

1 OF 1 SHEET

10

3279810





DRAWING NO.

CAD DRAWING. NO MANUAL CHANGES PLEASE

DO NOT SCALE DRAWING
IF IN DOUBT, ASK

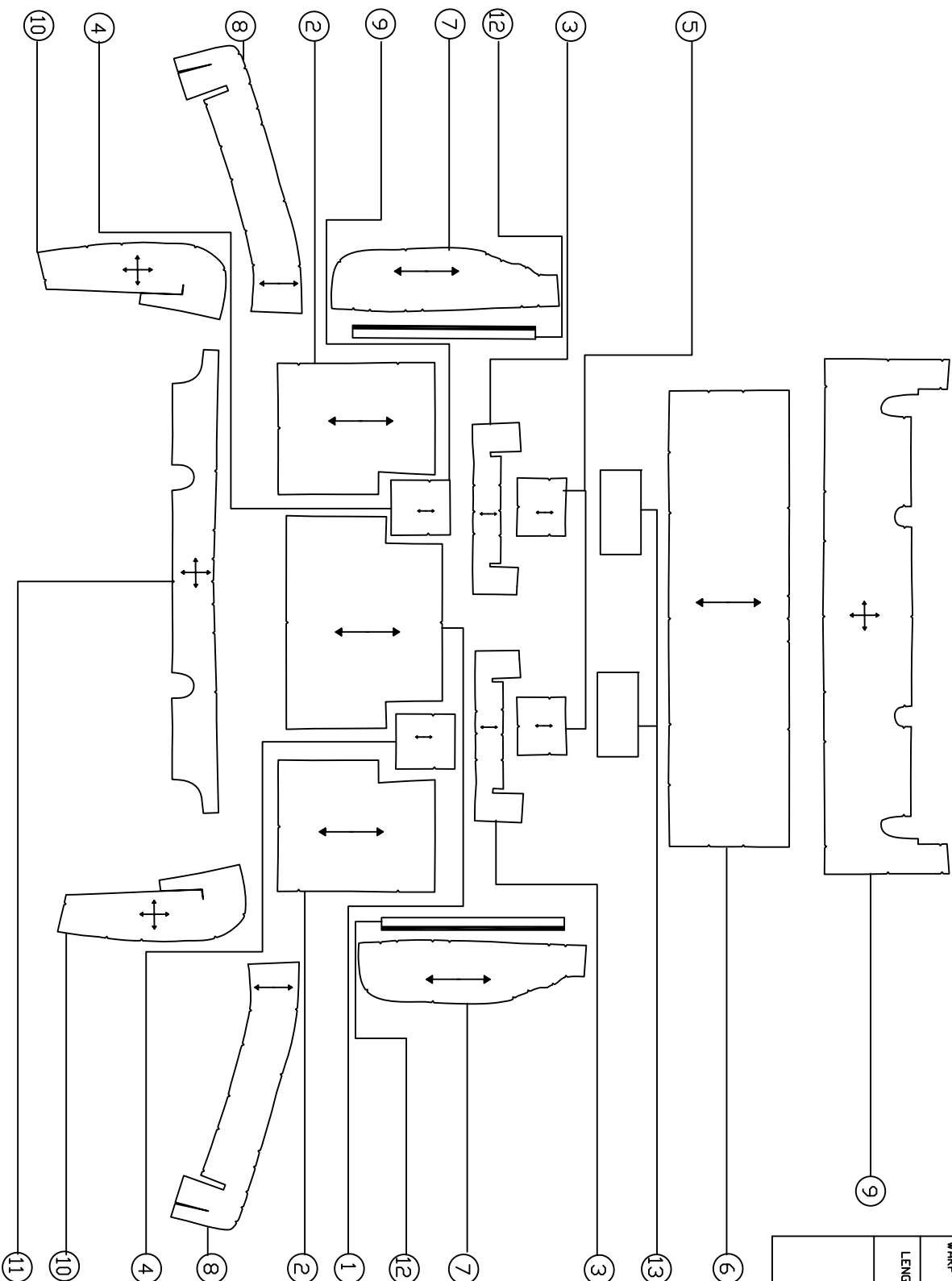
SHARP CORNERS AND BURRS NOT ALLOWED.

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

DESCRIPTION	SYMBOL
NON DIRECTIONAL	
WARP AND WEFT DIRECTION	
LENGTH OF ROLL (L.R)	
NAP	

SR NO	DESCRIPTION
1.	CUTTING TOLERANCE ± 3 MM FROM (X,Y).
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 ± 5 MM TO CENTER OF NOTCH.
7.	NOTCH ALIGNMENT ON STAIR / STOP OF EXTR. LISTING / SEWING COMPONENT JIS ± 5 MM TO CENTRE OF NOTCH
8.	NO EXPOSED THREAD ENDS.
9.	LEATHER, SCRM, LAMINATED VINYL & RETAINER OF TRIM SHOULD MEET FLAMMABILITY 100mm/min; max. AS PER FMVSS 302.
10.	JOIN SEAM ALLOWANCE IS 8MM ± 2 MM, UNLESS OTHERWISE SPECIFIED.
11.	STITCH LENGTH FOR RETAINER STRIP IS 4 STITCHES PER 20MM ± 1 STITCH.
12.	STITCH LENGTH FOR DECK FRENCH SEAMS IS 4 STITCHES PER 20MM ± 1 STITCH.
13.	DISTANCE BETWEEN DECK & FRENCH SEAM FROM CENTER JOIN SEW LINE IS 4MM ± 1 TO 2MM FOR CURVED PORTION & CORNER AREAS.
14.	DISTANCE BETWEEN DECK & FRENCH SEAM FROM CENTER JOIN SEW LINE IS 4MM $\pm 1/2$ TO 1MM FOR STRAIGHT PORTION.
15.	NO BACK TACKS ON DECK, FRENCH, SEAM STITCH LINE.
16.	THREAD SPECS AS PER JCS 9000 - FOR 1X1 30 - TYPE B, 10/1 tex, Nm 30/3
17.	THREAD SPECS AS PER JCS 9000 - FOR 1X1 20 - TYPE A, 16/1 tex, Nm 20/3
18.	STITCH VERTICAL PUNCH PWP WITH U SHAPE ON FRONT SIDE OF TRIM.

NOTES:-



14	1690694	01	BLACK THREAD	THREAD TKT 40 POLYAMIDE	1600288	NA	NA
13	1611023	01	PLASTIC STRIP	PLASTIC 227MM * 75MM	1611023	227 MM * 75MM	2
12	2087747	01	LPWP 20MM	LOCAL PRE WOVEN PLASTIC 20MM	1393068	420 MM	2
11	JCP035189	01	FACING FR1 EXTN	CARPET BLACK 190GSM	1924737	2.90	1
10	JCP035187/88	01	FACING SIDE EXTN RT / LT	CARPET BLACK 190GSM	1924737	2.90	1/1
9	JCP035186	01	FACING REAR EXTN	CARPET BLACK 190GSM	1924737	2.90	1
8	JCP035184/85	01	FACING SIDE RT / LT	VINYL	3279663	2.90	1/1
7	JCP035182/83	01	BOLSTER RT / LT	VINYL	3279663	2.90	1/1
6	JCP035181	01	INSERT REAR	INSERT FABRIC	3279661	2.90	1
5	JCP035179/80	01	CAVITY TOP RT / LT	VINYL	3279663	2.90	1/1
4	JCP035177/78	01	CAVITY BOTTOM RT / LT	VINYL	3279663	2.90	1/1
3	JCP035174/76	01	CAVITY FLAP RT / LT	VINYL	3279663	2.90	1/1
2	JCP035172/73	01	INSERT RT / LT	VINYL	3279663	2.90	1/1
1	JCP035171	01	PANEL CENTER	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

USED ON	SUPERSEDES	SOURCE	...
ACE CLOSED VAN			
TITLE			
ASSY. CUSHION TRIM 3RD ROW CLOSED VAN			
SCALE	DRAWING NO.	REV	
NTS	3279810	01	SHEET 1 OF 1



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Johnson Controls Automotive Ltd. India

APPD	SAN	29\04\06
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01	8224692	INITIAL RELEASE	29/04/16	ASL	DPD	RSH	---	SAN
REV	ECR NO.	CHANGES	DATE	DNN	STUZ	CHKD	REGL	APPD
<div style="border: 2px solid red; padding: 5px; text-align: center;"> CONTROLLED COPY RELEASED FOR MANUFACTURE </div>					CAD TYPE		PROJECT	
					AUTOCAD		AGE CLOSED VAN	

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CAD TYPE	THROLO
AUTOCAD	ACE CLOSED VAN

(THIS SCALE IS ONLY FOR REFERENCE.)