



Note:

If the crimped fixing falls into a hollow section when removed, inject wax to immobilise the residual fixing in the hollow section.

2. ASSEMBLY



(see 40H, Bolted connections, Screw connection with crimped mounting: Description)



Repair-40x01x34x14-01x22-1-1-1.xml



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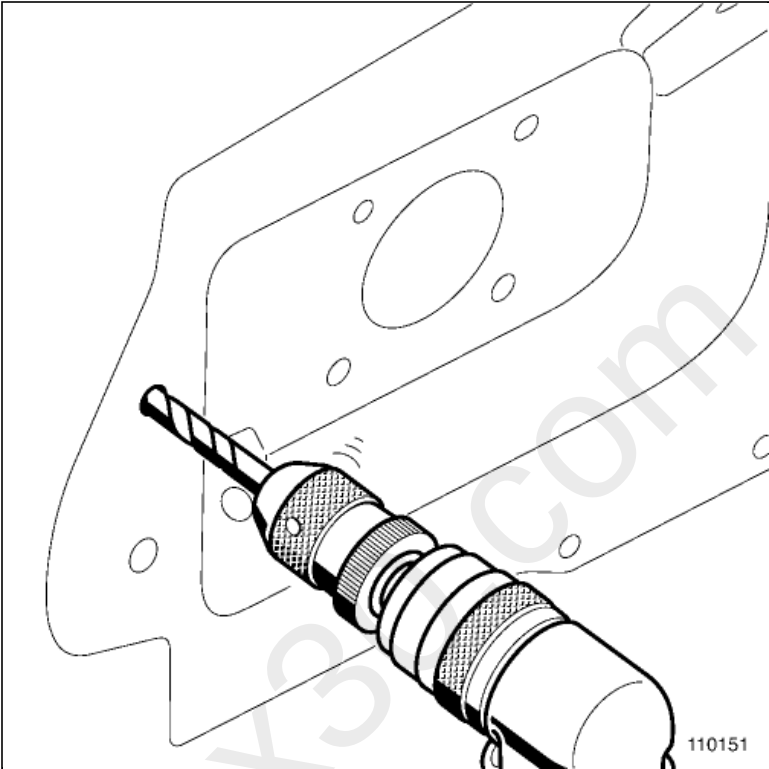
BOLTEDCONNECTIONWITHCRIMPEDMOUNTING

Special tooling required	
Tool for fitting crimped nuts.	Car. 1504



Note:
This operation cannot be carried out for an earth mounting; it does not guarantee the current will be properly conducted from the contact with the structure.

1. PREPARATION



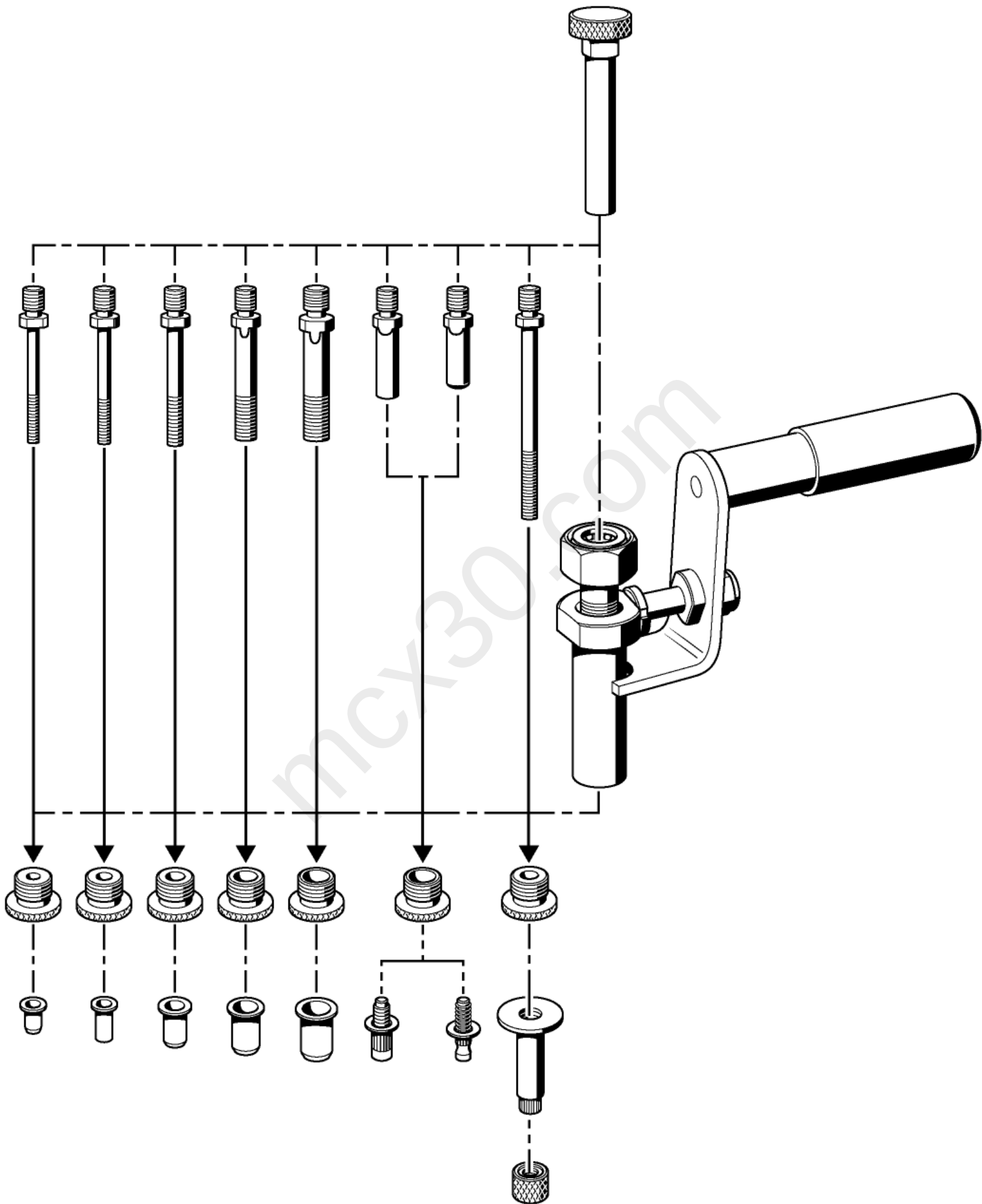
Drill the support panel using a drill bit which is adapted to the nominal diameter of the mounting, see table below.

	Ø nominal	Ø drilling hole (mm)
nuts	M6 x 100	10.2
	M8 x 125	13.5
	M10 x 150	15.5
studs	Fc5	8.2
	M6	10.2

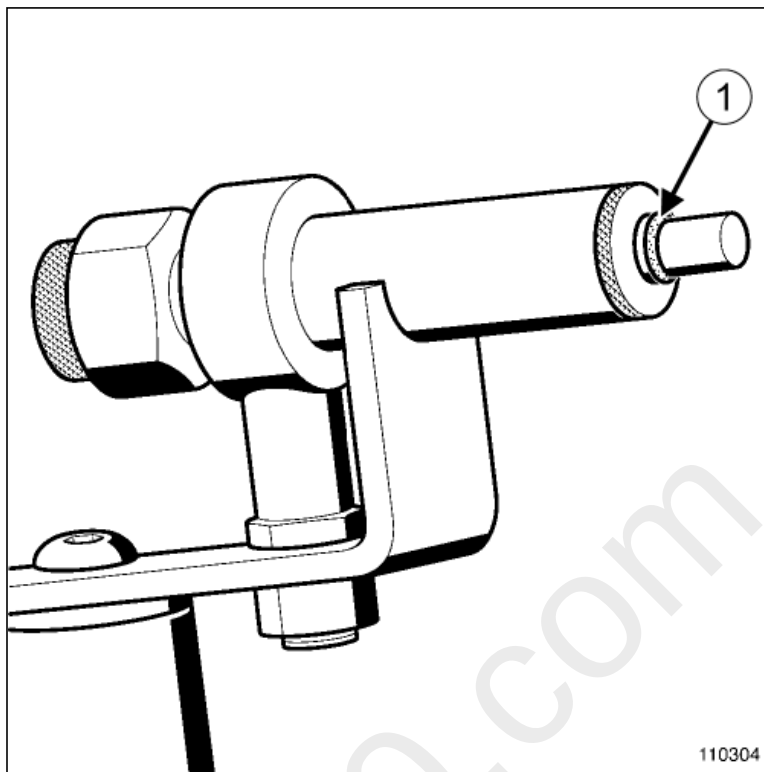
If it is a hollow section, insert wax to stabilise the shavings.(see 04F, Bodywork products and mountings, Anti-corrosion protection products after assembly: Use)

Fit the pull rod and the guide rod adapted to the fixation type to be crimped.

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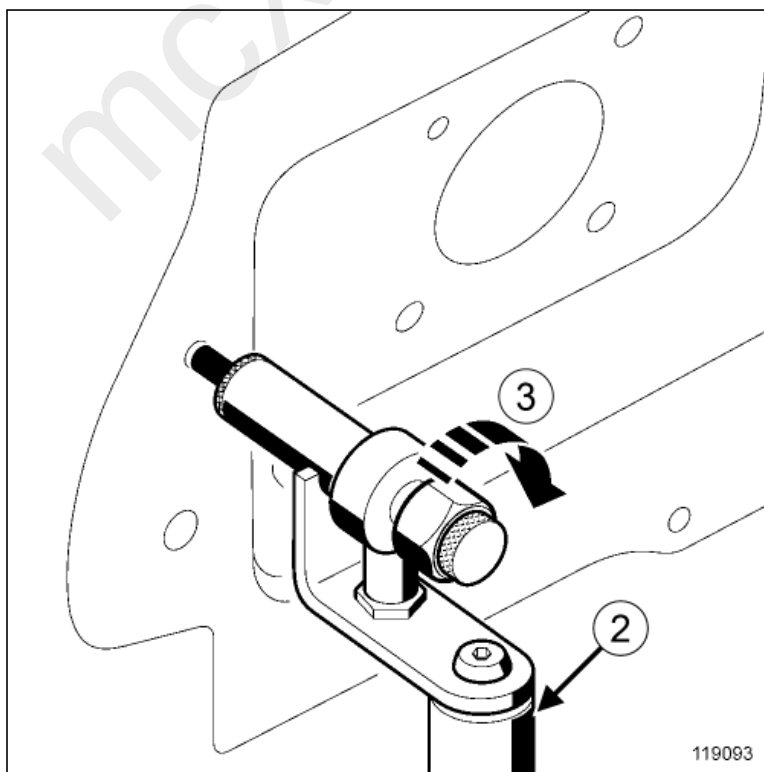


2. FITTING THE CRIMPED MOUNTING USING TOOL CAR. 1504



Screw the crimped nut or stud onto the Tool for fitting crimped nuts. (Car. 1504).

Place anti-corrosive sealing mastic (1) around the insert shaft.



Position and crimp the fixing, manually steadying the tool using the handle (2) and turning the nut (3) of the tool in the direction of the arrow.