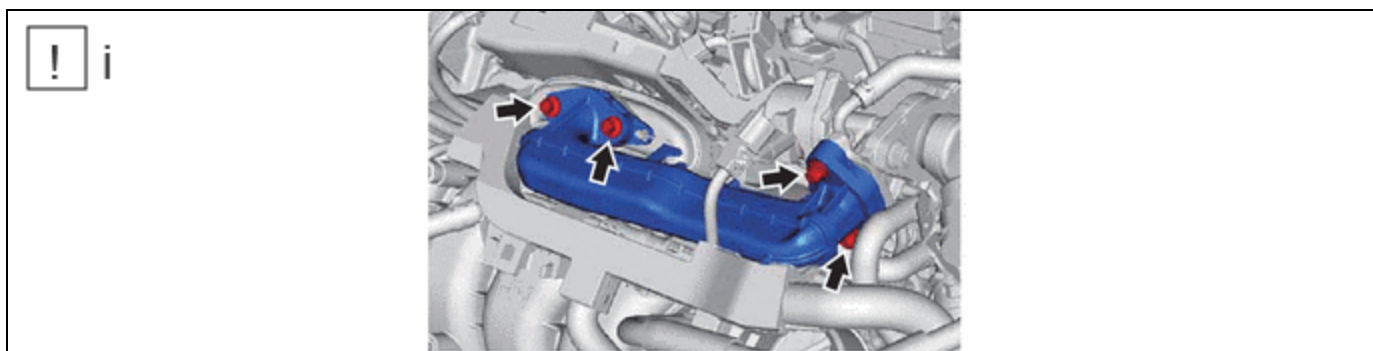
	PROCEDURE	PART NAME CODE			
1	LOOSEN NO. 1 EGR PIPE SUB-ASSEMBLY	25601	INFO	-	-

PROCEDURE		PART NAME CODE			
2	LOOSEN EGR VALVE ASSEMBLY	25620	INFO	-	-
3	NO. 1 EGR COOLER GASKET	25685	INFO	-	-
4	EGR VALVE GASKET	25627	INFO	-	-
5	EGR COOLER ASSEMBLY	25680	INFO	-	-
6	NO. 4 WATER BY-PASS HOSE	16281	INFO	-	-
7	NO. 3 WATER BY-PASS HOSE	16267	INFO	-	-
8	TIGHTEN EGR VALVE ASSEMBLY	25620	INFO	-	-
9	TIGHTEN NO. 1 EGR PIPE SUB-ASSEMBLY	25601	INFO	-	-
10	INVERTER WITH CONVERTER ASSEMBLY	G9200	-	-	-
11	ADD ENGINE COOLANT	-	-	INFO	-
12	INSPECT FOR COOLANT LEAK	-	INFO	-	-
13	INSPECT FOR EXHAUST GAS LEAK	-	-	-	INFO

*A	for Type A	*B	for Type B
	N*m (kgf*cm, ft.*lbf): Specified torque		Non-reusable part

PROCEDURE

1. LOOSEN NO. 1 EGR PIPE SUB-ASSEMBLY

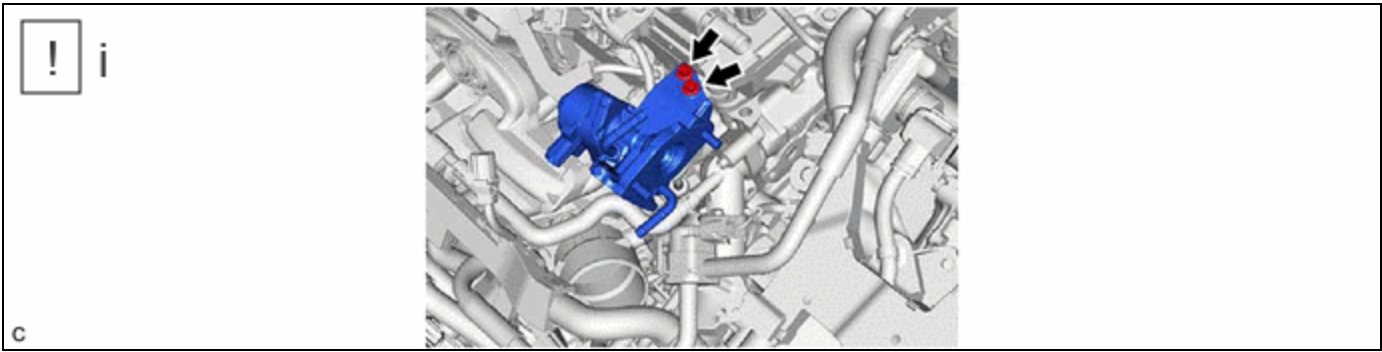


(1) Using an 8 mm socket wrench, loosen the 4 bolts of the No. 1 EGR pipe sub-assembly.

NOTICE:

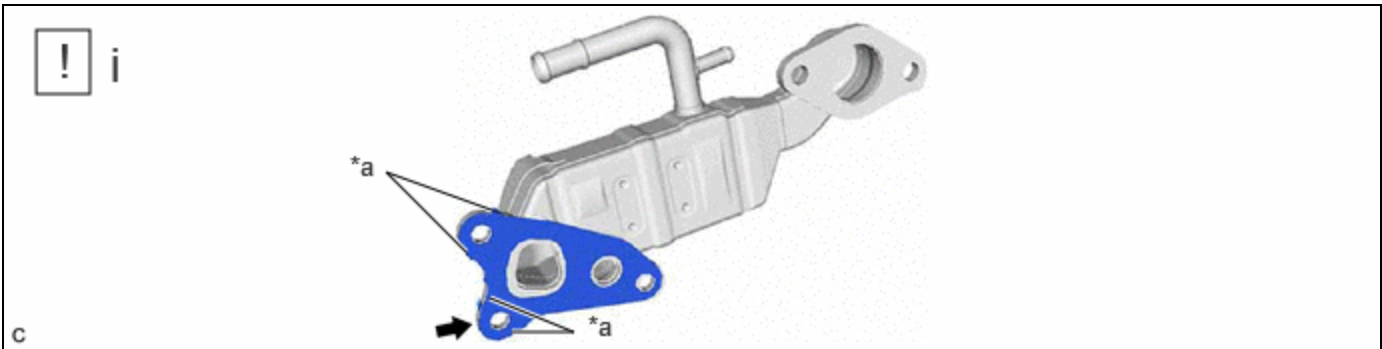
- As the bolts of the No. 1 EGR pipe sub-assembly are only to be loosened, it is not necessary to replace the EGR inlet gasket and EGR valve adapter gasket.
- If the No. 1 EGR pipe sub-assembly is removed, it is necessary to replace the EGR inlet gasket and EGR valve adapter gasket with new ones.

2. LOOSEN EGR VALVE ASSEMBLY



(1) Using an 8 mm socket wrench, loosen the 2 bolts EGR valve assembly.

3. INSTALL NO. 1 EGR COOLER GASKET



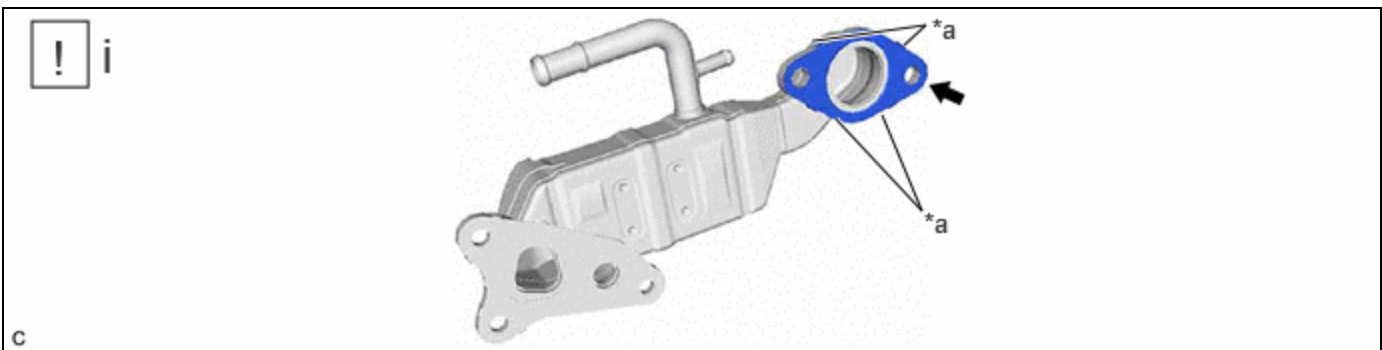
*a	Claw	-	-
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(1) Install a new No. 1 EGR cooler gasket to the EGR cooler assembly.

NOTICE:

Make sure that the claws of the No. 1 EGR cooler gasket are toward the EGR cooler assembly side.

4. INSTALL EGR VALVE GASKET



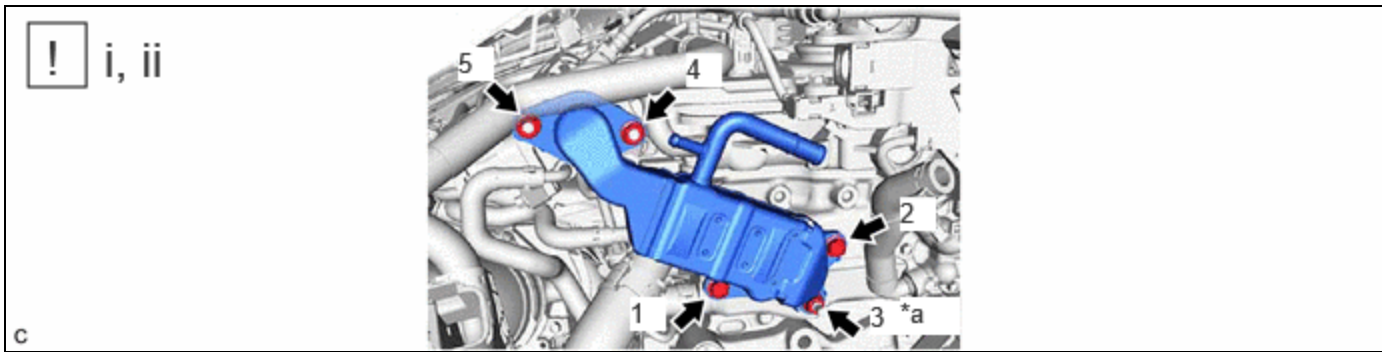
*a	Claw	-	-
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(1) Install a new EGR valve gasket to the EGR cooler assembly.

NOTICE:

Make sure that the claws of the EGR valve gasket are toward the EGR cooler assembly side.

5. INSTALL EGR COOLER ASSEMBLY



*a	Bolt or Nut	-	-
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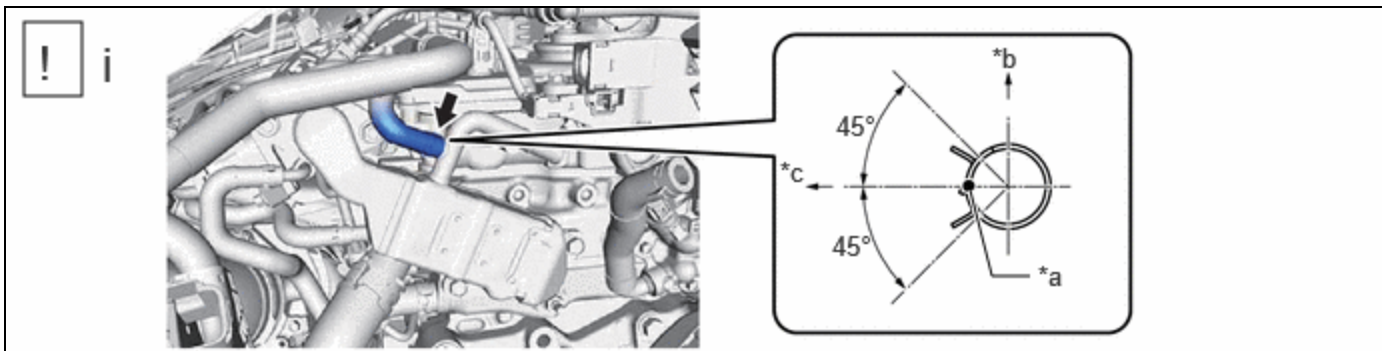
(1) Temporarily install the EGR cooler assembly to the cylinder head sub-assembly and EGR valve assembly with the bolts and nuts.

(2) Tighten the bolts and nuts in the order shown in the illustration.

Torque:

24 N·m {245 kgf·cm, 18 ft·lbf}

6. CONNECT NO. 4 WATER BY-PASS HOSE



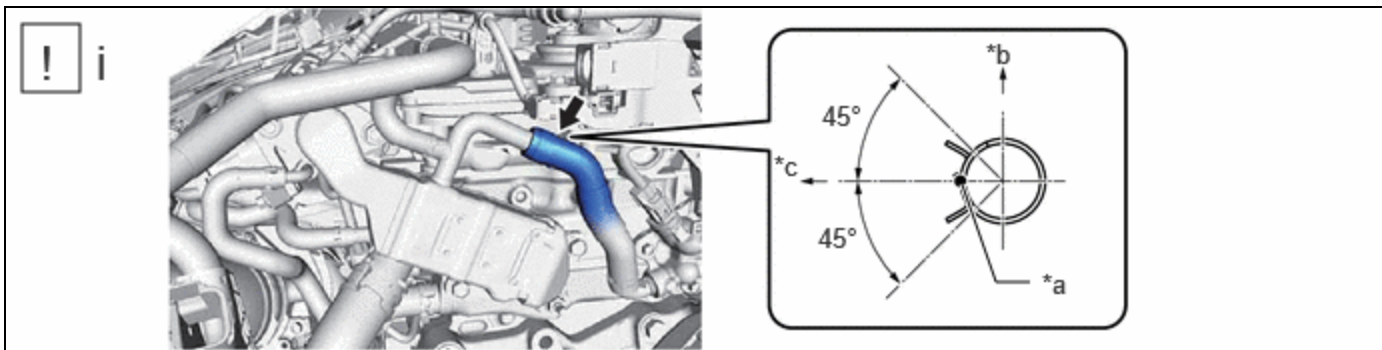
*a	Paint Mark	*b	Upper Side of Vehicle
*c	Left Side of Vehicle	-	-

(1) Connect the No. 4 water by-pass hose to the EGR valve assembly and slide the clip to secure it.

HINT:

Engage the clip within the area shown in the illustration.

7. CONNECT NO. 3 WATER BY-PASS HOSE

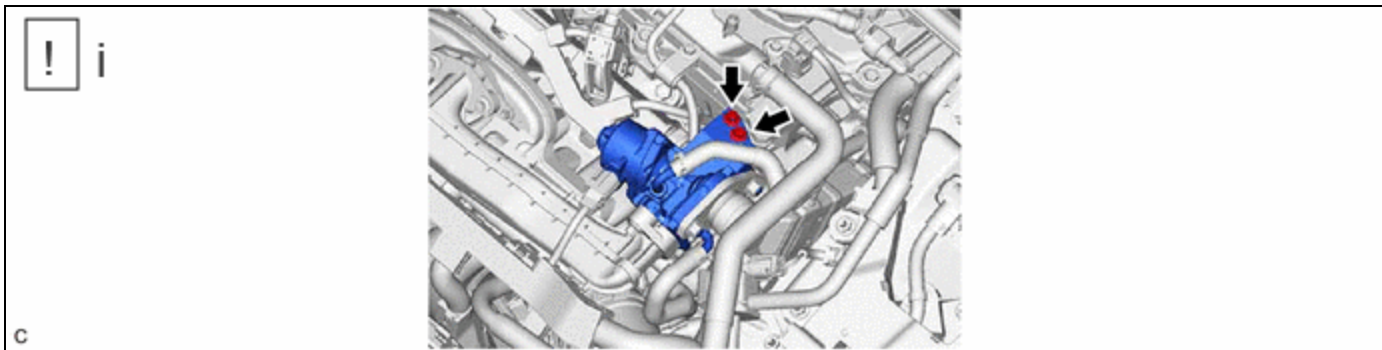


*a	Paint Mark	*b	Upper Side of Vehicle
*c	Left Side of Vehicle	-	-

(1) Connect the No. 3 water by-pass hose to the EGR valve assembly and slide the clip to secure it.

HINT:

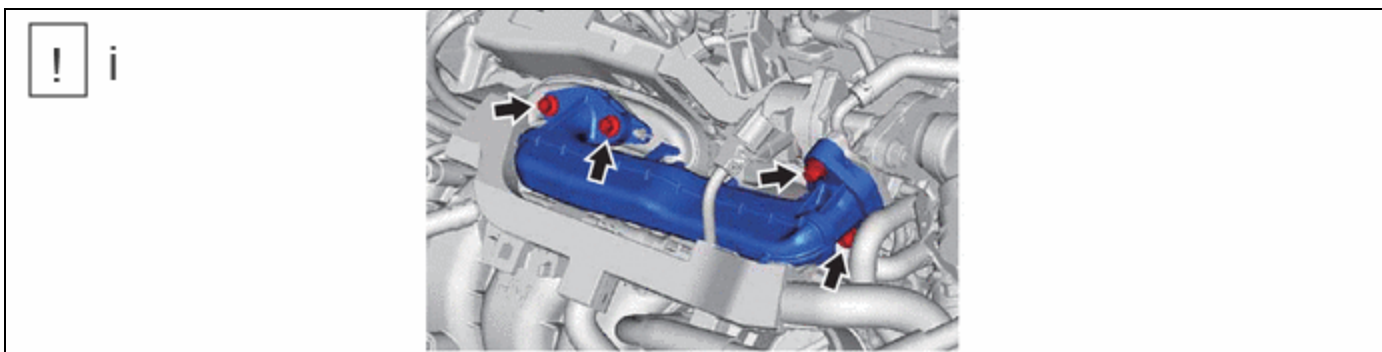
Engage the clip within the area shown in the illustration.

8. TIGHTEN EGR VALVE ASSEMBLY

(1) Using an 8 mm socket wrench, tighten the 2 bolts of the EGR valve assembly.

Torque:

10 N·m {102 kgf·cm, 7 ft·lbf}

9. TIGHTEN NO. 1 EGR PIPE SUB-ASSEMBLY

(1) Using an 8 mm socket wrench, tighten the 4 bolts of the No. 1 EGR pipe sub-assembly.

Torque:

10 N·m {102 kgf·cm, 7 ft·lbf}

10. INSTALL INVERTER WITH CONVERTER ASSEMBLY

- for HEV Model:

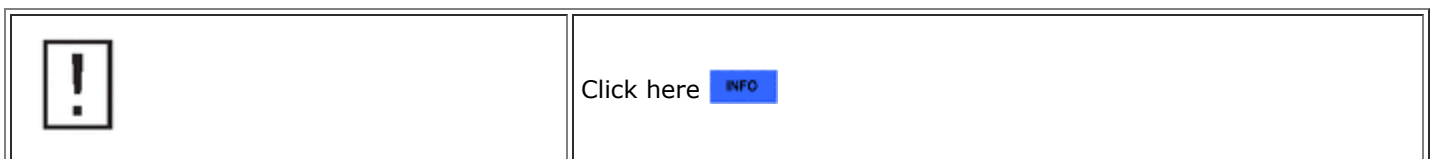
Click here [INFO](#)

- for PHEV Model:

Click here [INFO](#)

11. ADD ENGINE COOLANT (for Engine)

Click here [INFO](#)

12. INSPECT FOR COOLANT LEAK (for Engine)

13. INSPECT FOR EXHAUST GAS LEAK

(a) If gas is leaking, tighten the areas necessary to stop the leak. Replace damaged parts as necessary.

HINT:

Perform "Inspection After Repairs" after repairing or replacing the exhaust system.

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