

Item	Description	RFQ (L00)				ECN (L00)				Platform Resp.	Comments
		CC2S	AS400	Platform	AS400	CC2S	AS400	Platform	AS400		
2nd Row											
Confidential											
1	Release LH mesher into PDM	n/a		n/a		9402	8	n/r			
2	Articulation angle change	n/a		n/a		9613	8	09530	8	M Yesko	
3	Straps to o/s side of handle h/r's	9633	8	9643	8	10441	8	10456	8	M Yesko	DR6519 approved 11/25
4	post diameter 10mm + weight saves	9736	0	9743	5	12022	8	12137	8	M Yesko	processed after 12059
5	Poke yoke					8260	8	09265	8	M Yesko	No go. Need new ECN to change back.
5b	Reverse Poke yoke					10053	8	n/a (invalid part #s)	n/a	M Yesko	RH mechs only. Did not spawn platform ecn as incorrect part numbers attached.
6	Reverse Poke yoke again					10136	8	10248	8	M Yesko	RH mech numbers attached
7	Release for asm's					11145	8	11109	8	A Crainic	
7	Delete form/mech asm parts					11154	8				
8	10mm to 12mm					13212	8	13222	8	M Yesko	
9	12mm guide asm. o/s 5,6 & 7P					7124	8	14366	8	M Yesko	SA'd Push through
9b	12mm guide asm. o/s 5,6 & 7P.					14773	8	16717	8	M Yesko	push through w/ no quote. Bumps part
	Quote only - autoarticulation	15161	6	15287	4						Platform request. Still pending
10	Add assist spring for assembly	17038	8	17175	4	18007	8	18165	5	M Yesko	RFQ issued to follow change process. 16757 obsolete - do not process.
11	Add radii to trim closeouts	19016	8	19169	8	24908	8	24911		M Yesko	
12	Add Ford logo to latch plastic	20258	8	20388	4						
13	torsion tube material and end fit	21851	8	21863	5	24909	8	24929	4	M Yesko	
14	Add plastic standoff to latch cover	21854	8	21894	5	24910	8	25087	7	M Yesko	
15	Lock notch dimension change	21872	8	21890	5	31003	8	31110	-1	M Yesko	Group 5
16	change release effort callout					22478	8	n/a		M Yesko	group 4
17	add bumper/nylon stop pin	23376	8	23403	8	28671	-1	30077	-1	M Yesko	Group 5
18	Coating to inhibit rust	25267	8	25462	5					M Yesko	Group 5
19	Shorten fins	26145	8	26321	8	31004	-1	31121	-1	M Yesko	Group 5
20	ated to zinc/revised end	26717	6	26931	3					M Yesko	group 6
21	change locking angle	28524	8	28584	4	31331		31413		M Yesko	group 5
22	catch spring rate change										pending
23	notch depth increase	31111	6	31118	3					M Yesko	group 6
24	change lock pawl material/heat treat										pending
25	add Hydrex coating to post										pending
	change cable attachment angle										pending

Old Part #      New Part #

26	QUOTE 2ND ROW U251 5,6,7P HR MECHANISM CHANGE. ADD RUST INHIBITING COATING TO LOCK PAWL.	34247		34259		37568		41701	8		Group7	L0023286AJ10,005 L0023287AJ10,005 L0042999AH10,005 L0043001AH10,005	L0023286AJ11 L0023287AJ11 L0042999AH11 L0043001AH11
27	QUOTE CHANGE TO 2ND ROW U251 5,6,7P HR MECHANISMS: 1.) ADD RADI TO RELEASE CABLE END FITTING TO ELIMINATE SHARP CORNERS 2.) INCREASE DIAMETER AT ATTACHMENT LOCATION 3.) INCREASE THICKNESS OF END FITTING 4.) REVISE END FITTING MATERIAL FROM NYLON66 TO GLASS FILLED NYLON66 CHANGES MADE TO IMPROVE STRENGTH OF CABLE ATTACHMENT FEATURE TO MECHANISM AND RESIST BREAKING.	34429		34431		37569		41728	6		Group7	L0023286AJ11,003 L0023287AJ11,003 L0042999AH11,003 L0043001AH11,003	L0023286AJ12 L0023287AJ12 L0042999AH12 L0043001AH12
28	NO COST CHANGES. QUOTE FOR TIMING TO IMPLEMENT THE CHANGES. THESE CHANGES ARE APPLICABLE TO 2R 5P/6P/7P AND ARE AS LISTED BELOW: 1. LOCK LEVER DESIGN CHANGE TO HAVE LOCK ANGLE: 5.7+/-0.2 DEGREES 2. POST LOCK SURFACE TO HAVE 6+/-0.5 DEGREES RELIEF ANGLE AND ATLEAST 1MM CLEARANCE AT THE TOP WITH LOCK LEVER 3. LOCK LEVER & POST TO HAVE EQUAL HARDNESS OF 38 - 42 HRC. IF REQUIRED POST NEEDS TO BE HEAT TREATED. 4. LOCK LEVER PIN DIAMETER TO BE INCREASED TO 6.5MM FROM 5.0MM 5. NYLINER BUSH BEARINGS TO BE REPLACED WITH TEFLON COATED STEEL BUSHES. 6. ZINC ROD RIVET HEAD TO HAVE THICKNESS OF 2+/- 0.5MM AFTER					41652	8	41761	6		Group7	L0023286AJ12,002 L0023287AJ12,002 L0042999AH12,002 L0043001AH12,002	L0023286AJ13 L0023287AJ13 L0042999AH13 L0043001AH13
29	NO COST ECN. QUOTE FOR TIMING TO IMPLEMENT THE CHANGES. THE CHANGES ARE: 1. REPLACE ZINC ROD WITH STEEL ROD GEOMETRY WOULD BE SLIGHTLY MODIFIED TO SUIT MANUFACTURING. DIAMETER OF THE ROD WOULD REMAIN SAME.					42202	8	42428	6		Group7	L0023286AJ13,002 L0023287AJ13,002 L0042999AH13,002 L0043001AH13,002	L0023286AJ14 L0023287AJ14 L0042999AH14 L0043001AH14
30	U251 2R 5/6/7 Pass head restraint engineering changes to take care of pin peel-off in 201. These changes are no cost to Lear. Change is 1. Lock lever pin changed to have more robust design. New design is with flange on out side of stamping. Pin press fitted and welded to stamping. Other end of pin is cold riveted on washer.					42865	8	42888	6		Group7	L0023286AJ14,002 L0023287AJ14,002 L0042999AH14,002 L0043001AH14,002	L0023286AJ15 L0023287AJ15 L0042999AH15 L0043001AH15
29	No cost to Lear. Add Rm's Horn wire on U251 2R 5P/6/7P Head restraints mechanisms to take care 1.Strap padding loss 2. To cover sharp edge cutting thru form & trim					44414	-2	44438	-1		Group7	L0023286AJ15,003 L0023287AJ15,003 L0042999AH15,003 L0043001AH15,003	????
30	U251 2R 5/6/7Pass head restraint plastic guide modification.Add 0.25mm material on each side (a total of 0.5mm) to the existing rotation preventing TAB. Present size (thickness)of tab is 2.45mm. New size would be 2.95 nominal. Tolerance would be same as previous.Change is required for eliminating the ticking noise observed in shaker table test.					44455		44522			Group8	L0020735AB02	L0020735AB03
31	U251 2R 5/6/7Pass - Quote for adding branding on Trim close out. Branding includes (FOMOCO) (plant ID) (plant code).Platform needs to know the cost of this branding. After the quote they will decide to go with branding or not.	45729	0	46423	0						Has been cancelled	L0023286AJ15,003 L0023287AJ15,003 L0042999AH15,003 L0043001AH15,003	

32	Quote for new shell on U251 2R 5/6/7 pass head restraint mechanisms. This shell is required to meet ST-0047 requirement of 2.5mm radii. There are two shells in the design. One to cover the rear and another one to cover front. Both the shells will have minimum radius of 5mm every corner/edge.	42528		43497		46759	8	46777	6	mictelle	Group8	L0023286AJ15,002 L0023287AJ19,002 L0042999AH15,002 L0043001AH15,002	L0023286AJ18 L0023287AJ16 L0042999AH16 L0043001AH16
						Lear Corporation Confidential							
33	U251 2R 5/6/7 Pass no cost change. Modify the side plastic shield to prevent pull strap catching in. modify the shield to have effective support and clamp it to stamping with M4 screw.					45731	8	47812			group8	L0023286AJ16,002 L0023287AJ16,002 L0042999AH16,002 L0043001AH16,002	L0023286AJ17 L0023287AJ17 L0042999AH17 L0043001AH17
34	No cost change - For U251 2R 6pass Lead restraint. Move notch on both the posts down by 6mm. This will increase the distance between pivot and notch and eliminate the problem of partial dumping. Keep the length of the post below notch same. Hence Post length to be increased by 6mm.					46793	8	47863	4		Group9	L0023286AJ17,002 L0042999AH17,002	L0023286AJ18 L0042999AH18
35	ADD A BUTTON TO BELT STRAP FOR ERGONOMIC REASONS. THIS IS REQUIRED TO DEFINE THE SEQUENCE OF OPERATION FOR DUMPING THE SEAT. WINDSOR TO QUOTE COST TO ADD THIS BUTTON ON THE STRAP. THIS IS REQUIRED ON ALL HEAD REST MECHANISMS SUPPLIED FOR 2R-5P/6P/7P AND 3ROW.					47166	8	47888	4		Group9	L0023286AJ18,002 L0023287AJ17,002 L0042999AH18,002 L0043001AH17,002 L0020752AE08,002 (3R HR)	L0023286AJ19 L0023287AJ18 L0042999AH19 L0043001AH18 L0020752AE09 (3R HR)
REDACTED SECTION													
37	NO cost ECN. This ECN is for removal of Trim close-out. Further to 1PP shell under ECN46777, this trim close-out is integrated with shell. Hence present trim close out to be removed. Piece price saved from the removed trim close-out					48990	8	49046	4		Group9	L0023286AJ19,002 L0023287AJ18,002 L0042999AH19,002 L0043001AH18,002	L0023286AJ20 L0023287AJ19 L0042999AH20 L0043001AH19
38	improved version of shell to meet ST-047 requirement of 2.5mm radius. Previous shell (used for 1PP) was processed under Platform RFQ43497 and ECN46777. The new design is similar to 1PP design, but reduced in size and weight to reduce piece price and tooling cost. There are two shells in the design. One to cover the rear end and other to cover front end. Both the shells	48500	8	48504	8	60344	-1	60349	-1	myesko			
39	design with SHROUD. This is improved version of small shell. This shell will cover foam at openings. This shell also covers metal as seen from openings in dump condition. ---This shell is required to meet ST-0047 requirement of 2.5mm radii. There are two shells in the design. One to cover the rear and	50501	8	50503	3								
40	U251 2R 5/6/7 pass HR shell design with SHROUD. This is improved version of small shell. This shell will cover foam and metal as seen from openings in dump condition. ---This shell is required to meet ST-0047 requirement of 2.5mm radii. There are two shells (front and rear shells) in the design. Both the shells will have minimum radius of 5mm every corner/edge, wall to separate strap and radius at the bottom to take care of J-narrow assembly ENGG NOTE: Supplier to quote for this					54794	8	54829	5	dgaines		L0023286AJ20,002 L0023287AJ19,002 L0042999AH20,002 L0043001AH19,002 L0089421AA01 L0089422AA01 L0089424AA01 L0089425AA01	L0023286AJ21 L0023287AJ20 L0042999AH21 L0043001AH20 L0089421AA02 L0089422AA02 L0089424AA02 L0089425AA02
41	pass Comp HR. Below listed changes to be included in the design: 1) Lock lever material to be changed to 4130 from 950. Hardness to be 38-42 HRC. 2) Increase the corner radius on Lock lever to 1.5mm from 0.5mm 3) Change cable wire routing on RH mech to M-shape. This may potentially eliminate the possibility of cable pulling in 201 hit. 4) Post locking surface needs machining for effective locking. Locking face to be broached or use any equivalent to control the dimension from center line to					55300	8	55429	7	dgaines		L0023286AJ21,002 L0023287AJ20,002 L0042999AH21,002 L0043001AH20,002	L0023286AJ22 L0023287AJ21 L0042999AH22 L0043001AH21
42	5.7degrees. Modify Lock lever to have 3.9degrees lock angle. This change is required to make locking more robust on HR. This change will be in place for all HR after the tool is modified for the angle. Time for tool completion will be determined in consultation with WMG.					58665	8	58686	5			L0023286AJ22,002 L0023287AJ21,002 L0042999AH22,002 L0043001AH21,002	L0023286AJ23 L0023287AJ22 L0042999AH23 L0043001AH22
43	U251 2R 6pass HR (Quad) - No cost ECN. Following changes need to be implemented on the mech. 1) Increase the post thickness to 6mm from 4mm at locking section. This will result in reduction in the width at that section. 2) Increase steel rod length by 2mm. This to cover post thickness increase.					59081	8	59155	5			L0023286AJ23,002 L0042999AH23,002	L0023286AJ24 L0042999AH24
44	U251 2R 5/6/7pass HR - No cost change. Plastic side shield boss around the screw hole to be increased to dia8.75mm from dia6.8mm. This is to avoid crushing of the plastic material					59086	8	59510	5			L0023286AJ24,002 L0023287AJ22,002 L0042999AH24,002 L0043001AH22,002	L0023286AJ25 L0023287AJ23 L0042999AH25 L0043001AH23

45	to lock lever instead of PHOS-OIL. Phos-oil, per WMG, has slippery character, hence may not help lock lever for effective locking. Zinc coating would help lock lever to firmly hold the post and keep continuous locking. Engineering Comments:Phos-oil, per WMG, has slippery character, hence may not help lock lever for effective locking. Zinc coating would help lock lever to					Lear Corporation 59562 Confidential	59652	5			L0023286AJ25,002 L0023287AJ23,002 L0042999AH25,002 L0043001AH23,002	L0023286AJ26 L0023287AJ24 L0042999AH26 L0043001AH24
46	U251 5/6/7 pass HR - Quote for heat treatment of slave side post(opposite to lock lever side) to get same appearance(when Zinc coated)as lock lever side post. Process of heat treatment need to be decided with couple	59697	8	59703	4							
47	below modification to meet chuck requirement on HR, when seat allowed to fold w/o dumping HR. 1) Replace teflon coated bushings with Powder metal coated bronze bushes. 2) Modify stamping to have flange on bearing hole and flange to stop Hytrel peel-off 3) Add Spring clip to retain bush on slave side (Don't Process ECN)	60387	8	60397	0							
48	1) Replace Teflon coated steel bushings with Powder metal coated bushings(bronze as base metal) 2) Modify stamping to accommodate the PM bushes.Stamping hole will be increased from 11.6dia to 13.0dia. 3) Keep hytrel same on the stop pin for now 4)Lock lever pin to have Phos & oil					61780	8	61805	3	dgaines	L0023286AJ26,002 L0023287AJ24,002 L0042999AH25,002 L0043001AH24,002	L0023286AJ27 L0023287AJ26 L0042999AH27 L0043001AH25

Item	Description	RFD (LWI)				ECN (LSD)				Platform Req.	Comments
		CC28	AS400	Platform	AS400	CC28	AS400	Platform	AS400		
1	Release AS40016721										
2	Emboss shape change					8591	8	0828	8	S Lucas	
3	13.7mm rod to 11mm					7757	8	0783	8	S Lucas	
4	Weight bearing stamping	8530	8			8147	8	0978	8	S Lucas	No CAD
5	actuation indicator relocation change release for arm.	8551	8	8584	8	8703	8	0920	8	S Lucas	DTR431854R000245 approved 11/25
7	Add flanges/increase groove to 2.5	11215	-2			12411	8	12456	5	S Lucas	no cost change. Cancel initial RFQ 11215 DTR43175 DTR7250
8	change lock pawl material Add washer					18338	8	18732	4	S Lucas	In CP parts. Improve pawl wear characteristics
9	Quote bezel	18311	8	18315	0					S Lucas	To improve trim
10	add spacer bushing inside hole	22485	8	22482	8	24801	8	24827	2	S Lucas	closeout around post
11	change release offset cable					22170	8	718		S Lucas	group 4
12	actuator rod offset change	22938	8	22945	8	24805	8	24865	4	S Lucas	group 4
13	stamping coating	28308	8	28448	4					S Lucas	group 5
14	insert end rivet for assembly	28520	-1	29311	-1					S Lucas	group 5
15	U251 3RD ROW HR ASM. CHANGES: 1.) CHANGE RADII ON LOCKING CAM FROM 0.64MM TO 1.50MM 2.) COAT PAWL TO PREVENT RUST FORMATION 3.) ADD LUBRICANT TO CAM AT POST INTERFACE. LUBRICANT MUST MEET DURABILITY REQUIREMENTS AT EXTREME TEMPERATURE CONDITIONS.	34543		34545		39311		42798			
16	CATCH UP RFQ FOR 3RD ROW HR MECHANISM CHANGES: 1.) REMOVE 2.5MM FROM HOOKED END OF CAM SPRING TO IMPROVE CLEARANCE TO SPACER BUSHING 2.) CURL END OF DUMP SPRING TO WRAP OVER BACK OF STAMPING WALL - ELIMINATES SHARP POINT 3.) ADD 3.09MM RADII TO SHARP CORNERS ON FRONT FLANGE - REMOVES SHARP CORNERS.	34068		34086		42791		43498			
17	NO COST CHANGES. QUOTE FOR TIMING TO IMPLEMENT THE CHANGES. THESE CHANGES ARE APPLICABLE TO 3ROW HR. CHANGES ARE: 1. NYLINER BUSH BEARINGS TO BE REPLACED WITH TEFLON COATED STEEL BUSHES 2. U-POST TO BE CHANGED TO M-POST 3. INCREASE DIAMETER OF LOCK SIDE PIN ON POST FROM 7.5MM TO 10MM 4. INCREASE HOLE DIAMETER ON SPACER BUSH TO ACCOMMODATE LARGER PIN AND TEFLON BUSH. 5. INCREASE HEAD ON RIVETED PIN ON SLAVE SIDE TO HAVE ATLEAST 1.5MM THICKNESS 6. INTRODUCE TEFLON BEARING ON PAWL ROD NEAR PAWL. 7. HEAT TREAT THE PAWL ROD TO HAVE MINIMUM OF 55HRC					41659	8	41689	8		L0020752AE05_00_2 L0020752AE06 29801
18	ADD A BUTTON TO BELT STRAP FOR ERGONOMIC REASONS. THIS IS REQUIRED TO DEFINE THE SEQUENCE OF OPERATION FOR DUMPING THE SEAT. WINDSOR TO QUOTE COST TO ADD THIS BUTTON ON THE STRAP. THIS IS REQUIRED ON ALL HEAD REST MECHANISMS SUPPLIED FOR 2R-5P/MP/P/ AND 1ROW.					47166	8	47888	4		L0020752AE08,002 L0020752AE08
19	NO cost change - U251 3R Dump HR - Heat treat the spacer bushing to prevent elongation of the hole in vertical loading. Designed Material is 1018. Heat treatment required. a. Case carburise to 0.5mm deep (Case depth) b. Case harden to 40 to 47 HRC.					48690	8	48689	7		L0020752AE09,002 L0020752AE10
20	U251 3R Dump HR - ONLY FOR RFQ. RFQ for 1) Increase the dump spring stiffness to 1.5x. 2) Provide notch on the M-post, where pawl touches, to enable HR to fold more. This increased forward folding may reduce interference with 2R seat back when folded. (PLEASE DO NOT SPAWN ECN)	55927	8	55937	0						
21	ECN RFQ for 1) Strap routing to get approx 2:1 leverage from strap router. This strap routing to have fool proof arrangement for assembling onto the seat w/o any mistakes 2) Reinforce the base stamping with strap router welded at both ends. 3) Remove cut outs in the stamping to increase the strength of the bracket and reduce deformation in load. PLEASE DON'T SPAWN ECN.	55935	8	55938	0						
22	U251 3R HR - NO COST ECN - Add ribs inside the plastic washer to stop rattle on shaker table. ID of the plastic washer to be 9.8(+ 1/-0.0).					58243	8	58347	8		L0020752AE10 L0020752AE11
23	No cost ECN. 1) This ECN is to document the change in part # 2) L0020752 is for U251 3R HR foam+mech. New part # L0104109 is created for mechanism only. 3) Please update the parts list. Engineering Comments: U251 3R HR - no cost ECN. This will enable to monitor foam changes and mech changes properly by seat complete engineer and mech engineer respectively					57140	8	57155	8		L0020752AE11,002 L0020752AE12
24	Please Ignore ECN57140. This ECN is same as 57140, but with correct parts. No cost ECN 1) This ECN is to document the change in part # 2) L0020752 is for U251 3R HR foam+mech. New part # L0104109 is created for mechanism only. 3) Please update the parts list. Engineering Comments: U251 3R HR - no cost ECN. This will enable to monitor foam changes and mech changes properly by seat complete engineer and mech engineer respectively					57190	8	57199	8		L0020752AE12,002 L0104109AA00,001 L0020752AE13 L0104109AA01
25	U251 3R HR - ECN is for increasing the dump spring force on the mech. Replace present single torsion spring (13N-min/degree) with Dual torsion spring (21N-min/degree). This change will eliminate the plastic washer (PIA08). Engineering Comments: Refer RFQ55927 central and 55937 platform for this change.					57834	8	58022	8		L0020752AF01 L0104109AA01,002 L0020752AF02 L0104109AA02
26	U251 3R HR - This RFQ is for 1) Add reinforcement bracket at the master end corner. This is 5mm thick bracket to fix chuck due to abusive loads 2) Re(3) Remove embossing around the bolt holes. Reinforce the existing bracket with lesser trim cuts in the middle. This will help to reduce chuck at master and slave ends. Engineering Comments: U251 3R HR - This RFQ to fix Chuck from Abusive loads.	58100	8	58101	4						L0020750A002-- L0020751A002-- LEVEL for Job 1