

TH01

Molding, Bodyside



1. Description

This procedure describes methods for repairing and replacing bodyside molding. Inspection and evaluation requirements are also included.



2. Purpose

The purpose of this procedure is to provide industry-accepted requirements for performing high-quality repair of bodyside moldings. This procedure is intended for use by professionals who are qualified through training and experience.



3. Referenced Documents

The following documents are considered part of this procedure by reference.

3.1 Procedures

PS01 Personnel Safety

3.2 Other Information

Equipment-specific information
Product-specific information
Recycled parts information
Vehicle-specific repair information



4. Equipment And Material Requirements

4.1 Equipment

The use of this equipment is included in this procedure:

- flexible, thin-bladed knife
- piano wire
- heat gun
- die-grinder
- clip removal tools
- pneumatic molding removal tool

4.2 Materials

The use of these materials is included in this procedure:

- non-abrasive disc
- adhesive foam tape
- adhesive cleaner
- magnetic strips



5. Damage Analysis

5.1 General Damage

Inspect bodyside moldings for these conditions:

- visible damage
- loose or improper mounting or adhesion
- missing sections
- damaged or missing clips
- corrosion
- improper previous repairs

Determine if the molding can be repaired or requires replacement. Some moldings contain a metal insert or backing that may not allow for a permanent repair if they are twisted, bent, or have curled ends. Verify the availability of replacement parts.



6. Personnel Safety

6.1 General Safety

General safety information is in **PS01**.



7. Environmental Safety

Does not apply.



8. Vehicle Protection

8.1 Molding And Adjacent Areas

To protect the molding and adjacent areas when replacing moldings:

- Avoid permanent contact between dissimilar metals, such as aluminum and steel, to avoid galvanic corrosion.
- Protect adjacent areas when removing molding with a blade or wire tool.
- Do not use a disc grinder to remove a molding.
- Apply only a thin film of liquid adhesive when bonding a molding to avoid squeeze-out or drips.
- Follow the vehicle and paint makers' recommendations for the amount of time to wait before applying tape or magnetic strips to a newly applied finish.
- For proper performance, do not apply bonded moldings when the temperature is below 16° C (60° F). Ideally, the surface temperature should be 16–27° C (60–80° F).



9. Repair Procedure

For repairing a taped-on molding using adhesive, see **9.1**. For replacing a taped-on molding, see **9.2** and **9.3**. For replacing a clip-on molding, see **9.4** and **9.5**. For replacing a mechanically fastened molding, see **9.6** and **9.7**.

9.1 Taped Molding Repair Using Adhesive

To repair a molding, originally installed with tape, using adhesive:

- 1. Clean the repair area with pH-neutral soap and water. Wipe dry.
- 2. Remove any adhesive residue with adhesive remover. If the tape is still intact do not remove it. If the tape is damaged, see **9.2** and **9.3** for molding replacement.
- 3. Align the molding on the panel using a straightedge or existing moldings. Mark reference points with masking tape, if required.
- 4. Apply a thin film of adhesive to the molding backside and press the molding in place. Follow the adhesive maker's recommendations for cure time.

9.2 Taped Molding Removal

To remove a molding installed with tape:

- 1. Apply masking tape to the adjacent surface to protect the finish.
- 2. Carefully separate the foam tape, using appropriate tools to remove the molding.
- 3. Remove the protective masking tape.
- 4. Remove the tape and adhesive residue from the panel, and the molding backside if reusing the molding.
- 5. Clean the panel with pH-neutral soap and water. Wipe dry.
- 6. Clean the panel with wax and grease remover.

9.3 Taped Body Panel Molding Installation

To install a taped molding:

- 1. Align the molding on the panel using masking tape, a straightedge, or existing moldings. Mark reference points with masking tape, if required. Make sure the molding does not overlap panel edges, lock cylinders, etc. Check for adequate clearance of door or other closure panel moldings to adjacent panels when opening doors.
- 2. Apply the replacement tape to the molding.
- 3. Peel the tape backing from the front end of the molding and position the molding on the panel, aligning it with the reference points.
- 4. Press the molding to the panel while removing the tape backing to assure proper tape adhesion. Verify proper clearance of door or other closure panel moldings to adjacent panels.

(cont'd)



9. Repair Procedure (cont'd)

9.4 Clip-on Molding Removal

To remove a molding installed with clips:

- 1. Remove any through-fasteners holding the molding to the panel.
- 2. Separate any tape holding the edges of the molding. See **9.2**.
- 3. Determine how the clips are attached to the molding and the vehicle, using vehicle-specific information if available, and remove the molding from the clips.
- 4. Remove the clips from the panel. Replace any damaged or missing clips.
- 5. Clean the panel and the existing molding (back side), if it will be reused, using adhesive remover.
- 6. Clean the surfaces with pH-neutral soap and water. Wipe dry.

9.5 Clip-on Molding Installation

To install a clip-on molding:

- 1. Attach the clips to the body panel.
- 2. Apply tape to the molding, if required.
- 3. Attach the molding, making sure to engage all the clips. Make sure the tape is pressed down the full length of the molding.
- 4. Install through-fasteners, if required.

9.6 Mechanically Fastened Molding Removal

To remove molding that is mechanically fastened:

- 1. Remove the fasteners holding the molding to the panel. Replace any damaged or one-time fasteners with the same type, grade, and size.
- 2. Separate any tape, if required. See **9.2**.
- 3. Remove the molding from the vehicle.
- 4. Clean the panel and the existing molding (back side), if it will be reused, with the proper surface cleaner.
- 5. Clean the surfaces with pH-neutral soap and water. Wipe dry.

9.7 Mechanically Fastened Molding Installation

To install a mechanically fastened molding:

- 1. Align the replacement molding to the panel, making sure the fastener holes match the existing panel holes.
- 2. Apply replacement tape to the molding, if required. Remove the tape backing.
- 3. Position the replacement molding on the panel, aligning it to the existing holes.
- 4. Install the fasteners.



10. Use Of Recycled (Salvage) Parts

10.1 Condition Of Salvage Parts

Do not use salvage molding with these conditions:

- unrepairable damage
- damaged or missing mounting locations
- corrosion that has caused pitting



11. Inspection And Testing

11.1 Inspection Of Replaced Bodyside Molding

After replacement, inspect the molding for these conditions:

- proper adhesion
- no adhesive squeeze-out
- all fasteners and clips installed
- proper alignment and appearance
- proper operation of all closure panels

Correct any defects.