

WORK INSTRUCTION						
Operation #	SAP Line #	Operation Description	Level		Date	Author
M0999507	N/A	Service Instruction Inspect and Repair J-brackets	05	Released	10/21/2015	Chris Perkins
	Page 1 / 8			Revised	10/30/2015	Chris Perkins

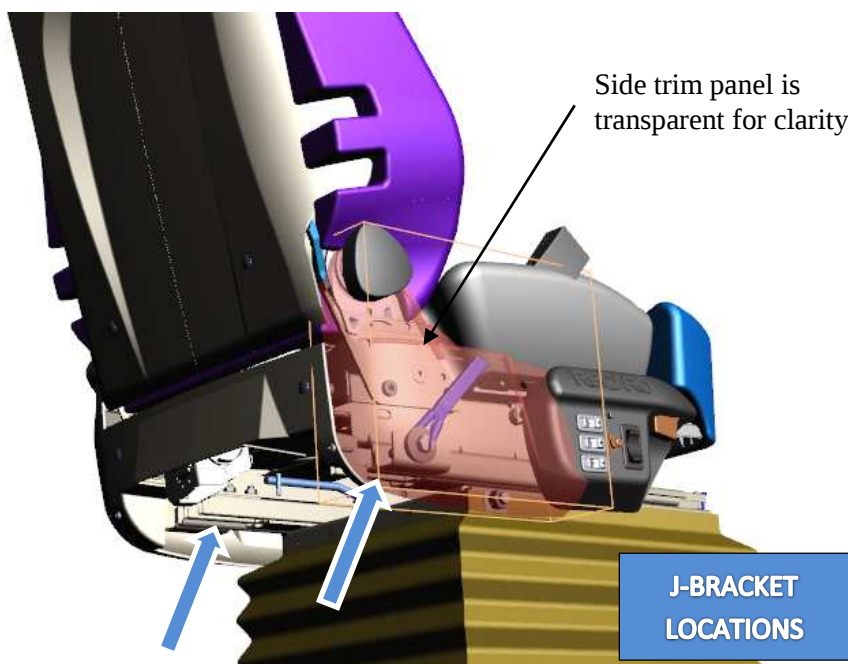
STEP	PICTURES / DESCRIPTIONS	Special Criteria
------	-------------------------	------------------

This procedure describes a 2 part process. Both inspection and repair, if necessary, are covered by this document.

SECTION 1 – INSPECTION

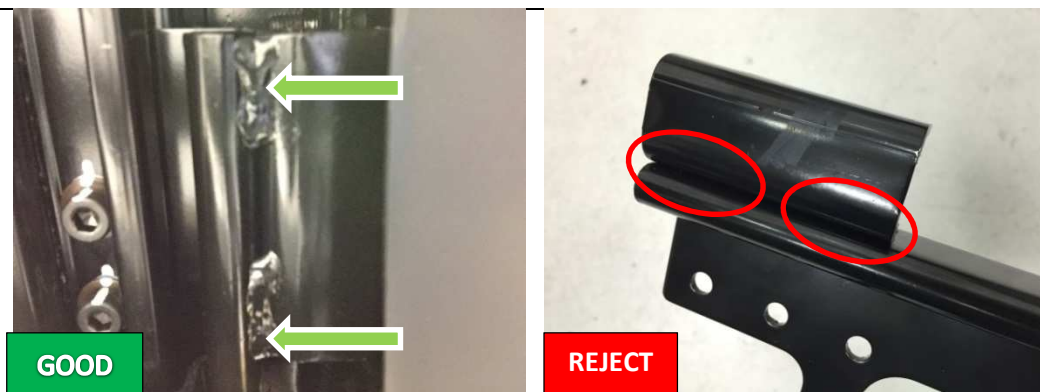


1. Position the seat to “full forward” and “full up” to obtain the serial number on the seat. The serial number decal is located on the back of the seat on the top of the suspension between the seat tracks, shown above. Record the bus number and serial number of the seat.



WORK INSTRUCTION						
Operation #	SAP Line #	Operation Description	Level		Date	Author
M0999507	N/A	Service Instruction Inspect and Repair J-brackets	05	Released	10/21/2015	Chris Perkins
	Page 2 / 8			Revised	10/30/2015	Chris Perkins

STEP	PICTURES / DESCRIPTIONS	Special Criteria
------	-------------------------	------------------



- Position the seat to best expose the underside of the J-brackets, “full up” and “full rear” would typically be best best location. Examine both J-brackets for presence of underside welds. Document condition of J-brackets.

If any of the welds are missing from the bottom of either J-Bracket, continue to section 2. If both welds are present and the parts are good, no further work is required.

SECTION 2 – REPLACEMENT

Parts List

Left hand kit, 7225212.1: 40854107-01 J Bracket Upper LH
 30870807 – BOLT M8-1.25X22 10.9 DIN – 3 pieces
 Right hand kit, 7225212.2: 50854107-01 J Bracket Upper RH
 30870807 – BOLT M8-1.25X22 10.9 DIN – 3 pieces

Tool List

Impact or wrachet wrench with 5/8” socket and 6mm hex socket
 13mm wrench
 Torque wrench(es) capable of 22 Nm and 50 Nm (6mm hex bit, 5/8” socket)
 Pick or small screwdriver (hole plug removal)
 #2 screwdriver
 2 inch tall block

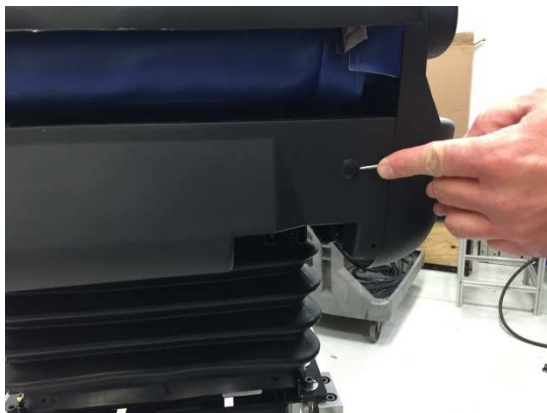
For technical support – Contact RECARO’s service technician, Zech Ellis at (248)484-3234

- Prior to replacing the J-bracket, complete the RECARO warranty form to place an order for the repair kit. Email the form to commercial@recaro-automotive.com or fax it to (248)364-3804,
 Once the parts have been received, follow the steps described here in Section 2.

WORK INSTRUCTION						
Operation #	SAP Line #	Operation Description	Level		Date	Author
M0999507	N/A	Service Instruction Inspect and Repair J-brackets	05	Released	10/21/2015	Chris Perkins
	Page 3 / 8			Revised	10/30/2015	Chris Perkins

STEP	PICTURES / DESCRIPTIONS	Special Criteria
------	-------------------------	------------------

Note: It is recommended that the seat is removed from the vehicle prior to replacing the J-bracket.



- If J-bracket(s) need to be replaced, remove the 2 hole plugs and 4 screws in the rear trim panel and the mounting screw from the rear corner panel(s). Remove the recliner handwheel.



Operation #	SAP Line #	Operation Description	Level		Date	Author
M0999507	N/A	Service Instruction Inspect and Repair J-brackets	05	Released	10/21/2015	Chris Perkins
	Page 4 / 8			Revised	10/30/2015	Chris Perkins

STEP	PICTURES / DESCRIPTIONS	Special Criteria
------	-------------------------	------------------

- Remove the belt buckle (or belt retractor/3pt anchor) from the bad J-bracket with a 5/8 socket. Set the removed components aside.



- Position the seat back to "full forward". Unfasten the front track bolt from the cushion frame using a 6mm hex bit and a 13mm wrench. Check the rear of seat for a track stop bolt. If present, remove it with the 6mm hex bit.



2 inch block



WORK INSTRUCTION						
Operation #	SAP Line #	Operation Description	Level		Date	Author
M0999507	N/A	Service Instruction Inspect and Repair J-brackets	05	Released	10/21/2015	Chris Perkins
	Page 5 / 8			Revised	10/30/2015	Chris Perkins

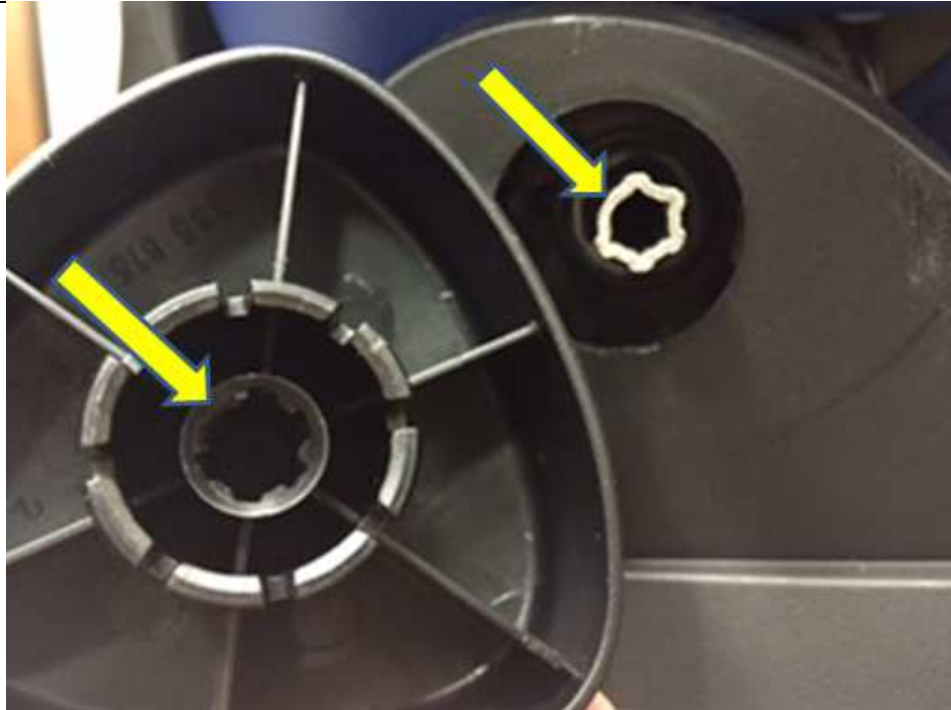
STEP	PICTURES / DESCRIPTIONS	Special Criteria
5.	Position the seat to “full rear”. Unfasten the rear track bolts from the cushion frame using an 6mm hex bit and a 13mm wrench. Place a 2 inch block between the cushion frame and suspension to create just enough clearance to remove the J-bracket by sliding it rearward along the path of the track.  	
6.	Position the replacement part utilizing the same path and aligning all the mounting holes. Obtain replacement M8 bolts. Place rear fasteners thru the mounting holes from below and start the flange nuts by hand. Torque to 22 Nm.  	
7.	Position the seat to “full forward”. Obtain replacement M8 bolts. Place front fastener thru the mounting holes from below and start, by hand, the flange nut. Torque to 22 Nm.	
8.	If applicable, replace the track stop bolt previously removed.	

Operation #	SAP Line #	Operation Description	Level		Date	Author
M0999507	N/A	Service Instruction Inspect and Repair J-brackets	05	Released	10/21/2015	Chris Perkins
	Page 6 / 8			Revised	10/30/2015	Chris Perkins

STEP	PICTURES / DESCRIPTIONS	Special Criteria
		
9.	Route the buckle through the rear trim panel. Hand start the seat belt buckle bolt into the replacement J-Bracket part now in the seat. Torque to 50 Nm.	
10.	If needed, replace the other side J-bracket using the same procedure documented in steps 5-10.	
		
11.	Replace the corner panel(s) in original position and secure with the mounting screw(s) previously removed.	

Operation #	SAP Line #	Operation Description	Level		Date	Author
M0999507	N/A	Service Instruction Inspect and Repair J-brackets	05	Released	10/21/2015	Chris Perkins
	Page 7 / 8			Revised	10/30/2015	Chris Perkins

STEP	PICTURES / DESCRIPTIONS	Special Criteria
------	-------------------------	------------------



- Replace the recliner handwheel making sure to align the keyed pattern of the recliner rod to the handwheel.



- Position the rear trim panel into its original position and secure with the mounting screws previously removed. Install the hole plugs into the rear trim panel that were previously removed.

Note: Save all parts as RECARO requires them to be returned.

Work Instruction						
Operation #	SAP Line #	Operation Description	Level		Date	Author
M0999507	N/A	Service Instruction Inspect and Repair J-brackets	05	Released	10/21/2015	Chris Perkins
	Page 8 / 8			Revised	10/30/2015	Chris Perkins

STEP	PICTURES / DESCRIPTIONS	Special Criteria
REV LEVEL	REVISION LOG	REV DATE
1.	Added document # and description provided by Adrienne Crowley	10/21/15
2.	Added part numbers.	10/22/15
3.	Added pictures of 3 pt retractor anchor, changed bolt quantity in kits to 3, and added block size.	10/23/15
4.	Added kit part numbers, 7225212.1 & 7225212.2	10/26/15
5.	Added picture to clarify J-bracket location on the seats and separated the inspection & repair.	10/30/15
6.		
7.		
8.		
9.		
10.		
11.		
12.		
13.		
14.		
15.		
16.		
17.		
18.		
19.		
20.		
21.		
22.		
23.		
24.		
25.		
26.		
27.		
28.		
29.		
30.		

SIGN OFF

Manufacturing Engineer:	Date:
Quality Control:	Date:
Environmental Officer:	Date:
Health and Safety Officer:	Date:

CC[A] CC SC IC