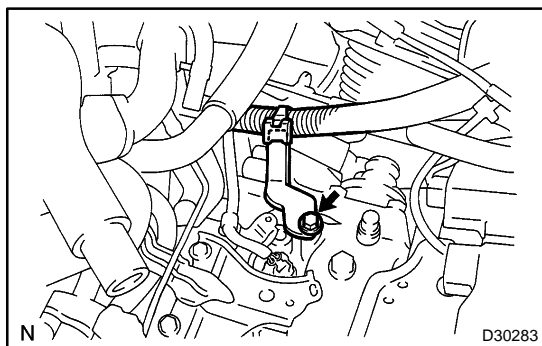


## REPLACEMENT

1. REMOVE FRONT WHEELS
2. REMOVE ENGINE UNDER COVER LH
3. REMOVE ENGINE UNDER COVER RH
4. DRAIN TRANSAXLE OIL
  - (a) Remove the filler plug and the gasket.
  - (b) Remove the drain plug, the gasket and the manual transaxle oil.
  - (c) Install a new gasket and the drain plug.

**Torque: 39 N·m (400 kgf·cm, 29 ft·lbf)**
5. REMOVE HOOD SUB-ASSY
6. REMOVE COWL PANEL SUB-ASSY (See page 26-10)
7. REMOVE CYLINDER HEAD COVER NO.2
8. REMOVE AIR CLEANER ASSY
9. REMOVE BATTERY

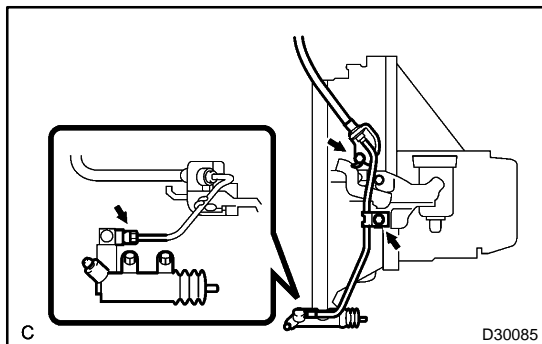


### 10. DISCONNECT WIRE HARNESS

- (a) Remove the bolt and disconnect the wire harness clamp.

### 11. DISCONNECT CONNECTOR

- (a) Disconnect the back-up lamp switch connector.



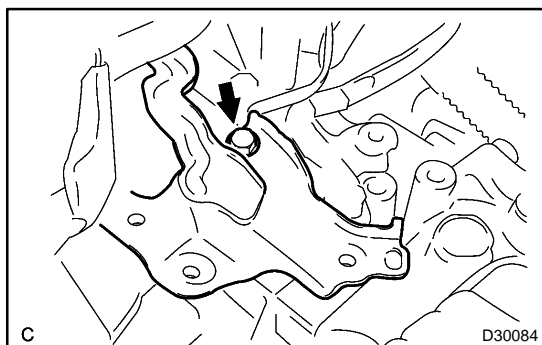
### 12. DISCONNECT CLUTCH RELEASE CYLINDER TO FLEXIBLE HOSE TUBE

- (a) Using SST, disconnect the flexible hose tube.  
SST 09023-00100

#### HINT:

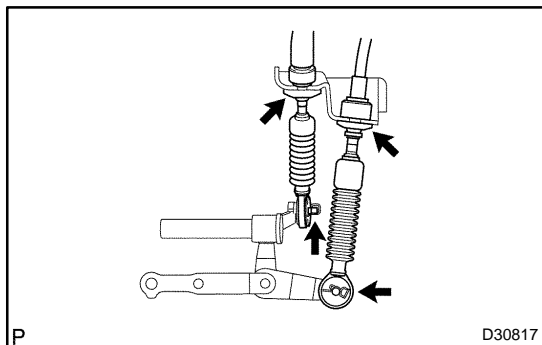
Use a container to catch the fluid.

- (b) Remove the 2 bolts and separate the flexible hose tube.



### 13. REMOVE AIR CLEANER BRACKET

- (a) Remove the bolt and the air cleaner bracket.



#### 14. DISCONNECT TRANSMISSION CONTROL CABLE ASSY

- Remove the 2 clips and the 2 washers, and disconnect the 2 cables from the transaxle.
- Remove the 2 clips, and disconnect the 2 cables from the control cable bracket.

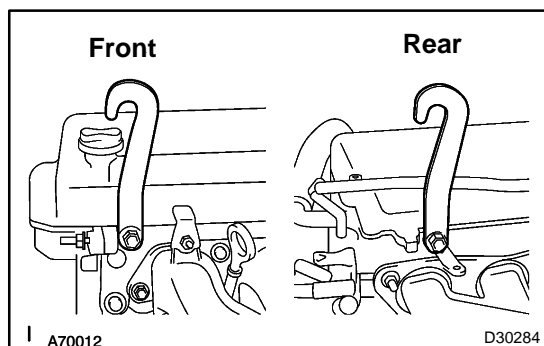
#### 15. REMOVE FRONT DRIVE SHAFT ASSY LH (See page 30-6)

SST 09520-01010, 09520-24010 (09520-32040)

#### 16. REMOVE FRONT DRIVE SHAFT ASSY RH (See page 30-6)

#### 17. REMOVE FLOOR PANEL BRACE FRONT (See page 15-3)

#### 18. REMOVE EXHAUST PIPE ASSY FRONT (See page 15-3)



#### 19. SUSPEND ENGINE ASSY

- Install the 2 hangers in the correct direction.
- Attach the engine chain hoist to the hangers.

#### CAUTION:

Do not attempt to hang the engine by hooking the chain to any other part.

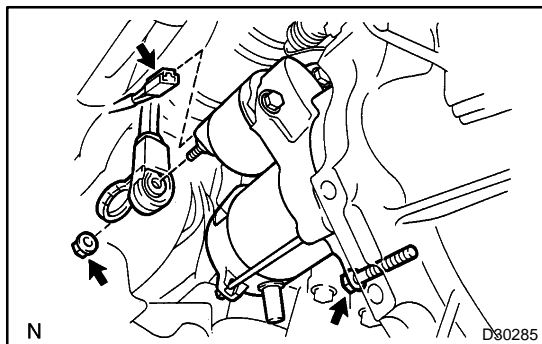
Parts No.:

Engine Hanger: 12281-21010

Bolt: 91642-81025

Torque: 40 N·m (408 kgf·cm, 29 ft·lbf)

#### 20. REMOVE FRONT SUSPENSION CROSSMEMBER SUB-ASSY(See page 51-20)

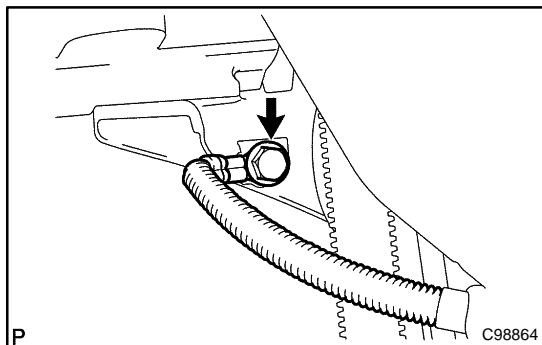


#### 21. REMOVE STARTER ASSY

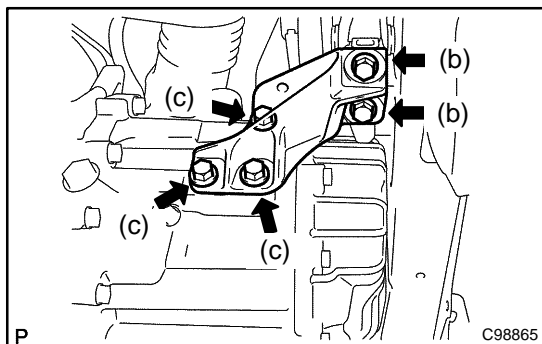
- Remove the flywheel housing side cover.
- Remove the nut and disconnect the starter wire.
- Disconnect the connector.
- Remove the 2 bolts and the starter assy.

#### 22. SUPPORT MANUAL TRANSAXLE ASSY

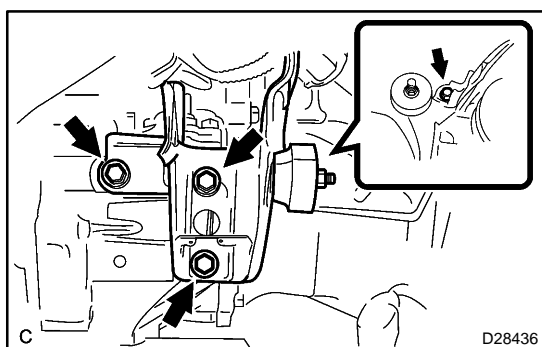
- Support the manual transaxle with a transmission jack.

**23. REMOVE ENGINE MOUNTING BRACKET LH**

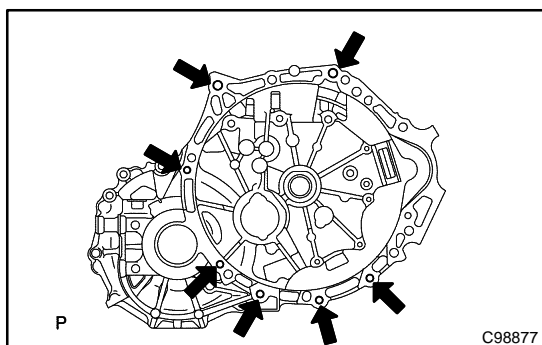
- (a) Remove the bolt, and disconnect the ground cable.



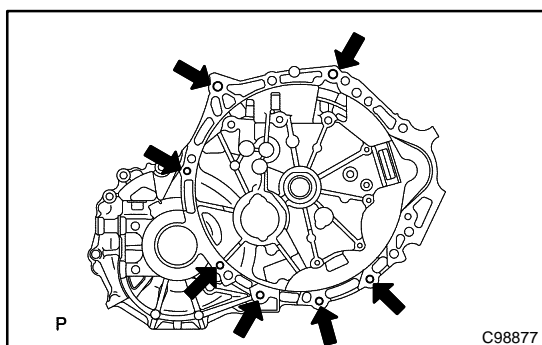
- (b) Remove the 2 bolts, and separate the engine mounting bracket LH from the engine mounting insulator LH.  
 (c) Remove the 3 bolts and the engine mounting bracket LH from the manual transaxle.

**24. REMOVE ENGINE MOUNTING BRACKET RR**

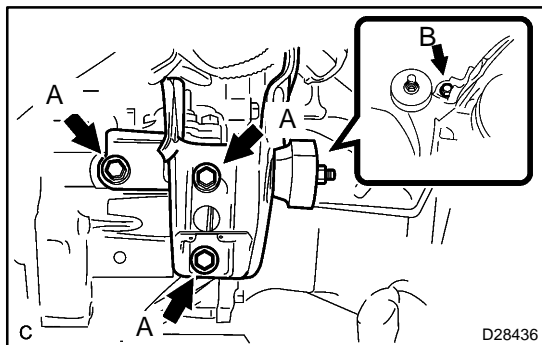
- (a) Remove the 4 bolts and the engine mounting bracket RR from the manual transaxle.

**25. REMOVE MANUAL TRANSAXLE ASSY**

- (a) Remove the 7 bolts and the manual transaxle from the engine.

**26. INSTALL MANUAL TRANSAXLE ASSY**

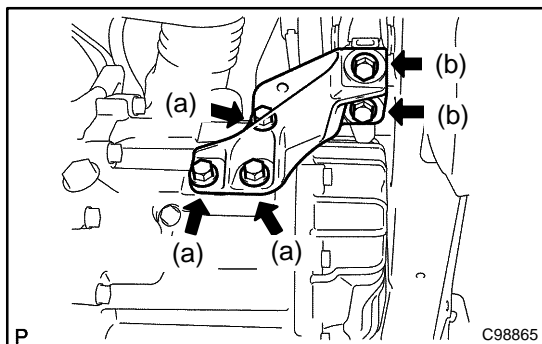
- (a) Align the input shaft with the clutch disc and install the manual transaxle on the engine.  
 (b) Install the 7 bolts.  
**Torque: 33 N·m (340 kgf·cm, 24 ft·lbf)**

**27. INSTALL ENGINE MOUNTING BRACKET RR**

- (a) Install the engine mounting bracket RR and the 4 bolts on the manual transaxle.

**Bolt A: Torque: 49 N·m (500 kgf·cm, 36 ft·lbf)**

**Bolt B: Torque: 18 N·m (180 kgf·cm, 13 ft·lbf)**

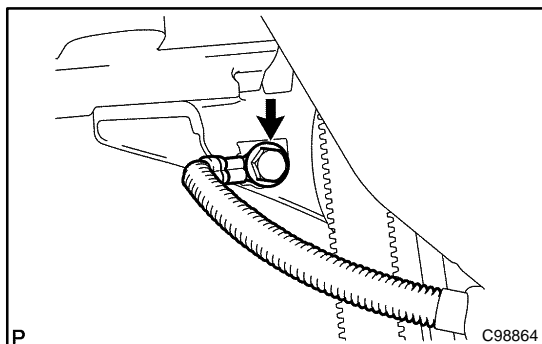
**28. INSTALL ENGINE MOUNTING BRACKET LH**

- (a) Install the engine mounting bracket LH on the manual transaxle with the 3 bolts.

**Torque: 64 N·m (653 kgf·cm, 47 ft·lbf)**

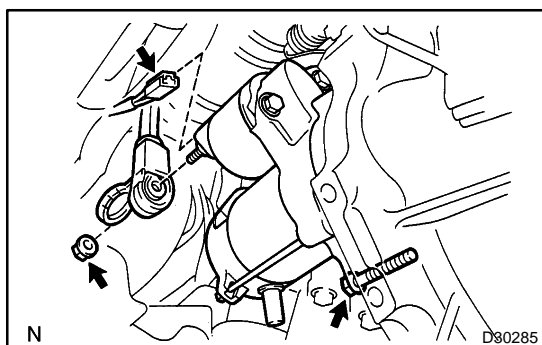
- (b) Install the engine mounting bracket LH on the engine mounting insulator with the 2 bolts.

**Torque: 49 N·m (500 kgf·cm, 36 ft·lbf)**



- (c) Install the ground cable on the engine mounting bracket with the bolt.

**Torque: 26 N·m (260 kgf·cm, 19 ft·lbf)**

**29. INSTALL STARTER ASSY**

- (a) Install the starter assy and the 2 bolts on the manual transaxle.

**Torque: 37 N·m (380 kgf·cm, 27 ft·lbf)**

- (b) Connect the starter connector.

- (c) Install the wire and the nut on starter assy.

**Torque: 9.8 N·m (100 kgf·cm, 87 in·lbf)**

- (d) Install the flywheel housing side cover.

**30. INSTALL FRONT SUSPENSION CROSSMEMBER SUB-ASSY (See page 51-20)**

SST 09670-00010

**31. INSTALL FRONT DRIVE SHAFT ASSY LH (See page 30-6)****32. INSTALL FRONT DRIVE SHAFT ASSY RH**

HINT:

Install the RH side by the same procedures as the LH side.

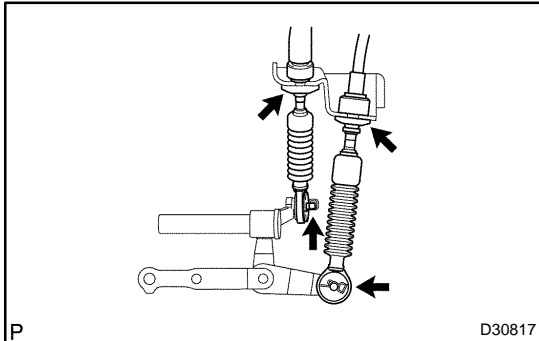
**33. INSTALL FRONT AXLE ASSY LH (See page 30-6)****34. INSTALL FRONT AXLE ASSY RH**

HINT:

Install the RH side by the same procedures as the LH side.

2004 SCION xB REPAIR MANUAL (RM1031U)

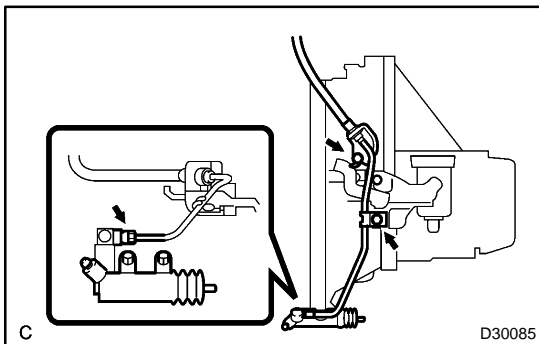
35. INSTALL EXHAUST PIPE ASSY FRONT (See page 15-3)  
 36. INSTALL FLOOR PANEL BRACE FRONT (See page 15-3)



37. CONNECT TRANSMISSION CONTROL CABLE ASSY  
 (a) Connect the 2 cable ends, and install the 2 washers and the 2 clips.  
 (b) Install 2 new clips on the control cable bracket.

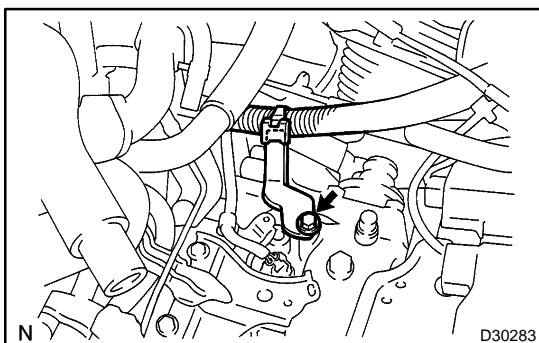


38. INSTALL AIR CLEANER BRACKET  
 (a) Install the air cleaner bracket with the bolt.  
**Torque: 19 N·m (195 kgf·cm, 14 ft·lbf)**



39. CONNECT CLUTCH RELEASE CYLINDER TO FLEXIBLE HOSE TUBE  
 (a) Using SST, connect the flexible hose tube.  
 SST 09023-00100  
**Torque: 15 N·m (155 kgf·cm, 11 ft·lbf)**  
 (b) Connect the flexible hose tube with the 2 bolts.  
**Torque: 19 N·m (195 kgf·cm, 14 ft·lbf)**

40. CONNECT CONNECTOR  
 (a) Connect the back-up lamp switch connector.



41. CONNECT WIRE HARNESS  
 (a) Connect the wire harness clamp with the bolt.  
**Torque: 5.0 N·m (51 kgf·cm, 44 in·lbf)**

42. INSTALL BATTERY
43. INSTALL AIR CLEANER ASSY
44. INSTALL CYLINDER HEAD COVER NO.2  
Torque: 7.0 N·m (71 kgf·cm, 62 in·lbf)
45. INSTALL COWL PANEL SUB-ASSY (See page 26-10)
46. INSTALL HOOD SUB-ASSY (See page 75-1)
47. INSPECT HOOD SUB-ASSY (See page 75-1)
48. ADJUST HOOD SUB-ASSY (See page 75-1)
49. INSTALL FRONT WHEELS  
Torque: 103 N·m (1,050 kgf·cm, 76 ft·lbf)
50. ADD TRANSAXLE OIL (See page 41-3)
51. INSPECT AND ADJUST TRANSAXLE OIL (See page 41-2)
52. INSTALL ENGINE UNDER COVER RH
53. INSTALL ENGINE UNDER COVER LH
54. INSPECT FRONT WHEEL ALIGNMENT (See page 26-7)
55. CHECK ABS SPEED SENSOR SIGNAL (See page 05-269)
56. CHECK FOR EXHAUST GAS LEAKS