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56966722

ON GUNWARD

CAD DRAWING. NO MANUAL CHANGES PLEASE

DO NOT SCALE DRAWING
IF IN DOUBT, ASK

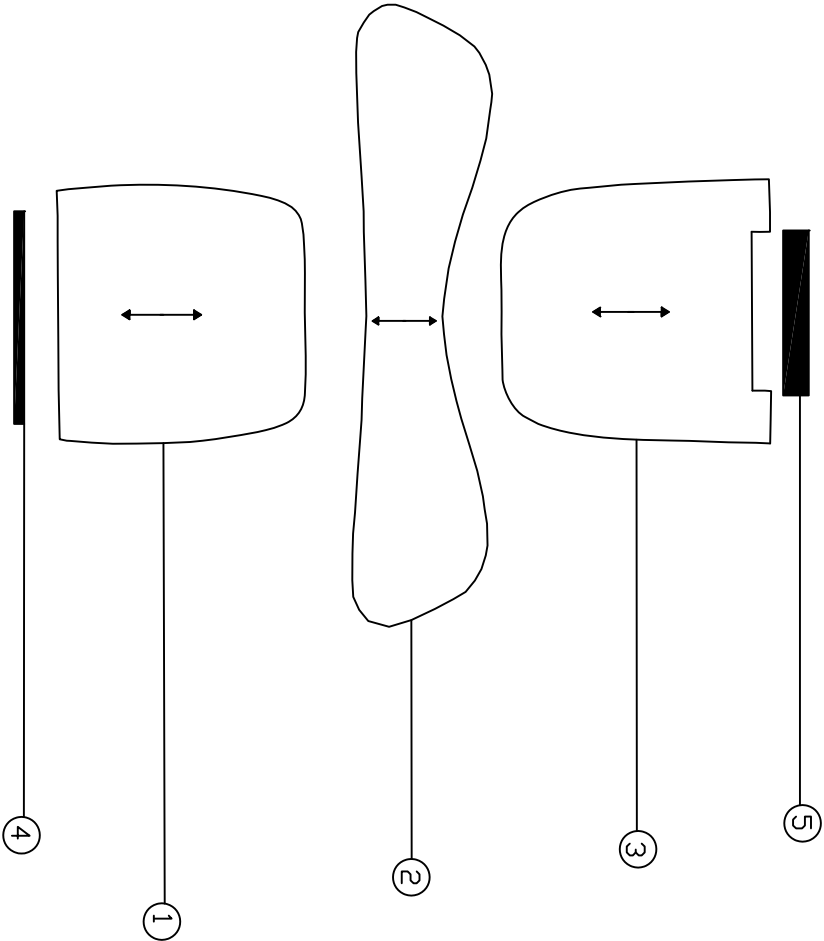
SHARP CORNERS AND BURNS NOT ALLOWED.
ALL DIMENSIONS ARE IN MM.

UNSPECIFIED TOLERANCE AS PER
IS: 2102 PART 1 'm' CLASS
PART 2 'K' CLASS

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

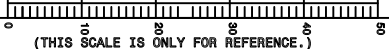
SR NO	DESCRIPTION
1.	CUTTING TOLERANCE +/- 3MM FROM (XY) 1.
2.	STITCH LENGTH FOR NORMAL STITCHING IS 5 STITCHES PER 20MM +/- 1 STITCH.
3.	NO SKIPPED STITCHES.
4.	ALL STITCH LINE REQUIRE BACK TACKS MIN 3 STITCHES MAX 5 STITCHES.
5.	SEAM OVERLAP 2MM MAX.
6.	NOTCH ALIGNMENT TOLERANCE IS +/- 5MM TO CENTER OF NOTCH.
7.	NOTCH ALIGNMENT ON START / STOP OF EXTRL 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 :-



6	1690694	01	BLACK THREAD	THREAD TKT 40 POL YAMIDE	1600288	NA	NA
5	2087973	01	J2 RETAINER BEIGE COLOUR	EXTRUDED POLYPROPYLENE	1393071	140 MM	1
4	1712329	01	FLAT AERROW RETAINER	EXTRUDED POLYPROPYLENE	1712329	140 MM	1
3	JCP035192	01	PANEL REAR	VINYL	3279663	2.90	1
2	JCP035191	01	FACING SIDE	VINYL	3279663	2.90	1
1	JCP035190	01	PANEL FRONT	VINYL	3279663	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



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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USED ON
ACE CLOSED VAN

SUPERSEDES

SOURCE

TITLE
ASSY. HR TRIM CLOSED VAN

SCALE

NTS

DRAWING NO.

3279695

REV

01

SHEET 1 OF 1

