



Installation Guide

Installation Instructions to Assemble New and Replacement Armrests on Milsco XB200 Seat (also works for XC180)

MILSCO KIT# C746700 INCLUDES:

1. One LH Armrest Assembly with Bracket
2. One RH Armrest Assembly with Bracket
3. Six Speed Nuts - 1/4-14
4. Six Self-Tapping Screws - 1/4-14 x 1"

MILSCO KIT# C746702 INCLUDES (K&M does not carry):

1. One RH Armrest Assembly with Bracket
2. Three Speed Nuts - 1/4-14
3. Three Self-Tapping Screws - 1/4-14 x 1"

TOOLS REQUIRED:

1. 3/8" Socket with Ratchet or Power Drive
2. 16mm Wrench
3. 17mm Wrench
4. 5/8" Socket with Extension & Driver

NOTE: This armrest assembly fits the Milsco XB200 Seat (also fits the Milsco XC180, but K&M does not carry the XC180). Check to ensure you have the correct seat. If the seat bottom is visible, there is a Milsco Name block molded in the plastic shell displaying the words Type XB-200 or Type XC-180.

NEW INSTALLATION PROCEDURE:

1. Fit three speed nuts into recessed areas as shown in Fig. 1. The outside surface of the shell has screw starts molded in. These screw starts are to line up with the hole center of the speed nut. The flat surface of the speed nut needs to be on the outside of the shell, and the threaded surface of the speed nut needs to be between the cushion and the shell. If there is glue on the shell surface in the speed nut recessed area, break it free from the shell with a sharp instrument (knife, flat bladed screw driver, or wood chisel with flat side to shell). This is to allow the speed nut to be fully seated.
2. Locate the proper arm assembly for one side of the seat. The proper arm assembly will not hit the cushion in its full range of motion. Hang the arm by starting the center screw into the shell, but do not tighten.
3. Install the top and bottom screws snugly (60 +/-10 in.lbs.). Now tighten the center screw snugly. **Do not over tighten.**

CAUTION:

As with servicing any product; certain hazards exist. Use caution and common sense when using hand tools, and servicing this product.

ALWAYS WEAR SAFETY GLASSES.

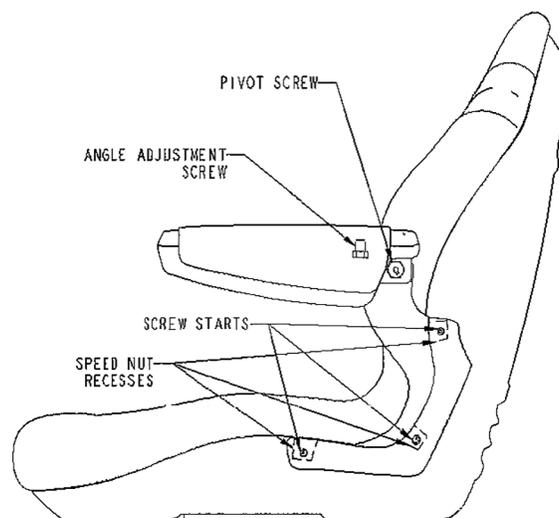


Figure 1

4. Repeat procedure for opposite side armrest (also for kit# C746700, which K&M does not carry).
5. Check the amount of force required to stow the arms upward and bring it down to the in-use position. Adjust the force to personal preference using the 16 & 17mm wrenches on the armrest pivot bolt.
6. Set the in-use position/elevation by adjusting the screw located in the bottom of the armrest. It is visible when the armrest is in the stowed (up) position. Use a 5/8" socket with an extension and driver.

ARM REPLACEMENT PROCEDURE:

1. Remove and discard the old arms, brackets, and hardware.
2. Follow steps 1 through 6 of the New Installation Procedure. Torque mounting screws to 60 +/-10 in.lbs. **Do not over tighten.**