## NOT TO BE USED, DISCLOSED OR REPRODUCED WITHOUT PERMISSION. PROPERTY OF THE FREEDMAN SEATING COMPANY.

	0774	PART #	DESCRIPTION
TEM 1	qty 1	CEE CHADT 1	WELDMENT, SEATBASE, 3PT, SS
2	+	26411	WELDMENT, FLOORMOUNT, 3PT, SS
3	<u> </u>	SEE CHART 1	
4	i	26415	WELDMENT, TRUSS, 3PT
5	1	26470	ROD. CONTROL. 3PT
6	1	26473	TUBE, TRUNION, 3PT
7	1	26472	TUBE, PIVOT, LOWER
8	1	38707	WELDMENT, PLATE, SIDE, AISLE, 3PT, SS
9	1	38703	WELDMENT, PLATE, SIDE, WALL, 3PT, SS
10	1	26469	PLATE, HANDLE, 3PT, SS
11	2	26466	PLATE, LOCK, CAM, 3PT
12	1	31347	FLEX-0-LATOR, BV
13	12	53962	OYSTER, U, CLIP
14	12	55859	SPRING, FLEX-O-LATOR, BV
15	1	99500	8-32 x 1 1/4 PHILLIPS PAN HEAD MACHINE SCREW, ZP
16	1	99113	SPLIT COTTER PIN, 3/16 X 2, ZP
17	1	21090	WELDMENT, LOCK MECH.
18	1	21091	WELDMENT, LOCK MECH.
19	1	21107	SPRING, RETURN
20	1	21108	SPRING, RETURN
21	6	9422301	1/2-13 PREV TORQUE HEX CONICAL TOP LOCKNUT, GR8, ZP
22	2	180124	3/8 - 16 X 1 1/4 HEX HEAD BOLT, GR 5, ZP
23	10	56408	BLACK SILICONE ADHESIVE
24	2	55965	3/8 I.D. X 1/2 LG. BLACK PLASTIC CAP
25	2	21214	RED PLASTIC COVER RECTANGLE
26	1	21210	GAS SPRING
27	2	21205	FITTINGS, BALL END
28	3	9422275	5/16 LOCK NUT, PREV TORQ, GR 5, ZP
29	1	21213	RED PLASTIC COVER, 1/2 X 1/4 X 1
30	3	180122	3/8 - 16 X 1 HEX HEAD BOLT, GR 5, ZP
31	1	180128	3/8 - 16 X 1 3/4 HEX HEAD BOLT, GR 5, ZP
32		99334	7/16-20 X 1.25 HEX HEAD BOLT, GR8, BLACK OXIDE
34			
35			
36	10	99325	7/16 - 20 PREV TORQUE HEX CONICAL TOP LCKNUT, GR C, BO
37	4	9422277	3/8-16 PREV TORQUE LOCK NUT, GR5, ZP
38	2	454979	7/16 - 20 X 2 1/2 HEX HEAD BOLT, GR 8, ZP
39	1	99474	7/16 - 20 X 2 1/2 TIEX TIEAD BOLL, GR 6, 2F 7/16 - 20 X 1 1/4 X 3/4 SPECIAL THREAD, HHCS, G8, B/0
40	1	455002	1/2 - 13 X 2 1/2 HEX HEAD BOLT, GR 8, ZP
<u> 40</u>		<del>4</del> 33002	1/2 - 13 x 2 1/2 HEX HEAD BULL, GR O, ZP

			CHA	IRT 1
	ITEM	QTY	PART #	DESCRIPTION
ASSY, 3PT FOLDAWAY, HI-BACK, 2PL, SS	1	1	26403	WELDMENT, SEATBASE, 3PT, SS
PART# 26501	3	1	26503	WELDMENT, SEAT BACK, 3PT, HI-BACK, SS
FARI# 20001	66	1	1001-186	COVER, 3PT FOLDAWAY, BACK, HI BACK, SS
	67	1	1000-186	COVER, 3PT FOLDAWAY, SEATBASE, SS
	1	1	26535	WELDMENT, SEATBASE, 3PT, CRS, SS
ASSY, 3PT FOLDAWAY, CRS, HI-BACK, 2PL, SS	3	1	26541	WELDMENT, SEAT BACK, 3PT, HI-BACK, CRS, SS
PART# 26529	66	1	1001-189	COVER, 3PT FOLDAWAY, BACK, HI-BACK, CRS, SS
	67	1	1000-189	COVER, 3PT FOLDAWAY, SEATBASE, CRS, SS

NOTE(S): 1) ASSE	EMBLED SEAT	WEIGHT IS	105 LBS.	
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PAGE	1	٥F	5	
PAGE	- 1	UΓ	J	

P	ADD 99063, 71728, 99015; UPDATE 120396 QTY	LH	2/19	742		NOTE(S): 1) ASSEMBLED	NOTE(S): 1) ASSEMBLED SEAT WEIGHT IS 105 LBS.												
N	ADDED QTY TO 99324	JL	8/18	7039		NOTE(S): 1) ASSEMBLED SEAT WEIGHT IS 105 LBS.													
M	REMOVE 70900	DN	11/14	4288	K	51126480 AND 51126474 WAS 26550;					Tolerances Unless Otherwise Specified	Material:		For a doc and Continue Co	4545 W. Augusta Blvd				
L	ADDED 52234590 TO BOM; 1001-186 WAS 26513					REPLACED 56603 WITH 27081 & 27082;				- 1	•			Freedman Seating Co.	Chicago, IL 60651				
	1000-186 WAS 26509; 1001-189 WAS 26547					REPLACED 56601 WITH 27079 & 27073	SC	11/11	2134		FRACTION 1/X ±1/32" DECIMAL .XX ±0.02"	Specifications:		Part Name ASSY, 3PT FOLDAWAY, HI-BACK,	טטו ככ				
	1000-189 WAS 26543	EAR	08/12	26	22 J	(20 21/32) WAS 20 21/32; (10 1/32) WAS 10 1/32				"	.XXX ±0.005"	'		ASSI, SPI FULDAWAI, HI-BACK,	ZPL, 33				
Rev Lev	Description of Change	Ву	Date	ECN	# Rev	Description of Change	Ву	Date	ECN		ANGULAR ±1°	Drawn by: <sub>RW</sub>	Date: 09/21/04	DO NOT SCALE DRAWING Prowing No. 26501	Rev. P				

	ITEM	QTY	PART #	DESCRIPTION
1	41	1	427565	1/2 - 13 X 1 3/4 HEX HEAD BOLT, GR 8, ZP
A				
Æ	42	5	120396	1/2 SAE FLATWASHER, ZP
-	43	_		W /
- 1	44	4	99240	#8 X 3/4 SCREW, TEK, ROUND, PHILL, BLACK
- 1	45			
	46	3	120392	1/4 SAE FLATWASHER, ZP
I	47			
	48			
- 1	49	2	99332	SCREW, CAP, SOKT, SHOULDER, 3/8 X 3/8 LONG
	50	1	38698	PLATE, DUMP LOCK, 3PT
	51	N/A	56383	THREAD LOCKER, VIBRA-TITE, RED
	52	1	26490	SPRING, 3PT, HANDLE
-		-	20430	SPRING, JEI, MANULE
-	53			
	54			
	55			
	56			
- 1	57	1	26429	WELDMENT, TRUSS LEG LOCK, 3PT
	58			
I	59			
- 1	60			
ı	61	1	26478	FOAM, SEATBASE, 3PT FOLDAWAY, SS
- 1	62	i i	51126480	FOAM, HI BACK, BACK, FRONT FACE, 3PT, FLDWY
	63	1	51126474	FOAM, MOLD, MID HI, 2PL, REAR W/ CHIPBOARD, 3PT, FLDWY
-		-	311204/4	FUAM, MULU, MIU III, ZEL, KEAN 11/ UNIEDUANU, JEI, ILUITI
	64	_		
-	65		OFF OUADT 4	CALES TOT FOLDAMAN BLOW III DAON CO
	66	1	SEE CHART 1	COVER, 3PT FOLDAWAY, BACK, HI BACK, SS
	67	1	SEE CHART 1	
	68	1	28583	DUMP COVER, AISLE SIDE, SS, 3PT
	69	1	28584	DUMP COVER, WALL SIDE, SS, 3PT
. 1	70	4	56618	NYLINER BEARING
Αl	71	4	99063	1/4" NYLON WASHER
Ā	72	2	71728	SCREW, BUTN HD, 1/4-20 X 3/4, ZP
淘	73	2	99015	7/16", WASHER, FLAT, USS, G8, ZP, YEL
4	74	3	99118	BELLVILLE WASHER, 1/2 ID X 1 OD
-	75	2	55988	BUMPER PAD, CROSS LINK POLETHYLENE 1/8 X 1 X 2 5/8
	76	1	31470	VINYL BLACK, 33 1/2 X 18
				VINTE BLACTIC CAR DILLO
	77	2	55253	BLACK PLASTIC CAP, PLUG
	78	1	55713	LABEL, ADHESV, SEATBACK, "CAUTION" 3"L X 3/4" W
	79	2	56589	END CAP, TRUSS, FOLDAWAY
- 1	80			
	81			
	82	11	99324	7/16" FLATWASHER, SAE BLACK OXIDE
- 1	83	1	15361	INSTRUCTIONS, SWITCHABLE ELR
- 1	84			
- 1	85	1	56658	INSTRUCTIONS, 3PT FOLDAWAY
	86		00000	momormore, s. r. regimen
	87	5	99195	1/4" - 20 X 3/4", SCREW, SOCKET, BTN HD, FLANGE
	88	1	99530	NUT, ACORN, CENTER-LOCK, 8-32, GR-A, ZP
	89		33330	NUI, ACURN, CENTEN-LOCK, O-DZ, GK-A, ZI
-		-	07001	DO ACCU DICID ID ELDUM CNITO LU
-	90	1	27081	RS,ASSY,RTCTR,3PT,FLDWY,CNTR,LH
	91	1	27082	RS,ASSY,BUCKLE,3PT,FLDWY,STEM,HC
	92	1	27079	RS,ASSY,RTCTR,3PT,FLDWY,WL,HC,LH
	93	1	27073	RS,ASSY,BUCKLE,3PT,FLDWY,WEB,HC
	94	2	52234590	FOAM, FAB, HDREST, RFACE, 3PT, FLDWY
				5,05,4,05,5

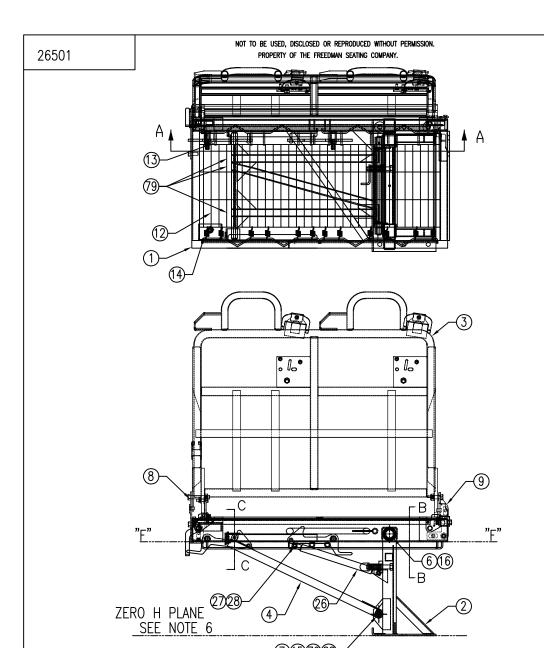
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## ASSEMBLY PROCEDURE

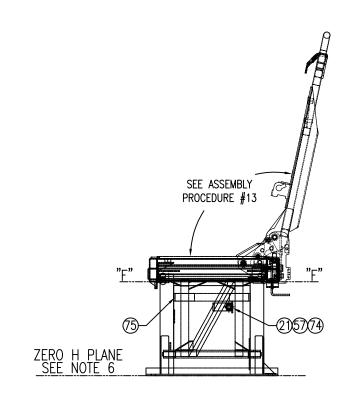
- 1) REMOVE WELD SPLATTER IN TRUSS SLIDER.
- 2) ATTACH SEATBASE TO FLOORMOUNT BY SLIDING TRUNION TUBE (26473) THROUGH SEATBASE BEARING. FASTEN USING 8-32 x 1 1/4 PHILLIPS PAN HEAD SCREW & 8-32 ACORN NUT (APPLY RED LOCTITE).
- 3) ENGAGE TRUSS IN TRUSS SLIDER CHANNELS OF SEATBASE AND SECURE AT BOTTOM WITH PIVOT TUBE. (26472) AND BEARINGS. ALIGN HOLES FOR SPRING PIN. CHECK FOR UPRIGHT VERTICAL POSITION OF SEATBASE.
- 4) ATTACH GAS SPRING END FITTING ONTO SEATBASE WITH 5/16 18 LOCK NUT. ASSEMBLE TWO (2) 3/8 16 X 1 1/4 LEVELING SCREWS TO END OF TRUSS SLIDER. ATTACH TWO (2) LOCKS, WITH SPRINGS, USING 1/2 - 13 WASHER HEAD LOCK NUTS.
- 5) FASTEN GAS SPRING END FITTING TO FLOORMOUNT USING 5/16 18 LOCK NUT.
- 6) "POP" THE TUBE END OF THE GAS SPRING ONTO THE FITTING ON THE SEATBASE. USING THE "LEVER ACTION FORCE TOOL," WITH THE SEATBASE IN THE UP POSITION. "POP" THE ROD END ONTO THE FITTING ON THE FLOORMOUNT, GAS SPRING IS MOUNTED WITH THE ROD END DOWN.
- 7) ATTACH FLEX-O-LATOR TO SEATBASE WITH TWELVE (12) SPRINGS AND TWELVE (12) OYSTER CLIPS. SEE PAGE 3 OF DRAWING FOR ORIENTATION AND LOCATION OF SPRINGS AND OYSTER CLIPS.
- 8) ASSEMBLE DUMP MECHANISM BY ATTACHING HANDLE (26469) AND CONTROL ROD (26470) TO LOCK (26466) WITH 1/4 20 BOLT AND LOCTITE. LEAVE LOOSE ENOUGH TO ROTATE. FEED ROD THROUGH REAR SEATBASE TUBE AND ATTACH LOCK (26466) TO CONTROL ROD WITH 1/4 - 20 BOLT AND LOCTITE, GREASE BOTH LOCKS AT PIVOT LOCATION, BOLT ASSEMBLY TO REAR TUBE WITH 1/2-13 BOLTS AND NUTS AS SHOWN ON PAGE 4. CHECK TO VERIFY PROPER EASY ROTATION.
- 9) ATTACH SIDE PLATE WELDMENTS (38703 AND 38707) TO SEATBASE USING 3/8 16 BOLTS, WASHERS AND NUTS. CONNECT HANDLE SPRING 26490 TO HANDLE AND AISLE SIDE PLATE, VERIFY OPERATION.
- 10) ATTACH SEATBACK TO SEATBASE SIDE PLATES WITH 7/16 20 BOLTS, WASHERS, AND NUTS. ATTACH PART (26495) TO SEATBACK, ADD FLAT SPRING TO SEATBACK USING BOLT 99330, VERIFY PROPER BACK OPERATION.
- 11) ADD DUMP LOCK 38698 TO SEAT USING BOLT 99332 WITH 5/16-18 NUT AND LOCTITE.
- 12) CHECK FOR OPERATION: UP/DOWN LOCKS, TRUSS SLIDING, DUMP MECHANISM, GAS SPRING FORCE, WELDS ON PULL DOWN WIRES AND MOTION OF SEATBACK.
- 13) CHECK THAT SEAT BACK CHUCK (MOVEMENT) IS LESS THAN 1' WHEN A REASONABLE LOAD IS APPLIED TO SEAT BACK.
- 14) PREPARE SEAT FOAM BY APPLYING TICKING TO BACKSIDE OF SEATBACK AND SEATBASE FOAM.
- 15) ATTACH SEATBACK FOAM ONTO FRAME ONLY ON TOP AND CENTER TUBES.
- ATTACH RETRACTORS TO SEATBACK USING 7/16 20 NUTS. VERIFY PROPER BELT OPERATION.
- 17) ADD TRIM COVERS TO SEAT. CUT FABRIC ON SEATBACK WHERE INDICATED. ATTACH BEZEL TO SEATBACK USING SCREWS (99240). ATTACH BUCKLES USING 7/16 - 20 BOLTS, WASHERS, AND NUTS.
- 18) ADD DUMP COVERS, HANDLE COVERS, 3PT INSTRUCTIONS, SIDE BUCKLE AND TRUSS LEG LOCK COMPONENTS.
- 19) VERIFY PROPER OPERATION OF BELTS AND BUCKLES.

- NOTE(S): 2) CAUTION: IT IS NOT POSSIBLE TO TEST EVERY PERMUTATION OF SEAT WIDTH, ACCESSORY COMBINATION, SEAT HEIGHT, POSITION IN VEHICLE, OR SEAT BELT REQUIREMENT. FOR THIS REASON, IT MUST BE EMPHASIZED THAT COMPLIANCE CAN NOT BE ASSUMED WHERE THERE IS ANY DEVIATION FROM THE STANDARD SUPPLY OR ASSEMBLY METHOD. ADDITIONALLY. THE ADVANTAGES OF THIS PRODUCT MAY BE LOST IF INSUFFICIENT CONSIDERATION IS GIVEN TO THE METHOD OF INSTALLATION OF SEAT TO VEHICLE.
  - 3) FULL FEDERAL MOTOR VEHICLE SAFETY STANDARDS AND RÉGULATIONS COMPLIANCE CAN ONLY BE ACHIEVED THROUGH VEHICLE
  - 4) PRODUCT IMPROVEMENT MAY AFFECT SPECIFICATIONS.
  - 5) INCLUDE ONE COPY OF #15361 WITH EVERY SEAT SET.
  - 6) FOR THE RESTRAINT SYSTEM TO WORK, SEAT FRAME PLANE C MUST BE PARALLEL TO ZERO H PLANE (HORIZONTAL FLOOR).

Р	ADD 99063, 71728, 99015; UPDATE 120396 QTY	LH	2/19	742	20										I PAGE	2 OF 5 I
N	ADDED QTY TO 99324	JL	8/18	70	59											
M	REMOVE 70900	DN	11/14	428	18 K	51126480 AND 51126474 WAS 26550;				Ţ	Tolerances Unless Otherwise Specified	Material:		Essander Cambina Ca		4545 W. Augusta Blvd
L	ADDED 52234590 TO BOM; 1001-186 WAS 26513					REPLACED 56603 WITH 27081 & 27082;				1 1				Freedman Seating Co.		Chicago, IL 60651
	1000-186 WAS 26509; 1001-189 WAS 26547					REPLACED 56601 WITH 27079 & 27073	SC	11/1	2134		ACTION 1/X ±1/32" CIMAL .XX ±0.02"	Specifications:		Part Name		
	1000-189 WAS 26543	EAR	08/12	262	2 J	(20 21/32) WAS 20 21/32; (10 1/32) WAS 10 1/32				] "	.XXX ±0.005"			ASSY, 3PT FOLDAWAY, HI-BACK, 2F	L, SS	
Rev.	Description of Change	Ву	Date	ECN	# Rev	Description of Change	Ву	Date	ECN		GULAR ±1°	Drawn by: RW	Date: 09/21/04	DO NOT SCALE DRAWING Drawing No. 26501	·	Rev. P



ASSY, 3PT FOLDAWAY, HI-BACK, 2PL, SS IS SHOWN



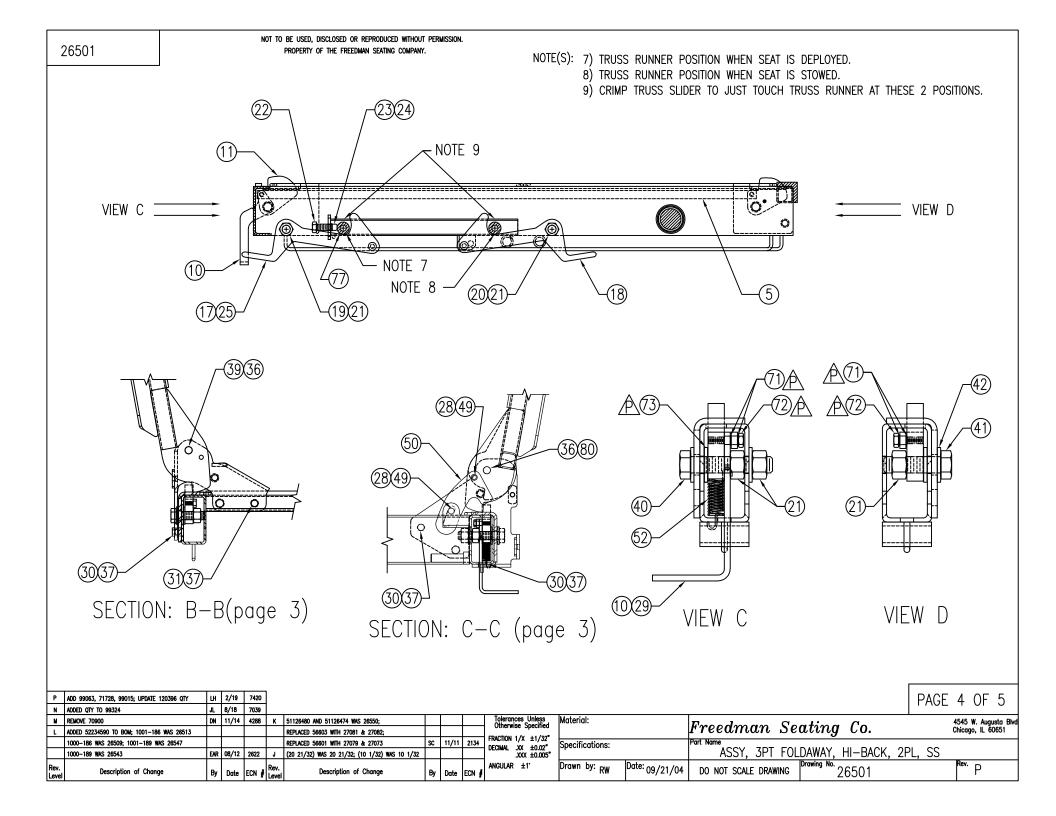
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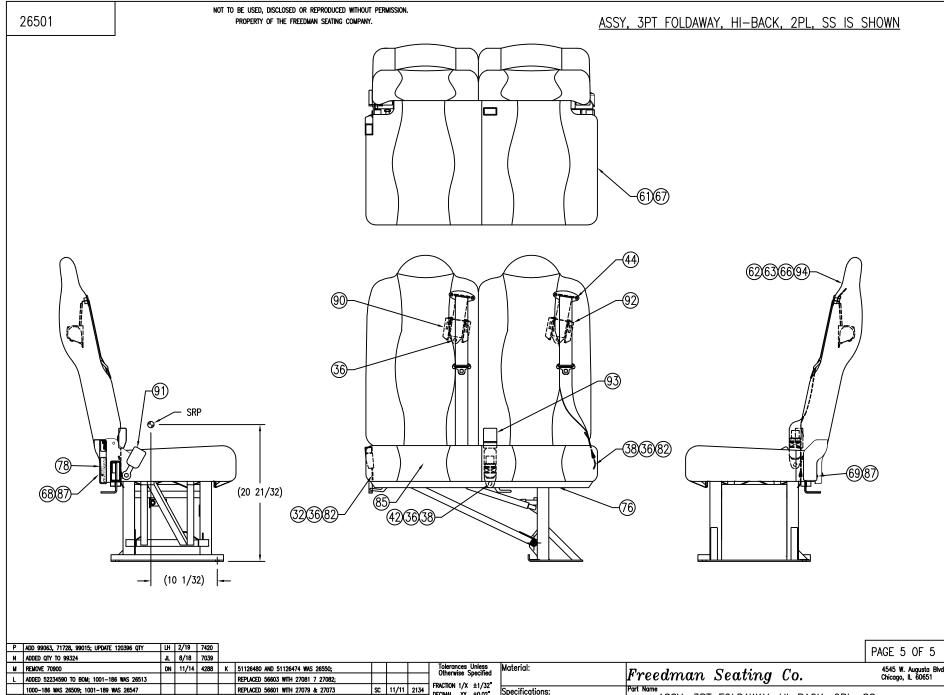
Rev. P

4545 W. Augusta Blvd Chicago, IL 60651

Р	ADD 99063, 71728, 99015; UDPATE 120396 QTY	Ш	2/19	7420	]					
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	1000-189 WAS 26543	EAR	08/12	2622	J	(20 21/32) WAS 20 21/32; (10 1/32) WAS 10 1/32				.XXX ±0.005
Rev. Level	Description of Change	Ву	Date		Rev. Level	Description of Change	Ву	Date	ECN #	ANGULAR ±1°

Material:		Freedman Seating Co.	
Specifications:		Part Name ASSY, 3PT FOLDAWAY, HI-BACK, 2PL,	SS
Drawn by: <sub>RW</sub>	Date: 09/21/04	DO NOT SCALE DRAWING Drawing No. 26501	





	N /	ADDED QIT IO 99324	JL	0/10	/\	139											
	¥ .	REMOVE 70900	DN	11/1	4 42	288	K	51126480 AND 51126474 WAS 26550;				Toleran	es Unless e Specified	Material:		E	4545 W. Augusta Blvo
	ı J	ADDED 52234590 TO BOM; 1001-186 WAS 26513						REPLACED 56603 WITH 27081 7 27082;					•			Freedman Seating Co.	Chicago, IL 60651
		1000-186 WAS 26509; 1001-189 WAS 26547						REPLACED 56601 WITH 27079 & 27073	sc	11/1	11 213		/X ±1/32" XX ±0.02"	Specifications:		Part Name	
		1000-189 WAS 26543	EAR	08/1	2 2	622	J	(20 21/32) WAS 20 21/32; (10 1/32) WAS 10 1/3	2				XXX ±0.02			ASSY, 3PT FOLDAWAY, HI-BACK, 2PL, S	SS
Re Le		Description of Change	Ву	Date	EC	N #	Rev. Level	Description of Change	Ву	Date	e ECN	ANGULAR	±1°	Drawn by: <sub>RW</sub>	Date: 09/21/04	DO NOT SCALE DRAWING Drawing No. 26501	Rev. P