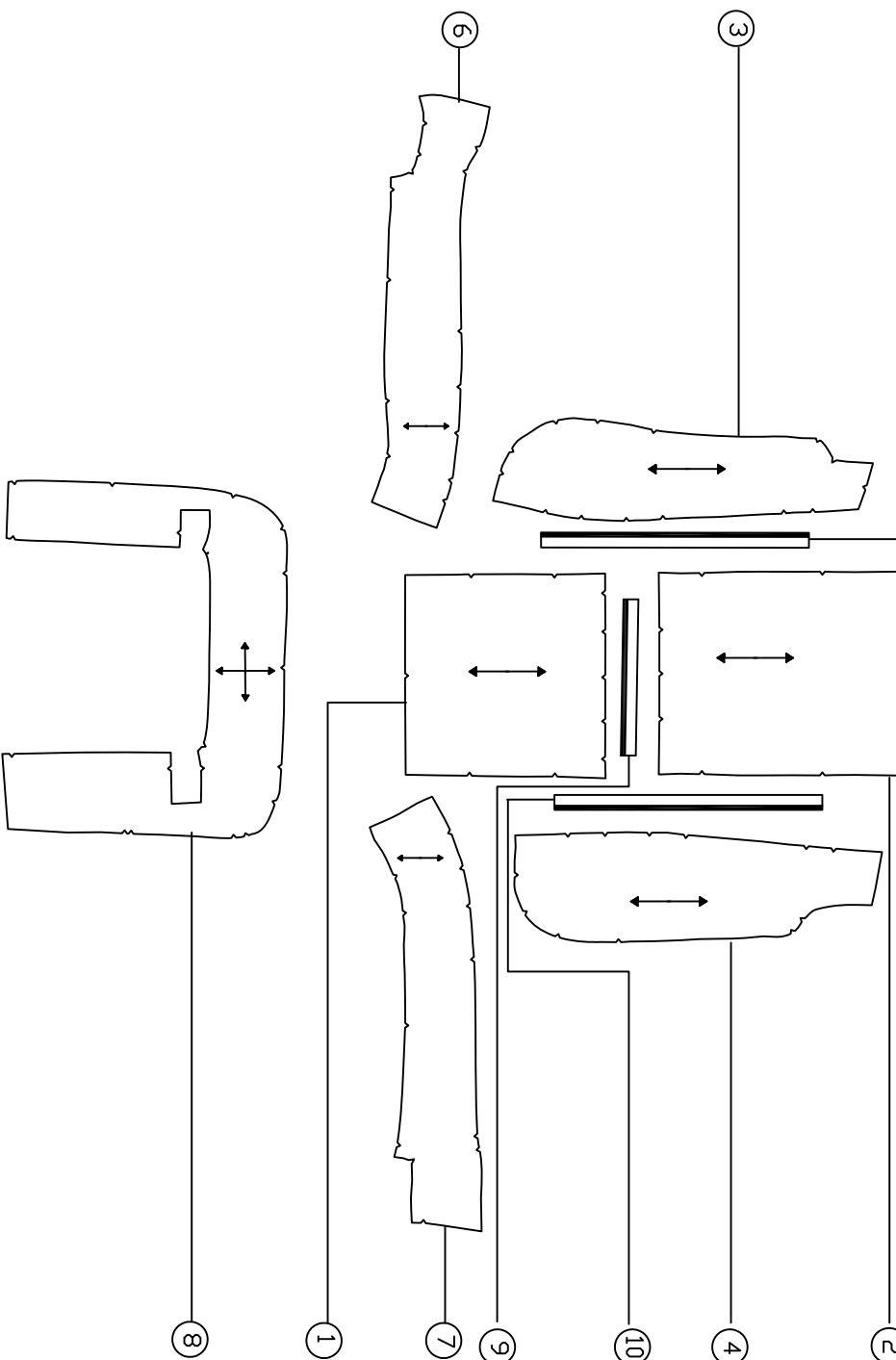


DESCRIPTION	SYMBOL
NON DIRECTIONAL	0.0
WARP AND WEFT DIRECTION	4.0
LENGTH OF ROLL (LDR)	2.90
MAP	1.0 1.180 1.270 1.90

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 EXTRCL LISTING (SEWING COMPONENT) IS +/- 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 :-

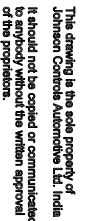
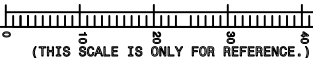


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CONTROL STATUS	CHANGES	DATE	DRN	STDZ	CHKD	REGL	APPD	CAD TYPE	PROJECT
01	8224692	INITIAL RELEASE	29\04\16	ASL	DPD	RSH	- - -	SAN	
REV	ECR NO.	CHANGES	DATE	DRN	STDZ	CHKD	REGL	APPD	

11	1690694	01	BLACK THREAD	THREAD TKT 40 POLYAMIDE	1600288	NA	NA
10	2087740	01	LPWP 20MM	LOCAL PRE WOVEN PLASTIC 20MM	1393068	300MM	2
9	2077235	01	LPWP 20MM	LOCAL PRE WOVEN PLASTIC 20MM	1393068	220MM	1
8	JCP035207	01	PANEL REAR	CARPET BLACK 190GSM	1924737	4.0	1
7	JCP035206	01	FACING SIDE LT	VINYL	3279663	2.90	1
6	JCP035205	01	FACING SIDE RT	VINYL	3279663	2.90	1
5	JCP035204	01	FACING REAR	CARPET BLACK 190GSM	1924737	4.0	1
4	JCP035203	01	BOLSTER LT	VINYL	3279663	2.90	1
3	JCP035201	01	BOLSTER RT	VINYL	3279663	2.90	1
2	JCP035202	01	INSERT REAR	VINYL	3279663	2.90	1
1	JCP035201	01	INSERT FRONT	INSERT FABRIC	3279661	2.90	1
ITEM NO.	PATTERN OR PART NUMBER	REV LEVEL	PATTERN OR PART DESCRIPTION	MATERIAL DESCRIPTION	DRAWING NUMBER	RAW PART SIZE	PCS PER COMP.

BILL OF MATERIAL

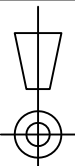


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Johnson Controls Automotive Ltd, India

USED ON	SUPERSEDES	SOURCE
ACE CLOSED VAN		- - - -

TITLE ASSY. CUSHION TRIM DRIVER CLOSED VAN



SCALE	DRAWING NO.	REV	SHEET	OF
NTS	3279676	01	1	1