

1. Installation Precautions

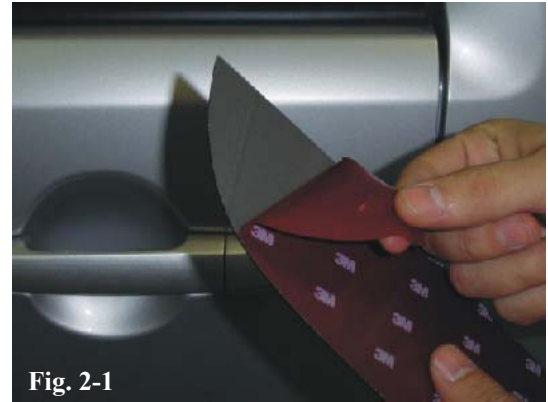
- ➔ (a) Thoroughly clean all installation surfaces. When cleaning with soap and water solution:
 - ⊘ (1) Always use a clean lint free cloth.
 - (2) Shake solution well.
 - ⊘ (3) Apply Cleaner to cloth or wipe. Do not spray cleaning solutions directly to any vehicle surfaces. (Fig. 1-1)
 - ➔ (4) Clean 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.

2. Install B Pillar Appliqué

- ➔ (a) Warm up vehicle surfaces (as required).
 - (1) 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



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

Vehicle Function Checks

Check the following functions:

Door Operation

Accessory Function Checks

Appliqué – Adhesive

Appliqué – Alignment

Appliqué - Tolerances

The doors shall open and close without any interference from the appliqué.

Appliqué should be securely attached to panels. Be sure to check appliqué edges for any signs of lifting, depression marks, or uneven layering.

Appliqué should be parallel to edges of door trim. Adjacent pieces shall have edges aligned and flush to provide uniform appearance.

Confirm tolerances in Step 2 and 3 for driver and passenger sides.