

Subject

FRONT DOOR REPLACEMENT WINDOW REGULATOR ADAPTOR KIT

Model: S-TYPE

Year: 1999 to 2002

VIN L00601 to M45255

Section: 501

Body Systems

Sub-Section: 501-25A

Body Repairs-General Information

Summary

When installing a new front door to vehicles built prior to VIN M45255, an adaptor kit is required to enable fitment of the early type window regulator.

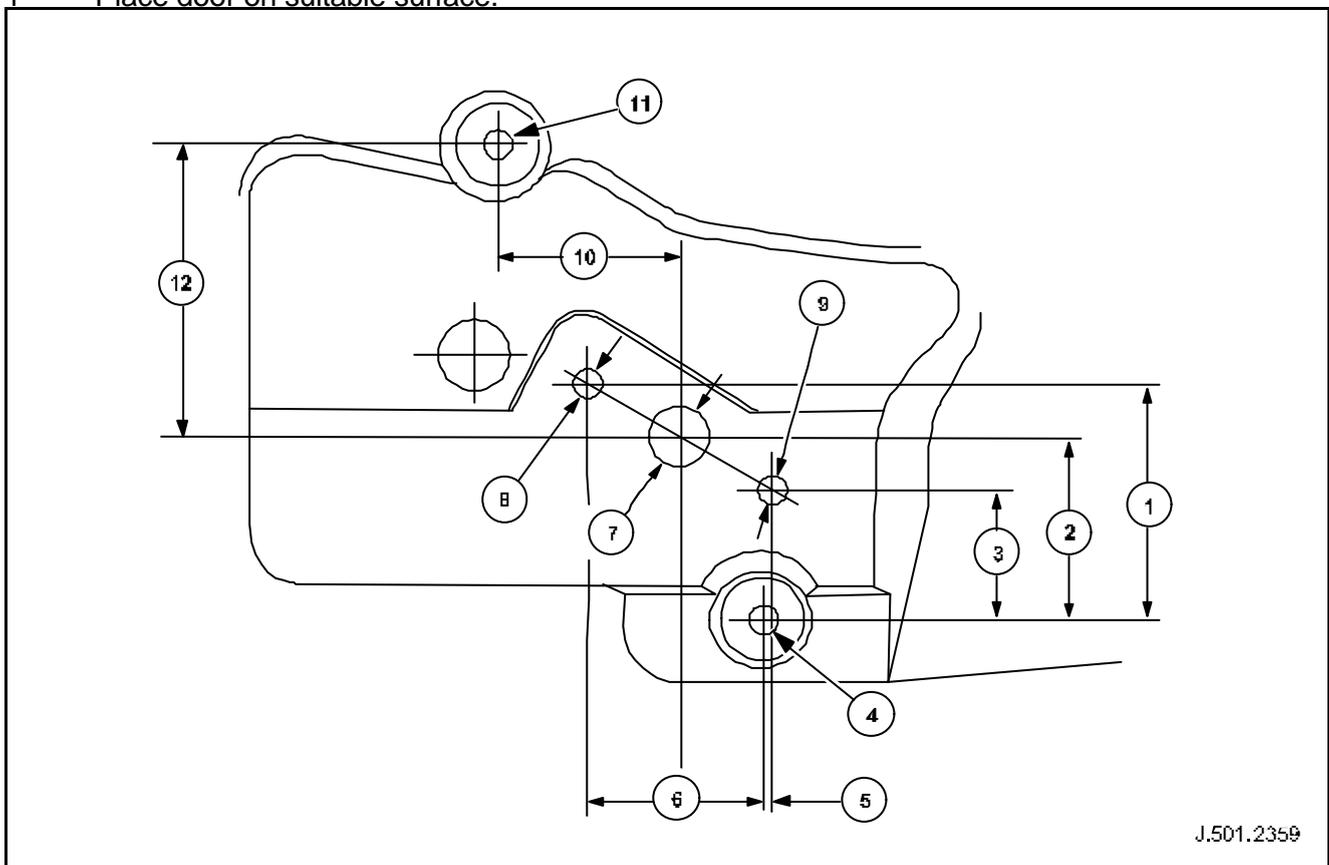
Action

To install the window regulator adaptor kit to the new front door, follow the workshop procedure outlined below.

Workshop Procedure

Note: Steps 1 to 7 are prior to painting new door.

1 Place door on suitable surface.



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Fig. 1 right hand

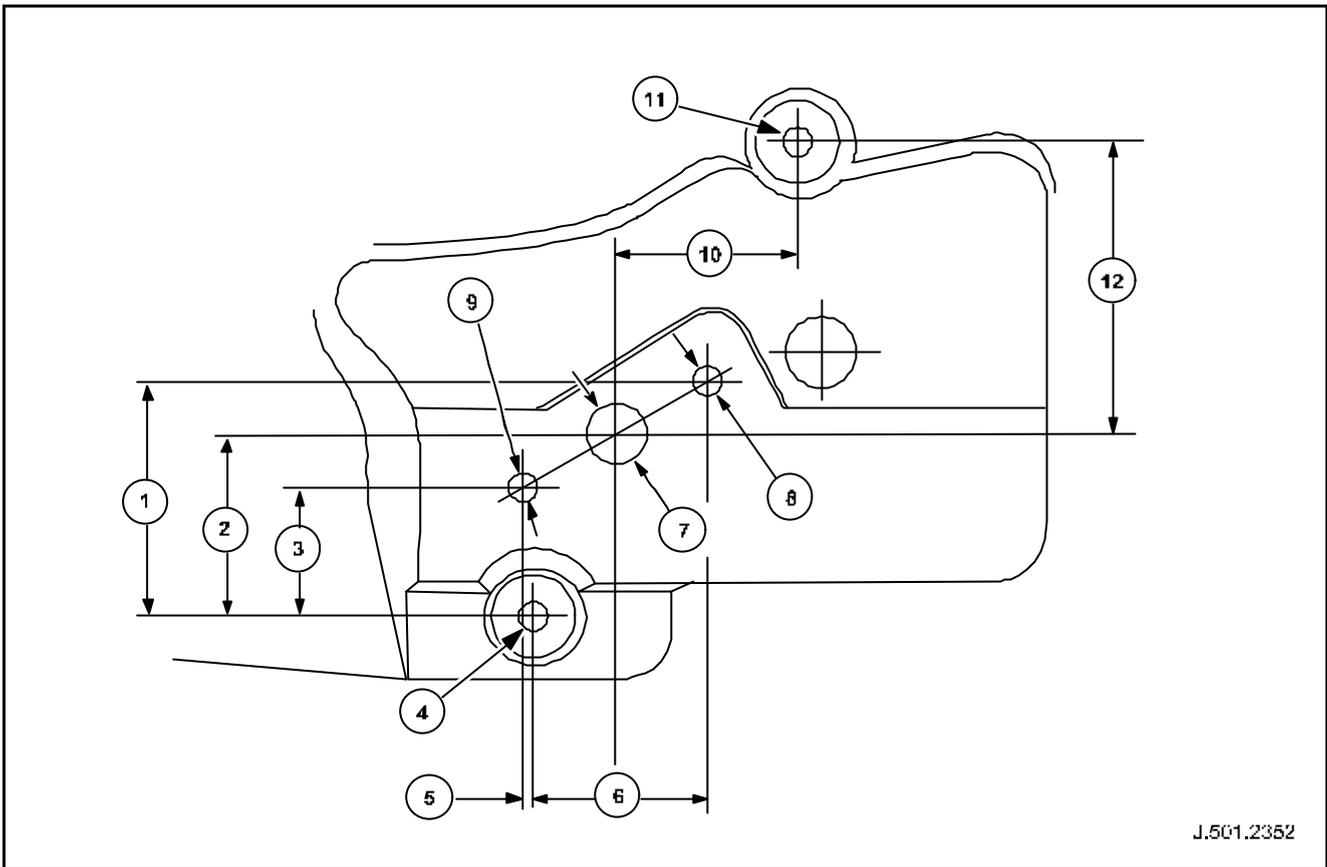


Fig.2 left hand

Dimensions in Fig. 1 and Fig. 2

1 = 83mm vertical
 5 = 3mm lateral
 12 = 102.5mm vertical

2 = 64mm vertical
 6 = 62mm lateral

3 = 45.5mm vertical
 10 = 65mm lateral

Measure and mark positions of three holes to be drilled.**Pilot hole 7.**

- Measure 65mm from center of hole 11 as indicated at 10 Fig. 1 and 2.
- Measure 102.5mm from center of hole 11 as indicated at 12 Fig. 1 and 2.

Pilot hole 8.

- Measure 83mm from center of hole 4 as indicated at 1 Fig. 1 and 2.
- Measure 62mm from center of hole 4 as indicated at 6 Fig. 1 and 2.

Pilot hole 9.

- Measure 45.5mm from center of hole 4 as indicated at 3 Fig. 1 and 2.
- Measure 3mm from center of hole 4 as indicated at 5 Fig. 1 and 2.

- Carefully center punch holes (7, 8 and 9) to be drilled at marked positions.
- Pilot drill three 3mm holes (7, 8 and 9).
- Using suitable hole saw, open out center pilot hole (7) to 20mm diameter.
- Using suitable drill, open out remaining pilot holes (8 and 9) to 8mm diameter.
- De-burr three drilled holes.
- Remove all drilling swarf.

Note: Apply suitable zinc enriched paint to bare metal surfaces created during process and allow to dry.

Note: Remainder of procedures to be completed after painting of door.

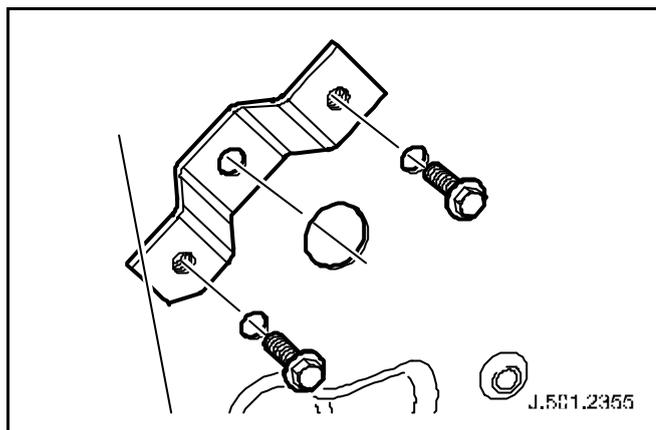


Fig. 3 left hand

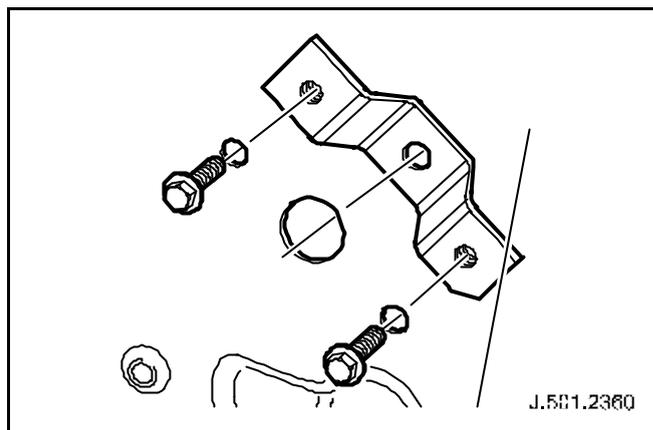


Fig. 4 right hand

8 Install bracket provided to the inside of the door (see Fig. 3 & 4).

Note: Chamfered corner of bracket to be positioned towards bottom of door.

9 Install but do not tighten bracket to door securing screws provided.

10 Install window regulator assembly.

11 Tighten bracket to door securing screws.

12 In turn, remove backing paper from adhesive patches.

13 Install 25mm diameter patches over holes 4 and 11 (see Fig. 1).

14 Install 50mm diameter patch over 20mm diameter drilled hole 7 (see Fig. 1).

Note: This parts/labor time cannot be claimed as warranty when the regulator support bracket is fitted to doors of cars undergoing an accident or similar repair.

Parts Information

The following parts must be ordered via Jaguar Cars Parts Operations (or through NSC/Importer).

| Description | Part Number | Quantity |
|---|-------------|----------|
| Window regulator adaptor kit (right hand) | XR8 38260 | 1 |
| Window regulator adaptor kit (left hand) | XR8 38261 | 1 |

Warranty Information

| Description | SRO | Labor Time Allowance | Warranty Code | Causal Part |
|---|----------|----------------------|---------------|-------------|
| Install window regulator adaptor kit (right hand) | 76 94 17 | 0.2 Hours | WD-CB-01 | XR8 38260 |
| Install window regulator adaptor kit (left hand) | 76 94 17 | 0.2 Hours | WD-KB-01 | XR8 38261 |