

Section I – Installation Preparation

Part Number: PTS10-52030

Section I – Installation Preparation

Kit Contents

Item #	Quantity Req'd.	Description
1	1	Driver Side Vent Trim
2	1	Passenger Side Vent Trim
3	1	Driver Side Outer Dash Trim
4	1	Pass. Side Outer Dash Trim
5	1	Driver Side Lower Column Dash Trim
6	1	Passenger Side Lower Column Dash Trim
7	1	Driver Side Front Door
8	1	Passenger Side Front Door
9	1	Driver Side Rear Door
10	1	Passenger Side Rear Door
11	1	Shift Surround
12	1	Care Card

Hardware Bag Contents

Item #	Quantity Req'd.	Description
1	None	

Additional Items Required For Installation

Item #	Quantity Req'd.	Description
1	None	

Conflicts

Note: None

Recommended Tools

Safety Tools	
Hand protection	Latex gloves (not mandatory)
Vehicle protection	Seat / Floor Covers
Special Tools	
Non Intrusive IR Temperature Probe/Gun	
Installation Tools	
Heat Source	Heat Gun (if required)
Thermometer	
Lint-Free Scratch Resistant Cloth	e.g. WypAll Disposable Cloth
Special Chemicals	
Cleaner	3M™ Prep Solvent-70

Color Applicability/Trim Level

Accessory Color																				
	Vehicle/Trim Color																			

General Applicability







Note: Applicable to all 2004MY SCION xA

Recommended Sequence of Application

Item #	Accessory	
1	Install Security/Audio	
2	Install Molded Dash	

*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.
	CRITICAL PROCESS: Proceed with caution to ensure a quality installation. These points will be audited on a completed vehicle installation.
	GENERAL PROCESS: This highlights specific processes to ensure a quality installation. These points will be audited during the accessory installation.
	TOOLS & EQUIPMENT: 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.

A. Pre-installation Precautions



1. Use Seat and Floor Protectors to avoid damage to surfaces. (Fig. A1)



2. Wear protective latex gloves while cleaning factory panels.

NOTE: The use of protective latex gloves during cleaning is mentioned as a precaution to those installers who may be sensitive to the chemicals being used in this process. The use of protective gloves is not mandatory.



3. When cleaning with 3M™ Prep Solvent-70.



i. Always use a clean (lint free, scratch resistant) soft cloth (or wipe), and clean a small area at a time (~ 3 ft. x 3 ft. max.). (Fig A2)

ii. **Shake Well.**



iii. Apply 3M™ Prep Solvent-70 to cloth or wipe. Do not spray cleaning solutions directly to **any** vehicle surfaces. (Fig. A3)



iv. Clean surface thoroughly and wipe dry immediately with a new clean cloth. Do not allow cleaner to air dry. (Fig. A4)



4. Dash appliqué must be between 70°F and 110°F (just prior to actual installation).

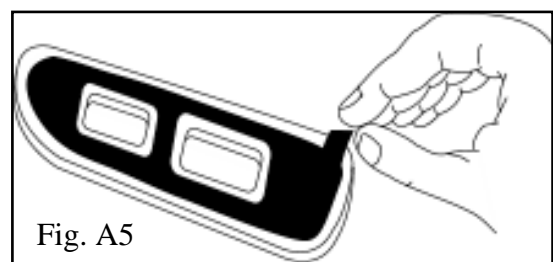
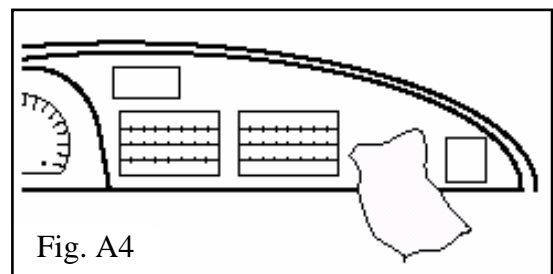
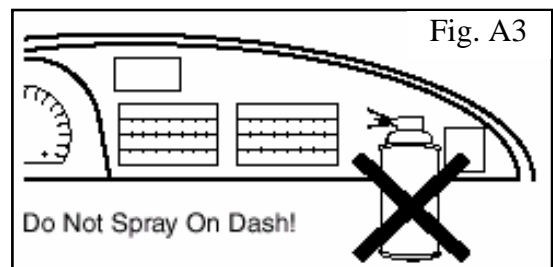
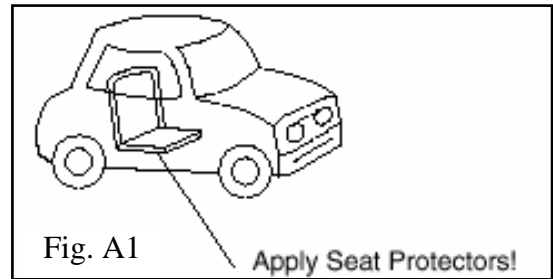


5. Vehicle dash surfaces must be between 70°F and 110°F (just prior to actual installation).

6. Use pull-tabs to remove 3M™ liners. (Fig. A5)



7. Do not touch or allow debris or contaminants to come into contact with the adhesive backing before installation.



B. Inspection of Parts

1. Inspect parts prior to installation to avoid unnecessary removal.

C. Clean Factory Surfaces

1. Thoroughly clean (using method in Step A. 3.) all applicable installation surfaces. (Figure C1)

D. Install Driver Front Door Trim

- ➔ 1. Warm up vehicle surfaces (if required).
 - i. Use heat gun, infrared lamps, shop heat or vehicle heating system to heat surfaces to a temperature between (at least) 70°F and 110°F. Keep heat gun at lowest setting, 6” from surfaces.
2. Remove adhesive liner from part. Be sure not to touch adhesive backing prior to installation.
3. Position and secure part.
 - ⚠ ii. Align part uniformly to edge of factory component. Edge of appliqué should be flush to edge of factory component, ±1.0mm. (Figure D1)
 - iii. Gently touch part into position.
- ➔ 4. Press firmly into place. Roll fingertips in a back and forth motion to set adhesive. Be sure to roll thumb along outside and inside edges while applying pressure.

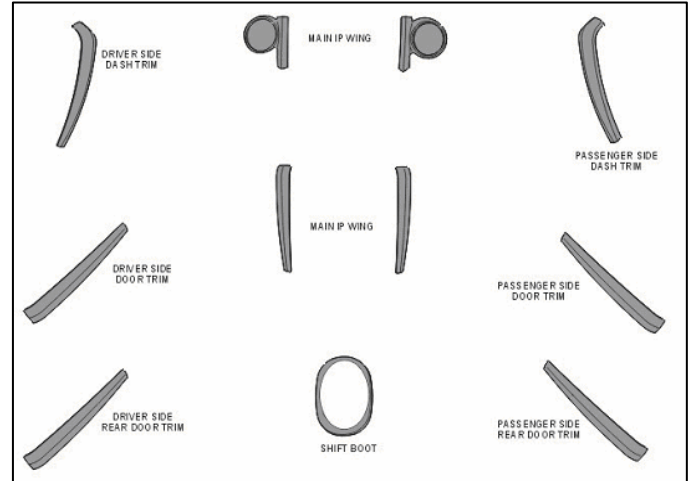


Figure C1




Figure D1


E. Install Driver Side Vent Trim

- ➔ 1. Follow steps to warm components as required.
2. Remove adhesive liners from part. Be sure not to touch adhesive backing prior to installation.
3. Position and secure part.
 - ⚠ i. Align around vent.
 - ⚠ ii. Align part uniformly to edge of factory component. Edge of appliqué should be flush to edge of factory component, ±1.0mm. (Figure E1)





Figure E1


 4. Verify function of vent.

 5. Press firmly into place. Roll fingertips in a back and forth motion to set adhesive. Be sure to roll thumb along outside and inside edges while applying pressure.


F. Install Driver Side Outer Dash Trim


 1. Follow steps to warm components as required.
 2. Remove adhesive liners from part. Be sure not to touch adhesive backing prior to installation.
 3. Position and secure part.


 i. Align part uniformly to edge of factory component. Edge of appliqué should be flush to edge of factory component, ±1.0mm. (Figure F1)

 4. Press firmly into place. Roll fingertips in a back and forth motion to set adhesive. Be sure to roll thumb along outside and inside edges while applying pressure.

G. Install Driver Side Lower Column Dash Trim

 1. Follow steps to warm components as required.
 2. Remove adhesive liners from part. Be sure not to touch adhesive backing prior to installation.
 3. Position and secure part.

 i. Align part uniformly to edge of factory component. Edge of appliqué should be flush to edge of factory component, ±1.0mm. (Figure G1)

 4. Press firmly into place. Roll fingertips in a back and forth motion to set adhesive. Be sure to roll thumb along outside and inside edges while applying pressure.

H. Install Passenger Front Door Trim


 1. Follow Step D. 1. through Step D. 4, to install the Passenger Front Door Trim. (Figure H1)



Figure F1



Figure G1



Figure H1

I. Install Passenger Side Vent Trim

1. Follow Step E. 1.through Step E. 5, to install the Passenger Side Vent Trim.

J. Install Driver Side Outer Dash Trim

1. Follow Step F. 1.through Step F. 4, to install the Passenger Side Vent Trim.

K. Install Passenger Side Lower Column Dash Trim

1. Follow Step G. 1.through Step G. 4, to install the Passenger Side Vent Trim.

L. Install Shift Surround

- ➡ 1. Follow steps to warm components as required.
- 2. Remove adhesive liners from part. Be sure not to touch adhesive backing prior to installation.
- 3. Position and secure part.



- i. Align part uniformly to edge of factory component. Edge of appliqué should be flush to edge of factory component, ±1.0mm (Figure L1)

- ➡ 4. Press firmly into place. Roll fingertips in a back and forth motion to set adhesive. Be sure to roll thumb along outside and inside edges while applying pressure.

M. Install Rear Passenger Door Trim

- ➡ 1. Follow steps to warm components as required.
- ➡ 2. Using a Philips head screwdriver, remove the screw located on the inside of the “grab handle” compartment. (Figure M1)
 - i. Pop out the upper panel of door.
 - ii. With the upper panel removed, remove adhesive liners from appliqué. Be sure not to touch adhesive backing prior to installation.



Figure L1



Figure M1

3. Position and secure part.



- i. Align part uniformly to edge of factory component. Edge of appliqué should be flush to edge of factory component, $\pm 1.0\text{mm}$.



- 4. Press firmly into place. Roll fingertips in a back and forth motion to set adhesive. Be sure to roll thumb along outside and inside edges while applying pressure.



- 5. Re-install the upper panel back onto the door, and re-fasten the screw.

N. Install Rear Driver Door Trim



- 1. Follow Step M. 1. through Step M. 5, to install the Rear Driver Door Trim.

O. Clean Up



- 1. With Prep-Sol 70, wipe down all molded surfaces to remove fingerprints, etc...
- 2. Remove protective covers from vehicle interior.



- 3. Place Care Card in Glove Compartment.



Section III – Functional Verifications

Check: _____

Clearance to switches

Clearance to buttons

Clearance to vents

Look For: _____

All switches should function properly.
(No binding)

All buttons should function properly.
(No sticking)

Vents should swing through full range of
motion.

Section IV: Process / Audit Criteria

Process   

Audited during accessory installation









Paragraph numbers refer to paragraph numbers in Section II

Audit 


Audited on completed vehicle installation

Part Number: PTS10-52030


A. Pre-installation Precautions

-  1. Use Seat and Floor Protectors to avoid damage to surfaces.
-  2. Wear protective latex gloves while cleaning factory panels.
-  3. When cleaning with 3M™ Prep Solvent-70
 -  i. Always use a clean (lint free, scratch resistant) soft cloth (or wipe), and clean a small area at a time (~ 3 ft. x 3 ft. max.).
 -  iii. Apply 3M™ Prep Solvent-70 to cloth or wipe. Do not spray cleaning solutions directly to **any** vehicle surfaces.
 - iv. Clean surface thoroughly and wipe dry immediately with a new clean cloth. Do not allow cleaner to air dry.
-  4. Dash appliqué must be between 70°F and 110°F (just prior to actual installation).
-  5. Vehicle dash surfaces must be between 70°F and 110°F (just prior to actual installation).
-  7. Do not touch or allow debris or contaminants to come into contact with the adhesive backing before installation.



B. Inspection of Parts

-  1. Inspect parts prior to installation to avoid unnecessary removal.

C. Clean Factory Surfaces

-  1. Thoroughly clean (using method in Step A. 3.) all applicable surfaces.

D. Install Driver Front Door Trim


-  1. Warm up vehicle surfaces (if required).
-  4. Press firmly into place. Roll fingertips in a back and forth motion to set adhesive. Be sure to roll thumb along outside and inside edges while applying pressure.

A. Pre-installation Precautions

B. Inspection of Parts

C. Clean Factory Surfaces

D. Install Driver Front Door Trim

-  3 i. Align part uniformly to edge of factory component. Edge of appliqué should be flush to edge of factory component, ±1.0mm.

Section IV: Process / Audit Criteria

Process   

Audited during accessory installation

Paragraph numbers refer to paragraph numbers in Section II

Audit 

Audited on completed vehicle installation

E. Install Driver Side Vent Trim



1. Follow steps to warm components as required



5. Press firmly into place. Roll fingertips in a back and forth motion to set adhesive. Be sure to roll thumb along outside and inside edges while applying pressure.

F. Install Driver Side Outer Dash Trim



1. Follow steps to warm components as required.



4. Press firmly into place. Roll fingertips in a back and forth motion to set adhesive. Be sure to roll thumb along outside and inside edges while applying pressure.

G. Install Driver Side Lower Column Dash Trim



1. Follow steps to warm components as required.



4. Press firmly into place. Roll fingertips in a back and forth motion to set adhesive. Be sure to roll thumb along outside and inside edges while applying pressure.

H. Install Passenger Front Door Trim



1. Follow Step D. 1. through Step D. 4, to install the Passenger Front Door Trim

I. Install Passenger Side Vent Trim



1. Follow Step E. 1. through Step E. 5, to install the Passenger Side Vent Trim.

J. Install Passenger Side Outer Dash Trim



1. Follow Step F. 1. through Step F. 4, to install the Passenger Side Vent Trim.

K. Install Passenger Side Lower Column Dash Trim



1. Follow Step G. 1. through Step G. 4, to install the Passenger Side Vent Trim

E. Install Driver Side Vent Trim



3 i. Align around vent.



3 ii. Align part uniformly to edge of factory component. Edge of appliqué should be flush to edge of factory component, ±1.0mm



4. Verify function of vent

F. Install Driver Side Outer Dash Trim



3 i. Align part uniformly to edge of factory component. Edge of appliqué should be flush to edge of factory component, ±1.0mm

G. Install Driver Side Lower Column Dash Trim



3 i. Align part uniformly to edge of factory component. Edge of appliqué should be flush to edge of factory component, ±1.0mm

H. Install Passenger Front Door Trim

I. Install Passenger Side Vent Trim

J. Install Passenger Side Outer Dash Trim

K. Install Passenger Side Lower Column Dash Trim

Section IV: Process / Audit Criteria

Process   



Audited during accessory installation

Paragraph numbers refer to paragraph numbers in Section II





Audit 

Audited on completed vehicle installation

L. Install Shift Surround

-  1. Follow steps to warm components as required.
-  2. Press firmly into place. Roll fingertips in a back and forth motion to set adhesive. Be sure to roll thumb along outside and inside edges while applying pressure.



M. Install Rear Passenger Door Trim

-  1. Follow steps to warm component as required.
-  2. Using a Philips head screwdriver, remove the screw located on the inside of the “grab handle” compartment
-  4. Press firmly into place. Roll fingertips in a back and forth motion to set adhesive. Be sure to roll thumb along outside and inside edges while applying pressure.
-  5. Re-install the upper panel back onto the door, and re-fasten the screw.


N. Install Rear Driver Door Trim

-  1. Follow Step M. 1.through Step M. 5, to install the Rear Driver Door Trim.


O. Clean Up

-  1. With Prep-Sol 70, wipe down all molded surfaces to remove fingerprints, etc...
-  3. Place Care Card in Glove Compartment.

L. Install Shift Surround

-  3 i. Align part uniformly to edge of factory component. Edge of appliqué should be flush to edge of factory component, ±1.0mm

M. Install Rear Passenger Door Trim

-  3 i. Align part uniformly to edge of factory component. Edge of appliqué should be flush to edge of factory component, ±1.0mm.

N. Install Rear Driver Door Trim

O. Clean Up