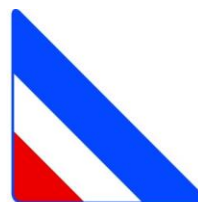


NEWTON COMMERCIAL



classic car interior trim

SEAT FITTING INSTRUCTIONS

TRIUMPH SPITFIRE Mk2 & 3

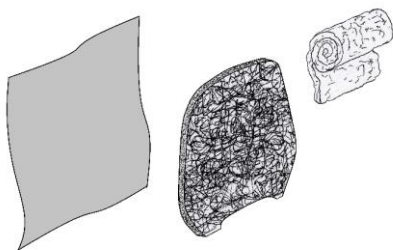
SPITFIRE Mk2 – (1964 -67)
SPITFIRE Mk3 – (1967 – 70)

**FOR USE WITH
NEWTON COMMERCIAL
MANUFACTURED SEAT KITS:**

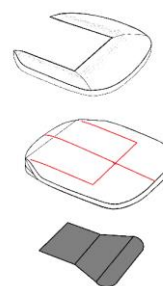
SC1501 & SC1502.



WE RECOMMEND USING NEW BASE & SQUAB PADDING KITS WHEN FITTING NEW SEAT COVERS – AVAILABLE FROM YOUR SUPPLIER. SEE BELOW FOR PART NUMBERS.



SF666S SPITFIRE Mk2&3 SQUAB PADDING KIT
2 off REQUIRED



SF105 – SPITFIRE Mk2&3 BASE FOAM KIT
2 off REQUIRED.

EASTLANDS INDUSTRIAL ESTATE, LEISTON, SUFFOLK. IP16 4LL.

TEL: 0044 (0) 1728 832880 FAX: 0044 (0) 1728 832810

WEB SITE: www.newtoncomm.co.uk

E-MAIL: sales@newtoncomm.co.uk

Wire Brush, 3mm drill, 3mm pop rivets (long) with pop rivet gun, packet of seat clips, hog ring pliers, hammer, Aerosol metal spray paint – black, aerosol contact adhesive, Jig saw, Flat screwdriver, Pliers, Scissors, Staple Gun. We recommend reading through these instructions carefully to familiarise yourself with the procedure and the order of operation.

When using aerosols, please ensure you do so in a well ventilated area & follow the instructions on the can.

SQUAB – (BACKREST) FITTING.



1) Remove old seat covers, padding and old ply tack strips at the bottom front of the frame. (Take a picture to remind you of how



2) Clean the frame. (Wire brush or sand blast to remove rust) – repair as necessary - then paint the frame with aerosol metal paint. – be sure to use a well ventilated area.



3) Cut replacement tack strips from 3mm ply or hardboard – (Size = 20cm x 2cm)



4) Place tack strips into frame & drill 3mm holes in them for rivets. (You may need to dampen the strips so that they follow the curve of the frame without breaking) Use 3mm long pop rivets to fix the strips to the frame. Flatten the rivets at the back of the frame as much as possible, either use a hammer or grind them partially off. (Not completely or the strips will pull away from the frame)



5) Take the piece of 3mm thick foam (This will be a foam laminated to a brushed nylon) - Spray glue the foam surface, then spray glue the back of the frame. Avoid spraying the cross shaped indent on the back of the frame. Once the glue has gone tacky, place the foam onto the back of the frame, make sure there are no creases & that there is sufficient foam to wrap around the edges of the frame. Press the foam onto the frame firmly. Now lay the frame on its back & spray around the edges of the frame & foam, sufficient to be able to fold the foam over the edge of the frame by approximately 20 – 25mm. Trim off any excess foam



6) Take the shaped 'Horsehair' pad from the SF666S squab padding kit.
(If you are re-using your original padding, move to Step (16))



7) Place the padding onto the squab frame to check it's fit. Trim if required.



8) Spray glue the back of the padding.



9) Spray glue the front of the squab frame.



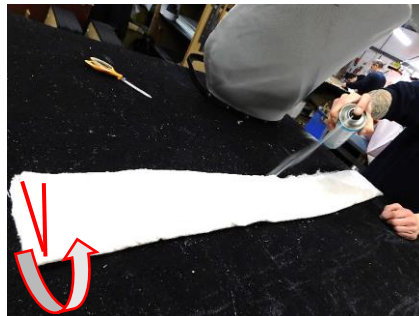
10) Place the pad carefully onto the squab frame then press firmly into place.



11) Carefully spray glue along the outer edge of the 'Horsehair' pad.
(Use a good covering of glue)



12) When the glue is almost dry. Squash the edges of the pad together to make them flat.
(No ridges or lumps around the frame. Trim off any excess.



13) Take the length of cotton wadding from the SF666S squab padding kit, lay it on the workbench & lightly spray glue the face.

Fold it in half lengthways.
It is now the same length but only half the width.



14) Again spray glue the wadding along its length.

Also spray glue around the edge of the frame (Around 30 to 40mm, front & back)
Lay the wadding centrally over the edge of the frame.



15) Press the wadding lightly in place around the front & rear of the frame. Trim off excess at the bottom, also cut off any gathered lumps of wadding, front & back.



16) Take the plastic bag that your seat kit was packed in. Cut a strip across the open end. (Approx. 15cm wide)
Cut across one layer to give one long length.



17) Lay the plastic on the workbench & lightly spray glue along its length. Also lightly spray the wadding



18) Place the plastic centrally over the wadding, keeping it crease free.



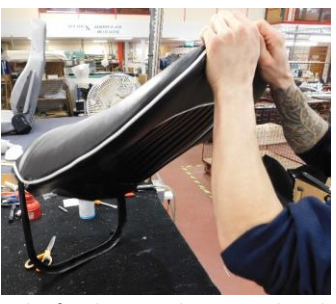
19) Trim off excess front and back. Ensure the wadding & plastic is flat and smooth. This will allow the seat cover to slide over the padding more easily.



20) Take the correct Squab Cover and begin to slide it down over the frame/padding to approximately half way.



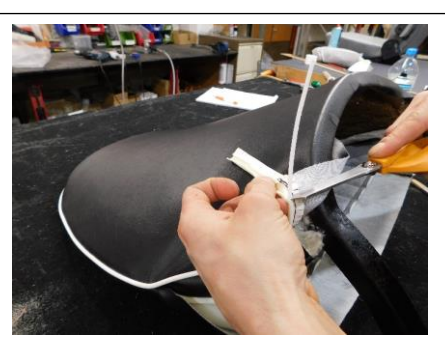
21) At the wide point of the frame, firmly grasp the seat cover where the front horseshoe joins the outer piping on both sides. (These are the weak points of the cover which need protecting so that they do not tear when pulling the cover down further) Now pull the cover fully downwards over the wide point, so that it is roughly in the correct position. Using the flat of the hand, gradually work the cover in a downwards



22) Continue to manipulate the cover by firmly smoothing your hands in a generally downwards direction, working out any creases and ensure the outer piping sits on the frame edge. Once in a satisfactory position, clip the back of the cover over the lower frame edge. Three clips will do at this stage.



23) Place the seat on its front – the front of the seat cover hangs well away from the padding. Spray glue the back of the centre fluted area only (NOT on the horseshoe part) & on the corresponding part of the horsehair padding. Allow to dry – then repeat the gluing.



24) Remove the piping core from the piping tails on the back of the cover. (To a few mm short of where the backrest meets the base frame). Use a sharp knife & scissors to cut the core.



25) Pull the piping down over the frame. This should remove any creases at the side. At the same time firmly smooth the piping downwards from the top of the seat whilst maintaining a good tension all around the cover.



26) Having pulled the piping over the edge of the frame, the cover next to the piping can be clipped to the base frame – Repeat for the other side.



27) Now we look at the inner bottom flaps on the piping. Pulling the flap inwards, you can see that it needs to lie flat onto the padding.



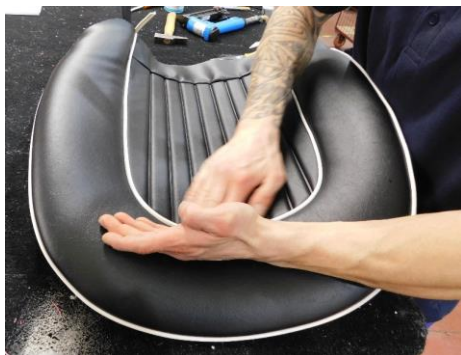
28) Remove the wadding from this area, using scissors to trim it away, just leaving the 'horsehair'. Repeat for the other side.



29) Glue the back of the flap & the 'horsehair' area. When nearly dry, pull the flap up over the padding & fix it into position. Repeat for the other side.



30) Staple the bottom of the flaps to the tack strip & trim off any excess.



31) Lay the seat on its back. It is now time to push the two glued surfaces together. Starting at the top, push the centre fluted area down onto the padding, ensure that the flutes are vertical and that there are no creases in the horseshoe surround. The cover should be a tight enough fit to avoid any creasing. Push down firmly over the whole fluted area.



32) Tuck the side edges at the bottom of the horseshoe under to make a neat finish. Smooth them flat with your hand.



33) staple the bottom flap onto the trim strips at the bottom of the frame.



34) Remove the piping core (as before) from the piping tails at the front.



35) Staple the empty piping down onto the woods. Again tuck the side edges neatly under, pulling out any creases, then staple the bottom of the horseshoe to the tacking strip.



36) You should have this result.



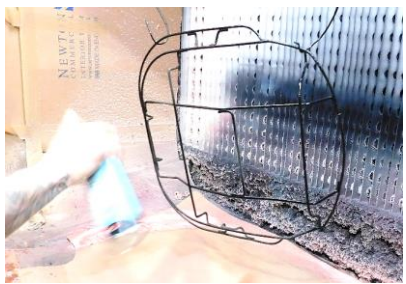
37) Trim off any excess & fold the trimmed front flap under the rear flap to give a neat finish.



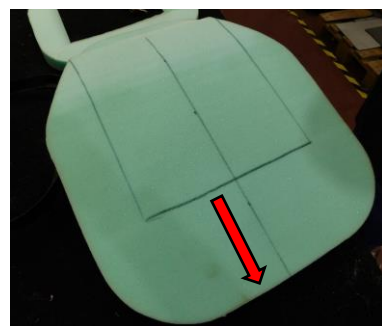
38) Your squab should look like this & is complete. Now for the Base.

BASE FITTING.

B1) Remove the old cover/Foam assembly from your base frame.
(This will be attached using hog rings which can be removed by grasping with pliers & pull off with a twisting motion.)



B2) Repair & wire brush the wire base frame as necessary, then spray with aerosol black paint. (As with the squab frame, in a well ventilated area.)



B3) Take the lower base foam from your new SF 105 Base Foam Kit
(The arrow shows the front of the foam)



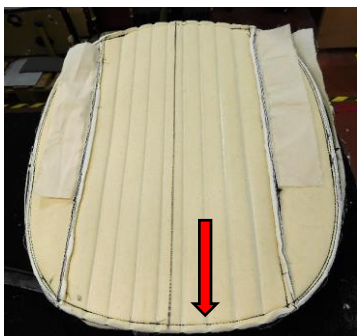
B4) Using a Ruler & Marker Pen, find the middle of the centre flute at the rear of the underside of the cover.



B5) Similarly, mark the middle at the front of the middle flute.



B6) Using a long straight edge, draw a line along the centre of the middle flute.



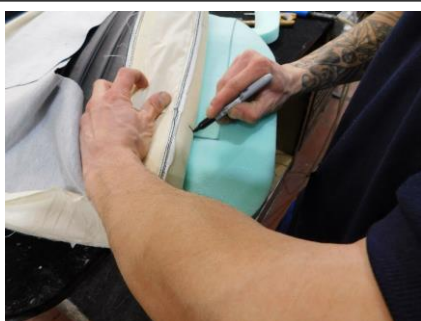
B7) Viewed from underneath, your cover will look like this.
(The arrow shows the front of the cover)



B8) With the cover inside out, lay the cover over the base foam (Front edge to front edge) make sure that all edges are level & check that the marked centre lines are in alignment.



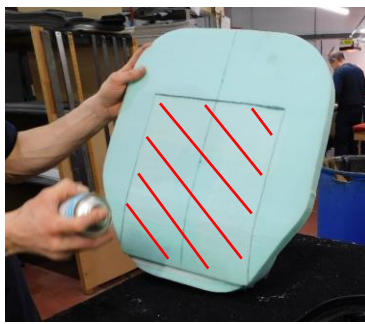
B9) Fold back at both sides & mark on each side of the fluted area where the front line across the base foam meets the cover.



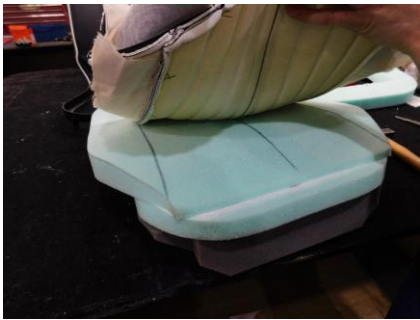
B10) Join these two marks using a marker pen & Ruler.



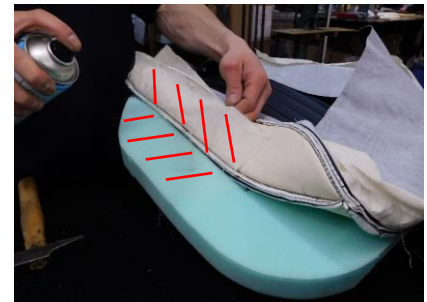
B11) Spray glue on the back of the fluted area of the cover up to the line and on the centre area on top of the base foam, to the marked lines. Where shown by the red hatch lines in the pictures above.



B12) Starting at the front of the glued areas, place the cover carefully on the foam



B13) Line up the centre lines & the piped edges with the outside lines, then press down firmly so that cover is fixed to the base foam within the marked lines.



B14) Fold back each side, lift the calico flap & spray glue the underside of the flap & the corresponding area on the foam. (As shown in red above)



B15) Press the flaps down onto the foam. No creases.



B16) Trim off any calico overhang.



B17) Next we attach the Top Roll (Part of the SF105 Foam Kit) On the flat underside, spray glue the area shown above. This is under the front roll.



B18) Lift the base cover away from the side & front roll areas, exposing the base foam. Spray glue across the front of the base foam



B19) Carefully position the Top Roll foam in place over the front of the Base foam with the front of the Seat Cover lifted up. Out of the way. Make sure the back edge of the roll aligns with the line marked across the front of the base pad & that all outside edges line up. When satisfied that all is well, press firmly together.



B20) Pull the seat cover forward so that the flutes lay over the front roll.



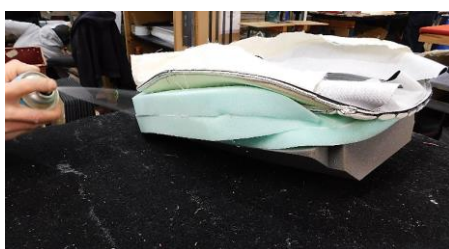
B21) Fold the sides of the cover inwards, away from the side roll foam. Lift the foam upwards & spray glue the base foam/ calico & the under side of the side roll foam. Repeat for other side.



B22) Push the side roll foam up against the edge of the calico on it's inside face & align the outer edges of the roll foam & base foam. Repeat for other side.



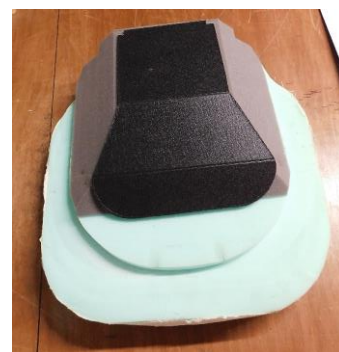
B23) Lightly spray glue the outer calico flap & then the outer vertical sides and front of the base foam/roll foam.



B24) Carefully pull the calico flap out and over the edge of the foam assembly, pulling out creases as you go.



B25) Trim off any excess calico at the rear edges & your result should be as shown above.



B26) Take the Board Stiffener from your Foam Kit SF105, fold it to shape at the creases & place over the base foam.



B27) Place the wire frame centrally over the base foam.



B28) Holding the frame in place, turn the assembly over, fold the rear side skirts over the sides of the assembly – as shown above right.





B29) Turn the assembly upside down. Pull the side skirts over the (Now upper) wire frame member and hog ring in place over the wire. Complete both sides, do not pull too tightly, just enough to hold the piping correctly at both sides. Check after two hog rings at each side.



B30) Fold the rear flap over the edge of the base foam & wire frame. Hog ring in place – Do NOT pull too tight.



B31) Turn the assembly upright. The back should look like this, with the flutes just rolling over the back edge of the base.



B32) Carefully roll the front skirt forwards over the front roll.



B33) Your base assembly will now look like this. This assembly is now ready for fitting to the rest of the seat.



B34) Lay the Squab assembly on its back & push the base assembly into place. Make sure the rear of the wire frame sit firmly onto the main frame & fully to the back, against the lower squab.



B35) The wire frame will sit inside the main frame all round. Pull the front skirt over the main frame.



B36) Turn the seat over. Clip the front skirt to the main frame.



B37) Slit (use scissors) the skirt so that it reveals the front frame legs & can be folded & clipped all round.



B38) With front skirt fully clipped in place the seat will look like this.



Your seat is now complete & ready to be fitted into your car.