



SEGWAY®

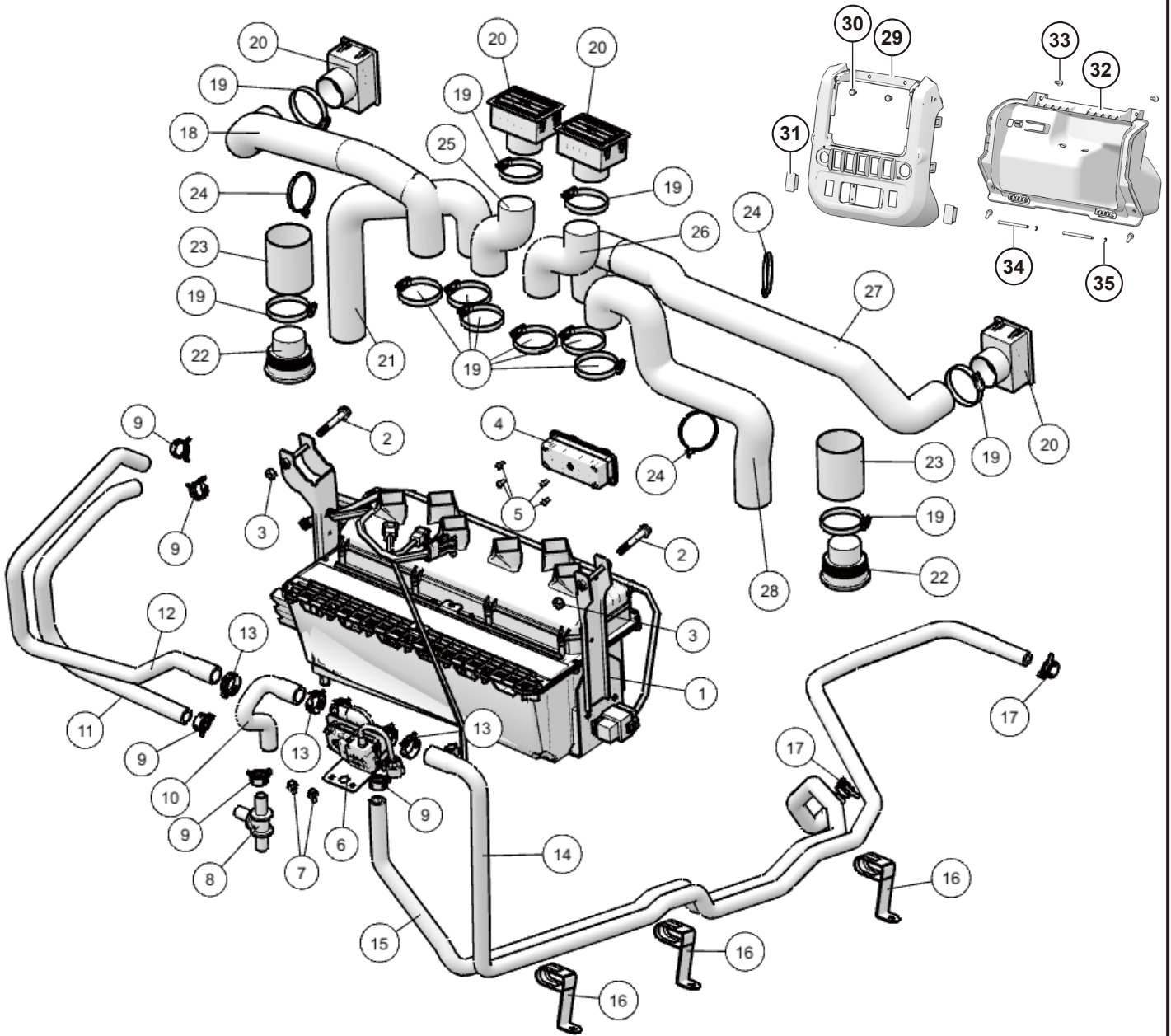
SEGWAY UT6

CABINE INSTALLATION GUIDE (with heater)



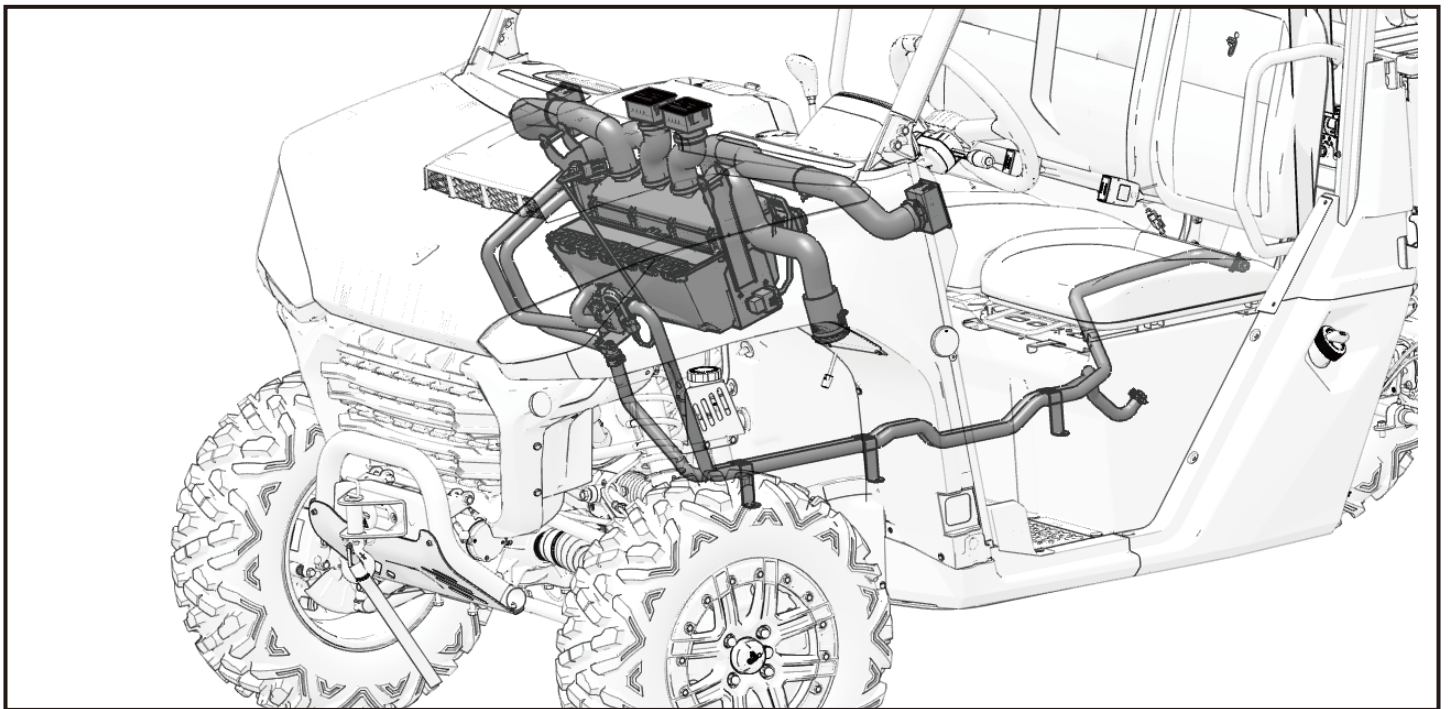
HEATING SYSTEM INSTALLATION GUIDE

Assembly drawing of heating system



| NO. | PART NAME | PART NUMBER | QUANTITY | REMARKS |
|-----|---|--------------------|----------|---------|
| 1 | Heater box assembly | U06-M701000-000-00 | 1 | |
| 2 | Hexagon flange bolt M8 × 55 trivalent chromium (grade 10.9) | BG057890-08055-CA1 | 2 | |
| 3 | Type 1 hexagon nut M8 | GBT006170004 | 2 | |
| 4 | Heater control switch panel assembly | U06-M702000-000-00 | 1 | |
| 5 | Black Self-Tapping Screw ST4.2×13 | GBT000845005 | 4 | |
| 6 | Electronic three-way valve | U06-M703000-000-00 | 1 | |
| 7 | Hexagon flange bolt M6 × 12 | GBT005789006 | 2 | |
| 8 | Tee (16 × 16 × 16) | S10-A456000-000-00 | 1 | |
| 9 | Steel Band Elastic Hose Clamp 22 | QCT006211009 | 5 | |

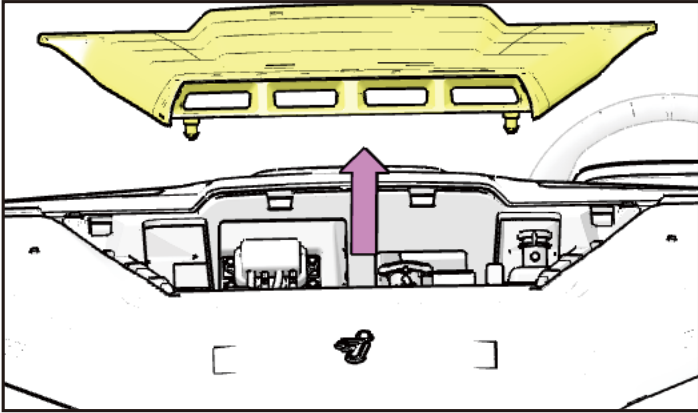
| | | | | |
|----|--|--------------------|----|-----------------------|
| 10 | Electronic three-way valve water hose 2 | U06-M715000-000-00 | 1 | |
| 11 | Warm core water outlet hose | U06-M717000-000-00 | 1 | |
| 12 | Electronic three-way valve water outlet hose 1 | U06-M714000-000-00 | 1 | |
| 13 | Steel band elastic hose clamp 28 | QCT006211007 | 3 | |
| 14 | Electronic three-way valve water inlet hose | U06-M713000-000-00 | 1 | |
| 15 | Electronic three-way valve water hose 3 | U06-M716000-000-00 | 1 | |
| 16 | hose clamp | U06-M718000-000-00 | 3 | |
| 17 | Steel Band Elastic Hose Clamp 20 | QCT006211015 | 2 | |
| 18 | Face blowing outlet duct assembly (right) | U06-M706000-000-00 | 1 | |
| 19 | Type A worm drive hose hoop 60 | QCT000620005 | 12 | |
| 20 | Air outlet | U06-M707000-000-00 | 4 | |
| 21 | Blowing foot outlet air duct assembly (right) | U06-M711000-000-00 | 1 | |
| 22 | Foot blowing tuyere | U06-M712000-000-00 | 2 | |
| 23 | Rubber sleeve | U06-M719000-000-00 | 2 | |
| 24 | Live buckle tie 5 × 250 | T05000001012 | 3 | |
| 25 | Defrosting air duct assembly (right) | U06-M709000-000-00 | 1 | |
| 26 | Defrosting air duct assembly (left) | U06-M708000-000-00 | 1 | |
| 27 | Face blowing outlet duct assembly (left) | U06-M705000-000-00 | 1 | |
| 28 | Blowing foot out air duct assembly (left) | U06-M710000-000-00 | 1 | |
| 29 | Switch panel | U06-H110503-000-01 | 1 | Passenger storage box |
| 30 | Replace | T04000003001 | 1 | |
| 31 | Blank cover plate | S01H11000001 | 1 | |
| 32 | Passenger storage box | — | 1 | |
| 33 | Hexagon flange bolt M6 × 16 | GBT005789007 | 4 | |
| 34 | Passenger storage box rotation shaft | U01H21303001 | 2 | |
| 35 | Open Retaining Ring 5 | GB0000896001 | 2 | |



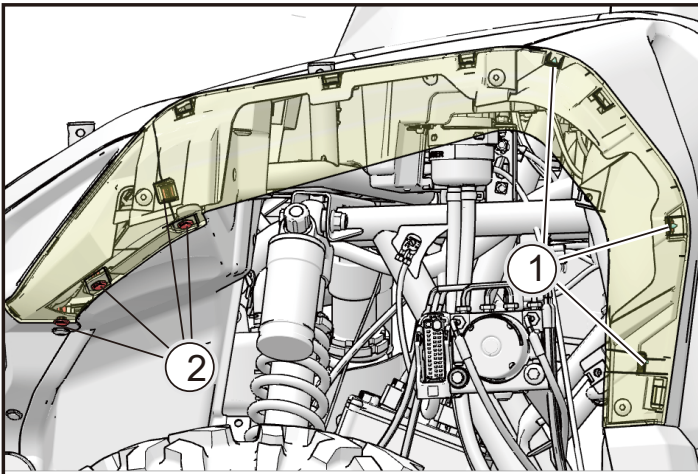
HEATING SYSTEM INSTALLATION GUIDE

REMOVAL OF VEHICLE PLASTIC PARTS

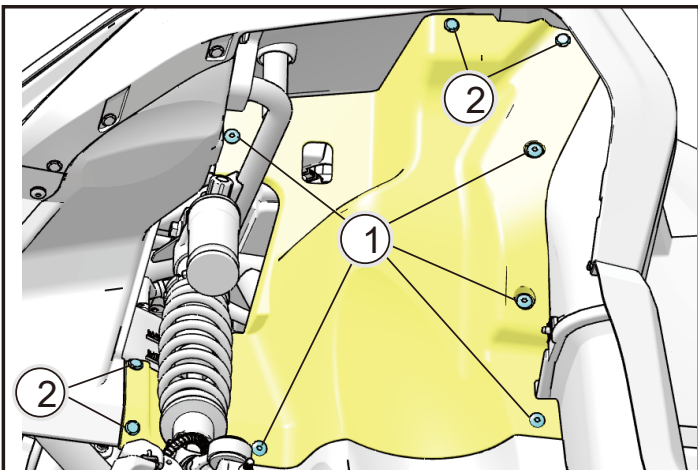
1. Remove the electrical maintenance cover, which is a quick disassembly art.



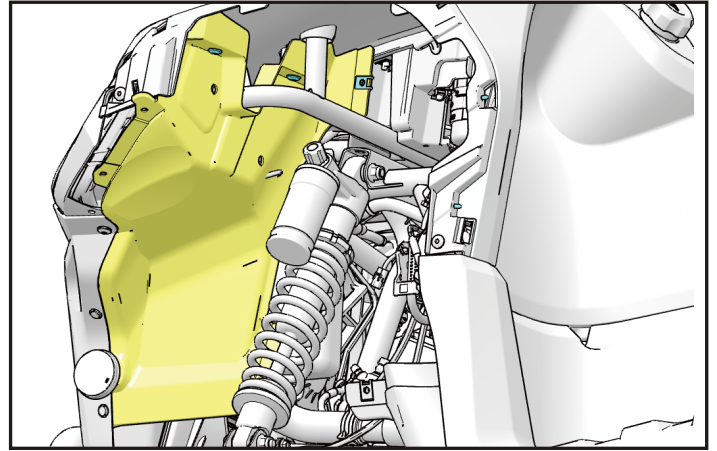
2. Take out 3 self-tapping nails ST4.2 × 13 (1). Take out 4 expansion buckle assemblies (2). You can take out the left front side strip, and the right front side strip is disassembled in the same way.



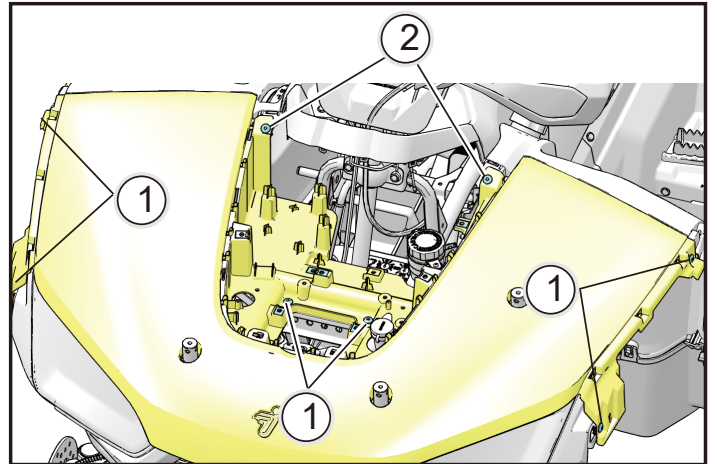
3. Remove the front upper fender and take out five large pan head hexagon socket bolts M6 × 16 (1). Take out the 4 expansion screws (2). You can take out the front upper fender, and the removal method of the right front upper fender is the same on the left and right.



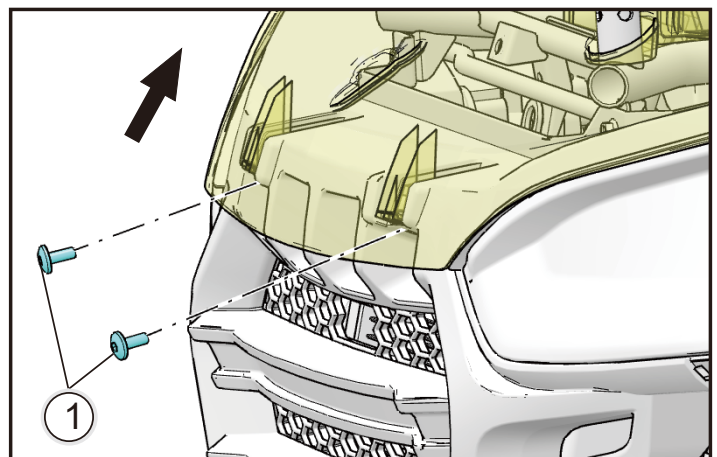
4. Removal of the left headlamp cover: remove the three large pan head hexagon socket bolts M6 × 16. remove the two expansion screws to take out the left headlamp cover. The removal method of the left and right headlamp covers is the same.



5. Remove the 4 large pan head hexagon socket bolts M6 × 16 1 above the front panel. Remove the 4 large pan head hexagon socket bolts M6 × 16 2 on the left and right sides of the front panel.

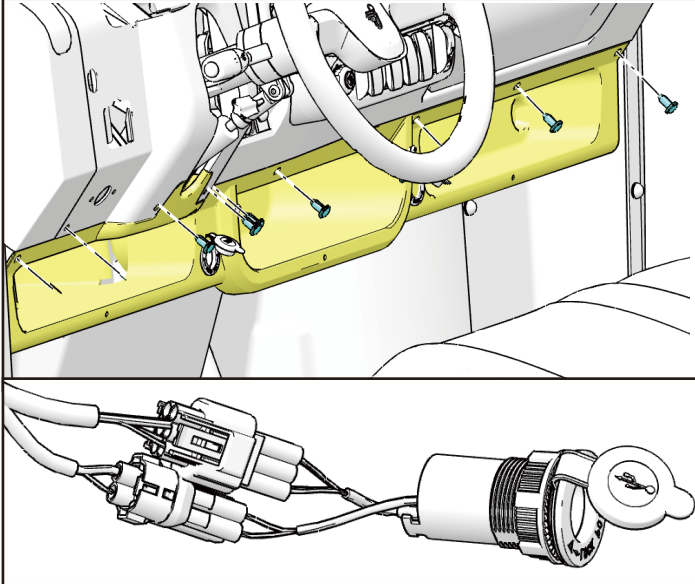


6. Remove the two large pan head hexagon socket bolts M6 × 16 on the front side of the front panel, and drag out the front panel along the arrow.

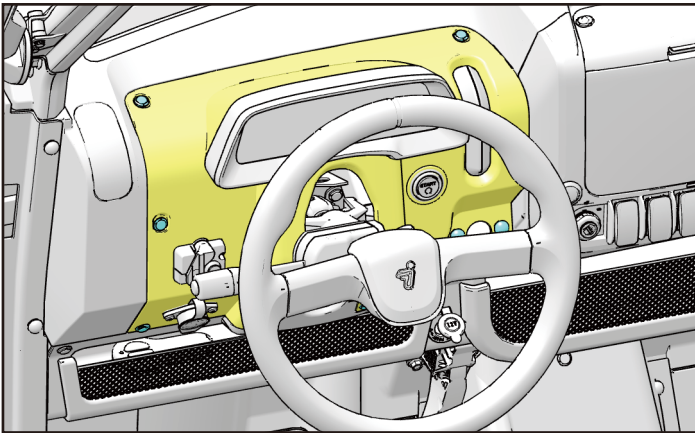


HEATING SYSTEM INSTALLATION GUIDE

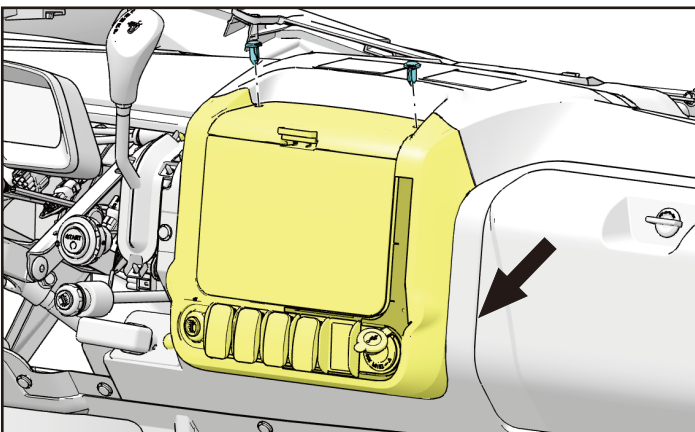
7. Buckle the lower part of the central control lower object grid, move it vigorously, pull out the buckle at the rear of the central control lower object grid from the fixing hole, and loosen the object grid. Pull out the plug behind the 12V power output base and remove the object compartment.



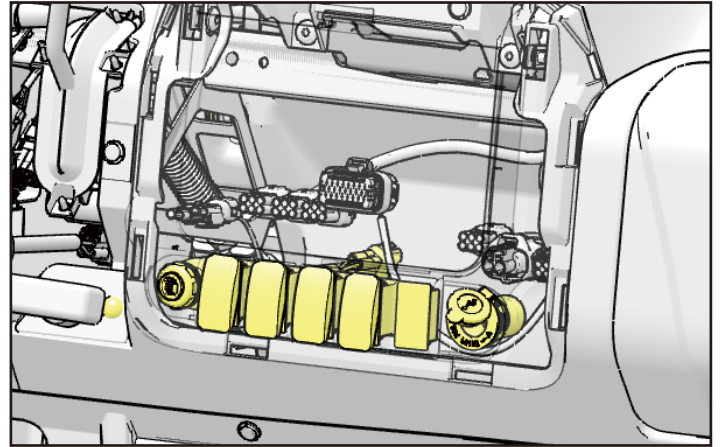
8. Remove the fasteners on the instrument cover in sequence, and remove the instrument cover outward.



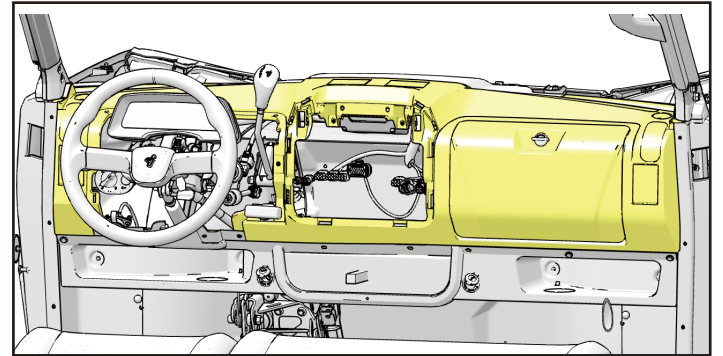
9. Remove the expansion nails above the switch panel and the storage box (or the central control panel). The rest of the switch panel is the insertion corner, and pull out all the insertion corners.



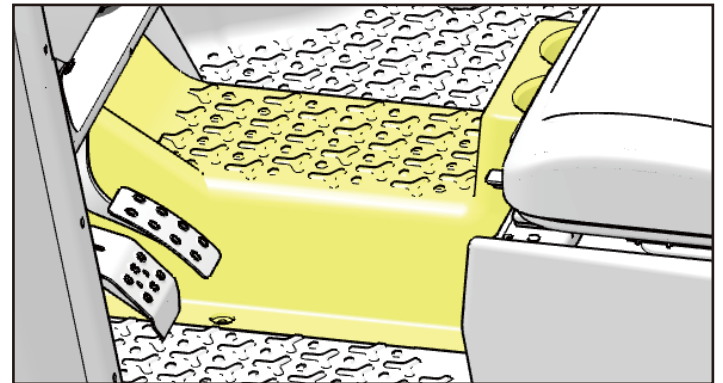
10. Pull out all kinds of wire harness connectors of all switches and sockets on the switch panel, and take down the switch panel.



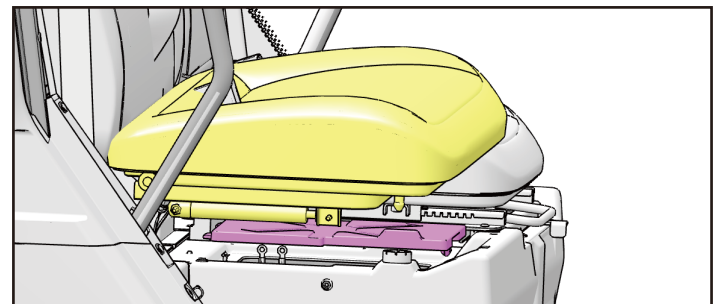
11. Remove the fasteners around the instrument panel body assembly and remove the instrument panel assembly.



12. Remove the fasteners on the middle guide cover and remove the middle guide cover.



13. Remove the passenger seat cushion and the lower middle cover plate of the seat (this is a quick-disconnect part).

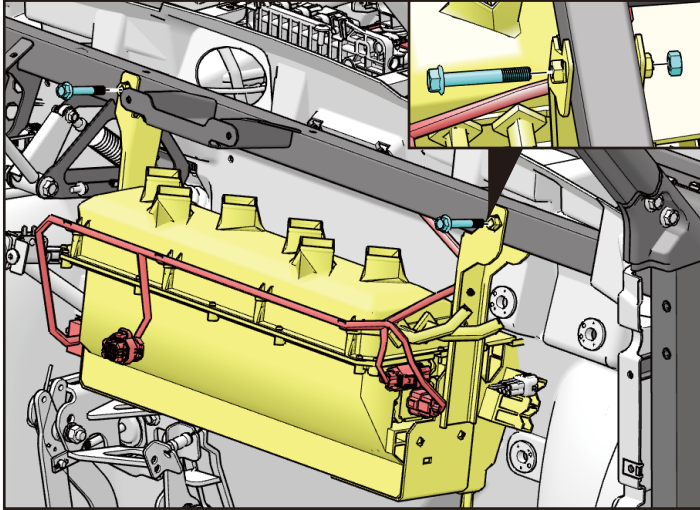


HEATING SYSTEM INSTALLATION GUIDE

HEATING SYSTEM INSTALLATION

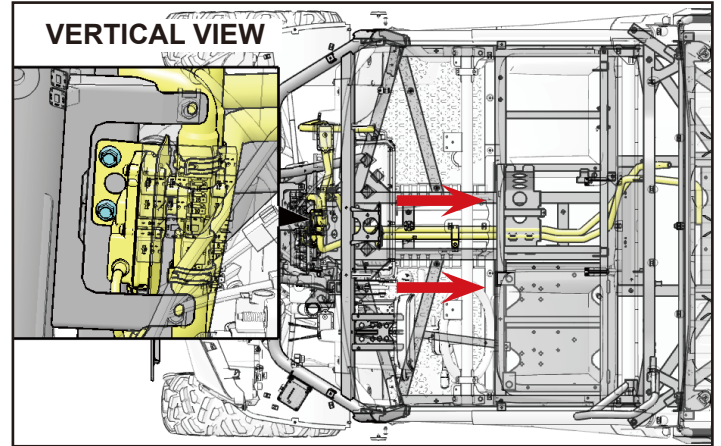
INSTALLATION OF HEATER BOX ASSEMBLY

1. Fix the heater box assembly on the frame horizontal tube on the instrument panel with 2 hexagon flange bolts M8X55 and 2 nuts M8.



2. Arrange the assembled electronic three-way valve and water inlet and outlet pipe assembly assembly from the front of the vehicle, and put each water pipe in the correct position.

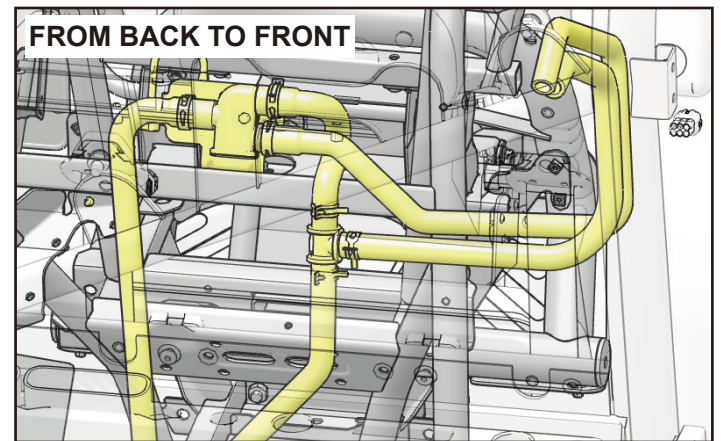
After all pipelines are put in place, fix the electronic three-way valve on the horizontal pipe at the front of the frame with 2 hexagon flange bolts M6 × 12.



INSTALLATION OF ELECTRONIC THREE-WAY VALVE

1. As shown in the following figure, connect the water inlet and outlet hoses of each three-way valve on the three-way valve body with corresponding clamps.

- ① Water inlet hose of electronic three-way valve
- ② 2 Steel belt type elastic hose clamp $\phi 28$ (3 pieces)
- ③ 3 Electronic three-way valve water hose 2
- ④ 4 Electronic three-way valve water outlet hose 1
- ⑤ 5 Tee
- ⑥ steel belt elastic hose clamp $\phi 22$ (3 pieces)
- ⑦ 7 Warm core water outlet hose
- ⑧ 8 Electronic three-way valve water hose 3

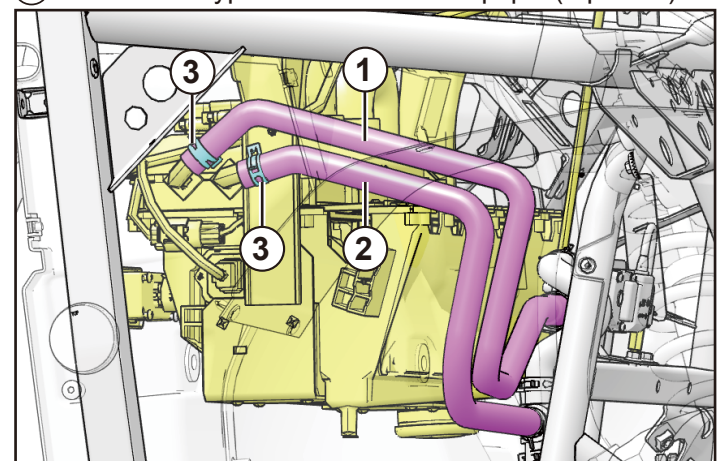
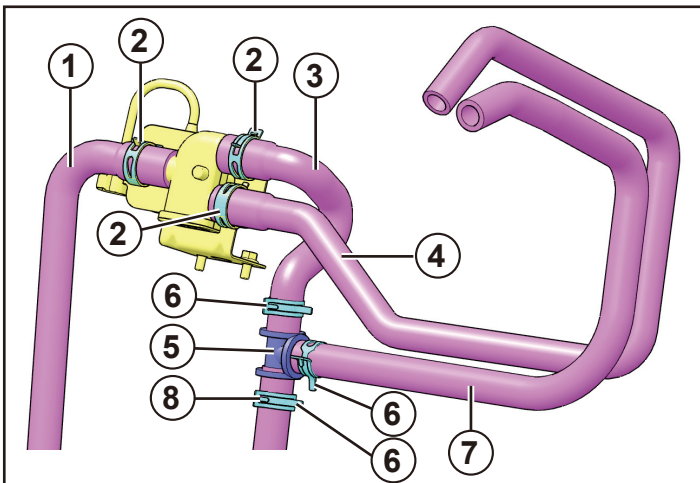


3. Connect the water outlet hose 1 of the electronic three-way valve to the heater box body assembly with the steel band elastic hose clamp $\phi 22$.

Connect the warm core water outlet hose to the warm air box body assembly with steel belt elastic hose clamp $\phi 22$.

- ① 1 Electronic three-way valve water outlet hose 1
- ② 2 Warm core water outlet hose
- ③ 3 Steel belt type elastic hose clamp $\phi 22$ (2 pieces)

TIPS
Pay attention to the layout and location of the pipeline during installation.

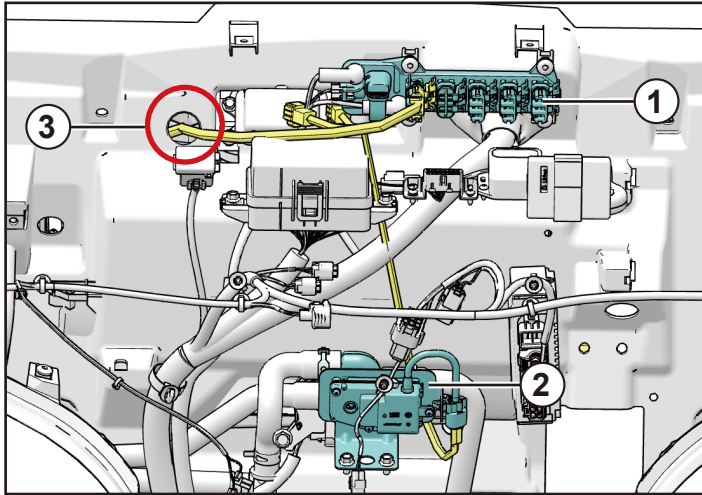


HEATING SYSTEM INSTALLATION GUIDE

WIRE-SPEED ASSEMBLY CONNECTION

1. Pass the branch harness on the heater harness assembly through the hole above the front middle baffle.

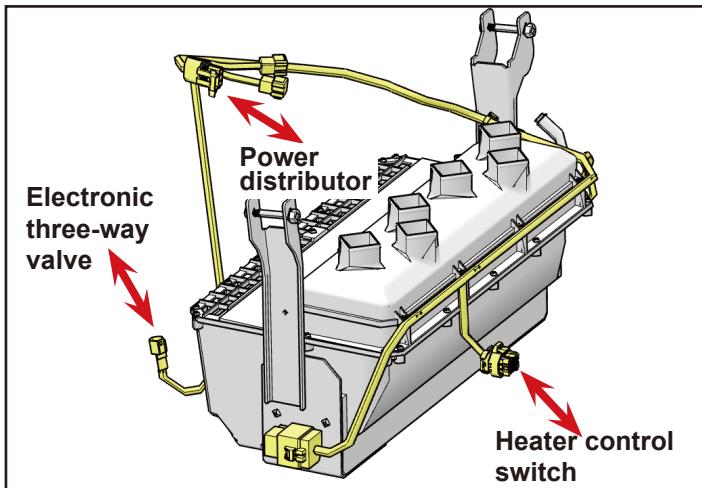
- ① Power distributor
- ② Electronic three-way valve
- ③ Harness hole



2. Connect each plug on the heater harness assembly to the corresponding connector.

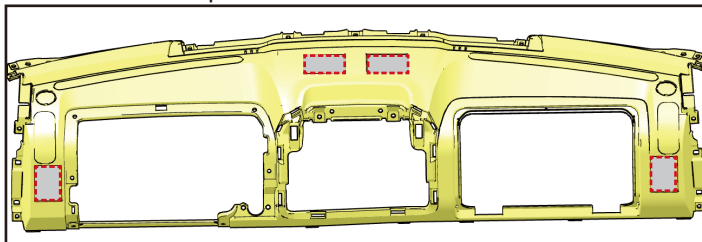
TIPS

Pay attention to the layout and position of the wire harness during installation.

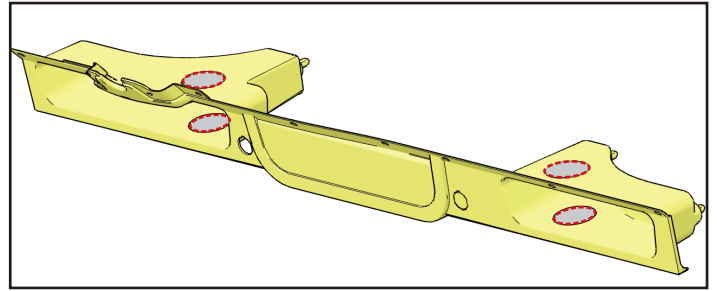


CUTTING AND SUB-ASSEMBLY OF INSTRUMENT COVER AND CENTRAL CONTROL LOWER GRID

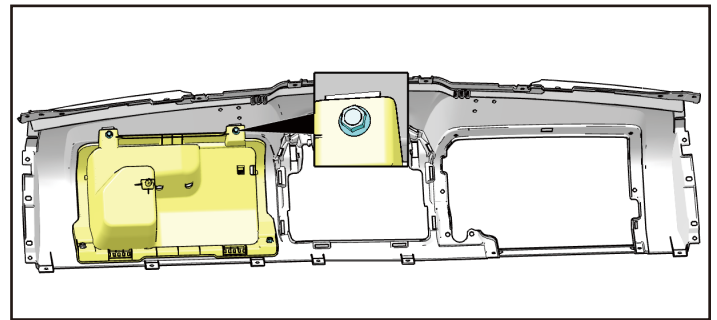
1. As shown in the figure below, use a cutting tool to open 4 warm air outlets (at the red dotted line) from the upper body of the instrument panel.



2. As shown in the following figure, use a cutting tool to open 4 air blowing feet out of the air duct outlet (at the red dotted line)



3.3. Install the passenger storage box (newly equipped) on the upper body of the instrument panel with 4 hexagon flange bolts M6 × 16.

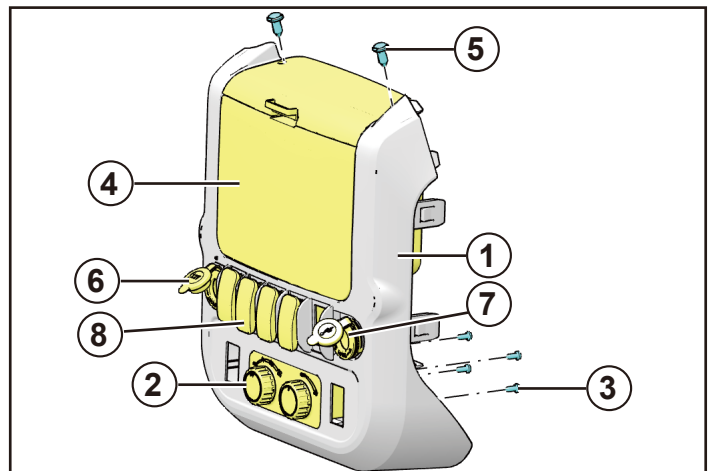


4. Fix the heater control switch panel assembly on the switch panel with 4 black self-tapping screws ST4.2 × 13.

Install the middle storage box removed from the old switch panel on the switch panel, and fix the upper end with a 2-piece expansion buckle assembly.

Install the DC socket, USB power output socket, and switch on the new switch panel.

- ① Switch panel (with heater only)
- ② Heater control switch panel assembly
- ③ black self-tapping nails ST4.2 × 13
- ④ Middle storage box
- ⑤ Expansion buckle assembly
- ⑥ DC socket
- ⑦ USB power output socket
- ⑧ Switch (installed in the position before removal)

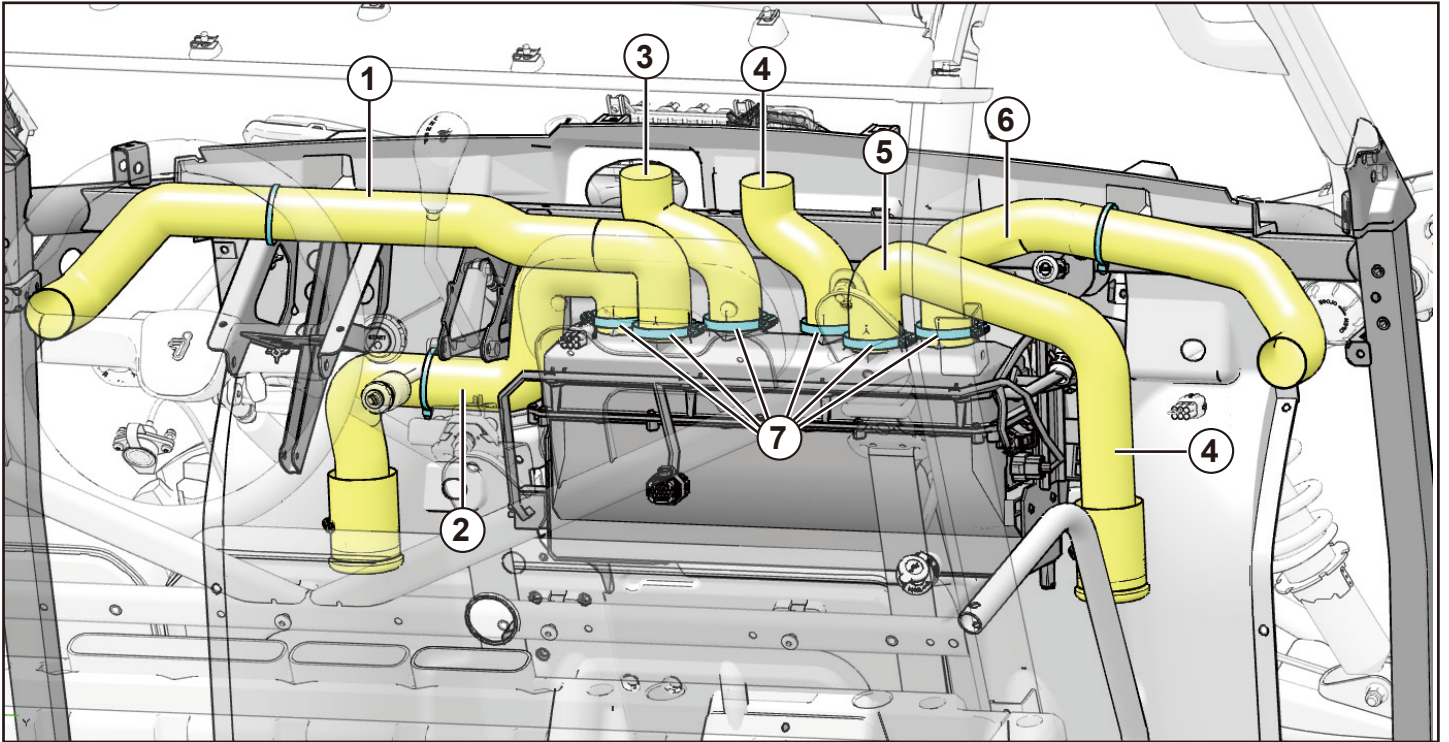


HEATING SYSTEM INSTALLATION GUIDE

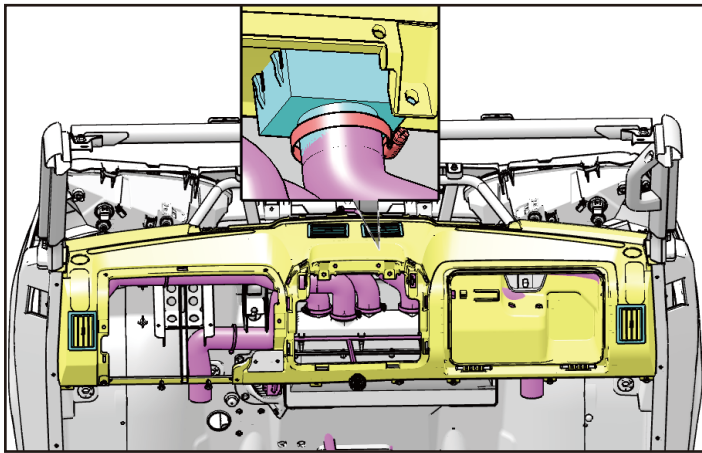
INSTALLATION OF AIR DUCT

1. Connect and arrange the 6 air ducts at the positions and directions shown in the figure below with the hoop and the heater box assembly.

- ① Face blowing air outlet duct assembly (left)
- ② Foot blowing air outlet duct assembly (left)
- ③ Defrosting air outlet duct assembly (left)
- ④ Defrosting air outlet duct assembly (right)
- ⑤ Foot blowing air outlet duct assembly (right)
- ⑥ Face blowing air outlet duct assembly (right)
- ⑦ Type A worm drive type hose hoop 60

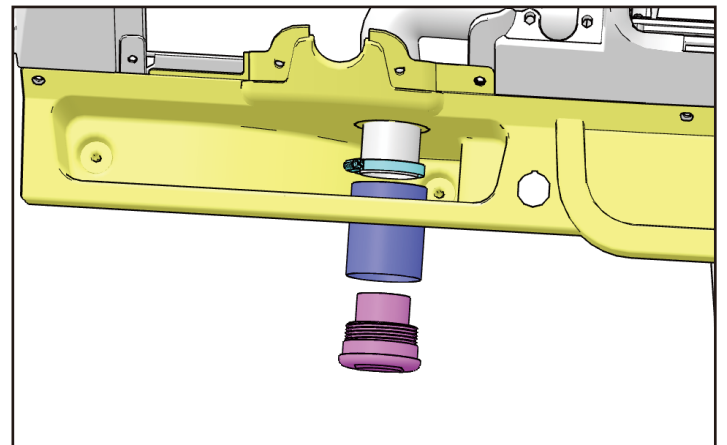


2. Reposition the instrument cover to the installation position, and connect the outlet of the 2 face-blowing air ducts and Align the outlets of 2 defrosting air ducts with the corresponding positions on the instrument cover, install 4 air outlets on the cut 4 holes, and fix them with A-type worm drive hose hoop 60.



3. Relocate the lower object grid of the central control to the installation position, align the cut holes of the outlet of the 2 blowing feet with the lower object grid of the central control, and cover the outlet pipe with a rubber sleeve.

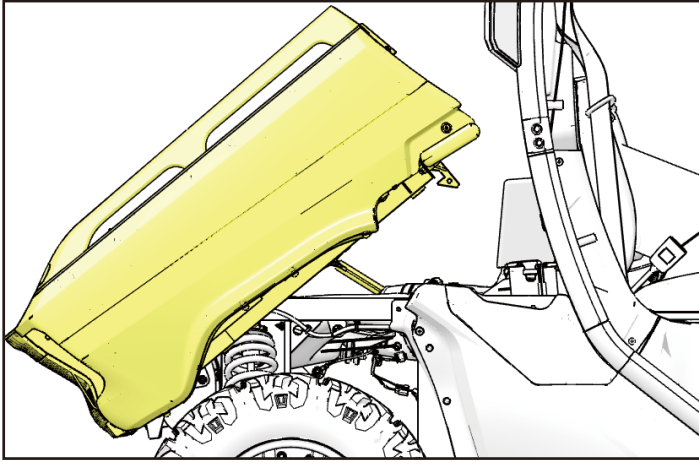
Screw the foot blowing air vent into the outlet of the foot blowing air duct and fix it with the-type worm drive type hose hoop 60.



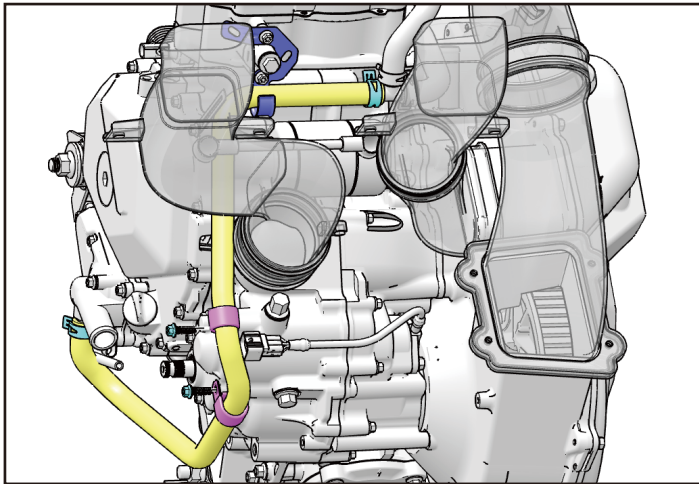
HEATING SYSTEM INSTALLATION GUIDE

INSTALLATION OF WATER INLET AND OUTLET PIPES AND ENGINE ENDS

1. Turn the rear cargo box over and open it.



2. Remove the fasteners on the water pipe clamp, loosen the steel band elastic hose clamps at both ends of the small circulating water pipe, and take the small circulating water pipe from the engine.

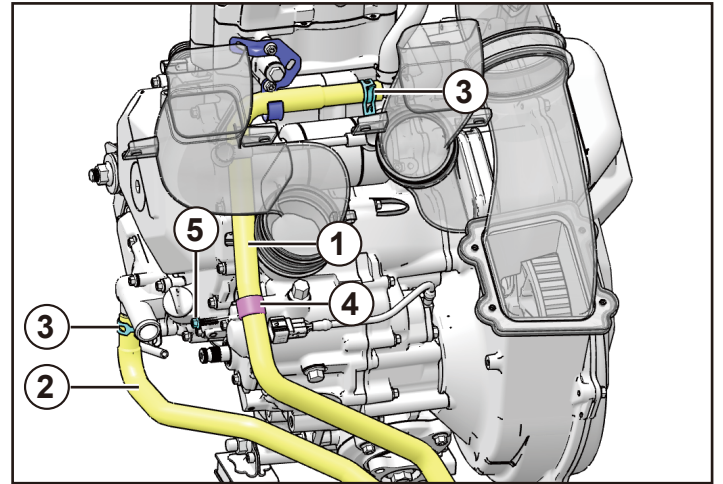


TIPS

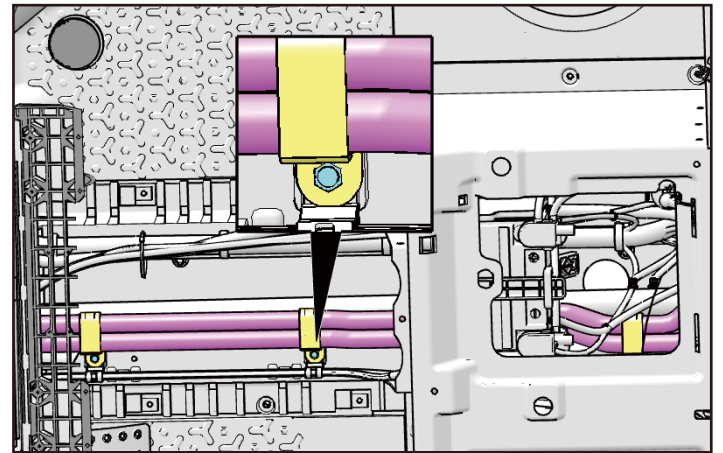
After the small circulating water pipe is removed, there may be coolant overflow.

3. Connect the electronic three-way valve water inlet hose and the electronic three-way valve water outlet hose 3 to the engine with a clamp as shown in the figure below.

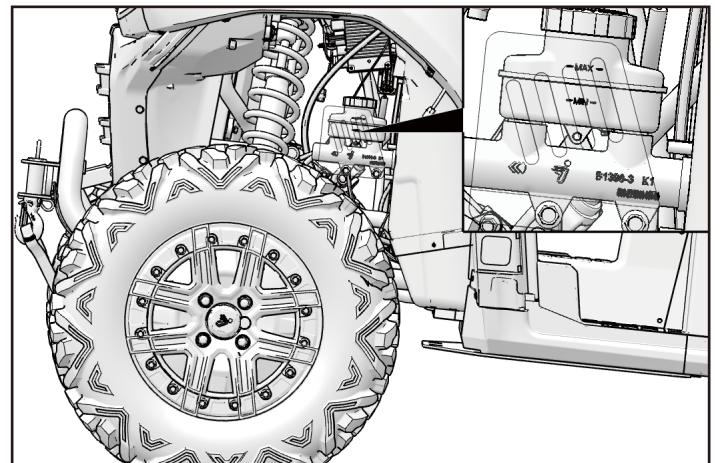
- ① Electronic three-way valve water inlet hose
- ② Electronic three-way valve water outlet hose 3
- ③ Steel belt elastic hose clamp $\phi 20$
- ④ Water pipe clamp
- ⑤ Bolt M6 \times 20



4. Fix the inlet and outlet pipes with 3 hose clamps, and the first 2 hose clamps are shared with the brake fixing point.



5. Check the brake fluid level through the brake fluid cup on the left. If the level is at the MIN-position, add brake fluid until it reaches the position between MAX and MIN.



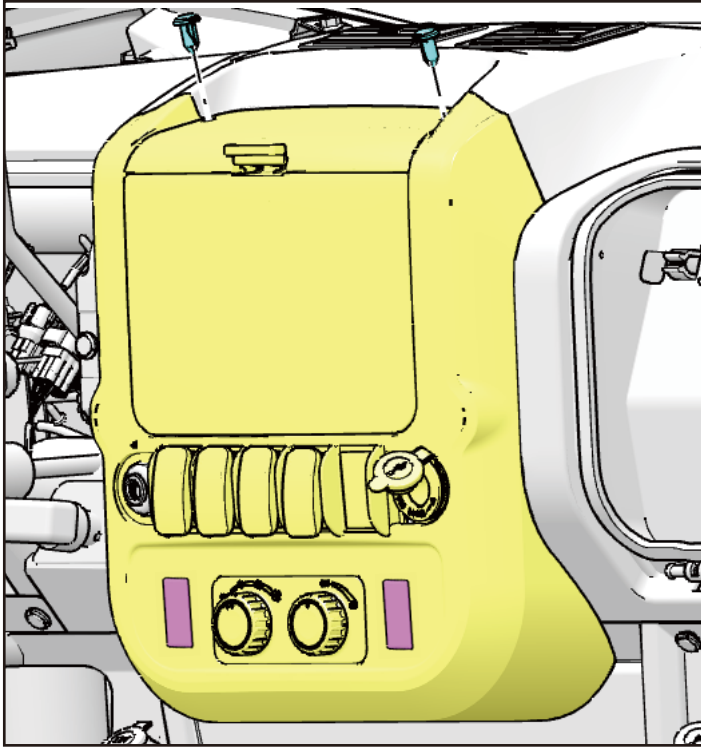
HEATING SYSTEM INSTALLATION GUIDE

EXTERIOR TRIM INSTALLATION

1. Reconnect all the switch plugs on the switch panel.

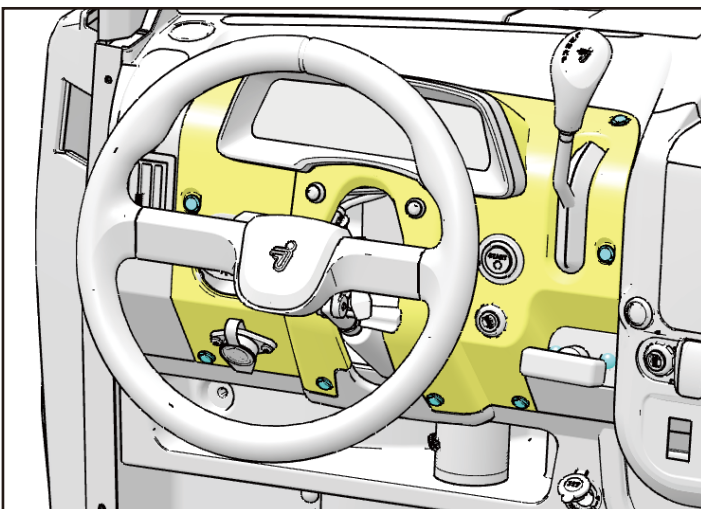
Insert all the plug corners on the switch panel into the corresponding jacks on the instrument panel, and fix the switch panel with two expansion components.

Install the 2 blank covers on the switch panel.



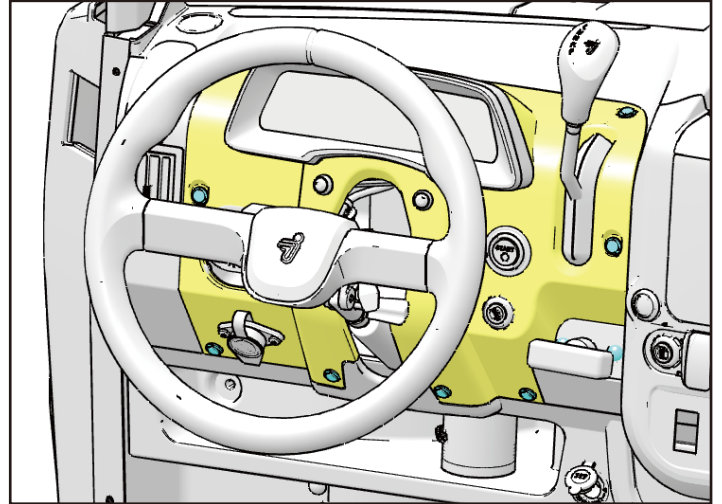
2. Install the instrument, ignition lock switch, one-key start switch, etc. on the instrument cover, and reconnect all switch plugs.

Fix the instrument cover to the upper body of the instrument panel with the expansion assembly.

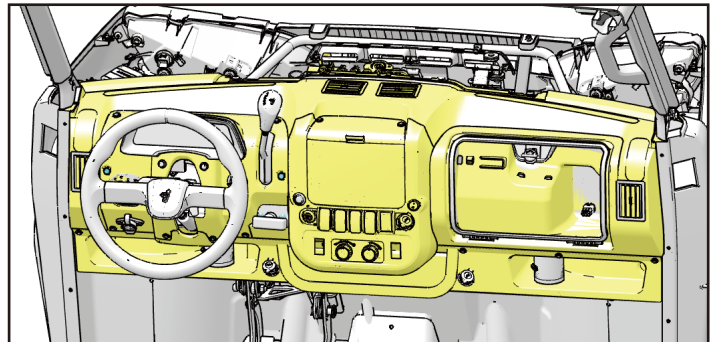


3. Install the instrument, ignition lock switch, one-key start switch, etc. on the instrument cover, and reconnect all switch plugs.

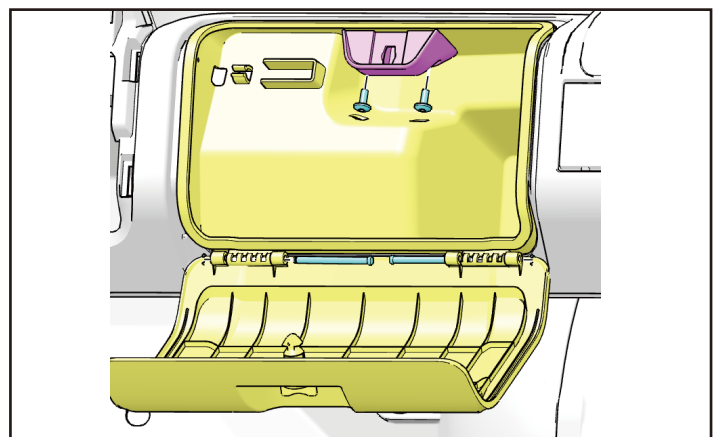
Fix the instrument cover to the upper body of the instrument panel with the expansion assembly.



4. Fix the instrument panel upper body and the central control lower grid on the vehicle with fasteners.



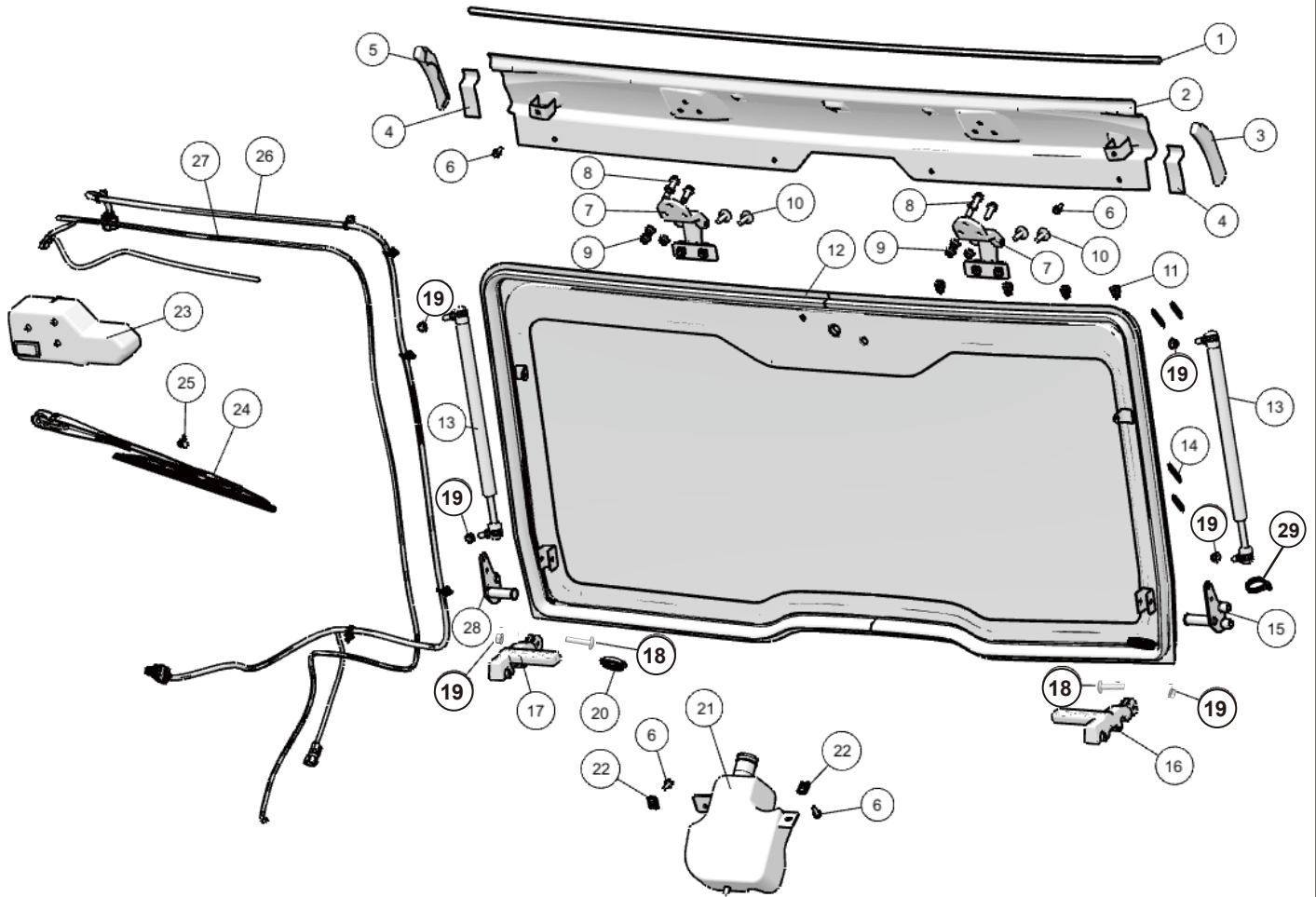
5. Fix the lock catch of the passenger storage box to the body of the passenger storage box with two bolts. Fix the passenger storage box cover on the passenger storage box body with the passenger storage box rotating shaft and the opening retaining ring.



6. Restore all remaining exterior trim parts and other parts to be installed in the reverse order of removal.

FRONT WINDSHIELD ASSEMBLY (WITH WIPER)

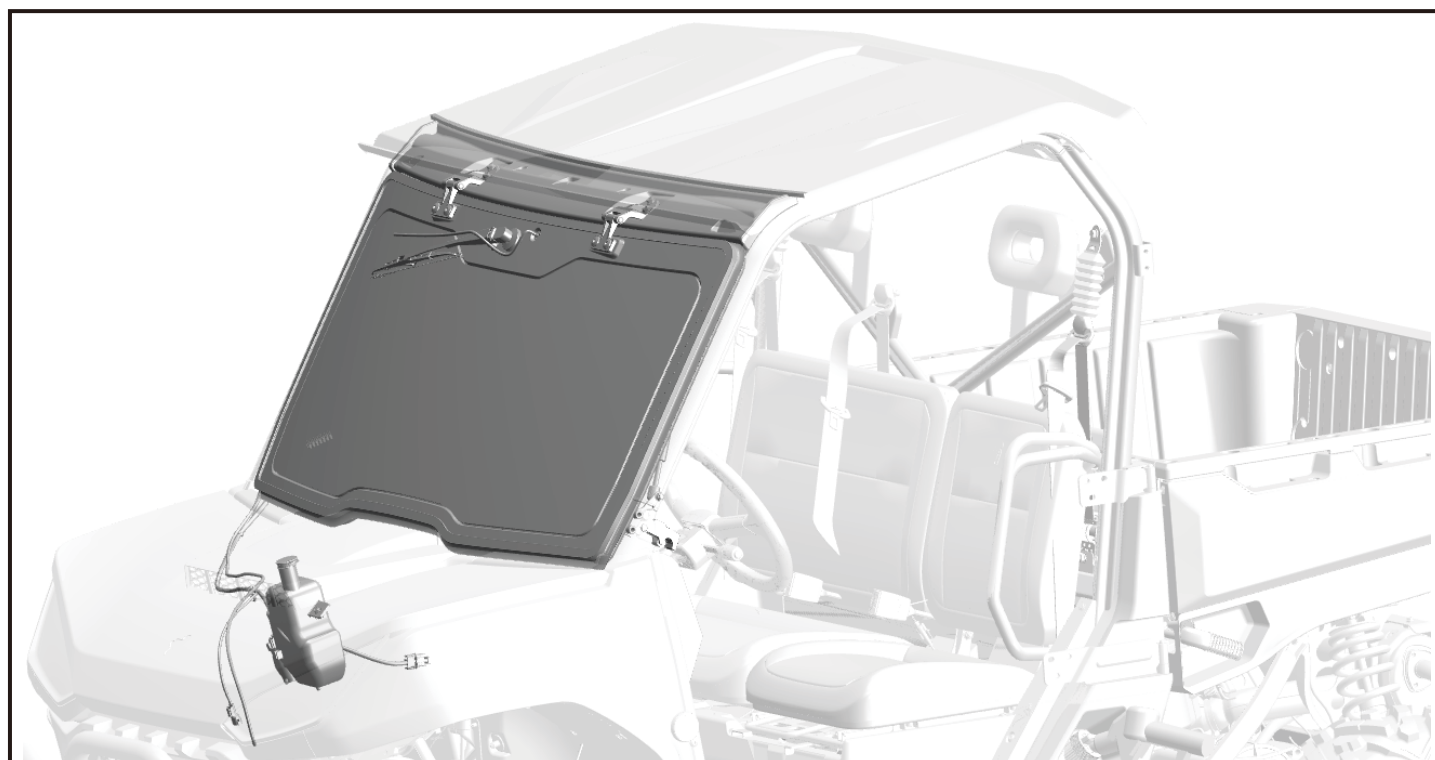
Assembly drawing of front windshield (with wiper)



| NO. | PART NAME | PART NUMBER | QUANTITY | REMARKS |
|-----|---|--------------------|----------|---------|
| 1 | Front Windshield Mount Sealing Strip | U06-R060104-0B0-00 | 1 | |
| 2 | Front Windshield Mount | U06-R060101-0MP-00 | 1 | |
| 3 | Rubber Pad of Front Glass Mount-Right | U06-R060103-0B0-00 | 1 | |
| 4 | Waterproof rubber pad | U03-R061105-0B0-00 | 2 | |
| 5 | Front Glass Mount Rubber Pad-Left | U06-R060102-0B0-00 | 1 | |
| 6 | Hexagon flange bolt M6 × 16 | GBT005789007 | 4 | |
| 7 | front windshield hinge | U06-R063030-000-00 | 2 | |
| 8 | Hexagon flange bolt M8 × 25 | GBT005789016 | 6 | |
| 9 | Non-metallic insert hexagon flange lock nut M8 | GBT061831003 | 6 | |
| 10 | Hexagon socket bolt with large pan head M8 × 25 | T03000008003 | 4 | |
| 11 | Sheet Metal Tie | T05100010003 | 4 | |
| 12 | Full windshield assembly | U06-R063020-000-00 | 1 | |
| 13 | Air Rod Assembly | U06-R063090-000-00 | 2 | |

FRONT WINDSHIELD ASSEMBLY (WITH WIPER)

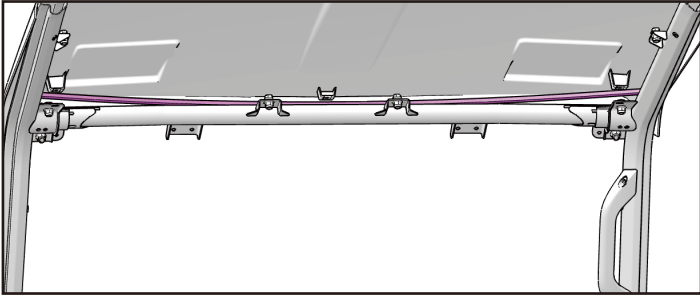
| | | | | |
|----|---|--------------------|---|--|
| 14 | Plastic-coated clamp (10x 95) | F01H00011001 | 2 | |
| 15 | Right Air Spring Mount | U06-R063080-000-00 | 1 | |
| 16 | Right Lock Hook Assembly | U06-R063060-000-00 | 1 | |
| 17 | Left Latch Hook Assembly | U06-R063050-000-00 | 1 | |
| 18 | Hexagon socket bolt with large pan head M6 × 30 | T03000007005 | 2 | |
| 19 | Hexagon flange nut M6 | GBT061771002 | 6 | |
| 20 | Instrument panel harness via rubber sleeve | U08-M064601-000-00 | 1 | |
| 21 | Wiper kettle | U06-M064200-000-00 | 1 | |
| 22 | M6 nut clamp | T04000002001 | 2 | |
| 23 | Wiper motor | U01M06410001 | 1 | |
| 24 | Wiper Blade | U08-M064300-000-00 | 1 | |
| 25 | Nozzle | U01M06450001 | 1 | |
| 26 | Wiper wire harness | U01M06460001 | 1 | |
| 27 | Wiper pipe | U01M06440001 | 1 | |
| 28 | Left Gas Spring Mount | U06-R063070-000-00 | 1 | |
| 29 | Loose tie 5 × 300 | T05000001006 | 1 | |



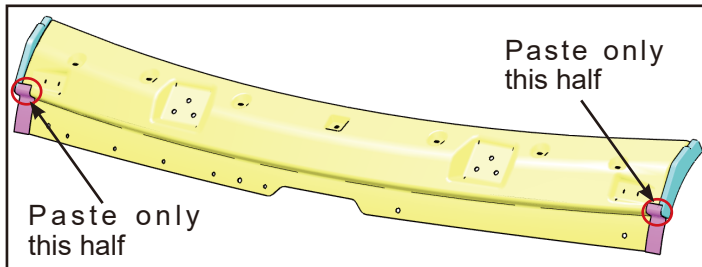
FRONT WINDSHIELD ASSEMBLY (WITH WIPER)

FRONT WINDSHIELD MOUNT INSTALLATION

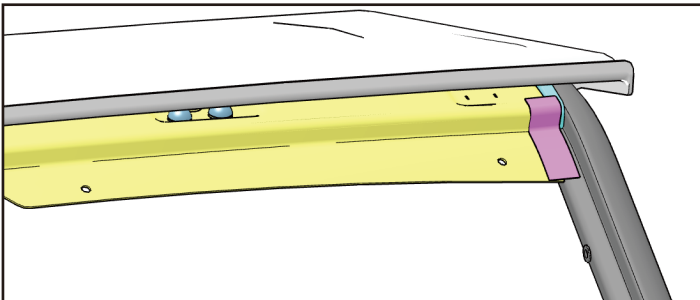
1. Paste the sealing strip of the front windshield mounting seat in the ceiling.



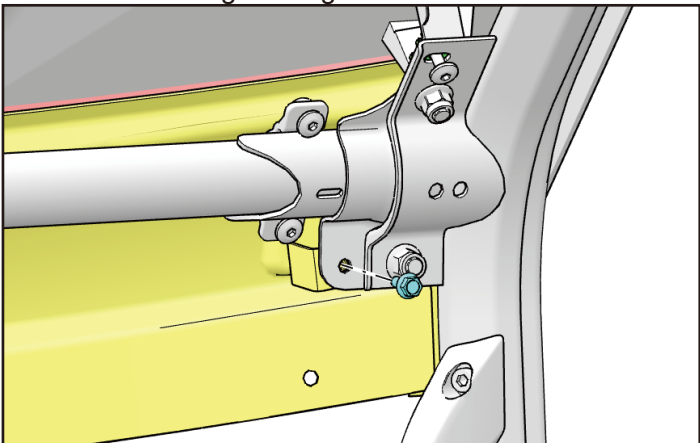
2. Tear off half of the protective film of the waterproof rubber pad and paste it at the bend of the front windshield mounting seat. Then install the rubber pad of the front left (right) windshield mount on both sides of the front windshield mount.



3. Place the front windshield mounting seat at the corresponding position of the ceiling, tear off the protective film of the other half of the waterproof rubber pad and paste it on the front windshield mounting seat.



4. Fix the left and right sides of the front windshield mounting seat on the front transverse tube of the top beam with 2 hexagon flange bolts M6 x 16.

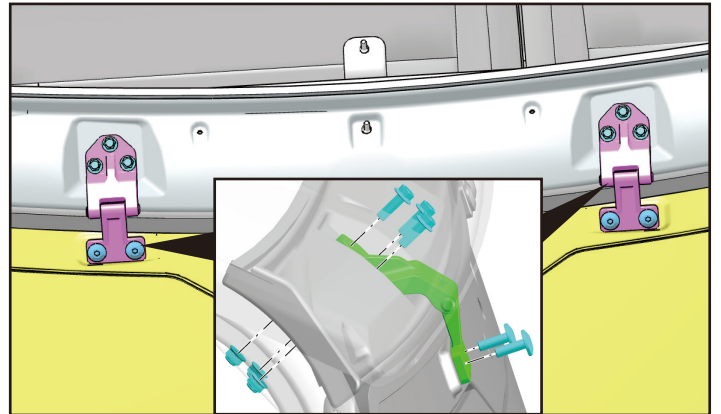


FRONT WINDSHIELD INSTALLATION

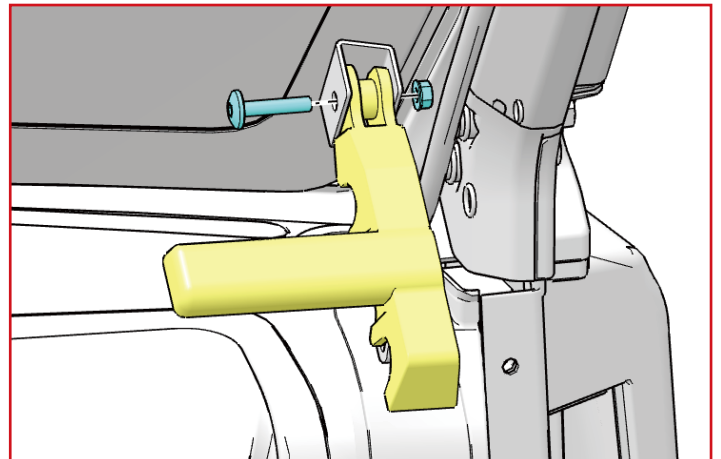
1. Place the windshield in a suitable position, use 2 pieces of front windshield hinges, 4 pieces of large pan head hexagon socket bolts M8 x 25, 6 pieces of hexagon flange bolts M8 x 25, and 6 pieces of M8 bolts. Install and fix the top of the windshield with the glass mounting seat. Torque value: 30 ~ 40N · m

TIPS

The bolts are pre-tightened first, and the bolts can only be tightened after the windshield position is fully adjusted.

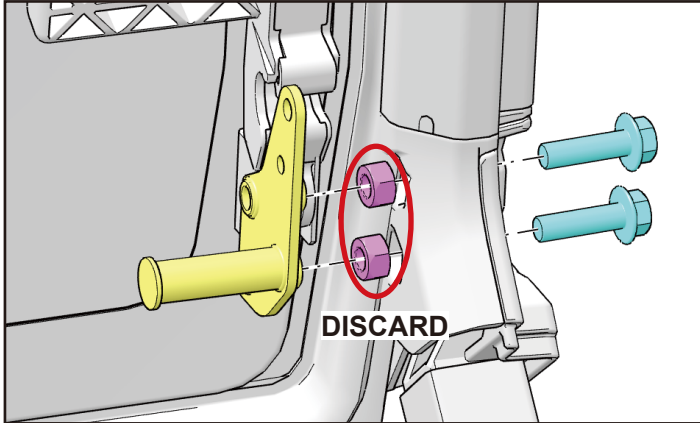


2. Install the left (right) lock hook assembly on the mounting bracket under the windshield with two large pan head hexagon socket bolts M6 x 30 and two hexagon flange nuts M6 respectively.

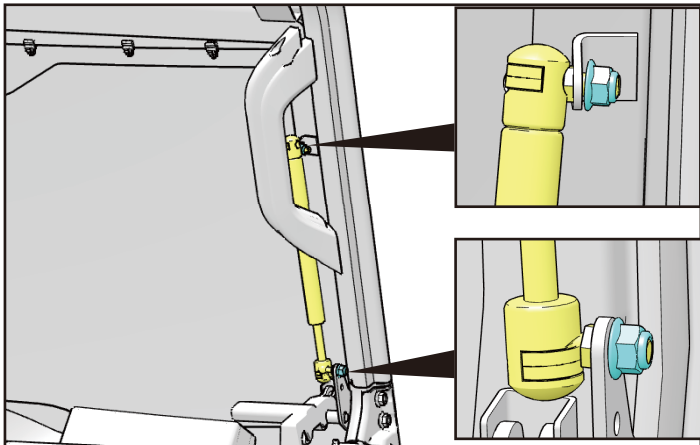


FRONT WINDSHIELD ASSEMBLY (WITH WIPER)

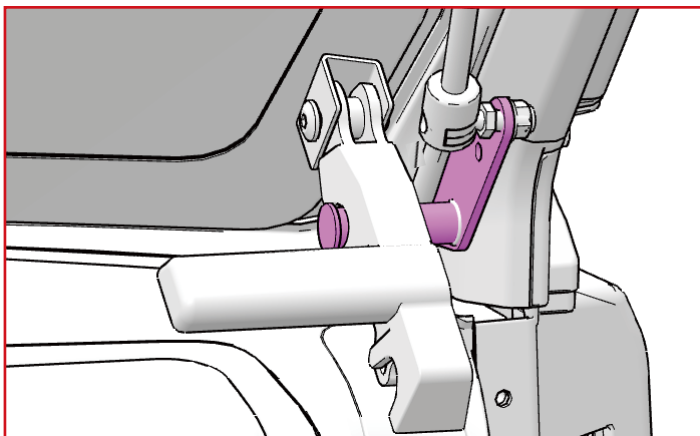
3. Remove the fixing fastener between the left (right) A-pillar welding assembly and the frame, discard the nut, place the left (right) mounting seat cylinder of the gas spring on the hole corresponding to the top beam, and re-tighten the removed A-pillar fastening bolt.



4. Fix the upper and lower ends of the air rod assembly on the corresponding holes with nuts.



5. Clip the slot on the lock hook assembly to the rotating shaft of the gas spring mounting base.

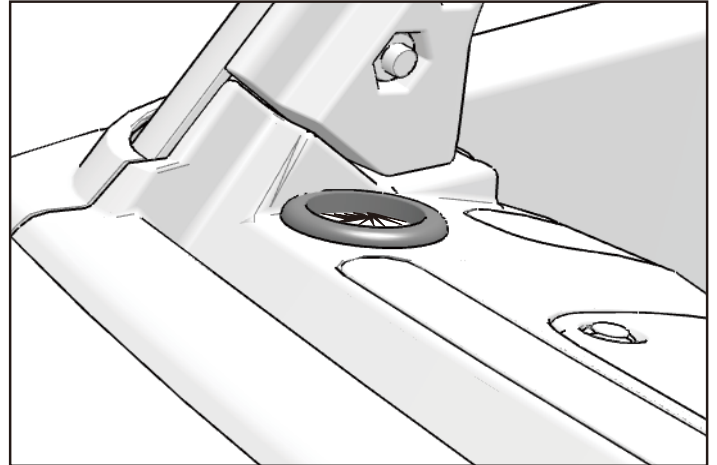


TIPS

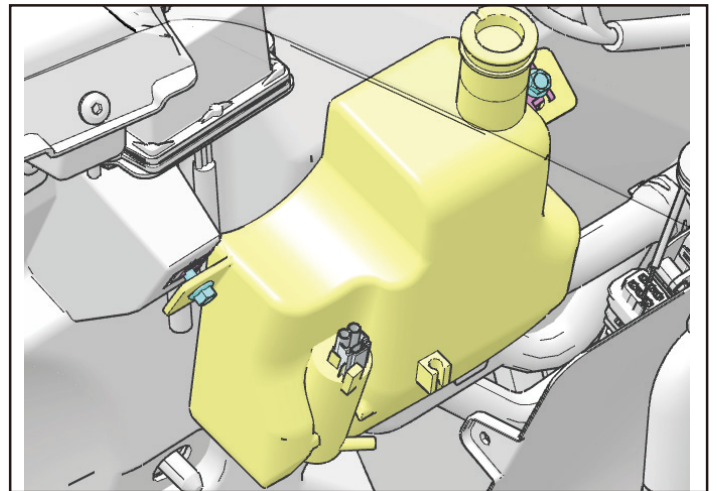
There are two rotation shafts on the lock hook assembly. The front locking position is the windshield half open state, and the rear locking position is the windshield full open state.

INSTALLATION OF WIPER SYSTEM ASSEMBLY

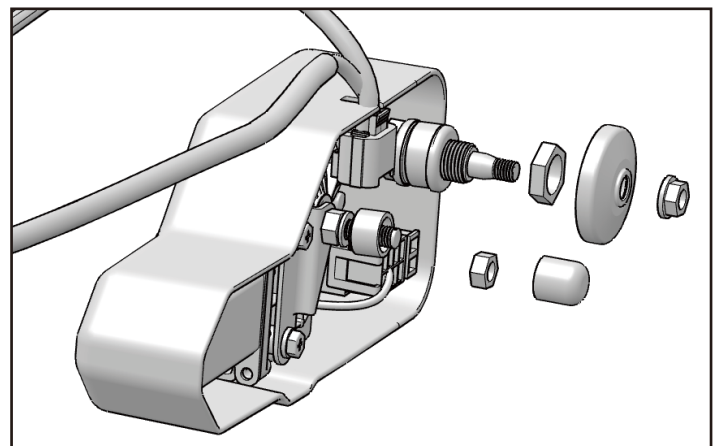
1. Cut a hole (with a cutting mark) on the right side of the instrument panel upper body with a tool, and clip the through-hole rubber sleeve of the instrument panel harness into the hole.



2. Remove the front access cover, and install the wiper kettle on the corresponding installation position under the front access cover with 2 bolts and 2 nut clamps.

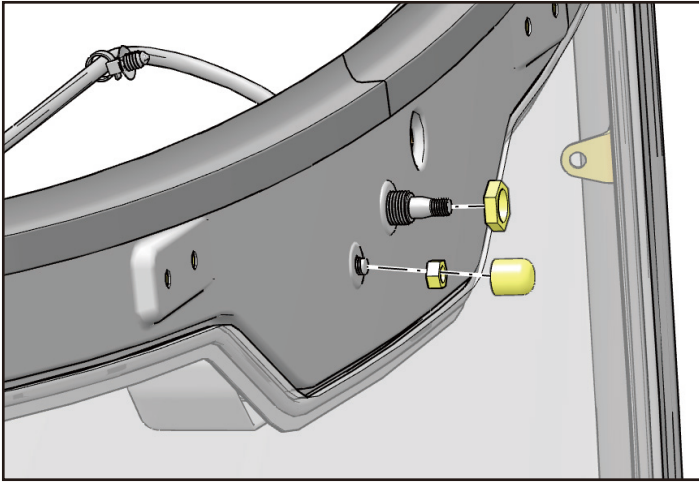


3. Take down the waterproof rubber sleeve, nut and decorative fixing cover on the wiper motor as shown below.

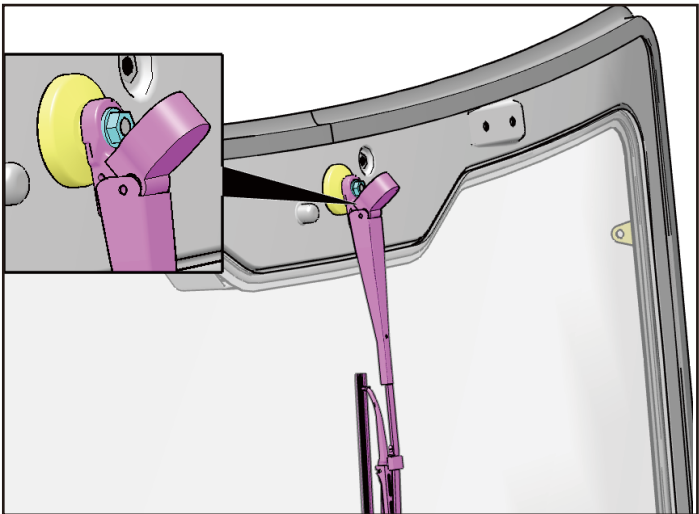


FRONT WINDSHIELD ASSEMBLY (WITH WIPER)

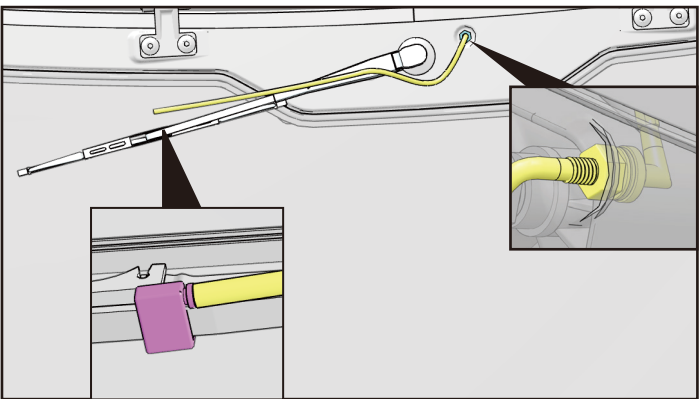
4. Place the wiper motor on the mounting hole on the upper part of the windshield, fix it with a nut, and install the waterproof rubber sleeve in place.



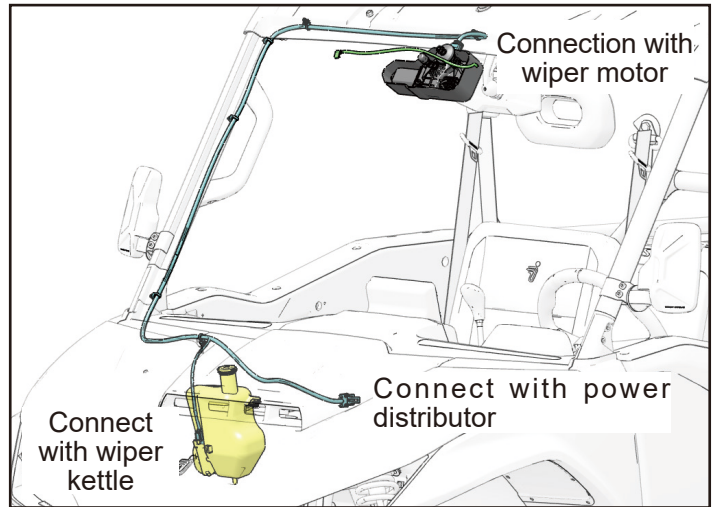
5. Open the dust cover on the wiper blade and fix the wiper blade with its own nut.



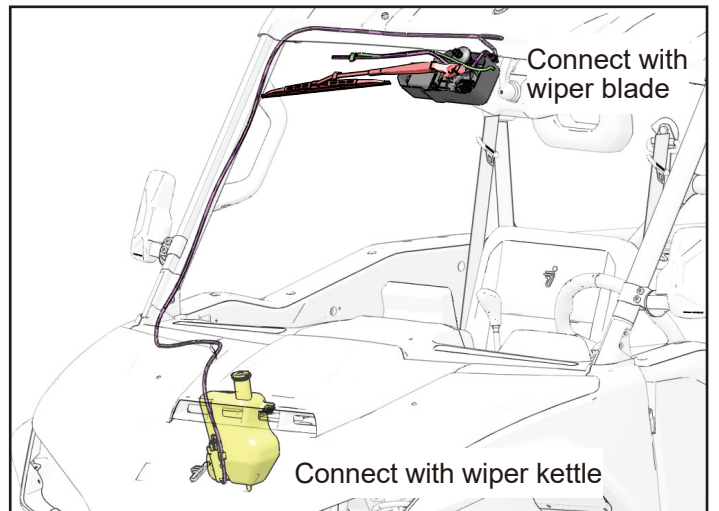
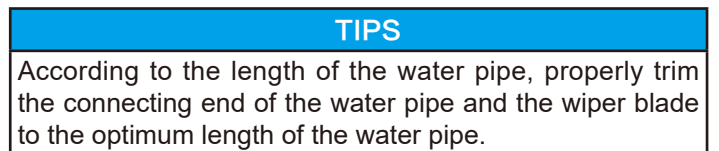
6. Loosen the nut in the middle of the wiper water pipe, split the wiper water pipe into 2 breaks, and screw the 2 break water pipe through the windshield to fix it with the nut, and connect the outer wiper water pipe tail to the wiper blade nozzle.



7. Arrange the wiper harness as shown in the figure below.



8. Arrange the wiper pipe as shown below.



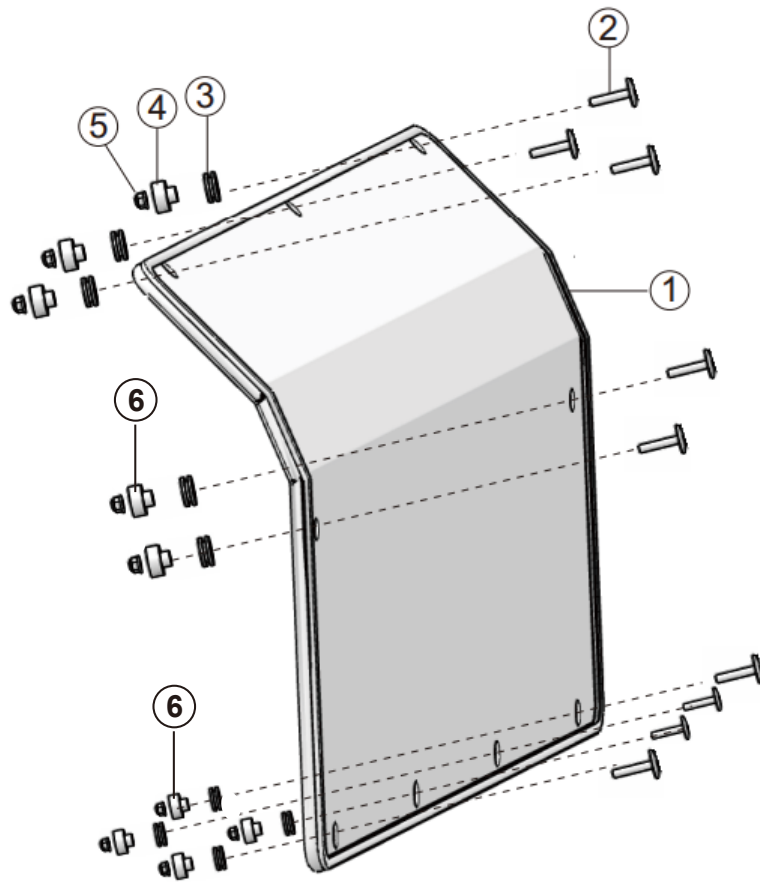
9. Fix the mushroom head tie of the wiper cable, and fix the water pipe and wire harness above the glass on the windshield mounting seat with the sheet metal tie.

10. Fix the wiper water pipe with the coated wire harness clip.

11. Add windshield washer fluid to the wiper kettle. After the vehicle is powered on, perform an operation test of the wiper system. After passing the test, reinstall the front access cover.

PC REAR WINDSHIELD COMBINATION INSTALLATION GUIDE

PC rear windshield assembly drawing



| NO. | PART NAME | PART NUMBER | QUANTITY | REMARKS |
|-----|---|--------------------|----------|-----------|
| 1 | PC rear windshield | U06-R062000-000-00 | 1 | Assembled |
| | Rear windshield sealing ring | U06-R062100-000-00 | | |
| 2 | Windscreen large flat head screw M8 × 40 | T03000009001 | 9 | |
| 3 | Windshield I-shaped rubber pad | T00000004001 | 9 | |
| 4 | Rear windshield cushion cover (long) | U01R62002001 | 3 | |
| 5 | Type 2 non-metallic insert hexagon flange lock nut M8 | GBT061831003 | 3 | |
| 6 | Rear windshield cushion cover (short) | U01R62003001 | 6 | |

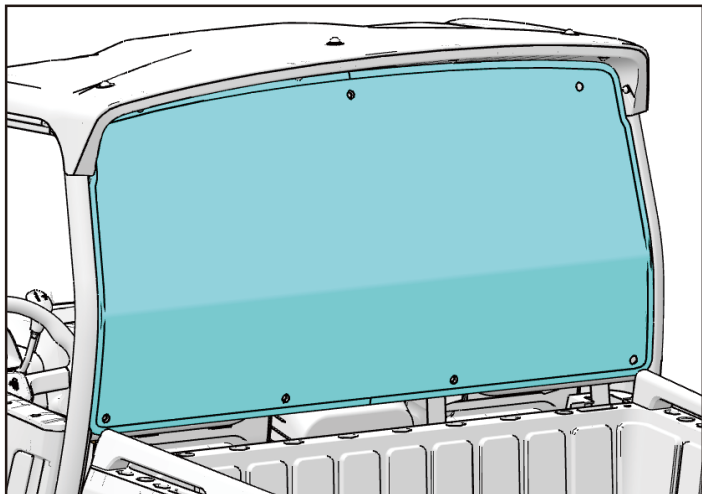
⚠ CAUTION

This installation instruction is suitable for many models, the illustration may be slightly different, please use the actual vehicle.

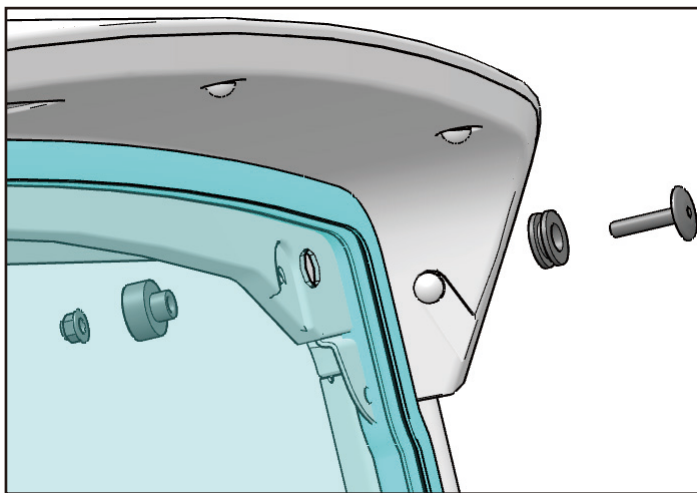
PC REAR WINDSHIELD COMBINATION INSTALLATION GUIDE

REAR WINDSHIELD ASSEMBLY INSTALLATION

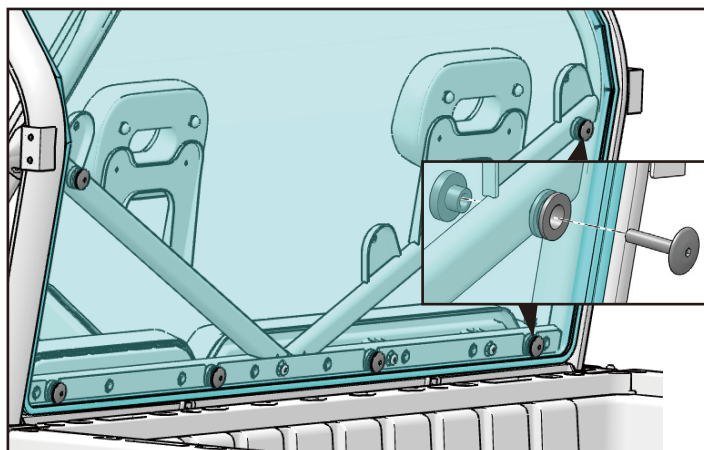
1. Align the holes of the rear windshield assembly with the installation holes on the rear of the ceiling



2. Install and fix the upper part of the windshield assembly and the holes on the ceiling in turn with 3 large flat head screws M8 × 40, I-shaped rubber pads, glass cushion covers (long) and nuts. Torque value: 30 ~ 40N · m(3.0~4.0kgf · m , 22.1~29.5ft · lb)

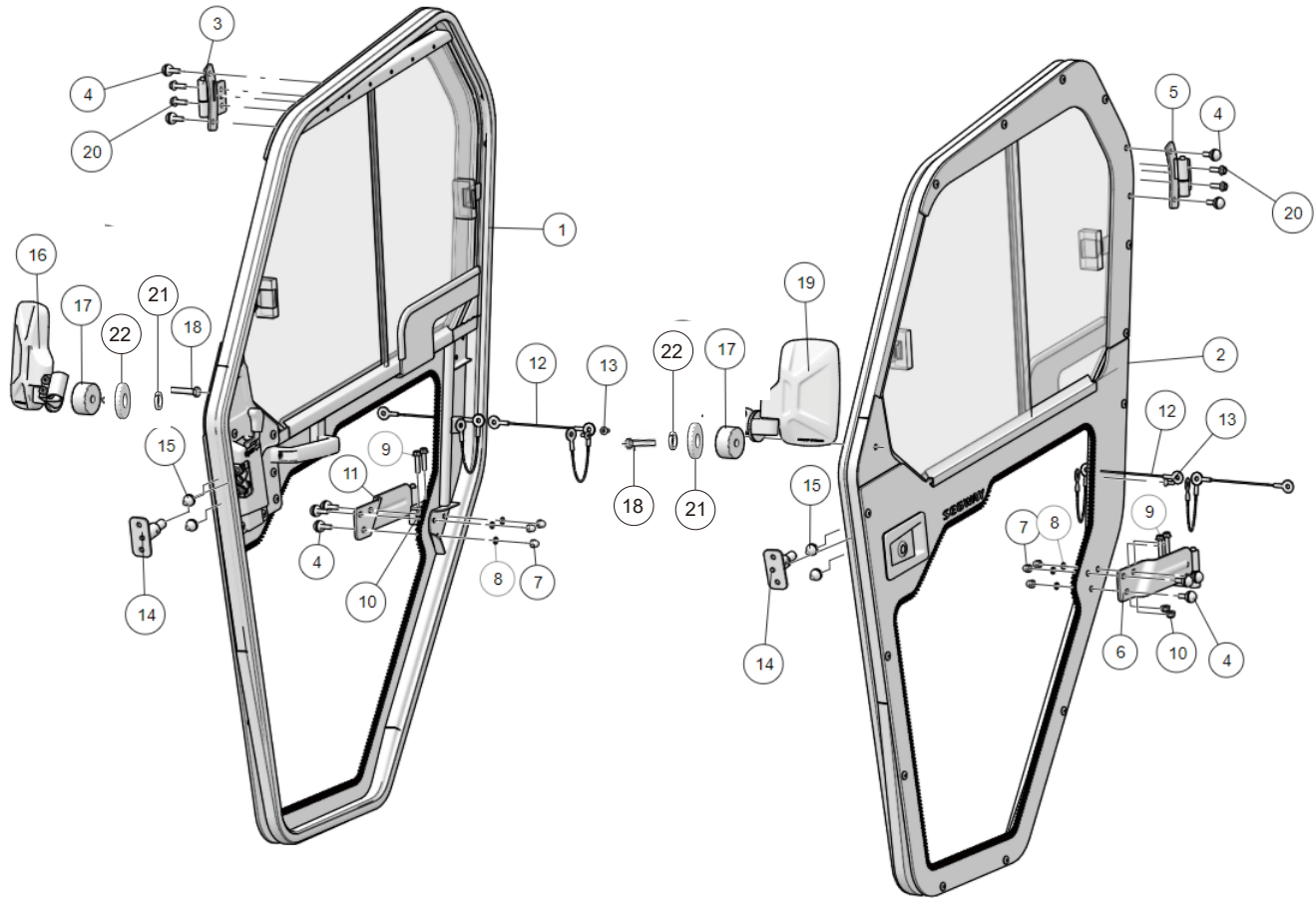


3. Use 6 large flat head screws M8 × 40, I-shaped rubber pads, and glass pad covers (short) to fix the middle and lower parts of the windshield assembly and the corresponding installation halo on the ceiling in turn. Torque value: 30 ~ 40N · m(3.0~4.0kgf · m , 22.1~29.5ft · lb)



INSTALLATION-FULL PC DOOR

Installation and assembly drawing of PC door



| NO. | PART NAME | PART NUMBER | QUANTITY | REMARKS |
|-----|---|--------------------|----------|--|
| 1 | Right pc side door | — | 1 | |
| 2 | Left pc side door | — | 1 | |
| 3 | Upper right hinge bracket assembly | U06-C500500-FB0-00 | 1 | |
| 4 | Hexagon socket bolt with large pan head m8 × 25 | T03000008003 | 10 | |
| 5 | Upper left hinge bracket assembly | U06-C500400-FB0-00 | 1 | |
| 6 | Lower left hinge bracket assembly | U06-C400500-FB0-00 | 1 | |
| 7 | Cap nut m8 | BG009230-08015-C81 | 6 | |
| 8 | Spring washer 8 | GB0000093004 | 6 | |
| 9 | Hexagon flange bolt m8 × 35 | GBT005789018 | 4 | |
| 10 | Non-metallic insert hexagon flange lock nut m8 | GBT061831003 | 4 | |
| 11 | Lower right hinge bracket assembly | U06-C400600-FB0-00 | 1 | |
| 12 | Door cable | U06-C431000-000-00 | 2 | |
| 13 | M6 step bolt | U01F10001001 | 4 | |
| 14 | Door lock post welding assembly | U06-C401000-0MP-00 | 2 | This part has been installed when it is shipped with the whole door. |
| 15 | Hexagon socket bolt with large pan head m8 × 16 | T03000008002 | 4 | |
| 16 | Right mirror assembly | T09000004001 | 1 | |
| 17 | Rear-view mirror cushion cover | U01-C530001-DB0-00 | 2 | |
| 18 | Hexagon head bolt m10 × 1.5 × 55 | BG057820-10055-C81 | 2 | |
| 19 | Left rear-view mirror assembly | T09000003001 | 1 | |
| 20 | Hexagon flange bolt m8 × 20 | GBT005789015 | 4 | |
| 21 | Spring washer 10 | GB0000093005 | 2 | |
| 22 | Flat washer 12.5 × 32 × 5 | F01F20509001 | 2 | |

INSTALLATION-FULL PC DOOR

INSTALLATION-FULL PC DOOR

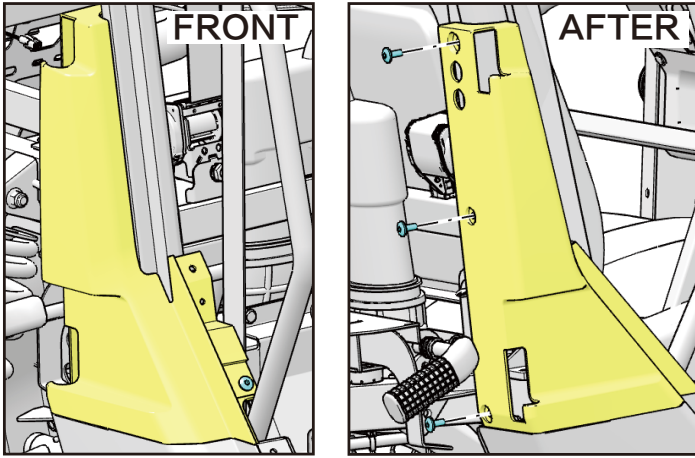
TIPS

The left and right sides are installed in the same way.

TIPS

Before the door is adjusted, all bolts are only pre-tightened. After the door is adjusted, all bolts are tightened according to the specified torque.

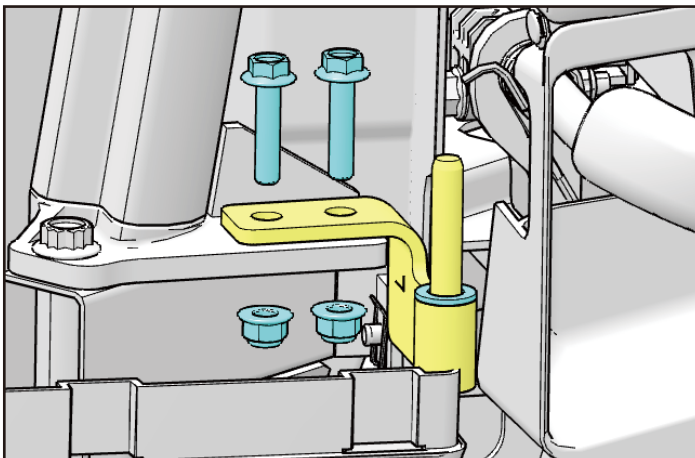
1. Remove the fixing bolts on the left side cover of the vehicle top bar, and remove the left side cover of the top bar.



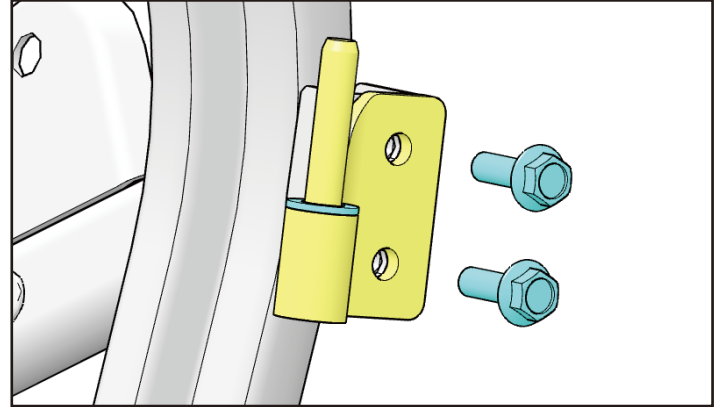
2. Install the lower hinge (pay attention to the left and right during installation, and the hinge is marked) in the corresponding fixing hole with 2 hexagon flange bolts M8 × 35 and non-metallic insert hexagon flange lock nut M8.

TIPS

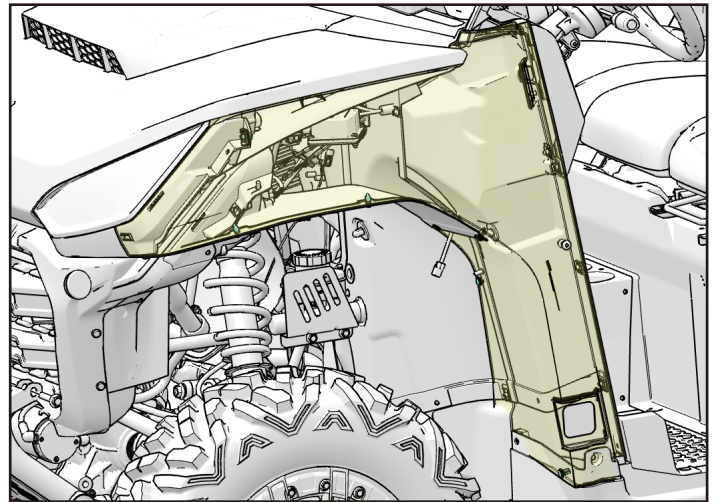
The left and right sides are installed in the same way.



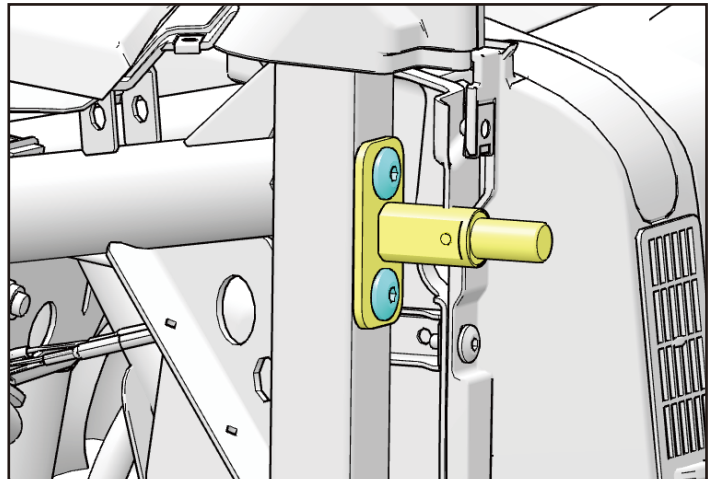
3. Install the upper hinge (pay attention to the left and right during installation, and the hinge is marked) in the corresponding fixing hole above the top beam with 2 hexagon flange bolts M8 × 20. Put the shim into the shaft.



4. Remove the fixing bolts on the left front side guard plate, and remove the left front side guard plate.

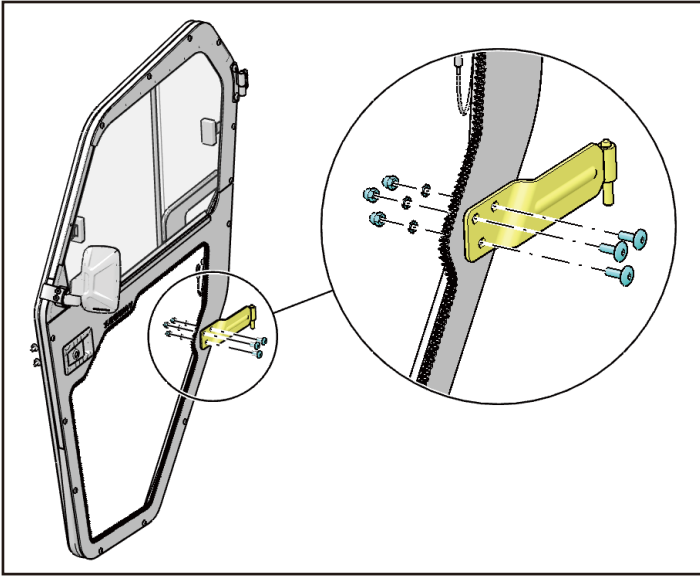


5. Remove the self-contained lock post on the vehicle, and install the newly equipped lock post with 2 large pan head hexagon socket head bolts M8 × 16. (Note: If the whole door has been configured at the factory, this lock cylinder does not need to be replaced, ignore this step)

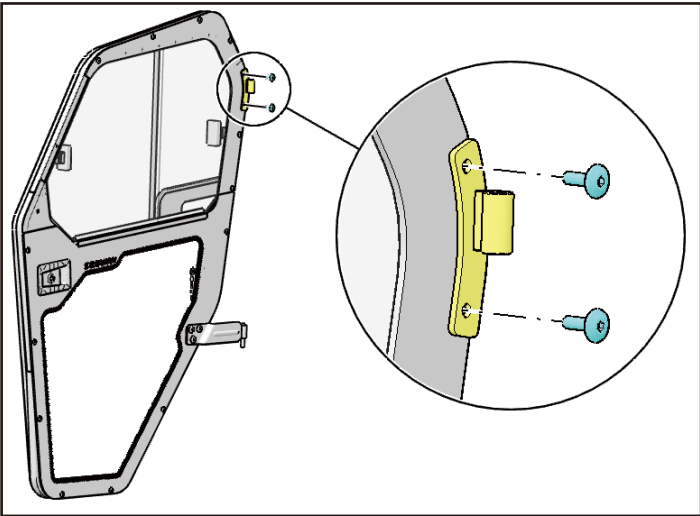


INSTALLATION-FULL PC DOOR

6. Install the lower hinge on the lower end of the door with 3 large flat head hexagon socket bolts M8 × 25, spring washer 8, and cap nut M8. Torque value: 30 ~ 40N · m(3.0~4.0kgf · m ,22.1~29.5ft · lb)

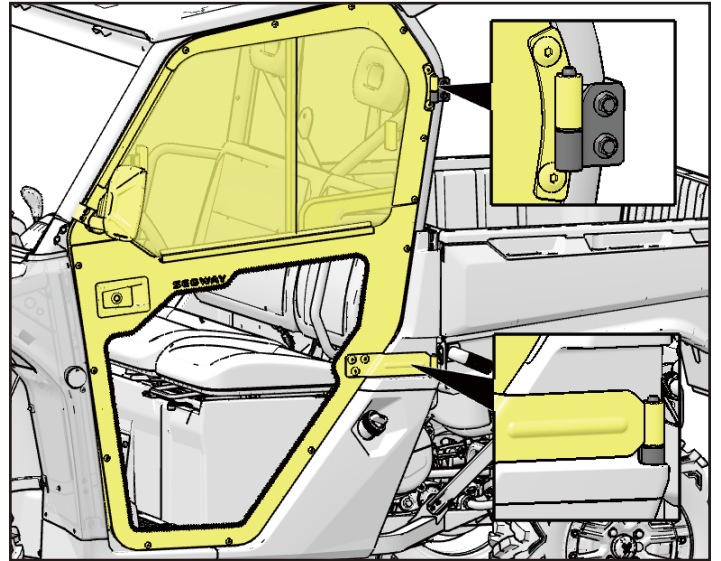


7. Install the upper hinge on the upper end of the door with 2 large flat head hexagon socket bolts M8 × 25 respectively. Torque value: 30 ~ 40N · m(3.0~4.0kgf · m , 22.1~29.5ft · lb)

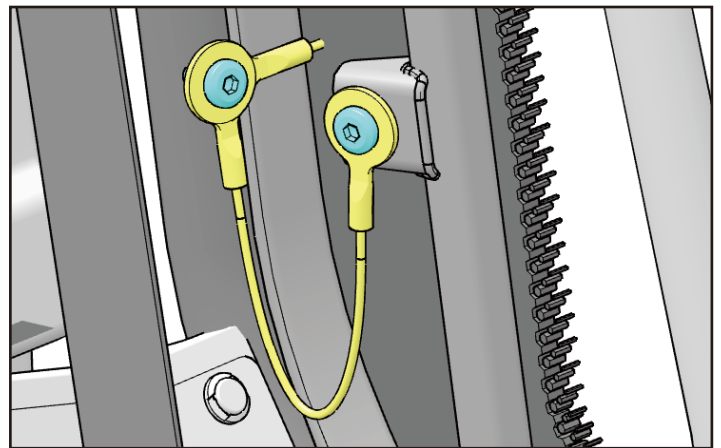


8. Insert the upper and lower fixed shafts of the door into the upper and lower hinge shafts respectively. Close the door and check the clearance between the door and the periphery. If the clearance is even, tighten all the fixing bolts of the upper and lower hinges. If the gap is not uniform, adjust the door until the door gap is uniform. Torque value: 30 ~ 40N · m (3.0~4.0kgf · m ,22.1~29.5ft · lb).

Perform the operation of opening and closing the door and locking the door. If the operation is not smooth, the lower hinge must be adjusted until the operation is smooth.



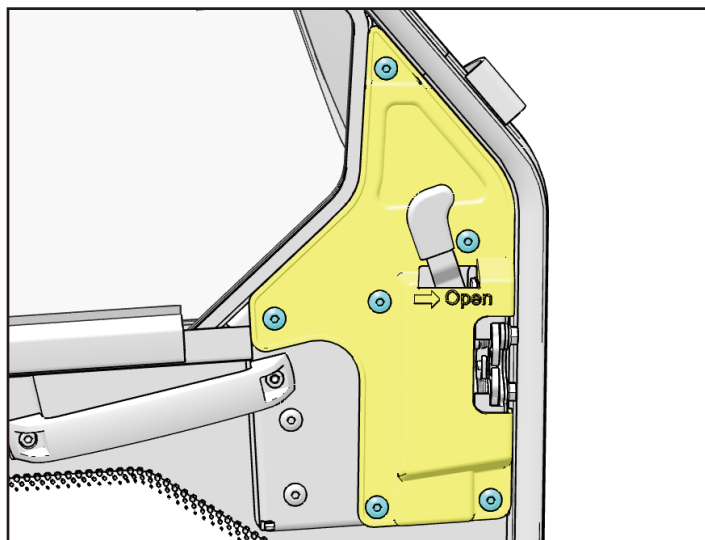
9. Fix one end of the door cable in the corresponding hole of the top beam with a M6 step bolt, and fix the other end in the corresponding hole of the door with a M6 step bolt.



INSTALLATION-FULL PC DOOR

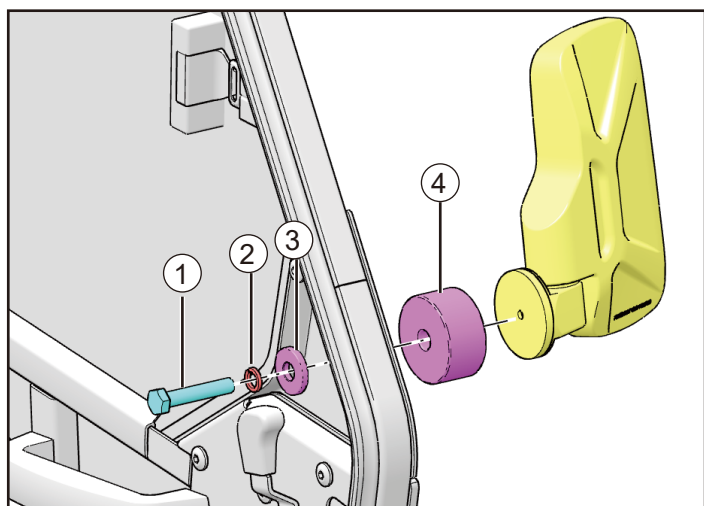
10. If the vehicle has its own rearview mirror, remove the rearview mirror.

11. Remove the fixing bolts on the door lock cover, and remove the door lock cover.



12. As shown in the figure below, reinstall the rearview mirror with hexagon head bolt M10 × 1.5 × 55, spring washer 10, flat washer 12.5 × 32 × 5, and rearview mirror cushion cover. Torque value: 30 ~ 40N · m(3.0~4.0kgf · m , 22.1~29.5ft · lb)

- 1、 Hexagon head bolt M10 × 1.5 × 55
- 2、 Flat washer 12.5 × 32 × 5
- 3、 Spring washer 10
- 4、 Rearview mirror cushion cover



13. Install the removed left (right) door lock cover, left (right) side top bar side cover, and left front side guard.