

INSTALLATION PROCEDURE

1. PANEL PREPARATION:

PREPARING PANELS FOR THE FLARED TYPE STRUCTURAL FASTENERS CAN EITHER BE ACCOMPLISHED WITH A STEP DRILL OR STANDARD DRILL AND COUNTERBORE OPERATION AS SHOWN IN FIGURE 1.

IF THE BOTTOM COVER SHEET EXCEEDS .032" THICK, AN ADDITIONAL EXTERNAL SPOTFACING OPERATION IS REQUIRED. SEE INSTALLATION DRILL SIZE TABLE FOR CORRECT DRILL, COUNTERBORE AND SPOTFACE DIAMETERS.

2. POSITION PANEL OVER ALIGNMENT TOOL WITH THE GUIDE ANVIL PROJECTING THROUGH THE PILOT HOLE. SEE FIGURE 2.

3. POSITION FASTENER IN PREPARED HOLE AND APPLY PRESSURE WITH THE PRESSING ANVIL UNTIL THE FASTENER HEAD BECOMES FLUSH WITH THE TOP SKIN. FIGURE 3.

4. REPLACE ALIGNMENT TOOL WITH FLARING ANVIL AND AGAIN APPLY PRESSURE WITH PRESSING ANVIL UNTIL FLARING ANVIL BECOMES FLUSH WITH THE BOTTOM SKIN. FIGURE 4.

5. AFTER INSTALLATION, THE 600 FLARED SERIES FASTENERS ARE SELF-RETAINED AND PROVIDE A FLUSH CONDITION ON THE EXTERIOR SURFACES WHEN USING THE "D" HEAD STYLE. SINCE THE HEAD DIAMETER OF THE FASTENER HAS THE GREATEST AREA OF CONTACT, IT MAY CAUSE A SLIGHT SPRING BACK CONDITION. HOWEVER, WHEN THE COMPONENT IS BOLTED DOWN TO THE PANEL, THE FASTENER WILL AGAIN BECOME FLUSH.

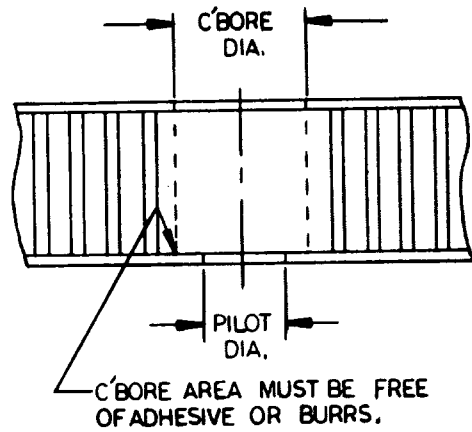


FIG. 1

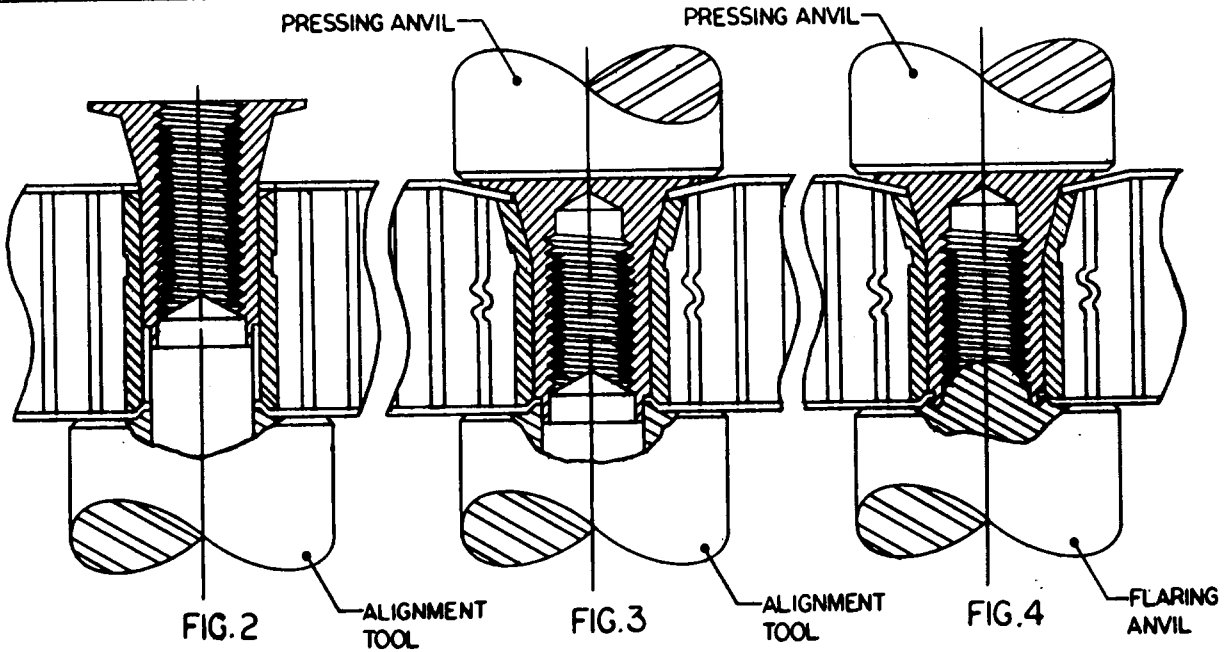


TABLE IV

SIZE CODE	INSTALLATION DRILL SIZE			INSTALLATION TOOL KIT
	PILOT DIA.	C'BORE DIA.	SPOTFACE DIA.	
1	.228-.233	.375-.385	.500	1632K2
2	.295-.300	.437-.447	.562	1632K4
3	.295-.300	.437-.447	.625	1632K4
4	.358-.363	.500-.510	.687	1632K5
5	.421-.426	.562-.572	.750	1632K6

DRAWING PROVIDES FORM, FIT AND FUNCTION DATA. DO NOT ATTEMPT TO MANUFACTURE PRODUCT USING THIS DRAWING.

Deltron <small>inserts</small>	
DRAWN BY: DAVE SATOW	DATE: 10-29-81
MPG. ENGRG:	DATE:
APPROVED BY: <i>[Signature]</i>	DATE: 8-20-82
PROJECT NUMBER:	

TITLE: **FASTENER INSTALLATION**

UNLESS OTHERWISE SPECIFIED:
 TOLERANCES: MILLIMETERS SURFACE FINISH
 DECIMALS: .XX ± .02 ± 0.80
 .XXX ± .010 ± 0.25
 ANGLES: ± 2°
 125 MICRONS

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606D FLARED SERIES

FSC: 29372 SHEET 4 OF 4

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