

Jaguar and Rover Triumph
 Parts & Accessories
 LEYLAND CARS
 Fletchamstead Highway
 Coventry CV4 9DB
 England

FITTING INSTRUCTION PART No. 330970

Issue 5 January 1976

SUBJECT: FITTING BENCH TYPE REAR SEAT

MODELS: Land Rover Series 11, 11A & 111

PARTS REQUIRED:

	Qty.	Part No.
REAR SEAT COMPLETE ASSEMBLY, GREY	1	330969
comprises:—		
Rear seat frame assembly	1	331228
Rear seat back rest trimmed assembly	1	320084
Bolt ($\frac{1}{2}$ " U.N.F. x $\frac{1}{2}$ " long)	6	255204
Spring washer	6	3074
Nut ($\frac{1}{2}$ " U.N.F.)	6	254810
Bolt ($\frac{1}{2}$ " U.N.F. x $\frac{3}{4}$ " long)	2	255207
Spring washer	2	3074
Plain washer	2	3821
Nut ($\frac{1}{2}$ " U.N.F.)	2	254810
Rear cushion assembly	1	331833
Rubber buffer	4	304125
Screw (2 B.A. x $\frac{1}{2}$ " long)	4	78120
Packing washer	4	3898
Plain washer	4	4030
Nut (2 B.A.)	4	2247
Packing washer, seat frame to wheel arch	8	2228

} Fixing back rest to frame
 } Fixing seat frame to wheelarch boxes
 } Fixing rubber buffer to seat frame

} 109

PROCEDURE:

1. Ensure that the support angles on the seat frame assembly are set and fitted in their correct positions. For 88 use the upper pair of holes and 109, use the lower pair of holes. Leave the bolts loose until the seat frame assembly is in position. For further details of support angle setting see Fig. 1.
2. 88. Items 2-5.
Take the rear seat frame assembly (331228) and place in a central position on the wheel arch box, ensuring that the support angles engage with the pre-cut slots on the underside of the body capping.
3. Using the frames as a template drill two holes $\frac{1}{2}$ in. (6,5 mm) dia. through the wheel arch box and secure the frame assembly, using two bolts $\frac{1}{2}$ in. x $\frac{3}{4}$ in. long (255207), two plain washers (3821), two spring washers (3074) and two nuts (254810).
Tighten the support angle bolts.
4. Secure the padded back rest (320084) to the seat frame with six bolts $\frac{1}{2}$ in. x $\frac{1}{2}$ in. long (255204), six spring washers (3074) and six nuts (254810).
5. Position the seat cushion (331833) in the seat frame and attach with the tapes provided.
6. 109. Items 6-12.
It is possible to fit one or two seat frame assemblies on each wheel arch box. The following details are for fitting two seat frame assemblies on each wheel arch box.

continued

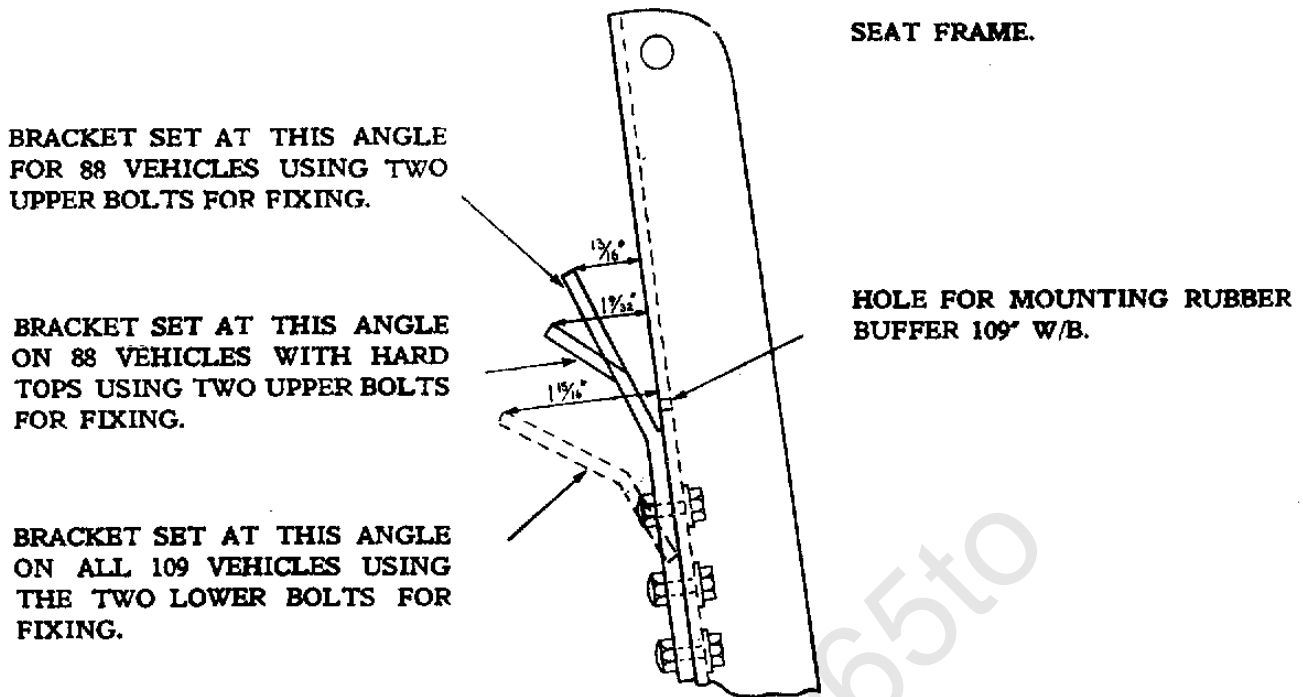


Fig. 1.

NOTE: When four seats are fitted it is necessary to use a special dished bonnet (Part No. 330812) suitable for the spare wheel carrier. The spare wheel well must then be blanked off with a cover plate (330616) and secured with twenty 2 B.A. x $\frac{1}{4}$ in. screws (77887), twenty plain washers (3816), twenty spring washers (3073) and twenty 2 B.A. nuts (2247).
These items are *not* part of the rear seat complete assembly.

7. Remove the spare wheel from the wheel well and remove all the clamping attachments from the body capping.
8. Fit two rubber buffers (304125) to the back of each seat frame assembly just above the support angle in the pre-drilled holes in the frame, using two screws 2 B.A. x $\frac{1}{4}$ in. long (78120), two packing washers (3898), two plain washers (4030) and two nuts 2 B.A. (3823).
9. Take the rear seat frame assembly (331228) and place on the wheel arch box, ensuring that all the support angles engage with the pre-cut slots on the underside of the body capping.
10. Secure the padded back rest (320084) to the seat frame with six bolts $\frac{1}{4}$ in. x $\frac{1}{2}$ in. long (255204), six spring washers (3074) and six nuts (254810).
11. Using the frame as a template, drill two holes $\frac{1}{4}$ in. (6,5 mm) dia. through the wheel arch box.
Place four packing washers (2228) between the seat frame and the wheel arch box before securing with two bolts $\frac{1}{4}$ in. x $\frac{1}{2}$ in. long (255207), two plain washers (3821), two spring washers (3074) and two nuts (254810).
12. Position the seat cushion (331833) in the seat frame and attach with the tapes provided.