

Section I – Installation Preparation

Part Number: PTS10-52043

Section I – Installation Preparation

Kit Contents

Item #	Quantity Reqd.	Description
1	1	Driver Side Taillight Garnish
2	1	Pass. Side Taillight Garnish
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: Taillight Garnish CAN NOT be installed on to the Tail Lens Enhancement by TYC – PN: PTS25-52041

Recommended Tools

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

Color Applicability/Trim Level

Accessory Color																				
	Vehicle/Trim Color																			

General Applicability







All SCION xB Grades

Recommended Sequence of Application

Item #	Accessory	
1	Install Satellite Radio	
2	Install Taillight Garnish	

*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

Section II – Installation Procedure

A. Clean Factory Surfaces

1. Make sure vehicle doors are unlocked.



2. Wear protective latex gloves while cleaning the specified vehicle components.

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. Thoroughly clean both rear (left & right) taillights 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.



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



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

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

B. Install Taillight Garnish

- ➔ 1. Open the rear tailgate hatch. (Figure B1)
- ➔ 2. Remove adhesive liner from either one of the garnishes. Be sure not to touch adhesive backing prior to installation. (Figure B2)
- ➔ 3. Position & secure the garnish to the proper taillight location
 - i. Align the garnish uniformly to the inside vertical edge of the factory taillight (edge adjacent to the rear tailgate hatch). Proceed to lay the garnish outboard of the vehicle, while aligning the top and bottom horizontal edges of the garnish to the edges of the factory taillight (Figure B3)
 - ⚠ ii. Edge of the garnish should be flush to edge of factory component, $\pm 2.0\text{mm}$.
4. Once installed, press the garnish 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 B4)
- ➔ 5. Repeat steps B. 1 – B. 4 on the opposite taillight of the vehicle.
6. Close rear tailgate hatch

C. Clean Up

- ➔ 1. With a clean Terry Cloth, wipe down taillight garnish to remove fingerprints, etc...



Figure B1

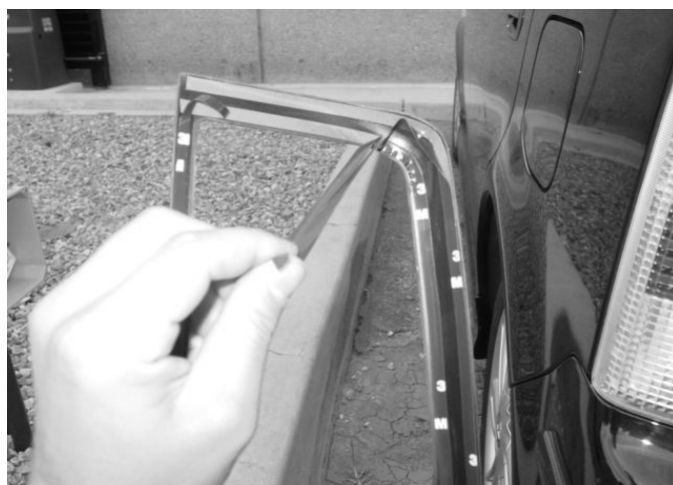


Figure B2

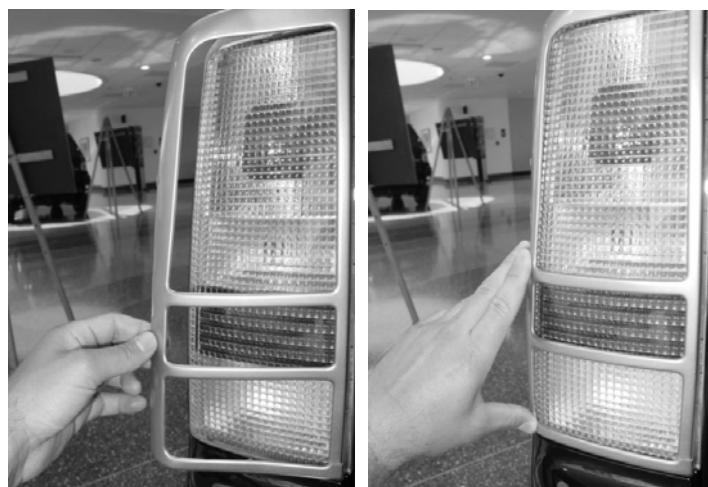


Figure B3



Figure B4



Section III – Functional Verifications

Check: _____

- Garnish alignment

- Tailgate Hatch Operation

Look for: _____

Taillight Garnish is uniform around the perimeter edge of the factory taillight

Tailgate hatch opens and closes without any interference from the garnish

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

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3. Thoroughly clean both rear (left & right) taillights 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. Taillight Garnish must be between 70°F and 110°F (just prior to actual installation).



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

B. Install Taillight Garnishes



1. Open the rear tailgate hatch



2. Remove adhesive liner from either one of the garnishes. Be sure not to touch adhesive backing prior to installation



3. Position & secure the garnish to the proper taillight location



5. Repeat steps B. 1 – B. 4 on the opposite taillight of the vehicle.

C. Clean Up



1. With a clean Terry Cloth, wipe down shift knob to remove fingerprints, etc...

A. Clean Factory Surfaces

B. Install Taillight Garnishes



3. ii. Edge of the garnish should be flush to edge of factory component, ± 2.0mm.

C. Clean Up