Dealer and Distributor: Air-Suspension Seat Inspection Instructions for National Seating HP Model Seats for Weld verification of air-spring mounting bracket for both Seats in trucks And Seats in your inventory

Overview

The purpose of this document is to define the procedure to be used to identify seats that may contain a component with a suspect weld joint located on the upper air spring mount within the inner arms of the air suspension. The concern is that a seat containing this suspect weld joint could unexpectedly lower if weld separation occurs.

Seats that could contain the suspect weld are within a date range from 12/20/2011 until 2/2/2012. The actual suspect weld is on the inner arm component of the suspension and is within a much smaller date range between 11/17/2011 and 11/22/2011. The inner arms are labeled with a date included on the label.

The ONLY parts affected are those that are robotically welded between 11/17/2011 and 11/22/2011. There is a visible difference between a robotically welded part and a manually welded part.

This procedure is intended to train the technician on:

1. How to identify seats within the suspect date range for seats – review of the seat build date on the seat label.

2. How to identify inner suspension arms within the suspect range for arms – review of the inner arm build date label.

3. How to determine whether arms are robotically or manually welded – review of difference between robotically and manually welded parts.

4. Where to go if the technician has questions.

Step 1

- Determine if the seat is on the list of affected Parts on the last page. If the seat is in a truck start with step 1. If the seat is in your inventory start with step 3.

- Only check NATIONAL seats with air-suspension
  (note: if seat has a rubber bellows around lower base, it may need to be moved slightly during this inspection)

- Lift cushion as shown:

Step 2

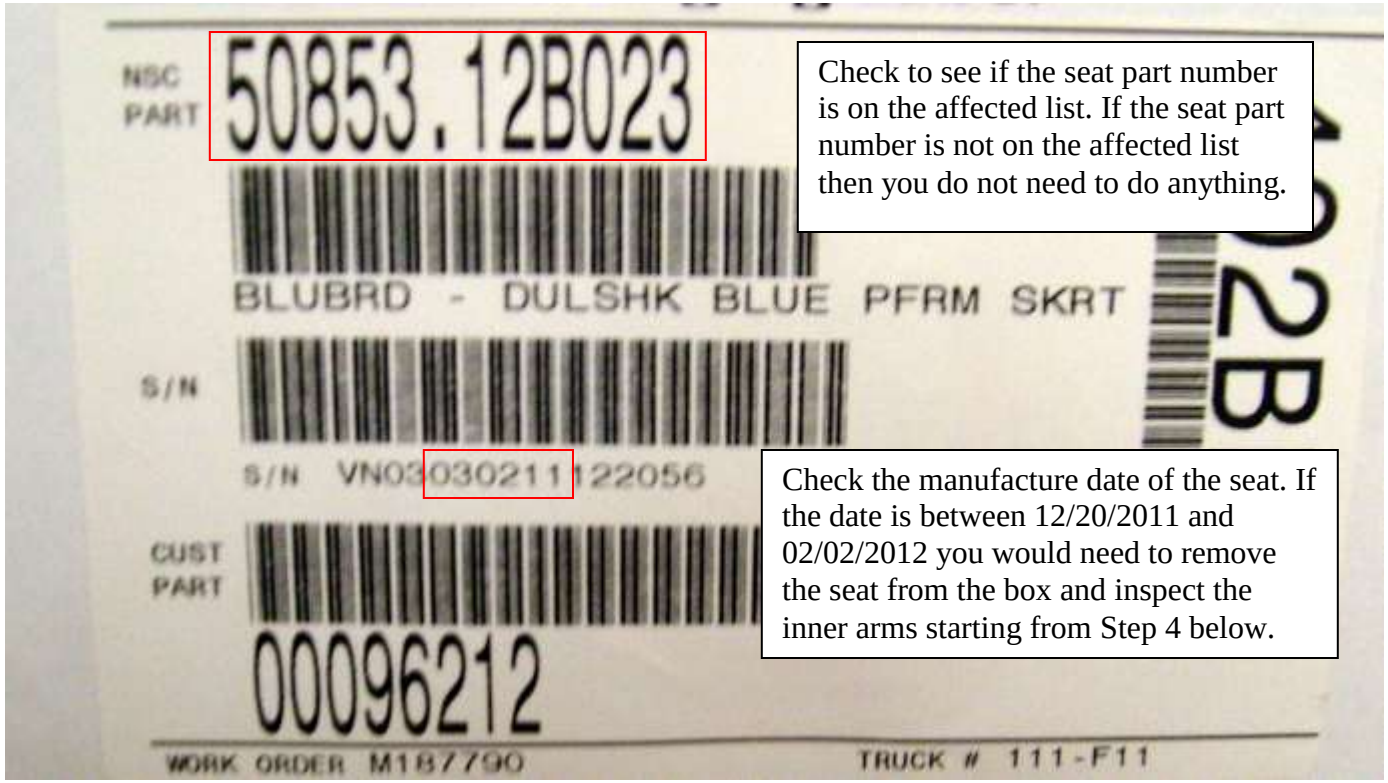
- check date on seat.
  (If date on seat is between 122011 and 020212 then continue).
  (If date on seat is NOT between 122011 and 020212, then the SEAT IS GOOD, no need to go any further.

Back of Seat Directly Under Cushion

These digits in the seat S/N are the date.
MM/DD/YY. Example to left is 12/23/2011

Step 3

- If the seat is in your inventory in its original box you can determine if it is potentially affected by checking the label on the box.

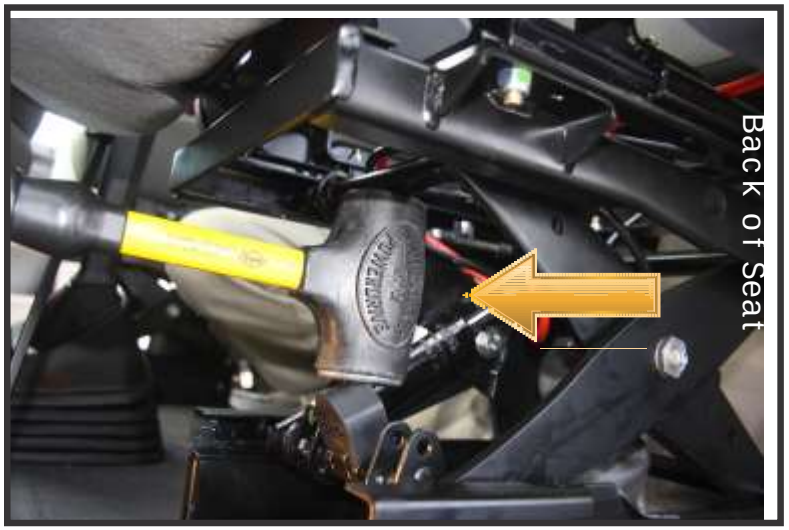


Check to see if the seat part number is on the affected list. If the seat part number is not on the affected list then you do not need to do anything.

Check the manufacture date of the seat. If the date is between 12/20/2011 and 02/02/2012 you would need to remove the seat from the box and inspect the inner arms starting from Step 4 below.

Step 4

- If date on seat is between 122011 and 020212 then check the date on the inner Base arm of the seat suspension.



Prop seat up using a 2x4x6 inches object in between the base arm at the top and the downstop bumper at the bottom as shown in this photo. Then release the air out of the seat.

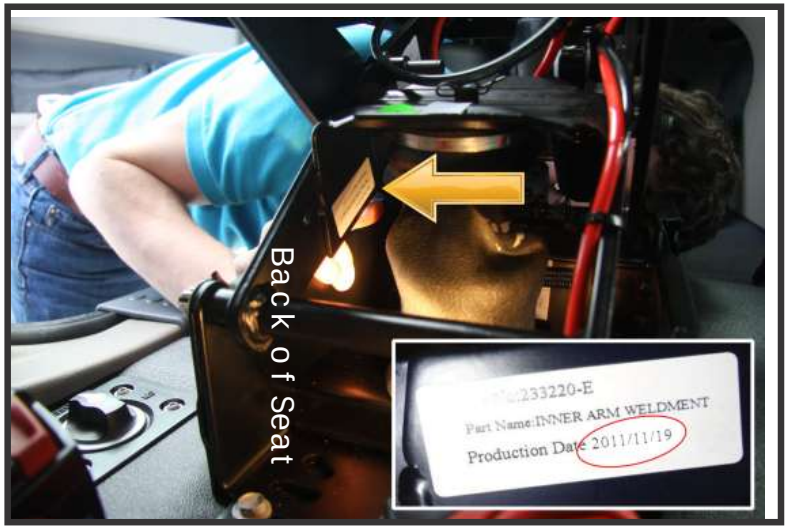
If the seat is not in a truck you will still prop it up but it will not have any air in it so you will not need to release the air as indicated below.

Release Air Suspension to facilitate a better view.

Step 4

- CHECK THE production date on the inner base arm.

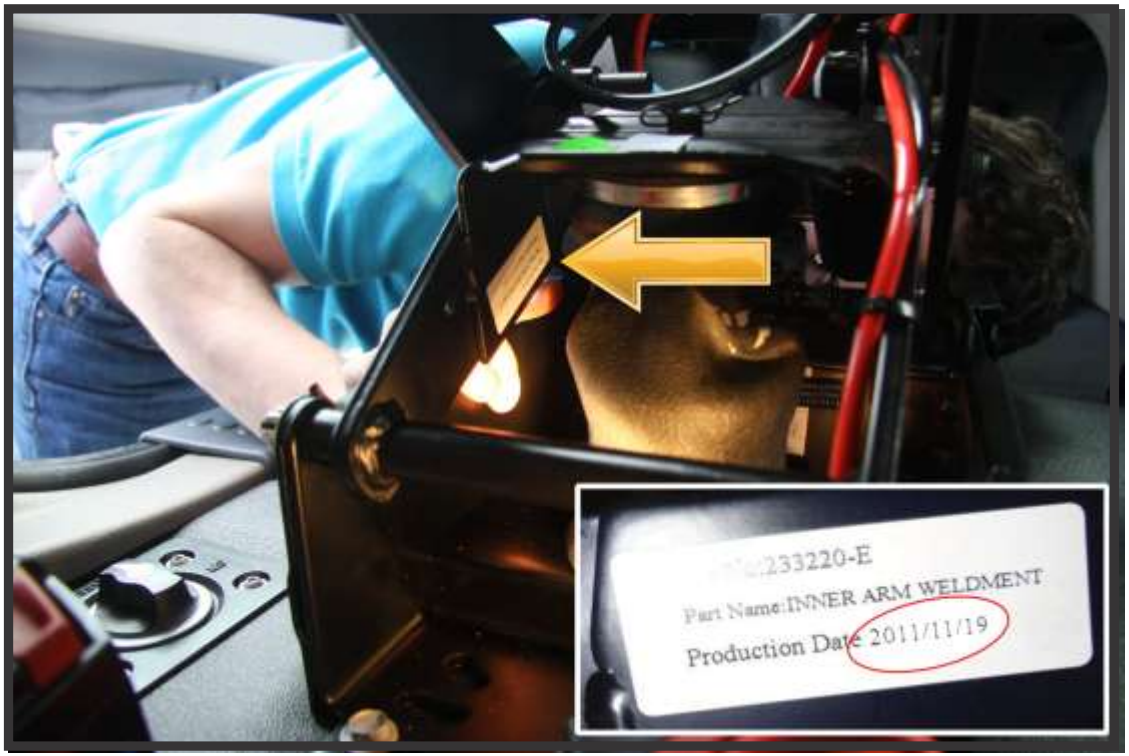
(A small mechanic's mirror may be useful for this check).



Inner base arm label is under the air-spring mounting bracket beside the air-spring.

Step 5

- CHECK THE production date on the inner base arm,



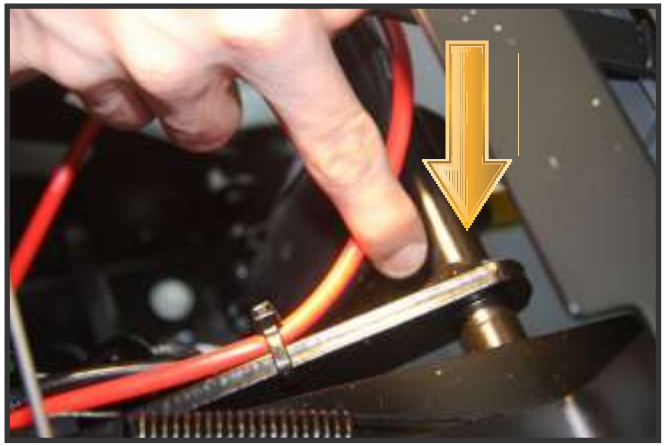
- If the production date on inner base arm is NOT between 2011/11/17 and 2011/11/22, the SEAT IS GOOD and there is no need to go any further.

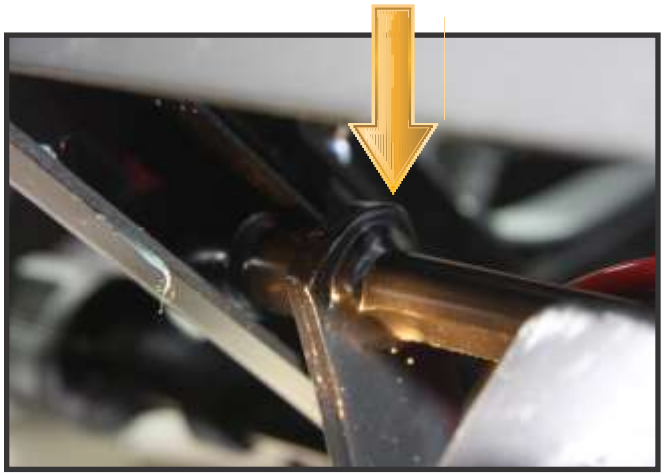
- If the production date on inner base arm is 2011/11/17 to 2011/11/22 Continue to next steps.

Step 6

Identify the weld type…

- CHECK Welds around the end tubes of the inner base arm.
- THIs can be checked at either end of the inner base arm (top or bottom).

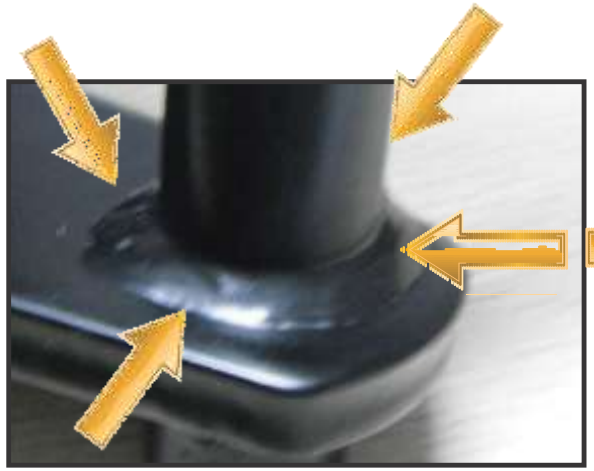
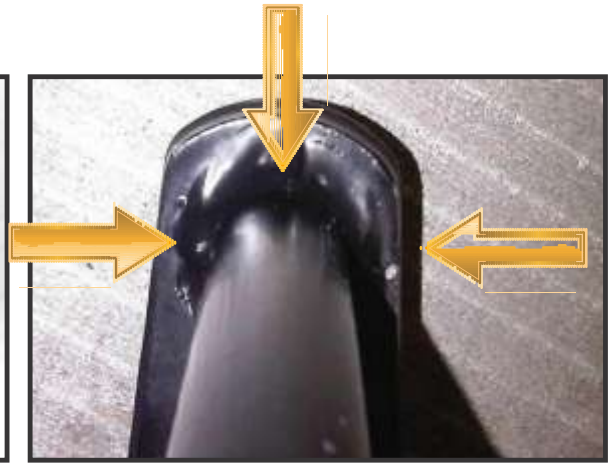
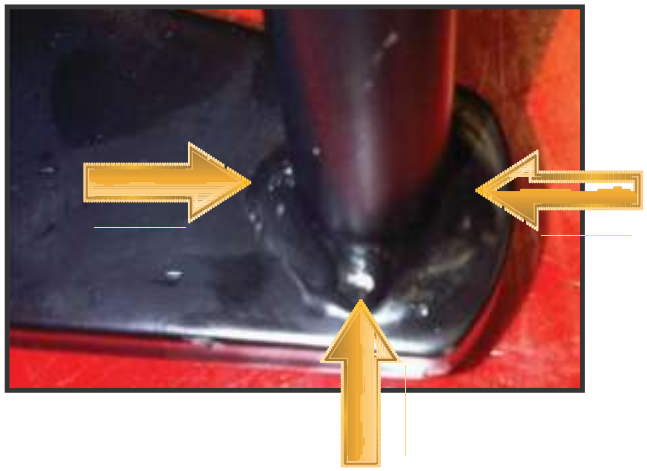




Check welds around the inside of the inner base arm end tubes.

Step 7

- THE Welds on each inner base arm are either all either robotically welded or from manually welded. The easiest place to visually determine how a part Is welded is to look at the weld around the inner base arm end tubes since it is difficult to determine at the air-spring bracket.

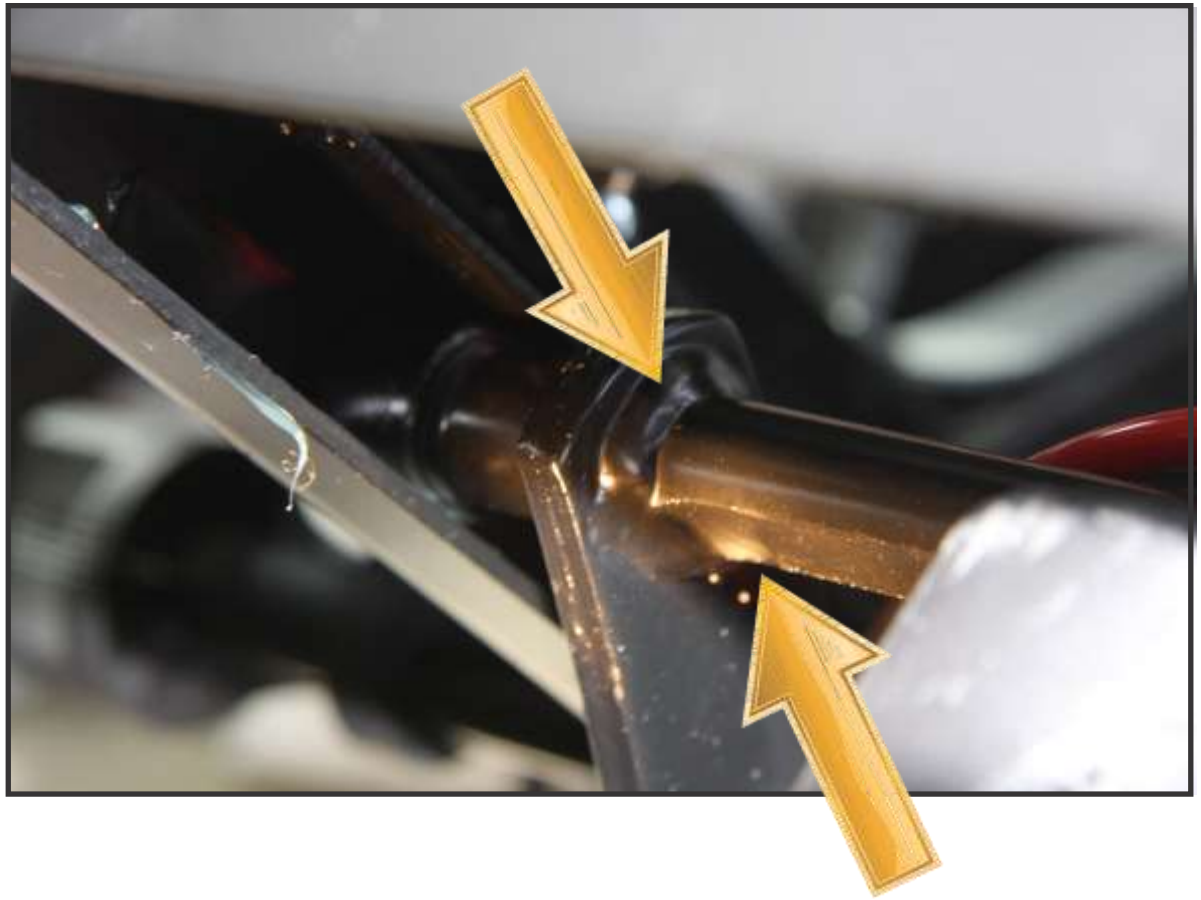




- Robotic Welds
  - Robot welded parts have 4 distinct points around the tube
  - Since the robot welder applies 4 short 90 deg welds around the tubes.

- Manual Welds
  - Manual welded parts have only 2 distinct points around the tube since manual welds are applied in 2 180 deg welds around the tubes.

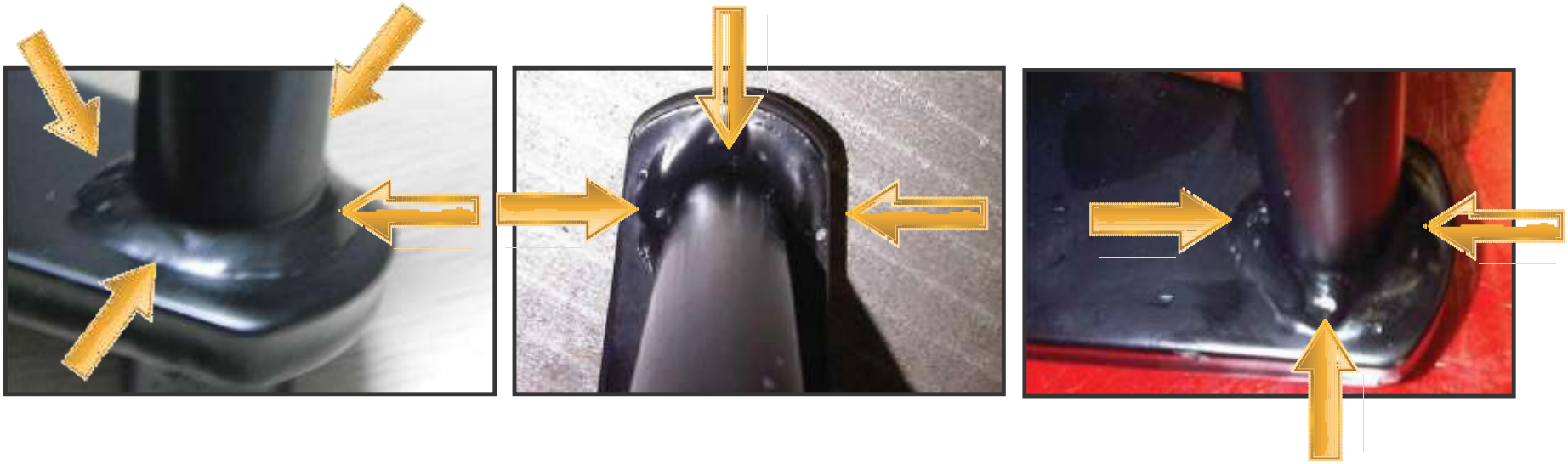
Step 8

- If the seat is manually welded the seat is good and no further steps are needed.
- If you are uncertain if the weld is manual or robotic, photograph it and email to warranty.national@cvgrp.com. We will review the photo and advise you which type of weld it is. The photo should be zoomed to provide a close up view of the weld and needs to be clear and without glare from the flash.



Step 9

- If the inner base arm is robotically welded, then please call our warranty department @ 1-800-222-7328 pick option 1 for customer service then option 3 for warranty. In order for us to supply you with a replacement base we will need the seat part number, the manufacture date of the seat, the date from the inner arms, and the address and contact information to send the replacement to, and if you are the owner who you originally purchased the seat from. Instructions to replace the seat base will included in the service kit.



- Robotic Welds

  Robot welded parts have 4 distinct points around the tube since the robot welder applies 4 short 90 deg welds around the tubes.

  If you have any question or need any assistance during the inspection or replacement process please call our warranty department at the number above.

Step 10

HP Seats Affected Part Numbers					
Part Number	Descriptio	Replacement Service Kit	Part Number	Descriptio	Replacement Service Kit
40049.344	Seat	SK-1616-07	40050.361	Seat	SK-1616-03
40049.346	Seat	SK-1616-07	40050.362	Seat	SK-1616-03
40049.347	Seat	SK-1616-07	40050.363	Seat	SK-1616-03
40049.353	Seat	SK-1616-07	40050.364	Seat	SK-1616-03
40049.355	Seat	SK-1616-07	40050.365	Seat	SK-1616-03
40049.356	Seat	SK-1616-07	40050.366	Seat	SK-1616-03
40049.361	Seat	SK-1616-07	40050.367	Seat	SK-1616-03
40049.364	Seat	SK-1616-07	40149.056	Seat	SK-1616-07
40049.365	Seat	SK-1616-07	40149.351	Seat	SK-1616-07
40049.367	Seat	SK-1616-07	40149.355	Seat	SK-1616-07
40050.041	Seat	SK-1616-03	40149.356	Seat	SK-1616-07
40050.065	Seat	SK-1616-03	40149.361	Seat	SK-1616-07
40050.066	Seat	SK-1616-03	40019.61B	Seat	SK-1616-03
40050.343	Seat	SK-1616-03	40019.65B	Seat	SK-1616-03
40050.344	Seat	SK-1616-03	40019.665B	Seat	SK-1616-03
40050.345	Seat	SK-1616-03	40019.665BC	Seat	SK-1616-03
40050.346	Seat	SK-1616-03	40036.43AB3E	Seat	SK-1616-03
40050.347	Seat	SK-1616-03	40052.43AB2A	Seat	SK-1616-03
40050.354	Seat	SK-1616-03	40156.64AF35M	Seat	SK-1616-03
40050.355	Seat	SK-1616-03			
40050.356	Seat	SK-1616-03	233397-19	Seat Base	SK-1616-03