



**Technical Service
Information Bulletin**

October 23, 2006

Title:
WINDOW FRAME MOLDING RATTLE

Models:
'03 – '07 GX 470

NV006-06
NVH

Introduction Some customers may experience a rattling, ticking, or wind noise coming from the sides of the vehicle at higher speeds. The rear piece of the front door window frame moldings may have come loose causing the noise. Use the following procedure to correct this condition.

- Applicable Vehicles**
- **2003 – 2007** model year **GX 470** vehicles produced **BEFORE** the Production Change Effective VIN shown below.

MODEL	PRODUCTION CHANGE EFFECTIVE VIN
GX 470	JTJBT20X870126655

PREVIOUS PART NUMBER	CURRENT PART NUMBER	PART NAME	QTY
75755-60030	Same	Molding, FR Door Window Frame, RR RH	1
75756-60030	Same	Molding, FR Door Window Frame, RR LH	1

TOOLS & MATERIAL	QUANTITY
Heat Light or Heat Gun	As Needed
3M General Purpose Adhesive Cleaner	As Needed

OP CODE	DESCRIPTION	TIME	OFP	T1	T2
NV5023	R & R Front Door Rear Window Frame Molding	0.4	75755-60030	91	15
Combo A	Opposite Side	0.4	75756-60030		

Applicable Warranty*:
This repair is covered under the Lexus Comprehensive Warranty. This warranty is in effect for 48 months or 50,000 miles, whichever occurs first, from the vehicle's in-service date.

* Warranty application is limited to correction of a problem based upon a customer's specific complaint.

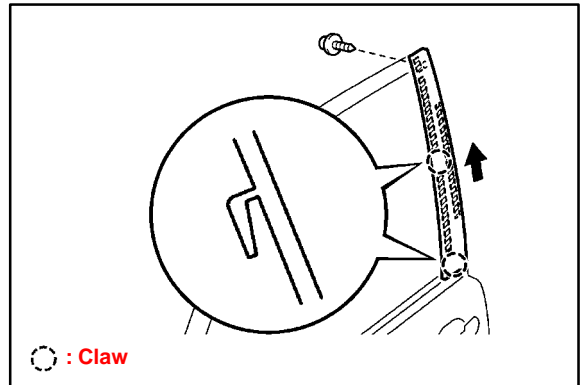


Repair Procedure

1. Tape off the leading edge of the rear pieces of the front door window frame and road test to confirm this as the source of the noise.
 - If the noise is gone, replace the rear piece of the window frame molding.
 - If the noise is NOT gone, this TSIB does NOT apply.

2. Remove the front door window frame molding rear.
 - A. Remove the screw.
 - B. Using a heat light (or heat gun), heat the molding between 104° – 140°F (40° – 60°C).

NOTE:
Do NOT heat the molding excessively.



3. Slide the molding upward to remove it.
4. Install the NEW front door window frame molding.
 - A. Clean the contact surface of the body using 3M General Purpose Adhesive Cleaner.
 - B. Using a heat light (or heat gun), heat the body and molding.
Body: 104° – 140°F (40° – 60°C)
Molding: 68° – 86°F (20° – 30°C)

NOTE:
Do NOT heat the body and molding excessively.

- C. Remove the peeling paper from the molding face.

HINT:
Be careful that dirt or foreign objects do not stick to the adhesive part when releasing the peeling paper.

- D. Engage the 2 claws and install the molding with the screw.
 - E. Press the molding down to ensure the adhesive tape creates a good bond.

NOTE:
Do NOT apply excessive force onto the molding, but apply steady pressure with your thumbs.

5. Road test the vehicle to confirm that the noise has been corrected.