

## APPENDIX L - ASSEMBLY PROCEDURE - WINDOW AND SEAT MECHANISMS

### Window Lift Mechanism Assembly Procedure

This procedure is intended to assist teams in the assembly of the window lift mechanism. There is a left hand assembly and a right hand assembly. While reading the instructions, note if two item numbers are indicated in parenthesis the first number is for right hand assemblies and the second number is for left hand assemblies.

#### Parts List

Item	Description
1	Window Lift Bracket, Right Hand
2	Window Lift Bracket, Left Hand
3	Flanged Bushing
4	Channel For Tape Drive
5	Window Lift Mechanism Tape
6	Gear
7	Window Motor, Right Hand
8	Window Motor, Left Hand
8A	Washer
9	Guide Drive
10	Guide, Right Hand
11	Guide, Left Hand
12	Triangular Mount

1. Enlarge the 5/16" hole on the window lift bracket (item 1 and 2) to 7/16". This will allow the insertion of the flanged bushing (item 3).
2. Place an end of the channel for tape drive (item 4) between the three tabs found on the window lift bracket (item 1 and 2). Ensure the end of the channel is firmly up against the stop.
3. Using the two 9/64" holes located on the window lift bracket (item 1 and 2) as guides drill two 9/64" through holes into the channel for tape drive (item 4). Note on some channel the 9/64" through holes may have already been located and drilled.
4. Using an appropriate size rivet (two), attach the channel for tape drive (item 4) to the window lift bracket (item 1 and 2), Ensure the head of the rivet is on the outside of the window lift bracket (item 1 and 2),

5. If desired the channel for tape drive (item 4) may be bent. When bending the channel for tape drive insert a suitable object into the channel which will support the sides of the channel from collapsing.
6. Insert the window lift mechanism tape (item 5) into the channel, into the window lift bracket (item 1 and 2) slot, along the inside radius of the gear socket and around the outside radius of the lobe. Verify the window lift mechanism tape (item 5) is seated inside the guide located on the lobe. Align four holes at the end of the tape with the four tabs on the window lift bracket (item 1 and 2) and press the tabs firmly into the holes.
7. Install the gear (item 6) into the gear socket located in the window lift bracket (item 1 and 2). Verify the window lift mechanism tape (item 5) is located on the outside of the gear (item 6) Align the tabs on the gear (item 5) with the holes in the window lift mechanism tape (item 5) .
8. Place the flanged bushing (item 3) over the gear shaft on the window motor (item 7 and 8). The flanged end of the bushing (item 3) should be firmly set against the side of the gear.
9. Install the washer (item 8A) over the flanged bushing (item 3) so it firmly rests against the flange of the bushing.
10. Align the three window motor (item 7 and 8) mounting holes with the three 1/4" through holes on the window lift bracket (item 1 and 2), the window motor (item 7 and 8) gear teeth to the inside teeth of gear (item 6), and the bushing on the gear shaft of the window motor (item 7 and 8) to the 7/16" hole in the window lift bracket (item 1 and 2), If alignment is satisfactory push the window motor (item 7 and 8) into the window lift bracket (item 1 and 2) until window motor is firmly against the bracket.
11. Install a 1/4" x 1.25 inch bolt (3) through the mounting holes (3) in the window lift motor (item 7 and 8) and window lift bracket (item 1 and 2). Secure with a 1/4" nut.
12. Place the cylindrical tabs on the end of guide drive (item 9) over the tabs on the guide (item 10 and 11). Rotate the guide drive (item 9) until spring tab rests inside the guide (item 10 and 11).
13. Align the slot in the guide (item 10 and 11) to the channel for tape drive (item 4) and align the four tabs on the guide drive (item 9) with four holes in the window lift mechanism tape (item 5).
14. Apply 12 Vdc power to the window motor (item 7 and 8) so it pulls the window lift mechanism tape (item 5) into the assembly and the guide (item 10 and 11) slides over the channel. This may take a few trial and error attempts until the desired length of window lift mechanism tape (item 5) and guide (item 10 and 11) travel is achieved.
15. Pass the oval hole on the triangular mount (item 12) over the oval tab on the guide (item 10 and 11) and rotate 90 degrees.
16. The window lift mechanism is complete.



6. Gear



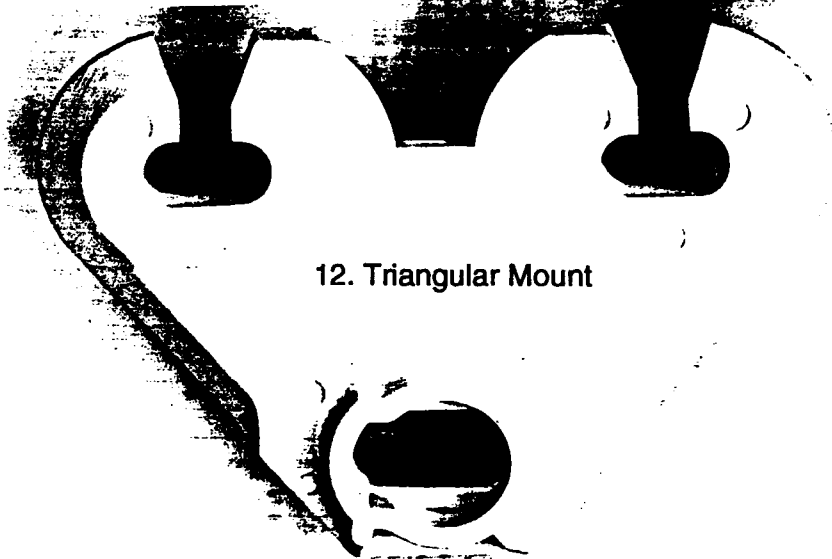
9. Guide Drive



11. Guide, Left Hand



10. Guide, Right Hand

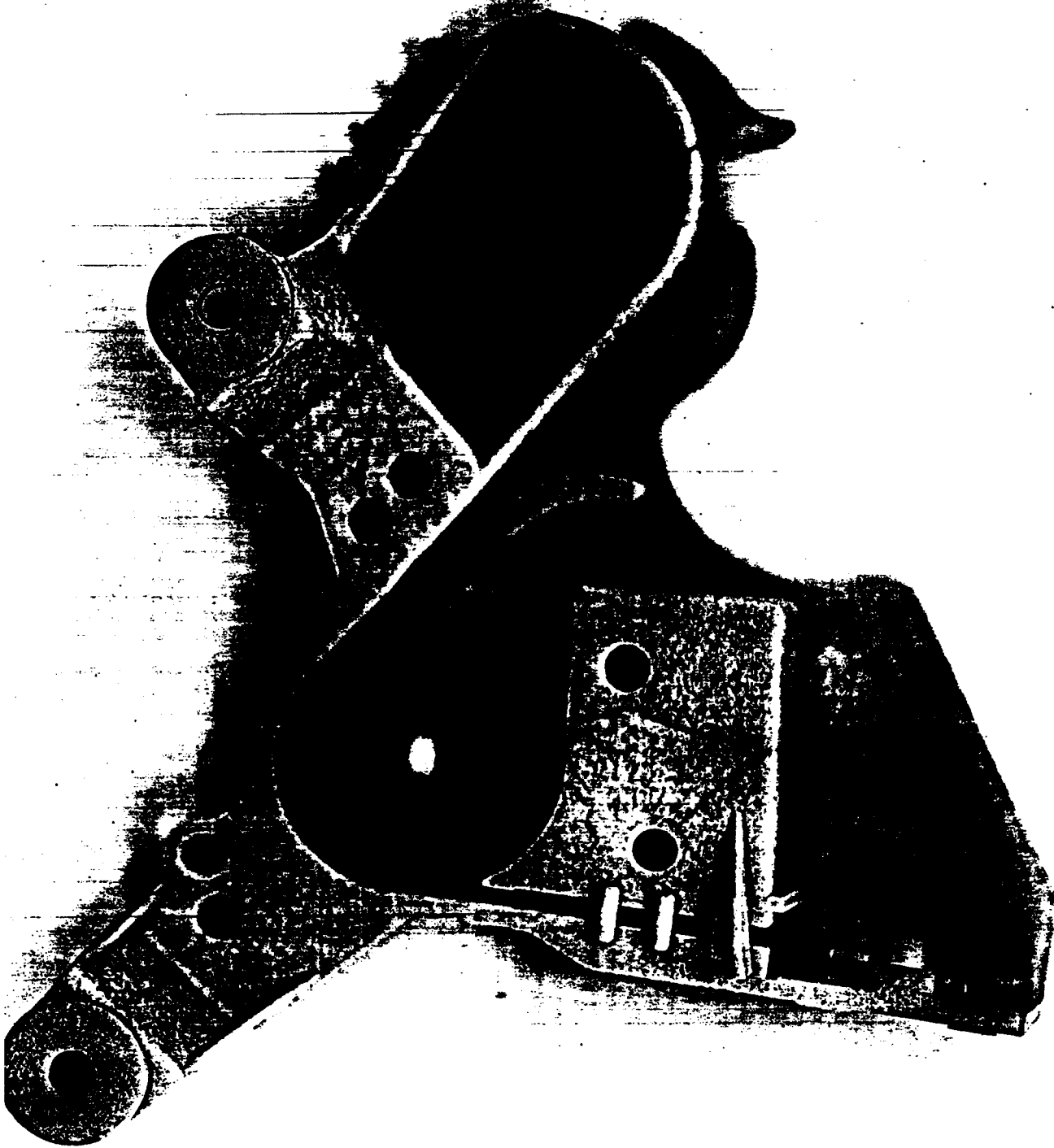


12. Triangular Mount



Window Lift Bracket

Left Hand





### Seat Positioning Unit Assembly Procedure

This procedure is intended to assist teams in the assembly of the seat positioning unit. There is a left hand assembly and a right hand unit. While reading the instructions, note if two item numbers are indicated in parenthesis the first number is for right hand assemblies and the second number is for left hand assemblies.

#### Parts List

Item	Description
1	Upper Channel/with Gear Assembly
2	Lower Channel
3	Horizontal Actuator Right Hand, Black and Natural Color
4	Horizontal Actuator Left Hand, Natural Color
5	Flange Nut, M6 x 1.0
6	Hex Head Bolt, M6 x 1.0 x 30 mm

1. Using a clamping device, clamp two white slide bushings located on opposite sides of the upper channel (item 1) firmly against the edges.
2. Locate the rectangular shaped hole in the middle of the lower channel (item 2). On one side of this rectangle is 0.125" x 0.625" notch. Make note of this.
3. Align the end of the upper channel (item 1) which has the clamped slide bushings with the end of the lower channel (item 2) that does not have the raised tabs. Ensure the gear of the upper channel (item 1) and the notch in the rectangle of the lower channel (item 2) (located in step 2) are on the same side.
4. Secure the lower channel (item 2). Using a hammer, tap the upper channel (item 1) into the lower channel (item 2).
5. While the upper channel (item 1) is entering the lower channel (item 2), ensure the clamping device is secured and the white slide bushings do not move on the upper channel.
6. Slide the upper channel (item 1) into the lower channel (item 2) until the clamping device contacts the end of the lower channel (item 2).
7. Remove the clamping device from the upper channel (item 1) and place on the other two white slide bushings.
8. Continue to slide the upper channel (item 1) into the lower channel (item 2). Once the clamping device contacts the end of the lower channel (item 2) it should be removed.
9. With the clamping device removed continue to slide the upper channel (item 1) into the lower channel (item 2) until the upper channel (item 1) located entirely in the lower channel (item 2). This will be referred to as the upper/lower channel assembly.

10. Align the gear of the horizontal actuator (item 3 and 4) with the upper channel (item 1) gear. Push the horizontal actuator (item 3 and 4) into the upper/lower channel assembly until it firmly rests against the lower channel (item 2).
11. Fasten the horizontal actuator (item 3 and 4) to the upper/lower channel assembly using two M6 x 1.0 x 30 mm long hex head bolts (item 5). Tighten bolts firmly.
12. To ensure the upper channel (item 1) does not slide out of the lower channel (item 2) place a 1/4" bolt through the hole on the end of the lower channel (item 2). Secure the bolt with a 1/4" nut.
13. If desired, the M6 x 1.0 flange nuts (item 6) can be placed on the M6 studs on the upper channel.
14. The seat positioning unit is complete.