# Part Number: PTS10-52071

## **Base Kit Contents**

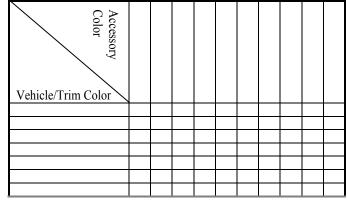
| Item # | Quantity Reqd. | Description                |
|--------|----------------|----------------------------|
| 1      | 1              | Driver Side B-Pillar       |
| 2      | 1              | Driver Side C-Pillar       |
| 3      | 1              | Driver Side B-Pillar Upper |
| 4      | 1              | Driver Side D-Pillar       |
| 5      | 1              | Driver Side D-Pillar Upper |
| 6      | 1              | Pass Side B-Pillar         |
| 7      | 1              | Pass Side C-Pillar         |
| 8      | 1              | Pass Side B-Pillar Upper   |
| 9      | 1              | Pass Side D-Pillar         |
| 10     | 1              | Pass Side D-Pillar Upper   |
| 11     | 1              | Installation Instructions  |
| 12     | 1              | Customer Care Card         |

### Conflicts

### **Recommended Tools**

| Safety Tools                | Notes               |
|-----------------------------|---------------------|
|                             |                     |
| Special Tools               |                     |
| Non Intrusive IR            |                     |
| Temperature Probe/Gun       |                     |
|                             |                     |
| <b>Installation Tools</b>   | Notes               |
| Heat Source                 | If needed           |
| Lint-Free Scratch Resistant | 3M Disposable Cloth |
| Cloth                       | (Recommended)       |
| Hand Roller                 | If needed           |
|                             |                     |
| Special Chemicals           | Notes               |
| Spray Cleaner               | Soap & Water        |
| Bottled Distilled Water     | In spray bottle     |
|                             |                     |

### **Color Applicability/Trim Level**



## **General Applicability**

Scion xB – PTS10-52071

#### Service Parts (may be required for reassembly)

| Item # | Qty | Description |
|--------|-----|-------------|
|        |     |             |
|        |     |             |
|        |     |             |
|        |     |             |
|        |     |             |
|        |     |             |
|        |     |             |
|        |     |             |

## Legend

\*Mandatory

**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.

**<u>CAUTION:</u>** 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.

**<u>REVISION MARK:</u>** This mark highlights a change in installation with respect to previous issue.

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## 1. Installation Precautions

- (a) Thoroughly clean all installation surfaces. When cleaning with soap and water solution:
  - (1) Always use a clean lint free cloth.
    - (2) Shake solution well.
- (3) Apply Cleaner to cloth or wipe. Do not spray cleaning solutions directly to any vehicle surfaces. (Fig. 1-1)
- (4) Clean surface thoroughly and wipe dry immediately with a new clean cloth. Do not allow cleaner to air dry. (Fig. 1-2)
- (b) Window applique must be between 60°F and 110°F at time of installation.
- (c) Vehicle surfaces must be at or above 60°F at time of installation
- (d) Do not touch or allow debris or contaminants to come into contact with the adhesive backing before installation.



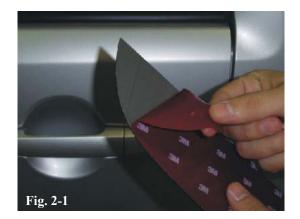


(e) Inspect parts prior to installation. Dry fit parts prior to removing adhesive liner.

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## 2. Install B Pillar Appliqué

- (a) Warm up vehicle surfaces (as required).
  - Use heat gun, infrared lamps, shop heat or vehicle heating system to heat surfaces to a temperature of at least 60°F. Keep heat gun at lowest setting, 6" from surfaces.
  - (b) Position part over vehicle surface to check proper fit prior to install. Note: opening the front and rear doors will aid in the installation.
  - (c) Remove the 3M adhesive liners from the appropriate applique. Be sure not to touch the adhesive during installation.(Fig. 2-1)
  - (d) Using a clean water mist bottle, lightly mist part prior to installing the applique.(Fig. 2-2) It may necessary to use more mist in higher temperatures.
  - (1) Align part uniformly to top and side edges of factory component. (Gaps between bottom of pillar applique and vehicle will vary.) Pressing from the center to the edges to allow all of the air to escape. (Air trapment will cause bumps under the surface of the applique) (Fig. 2-3)







- (e) Gently touch part into position. Once positioned apply even steady pressure to part, maximizing adhesive contact. A roller may be used to improve bonding.
- (f) Edge of appliqué should be flush to top and side edge of factory component, +2.0/-0.0 mm (no overhang).
- (g) The bottom edge of applique should be 0-4 mm from door weatherstripping.

# 3. Install remaining Driver side appliqué

- (a) Install in following order: (i) Driver side
  B-Pillar upper, (ii) Driver side C-Pillar,
  (iii) Driver side D-Pillar upper, (iv) Driver
  side D-pillar. (Figs. 3-1 thru 3-4)
- (b) Align edges of adjacent pieces to be flush with each other, creating a "single piece" appearance (0 mm gap).
- (c) Edges of appliqué should be parallel to top and side edges of factory component.
   (+2.0/-0.0 mm gap, no overhang)
- (d) Use the following tolerances for remaining edges of installed pieces:
  - (1) For B-pillar upper piece, use 0-3 mm gap to mirror support.
  - (2) For B-pillar and C-pillar pieces, bottom edges should be aligned, with max difference of 2 mm.
  - (3) For C-pillar and D-pillar pieces, use 0-4 mm gap from bottom edge to door weatherstripping.
- 4. Repeat Step 3 for Passenger side appliqué
- 5. Place Care Card in glove box









# SCION xB 2008 - CARBON FIBER WINDOW TRIM Checklist - these points MUST be checked to ensure a quality installation.

| Check the following functions: |   |
|--------------------------------|---|
|                                |   |
| Door Operation                 | The doors shall open and close without any interference from the appliqué.  |
| Accessory Function Checks      |   |
| Appliqué – Adhesive            | Appliqué should be securely attached to panels.<br>Be sure to check appliqué edges for any signs of<br>lifting, depression marks, or uneven layering. |
| Appliqué – Alignment           | Appliqué should be parallel to edges of door trin<br>Adjacent pieces shall have edges aligned and<br>flush to provide uniform appearance.             |
| Appliqué - Tolerances          | Confirm tolerances in Step 2 and 3 for driver and passenger sides.  |
|                                |   |
|                                |   |
|                                |   |
|                                |   |
|                                |   |
|                                |   |