

CHAPTER 9

✓ SEAT & SEAT SUPPORT TUBE ASSEMBLY

SECTION 1 SEAT & SEAT SUPPORT TUBE ASSEMBLY

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✓ CHAPTER 9

SEAT & SEAT SUPPORT TUBE ASSEMBLY

Section 1

Seat & Seat Support Tube Assembly Figures SA- 1, SA-2, & SA-3

1. **Figure SA-1 INSERTING METAL INSERT INTO THE TC-1 TUBE CONNECTOR**
Prepare the tube connector (2) by putting the threaded metal insert, threaded end up, in through the bottom of the tube connector. Align the holes in the threaded metal insert with the saddle shaped cut outs in the tube connector. This part will be referred as tube connector / insert.
2. a) **Figure SA-1 ATTACHING MIDDLE CENTER UPRIGHT TO SEAT SUPPORT TUBE**
Locate the top - (i.e. the end with 3/16" bolt hole) - of the middle center upright (1). Insert the tube connector into the middle center upright. Place washer (10) on bolt (6). Insert the bolt through the top hole of the middle center upright. Add a second washer (10) and secure with locknut (7).

b) Align the top (1/4") hole on the tube connector / insert (2) with the center hole of the upper seat support tube (3). Use bolt (5) to attach the two.
3. **Figure SA-1 ATTACHING MIDDLE CENTER UPRIGHT TO REAR CENTER CAGE RAIL**
Attach the bottom of the middle center upright (1) to the previously installed stainless channel (Refer to Chapter 2 / Section 2 / Figure CA-2), which is located on the rear of the center cage rail. Attach with bolt (13) and secure with locknut (11). Due to variation in the bends of the center uprights, a small plastic saddle (18) may be needed Under the stainless channel for proper alignment.
4. **Figure SA-2 PREPARING TO ATTACH BULKHEAD GUSSET PLATE TO CENTER UPRIGHTS**
a) **USING THE METHOD SHOWN IN BOTTOM LEFT FIG SA-2, VERIFY THAT THE BOOM / UPRIGHTS ARE SQUARE AND THAT THE TAIL ALIGNMENT IS CORRECT.**

b) Once the boom and uprights are square, find the center of the upright tubes. This can be accomplished by making several rubbings with a broom handle up and down both of the uprights, at the same time. The high point or center of the tubes will become 'etched' by the broom rubbing.
5. **Figure SA-3 ASSEMBLING THE SEATS**
Assemble the cloth seats (14) by inserting the plastic seat insert (15) into the cloth portion of the seat. Pull the lip of the cloth around the seat insert, starting at one end and working toward the other side. The insert may need to be trimmed down around the edges and filed to remove any sharp edges. Be very careful not to tear out the threads at the corner of the seat.

6. Figure SA-1 ATTACHING RESTRAINT HARNESS TO SEAT SUPPORT TUBE
Slide the upper end of the restraint harness (Refer to Chapter 2 / Section 3 / Figure CA-3) over the left and right side of the upper seat support tube (3). Slide the seat assemblies over the left and right side of the upper seat support tube. Please Note: the position of single strap should be inside of the seat on the three point harness.

Figure SA-1 ATTACH UPPER SEAT SUPPORT TUBE TO CENTER UPRIGHTS

7. Attach the upper seat support tube (3) to the bulkhead gusset plate (4) and the center uprights. Slide the bolt (8) through the grommet on the top of the seat, the hole, as pictured, on the upper seat support tube, through the bulkhead gusset plate, and through the PREDRILLED 1/4" hole in the upright. Add a thin washer (19) and locknut (11). Hand tighten the locknut only, as the upper fuel tank mount tube will be mounted to these bolts. Repeat procedure on opposite side.
8. Figure SA-2 CONT. ATTACHMENT OF BULKHEAD GUSSET PLATE TO UPRIGHTS
Continue attaching the bulkhead gusset plate (4) to the center uprights by lining up the 'etched' lines on the uprights. VERIFY THAT THE TAIL IS VERTICAL AND THAT THE PLATE IS CENTERED ON THE UPRIGHTS. Clamp the plate (clamps not provided) into position. Drill out the TWO UPPER 3/16" holes as noted in the figure, using the plate as a guide, into the center uprights.
9. Figure SA-1 COMPLETING ATTACHMENT OF BULKHEAD GUSSET PLATE TO UPRIGHTS
a) Place washer (9) on bolt (5). Insert through bulkhead gusset plate and center upright. Finish with a second washer (9) and secure tightly with locknut (11). Repeat this procedure on opposite side.

Finish the assembly by pop riveting (17) the gusset plate to the uprights using the remaining four upper 3/16" holes. If you are going to use the Fastback option, wait to pop-rivet the plate.

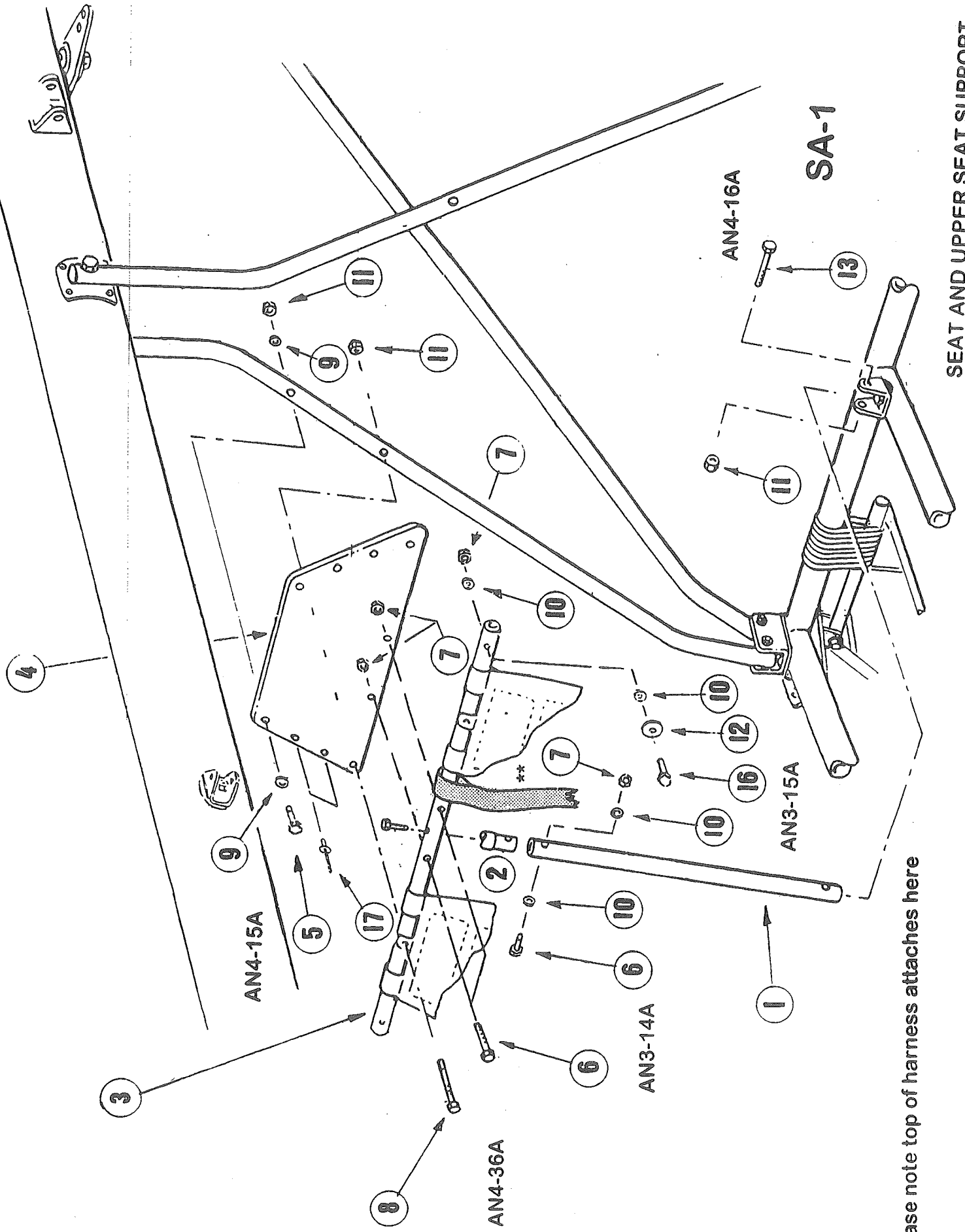
10. Figure SA-3 COMPLETING SEAT ASSEMBLY
Remove the lower seat support tube that was previously installed in Chapter 2 / Section 4 / Figure CA-4. Slide the seat assembly over the lower seat support tube. Reinstall to cage. Securely tighten nuts. DO NOT CRUSH THE TUBE.
11. Figure SA-1 COMPLETING ATTACHMENT OF SEAT SUPPORT TUBE TO BULKHEAD GUSSET PLATE
Attach the upper seat support tube to the bulkhead gusset plate by drilling out the two 3/16" holes located in the center (on either side of the middle center upright) using the upper seat support tube as a guide. Place washer (10) on bolt (6). Insert bolt through upper seat support tube and the bulkhead plate. Add a second washer (10) and secure with locknut (7).

✓ Chapter 9 SECTION 1 SEAT & SUPPORT TUBE

Section 1
 Seat and Seat Support Tube Parts List
 Figures SA-1 - SA-3

INDEX#	PART #	QTY	DESCRIPTION
1.	C-222	1	MIDDLE CENTER UPRIGHT
2.	TC-1	1	TUBE CONNECTOR 1"
	T1-1	1	METAL THREADED INSERT
3.	C-204	1	UPPER SEAT SUPPORT TUBE
4.	C-205	1	BULKHEAD GUSSET PLATE
5.	AN4-15A	3	1/4" BOLT
6.	AN3-14A	2	3/16" BOLT
7.	AN365-1032	6	3/16" LOCKNUT
8.	AN4-36A	2	1/4" BOLT
9.	AN960-416	8	1/4" WASHER
10.	AN960-10	8	3/16" WASHER
11.	AN365-428	5	1/4" LOCKNUT
12.	AN970-4	2	3/16" FENDER WASHER
13.	AN4-16A	1	1/4" BOLT
14.	C-212	2	SEAT
15.	C-126	2	SEAT INSERT
16.	AN3-15A	4	3/16" BOLT
17.	SS64	4	3/16" STAINLESS POP RIVET
18.	SO114	1	1-3/4" PLASTIC SADDLE
19.	AN960-428L	2	1/4" WASHER, THIN

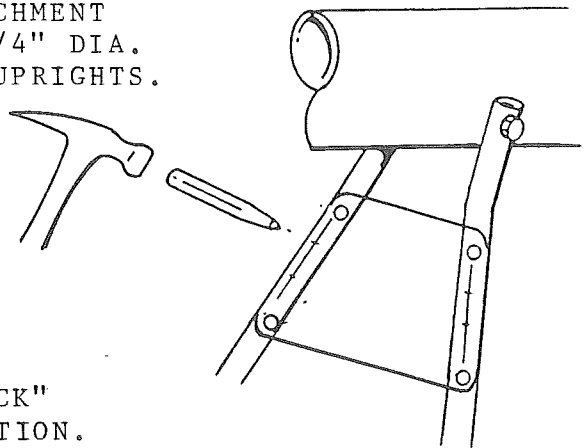
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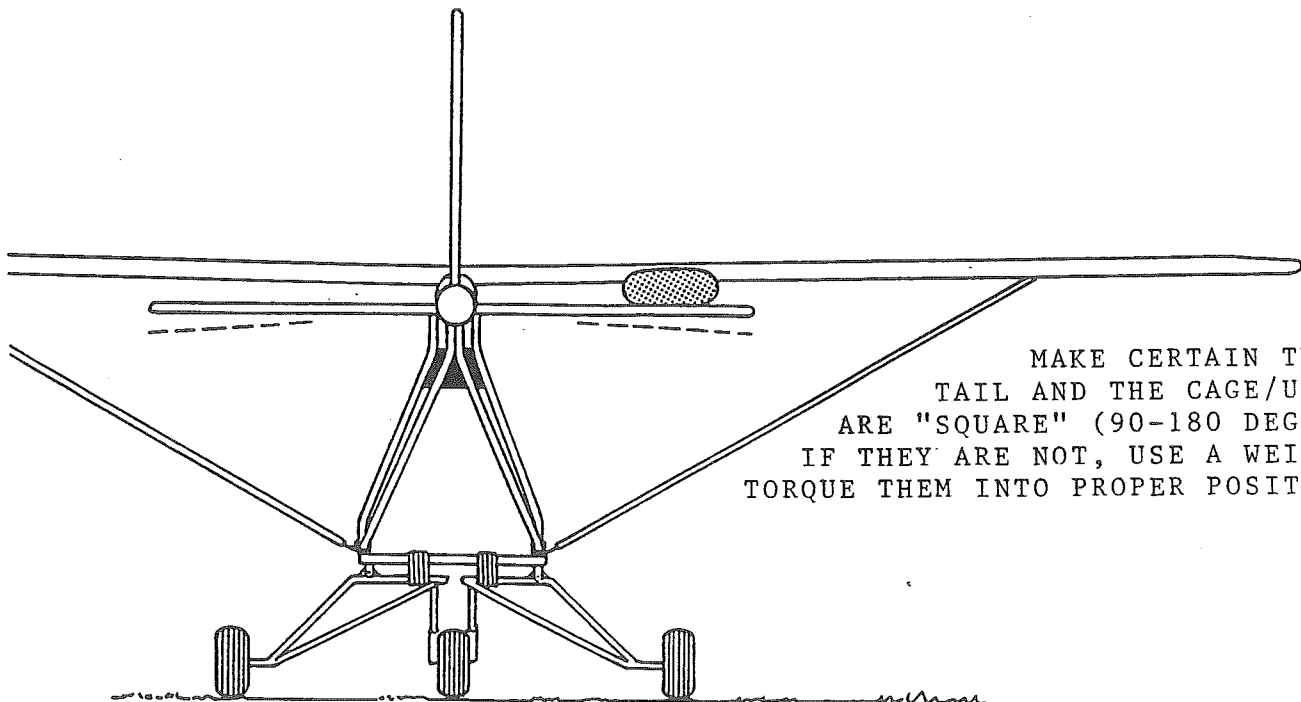
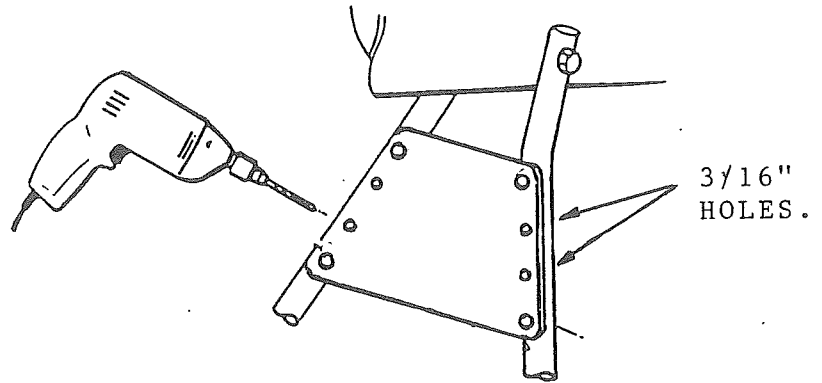
SEAT AND UPPER SEAT SUPPORT

** Please note top of harness attaches here

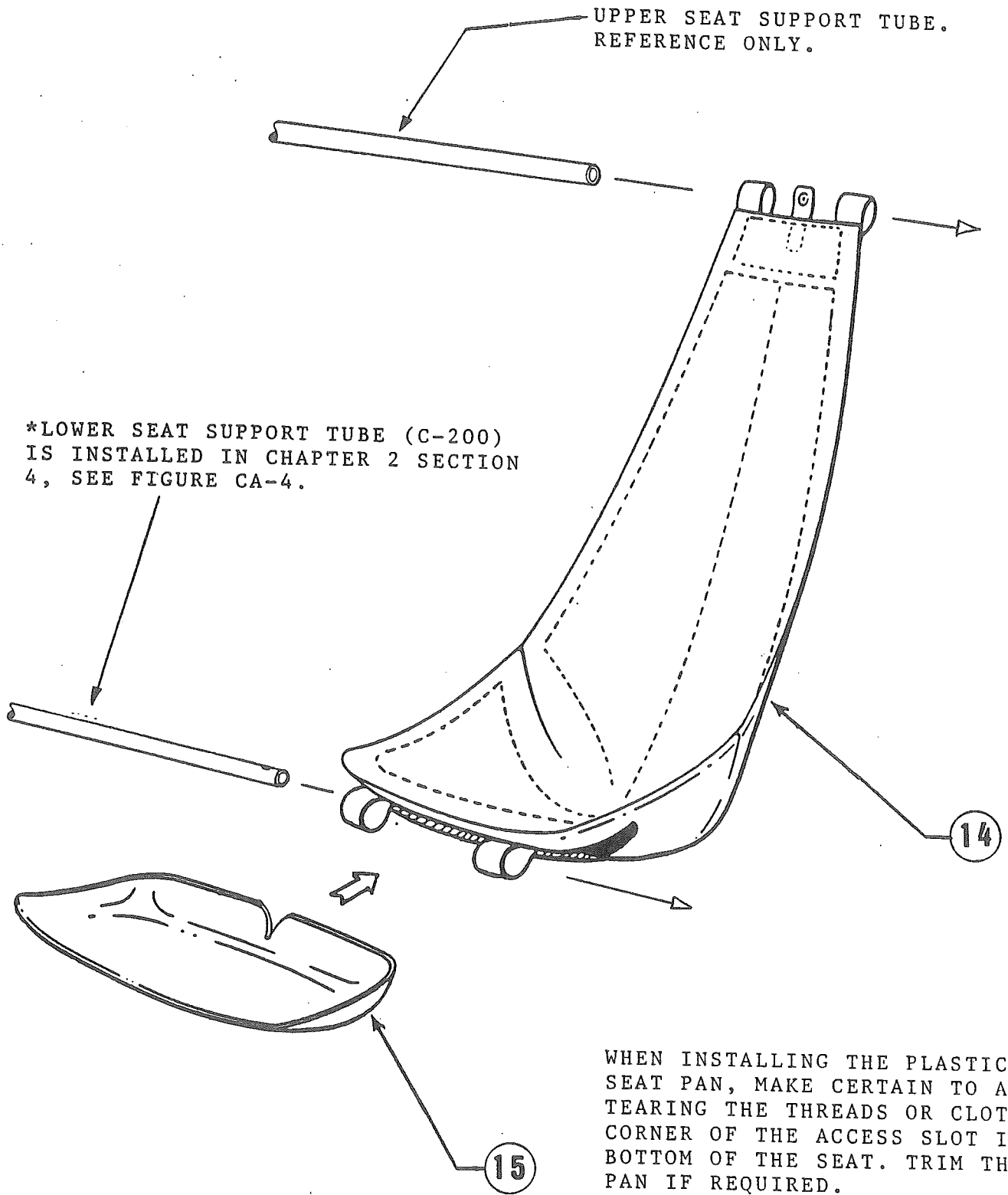
THE UPPER AND LOWER HOLES FOR ATTACHMENT OF THE BULKHEAD GUSSET PLATE ARE 1/4" DIA. THEY ARE PREDRILLED ON THE CENTER UPRIGHTS. AFTER ATTACHING THE 1/4" BOLTS FOR THE GUSSET PLATE, "SQUARE UP" THE TAIL AS SHOWN BELOW.



DRILL OUT THE 3/16" HOLES THAT "LOCK" THE BUKHEAD GUSSET PLATE INTO POSITION. POP RIVET THE PLATE INTO POSITION AS DESCRIBED IN THE TEXT.



MAKE CERTAIN THAT THE TAIL AND THE CAGE/UPRIGHTS ARE "SQUARE" (90-180 DEGREES).. IF THEY ARE NOT, USE A WEIGHT TO TORQUE THEM INTO PROPER POSITION



SA-3

CHAPTER 10

✓ FUEL TANK ASSEMBLY

SECTION 1 FUEL TANK ASSEMBLY

Fuel Tank Assembly	10-1
Fuel Tank Parts List	10-2
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