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PROPERTY OF FREEDMAN SEATING COMPANY.

TORQUE REQUIREMENTS FOR FREEDMAN SEATING SEATS.

FW, CORPORATE COLLECTION, BERKSHIRE, GLITZ, RITZ, MT., ARAC AND SALON. ASSEMBLY PRINT 35774.

Application/Process	Parts Required	Qty per Seat	Torque Requirements	Added notes
SEAT TO BASEFRAME	5/16-18 hex nut	4	13ft lbs +/- 2 ft lbs	
	5/16 lock washer	4		
	3/8 flat washer	4		
SEAT TO BASEFRAME (CRS) Assembly Print 35774	5/16-18 hex nut	4	13ft lbs +/- 2 ft lbs	
	5/16 lock washer	4		
	5/16 flat washer	4		
Leg, Weldment to Baseframe (Rear attachment)	1/2 high strength flat washer	6		
	3/4" square tube	2		
	1/2-13 spring nut (unistrut)	1		
(front attachment)	1/2 - 13 x1 1/2 grade 8 hex head screw	1	60 ft lbs +/- 3 ft lbs	The rear sleeve must be between the leg and baseframe
	1/2 spring lock washer	1		
	1/2 high strength flat washer	2		
USR Center Plate to Baseframe Assembly Prints 17941/42	1/2-13 spring nut (unistrut)	1		
	1/2 - 13 x1 1/2 grade 8 hex head screw	1	15 ft lbs +/- 3ft. Lbs	
	1/2 high strength flat washer	1		
Center Retractor Installation	7/16 - 14 spring nut	4		
	7/16 high strength flat washer Z/P	4		
	7/16 - 14 1/2 grade 8 head cap screw ZP	4	15 ft lbs +/- 2ft. Lbs	
Buckle Dead Cables (Both sides)	1/2-13x1 1/2 hex head cap screw , grade 8 ZP	1		
	1/2 flat washer SAE, Z/P	1		
	1/2 Prev Torque hex Conical top locknut, Grade 8,CP	1	60 ft lbs +/- 3 ft lbs	
Tighten until (4) threads are exposed past the nut. Do not overtighten, which tends to crush the rail.	7/16-20x2 1/2 Hex head cap screw Grade 5, ZP	3		
	7/16-20Prev Torque Hex Conical Top Locknut, Grade 8, ZP	3	See Note	

NOTE(S)
1) ASSEMBLY DRAWINGS IN BOM ARE MASTER.
2) TABLE VALUES FOR REFERENCE ONLY.

SEE NOTE 2

REV	DATE	BY	DESCRIPTION
A	02/08/12	NA	PRELIMINARY DRAWING
B	NA	NA	ADD TO SEAT
C	02/04	4013	RELEASE TO PRODUCTION
D	02/14	4022	CHANGE FRONT COUPLER PAGE 2

SEE NOTE 1

ITEM	QTY	DESCRIPTION
7	NA	17941/42 INSTRUCTIONS, ASSEMBLY,USR
6	NA	KIT, ASSY,USR,PREL,CS
5	NA	7/16-20x2 1/2 Hex Head Cap Screw, Grade 5, Z/P
4	NA	24385 INSTRUCTIONS, ASSY, FAMILY, PFL, CS
3	NA	24384 INSTRUCTION ASSY, PFL, SPT
2	NA	31520 ASSY, CHILD RESTRAINT SEAT, CS
1	NA	35774 INSTRUCTIONS, FW SEAT INSTALLATION

COMMENTS:

INSTRUCTIONS: TORQUE SPECS, FW/CORPORATE ASSEMBLIES

DATE: 02/08/12

BY: NA

REV: D

33481

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REV	DATE	BY	DESCR	REV	DATE	BY	DESCR
A	02/08/12	NA	PRELIMINARY DRAWING	1P	TM	DK	
B	NA	NA	ADD TO SEAT	NA	NA	NA	SC
C	02/04	4013	RELEASE TO PRODUCTION	NA	NA	NA	SC
D	07/14	4092	CHANGE FRONT CHAIR LEG Z	NA	NA	NA	SC

TORQUE REQUIREMENTS FOR FREEDMAN SEATING SEATS.

3PT, FAMILY, THOMPSON AND ICS SEAT. ASSEMBLY PRINT 25854

Application/Process	Parts Required	Qty per Seat	Torque Requirements	Added notes
SEAT TO BASEFRAME	3/8-24 hex nut 3/8 lock washers 3/8 flat washer 7/16 high strength flat washer	4 4 4 2	13 ft lbs +/- 2 ft lbs	
Leg Weldment to Baseframe (Rear attachment)	1/2-13 spring nut (unistrut) 1/2 - 13 x 1 1/2 grade 8 hex head screw 1/2 spring lock washer	1 1 1	60 ft lbs +/- 3 ft lbs	The Sleeve must be between the leg and baseframe
(front attachment)	1/2 high strength flat washer 1/2-13 spring nut (unistrut) 1/2 - 13 x 1 1/2 grade 8 hex head screw 1/2 spring lock washer	2 1 1 1	15 ft lbs +/- 3ft. Lbs	The Sleeve must be between the leg and baseframe
	1/2 high strength flat washer	1		
	GO AND GO-ES: ASSEMBLY PRINT 33493			
SEAT TO BASEFRAME	7/16-20x2 3/4 grade 8 hex head screw 7/16 high strength flat washer Seat shackle 7/16-20 lock nut	4 6 2 4	29 ft lbs +/- 2 ft lbs	
Leg Weldment to Baseframe	1/2-13 u-bolt Leg shackle 1/2 high strength flat washer 1/2-13 grade 8 lock nut	2 2 4 4	26 ft lbs +/- 3 ft lbs	
USR Center Plate to Baseframe Assembly Print 32725	7/16-14 spring nut 7/16 high strength flat washer Z/P	4 4	29 ft lbs +/- 2 lbs	
Center Retractor Installation	7/16-14 1 1/2 grade 8 head cap screw Z/P 1/2-13x1 1/2 hex head cap screw, grade 8 ZP 1/2 flat washer SAE, Z/P	4 1 1		
Buckles (Both sides)	1/2 Prev Torque hex Conical top locknut, Grade 8, CP 7/16-20 Prev Torque Hex Conical Top Locknut, Grade 8, ZP	1 3	60 ft lbs +/- 3 ft lbs 29 ft lbs +/- 2 lbs	

NOTE(S)
1) ASSEMBLY DRAWINGS IN BOM ARE MASTER.
2) TABLE VALUES FOR REFERENCE ONLY.

SEE NOTE2

SEE NOTE 1

ITEM	QTY	UNIT	PART #	DESCRIPTION
7	NA	NA	1794142	INSTRUCTIONS, ASSEMBLY, USR
8	NA	NA	32725	KIT, ASSY, USR DEL, CO
9	NA	NA	32725	CS, LEG, THOMPSON, ICS, NER
10	NA	NA	22385	INSTRUCTIONS, ASSY, FAMILY, PBL, CS
11	NA	NA	24884	INSTRUCTION ASSY, PBL, SPT
12	NA	NA	31520	ASSY, CHILD RESTRAINT SEAT, CS
13	NA	NA	35774	INSTRUCTIONS, FW SEAT INSTALLATION

COMMENTS:

INSTRUCTIONS: TORQUE SPECS, FW/CORPORATE ASSEMBLIES

DATE: 02/08/12

BY: [Signature]

REV: D

REV: 33481

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