

Part Number: 00012-X0846-02

Base Kit Contents

Item #	Quantity Req'd.	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

Conflicts

--

Recommended Tools

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

Color Applicability/Trim Level

Accessory Color																			
	Vehicle/Trim Color																		

General Applicability


Scion xB – PTS10-52071


Service Parts (may be required for reassembly)


Item #	Qty	Description
00012-X0846-26	1	Driver side front (2 piece)
00012-X0846-28	1	Driver side rear (3 piece)
00012-X0846-27	1	Passenger side front (2 piece)
00012-X0846-29	1	Passenger side rear (3 piece)


*Mandatory


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.

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 70°F and 110°F (just prior to actual installation.)
- ➔ (c) Vehicle surfaces must be between 70°F and 110°F (just prior to actual 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 70°F. Keep heat gun at lowest setting, 6" from surfaces.

- (b) Using a clean water mist bottle, thoroughly mist each pillar area prior to installing the appliqué. (Fig. 2-1)

- (c) Position part over vehicle surface to check proper fit prior to install. Note: opening the front and rear doors will aid in the installation.

- (d) Remove the 3M adhesive liners from the appropriate appliqué. Be sure not to touch the adhesive during installation. (Fig. 2-2)

- ⚠ (1) Align part uniformly to top and side edges of factory component. (Gaps between bottom of pillar appliqué 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 appliqué) (Fig. 2-3)

- (e) Gently touch part into position. Once positioned apply hand pressure to part, ensuring maximum adhesive contact.



Fig. 2-1

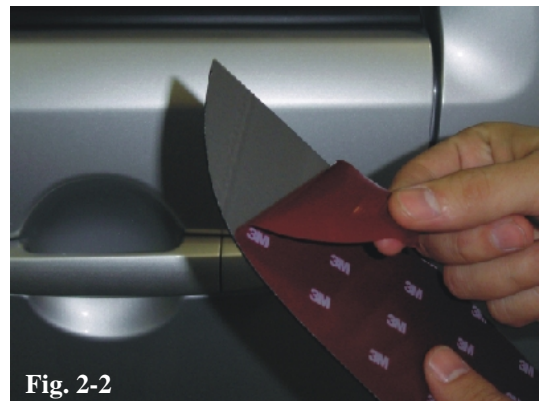


Fig. 2-2



Fig. 2-3

- (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 appliqué 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



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

Vehicle Function Checks

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.

Appliqué – Alignment

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

Appliqué - Tolerances

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