



**SEAT ASSEMBLY  
AND  
INSTALLATION  
INSTRUCTIONS**



Document no: SG2024-04-17

Date: 17.04.2024

## **INSTRUCTIONS RELATE TO ALL SEGE SEATS FOR ADR 68/00 REVISION 17.04.2024**

The Sege seats have been tested and approved to comply with ADR68, Appendices 1 and 2, and issued with Component Type Approval by the Road Vehicle Regulator (ROVER). Provided below are instructions to install the seats into the applicable vehicles. Please be aware that Sege Seats are not to be modified in any way unless approved by the manufacturer.

The seats are only to be fitted by a competent installer and Sege will not be hold responsible for any poor workmanship or mistakes performed by the installer.

It is important that the seats are installed as per the manufacturer's instructions. Failing to follow the instructions may result in non-compliance and the manufacturer will not be held responsible for the neglect of the installers' duty of care.

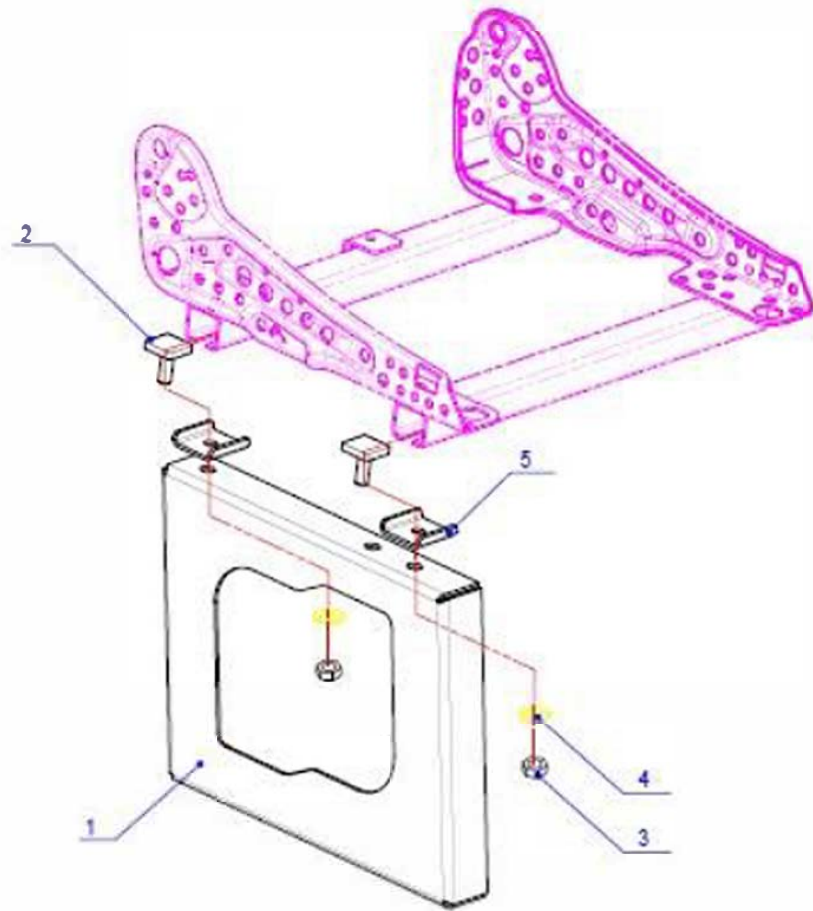
### **Safety and Guidance**

- Ensure that the proper personal safety equipment is used.
- It is recommended that a pilot hole is drilled first to ensure correct position and adequate clearance is provided from fixtures such as wiring looms and fuel lines etc.
- Clean vehicle of any swarf to prevent damage to the floor coverings.
- Seek assistance if needed for manual handling of seats.
- Where mounting holes pass through hollow sections a suitable crush tube/spacer must be fitted to prevent crushing of the section. It is preferred that is tube/spacer is welded. However, a removable insert is acceptable if the bolt will not pull through under crash loads and a tube/spacer is used in each bolt.
- Seating legs and side wall mountings must not exceed 860mm spacing. If this cannot be avoided then additional seat channel clamps must be fitted.

## Fitting Instructions

- Study and understand the seat layout prior to any work being carried out.
- Position the seats as per the approved layout.
- Mark the positions of the holes to be drilled as per the mounting holes in the seat.
- Checks the locations of holes are in the correct position.
- Predrill the holes with a suitable pilot hole to ensure that the seat is installed in the correct position and not interfering with any fixtures. (Use a suitable drill depth guide if needed.)
- Drill out the pilot holes out to 10mm for legs and side walls.  
Note: predrilled holes must not be any larger than 1mm of the bolt diameter. Alternatively, holes can be drilled at 8.5mm and then tapped out to suit bolts.
- Installation of fasteners/bolts can be in plain or tapped holes.
- Clean filling and swarf.
- Position and bolt seat into position using 3 of M10 x 1.50/1.25 10.9 Grade Bolts for legs and of M10 x 1.50/1.25 10.9 Grade Bolts for side wall brackets.
- Bolts are to be fitted with flat washers to top side of mountings. When fixing the underside Sege recommends one of the following options,
  - Flat washer, spring washer and nut.
  - Flat washer and nyloc nut.
  - Hex Flange Serrated (Wizz) Lock Nuts.
  - If tapped frame member with minimum thickness of 8mm then spring washer must be added to the flat washer on the top side of the mountings. It is recommended to use thread lock
- All 10mm x 10.9 high tensile bolts and T-bolts are recommended to be torqued to 63Nm as per AS111

PARTS LIST			
1	209096	SEAT LEG	1
2	2147483647	M10X27.5 - 10.9 GRADE SEAT ASSEMBLY BOLT	2
3	600012	M10 HIGH TENSILE NUT	2
4	600093	WASHER 3MM 10/30	2
5	202030	RAIL CLAMP	2



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MATERI		SENHIST BUCU TOLERANSI		Scale	OLEGLER	Material	HALZEN
				1:10 R 200		ALUMINUM	TIN
		2013 TARİH	ISIM	Designation		403	
		CIZEN 24.04.	SEFBROGLU	SEAT LEG ASSEMBLY			
		ONAY 24.04.	LANGAL				
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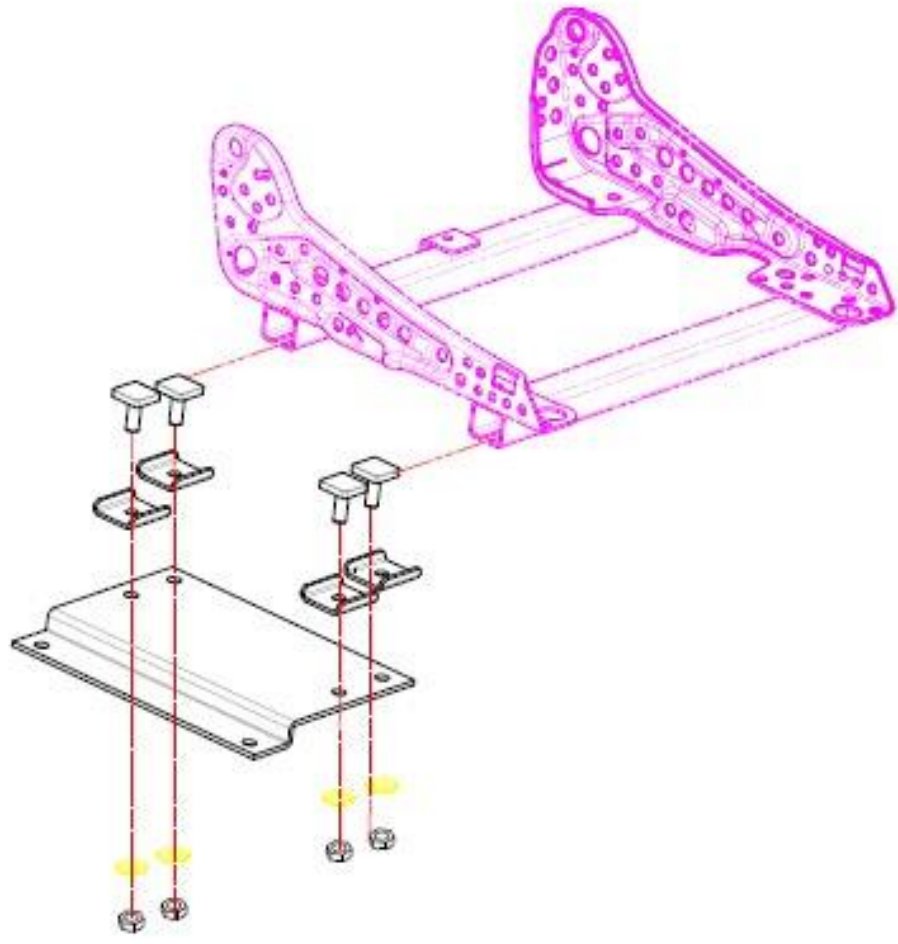


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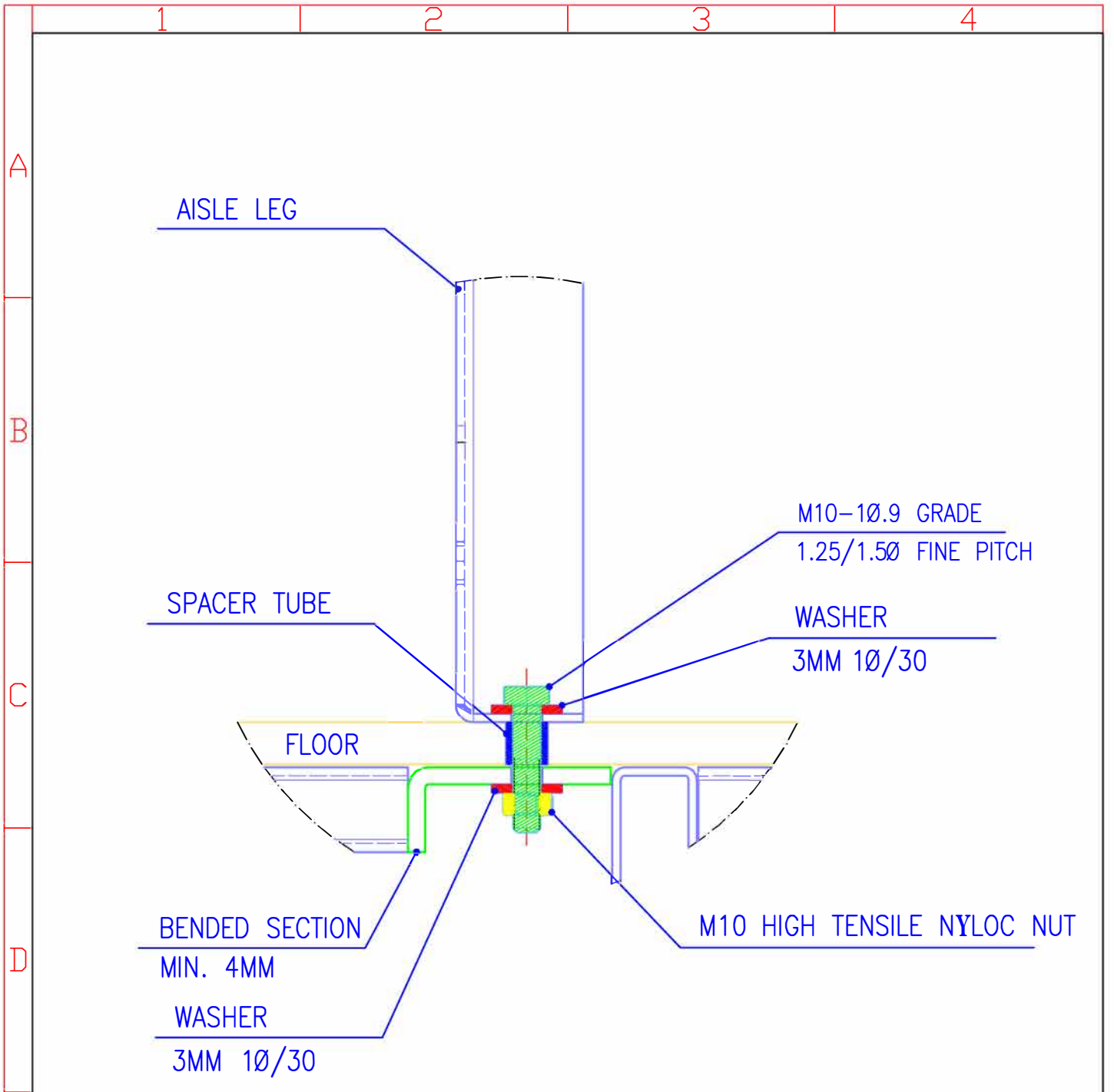
PARTS LIST

1	209097	WALL MOUNT BRACKET	1
2	2147483647	M10X27.5 - 10.9 GRADE SEAT ASSEMBLY BOLT	4
3	600012	M10 HIGH TENSILE NUT	4
4	600093	WASHER 3MM 10/30	4
5	202030	RAIL CLAMP	4

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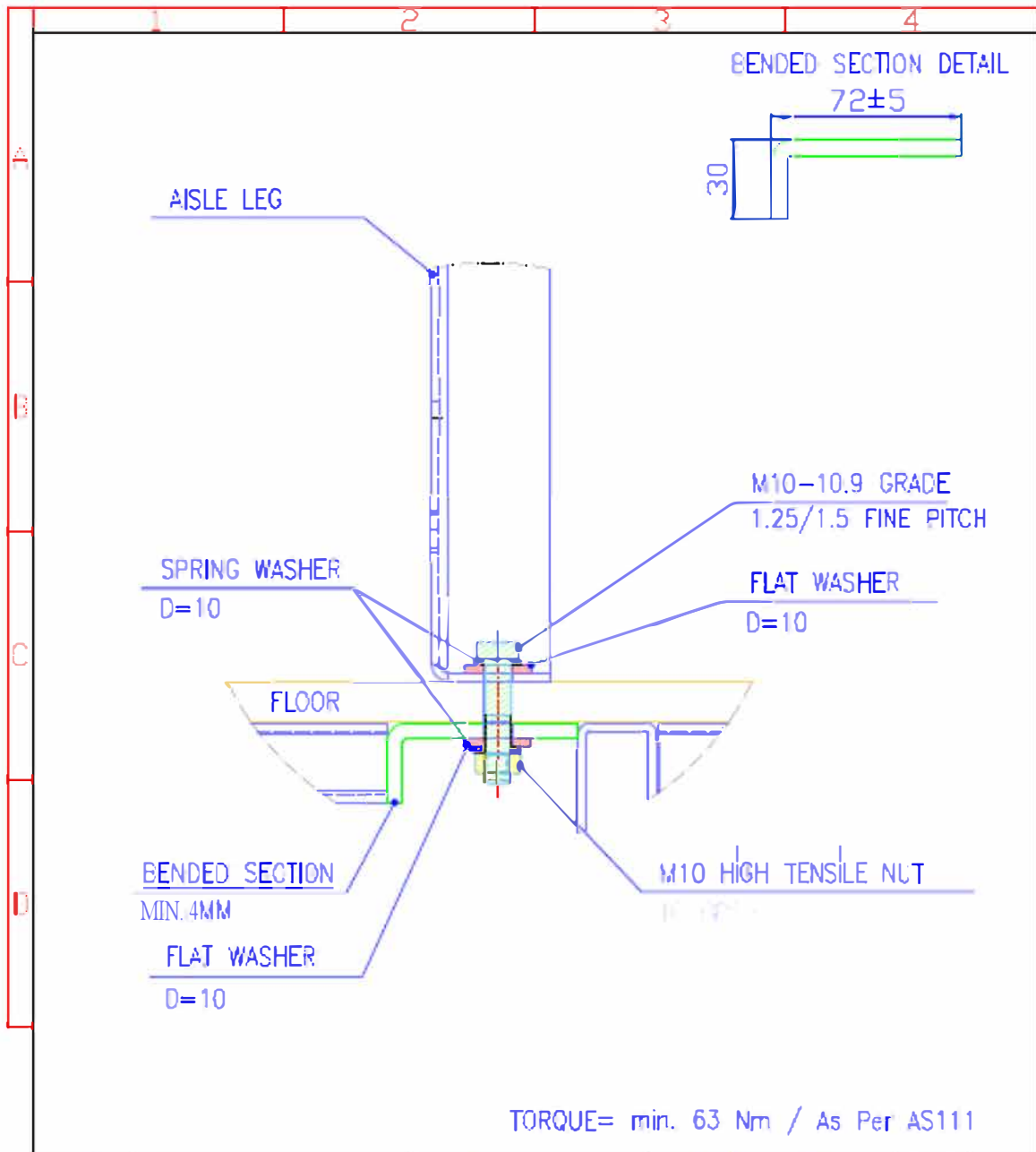


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BİREYSEL/İST			MİSTERİ		<input checked="" type="checkbox"/> Y	Scale	BLOKLER	MALZEME
			SERBEST BLOK TOLEMANCI		BLOK	1/50 R 1/20	Material	
					BLOK İN		BLOK İN	DIN
			2013 TARİH	İSİM	Designation			AİD
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			İNAY 24.04.	LANGAL				
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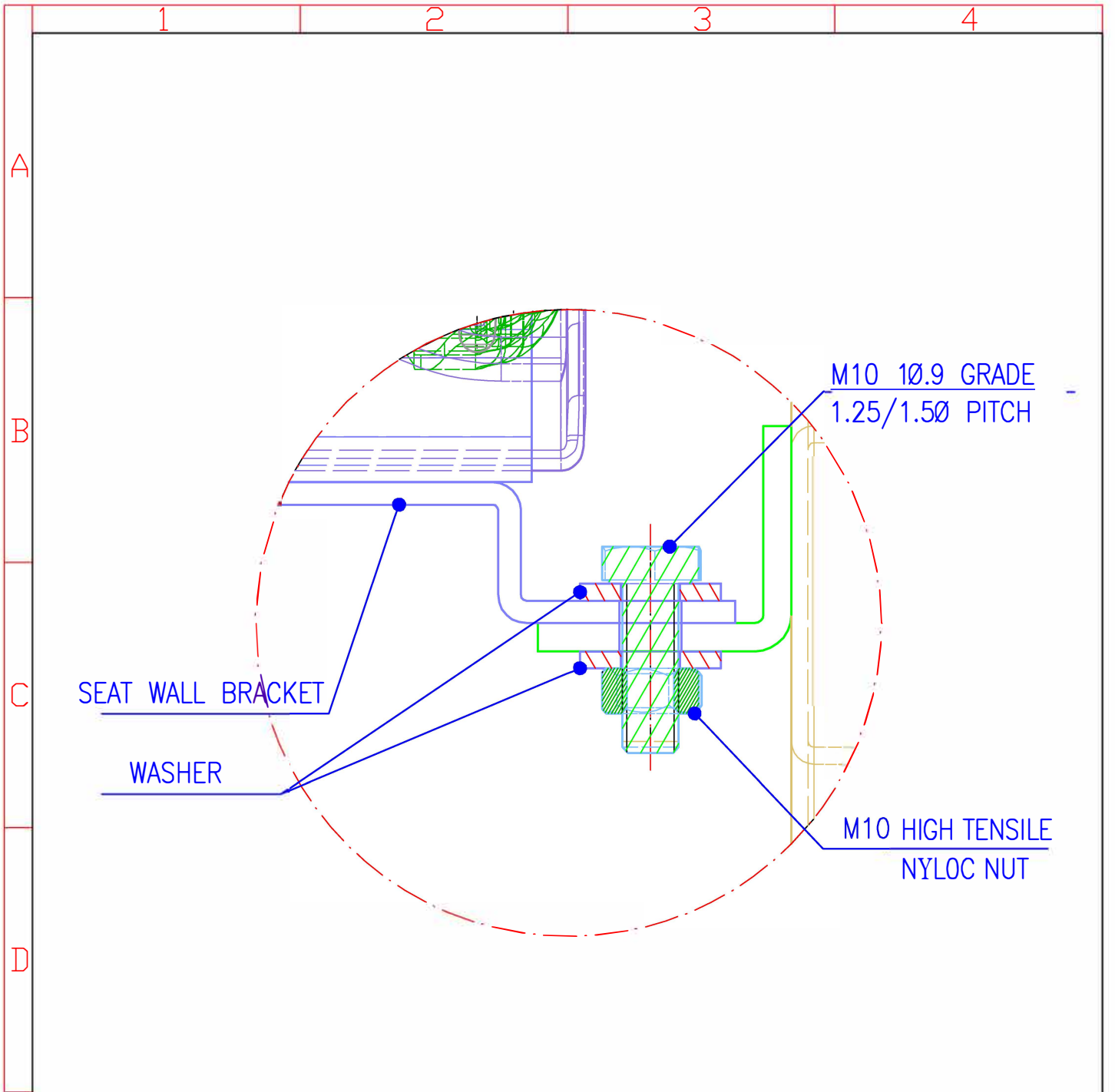
TORQUE= 63 Nm / AS PER AS111

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ÖZELLİKLERİ					MÜŞTERİ			Y			
					SERBEST ÖLÇÜ TOLERANSI			Scale ÖLÇEK	ÖLÇÜLER	Material	MALZEME
								ÖLÇÜ mm	ISO R 128		
					2021 TARİH İSİM			Designation		ADI	
					CİZEN 01.02. SEFEROĞLU			LEG TO FLOOR			
					ONAY 01.02. LANGAL			ASSEMBLY DWG			
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								Dr.Nr.		RESİM NO.	Page
										1	SAYFA 1
										A	4
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MATERIAL				MATERIAL		Scale		DIN/ULI		Material		MATERIAL	
				TOLERANSI		BLOCK		ISO R 320		DIN			
				2021		TARJH		ISIM		Description		411	
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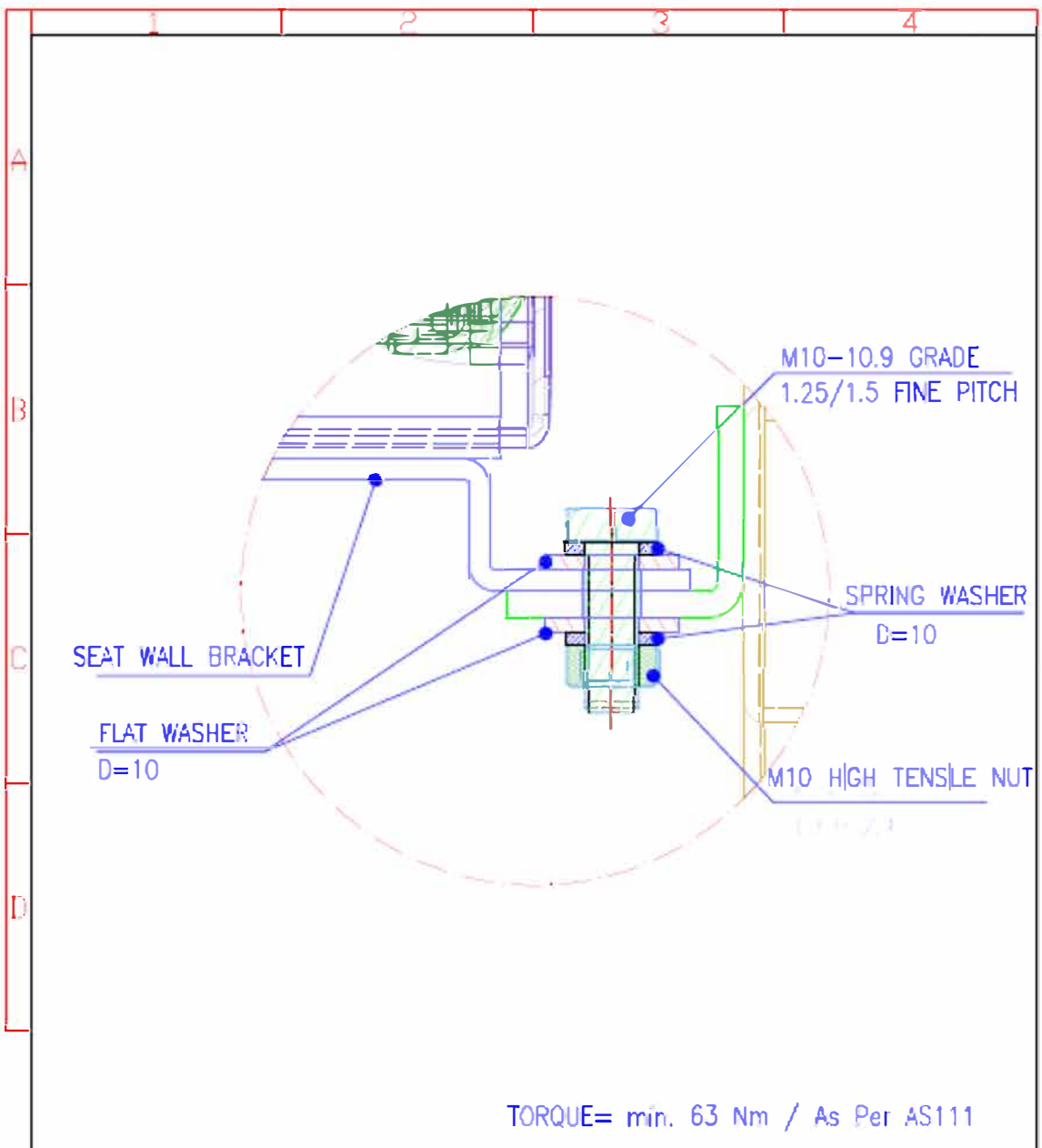


TORQUE= 63 Nm / AS PER AS111

Specifications		Customer		RESİM SEKİ	ÖNEMLİ FONKSİYONLAR/ KONTROL ÖLÇÜSÜ	KRIT.KAR	AUTOCAD
ÖZELLİKLERİ		MÜŞTERİ		Y			
		SERBEST ÖLÇÜ TOLERANSI		Scale ÖLÇEK	ÖLÇÜLER ISO R 128	Material	MALZEME
				ÖLÇÜ mm	⊕	ÖLÇÜ NÖRME	DIN
		2021	TARİH	ISIM	Designation		ADI
		CİZEN	01.02.	SEFEROĞLU	WALL BRACKET ASSEMBLY DWG		
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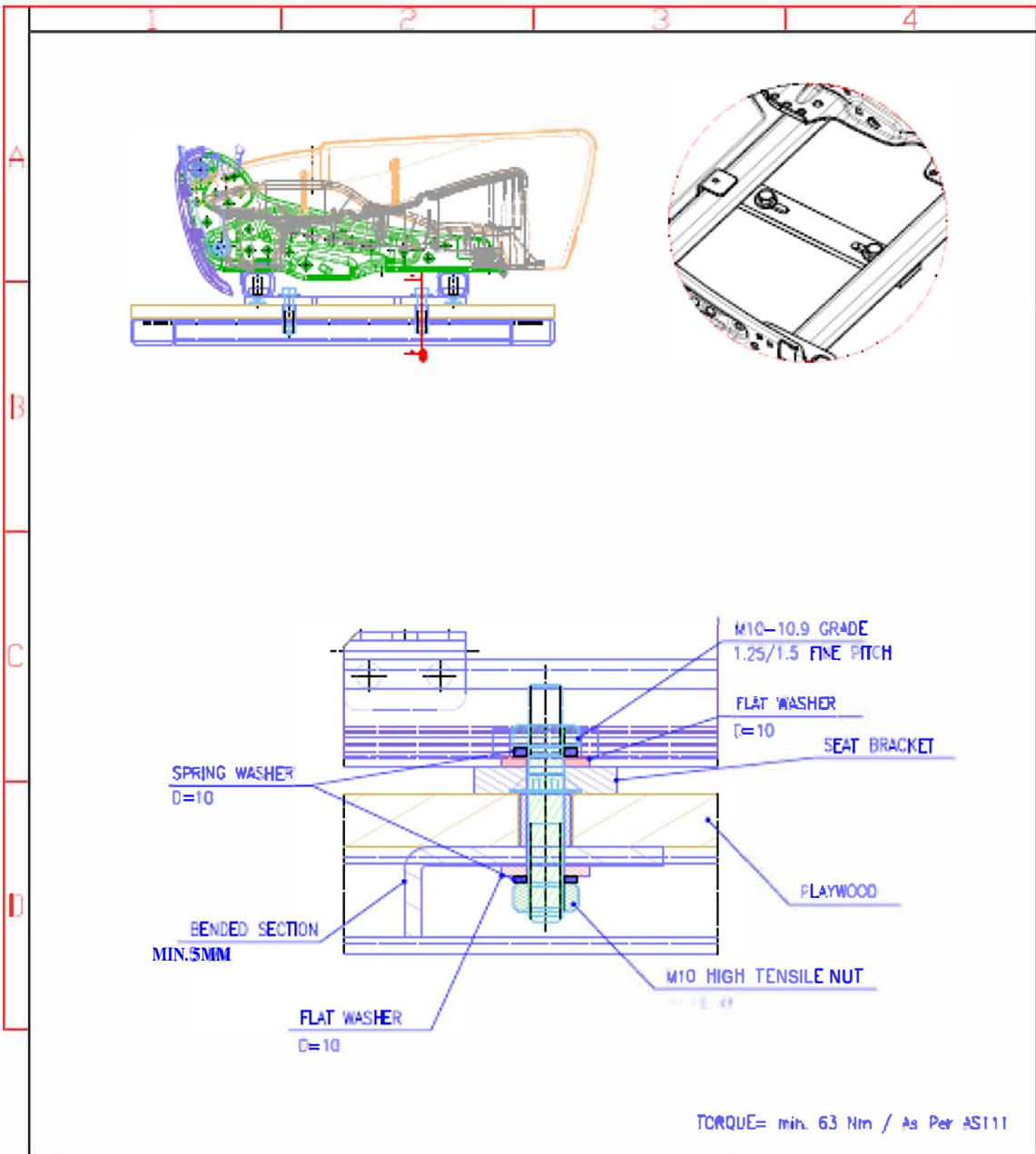
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Specifications		Customer		RESIM SEHLI	<input checked="" type="checkbox"/> ONE-MLI FONKSIONALAR/ IDYTEL BULUSU	KRITIKAR	AUTOCAD
MUTLUKLERI		MUTLUK		<input checked="" type="checkbox"/> Y	Scale	ALUTLER	Material
		SENHESIT BUCU TOLERANSI		Scale	3:50 R 3:20		HALZEPHE
				BUCU NO	<input checked="" type="checkbox"/>	ALCANDIRI	DIN
		2021	TARİH	ISIM	Designation		403
		CCZEN	01.02.	SEFDHOKLU	WALL BRACKET ASSEMBLY DWG		
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BZELD/LEP1		MISTERO		<input checked="" type="checkbox"/> Y	OUTLER	Material	MALJEME
		SEWREST BLDU TOLEWANST		Scale	JSD R 328		
				BLCD H		ALCONDRM	DIN
		2021	TARJH	Designation		A11	
		CIZEN	D.S.D2.	REAR ROW ASSEMBLY DWG			
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				Dr.Nr.		RESIN NO.	Page
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BUTUN		DEGISIKLIK	TARJH				1
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