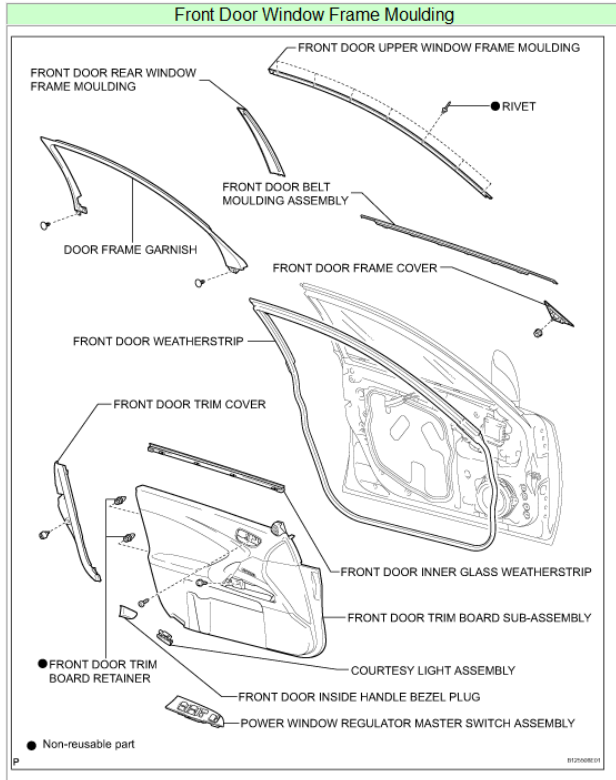


2007 Lexus IS 250 RWD V6-2.5L (4GR-FSE)

Vehicle Level → Body and Frame → Doors, Hood and Trunk → Front Door Moulding / Trim → Service and Repair → Front Door Window Frame Moulding

Front Door Window Frame Moulding

FRONT DOOR WINDOW FRAME MOULDING



Zoom

Sized for Print

REMOVAL

1. REMOVE FRONT DOOR INSIDE HANDLE BEZEL PLUG
2. REMOVE POWER WINDOW REGULATOR MASTER SWITCH ASSEMBLY
3. REMOVE COURTESY LIGHT ASSEMBLY
4. REMOVE FRONT DOOR TRIM BOARD SUB-ASSEMBLY
5. REMOVE FRONT DOOR INNER GLASS WEATHERSTRIP
6. REMOVE FRONT DOOR FRAME COVER
7. REMOVE FRONT DOOR BELT MOULDING ASSEMBLY
8. REMOVE FRONT DOOR TRIM COVER
9. REMOVE DOOR FRAME GARNISH
10. REMOVE FRONT DOOR WEATHERSTRIP
11. REMOVE FRONT DOOR REAR WINDOW FRAME MOULDING **HINT:** When installing the front door rear window frame moulding, heat the vehicle body and front door rear window frame moulding using a heat light.

Heating temperature:	
Item	Temperature
Vehicle Body	40 to 60°C (104 to 140°F)
Moulding	20 to 30°C (68 to 86°F)

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NOTICE: Do not heat the vehicle body and moulding excessively.

- a. Fully open the front door glass.
- b. Using a heat light, heat the front door rear window frame moulding.



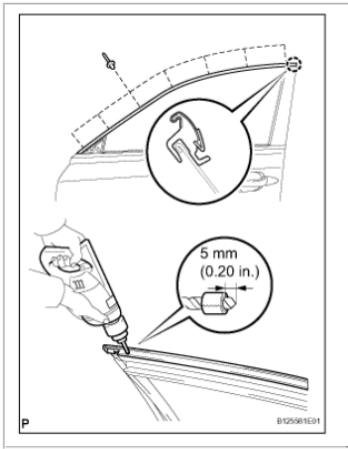


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- c. Using a moulding remover, remove the clip and front door rear window frame moulding.

12. REMOVE FRONT DOOR UPPER WINDOW FRAME MOULDING



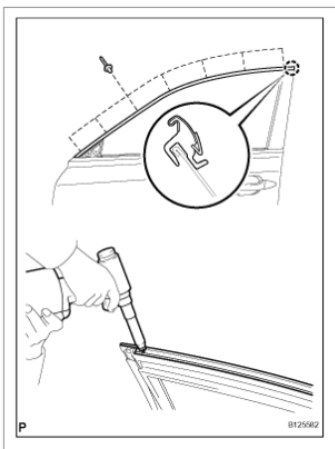
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- a. Put a **4 mm (0.16 in.)** drill bit into a drill.
- b. Tape the **4 mm (0.16 in.)** drill bit without the portion of **5 mm (0.20 in.)** from the tip covered. **HINT:** Tape the **4 mm (0.16 in.)** drill bit to prevent the drill bit from going too deep.
- c. Lightly press the drill against the rivets, drill off the flanges of the rivets, and remove the 7 rivets. **NOTICE:**
- Pressing the drill too firmly will cause the rivet to turn and result in the rivet not being drilled through.
 - Do not pry the rivets with the drill, because this may cause damage to the installation holes of the rivets or the drill bit.
 - Be careful of the drilled rivets as they may become hot.
- d. Using a vacuum cleaner, remove the rivet fragments and shavings from the drilled areas.
- e. Remove the front door upper window frame moulding from the door [frame](#).

INSTALLATION

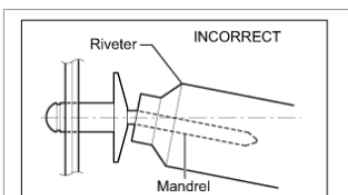
1. INSTALL FRONT DOOR UPPER WINDOW FRAME MOULDING



Zoom

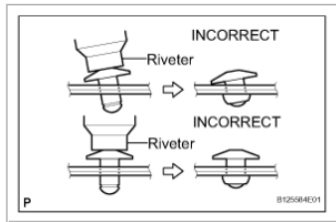
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- a. Engage the front door upper window frame moulding to the door [frame](#).
- b. Using an air riveter or hand riveter with a nose piece, install the front door upper window frame moulding with 7 new rivets. **HINT:** If the rivet cannot be cut, pull it once and cut it.

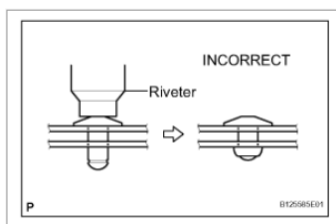


NOTICE:

- Do not pry the rivet with the riveter, as this will cause damage to the riveter and mandrel.



- Confirm that the rivets are seated properly against the moulding. Do not tilt the riveter when installing the rivet to the moulding. Do not leave any space between the rivet head and moulding.



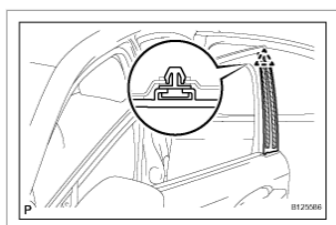
- Do not leave any space between the moulding and door [frame](#). Firmly hold together the 2 items while installing the rivet.
2. INSTALL FRONT DOOR REAR WINDOW FRAME MOULDING **HINT:** When installing the front door rear window frame moulding rear, heat the vehicle body and front door rear window frame moulding using a heat light.

Heating temperature:

Item	Temperature
Vehicle Body	40 to 60°C (104 to 140°F)
Moulding	20 to 30°C (68 to 86°F)

NOTICE: Do not heat the vehicle body and front door window frame moulding rear excessively.

- Clean the vehicle body surface.
 - Using a heat light, heat the vehicle body surface.
 - Remove the double-sided tape from the vehicle body.
 - Wipe off any tape adhesive residue with cleaner.
- Clean the front door rear window frame moulding. (If reusing the front door rear window frame moulding)
 - Using a heat light, heat the front door rear window frame moulding.
 - Remove the double-sided tape from the front door rear window frame moulding.
 - Wipe off any tape adhesive residue with cleaner.
 - Apply new double-sided tape to the front door rear window frame moulding.
- Install the front door rear window frame moulding.



- Using a heat light, heat the vehicle body and front door rear window frame moulding.
- Remove the peeling paper from the face of the front door rear window frame moulding. **HINT:** After removing the peeling paper, keep the exposed adhesive free from foreign matter.

3. Install the front door rear window frame moulding with the clip.
3. INSTALL FRONT DOOR WEATHERSTRIP
4. INSTALL DOOR [FRAME](#) GARNISH
5. INSTALL FRONT DOOR TRIM COVER
6. INSTALL FRONT DOOR BELT MOULDING ASSEMBLY
7. INSTALL FRONT DOOR [FRAME](#) COVER
8. INSTALL FRONT DOOR INNER GLASS WEATHERSTRIP
9. INSTALL FRONT DOOR TRIM BOARD SUB-ASSEMBLY
10. INSTALL COURTESY LIGHT ASSEMBLY
11. INSTALL POWER WINDOW REGULATOR MASTER SWITCH ASSEMBLY
12. INSTALL FRONT DOOR INSIDE HANDLE BEZEL PLUG
13. POWER WINDOW CONTROL SYSTEM INITIALIZATION