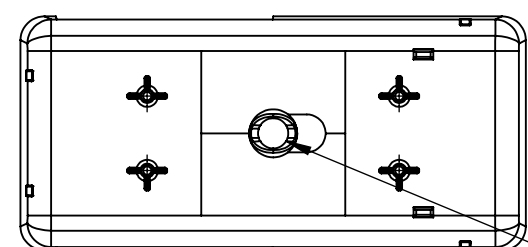


PULL WIRES THROUGH HOLE IN BALLJOINT

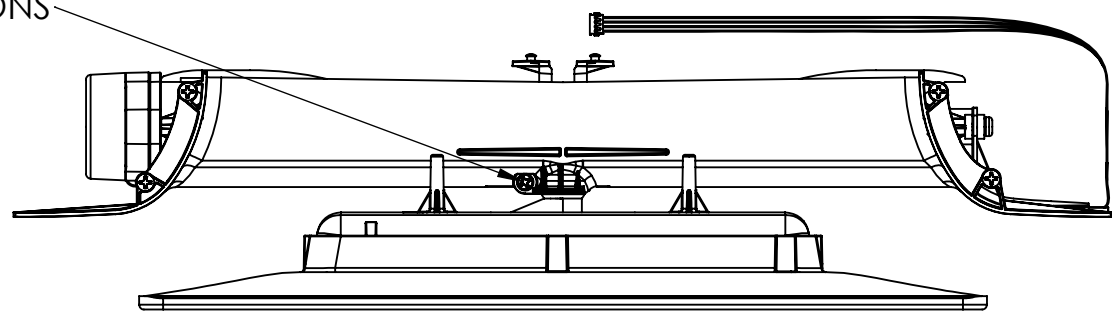
INSERT BALLJOINT INTO FEMALE JOINT HERE

ROUTE PRESSURE SENSOR CABLE THROUGH THIS HOLE IN OUTER BOX

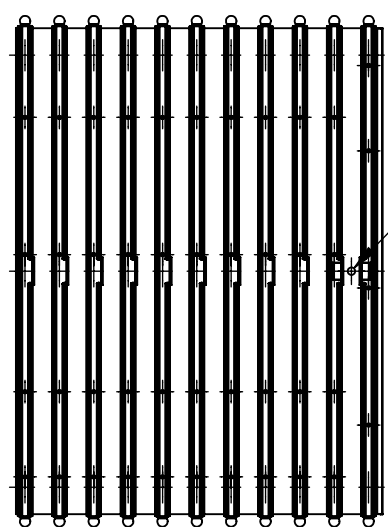


ROUTE WIRES THROUGH THIS HOLE IN BALLJOINT FACEPLATE

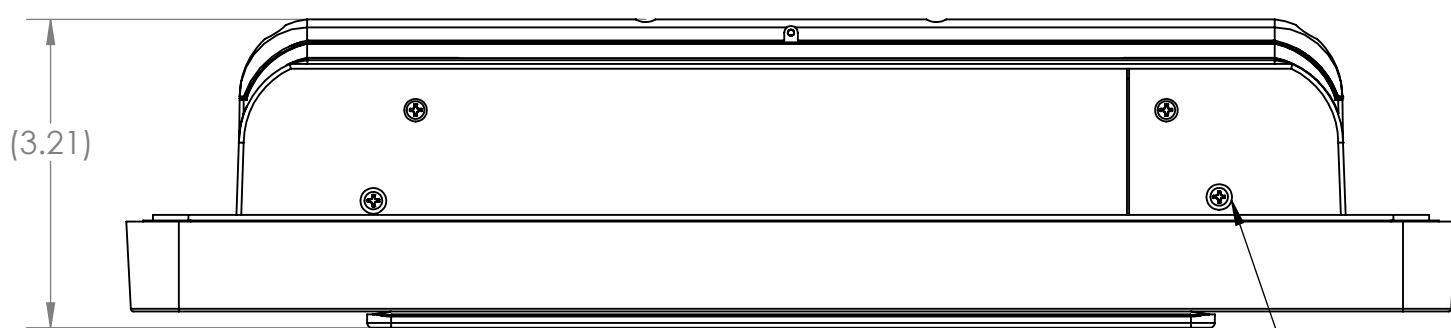
ENSURE M2 BOLT IS TORQUED TO SPEC GIVEN IN WORK INSTRUCTIONS



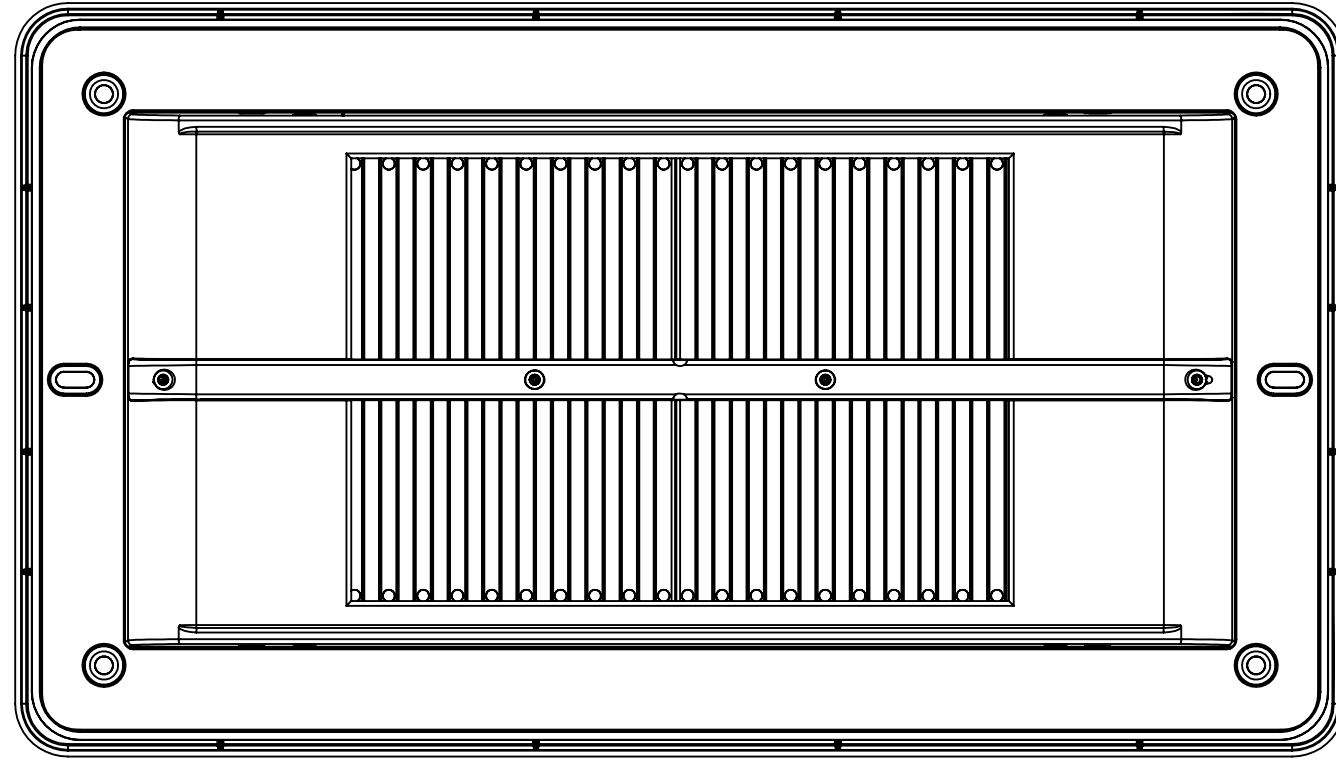
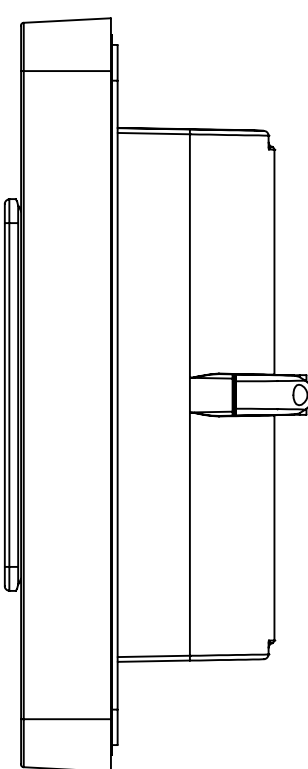
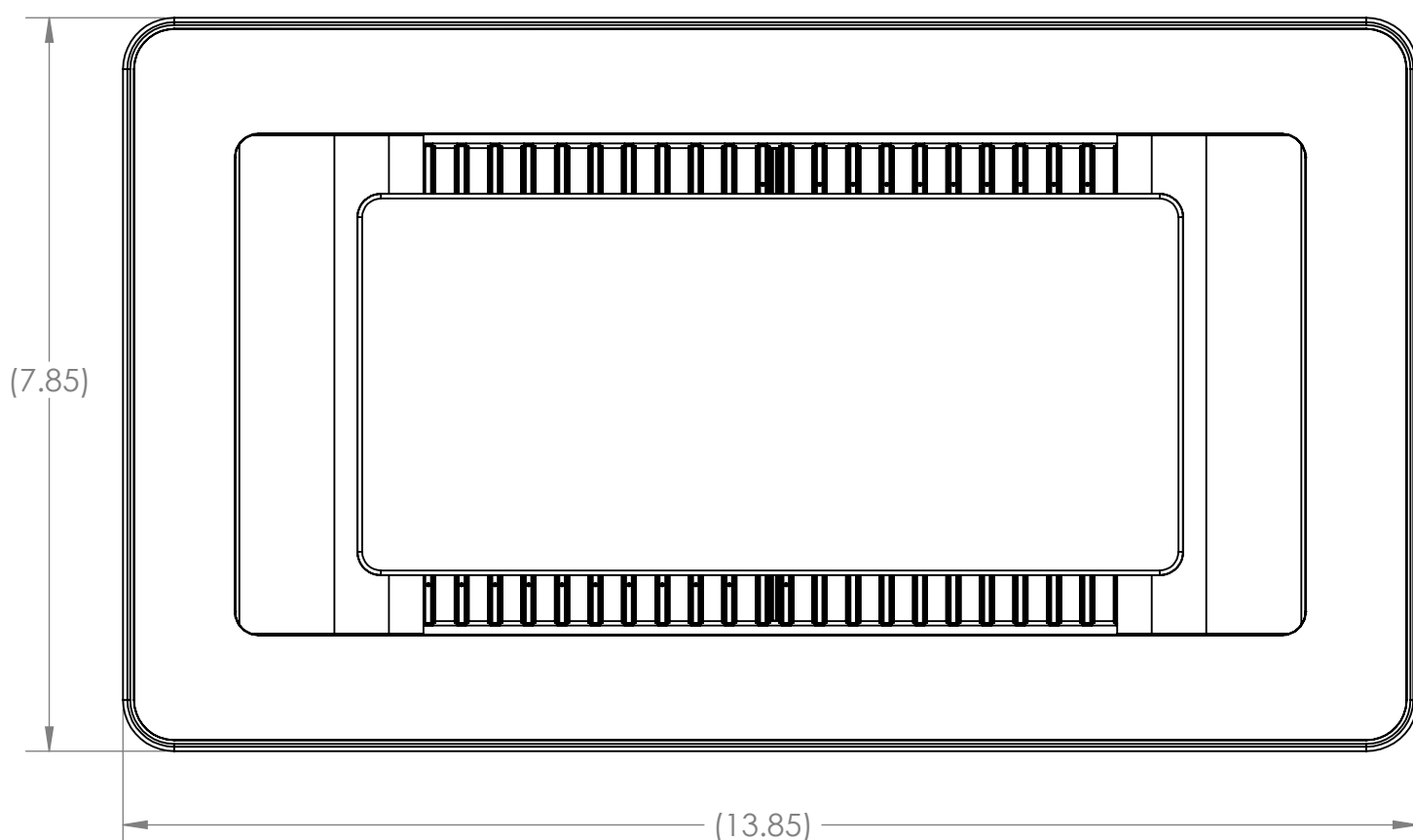
SEAT MOTOR AND BUSHING SIDE NUTS IN THIS LOCATION ON EACH DOOR



ENSURE MUSHROOM FEATURE IS FULLY ENGAGED INTO EACH DOOR



SCREW TO ATTACH DRIVETRAIN INSERT TO MAIN BODY 8 PLACES



GENERAL NOTES

- SEE ARENA PLM FOR PART NUMBER REFERENCE DESIGNATORS AND CURRENT REVISIONS.
- 1 CALLOUTS ARE APPLIED TO TOLERANCES THAT MAY REQUIRE SPECIAL QUALITY CONTROL PROCESSES. QUALITY CONTROL INSTRUCTIONS ARE OUTSIDE THE SCOPE OF THIS DRAWING AND ARE DEFINED BY EXTERNAL DOCUMENTATION TO BE AGREED TO WITH THE MANUFACTURER.
- ALL DIMENSIONS AND TOLERANCES MUST BE HELD REGARDLESS OF THE USE OF QUALITY CONTROL SYMBOLS.
- 1 X.XX DIMENSIONS ARE USED AS REFERENCE ONLY AND ARE NOT SUBJECT TO TOLERANCES.
- UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS AND TOLERANCES ARE APPLICABLE AT 20 DEGREES CELSIUS (68 DEGREES FAHRENHEIT) IN ACCORDANCE WITH ANSI/ASME B89.6.2.
- ALL HOMOGENOUS MATERIALS AND PROCESSES IN THIS DRAWING SHALL BE COMPLIANT TO THE EU RoHS DIRECTIVE 2011/65/EC.
- REFER TO DETAILED WORK INSTRUCTIONS FOR ASSEMBLY SPECIFICATIONS SUCH AS SCREW TORQUE AND GLUE VOLUME.

ASSEMBLY INSTRUCTIONS:

- INSERT THE DRIVETRAIN INSERT INTO THE MAIN BODY. MAKE SURE TO ROUTE THE PRESSURE SENSOR CABLE THROUGH THE HOLE IN THE OUTER BOX AS SHOWN.
- ONCE THE DRIVETRAIN IS INSERTED, SNAP THE MOTOR SIDE AND BUSHING SIDE NUTS INTO THE FLEX FLOORS. USE A TOOL TO FULLY ENGAGE THE NUT MUSHROOM FEATURE INTO THE DOOR.
- SECURE THE DRIVETRAIN INSERT TO THE MAIN BODY USING #2-28X1/4" SCREWS IN 8 PLACES. TORQUE SCREWS TO SPEC GIVEN IN THE DETAILED WORK INSTRUCTIONS.
- INSTALL THE FACEPLATE EXTENSION ONTO THE BALLJOINT FACEPLATE FROM THE BACK, ENSURING THAT ALL SNAPS ENGAGE FULLY.
- ROUTE THE MOTOR AND PRESSURE SENSOR WIRE HARNESES THROUGH THE BALLJOINT HOLE.
- MOUNT THE BALLJOINT FACEPLATE ONTO THE DRIVETRAIN INSERT BY PUSHING THE MALE BALLJOINT INTO THE FEMALE BALLJOINT. ENSURE WIRES ARE NOT DAMAGED. TORQUE THE M2 SCREW TO SPEC GIVEN IN DETAILED WORK INSTRUCTIONS.
- USE TAPE TO SECURE THE VENT BOARD COVER IN PLACE INSIDE THE BALLJOINT FACEPLATE. DO NOT ENGAGE SNAP FIT FEATURES.
- USE TAPE TO SECURE THE PRESSURE SENSOR COVER ONTO THE BACK OF THE MAIN BODY AS SHOWN.
- MAGNETICALLY ATTACH THE FRAME ONTO THE MAIN BODY.
- MAGNETICALLY ATTACH THE FACEPLATE COVER ONTO THE FACEPLATE EXTENSION.
- BATTERY PACK SHIPPED ALONGSIDE VENT IN PULP PACKAGING. DO NOT INSTALL.
- PULP PACKAGING NOT SHOWN. SEE DETAILED WORK INSTRUCTIONS FOR PACKAGING ASSEMBLY INSTRUCTIONS.

DRAWING NO. 201-00025			
REV	DESCRIPTION	ECO	DATE BY
A	INITIAL RELEASE (FROM 900-00006 DRAWING)	000085	3/21/14 AK
B	REMOVE SCREWS (403-00019) FROM PSC	000085	3/21/16 AK
NOTICE: CHANGES TO MATERIAL, DESIGN, CONFIGURATION OR PROCESS MAY NOT BE MADE WITHOUT NOTICE/ACT TO RECOVER. ALL MATERIALS AND PROCESSES MUST BE COMPLIANT WITH ENVIRONMENTAL LAWS AND REGULATIONS AS REFERENCED IN XXXXX.			
MATERIAL:		DESIGN	CTD
FINISH		REVIEW:	DATE:
PART NO.		TITLE	CLASSIFICATION OF CHANGES
DESCRIPTION		VENT 12X6 WALL	INTERNAL
		900-00006	EXTERNAL
		SHEET 1 OF 1	DATE:
		SCALE: 1:1	DATE: