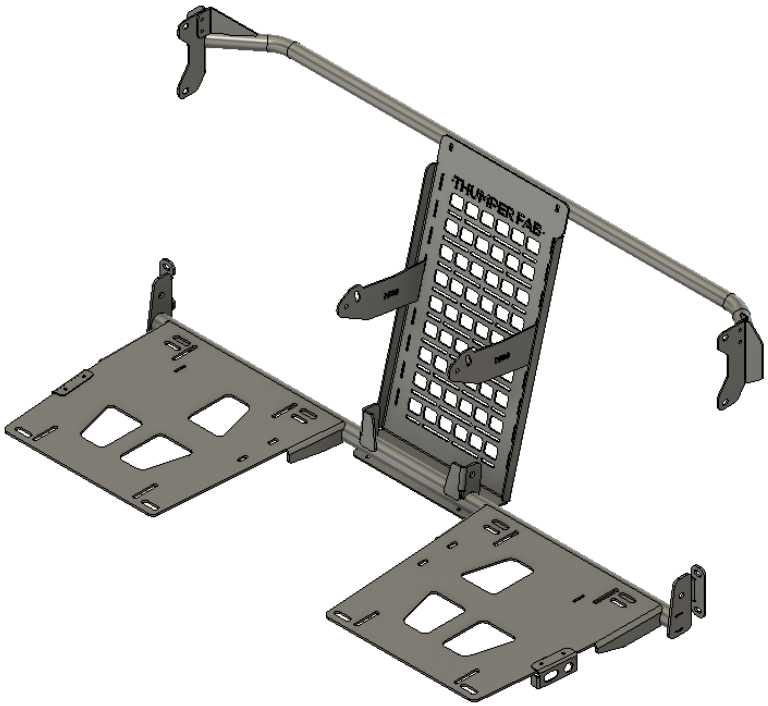
THUMPER FAB

Aluminum Audio Roofs • Roll Cages • UTV Accessories

Ranger 1500 XD
Seat Mount Kit

SKU: TF233201



Thumper Fab
5103 Elysian Fields Rd, Marshall, TX 75672
Customer Service: 903-472-0928

Ranger 1500 XD
Seat Mount Kit
SKU: TF233201

PARTS

REF	QTY	DESCRIPTION
1	1	Seat Mount Frame
2	1	Harness Bar Frame
3	1	Center Console Main Mount
4	2	Center Console Side Mount
5	1	Console Mount - Backing Plate
6	1	Seat Sensor Block Off Plate
7	2	Seat Switch Panel
8	1	Wiring Harness

TOOLS

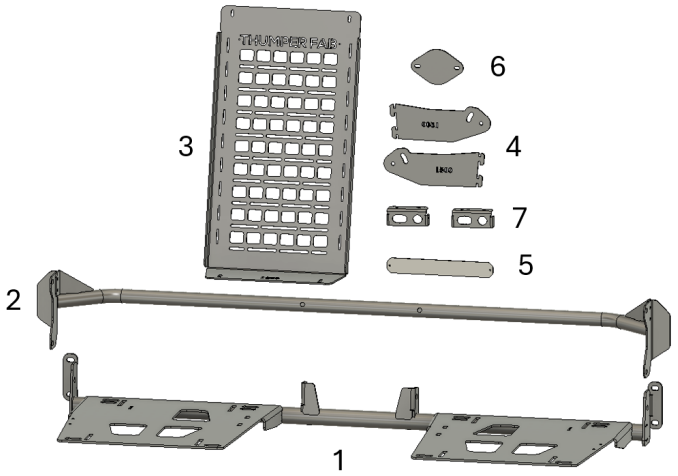
- 10mm Socket and Wrench
- 13mm Socket and Wrench
- 15mm Socket and Wrench
- 16mm Socket and Wrench
- 18mm Socket and Wrench
- Grinder with Flap Disc
- Reciprocating Saw
- Black Touch-Up Paint
- T30 Torx
- T40 Torx
- Drill
- Fire Proof Blanket

BEFORE YOU BEGIN

If you do not feel comfortable installing your **Thumper Fab** Seat Mount Kit, please see your nearest Thumper Fab® Dealer for installation.

Torque Specs:

SIZE (STANDARD)	GRADE 5	GRADE 8	SIZE (METRIC)	CLASS 8.8	CLASS 10.9
5/16"	15 ft/lbs	20 ft/lbs	6MM	5 ft/lbs	9 ft/lbs
3/8"	30 ft/lbs	35 ft/lbs	8MM	18 ft/lbs	23 ft/lbs
7/16"	45 ft/lbs	60 ft/lbs	10MM	32 ft/lbs	45 ft/lbs
1/2"	65 ft/lbs	90 ft/lbs	12MM	55 ft/lbs	75 ft/lbs
9/16"	95 ft/lbs	130 ft/lbs	14MM	85 ft/lbs	120 ft/lbs
5/8"	135 ft/lbs	175 ft/lbs	16MM	130 ft/lbs	165 ft/lbs
3/4"	185 ft/lbs	280 ft/lbs	18MM	170 ft/lbs	240 ft/lbs



Ranger 1500 XD
Seat Mount Kit
SKU: TF233201

PARTS

REF	QTY	HARDWARE KIT
A	2	#8 Nylon Lock Nut
B	2	#8x1/2” Socket Cap Screw
C	4	M6x20mm Flange Head Bolt
D	4	M6x20mm Button Flange Screw
E	2	M6x30mm Flange Head Bolt
F	6	M6 Flange Nylon Lock Nuts
G	8	M8x25mm Carriage Bolt
H	2	M8x30mm Flange Head Bolt
I	4	M8x80mm Flange Head Bolt
J	8	M8 Flange Nylon Lock Nut
K	4	M12x30mm Flange Head Bolt
L	4	M12 Flange Nylon Lock Nut
M	4	Spacers
N	1	Junction Block
O	1	5/16” Terminal Covers
P	8	1/4” Ring Terminals 16-14 AWG
Q	8	Butt Connectors 16-14 AWG
R	2	1/8” Rivets
S	5	Push Mount Zip Ties

Ranger 1500 XD
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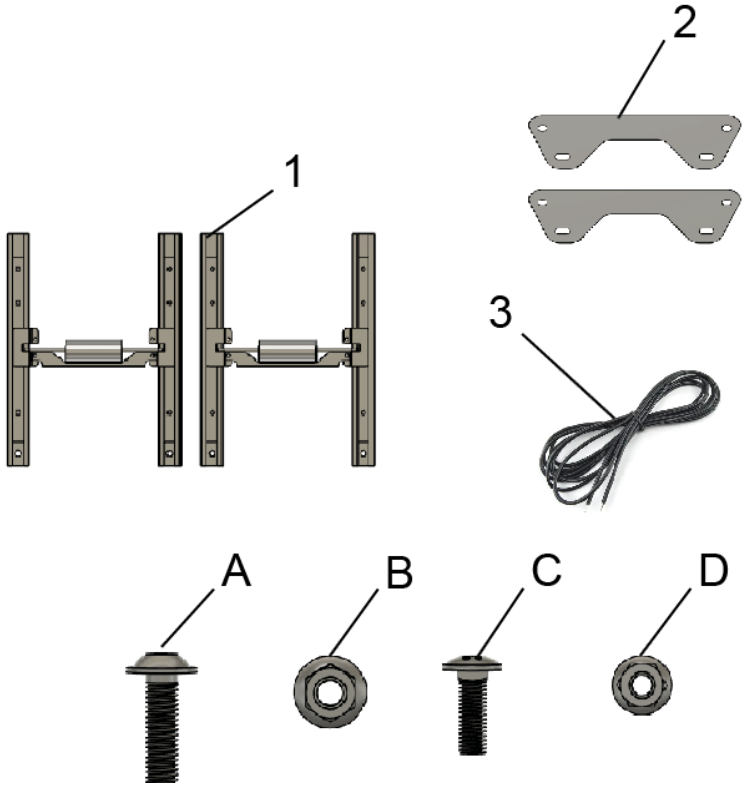
HARDWARE



Ranger 1500 XD
OPTIONAL-SEATMOUNT-ELECTRICSLIDERKIT
SKU: TF233202

PARTS

REF	QTY	DESCRIPTION
1	2	Electric Seat Slider Mount
2	2	Adapter Plate
		HARDWARE KIT
A	8	M10x35mm Long, Flanged Button Head Screws
B	8	M10 Flanged Locknuts
C	4	M8x25mm Long, Carriage Bolts
D	12	M8 Flanged Locknuts



Installation Preperation

Begin by removing the front seats out of the vehicle. To remove, start with the passenger seat, flip up and use a 13mm socket to remove the seat frame mounting bolts that fasten to the center underseat console (**FIG 1**).



FIG 1 - Remove passenger seat frame OEM bolts

Remove remaining bolts that fasten the seat frame to the center underseat console (**FIG 2**).



FIG 2 - Remove remaining seat frame OEM mounting bolts under the front seat

Installation Preperation

Remove the seat mount frame hardware that fastens the frame to the B-Pillars using a 15mm socket. Save the hardware as it will be reused during installtion (**FIG 3**).



FIG 3 - Remove seat frame mount bolts from B-Pillar

Disconnect the front seat belt upper assemblies from the OEM harness bar using an 18mm socket and an 18mm wrench (**FIG 4 & FIG 5**).





FIG 4 & 5 - Remove the front seat belt assemblies

Installation Preperation

Remove the plastic covers from the center seat belt to gain access to the mounting hardware (**FIG 6**).



FIG 6 - Remove center seat belt upper plastic covers

Unplug the seat belts, seat sensor, and other wires from under the seat frame (**FIG 7**).



FIG 7 - Unplug the electrical connectors under the front seat frame

Installation Preperation

Remove center seat belt mounting hardware using an 18mm socket and wrench (**FIG 8**).



FIG 8 - Remove center seat belt upper mounting hardware

Fully remove the front seat belts and the seat belt retractors from the vehicle (**FIG 9**).



FIG 9 - Remove the front seat belts from the vehicle

Installation Preperation

Place a fire blanket inside the vehicle to prevent any sparks from burning the interior. Use the reciprocating saw to cut off the OEM harness tube and the upper seat belt mounting brackets located near the top of the B-Pillars (**FIG 10 & FIG 11**).



FIG 10 - Cut the harness tube at the B-Pillar using a reciprocating saw



FIG 11 - Cut the upper seat belt mounts at the B-Pillar

Installation Preperation

The closer you are able to cut the harness bar and the upper seat belt mounts to the B-Pillar, the less grinding will have to be done for a smooth finish (**FIG 12 & FIG 13**).





FIG 12 & 13 - Cut the harness tube and seat belt mount as close to the B-Pillar using a reciprocating saw

Use a grinder with a flap disk to grind the remainder of the OEM harness bar and upper seat belt mount brackets flat with the B-Pillar (**FIG 14 & FIG 15**).





FIG 14 & 15 - Grind the remaining harness bar and seat belt upper mount brackets flush with B-Pillar

Installation Preperation

Once the B-Pillar is ground flat and smooth, use black touch up paint to cover any bare metal and prevent any rusting in the area (**FIG 16 & FIG 17**).



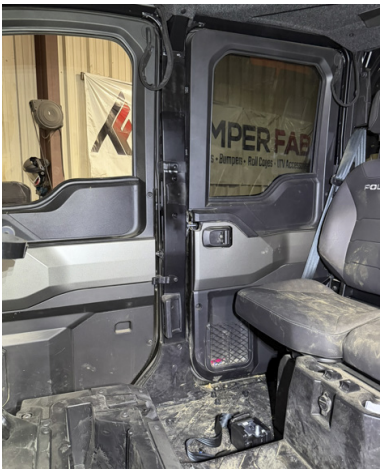


FIG 16 & FIG 17 - Use touch up paint on the bare metal locations of the B-Pillar

Locate the driver side seat belt wiring harness and plug in the seat belt bypass harness (**FIG 18 & FIG 19**).





FIG 18 & 19 - Locate the driver side seat belt female plug on the drivers seat belt latch and cut with 6 inches of wire remaining

Installation Preperation

Unmount the driver side seat base from the front seat assembly and take the bottom section of the seat off to expose the seat sensor by pressing down on the tab below (**FIG 20 & FIG 21**).

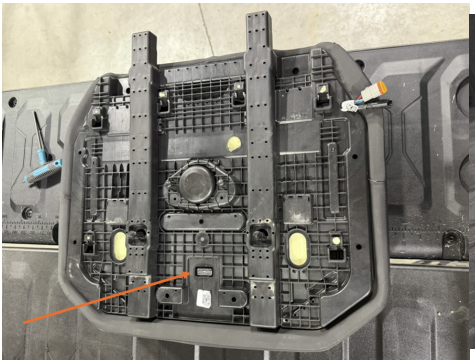
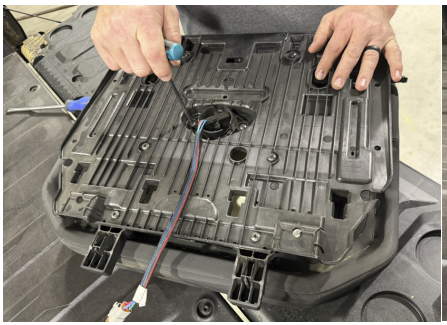




FIG 20 & FIG 21 - Use touch up paint on the bare metal locations of the B-Pillar

Remove the seat sensor from the underside of the seat using a T30 Torx (**FIG 22 & FIG 23**).



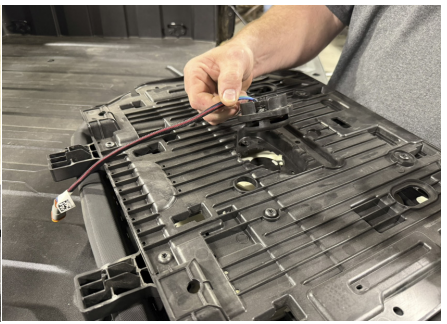


FIG 22 & 23 - Remove the seat sensor from the driver side seat base

Installation Preperation

Fasten the seat sensor block off plate to the seat sensor using 2 x M6x30mm flange head bolts and 2 x M6 flange nylon lock nuts. Loosley tighten using a 10mm socket and wrench (**FIG 24 & FIG 25**).



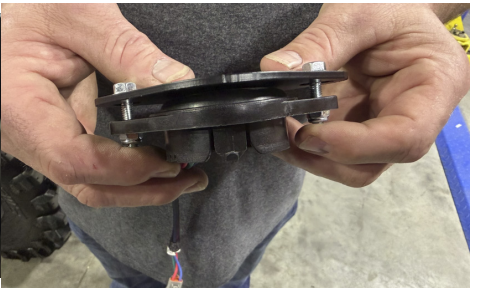


FIG 24 & FIG 25 - Fasten the Seat Sensor Block off Plate to Sensor

Remove the under seat cubby using a T40 Torx and set aside to be reinstalled in a later step (**FIG 26 & FIG 27**).





FIG 26 & 27 - Remove the under seat cubby

Installation Preperation

Slide the under seat wiring harness into the hole in the under seat plastic panel. Once the harness is inside the panel, plug in the seat sensor and zip tie up on inside of cubby (**FIG 28 & FIG 29**).



FIG 28 & FIG 29 - Plug in Seat Sensor

Remove the driveline tunnel in the front of the cab using a T25 and a T40 Torx. Once the tunnel has been lifted slightly, disconnect the HVAC ducting that runs to the rear of the cab to be able to remove the tunnel from the vehicle fully (**FIG 30 & FIG 31**).



FIG 30 & 31 - Remove the front driveline tunnel

Installation Preperation

Route the wiring harness provided with the kit from the hood of the vehicle to into the cab, zip tie along the way to the OEM harness being careful to avoid any hot or rotating components. Bundle the harness up and zip tie neatly on the inside of the plastic cubby (**FIG 32 & FIG 33**).



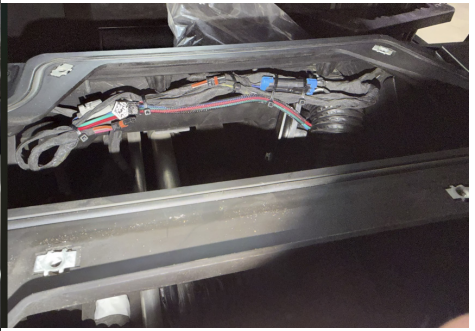


FIG 32 & FIG 33 - Route harness to inside seat cubby and zip tie wires together

Use the junction block as a template to drill holes in the under seat cubby. Once drilled, attach the seat heater harness and optionally the seat slider harnesses to the junction block (**FIG 34 & FIG 35**).



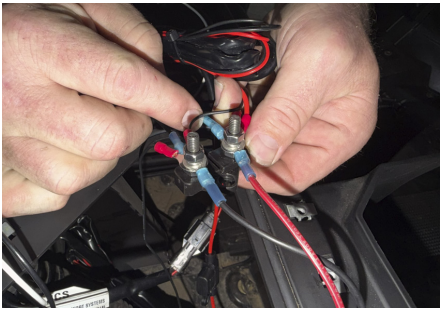


FIG 34 & 35 - Drill holes for junction block and attach seat heater and optionally electric slider harness (If slider option was selected)

Installation Preperation

Slide the 5/16” terminal covers over the posts on the junction block. Fasten the junction block to the inside of the underseat cubby using 2 x #8x1/2” socket cap screws and 2 x #8 nylon lock nuts (**FIG 36 & FIG 37**).

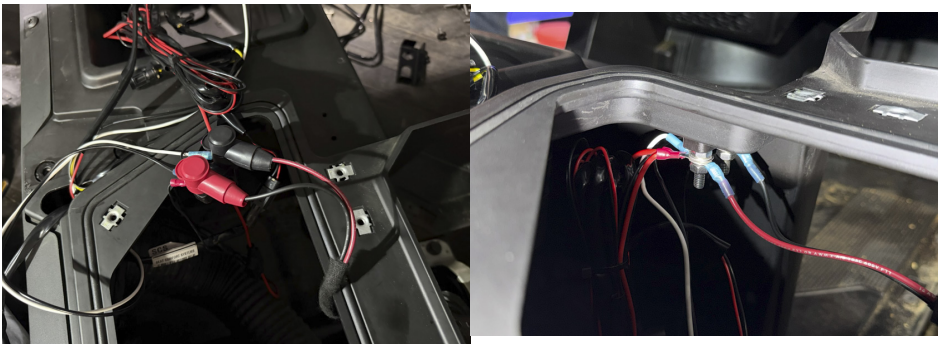


FIG 36 & FIG 37 - Fasten junction block to inside of under seat cubby

Tie up the excess harness from the seat heaters and electric seat sliders. Once all wiring is routed to the junction block, zip tie the main harness from under the hood in position away from the driveline and coolant lines. Reinstall the front driveline tunnel and the underseat cubby (**FIG 38 & FIG 39**).



FIG 38 & 39 - Tie up wires and reinstall front driveline tunnel

Installation Preperation

Plug the harness into the pulse bar located under the hood. Fasten the seat switch panel to the seat mount frame using 4 x M6x20mm button flange screws and 4 x M6 flange nylon lock nuts (**FIG 40 & FIG 41**).

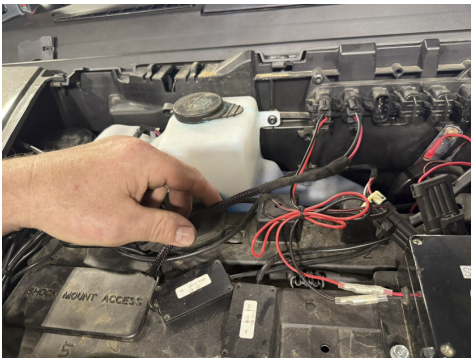




FIG 40 & FIG 41 - Plug the harness into the pulse bar and fasten the seat switch panel to the seat mount frame

Fasten the seat frame to the frame of the vehicle using the OEM hardware. Loosley tighten using a 15mm socket (**FIG 42 & FIG 43**).

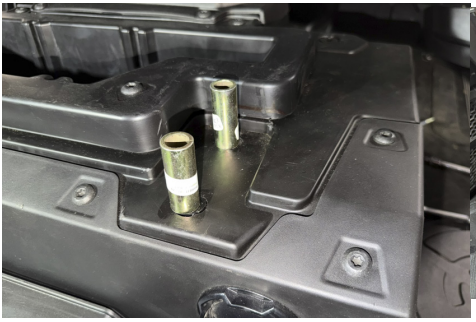




FIG 42 & 43 - Fasten the seat frame to the vehicle

Installation Preperation

Fasten the center of the seat frame to the vehicle by sliding the spacers under the welded seat frame and use the 4 x M8x80mm flange head bolts to secure the center of the seat frame to the vehicle. Tighten using a 13mm socket (**FIG 44 & FIG 45**).



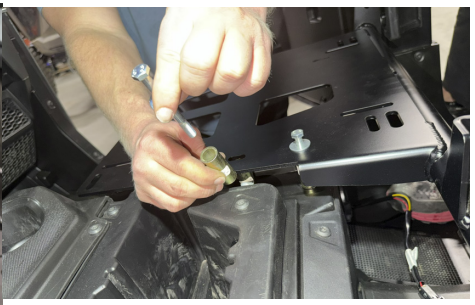


FIG 44 & FIG 45 - Fasten the center of the Seat Frame to the vehicle

Now, you can pre-assemble and install the electric seat slider mounts, if you have purchased those as well. First start the pre-assemby as shown below. First, adjust the sliders so that both mount holes are exposed. Use the cable in the from the motor assembly in the slider kit and a drill to adjust them (**FIG 46 & FIG 47**).





FIG 46 & 47 - Seat Slider assmebly process

Installation Preperation

Next, remove the button head screw to be reused in mounting of the motor assembly. Assemble both sliders and the motor with cables as shown below using the button head screws removed previously (**FIG 48-FIG 50**).



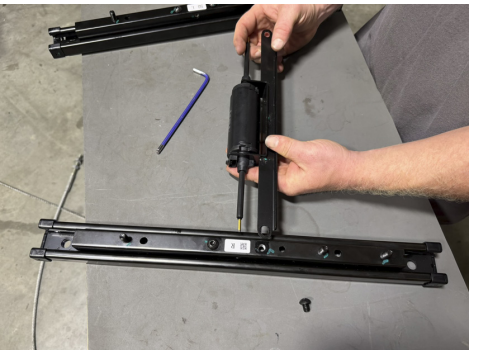




FIG 48-50 - Seat Slider assmebly process

Installation Preperation

If the seat slider option was selected, fasten the seat sliders to the seat frame using 8 x M10x35mm flange button head screws and 8 x M10 flange nylon lock nuts. Tighten the adapter plate to the seat slider using 4 x M8 flange nylon lock nuts (**FIG 51 & FIG 52**).



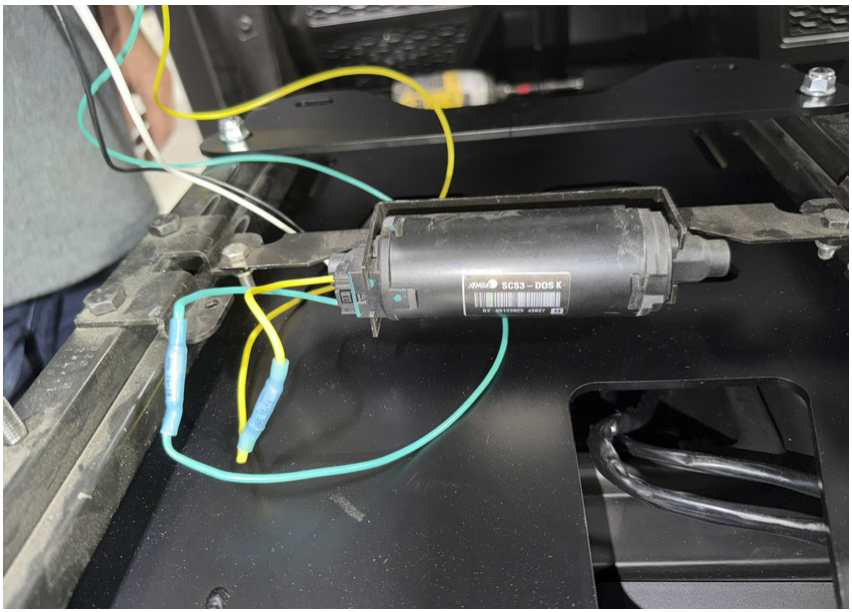


FIG 51 & 52 - Fasten the seat slider to the welded seat frame

Installation Preperation

Slide the electric slider harness switch and the seat heater switch through the seat switch panel (**FIG 53 & FIG 54**).



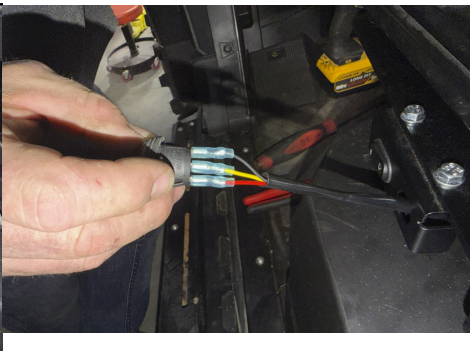


FIG 53 & FIG 54 - Slide the switches into the switch seat panel

Connect the seat heaters to the harness underneath the seat and fasten the seat to the seat slider (if slider was selected) using 8 x M8x25mm carriage bolts and 8 x M8 flange nylon lock nuts (**FIG 55 & FIG 56**).





FIG 55 & 56 - Plug in the seat heaters and fasten the seat to the seat sliders

Installation

If the seat slider option was not selected, the harness bar is installed before the seat so the seat is positioned in a spot that will not contact the harness bar. Remove and reinstall the 4 x OEM bolts that slide through the B-Pillars. Use the fasteners to mount the harness bar (**FIG 57**).



FIG 57 - Mount the Harness Bar

Drill 1/4” holes in the rear of the underseat cubby and use the push mount zip ties to fasten the seat heater harness to the rear of the underseat console (**FIG 58 & FIG 59**).





FIG 58 & 59 - Fasten the seat heater harness to the underseat cubby

Installation

Fasten the seat to the seat frame using 8 x M8x25mm carriage bolts and 8 x M8 flange nylon lock nuts. Once seat is in a position that is desirable, tighten using a 13mm socket (**FIG 60**).



FIG 60 - Mount the Seat (If slider option was not selected)

Remove the mounting hardware from the center console using a 13mm socket. Fasten the center console side mounts to the center console using 2 x M8x30mm flange head bolts (**FIG 61 & FIG 62**).





FIG 61 & 62 - Fasten the center console side mounts to the center console

Installation

Fasten the console mount - backing plate to the center console main mount using 2 x rivets and a rivet gun (**FIG 63**).



FIG 63 - Mount the backing plate to the center console main mount

Fasten the center console main mount to the harness bar and the seat frame using 4 x M6x20mm flange head bolts. Tighten using a 10mm socket and wrench. Slide the tabs of the center console side mounts into the vertical slots in the center console main mounts. Adjust as needed (**FIG 64 & FIG 65**).





FIG 64 & 65 - Fasten the center console main mount to the harness bar and the seat frame

Installation

Fasten the harness to the seat belt tabs located on the seat frame using the 4 x M12x30mm flange head bolts and 4 x M12 flange nylon lock nuts (**FIG 66 & FIG 67**).



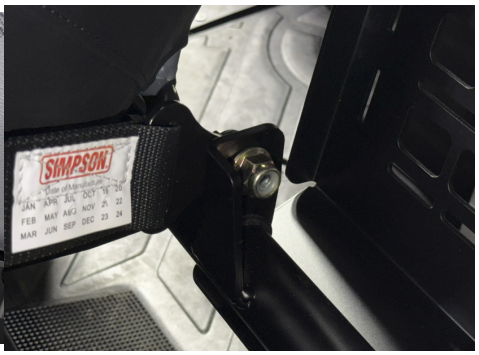


FIG 66 & FIG 67 - Fasten the seat belt harnesses to the seat frame

Wrap the harnesses around the harness bar, adjust them as needed to have them ride properly on your shoulders (**FIG 68**).



FIG 68 - Fasten the harnesses to the harness bar

PRODUCT DISCLAIMER

The installation of products sold or manufactured by Thumper Fabrication, LLC (Thumper Fab) including, but not limited to suspension components such as lift kits, audio roofs, roll cages, frame stiffener kits, and tires that exceed the original specifications for the vehicle, may change the vehicle's center of gravity and handling characteristics both on- and off-road. You are aware that the installation of tires that are larger than original vehicle specifications may reduce the effectiveness of the braking system. Use of these products may place added stress to the original factory vehicle components which could cause them to weaken or possibly fail.

Products sold or manufactured by Thumper Fab are intended for off-road use only. Operation of a vehicle modified with these products on a road could result in serious bodily injury or death, and such operation may violate the laws of your state or municipality. You agree to operate your vehicle exclusively in the manner intended by the vehicle manufacturer. You agree that failure to safely and reasonably operate your vehicle could result in serious bodily injury or death, and that, as a result of installation of this product(s) to your vehicle, extreme care must be taken to prevent vehicle rollover or loss of control, which may be more likely to occur as a result of said modifications. You will avoid unsafe maneuvers, including sudden sharp turns or other abrupt maneuvers, which could make a vehicular accident more likely. You understand that Thumper Fab is not responsible or liable for any damages or any injuries to yourself or your passengers that could occur upon possible accidents due to driver error, incorrect installations, bad judgment, incompatibility with other aftermarket accessories or natural disasters to the fullest extent allowable by law. You will have all vehicle occupants fasten seatbelts, if equipped, and wear proper safety equipment, such as DOT approved helmet and eye protection prior to operating the vehicle. You understand and acknowledge that failure to wear proper safety equipment may increase the risk of serious bodily injury or death to yourself and any passengers.

Proper installation of products sold or manufactured by Thumper Fab requires knowledge of the factory recommended procedures for removal and installation of original equipment components. Installation of these products without proper knowledge and experience may affect the performance of these components and the safety of the vehicle and cause serious bodily injury or death. It is strongly recommended that a certified mechanic familiar with the installation of similar components perform the product(s) installation.

Prior to installing any products sold or manufactured by Thumper Fab, you will perform or cause to be performed an inspection of their vehicle to confirm its condition is suitable for the installation of these products. A proper inspection of the vehicle includes confirmation that the vehicle has not been in a collision and is free of corrosion. If the vehicle is suspected to have been in a collision or misused, or is otherwise unsuitable for modification, you will not install the product(s). You will continue to inspect the vehicle prior to each use to confirm its condition is suitable for its intended use, and you acknowledge that the failure to do so may result in serious bodily injury or death, as well as damage to the vehicle itself.

You will install any warning labels provided with the product so it may be prominently seen by yourself and all passengers. You will notify all passengers of the modifications performed to your vehicle prior to operation.

Insurance companies may handle coverage of a modified vehicle differently. Please check with your insurance carrier prior to modifying the vehicle to ensure your coverage remains sufficient. Installation of this product(s) may void your vehicle warranty. If this is a concern, please check with the manufacturer or dealer before purchase or installation of this product(s).



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