

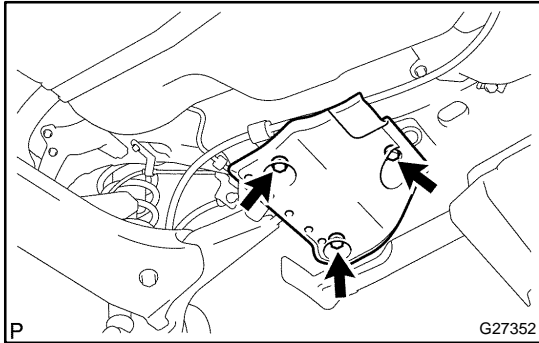
# REAR AXLE BEAM ASSY REPLACEMENT

27017-01

HINT:

COMPONENTS: See page 27-2.

## 1. REMOVE REAR WHEEL



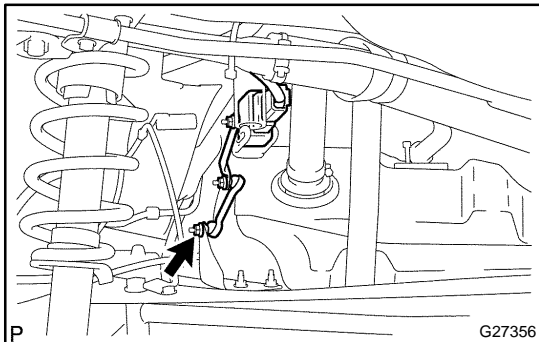
## 2. REMOVE FLOOR PANEL SIDE PLATE LH

- (a) Remove the 3 bolts and the floor panel side plate.

## 3. REMOVE FLOOR PANEL SIDE PLATE RH

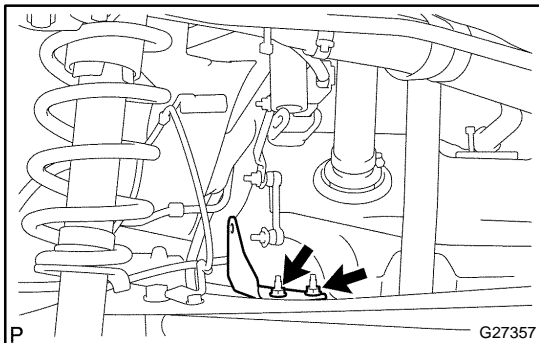
HINT:

Use the same procedures for the RH side and LH side.



## 4. SEPARATE HEIGHT CONTROL SENSOR SUB-ASSY REAR LH (W/ DISCHARGE HEAD LAMP)

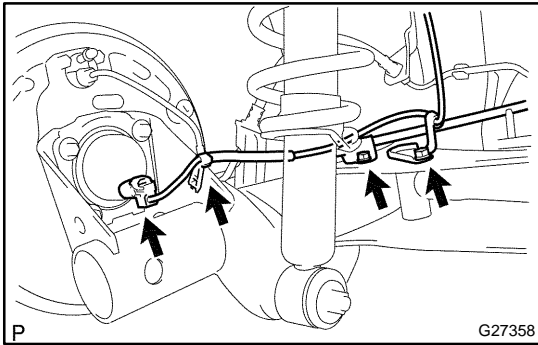
- (a) Remove the nut and separate the height control sensor sub-assy.



## 5. REMOVE SENSOR CONNECTING BRACKET REAR (W/ DISCHARGE HEAD LAMP)

- (a) Remove the 2 nuts and the sensor connecting bracket.

## 6. REMOVE REAR BRAKE DRUM SUB-ASSY

**7. SEPARATE SKID CONTROL SENSOR WIRE**

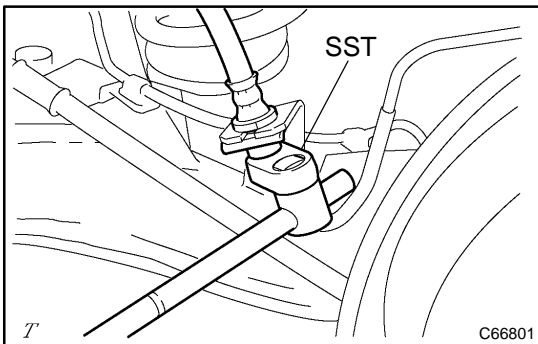
- (a) Remove the 2 bolts and clip, and separate the skid control sensor wire and parking brake cable from the rear axle beam.

**NOTICE:**

- Ensure no foreign matter is on the end of the skid control sensor wire.
- Ensure that the skid control sensor wire is separated from the rear axle beam.

**HINT:**

Use the same procedures for the RH side and LH side.

**8. REMOVE REAR AXLE BEAM DAMPER (SEE PAGE 27-16)****9. REMOVE STABILIZER BAR REAR (SEE PAGE 27-16)****10. SEPARATE REAR BRAKE TUBE NO.4**

- (a) Separate the rear brake tube from the flexible hose using SST.

SST 09023-00100

**NOTICE:**

**Do not damage the rear brake tube or flexible hose.**

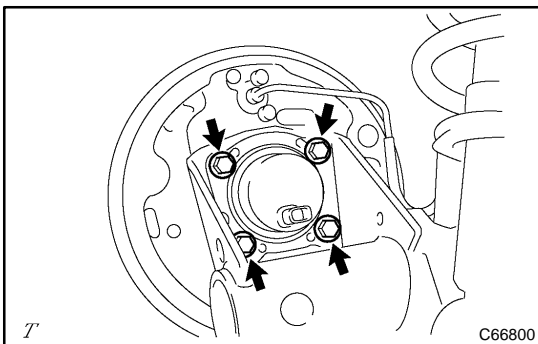
- (b) Remove the clip.

**11. SEPARATE REAR BRAKE TUBE NO.3**

SST 09023-00100

**HINT:**

Use the same procedures for the RH side and LH side.

**12. REMOVE REAR AXLE HUB & BEARING ASSY LH**

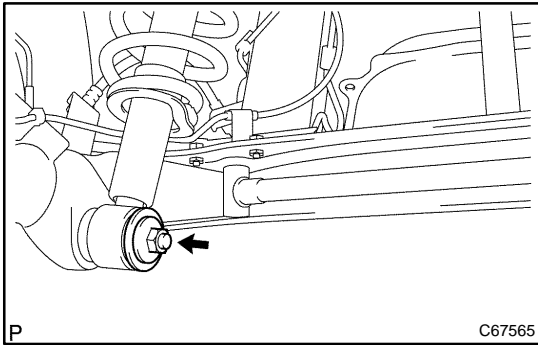
- (a) Remove the 4 bolts. Remove the axle hub & bearing assy and parking brake plate assy from the rear axle beam.

**NOTICE:**

- Do not twist the parking brake cable.
- Use rope, etc. to suspend the parking brake plate assy.

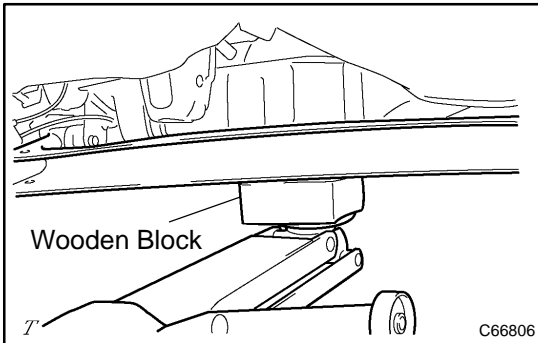
**13. REMOVE REAR AXLE HUB & BEARING ASSY RH****HINT:**

Use the same procedures for the RH side and LH side.



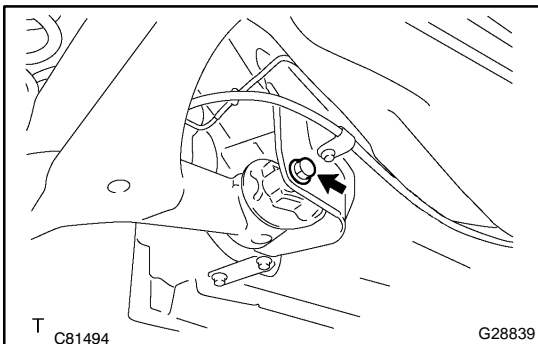
#### 14. SEPARATE REAR SHOCK ABSORBER WITH COIL SPRING

- (a) Remove the 2 nuts from the left- and right-hand sides. Remove the rear shock absorber with coil spring (lower side) from the rear axle beam.



#### 15. REMOVE REAR AXLE BEAM ASSY

- (a) Support the rear axle beam with a jack. Insert a wooden block between the jack and the center of the rear axle beam to prevent damage.



- (b) Remove the 2 bolts and 2 nuts from the left- and right-hand sides.

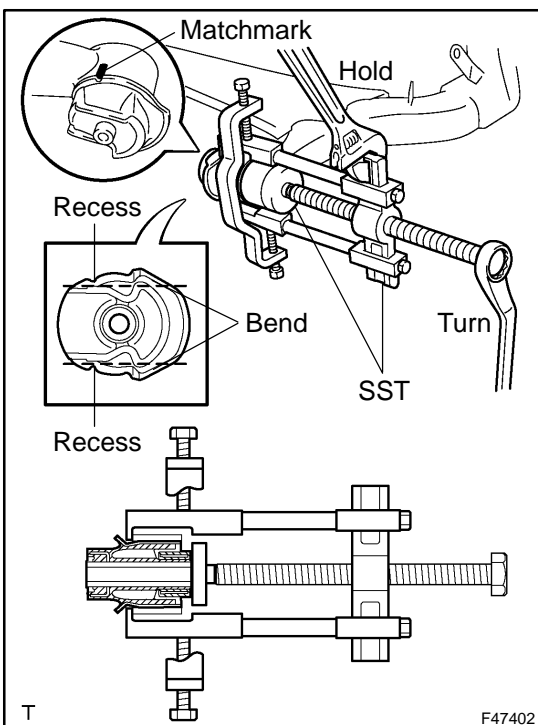
#### NOTICE:

**Keep the nut from rotating when removing the bolt.**

- (c) Remove the rear axle beam by slowly lowering the jack.

#### NOTICE:

**Ensure that the skid control sensor wire is completely separated from the rear axle beam.**



#### 16. REMOVE REAR AXLE CARRIER BUSH LH

- (a) Place a matchmark on the rear axle beam after aligning it with the bush recess.
- (b) Make 2 bends in the rim of the bush using a chisel and hammer.
- (c) Remove the bush from the rear axle beam using SST.  
SST 09950-40011 (09951-04020, 09952-04010, 09953-04030, 09954-04020, 09955-04051, 09957-04010, 09958-04011), 09950-60010 (09951-00630)

#### NOTICE:

- Do not erase the matchmark on the rear axle beam when removing the bush.
- Apply chassis black if the rear axle beam is scratched.

**17. REMOVE REAR AXLE CARRIER BUSH RH**

SST 09950-40011 (09951-04020, 09952-04010, 09953-04030, 09954-04020, 09955-04051, 09957-04010, 09958-04011), 09950-60010 (09951-00630)

**HINT:**

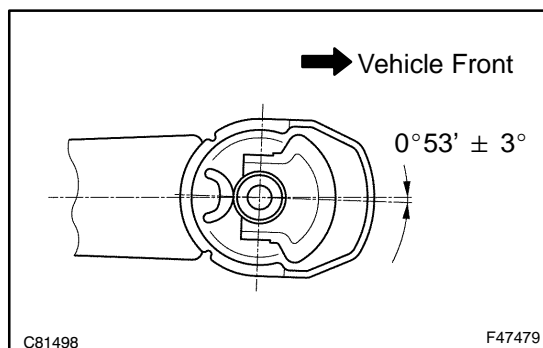
Use the same procedures for the RH side and LH side.

**18. INSTALL REAR AXLE CARRIER BUSH LH**

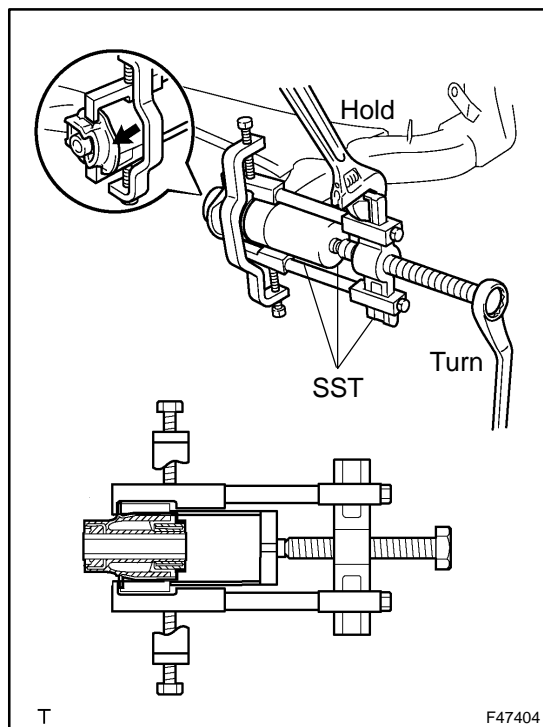
- (a) Temporarily install a new bush recess by aligning it with the matchmark on the rear axle beam (when replacing bush only).

**NOTICE:**

**Install the bush in the same direction as before it was removed.**



- (b) Temporarily install a new bush as shown in the illustration (when replacing the rear axle beam).



- (c) Install the bush to the rear axle beam using SST.

SST 09950-40011 (09951-04020, 09952-04010, 09953-04030, 09954-04020, 09955-04051, 09957-04010, 09958-04011), 09950-60010 (09951-00620), 09710-04101

**NOTICE:**

- Hang the claw of SST to the bush deeply and firmly.
- Do not damage the rubber sections indicated by the arrow in the illustration when installing the bush.

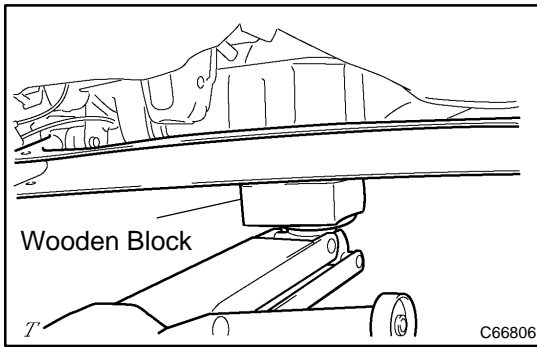
**19. INSTALL REAR AXLE CARRIER BUSH RH**

SST 09950-40011 (09951-04020, 09952-04010, 09953-04030, 09954-04020, 09955-04051, 09957-04010, 09958-04011), 09950-60010 (09951-00620), 09710-04101

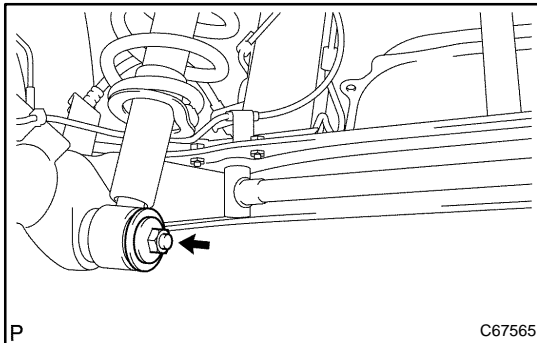
**HINT:**

Use the same procedures for the RH side and LH side.

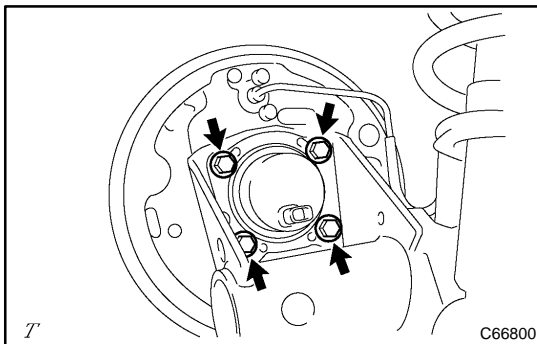
2004 Prius - Preliminary Release (RM1075U)



- 20. TEMPORARILY TIGHTEN REAR AXLE BEAM ASSY**
- Support the rear axle beam with a jack. Insert a wooden block between the jack and the center of the rear axle beam to prevent damage.
  - Slowly raise the jack to install the rear axle beam on the vehicle. Insert the 2 bolts from inside the vehicle and temporarily tighten them with the 2 nuts (one nut and bolt each for both the left- and right-hand sides).



- 21. TEMPORARILY TIGHTEN REAR SHOCK ABSORBER WITH COIL SPRING**
- Install the left- and right-hand side rear shock absorber with coil spring (lower side) to the rear axle beam. Temporarily tighten the nuts.

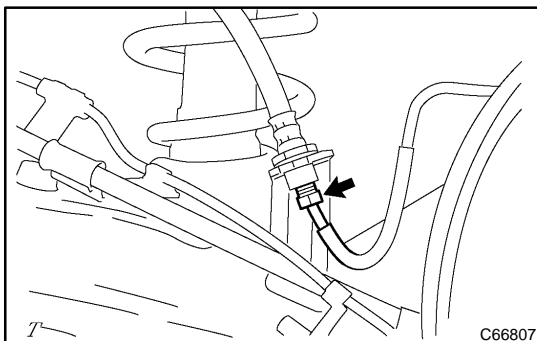


- 22. INSTALL REAR AXLE HUB & BEARING ASSY LH**
- Install the parking brake plate assy and the axle hub & bearing assy to the rear axle beam using the 4 bolts.  
**Torque: 61 N·m (622 kgf·cm, 45 ft·lbf)**

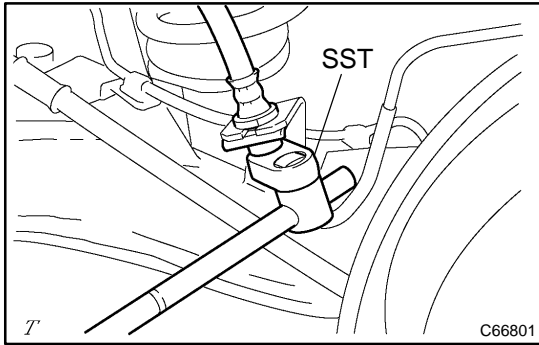
**23. INSTALL REAR AXLE HUB & BEARING ASSY RH**

**HINT:**

Use the same procedures for the RH side and LH side.



- 24. INSTALL REAR BRAKE TUBE NO.4**
- Temporarily tighten the rear brake tube and flexible hose.
- NOTICE:**
- Do not damage the rear brake tube or flexible hose.
  - Replace the rear brake tube and flexible hose with new parts if they are damaged.
- Install the rear brake tube to the rear axle beam and secure it with the clip.



- (c) Fully tighten the rear brake tube using SST.  
 SST 09023-00100  
**Torque: 15 N·m (155 kgf·cm, 11 ft·lbf)**

### 25. INSTALL REAR BRAKE TUBE NO.3

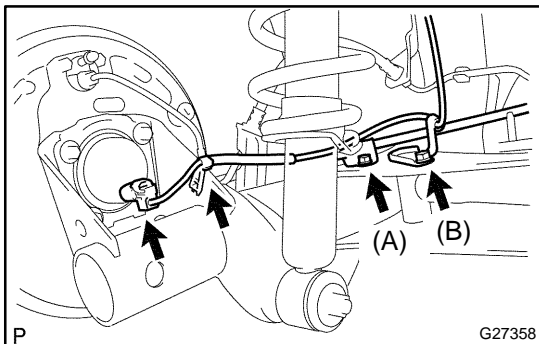
SST 09023-00100

#### HINT:

Use the same procedures for the RH side and LH side.

### 26. INSTALL STABILIZER BAR REAR (SEE PAGE 27-16)

### 27. INSTALL REAR AXLE BEAM DAMPER (SEE PAGE 27-16)



### 28. INSTALL SKID CONTROL SENSOR WIRE

- (a) Install the skid control sensor wire and parking brake cable to the rear axle beam using the 2 bolts and clip.

**Torque:**

**Bolt A: 5.4 N·m (55 kgf·cm, 48 in·lbf)**

**Bolt B: 5.0 N·m (51 kgf·cm, 44 in·lbf)**

#### NOTICE:

**Do not twist the skid control sensor wire while installing.**

#### HINT:

Use the same procedures for the RH side and LH side.

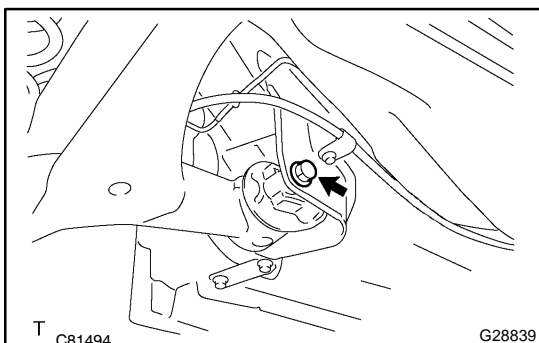
### 29. INSTALL REAR BRAKE DRUM SUB-ASSY

### 30. STABILIZE SUSPENSION

- (a) Install the rear wheel.

**Torque: 103 N·m (1,050 kgf·cm, 76 ft·lbf)**

- (b) After jacking down the vehicle, bounce the vehicle up and down to stabilize the rear suspension.



### 31. FULLY TIGHTEN REAR AXLE BEAM ASSY

- (a) Hold the nut and rotate the bolt to fully tighten the rear axle beam on the LH side.

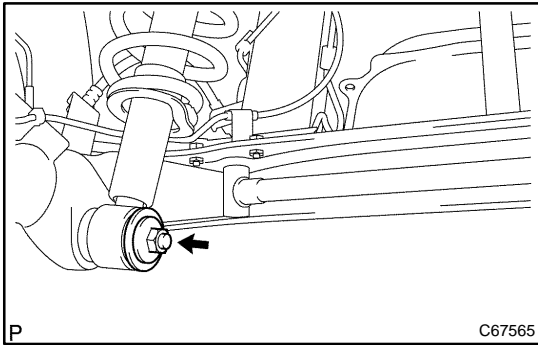
**Torque: 85 N·m (867 kgf·cm, 63 ft·lbf)**

#### NOTICE:

**Ensure the vehicle is lowered to the ground.**

#### HINT:

Use the same procedures for the RH side and LH side.



### 32. FULLY TIGHTEN REAR SHOCK ABSORBER WITH COIL SPRING

- (a) Install the rear shock absorber with coil spring (lower side) and tighten the nut.

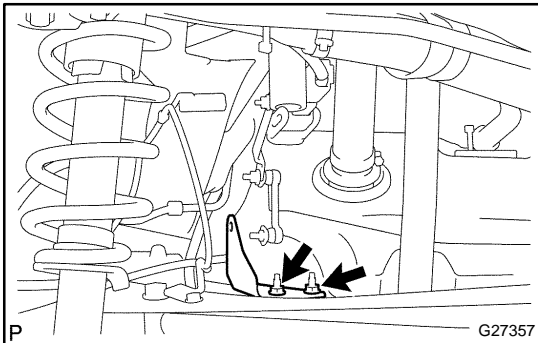
**Torque: 80 N·m (816 kgf·cm, 59 ft·lbf)**

#### NOTICE:

Ensure the vehicle is lowered to the ground.

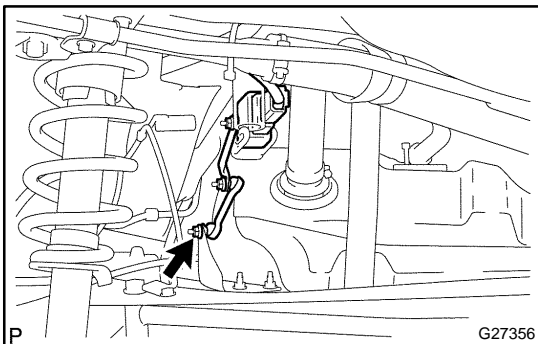
#### HINT:

Use the same procedures for the RH side and LH side.



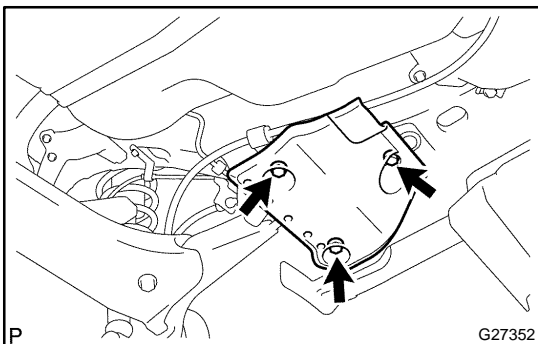
### 33. INSTALL SENSOR CONNECTING BRACKET REAR (W/ DISCHARGE HEAD LAMP)

- (a) Install the sensor connecting bracket using the 2 nuts.



### 34. INSTALL HEIGHT CONTROL SENSOR SUB-ASSY REAR LH (W/ DISCHARGE HEAD LAMP)

- (a) Install the height control sensor sub-assy using the nut.



### 35. INSTALL FLOOR PANEL SIDE PLATE LH

- (a) Install the floor panel side plate using the 3 bolts.

### 36. INSTALL FLOOR PANEL SIDE PLATE RH

#### HINT:

Use the same procedures for the RH side and LH side.

### 37. BLEED BRAKE LINE (SEE PAGE 32-4)

### 38. INSPECT BRAKE FLUID

### 39. INSPECT REAR WHEEL ALIGNMENT (SEE PAGE 27-3)

### 40. PERFORM INITIALIZATION (W/ DISCHARGE HEAD LAMP) (SEE PAGE 05-1675)

### 41. ADJUST HEADLIGHT AIM ONLY (W/ DISCHARGE HEAD LAMP) (SEE PAGE 65-16)

### 42. CHECK ABS SPEED SENSOR SIGNAL (SEE PAGE 05-961)