

SIX-WAY REPLACEMENT INSTRUCTIONS 184062PS

READ INSTRUCTIONS THOROUGHLY BEFORE PROCEEDING

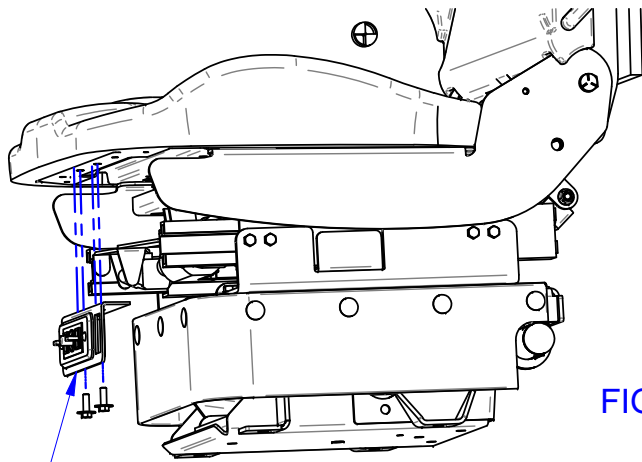


FIG. 1

SWITCH
PANEL

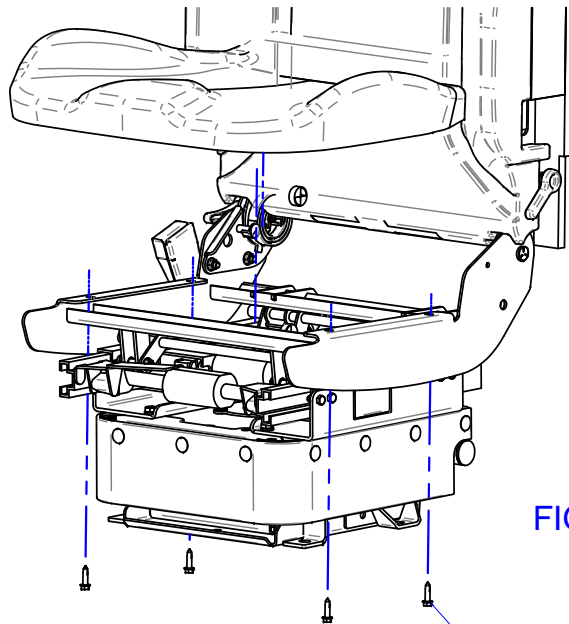


FIG. 2

1/4"-14 SCREWS

1. DISCONNECT ALL POWER AND AIR TO SEAT INCLUDING ROL-TEK CONNECTIONS.
2. REMOVE AIRLINES FROM PADDLE VALVE ON FRONT SWITCH PANEL. CARE SHOULD BE TAKEN HERE TO NOT DAMAGE PADDLE VALVE AIRLINE BARBS THAT COULD CAUSE AN AIR LEAK.
3. REMOVE PADDLE VALVE FROM FRONT SWITCH PANEL BY SQUEEZING THE PRONGS IN BACK AND RETAIN.
4. REMOVE (2) SCREWS FROM FRONT SWITCH PANEL TO DETACH FROM UNDERNEATH CUSHION PAN. (FIG. 1)
5. REMOVE (4) 1/4"-14 SCREWS FROM CUSHION ASSEMBLY AND RETAIN. (FIG. 2)



SIZE: A DRAWN BY: PTB
DATE: 12/17/13 REV. 00 DWG. NO. 712290

Seats Incorporated
1515 Industrial St.
Reedsburg, WI 53959
(608) 524-8261
Toll Free: 1-800-443-0615

WARNING

THE INSTALLER MUST ENSURE THAT THE SEAT IS POSITIONED AND MOUNTED PROPERLY SO THAT THE SEAT, SAFETY BELTS, TETHER BELTS, TETHER MOUNTING POINTS AND FLOOR ANCHOR POINTS MEET FMVSS 207/210 AND SAE STANDARDS WHEN APPLICABLE. FAILURE TO DO SO MAY CAUSE SERIOUS INJURY OR DEATH.

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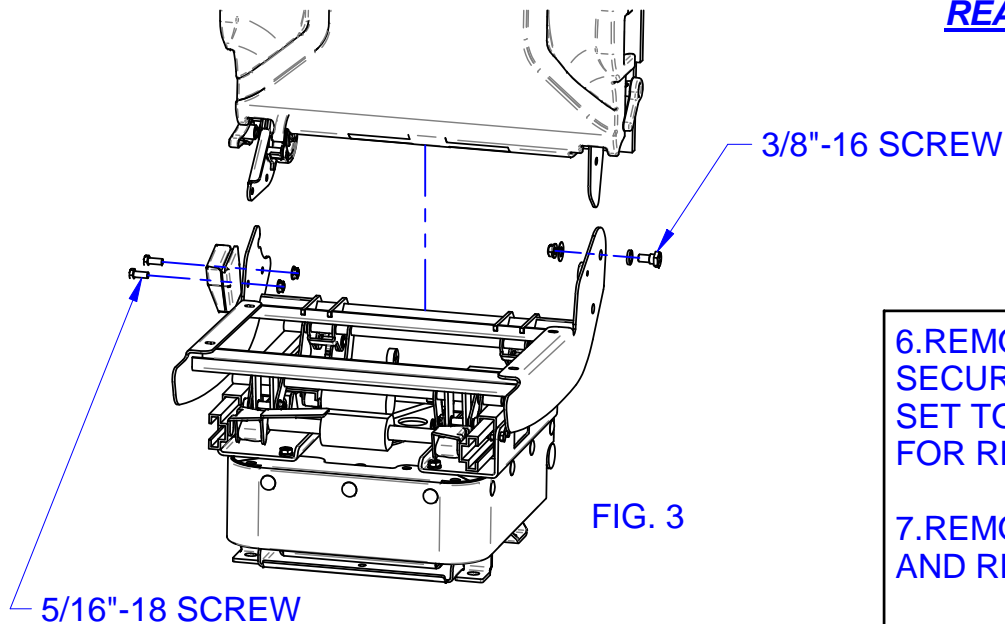


FIG. 3

6. REMOVE (2) 5/16"-18 SCREWS AND (1) 3/8"-16 SCREW SECURING THE BACK ASSEMBLY TO THE CUSHION FRAME AND SET TO THE SIDE. NOTE SEQUENCE OF WASHER AND SPACER FOR REASSEMBLY. DISCARD HARDWARE. (FIG. 3)

7. REMOVE SEAT BELT RETRACTOR FROM CUSHION FRAME AND RETAIN.

8. REMOVE (6) 3/8"-16 SCREWS ATTACHING OLD POWER UNIT BRACKETS TO TOP OF SUSPENSION AND REMOVE WHOLE POWER UNIT WITH CUSHION FRAME. DISCARD HARDWARE ALONG WITH POWER UNIT HARNESS, SWITCH AND FRONT SWITCH PANEL. (FIG. 4)

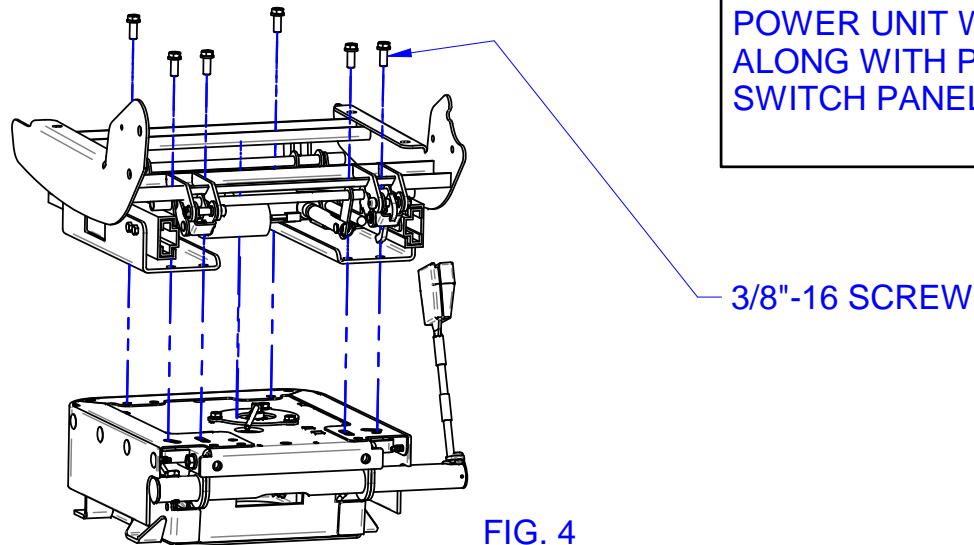


FIG. 4

3/8"-16 SCREW



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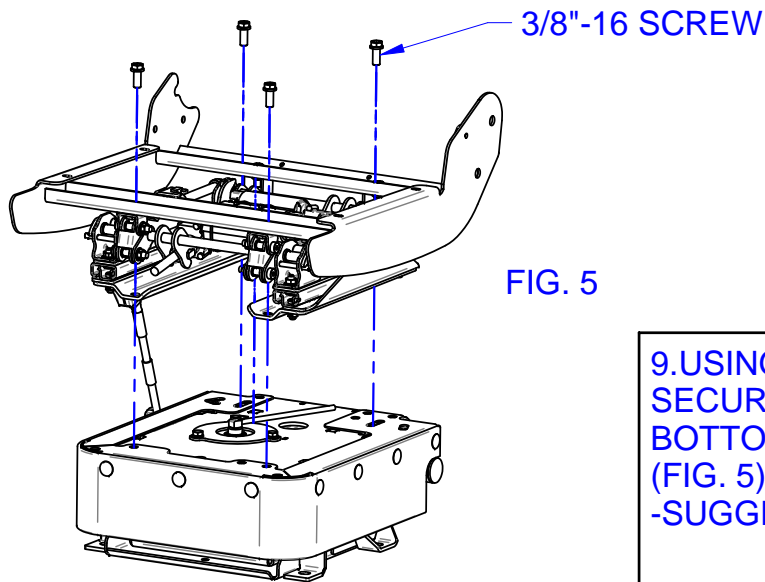
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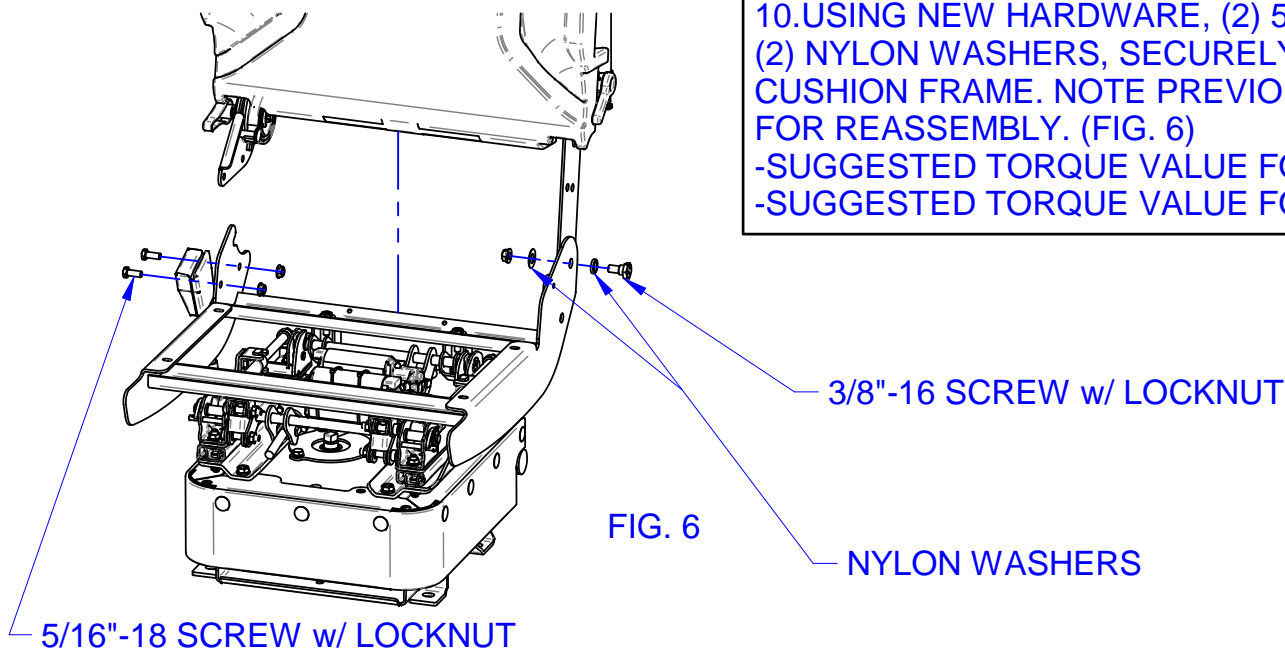
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9. USING NEW HARDWARE, (4) LOCK WASHERS AND 3/8" -16 SCREWS, SECURELY ATTACH NEW POWER UNIT ASSEMBLY COMPLETE WITH BOTTOM BRACKETS AND CUSHION FRAME TO TOP OF SUSPENSION. (FIG. 5)
-SUGGESTED TORQUE VALUE FOR 3/8"-16 GRADE 8 SCREW =23 FT-LBS.

10. USING NEW HARDWARE, (2) 5/16"-18 SCREWS, (1) 3/8"-16 SCREW AND (2) NYLON WASHERS, SECURELY REATTACH BACK ASSEMBLY TO CUSHION FRAME. NOTE PREVIOUS SEQUENCE OF WASHER AND SPACER FOR REASSEMBLY. (FIG. 6)
-SUGGESTED TORQUE VALUE FOR 5/16"-18 GRADE 5 SCREW =19 FT-LBS.
-SUGGESTED TORQUE VALUE FOR 3/8"-16 GRADE 5 SCREW =33 FT-LBS.



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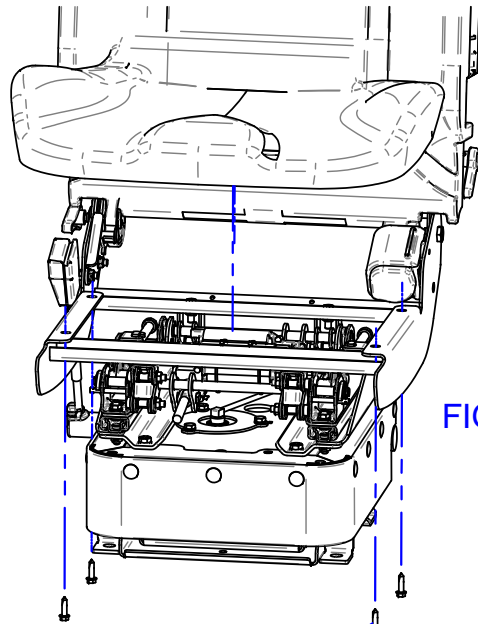


FIG. 7

1/4"-14 SCREWS

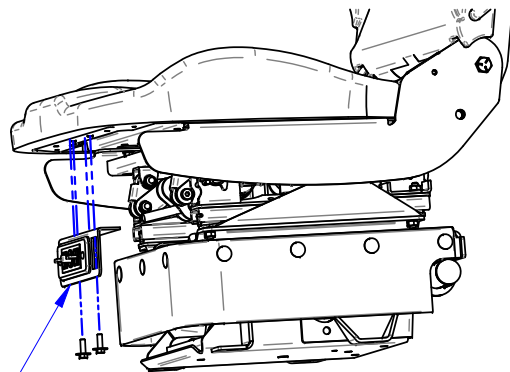


FIG. 8

SWITCH
PANEL

11. SECURELY REATTACH CUSHION ASSEMBLY. USING (4) 1/4"-14 SCREWS. (FIG. 7)
CARE SHOULD BE TAKEN TO NOT OVER TORQUE THE SCREWS TO CAUSE THEM TO STRIP OUT.

12. USING NEW HARDWARE, (2) 1/4"-20 SCREWS, SECURELY ATTACH NEW FRONT SWITCH PANEL TO UNDERNEATH CUSHION. (FIG. 8)
-SUGGESTED TORQUE VALUE FOR 1/4"-20 GRADE 5 SCREW =3 FT-LBS.

13. REATTACH PADDLE VALVE TO FRONT SWITCH PANEL AND REATTACH AIR LINES TO PADDLE VALVE.

14. SECURELY REATTACH SEAT BELT RETRACTOR TO CUSHION FRAME PER MANUFACTURER SPECIFICATIONS.

15. RECONNECT ALL POWER AND AIR TO SEAT INCLUDING ROL-TEK CONNECTIONS.

16. RUN SEAT THROUGH FULL RANGE OF MOTION TO ENSURE NO AIRLINES OR POWER UNIT HARNESSSES ARE IN DANGER OF BEING PINCHED IN THE SEAT. SEE PHOTOS ON SHEET 5 & 6. OPERATE SUSPENSION TO ENSURE THERE ARE NO AIR LEAKS. OPERATE RECLINER TO ENSURE FULL RANGE OF MOTION.



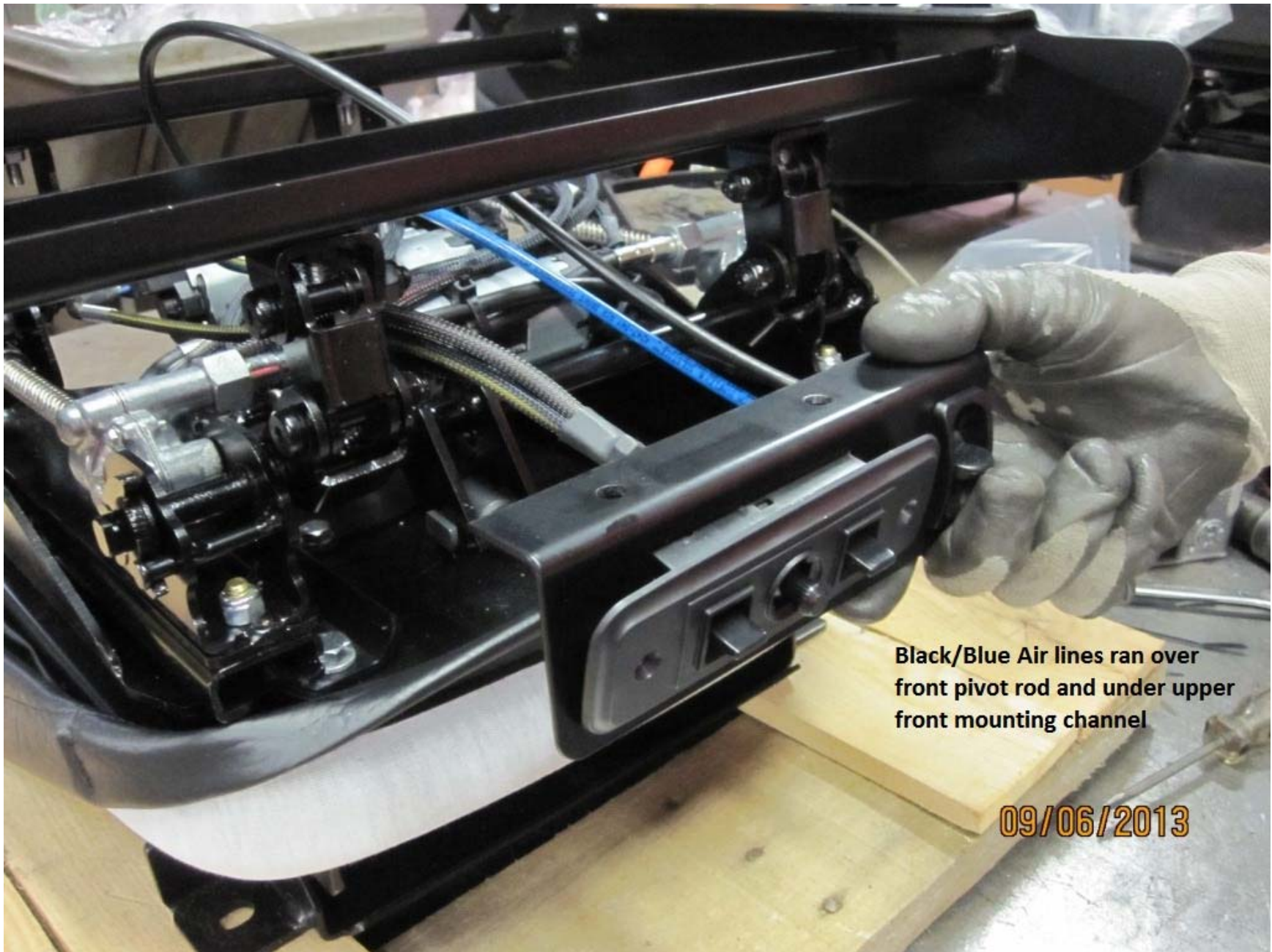
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Black/Blue Air lines ran over front pivot rod and under upper front mounting channel

09/06/2013

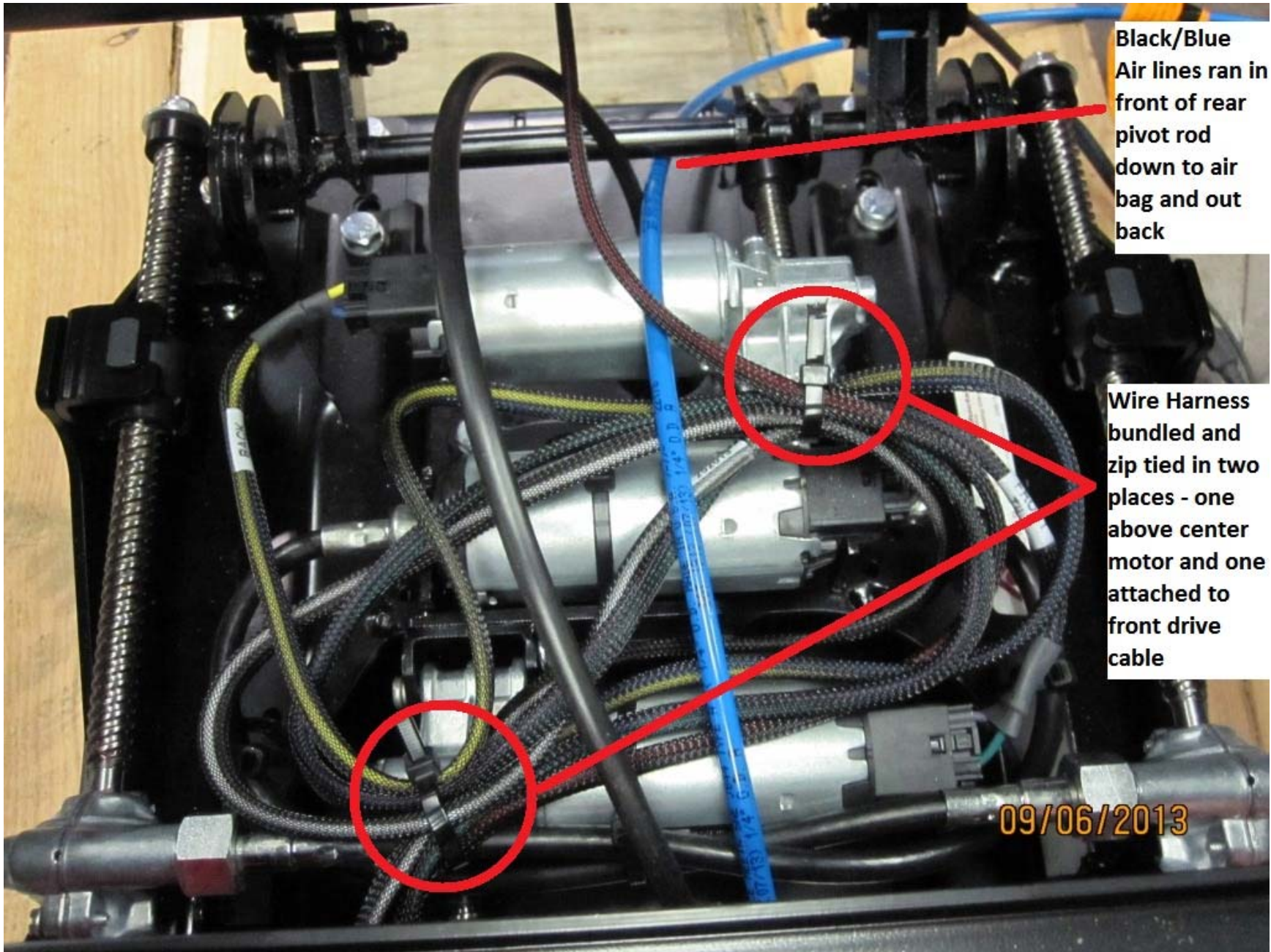


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**Black/Blue
Air lines ran in
front of rear
pivot rod
down to air
bag and out
back**

**Wire Harness
bundled and
zip tied in two
places - one
above center
motor and one
attached to
front drive
cable**

09/06/2013



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