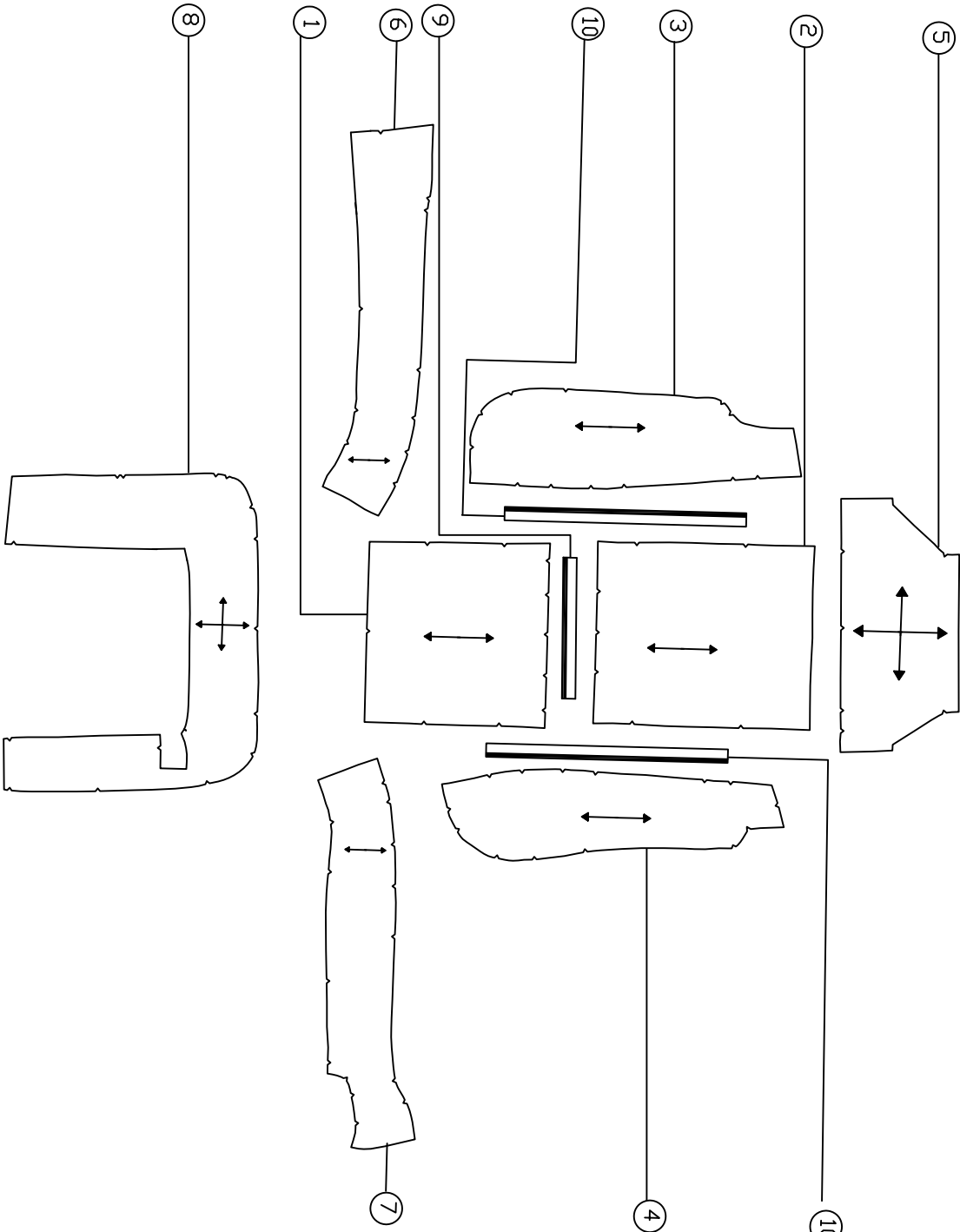


DESCRIPTION	SYMBOL
NON DIRECTIONAL	0.0
WARP AND WEFT DIRECTION	4.0
LENGTH OF ROLL (LDR)	2.0
MAP	1.0 1.180 1.270 1.90

SR NO	DESCRIPTION
1.	CUTTING TOLERANCE +/- 3MM FROM (XY) 1.
2.	STITCH LENGTH FOR NORMAL STITCHING IS 5 STITCHES PER 20MM +/- 1 STITCH.
3.	NO SKIPPED STITCHES.
4.	ALL STITCH LINE REQUIRE BACK TACKS MIN 3 STITCHES MAX 5 STITCHES.
5.	SEAM OVERLAP 2MM MAX.
6.	NOTCH ALIGNMENT TOLERANCE IS +/-5MM TO CENTER OF NOTCH.
7.	NOTCH ALIGNMENT ON START / STOP OF EXTRC LISTING(SEWING COMPONENT JS +/- 5MM TO CENTRE OF NOTCH
8.	NO EXPOSED THREAD ENDS.
9.	LEATHER,SCRIM, LAMINATED VINYL & RETAINER OF TRIM SHOULD MEET FLAMMABILITY 100mm/min max. AS PER FMVSS 302.
10.	JOIN SEAM ALLOWANCE IS 8MM +/- 2MM, UNLESS OTHERWISE SPECIFIED.
11.	STITCH LENGTH FOR RETAINER STRIP IS 4 STITCHES PER 20MM +/- 1 STITCH.
12.	STITCH LENGTH FOR DECK,FRENCH SEAM IS 4 STITCHES PER 20MM +/- 1 STITCH.
13.	DISTANCE BETWEEN DECK & FRENCH SEAM FROM CENTER JOINSEW LINE IS 4MM +/-1/2 TO 1MM FOR STRAIGHT PORTION.
14.	DISTANCE BETWEEN DECK & FRENCH SEAM FROM CENTER JOIN SEW LINE IS 4MM +/-1 TO 2MM FOR CURVED PORTION & CORNER AREAS.
15.	NO BACK TACKS ON DECK, FRENCH SEAM STITCH LINE.
16.	THREAD SPECS AS PER JCS 9000 - FOR TKT 30 - TYPE B, 107 tex, Nm 30/3
17.	THREAD SPECS AS PER JCS 9000 - FOR TKT 20 - TYPE A,161 tex, Nm 20/3
18.	STITCH VERTICAL PUNCH PWP WITH 'L' SHAPE ON FRONT SIDE OF TRIM.

NOTES :-



11	1690694	01	BLACK THREAD	THREAD TKT 40 POLYAMIDE	1600288	NA	1
10	2315046	01	LPWP 20MM	LOCAL PRE WOVEN PLASTIC 20MM	1393061	300MM	2
9	1393068	01	LPWP 20MM	LOCAL PRE WOVEN PLASTIC 20MM	1393061	220MM	1
8	JCP035215	01	PANEL REAR	CARPET BLACK 190GSM	1924737	4.0	1
7	JCP035214	01	FACING SIDE LT	VINYL	3279663	2.90	1
6	JCP035213	01	FACING SIDE RT	VINYL	3279663	2.90	1
5	JCP035212	01	FACING REAR	CARPET BLACK 190GSM	1924737	2.90	1
4	JCP035211	01	BOLSTER LT	VINYL	3279663	2.90	1
3	JCP035210	01	BOLSTER RT	VINYL	3279663	2.90	1
2	JCP035209	01	INSERT REAR	VINYL	3279663	2.90	1
1	JCP035208	01	INSERT FRONT	INSERT FABRIC	3279661	2.90	1

BILL OF MATERIAL

ITEM NO.	PART NUMBER	REV.	PATTERN OR PART DESCRIPTION	MATERIAL DESCRIPTION	DRAWING NUMBER	RAW PART SIZE.	PCS PER COMP.
11	1690694	01	BLACK THREAD	THREAD TKT 40 POLYAMIDE	1600288	NA	1
10	2315046	01	LPWP 20MM	LOCAL PRE WOVEN PLASTIC 20MM	1393061	300MM	2
9	1393068	01	LPWP 20MM	LOCAL PRE WOVEN PLASTIC 20MM	1393061	220MM	1
8	JCP035215	01	PANEL REAR	CARPET BLACK 190GSM	1924737	4.0	1
7	JCP035214	01	FACING SIDE LT	VINYL	3279663	2.90	1
6	JCP035213	01	FACING SIDE RT	VINYL	3279663	2.90	1
5	JCP035212	01	FACING REAR	CARPET BLACK 190GSM	1924737	2.90	1
4	JCP035211	01	BOLSTER LT	VINYL	3279663	2.90	1
3	JCP035210	01	BOLSTER RT	VINYL	3279663	2.90	1
2	JCP035209	01	INSERT REAR	VINYL	3279663	2.90	1
1	JCP035208	01	INSERT FRONT	INSERT FABRIC	3279661	2.90	1

01	8224692	INITIAL RELEASE	29\04\16	ASL	DPD	RSH	---	SAN
REV	ECR NO.	CHANGES	DATE	DRN	STDZ	CHKD	REGL	APPD
CONTROL STATUS								
CAD TYPE PROJECT								
AUTOCAD ACE CLOSED VAN								

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MATERIAL SPECIFICATION

TREATMENT

FINISH



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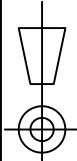
Johnson Controls Automotive Ltd, India

USED ON
ACE CLOSED VAN

SUPERSEDES

SOURCE

TITLE
ASSY. CUSHION TRIM CD DRIVER CLOSED VAN



SCALE

NTS

DRAWING NO.

3279709

REV

01

SHEET

1 OF 1