

Subject: **2007-2012 Lexus ES350 Window Clip Replacement**

1.0 Purpose

The following instruction details the tools and supplies required, and the steps for removing and replacing the broken window clip in your 2007-2012 Lexus ES350.

2.0 Tools and Supplies

- 2.1 Phillips screwdriver
- 2.2 Flathead screwdriver with tape over blade
- 2.3 Ratchet and deep 10mm socket (or equivalent length combination of socket and extension)
- 2.4 Razor blade(s) (supplied in kit)
- 2.5 Alcohol wipe(s) (supplied in kit)
- 2.6 Panel removal tool (not required but recommended)
- 2.7 Standard caulking gun
- 2.8 Disposable latex gloves or equivalent
- 2.9 3M Adhesive (supplied in kit)



3.0 Step 1 - Remove door panel

- 3.1 Open the door all the way. Give yourself plenty of room to work.



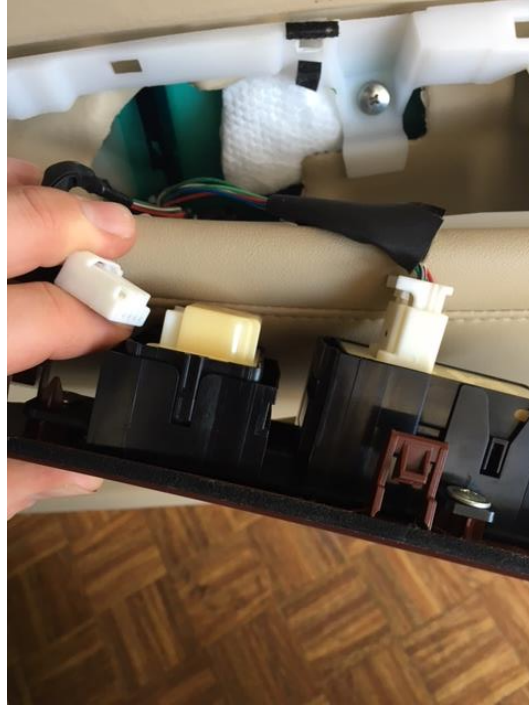
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- 3.2 Using the tape covered flathead screwdriver, pry the window/door lock control panel up and out of its location.



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- 3.3 Unclip the wiring harness plugs for the window and door lock controls. Set the control panel aside in a safe location.



- 3.4 Next remove the five phillips screws. See images below for locations. Set the screws aside in a safe place. Remember what hole each one came out of. They are all different.



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- 3.5 Once the five phillips screw are removed, use your panel tool (or your hands) to pry the door panel away from the door, starting at the bottom and working your way up the sides, finishing at the top.

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3.6 Next, unclip the wiring harness plug from the puddle lamp at the bottom of the door panel.



3.7 Finally remove the two phillips screws that secure the door latch handle and cables, to the door panel. Take care not to lose these in the door panel. The door panel is free now. Set it aside out of the way.



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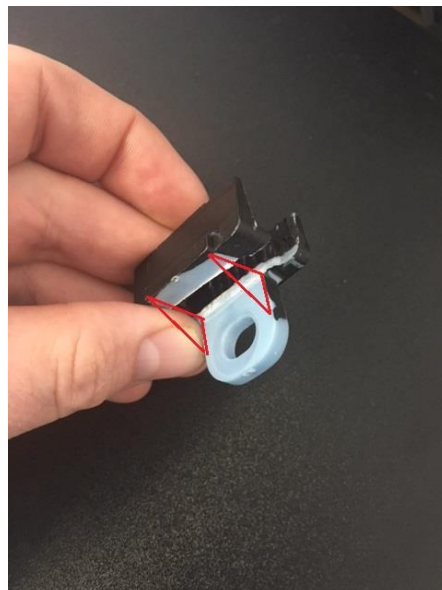
- 3.8 Next, if you are replacing the front-most clip, remove the four screws that hold the speaker in. Also, unclip the wiring harness plug from the speaker. Set the speaker aside in a safe location.



- 3.9 If you are replacing the rear-most clip, peel the plastic covering off the hole toward the rear so you can access the inside of the door.

4.0 Step 2 - Remove the old part

- 4.1 Once the door panel is removed, you can access the inside of the door. You should see that your window clip is broken (if it isn't what are you doing?). The following instructions are general because each clip breaks differently.



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- 4.2 Unbolt the tab of the clip from the window regulator arm. Set the bolt aside in a safe place.



- 4.3 If the parts of the clip are still partially or totally adhered to the glass, use a razor blade to cut the adhesive behind the plastic, setting the plastic free.
- 4.4 Once the plastic parts are removed, use a fresh razor blade to scrape the glass clean. It's okay if there are tiny remnants of old adhesive. Just try to get >95% of the old adhesive off.



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- 4.5 Wipe both sides of the glass with the provided alcohol wipes. Now you're ready to install the new clip.

5.0 Step 3 – Install the new part

- 5.1 Once the area is clean, test fit the new part. It looks great doesn't it?



- 5.2 Remove the part and set it aside. Open the tube of adhesive and puncture the seal using the point on the top of the cap.

NOTE: Before extruding any adhesive, make sure to put on your disposable latex gloves. Trust me. The adhesive isn't corrosive or anything like that, but it gets everywhere and it is hard to get off of your skin.

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- 5.3 Holding your part in one hand, or in a bench vise or similar fixture, fill the entire groove with adhesive. More is better.



- 5.4 Once the groove is filled, you're ready to install the part.
- 5.5 Hold the part up in front of the glass and approximate its location.
- 5.6 Using one hand to push the regulator arm back, slide the clip up and onto the glass, allowing the glass to come to rest gently on the bottom of the groove.
- 5.7 Allow the regulator arm to come forward, centering the hole in the clip over the bolt hole on the regulator arm.



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- 5.8 Inspect the adhesive looking for spots where more can be added. If necessary, use your finger or a popsicle stick or similar tool to spread additional adhesive around the part. This is really just a judgement call.

Note: The adhesive in this application is a damper (absorbs vibration) and a bonding agent so don't be afraid to use extra

- 5.9 Retrieve the regulator arm bolt, thread into the regulator arm, and tighten to roughly hand snug plus 1/4 - 1/2 turn.



- 5.10 **Allow adhesive to cure for 24 hours before operating the window.** Once 24 hours has elapsed you may test your work by cycling the window up and down.
- 5.11 When you are done testing, install the door panel in the reverse of the steps that you followed for removal.

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6.0 Step 4 – Reset “pinch protection” or “auto-up/down” - only if window controls are not working properly

6.1 Condition1: If the driver’s side switch for the passenger front window doesn’t work, and the tiny lights on the window switches are blinking rhythmically

- 6.1.1 Turn the car on and sit in the passenger seat.
- 6.1.2 Using the passenger side window switch, fully depress and hold the button to put the window down and hold the button in for an additional 5 seconds after the window has stopped moving.
- 6.1.3 Next, pull up on the switch to raise the window all the way to the top and hold the switch up for an additional five seconds after the window is all the way up.
- 6.1.4 Turn the car off and back on. The lights on the switches should no longer be blinking and all the window switches should operate normally.

6.2 Condition 2: If the window goes up then automatically comes back down when using the auto-up function

- 6.2.1 Remove door panel (if not already)
- 6.2.2 Reconnect window switch (if not already)
- 6.2.3 While operating the window, with the window traveling upward, disconnect the electrical plug from the window motor – you will actually pull the plug out of the motor as the window is going up
- 6.2.4 Reconnect the plug to the window motor
- 6.2.5 Open the window all the way, holding the switch down for 3 seconds after the window is all the way down
- 6.2.6 Close the window all the way, holding the switch down for three seconds after the window is all the way up
- 6.2.7 The auto-up and auto-down feature should work again