

## Boston Whaler Pilot Seat Assembly Instructions

- Unpack components and locate the bench seat assembly, and the right & left leg, as shown below.



- You will need a table for this step. Lay the seat assembly upside down (with blocks facing up). Place one of the legs upside down on the seat assembly. Be sure the backrest portion of the leg is all the way up against the rear side of the seat assembly (see below). Note: Be sure the rounded side of the blocks holding the seat assembly together are facing forward (see below).



- Using the #8 x 1 ¼" screws (smaller of the 2 sizes included), fasten each leg to the seat assembly (as shown below). It may be helpful to drill small pilot holes prior to fastening the screws. Important Note: Be sure each leg is on the correct side. The larger pre-drilled counter sunk holes should be on the outside, these are so the head of the screw can be counter sunk and wood plugs be pushed in.



- Next, fasten the triangular seat supports to the bottom of the seat assembly and legs, using the same screws as in previous step (see below).



- Locate the rear bench support (long strip). Place it along the bottom/back edge of the seat assembly, see images below. Using the pre-drilled holes, fasten the rear bench support with the same screws as in prior steps.



- Turn seat upright. It's now time to mark the location of the backrest and fasten to the upper portion of the seat legs. You will need to locate the arm rests as well to use as spacers so the backrest is fastened in the correct location. Place each armrest on top of the seat assembly at each side, be sure to place it over the pre-drilled holes. Next, place the backrest plank on top of the handles and up against the upper seat legs. Once in place, mark the location of the backrest (see below). Remove the arm rests and fasten the backrest with the same size screws as in prior steps.



- Place the arm rests in place, be sure they are centered on top of the pre drilled holes. Fasten with the same size screws as in prior steps. (see below)

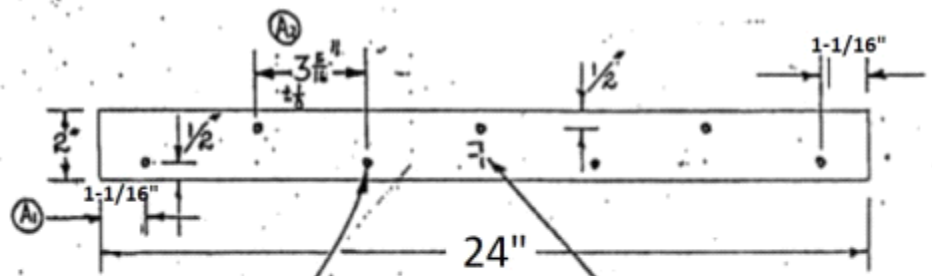
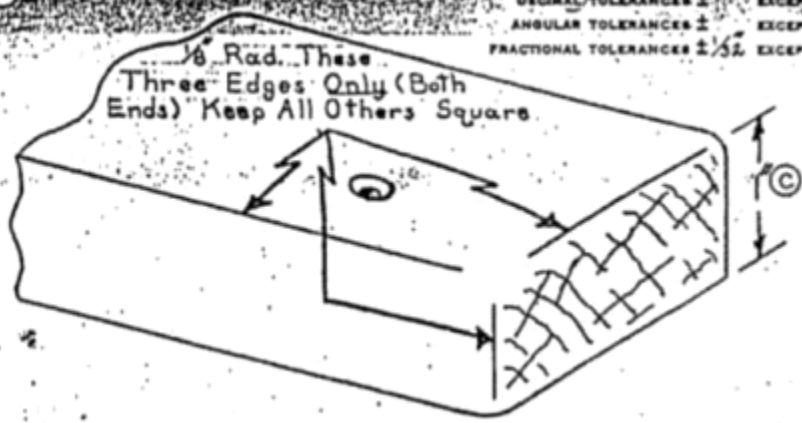


- Install wood plugs over the screws. You may need to cut them shorter to fit. Tap them in using a scrap block of wood and a hammer so they are flush with the surface. Use wood

glue or epoxy. Sand seat with 220 grit sandpaper and varnish as desired. Follow varnish instructions per product, such as Zspar varnish.

- The final step is installing the seat to the deck of your boat using the 2 included blocks (cleats). Varnish the blocks prior to installation. Place the seat on a flat surface and center each block on the inside of each leg. Then mark each of the 3 hole locations onto the blocks using a marking tool or small drill bit. Drill pilot holes in the blocks and then fasten them to the seat legs with the smaller of the remaining screws and finish washers. You will be removing them again below so no need to fasten too tightly.
- Below is a rough drawing of the two cleats, (Dimensions may differ) that are used to fasten the seat to the deck. The screws used here are the largest screws (#14x2") along with washers.) With the cleats attached to the seat, position the seat in the boat at the desired location. Then use a pencil to trace the corners of the cleats onto the deck.
- Next, remove the cleats from the seat and use the drawing below as a general guide to drill holes in the cleats, there are 7 per cleat in a staggered pattern. Note that the location of these holes does not need to be exactly precise. If you are replacing a seat, use the old cleats as a template to drill holes in the new cleats.
- The recommended and easiest way to install the cleats onto the deck is by using 3M 5200 marine adhesive sealant to strengthen the bond of the seat to the deck. It doubles as a sealant to prevent moisture from entering the foam core of the boat. Apply a small bead around the perimeter but not too close as it will squeeze out the sides when fastened to the deck. You can also apply a bead around each hole. Once applied, place the cleats into position on the deck using the guides marked earlier. Press down firmly so there is little to no gap between the cleat and the deck. Let cure overnight.
- At this point the cleats should be bonded to the deck with 5200. Before fastening with #14 x 2" screws, drill pilot holes in the deck through the holes that are drilled in the cleats. Then fasten each screw with finish washers. Note that it is a good idea to coat the threads of the screws with 5200 to use as a sealant and better bond.

DECIMAL TOLERANCES  $\pm$  EXCEPT AS NOTED  
 ANGULAR TOLERANCES  $\pm$  EXCEPT AS NOTED  
 FRACTIONAL TOLERANCES  $\pm 1/32$  EXCEPT AS NOTED



(B) Note: Stamp mfg's ID mark on bottom of cleat. (F is only an example).

(A) (7) Holes, Drill  $\frac{7}{32}$ " dia. C'sinK B2 to  $\frac{7}{16}$ " dia.