

Part Number: PT938-48141-XX

Kit Contents

Item #	Quantity Req'd.	Description
1	1	Molding, LH Front Door
2	1	Molding, LH Rear Door
3	1	Molding, RH Front Door
4	1	Molding, RH Rear Door

Hardware Bag Contents

Item #	Quantity Req'd.	Description
1		
2		

Additional Items Required For Installation

Item #	Quantity Req'd.	Description
1		
2		

Conflicts

None

Recommended Tools

Personal & Vehicle Protection	Notes
Safety Glasses	
Vehicle Protection	Seat & Floor Covers
Special Tools	Notes
Roller	Hard Rubber Hand Roller, 1" to 3" wide
Installation Tools	Notes
Flexible Scale or Tape Measure	
Masking Tape	1" wide
Clean Lint-free Cloths	
Non intrusive Infrared Temp Probe/Gun	
Non-marring straight edge	
Heat Gun (if required to warm surfaces)	
Special Chemicals	Notes
Cleaner	3M™ Prep Solvent-70

General Applicability

Body Side Molding can be installed on all Highlander Gas/Hybrid models.

Recommended Sequence of Application

Item #	Accessory
1	Body Side Molding
2	Door Edge Guard

*Mandatory

Vehicle Service Parts (may be required for reassembly)

Item #	Quantity Req'd.	Description

Legend



STOP: Damage to the vehicle may occur. Do not proceed until process has been complied with.



OPERATOR SAFETY: Use caution to avoid risk of injury.



CAUTION: A process that must be carefully observed in order to reduce the risk of damage to the accessory/vehicle and to ensure a quality installation.



TOOLS & EQUIPMENT: Used in Figures calls out the specific tools and equipment recommended for this process.



REVISION MARK: This mark highlights a change in installation with respect to previous issue.



SAFETY TORQUE: This mark indicates that torque is related to safety.

Care must be taken when installing this accessory to ensure damage does not occur to the vehicle. The installation of this accessory should follow approved guidelines to ensure a quality installation.

These guidelines can be found in the "Accessory Installation Practices" document.

This document covers such items as:

- Vehicle Protection (use of covers and blankets, cleaning chemicals, etc.).
- Safety (eye protection, rechecking torque procedure, etc.).
- Vehicle Disassembly/Reassembly (panel removal, part storage, etc.).
- Electrical Component Disassembly/Reassembly (battery disconnection, connector removal, etc.).

Please see your Toyota dealer for a copy of this document.

1. Prepare the Vehicle.



- (a) Before working on the vehicle, protect the seats and carpets with covers.



- (b) The work area, body side moldings, and vehicle door surface temperature must be at least 60°F.

- (c) Saturate a clean lint-free cloth with 3M™ Prep Solvent-70 and clean the shaded areas of each door (Fig. 1-1).



NOTE: When cleaning with 3M™ Prep Solvent-70, follow the manufacturer's directions. Do not allow cleaner to air dry.

- (d) Wipe the cleaned surfaces with a clean, dry, lint-free cloth.



NOTE: Once cleaned, do not contaminate this surface by touching it with your bare hands.

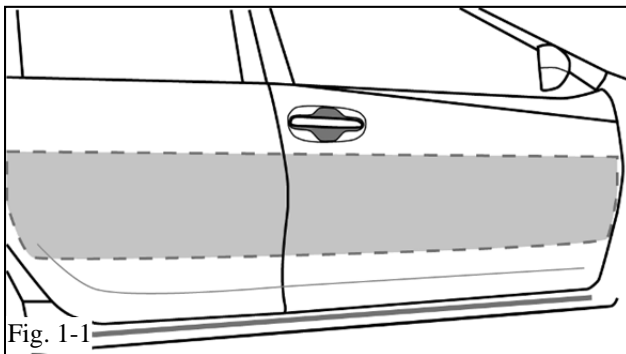
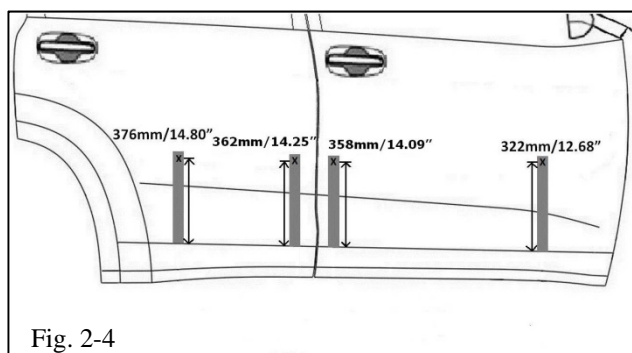
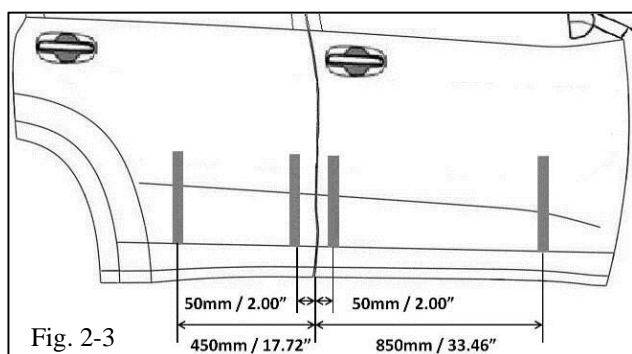
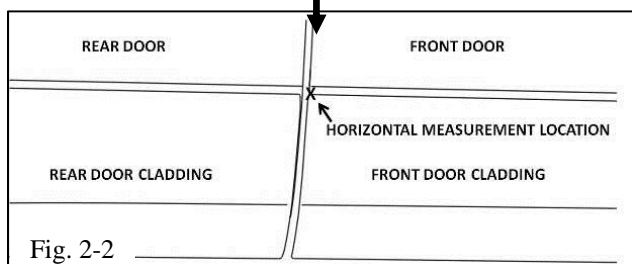
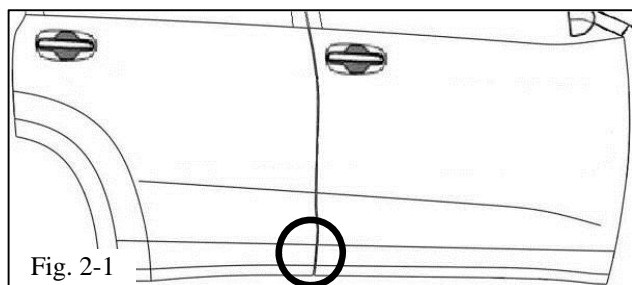


Fig. 1-1



2. Apply Placement Tape.

- ⚠ (a) Locate the top most point on the rear edge of the front door cladding (Fig. 2-1 & Fig. 2-2). All horizontal measurements will be provided from this location.

- ⚠ (b) Measure 50mm forward and place a vertical piece of tape on the front door approximately 360mm long (Fig. 2-3).

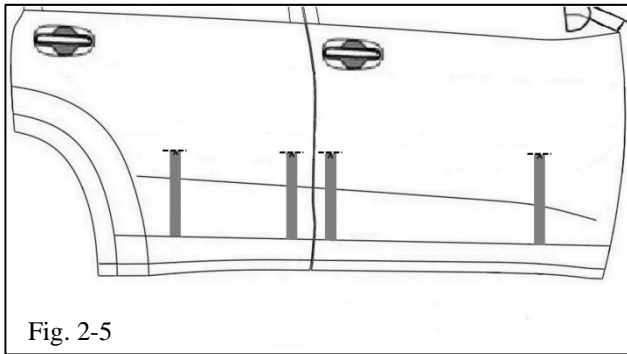
- ⚠ (c) Measure 850mm forward and place a vertical piece of tape on the front door approximately 330mm long (Fig. 2-3).

- ⚠ (d) Measure 50mm rearward and place a vertical piece of tape on the rear door approximately 370mm long (Fig. 2-3).

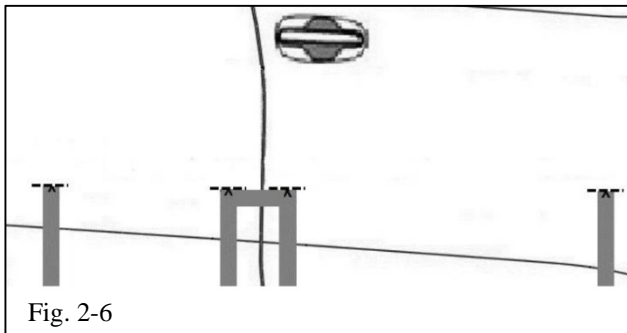
- ⚠ (e) Measure 450mm rearward and place a 380mm vertical piece of tape on the rear door (Fig 2-3).

- (f) Mark the vertical pieces of tape (Fig. 2-4). Measurements are taken from the top most edge of the door cladding.

- ⚠ **NOTE:** The measuring device should be held vertically, not pressing against the contour of the door sheet metal.



- (g) Trim any length of vertical tape protruding above the marks made in step (c) as shown in (Fig 2-5).



- (h) Apply a 100mm piece of tape horizontally, bridging the front and rear door gap and overlapping the two vertical pieces of tape closest to the door gap (Fig 2-6). Ensure that the top edge of the tape is aligned with the marks made in Step 2(f).



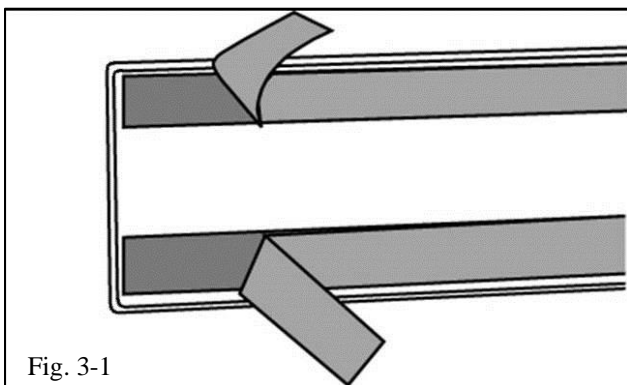
- (i) Mark the piece of tape applied in Step 2(h) with a straight vertical line 7.0mm forward from the door edge of the front door.



- (j) Mark an additional vertical line on the same piece of tape 6.6mm rearward from the rear door edge.

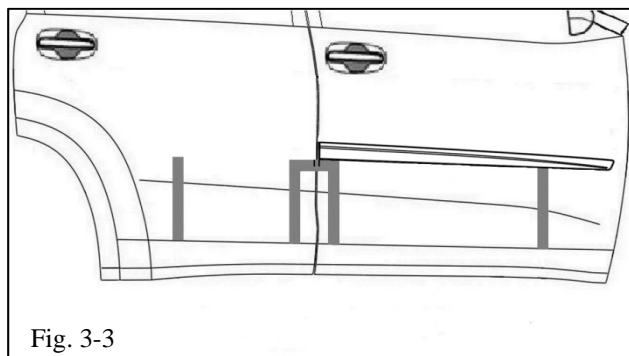
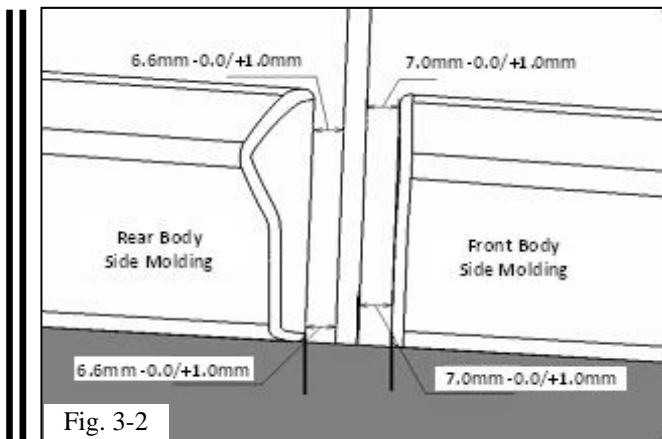


CAUTION: Ensure the 7.0mm and 6.6mm minimum distances are carefully measured.



3. Install the Front Body Side Molding.

- (a) The inside of each of the four moldings is identified as to their correct position on the vehicle. While carefully holding the molding by its edges, fold the tape liner tabs on the horizontal 3M tape lengths upwards (top piece) and downwards (bottom piece) (Fig. 3-1) such that the tabs are accessible when the molding is in the install position.



(b) Start with either front door using the appropriate front (longer) molding.

⚠ (c) The opening between the doors should look like Fig. 3-2.

⚠ **NOTE:** Tolerance for flushness in the vertical direction of the front and rear molding in relation to each other is 0.0mm +/-1.0mm (Fig. 3-2).

⚠ (d) Align the rear edge of the front molding with the vertical mark on the horizontal piece of tape located 7.0mm forward of the front door edge (Fig. 3-2).

(e) Align the bottom of the molding flush with the top edges of the vertical tape pieces (Fig. 3-3).

(f) Re-position the part as required before sticking the tape to the door.

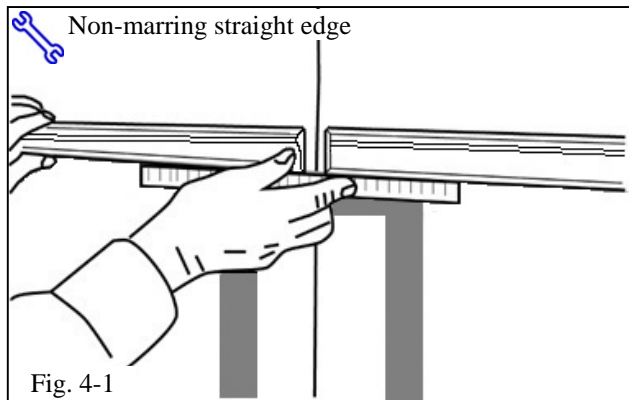
⚠ (g) Once properly aligned, carefully expose the 3M tape by peeling away the liner beginning with the tape at the rear of the molding and working forward.


(h) Repeat Step 3 for the front body side molding on the other side of the vehicle.

4. Install the Rear Body Side Molding.


(a) Start with either rear door using the appropriate rear (shorter) molding.

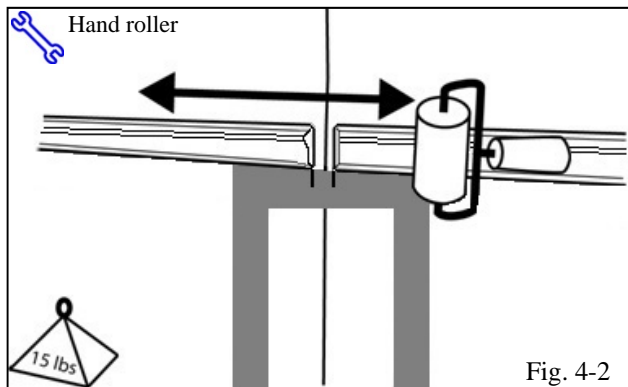
⚠ (b) Align the front edge of the rear molding with the vertical mark on the horizontal piece of tape located 6.6mm rearward of the rear door edge (Fig. 3-2).




 (c) Verify the placement.

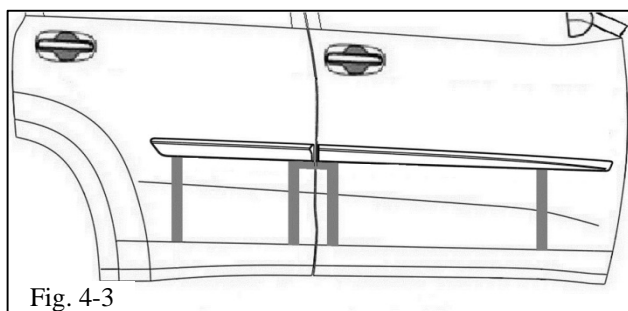
- (1) Place a non-marring straight edge flush with the bottom of the front molding (Fig. 4-1).
- (2) Set the front edge of the rear molding on top of the straight edge. The edges must align (Fig. 4-1).
- (3) Ensure the rear portion of the bottom edge of the rear molding aligns with the vertical piece of tape (Fig. 4-1).

 (d) Once properly aligned, carefully expose the 3M tape by peeling away the liner beginning with the tape at the front of the molding and working rearward.



 (e) Use the hand roller to roll around the perimeter of the parts with a firm pressure to ensure complete adhesion of the acrylic foam tape to the door surfaces (Fig. 4-2).

(f) Repeat Step 4 on the opposite side of vehicle.



(g) Remove and discard all tape strips (Fig 4-3).

Checklist - these points **MUST** be checked to ensure a quality installation.

Check:	Look For:
<p><u>Accessory Function Checks</u></p> <p><input type="checkbox"/> Check visual alignment</p> <p><input type="checkbox"/> Check for proper tape adhesion.</p>	<p>The molding should be visually straight.</p> <p>Confirm 100% tape adhesion completely around the part between the Body Side Molding and door sheet metal.</p> <p>No gap is allowed between the tape and the vehicle door surfaces, except where the tape seam joints on the backside.</p>
<p><u>Vehicle Function Checks</u></p> <p><input type="checkbox"/> None Required</p>	
<p><u>Vehicle Appearance Check</u></p> <p><input type="checkbox"/> After accessory installation and removal of protective cover(s), perform a visual inspection.</p>	<p>Ensure no damage (including scuffs and scratches) was caused during the installation process.</p> <p>(For PPO installations, refer to TMS Accessory Quality Shipping Standard).</p>