

Section I – Installation Preparation

**Part Number:**

**PTS10-52041 (xA – Fuel Lid)**

**PTS10-52040 (xB – Fuel Lid)**

Section I – Installation Preparation

**Kit Contents**

Item #	Quantity Reqd.	Description
1	1	Fuel Lid Door
2	1	Care Card
3	1	Installation Instructions

**Hardware Bag Contents**

Item #	Quantity Reqd.	Description
1	None	

**Additional Items Required For Installation**

Item #	Quantity Reqd.	Description
1	None	

**Conflicts**

Note: None

**Recommended Tools**

<b>Safety Tools</b>	
Hand protection	Latex gloves (not mandatory)
<b>Special Tools</b>	
Non Intrusive IR Temperature Probe/Gun	
<b>Installation Tools</b>	
Spray Bottle	Water filled
Lint-Free Scratch Resistant Cloth	
Heat Source	Heat Gun (if required)
<b>Special Chemicals</b>	
Cleaner	3M™ Prep Solvent-70

**Color Applicability/Trim Level**

Vehicle/Trim Color	Accessory																		
All																			

**General Applicability**

Note:







- Applicable to SCION Vehicles only

**Recommended Sequence of Application**

Item #	Accessory	
1		

\*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.

## Section II – Installation Procedure

**A. Clean Factory Surfaces**

Make sure fuel lid door is released.



1. Wear protective latex gloves while cleaning the specified 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.



2. Thoroughly clean the fuel lid door 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.).

- ii. **Shake Well.**



- 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.



3. Fuel Lid appliqué must be between 70°F and 110°F (just prior to actual installation).



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

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

**B. Install Fuel Lid Appliqué**

Warm up vehicle fuel lid (if required).

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.

➡ Using the water filled spray bottle, thoroughly mist the fuel door area immediately prior to installing the appliqué. (Figure B1)

➡ Once sprayed, release the Fuel Lid Door lever, located to the left of the drivers seat. (Figure B2)

➡ Remove adhesive liner from appliqué. Be sure not to touch adhesive backing prior to installation. (Figure B3)

➡ 1. Position and secure appliqué onto vehicle fuel door.

⚠ i. Align appliqué uniformly to edge of factory Fuel Lid. Edge of appliqué should be flush to edge of factory component, ±2.0mm. (Figure B4)

⚠ ii. On xA vehicles equipped with Pillar Appliqué, align Carbon Fiber Fuel Door pattern to match that of the Pillar Appliqué

2. Press appliqué 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.

3. Close fuel door.

**C. Clean Up**

➡ 1. Using water, wipe down all appliqué surfaces to remove fingerprints, etc...

➡ Place Care Card in Glove Compartment.

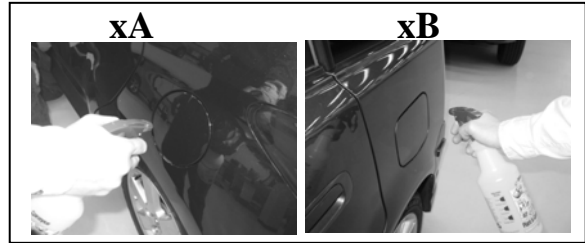


Figure B1



Figure B2

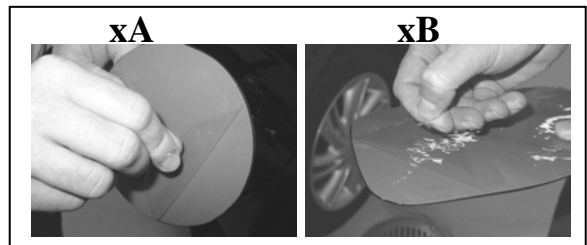


Figure B3

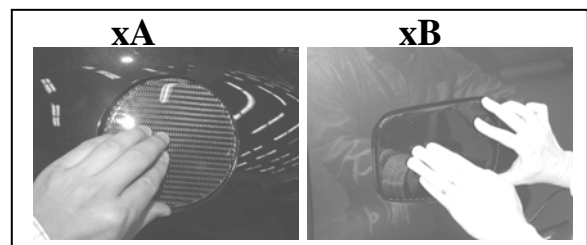


Figure B4



Section III – Functional Verifications

Check: \_\_\_\_\_

Appliqué alignment

Vehicle Fuel Door operation

Look for: \_\_\_\_\_

Applique is uniform around the perimeter edge of the vehicle fuel door. On xA vehicles equipped with Pillar Appliqué, align Carbon Fiber Fuel Door pattern to match that of the Pillar Appliqué.

Fuel door opens and closes without any interference from the applique.

## 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: PTS10-52041** (xA – Fuel Lid)

**PTS10-52040** (xB – Fuel Lid)



**A. Clean Factory Surfaces**

-  1. Make sure fuel lid door is released.
-  2. Wear protective latex gloves while cleaning factory panels.
-  3. Thoroughly clean the fuel lid door 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. Fuel Lid 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).

**B. Install Fuel Lid Appliqué**



-  2. Using the water filled spray bottle, thoroughly mist the fuel door area immediately prior to installing the appliqué
-  3. Once sprayed, release the Fuel Lid Door lever, located to the left of the drivers seat.
-  4. Remove adhesive liner from appliqué. Be sure not to touch adhesive backing prior to installation.
-  5. Position and secure appliqué onto vehicle fuel door.

**C. Clean Up**

-  1. Using water, wipe down all appliqué surfaces to remove fingerprints, etc...
-  2. Place Care Card in Glove Compartment.

**A. Clean Factory Surfaces**

**B. Install Fuel Lid Appliqué**

-  5.i. Align appliqué uniformly to edge of factory Fuel Lid. Edge of appliqué should be flush to edge of factory component, ±2.0mm.
-  5.ii. On xA vehicles equipped with Pillar Appliqué, align Carbon Fiber Fuel Door pattern to match that of the Pillar Appliqué

**C. Clean Up**