

**Part Number: PTS10-52031**

Section I – Installation Preparation

**Kit Contents**

Item #	Quantity Reqd.	Description
1	1	Driver Side Front Door
2	1	Passenger Side Front Door
3	1	Center Instrument Panel
4	1	Shift Surround
5	1	Care Card

**Hardware Bag Contents**

Item #	Quantity Reqd.	Description
1	None	

**Additional Items Required For Installation**

Item #	Quantity Reqd.	Description
1	None	

**Conflicts**

Note: None
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**Recommended Tools**

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

**Color Applicability/Trim Level**

Accessory Color																			
	Vehicle/Trim Color																		

**General Applicability**







Note: Applicable to all 2004MY SCION xB

**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).

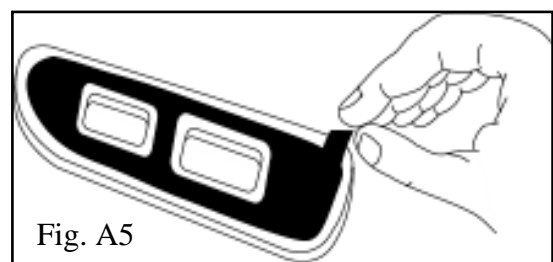
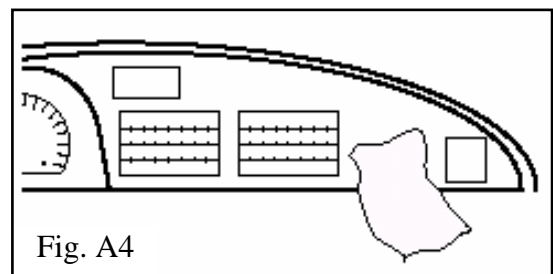
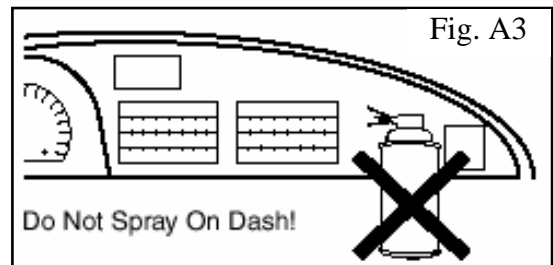
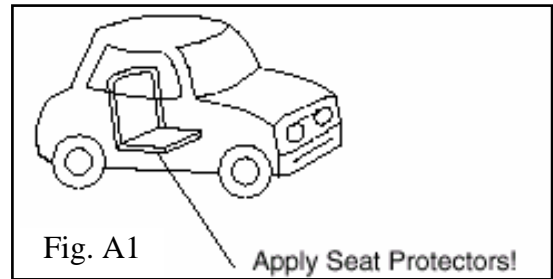


5. Vehicle dash surfaces must be between 70°F and 110°F (just prior to actual installation).

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.
  - i. Align cutouts for all switches
  - ⚠ 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. Verify function of all switches.
- ➔ 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.

**E. Install Center Instrument Panel**

- ➔ 1. Follow steps to warm components as required.
- ➔ 2. To ease the installation, use a wet cloth to moisten the entire Center IP.
3. Remove adhesive liners from part. Be sure not to touch adhesive backing prior to installation.

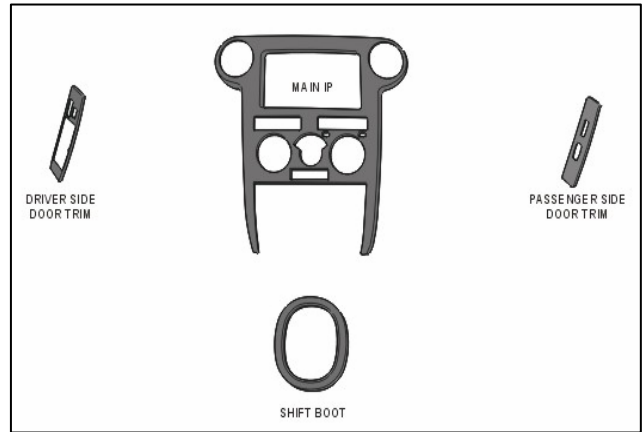


Figure C1



Figure D1

4. Position and secure part.



i. Align part uniformly to edge of factory component. Edge of appliqué should be flush to edge of factory component,  $\pm 1.0\text{mm}$  (Figure E1)



5. Verify function of all center IP components.



6. 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 Passenger Front Door Trim**



1. Follow Step D. 1. through Step D. 4, to install the Passenger Front Door Trim. (Figure F1)

**G. 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,  $\pm 1.0\text{mm}$  (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. 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.



Figure E1

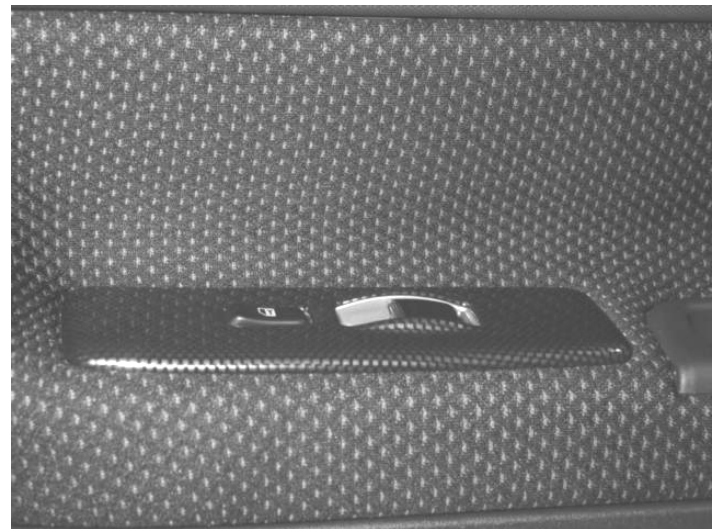


Figure F1



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: PTS10-52031


##### 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).
-  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.

##### A. Pre-installation Precautions

##### B. Inspection of Parts

##### C. Clean Factory Surfaces

##### D. Install Driver Front Door Trim

-  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 all switches.

**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 Center Instrument Panel**



1. Follow steps to warm components as required
2. To ease the installation, use a wet cloth to moisten the entire Center IP.
6. 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.



**E. Install Center Instrument Panel**



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



5. Verify function of all center IP components.

**F. Install Passenger Front Door Trim**



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

**F. Install Passenger Front Door Trim**

**G. Install Shift Surround**



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 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

**H. Clean Up**



1. With Prep-Sol 70, wipe down all molded surfaces to remove fingerprints, etc...



2. Place Care Card in Glove Compartment.

**H. Clean Up**