**Work Instruction: Install Tilt Passenger Seat**

**Tilt Passenger Seat Kit (2401AUA00421N)**

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**INSTALLATION PROCEDURE**

1. Open under seat box, remove (4) lock nuts and washers to remove seat and retain fasteners.

2. Remove (2) seat tracks. Slide seat tracks forward or backward to access all (4) bolts.

3. Install (1) bumper to hinge assembly bracket with (1) M8 button head bolt, (1) washer and (1) nut.

4. Place hinge assembly bracket on outside of seat, secure with (2) M8 button head bolt. Front bolt is installed with second bumper as shown.

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**WORK INSTRUCTION OVERVIEW**

**WARNING**

- **DO NOT ATTEMPT THIS PROCEDURE IF YOU DO NOT HAVE PROPER TOOLS, TRAINING, AND FACILITIES.**
- Read and follow all instructions provided when installing this product. Failure to do so may result in placing occupants at risk of serious injury or death.
- To protect bystanders and the service technician(s), shut vehicle off, remove the Ignition Key and secure vehicle to prevent unintended movement.

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**TOOLS REQUIRED**

- T-40 Torx Bit
- 13 mm Socket

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**TORQUE SPECIFICATION**

Tighten all fasteners to the torque specification below:

- **M8 fasteners** – 7.0 N•m (±1.0 N•m)
- **Seat fasteners** – 24.0 N•m (±3.0 N•m)

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**COMPONENT TABLE**

<table>
<thead>
<tr>
<th>Component</th>
<th>Description</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Hinge Assembly - Seat</td>
<td>P/N - 2401AUA00601N</td>
<td>1</td>
</tr>
<tr>
<td>Support Brace Assembly</td>
<td>P/N - 2401AUA00591N</td>
<td>1</td>
</tr>
<tr>
<td>Latch Bracket Assembly</td>
<td>P/N - 2401AUA00541N</td>
<td>1</td>
</tr>
<tr>
<td>Latch Side Bumper</td>
<td>P/N - 2401AUA00501N</td>
<td>2</td>
</tr>
<tr>
<td>M8 Washer-Plain</td>
<td>P/N - 0028552</td>
<td>5</td>
</tr>
<tr>
<td>M8 Nyloc Nut</td>
<td>P/N - 5308202</td>
<td>5</td>
</tr>
<tr>
<td>M8 x 25 Button Head Flange Bolt</td>
<td>P/N - 0000AUA02021N</td>
<td>2</td>
</tr>
<tr>
<td>M8 x 20 Button Head Flange Bolt</td>
<td>P/N - 0000AUA0331N</td>
<td>3</td>
</tr>
</tbody>
</table>
5. Push rear wire loop pull, through bite-line at rear of seat bottom.

6. Install hinge with (2) M8 flange head bolts in positions shown.

7. Install support brace to top of seat box as shown.

8. Install seat on support brace, putting weld studs through holes of brace.

9. Reinstall (4) nuts and (4) washers to weld studs inside of seat box.

10. Route side wire loop pull for ease of access. Both loop pulls shown for reference.

11. Test tilt seat operation.