

Part Number: PT938-48141-XX

Kit Contents

Item #	Quantity Req.	Description
1	1	Molding, LH Front Door
2	1	Molding, LH Rear Door
3	1	Molding, RH Front Door
4	1	Molding, RH Rear Door

Hardware Bag Contents

Item #	Quantity Req.	Description
1		
2		

Additional Items Required For Installation

Item #	Quantity Req.	Description
1		
2		

Conflicts

None

Recommended Tools

Personal & Vehicle Protection	Notes
Safety Glasses	
Seat & Floor Covers	
Special Tools	Notes
Roller	Hard Rubber Hand Roller, 1" to 3" wide i.e. Marshalltown E54D or Dynamat 10007
Non-intrusive Infrared Temp Probe/Gun	
Installation Tools	Notes
Flexible Scale or Tape Measure	
Masking Tape	1" wide
Clean Lint-free Cloths	
Straight Edge (Plastic)	Non-marring
Heat Gun (if required to warm surfaces)	
Special Chemicals	Notes
Simple Green All Purpose Cleaner	½ Strength (1 part Simple Green to 1 part water)

General Applicability

Body Side Molding can be installed on all MY2016 or later RX 350/450h models.

Recommended Sequence of Application


Item #	Accessory
1	Body Side Molding
2	Door Edge Guards
3	


*Mandatory


Vehicle Service Parts (may be required for reassembly)


Item #	Quantity Req.	Description


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.

 **SAFETY TORQUE:** This mark indicates that torque is related to safety.

Care must be taken when installing this accessory to ensure damage does not occur to the vehicle. The installation of this accessory should follow approved guidelines to ensure a quality installation.

These guidelines can be found in the "Accessory Installation Practices" document.

This document covers such items as:-

- Vehicle Protection (use of covers and blankets, cleaning chemicals, etc.).
- Safety (eye protection, rechecking torque procedure, etc.).
- Vehicle Disassembly/Reassembly (panel removal, part storage, etc.).
- Electrical Component Disassembly/Reassembly (battery disconnection, connector removal, etc.).

Please see your Lexus dealer for a copy of this document.

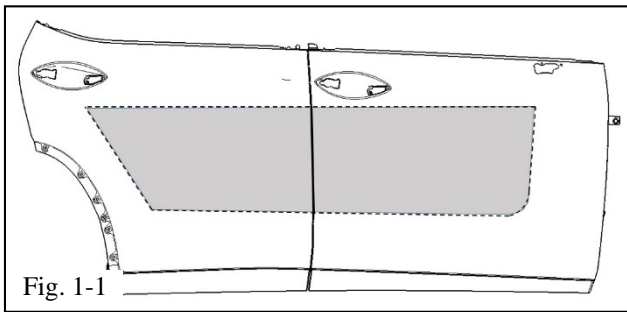
1. Prepare the Vehicle.

STOP (a) The work area, body side moldings, and vehicle door surface temperatures must be between 60°F (16°C) and 110°F (43°C).

(b) Clean the areas of each door as shown in Fig. 1-1 using a ½ strength Simple Green solution (1 part Simple Green to 1 part water).

(c) Wipe the cleaned surfaces with a clean, dry, lint-free cloth.

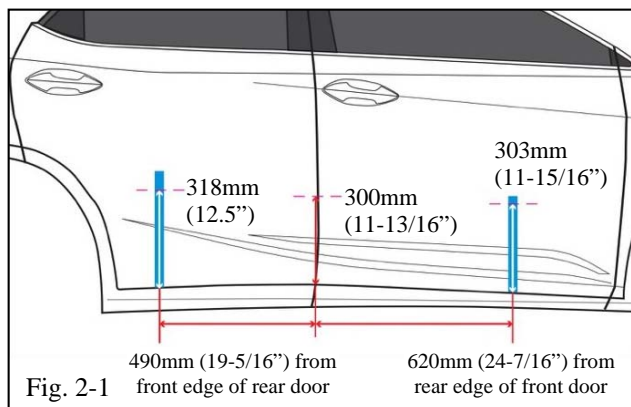
NOTE: Once cleaned do not contaminate this surface by touching it with your bare hands.

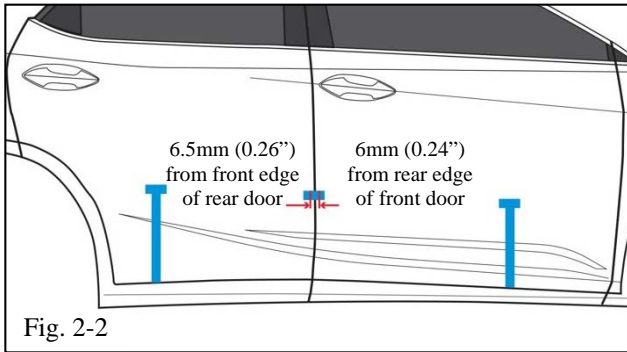


2. Apply Alignment Tape.

! (a) Apply tape to the vehicle per Fig. 2-1 using the edge of the door for start points as directed at bottom of figure. Place marks on the tape to show the measurements.

! (b) Mark the vertical pieces of tape (Fig. 2-1). The measurements are taken from the top most edge of the door cladding. The measuring device should be held vertically, not pressing against the contour of the door sheet metal.





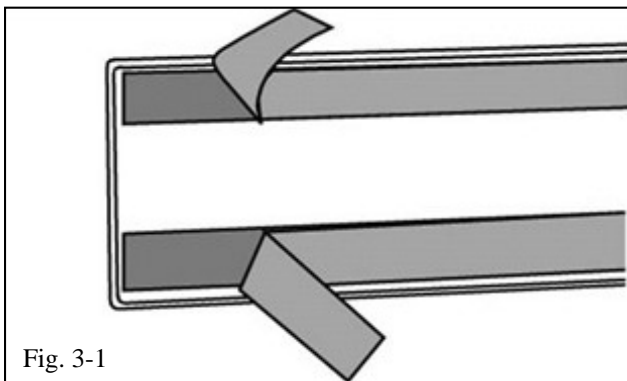
- ⚠ (c) Trim the vertical tape protruding above the marks made in Step 2(b) (Fig. 2-2).
- ⚠ (d) Apply a 100mm piece of tape horizontally, bridging the front and rear door gap (Fig. 2-1 & Fig. 2-2). Ensure that the top edge of the tape is aligned with the marks made in Step 2(a).
- (e) Mark the piece of tape applied in Step 2(d) with a straight vertical line 6.0mm forward from the door edge of the front door.
- (f) Mark an additional vertical line on the same piece of tape 6.5mm rearward from the rear door edge.

⚠ **NOTE:** Ensure the 6.0mm and 6.5mm minimum distance is carefully measured.

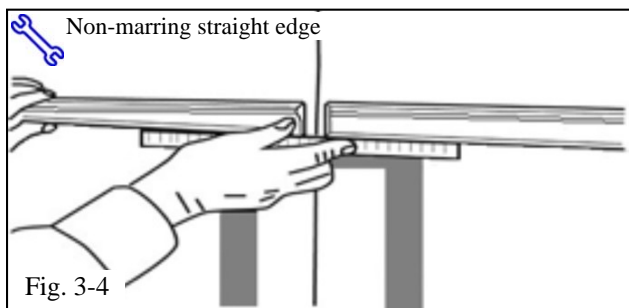
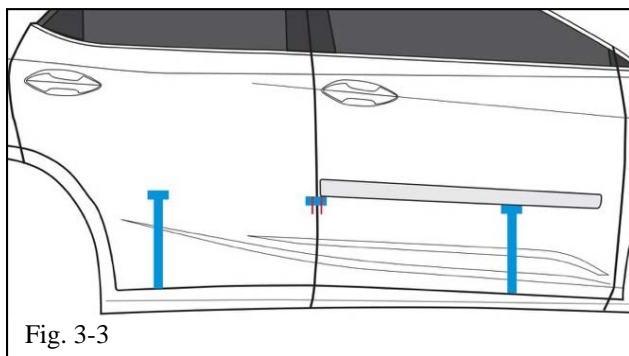
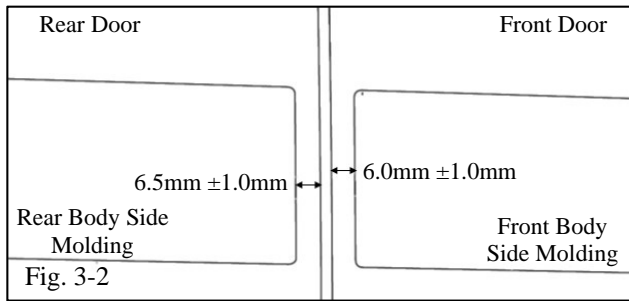
- (g) Repeat Step 2 on the other side of the vehicle.





3. Install the Body Side Molding.

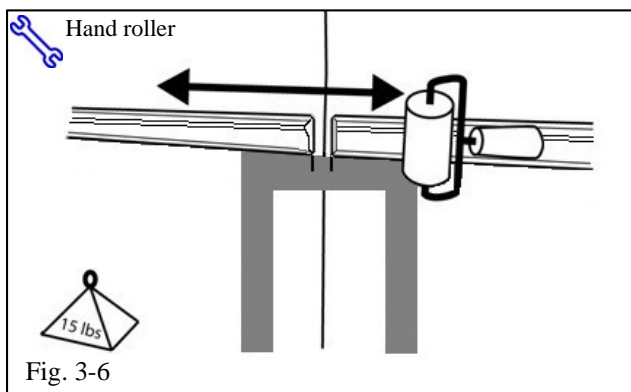
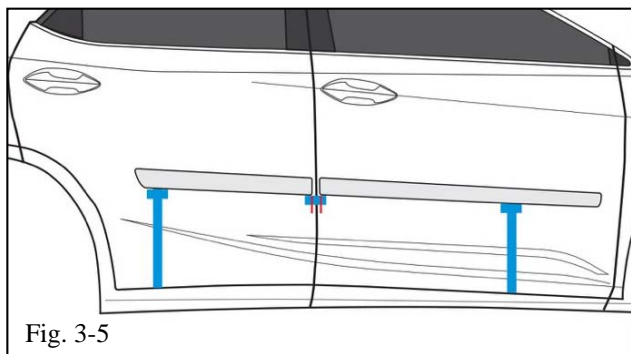
- (a) The inside of each of the four moldings is identified as to their correct position on the vehicle.
- (b) Start with either front door using the appropriate front molding (longer molding).
- (c) While carefully holding the molding by its edges, fold the tape liner tabs on the horizontal tape lengths upwards (top piece) and downwards (bottom piece) (Fig. 3-1) such that the tabs are accessible when the molding is in the install position.



⛔ **NOTE:** Once the release liner is removed from the molding, the surface of the foam tape must not be touched!



- (d)  The opening between the doors should look like Fig. 3-2. The tolerance for flushness in the vertical direction of the front and rear molding in relation to each other is 0.0mm +/-1.0mm.
- (e) Align the rear edge of the front molding with the vertical mark on the horizontal piece of tape located 6mm forward of the front door edge (Fig. 3-2).
- (f) Align the bottom of the molding flush with the top edge of the horizontal tape (Fig. 3-3).
- (g) Reposition the part as required before sticking the tape to the door.
- (h)  Once the molding is properly aligned, carefully expose the tape by peeling away the liner, beginning with the tape at the rear of the molding and working forward. Ensure the bottom of the molding is aligned to the top of the vertical piece of tape on the front door.
- NOTE:**  Do not allow both ends to contact and stick to the door before the center contacts.
- (i) Align the front edge of the rear molding with the vertical mark on the horizontal piece of tape located 6.5mm rearward of the rear door edge (Fig. 3-2).
- (j)  To ensure vertical alignment where the rear and front molding meet between the doors, hold a plastic straight edge against the bottom of the front molding and use it as a guide for the rear molding as shown in Fig. 3-4. The tolerance for alignment in the vertical direction of the front and rear molding in relation to each other is 0.0mm +/-1.0mm.



(k) Set the front edge of the rear molding on top of the straight edge. The edges must align. Ensure the rear portion of the bottom edge of the rear molding aligns with the vertical piece of tape (Fig. 3-5).

! (l) Once the molding is properly aligned, carefully expose the tape by peeling away the liner, beginning with the tape at the rear of the molding and working forward.

! **NOTE:** Do not allow both ends to contact and stick to the door before the center contacts.

! (m) Use the hand roller to roll around the perimeter of the parts with firm pressure to ensure complete adhesion of the tape to the door surface. Roll along both the top protrusion and along the bottom of both parts (Fig. 3-6).

(n) Repeat the entire installation procedure for the other side of the vehicle.

(o) Remove and discard all of the tape strips.

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

<u>Check:</u>	<u>Look For:</u>
<p><u>Accessory Function Checks</u></p> <p><input type="checkbox"/> Check visual alignment</p> <p><input type="checkbox"/> Check for proper tape adhesion.</p>	<p>The moldings should be visually straight.</p> <p>Confirm 100% tape adhesion completely around the part between the Body Side Molding and door sheet metal.</p> <p>No gap is allowed between the tape and the vehicle door surfaces, except where the tape seam joints on the backside.</p>
<p><u>Vehicle Function Checks</u></p> <p><input type="checkbox"/> None Required</p>	
<p>Vehicle Appearance Checks</p> <p><input type="checkbox"/> After accessory installation and removal of protective cover(s), perform a visual inspection.</p>	<p>Ensure no damage (including scuffs and scratches) was caused during the installation process.</p>