

# 2019MY Impreza & 2019MY Crosstrek & Hybrid Body Side Molding Installation Instructions Kit Part Number J101SFL501XX

**Note: 2019MY Impreza and 2019MY Crosstrek & Hybrid models will require the BSM installation fixtures that will need to be set-up prior to actual production use. The set-up adjustment instructions are provided by the supplier RAMKO Manufacturing, Inc. are provided separately. A 2017MY Impreza 5dr. (HR3) was used for these BSM installation work instructions.**

**STOP Body side molding must be installed before installing accessory Door Edge Guards.**



**J. Luessenhop/M. Dover  
7/11/2019**

**STOP Ensure the VIN matches the work order and the vehicle date is in the lock period and there are no "Holds" on the vehicle for any reason. Ensure the vehicle calls for the accessory installation. Inspect the area where the accessory is to be installed and the vehicle for damages, etc. prior to all work.**








**CAUTION: ACCESSORY INSTALLATIONS PERFORMED BY UNTRAINED PERSONS COULD RESULT IN SERIOUS INJURY TO THOSE PERSONS OR TO OTHERS.**

Subaru Work Instructions are intended for use by professional accessory installers ONLY. They are written to provide step by step accessory installation instruction for a fast paced production environment. Properly trained accessory installers have the equipment, tools, safety instructions and know-how to do the job correctly and safely. Included in this information are the use of "special" accessory installation fixtures and templates that are not available to the Retailers or general public. Please refer to the Retailer Installation Instructions found in Subaru Tech Info System (STIS).

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Inspect the Body Side Molding Kit for missing or defects parts. Refer to the AQA Levelling guide for questions concerning paint or part defect levelling prior to installation. Questions please ask your Supervisor.



	<b>STOP:</b> Damage may occur to the vehicle/part. Do not proceed until process has been complied with.
	<b>Work Hazard Analysis (WHA):</b> Operator safety-Use caution to avoid risk of injury.
	<b>Caution:</b> 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.
	<b>Revision Mark/Highlight:</b> This mark highlights a change in installation with respect to the previous issue.
	<b>Work Instruction Training (WIT):</b> Key point that designates an important step to ensure the quality of the installation.
	<b>Recycle:</b> Item to be recycled.
	<b>Safety Torque -</b> This mark indicates that a torque is related to safety

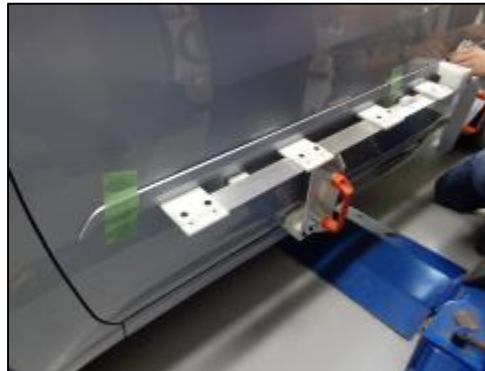
## Required Tools and Supplies:

- Infrared Temperature Gun
- Clean Towels (minimum 3)
- 99% Alcohol Cleaner
- Window Cleaner if extremely dirty painted surfaces may be required.
- (2) Body Side Molding Installation Fixtures, RH and LH sides.



Rubber Roller for Installation

Optional not required



**Ensure the body temperature is within 60° to 110°Fahrenheit which is a standard requirement for all parts using 3M® double sided tape to affix the part to the vehicle.**



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1. Clean the side of the vehicle where the fixture and the body side moldings will be installed using 99% Alcohol and a clean towel.
2. Dry the vehicle surface with a clean dry towel.
3. Only clean and dry one side (Front and Rear Doors) at a time.



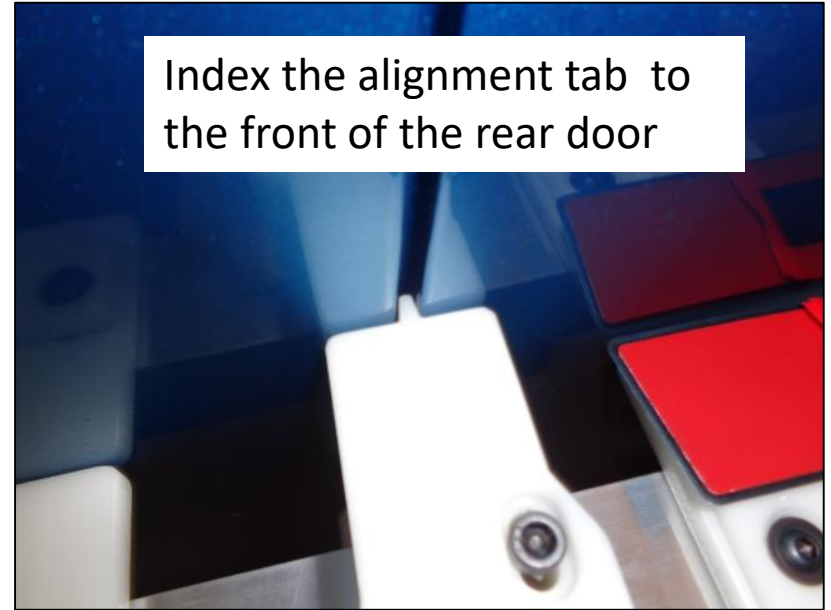
Note: The adhering surface must be clean and dry at all times.

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1. Carefully insert the lower feet of the BSM fixture. Be careful not to contact the body panels or drag the foot edge along painted surfaces.
2. Align the alignment lower tab and upper tab with the opening between the rear edge of the front door and the leading edge of the rear door (B-Pillar).
3. Index the upper alignment tab to the front of the rear door.



Index the alignment tab to the front of the rear door



Driver's Side Shown



To ensure a scratch free BSM installation always ensure the BSM fixture is clean especially the areas that attach to the vehicle. Magnetic attachment points will attract metal shavings and must be inspected and cleaned if necessary with each use.

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1. Index the upper alignment tab to the front of the rear door.

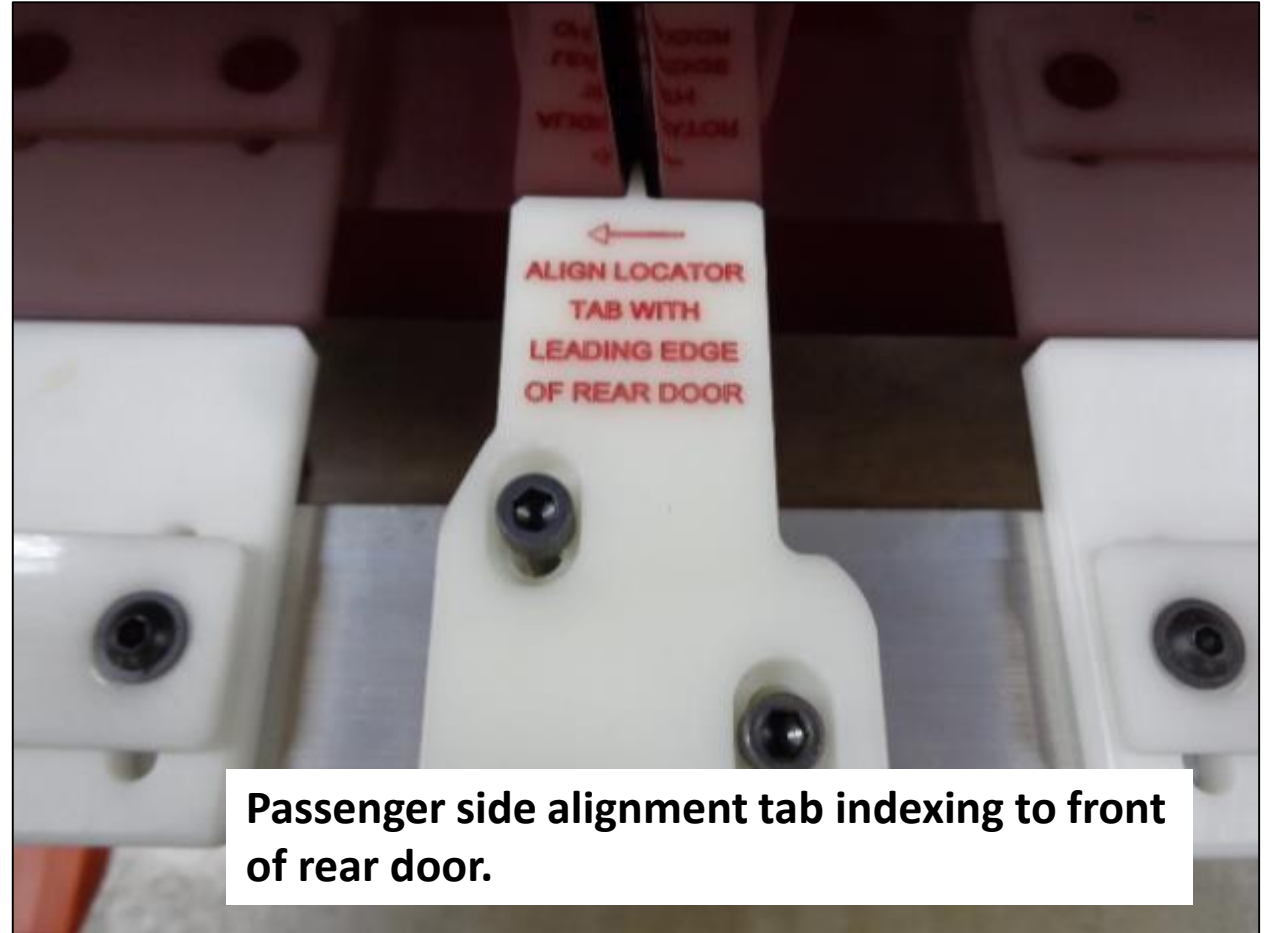
Index Direction

Driver's Side


Rear Door  
Leading Edge

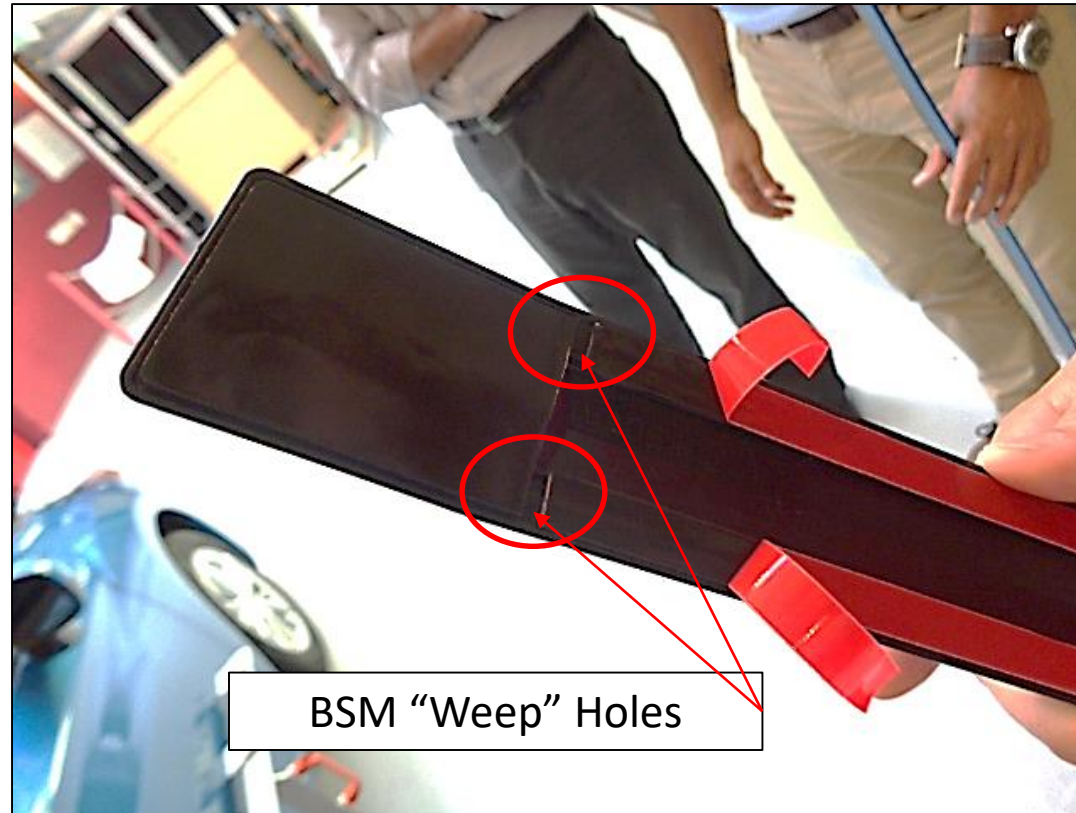
Rear Door  
Leading Edge

Passenger Side



Passenger side alignment tab indexing to front of rear door.

 Note: The Body Side Molding (BSM) sections have spaces between the tape sections for moisture and dust removal between the BSM and the door painted surfaces. This is a normal condition. The BSM is designed with the “Weep” holes.

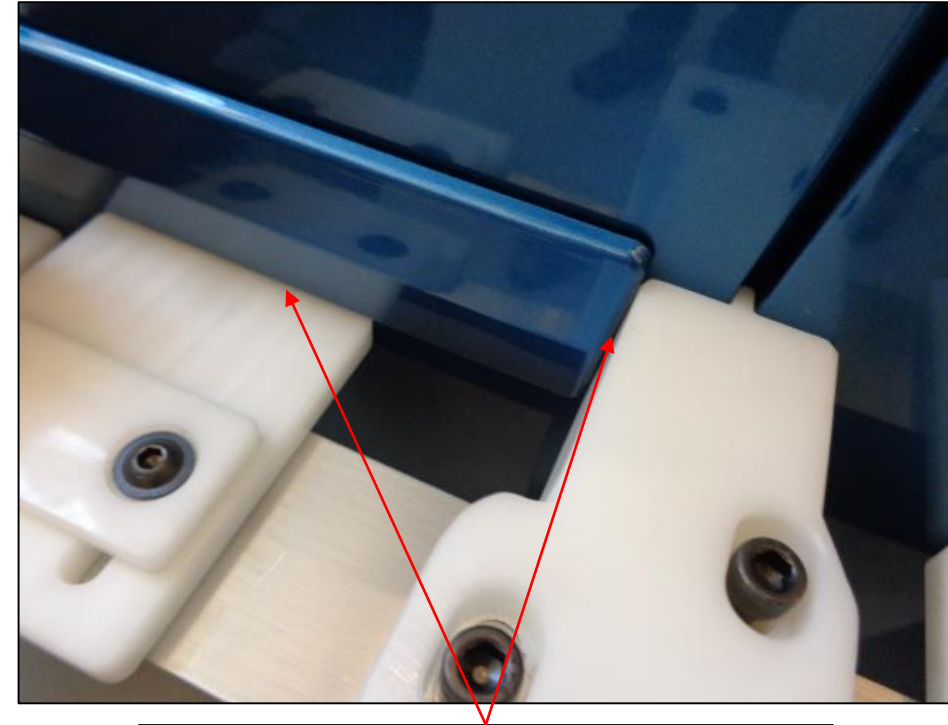


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1. Remove the double sided tape covering on the front door BSM and carefully lean the BSM section to the bottom flush against the fixture with the starting edge flush against the indexing tab.
2. Install the rear BSM in the same order as the front section.
3. Lightly press both in place.



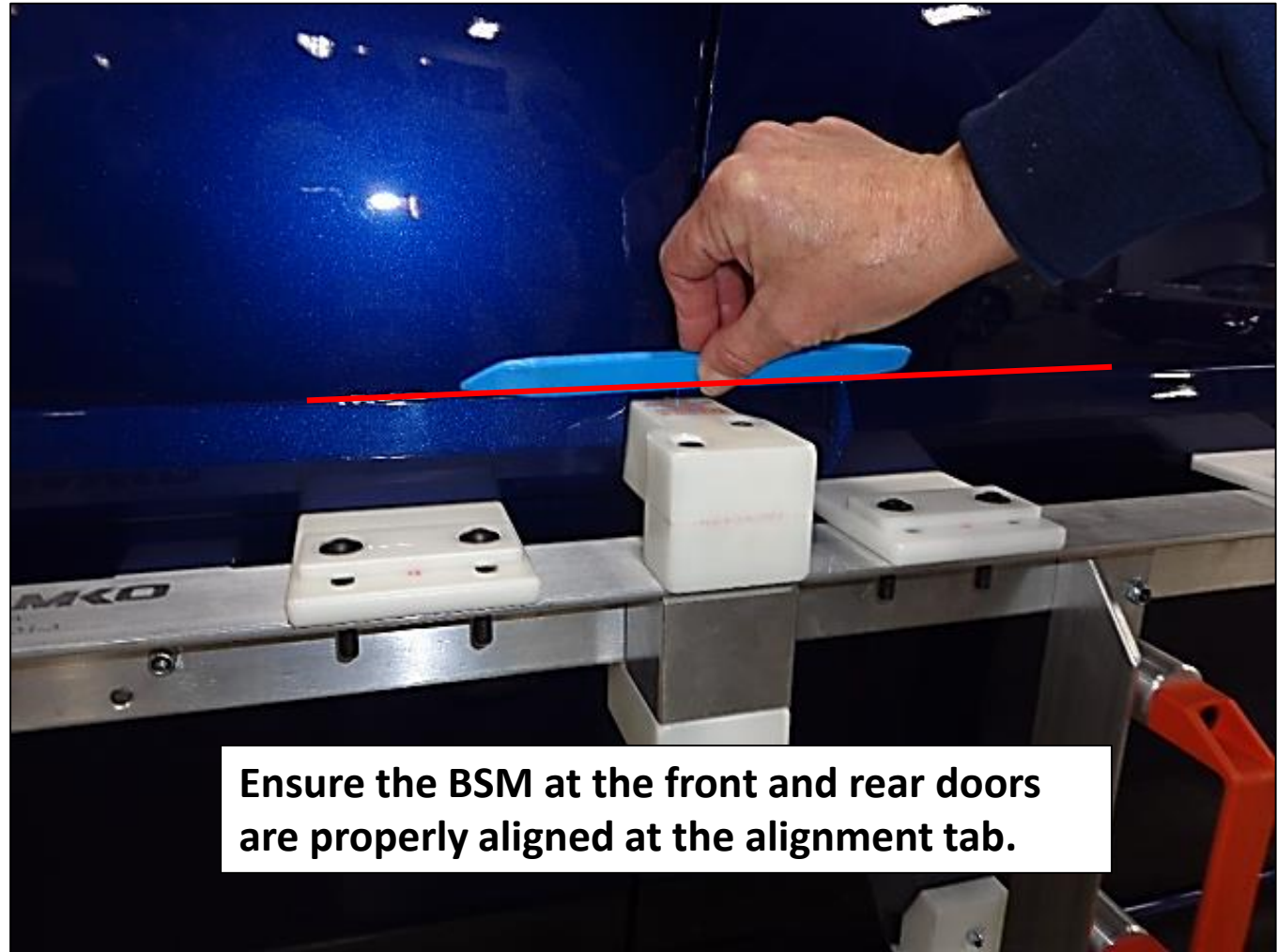
Apply light pressure across the entire



BSM flush (seated) areas to ensure a proper installation

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- Ensure the front and rear body side molding pieces are properly aligned at the alignment tab starting points on the template by using a nylon trim tool to bridge the gap between the front and rear door body side molding sections.



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1. Carefully Remove the BSM fixture by using the grab handles and pulling straight.
2. Apply light pressure across the entire BSM section using a clean dry towel or a roller. Be careful not to apply too much pressure or accidentally scratch the BSM or body painted surface.
3. Repeat the process for the opposite side of the vehicle. Ensure you are using the correct BSM fixture.



**The Roller Is Optional Depending on Processor Preference**

## Check Your Work Validation

### **Check Your Work:**

- Ensure the BSM is fully seated in place by observing all parts that were installed.
- Ensure the parts are defect free, no scratches or paint chipped edges, etc.
- Ensure the BSM is straight by sighting down each side of the vehicle.
- Ensure good color match.
- Ensure all surfaces are clean and defect free.

