

INSTALL/REMOVAL INSTRUCTIONS: WINDOW REGULATOR

ATTENTION: Refer to the appropriate shop manual for your vehicle to obtain specific service procedures for this part. If you do not have a service manual or lack the skill to install this part, it is recommended that you seek the services of a qualified technician. Pay special attention to all cautions and warnings included in the shop manual. Read and follow all instructions carefully.

REMOVAL/INSTALL OF WINDOW REGULATOR (751-015) Saturn ION 2003–07

General Tech Tips:

- Use painter's tape rather than duct tape to secure window. It will not damage paint or leave sticky residue.
- A plastic pry tool is useful. It will not easily damage delicate trim like a screwdriver or metal pry bar.
- The replacement regulator should have a liberal amount of grease on slide area. If there is not much grease present, white lithium grease works well to lubricate the slide area.
- Aftermarket window tinting can cause the window to travel slower and put additional strain on the window regulator assembly.
- Window run channels should be cleaned and lubricated before installation of a new window regulator assembly. Silicone spray works well.

**PLEASE WEAR SAFETY
GLASSES!**

Tools required for removal and installation of window regulator and motor assembly:

- **Silicone spray lubricant**
- **Trim panel removal tool**
- **Pick**
- **Saddle cup assembly, tape or wedge to hold window in place**
- **Flat-blade screwdriver or plastic pry tool**
- **10 mm socket or driver**
- **Phillips screwdriver**
- **Grease pencil or marker**
- **Razor blade or knife (optional)**



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Removal Instructions

STEP 1: Lower the window regulator into the down position.

STEP 2: Using your trim panel removal tool, remove the rear view mirror cover assembly.



STEP 3: Remove the master power switch/ interior door trim panel attaching screws.



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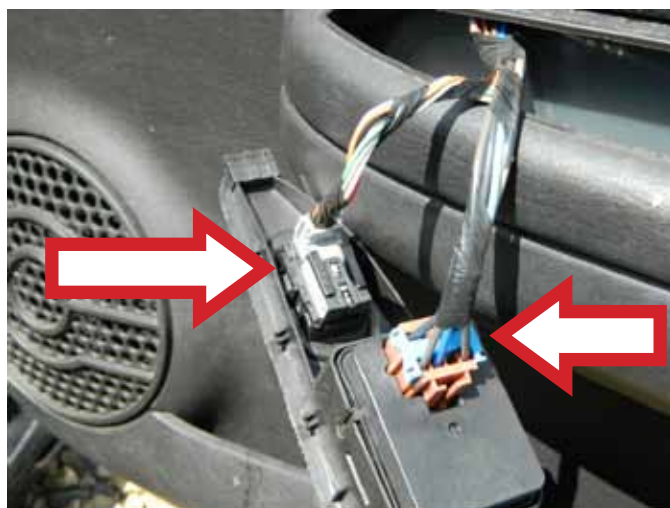
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STEP 4: Using the trim panel removal tool, separate the master power switch assembly from the interior door trim panel.



STEP 5: Disconnect the master power switch assembly from the door harness.



STEP 6: Using your trim panel removal tool, place the tool between the interior door trim panel and the door to release the interior door trim panel retaining clips.

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STEP 6a: Remove the interior door trim panel.



STEP 7: Remove the interior door trim panel support. **NOTE:** Instead of removing the trim panel support you could trim around it using a razor blade or knife. Some vehicles had the support riveted on from the factory, while others were attached by screws.



STEP 8: Remove the water vapor barrier assembly.



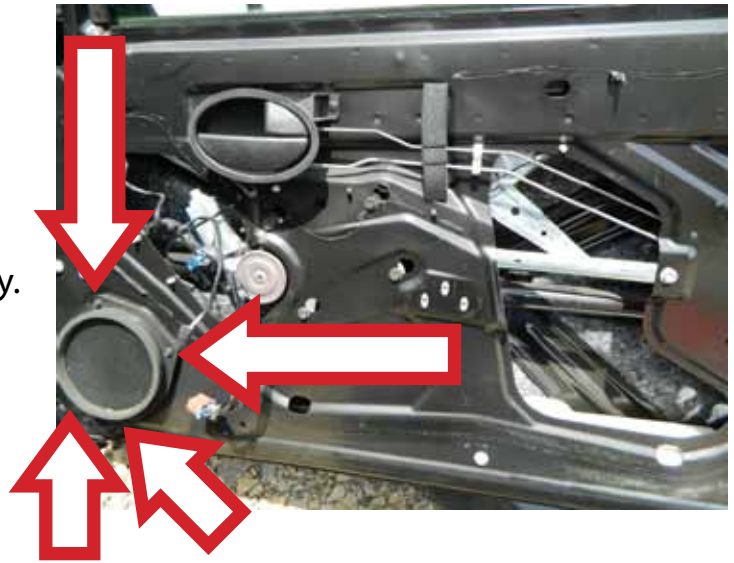
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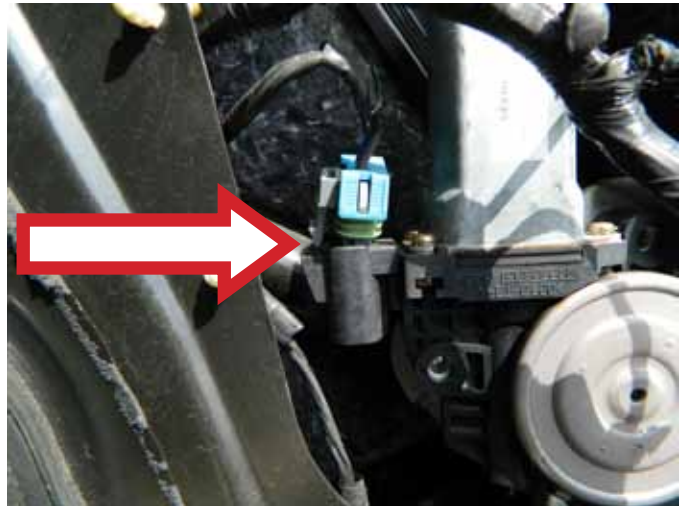
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STEP 9: Remove the door speaker assembly.



STEP 10: Disconnect the power window lift motor connector.



STEP 11: Remove the attaching bolts holding the window glass onto the power window regulator.

STEP 12: Manually lift the window glass into the up position. Hold the glass in place with either the saddle cup assembly, painters tape, or wedge.

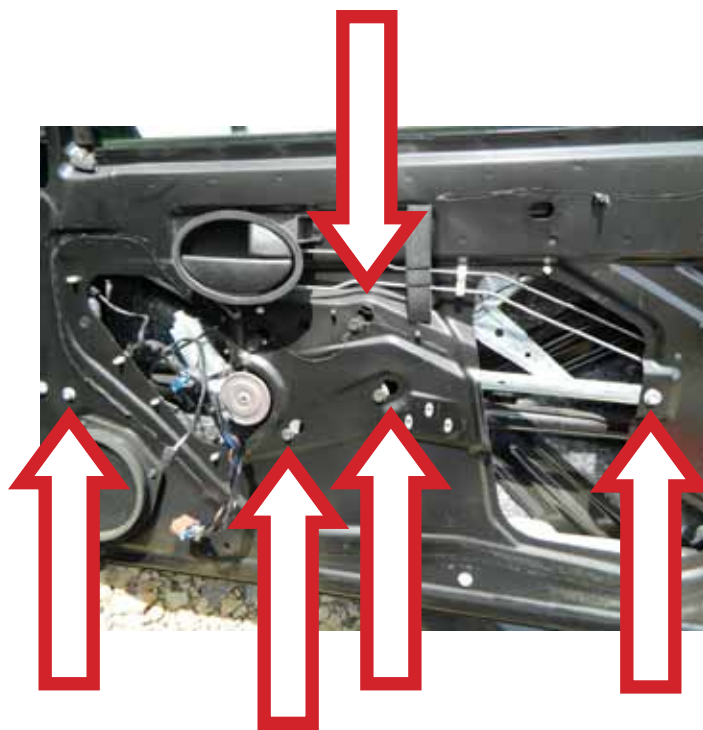
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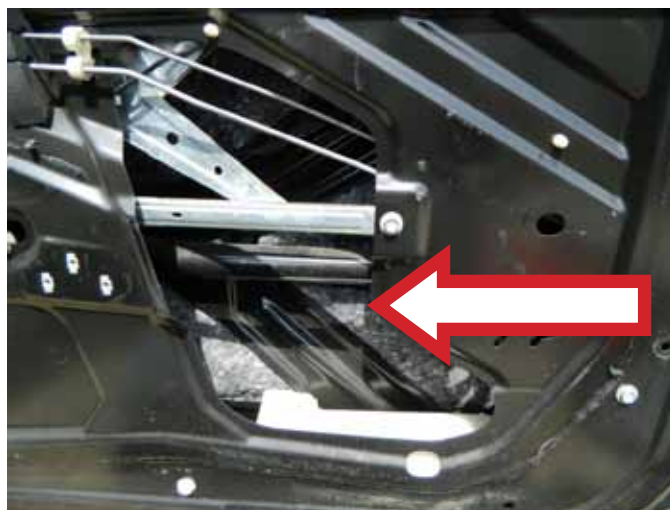
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STEP 13: Remove the power window regulator attaching bolts.



STEP 14: Remove the window regulator assembly through the large access hole.



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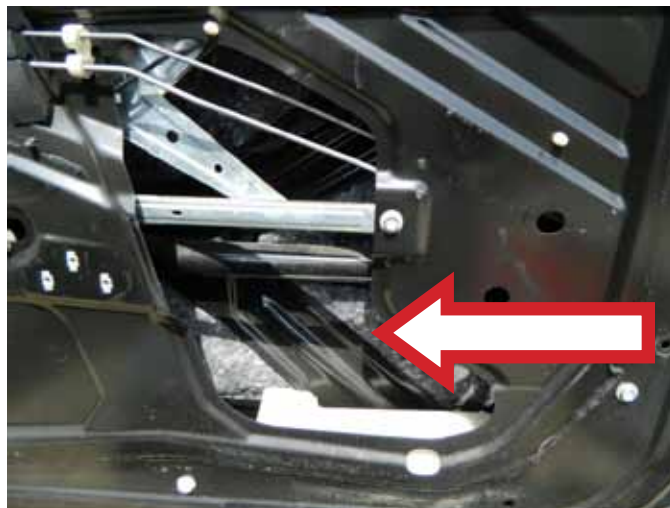
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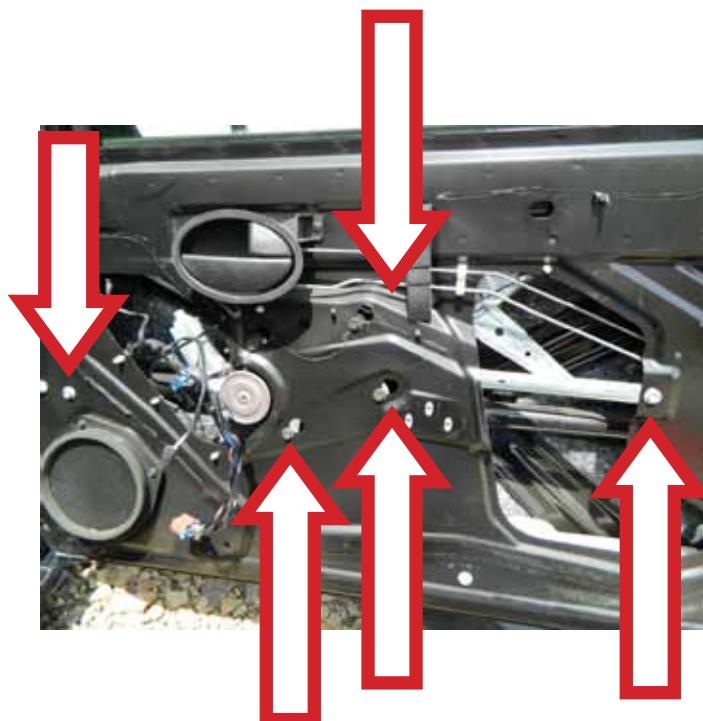
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Installation Instructions

STEP 1: Install the window regulator assembly through the large access hole.



STEP 2: Loosely mount the window regulator in place.



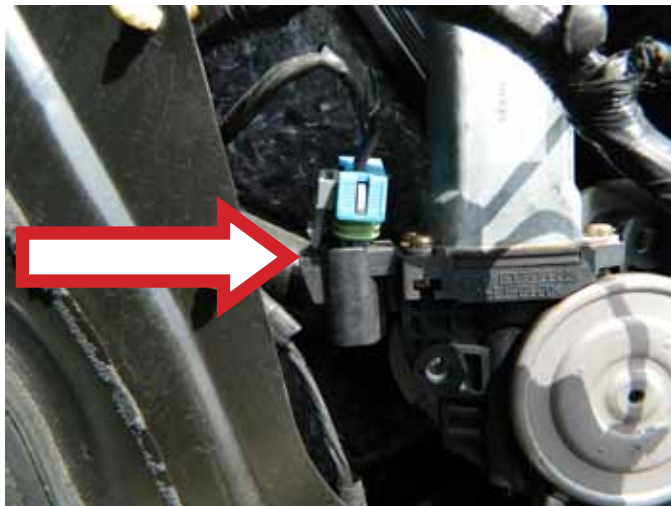
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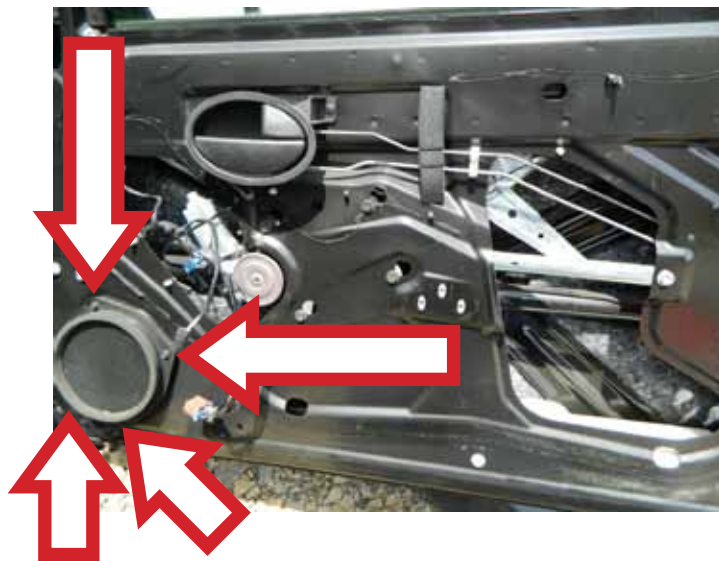
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STEP 3: Connect the power window lift motor.



STEP 4: Install the door speaker assembly.



STEP 5: Temporarily install the master power switch assembly, at this time lower the power window regulator into the down position.

STEP 6: Gently lower the window glass to align the attaching points on the window regulator and attach the window glass to the regulator. **NOTE:** Be careful not to over tighten the mounting bolts, failure to do so will result in broken glass.

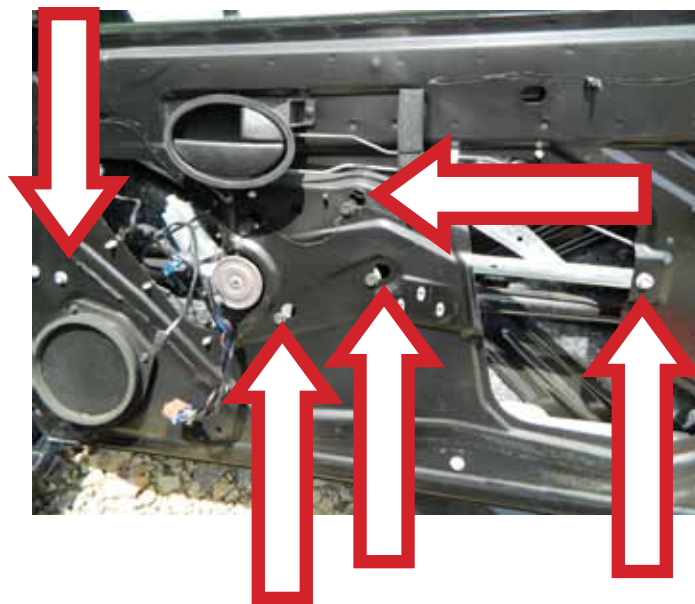
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STEP 7: Tighten the power window regulator attaching bolts.



STEP 8: With the power window regulator installed, operate the window in the up position and then into the down position, verifying that the power window regulator is operating properly.

STEP 9: Remove the master power switch assembly.

STEP 10: Install the water vapor barrier assembly.



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STEP 11: If you removed the interior door trim panel support re-install with either the attaching screws or rivets.



STEP 12: Install the interior door trim panel.
NOTE: Route the master power switch wiring as well as the door lock switch through the opening in the interior door trim panel.



STEP 13: Install the interior door trim panel, be sure to align all of the interior door trim panel retainers before pressing the panel into place.

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STEP 14: Connect the master power switch assembly to the door harness.



STEP 15: Install the master power switch assembly into the interior door trim panel.



STEP 16: Reattach the rear view mirror cover assembly.

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STEP 17: Attach the two (2) master power switch/interior door trim panel attaching screws.



STEP 18: Verify that the power window assembly is operating properly and that the door panel is sitting flush.

**We appreciate your opinions regarding this product!
Please call our Technical Assistant with any challenges or suggestions
regarding the installation or operation of this product.**

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