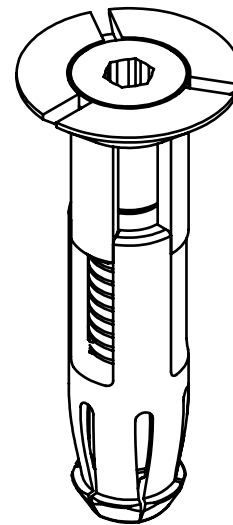


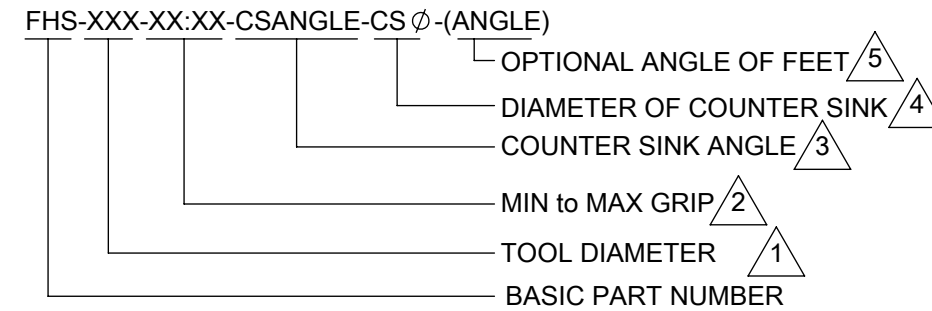
Note: when ordering, it is up to the user to determine the necessary diameter of the tool to achieve the desired fit.



FUNCTION OF TOOL:

=> USED TO TEMPORARILY CLAMP & ALIGN.

TOOL ORDERING CODE:



1 **TOOL DIAMETER (XXX)** specified by customer as a *custom diameter*. The Tool is manufactured to the custom diameter with typical tolerances of -0.001 to -0.003.

1 **DIAMETER requirements:** if TOOL DIAMETER is called out as a 3 PLACE number (XXX), then the tool is manufactured to the specified diameter. Nominal tool diameter tolerance is -0.001/-0.003 inch (see example tool code below).

2 **MINto MAX GRIP:** The tool is manufactured to be slightly less than the minimum grip required by the customer. Depending on the stroke of the temporary fastener, we will try to accommodate all of the grip ranges in one tool (i.e from MIN grip to MAX grip). If the tool is unable to reach to the MAX grip then additional fasteners will need to be produced to accomodate the different material stacks. Each temporary fastener is given a part number using the minimum grip (all fasteners are labelled with min grip and max grip).

3 **COUNTER SINK ANGLE:** Angle of the counter sink. (Typically 100°)

4 **DIAMETER OF COUNTERSINK:** Diameter of the countersink.

5 **Optional ANGLE callout:** Standard tool configuration is "ANGLE" on clamping feet = 180°, and will be provided if no ANGLE is called out. If the tool is to be used to clamp in a c'sink hole, or is to be used in other special requirements, then specify the desired angle (see detail view A) in the "(ANGLE)" space located in the part number (see example tool code below).

EXAMPLE ORDERING TOOL CODE:

Customer orders: FHS-312-.50-1.10-100°-.620
 => Tool manufactured diameter will be between ϕ 0.311 to ϕ 0.309 for nominal hole diameter of ϕ 312.
 => Tool will be made with a standard 100° countersink, that sits flush with the material at a counter sink ϕ of .620.
 => Angle on feet (see detail view A) will be 180° (default).
 => Tool's grip range will be from .5 inch to 1.2 inch. If this can not be accomadated with 1 tool then CENTRIX will break up the grip range into different tools. For Example the given grip range may require the following tools:

FHS-312-.50-100°-.620
 This tool has a diameter of ϕ 0.311 to ϕ 0.309 and grips material from 0.50" to 0.80". It has counter sink angle of 100° and sits flush with the material at a diameter of ϕ 0.620.

FHS-312-.80-100°-.620
 This tool has a diameter of ϕ 0.311 to ϕ 0.309 and grips material from 0.80" to 1.10". It has counter sink angle of 100° and sits flush with the material at a diameter of ϕ 0.620.

Assy drawing only

SCALE: 2:1 & NOTED

SHEET 1 of 1

FHS-XXX-XX:XX-CSANGLE-CS<MOD-D

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CENTRIX LLC

FHS-XXX-XX:XX-CSANGLE-CS φ -(ANGLE)

FLUSH BLIND TEMPORARY FASTENER

NOTES:

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