



**SEAT ASSEMBLY
AND
INSTALLATION
INSTRUCTIONS**



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SEGE SEATS INSTALLATION INSTRUCTIONS FOR ADR 68/00 REVISION 14.05.2024

Introduction:

These instructions apply to all Sege seats approved for compliance with ADR68, Appendices 1 and 2, and issued with Component Type Approval by the Road Vehicle Regulator (ROVER).

The following guidelines detail the correct installation procedures for these seats in applicable vehicles. It is essential to adhere strictly to these instructions, as any modifications to the seats must be approved by the manufacturer. Sege seats are to be installed only by competent installers, and Sege will not be held responsible for any installation errors or poor workmanship.

Safety and Guidance:

- Ensure proper personal safety equipment is used during installation.
- Drill a pilot hole first to ensure correct positioning and to avoid interference with fixtures like wiring looms and fuel lines.
- Clean the vehicle of any debris to prevent damage to floor coverings.
- Seek assistance with manual handling of seats if needed.
- Use crush tubes/spacers in mounting holes that pass through hollow sections to prevent crushing of the section. Welding the tube/spacer is preferred, but a removable insert is acceptable if the bolt will not pull through under crash loads, and a tube/spacer is used in each bolt.
- Ensure seating legs and side wall mountings do not exceed 860mm spacing. If this spacing cannot be avoided, additional seat channel clamps must be fitted.

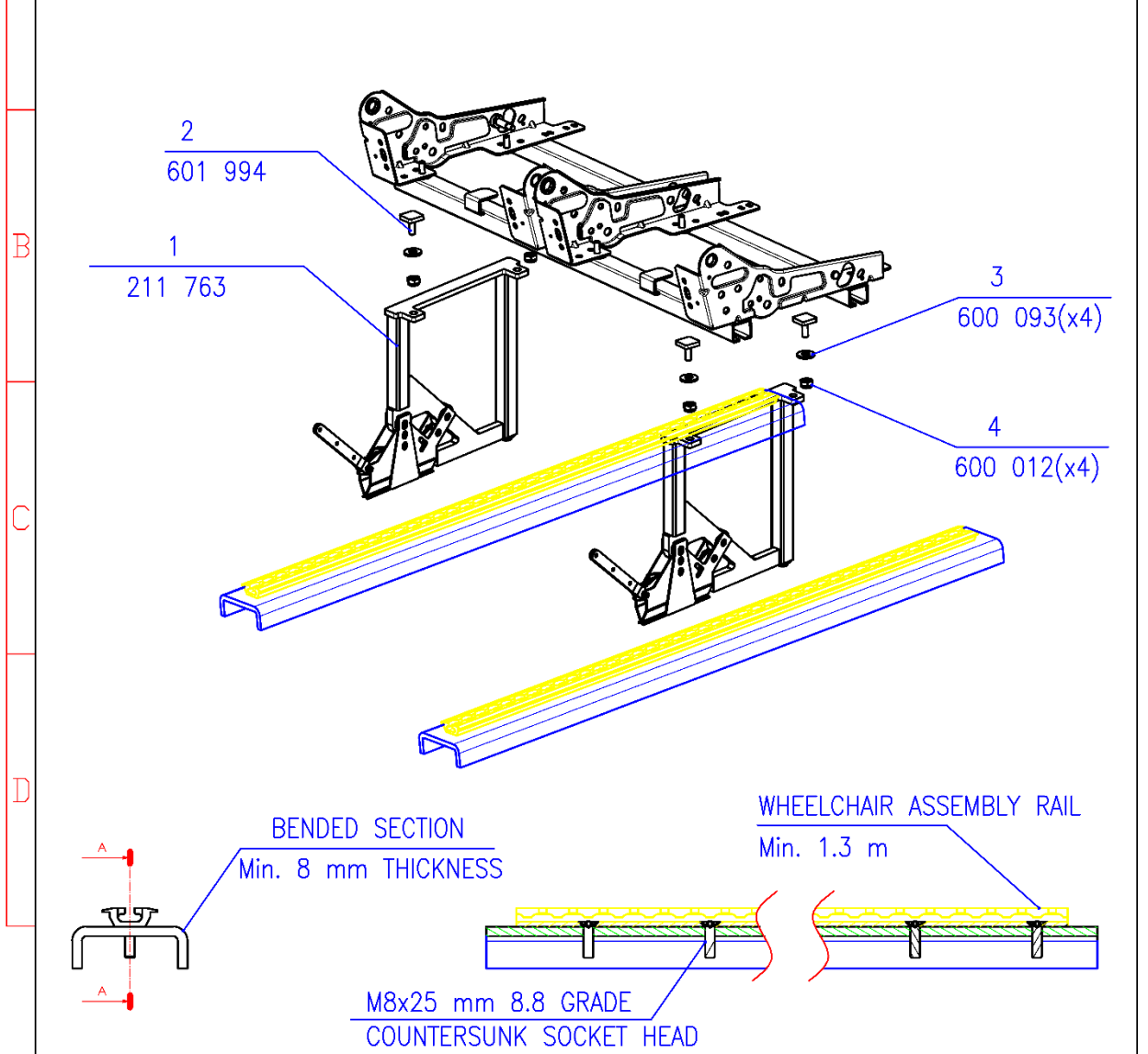
Fitting Instructions:

- Study and understand the seat layout before beginning any work.
- Position the seats according to the approved layout.
- Mark the positions of the holes to be drilled based on the mounting holes in the seat.
- Check that the hole locations are correct.
- Pre-drill the holes with a suitable pilot hole to ensure correct positioning and to avoid interference with fixtures. Use a drill depth guide if necessary.
- Drill out the pilot holes to 10mm for legs and side walls. Note that pre-drilled holes must not exceed 1mm larger than 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 any filings and debris.

Fixed Leg Mounting:

- Sege Seats have been tested using a 50x50x3mm Floor Channel and 40x40x5mm Right Angle side wall framing.
- Position and bolt the seat into place using 3 M10 x 1.50/1.25 10.9 Grade Bolts for legs and 2 M10 x 1.50/1.25 10.9 Grade Bolts for side wall brackets.
- Bolts should be fitted with flat washers on the top side of mountings. For the underside, use one of the following options:
 - Flat washer, spring washer, and nut.
 - Flat washer and nyloc nut.
 - Hex Flange Serrated (Wizz) Lock Nuts.
 - If the frame member is tapped with a minimum thickness of 8mm, add a spring washer to the flat washer on the top side of the mountings. It is recommended to use thread lock.
- Torque all 10mm x 10.9 high tensile bolts and T-bolts to 63Nm as per AS1111.

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PART LIST			
1	211763	NMI-SEGE LEG 285 mm	2
2	601994	M10x27.5 - 10.9 GRADE SEAT ASSEMBLY BOLT	4
3	600093	WASHER 3 mm 10/30	4
4	600012	M10 FIBER NUT 8.8	4



Specifications				Customer		RESİM SEKLI	<input type="checkbox"/> ÖNEMLİ FONKSIYONLAR/KONTROL BÖLÜCÜSÜ	KRIT.KAR	AUTOCAD
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				SERBEST BÖLÜCÜ TOLERANSI		Scale	BÖLÜCÜLER	Material	MALZEME
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						BÖLÜCÜ mm		BÖLÜCÜDÜR	DIN
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				İNAY	22.07.				
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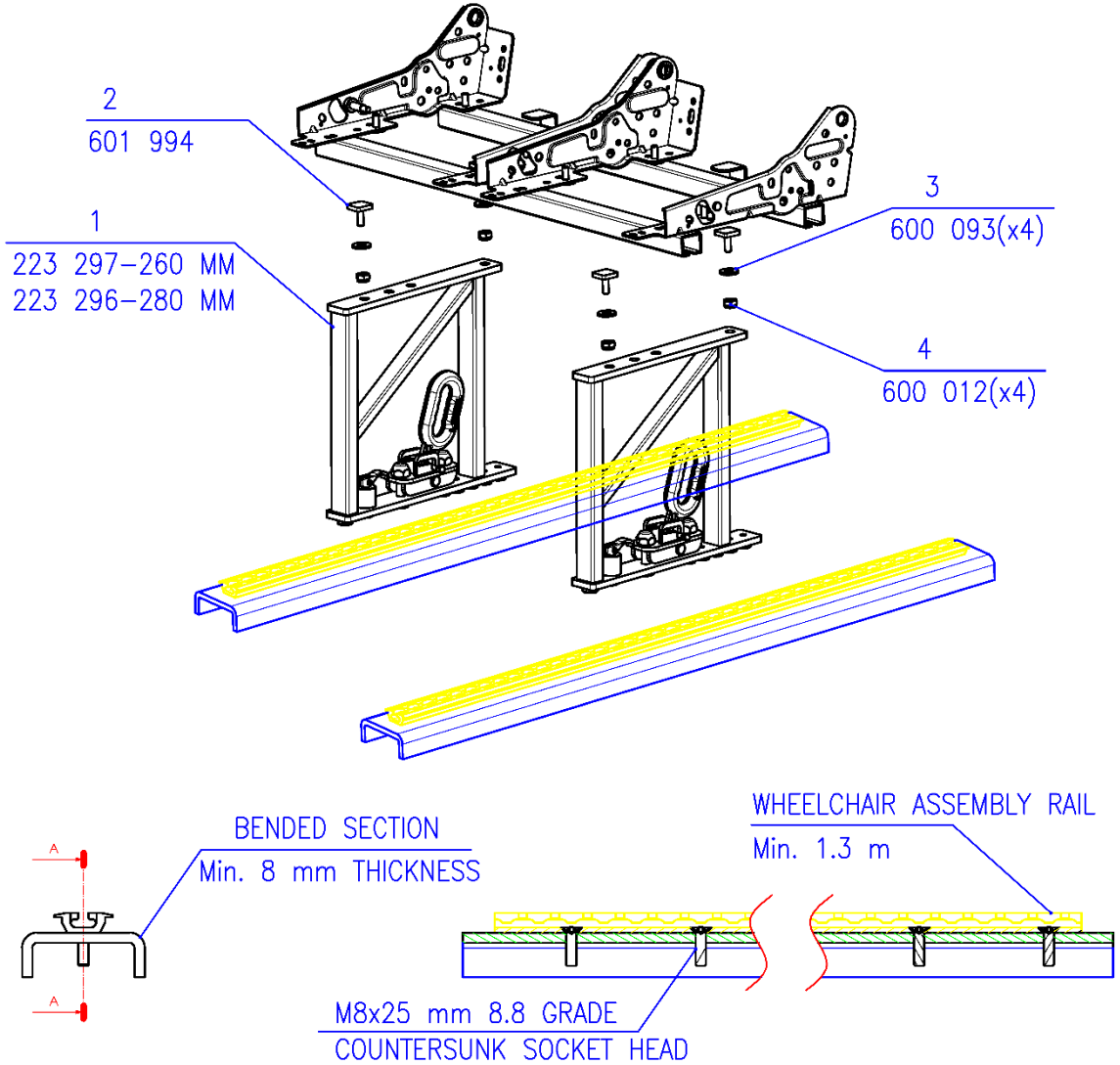
1	223297	DISMO LEG 260 mm	2
1	223296	DISMO LEG 280 mm	2
2	601994	M10x27.5 - 10.9 GRADE SEAT ASSEMBLY BOLT	4
3	600093	WASHER 3 mm 10/30	4
4	600012	M10 FIBER NUT 8.8	4

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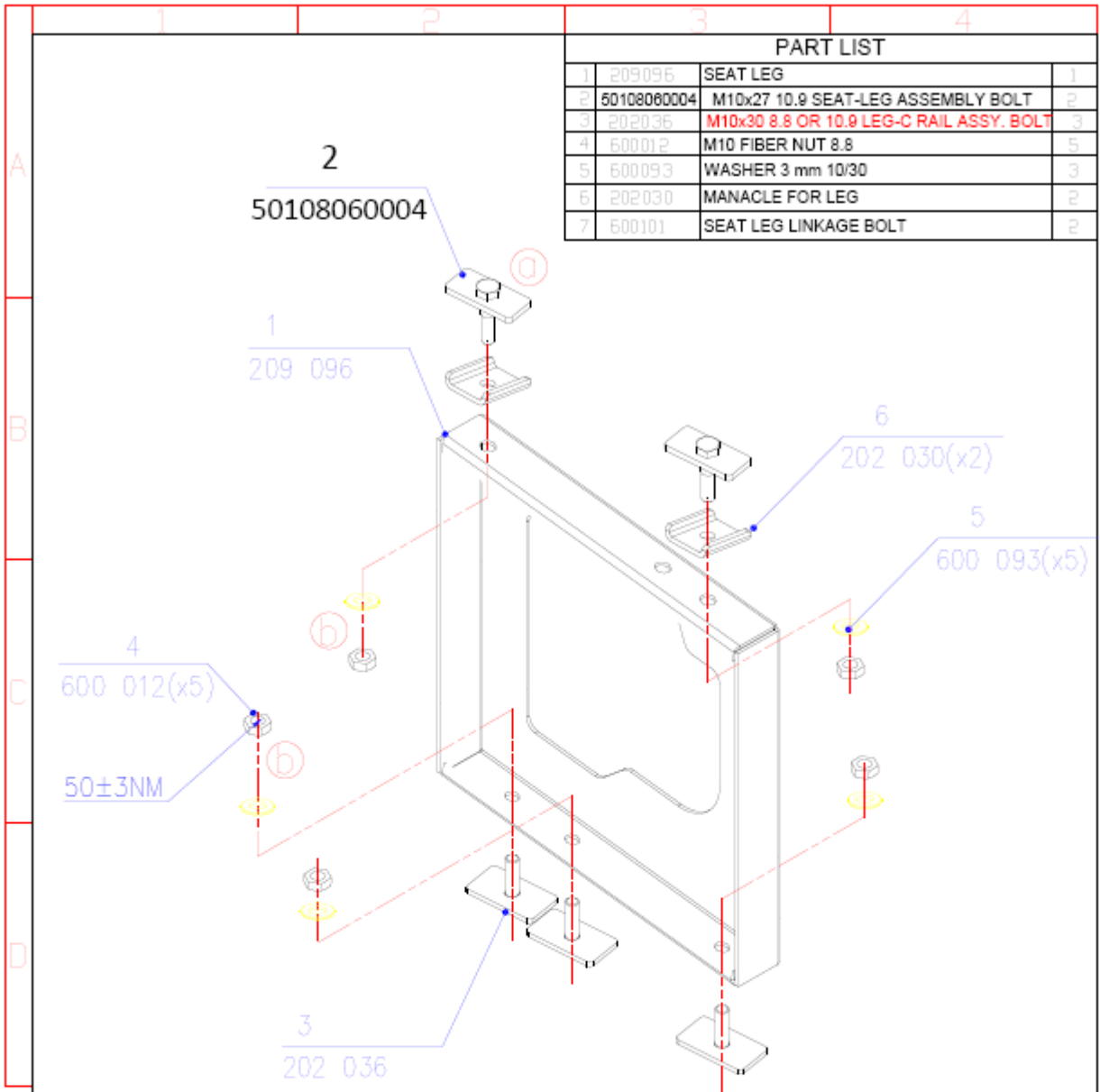
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Specifications				Customer		RESİM SEKLI	<input checked="" type="checkbox"/> ÖNEMLİ FONKSİYONLAR/ KONTROL ÖLÇÜSÜ	KRIT.KAR	AUTOCAD
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						ÖLÇÜ mm	<input checked="" type="checkbox"/>	ÖLÇÜ ÖLÇÜSÜ	DIN
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SÜTÜN		DEĞİŞİKLİK	TARİH	İSİM	İNAY				





PART LIST			
1	209096	SEAT LEG	1
2	50108060004	M10x27 10.9 SEAT-LEG ASSEMBLY BOLT	2
3	202036	M10x30 8.8 OR 10.9 LEG-C RAIL ASSY. BOLT	3
4	600012	M10 FIBER NUT 8.8	5
5	600093	WASHER 3 mm 10/30	3
6	202030	MANACLE FOR LEG	2
7	600101	SEAT LEG LINKAGE BOLT	2

If the wall bracket and aisle leg distance exceeds more than 860 mm, it may require seat channel clamps for added safety. PART NO:202030

Specifications				Customer		RESM SEKLİ	<input checked="" type="checkbox"/> ÖNEMLİ FONKSİYONLAR/KONTROL ÖLÇÜSÜ	ARTIKAR	AUTOCAD
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						ÖLÇÜ mm	\pm	ÖLÇÜNDÜR	DIN
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				Norm		AD			
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ROZ.	Col. Revision	Date	Name	Appr.	A 4				
BÜTÜN	DEĞİŞİKLİK	TARİH	İSİM	ÖMÜ					

