



Standard Operating Procedure

SOP Title :

[75-2 and 75-4 Rear TV Bracket cheek Rectification](#)

Document No. :	Z-SOP-AH2-P-SP-0075	Revision :	A01
Initial Release Author :	A.Owen	Initial Release Date :	18/01/2017
Ranges Affected :	Autograph II	Models Affected :	75-2 75-4

Document Revision History :

Revision :	Reason For Change :	Prepared By :	Release Date :
A01	Initial Release	A.Owen	18/01/2017

Document Sign Off :

Revision :	Prepared By :	Quality :	Production :	Prototype (Optional) :
A01				

EHS and PPE Requirements :

<p>PPE Requirements:</p> <div style="display: flex; flex-direction: column; gap: 10px;"> <div style="display: flex; align-items: center;"> <div style="background-color: #0056b3; color: white; padding: 2px 5px; font-size: 8px;">Protective footwear must be worn</div> </div> <div style="display: flex; align-items: center;"> <div style="background-color: #0056b3; color: white; padding: 2px 5px; font-size: 8px;">Hearing protection must be worn</div> </div> </div>	<p>Additional EHS Information :</p>
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Parts :

	<p>No10x1/2 Pozi Pan Steel Screw Type AB S/T</p> <p>PART NUMBER 1410044</p>		<p>605mm x 150mm x15mm Edged mendip ash panel</p>
	<p>160mm x 100mm x 9mm wood block</p>		

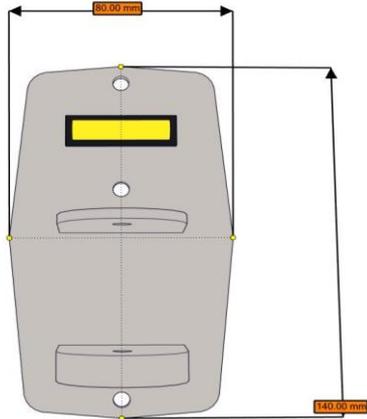
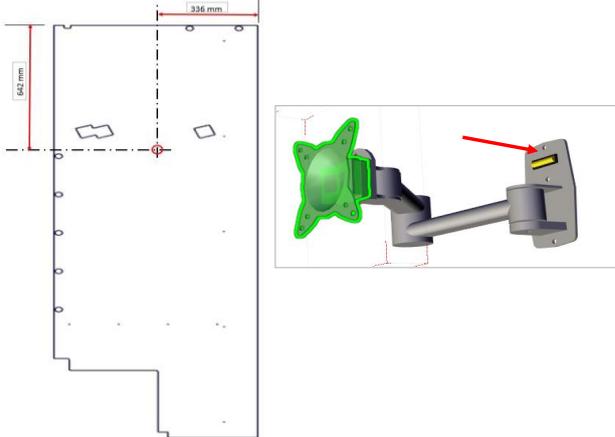
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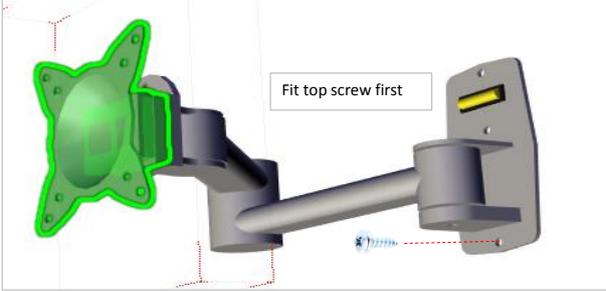
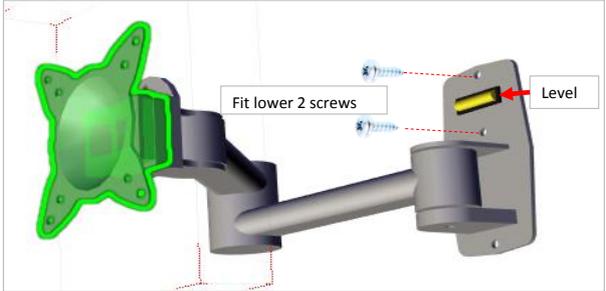
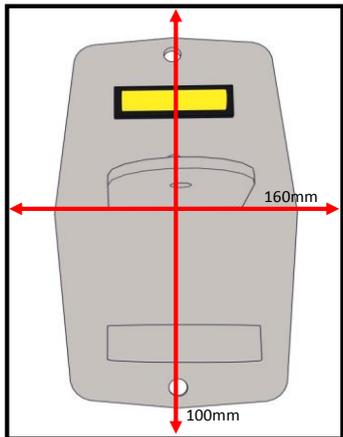


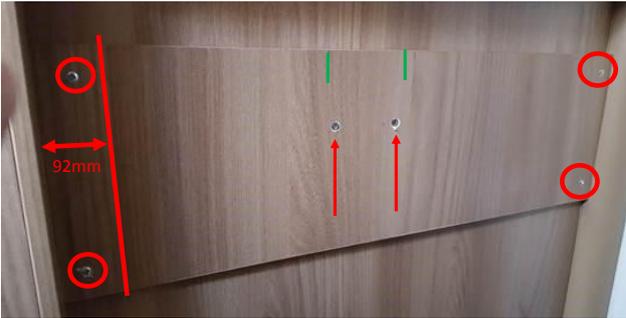
DeWalt Drill



Tape Measure

Op.	Operation Description :	Photo :
1	<p>As part of a weight reduction exercise the robe cheek in the 75-2 and 75-4 has been changed from a solid panel to pin construction.</p> <p>This means no provision for supporting an aftermarket TV bracket is in place.</p> <p>Therefore the following SOP is an aftermarket solution.</p> <p>PLEASE NOTE ONLY 2 BUILDS OF VAN ARE EFFECTED BY THIS ISSUE. THE PROBLEM HAS NOW BEEN RESOLVED.</p>	
2	<p>The base of the TV arm bracket measures:</p> <p>140mm in height 80mm in width</p>	
3	<p>Firstly you will need to fit the bracket in place. This will show you exactly where you should cut in the next step of this SOP.</p>	
4	<p>The correct location for the TV arm is as follows:</p> <p>The measurements are to locate the top screw hole on the base of the TV bracket.</p> <p>642mm from the top of the cheek 336mm from the left side (Wall side) of the cheek</p>	

Op.	Operation Description :	Photo :
5	<p>Measure the position of the top hole and fixing bracket with No.10 X 1/2 Pozi Pan Steel Screw (1410044) in top hole. Do not use the screws supplied with the fix bracket.</p>	
6	<p>Adjust and hold the bracket level (has own spirit level) then fit remaining 2 screws (1410044).</p>	
7	<p>Once the arm has been screwed into place remove all three screws and remove the TV arm. This will leave 3 holes in the cheek.</p> <p>Move to the opposite side of the cheek (inside the robe and mark the same measurement for the top screw hole (Step 4) on this side.</p> <p>Using the top hole location as a guide place the tv arm in place (inside the robe) and draw around the base.</p> <p>Once you have the the shape of the base marked you should mark a rectangle around it allow 10mm on each side.</p>	
8	<p>Using the oscillator, carefully cut out the rectangle you have just marked.</p> <p>You must make sure you only cut through the first layer of 3mm ply. Any deeper cut will damage the other side of the cheek and will lead to a full cheek replacement.</p> <p>The picture shows the cut inner ply and the exposed tv bracket holes.</p>	

Op.	Operation Description :	Photo :
9	Place the block of 160mm x 100mm x 9mm wood in to the cut out.	
10	Whilst holding the block in place screw the TV arm back into position using the holes you previously drilled.	
11	<p>Offer up the edged backing panel and mark the position of the block you have fitted (Green lines). This is needed for the final 2 screws.</p> <p>The the side supports within the cheek of the robe are 92 mm wide. Therefore the 4 outer screws should be place no more than 20mm in from the sides (This allows for the width of the coving on the righthand side).</p> <p>Once the backing panel is fitted in place screw in the final 2 screws. Indicated by the 2 red arrows.</p>	
12	Finally cover all of the screw heads with wood stickers ensuring the grain runs in the correct direction.	

Op.	Operation Description :	Photo :
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