

TABLE 2: SLEEVE LENGTH SELECTION DATA

LENGTH CODE	SLEEVE L	MATERIAL THICKNESS T	
		MIN	MAX
4	.062	.048	.063
5	.077	.064	.078
6	.093	.079	.094
7	.108	.095	.109
8	.124	.110	.125
9	.140	.126	.141
10	.155	.142	.156
11	.171	.157	.172
12	.187	.173	.188
13	.202	.189	.203
14	.218	.204	.219
15	.233	.220	.234
16	.249	.235	.250
17	.265	.251	.266
18	.280	.267	.281
19	.296	.282	.297
20	.312	.298	.313
21	.327	.314	.328
22	.343	.329	.344
23	.358	.345	.359
24	.374	.360	.375
25	.390	.376	.391
26	.405	.392	.406
27	.421	.407	.422
28	.437	.423	.438
29	.452	.439	.453
30	.468	.454	.469
31	.483	.470	.484
32	.499	.485	.500

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GLICK BOND

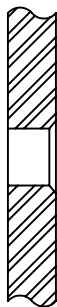
CARSON CITY
NEVADA 89706

CAD CB9530-2	
ANGLES	±1°
.XX	±.03
.XXX	±.010
.XXXX	±.001

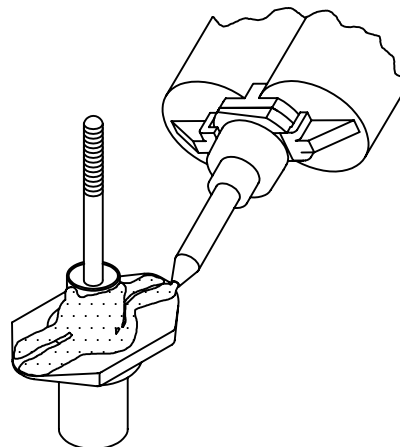
APPROVALS	DATE
DRAWN <i>DAC</i>	16JUL04
CHECKED <i>DOC/mtm</i>	16JUL04
RELEASED <i>CGH</i>	17JUL04
REVISED	

TITLE NUTPLATE, EXTENDED FLOAT, SEALED, FLARE SLEEVE			
SIZE A	CAGE CODE 66530	DWG. NO. CB9530	REV. 0
SCALE 2/1	17JUL04		SHEET 2 OF 4

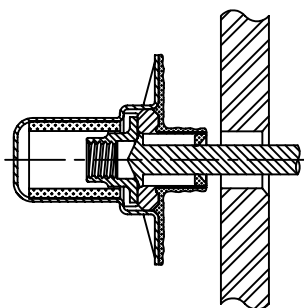
1. PREPARE HOLE IN SUBSTRATE.



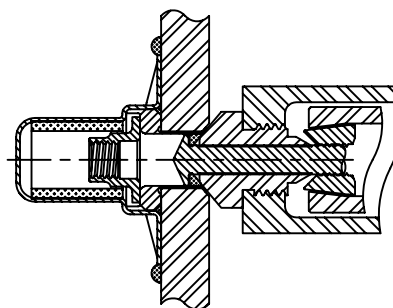
2. APPLY MIXED ADHESIVE TO BASEPLATE AND OUTSIDE OF SLEEVE.



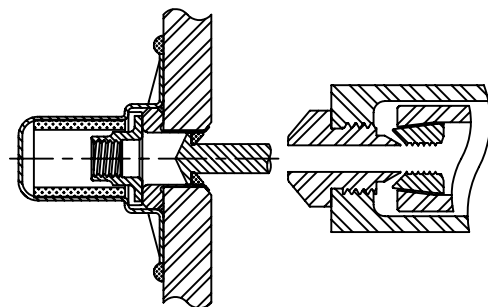
3. INSERT ASSEMBLY THROUGH SUBSTRATE HOLE AND SEAT AGAINST SUBSTRATE SURFACE.



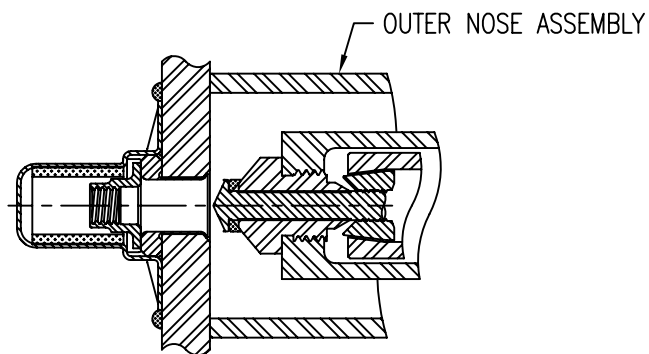
4. PLACE NOSE OF PULL TOOL OVER STEM (MAKE SURE TOOL HAS BEEN RELEASED). ACTUATE TOOL TO PULL STEM AND FLARE SLEEVE



5. WHEN FLARING IS COMPLETE RELEASE STEM AND REMOVE PULL TOOL. WIPE EXCESS ADHESIVE FROM FLARED SLEEVE SUBSTRATE AREA AND TOOL NOSE.



6. INSERT OUTER NOSE ON PULL TOOL THEN PLACE OVER STEM AND PULL STEM AWAY FROM ASSEMBLY.



7. EJECT STEM FROM PULL TOOL. FLARING OPERATION IS COMPLETE.

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CARSON CITY
NEVADA 89706

CAD CB9530-3

APPROVALS

DATE

TITLE

ANGLES ±1°

DRAWN DAC

16JUL04

NUTPLATE, EXTENDED FLOAT, SEALED, FLARE SLEEVE

.XX ±.03

CHECKED *DDC/mtm*

16JUL04

SIZE A CAGE CODE 66530 DWG. NO. CB9530 REV. 0

.XXX ±.010

RELEASED CGH

17JUL04

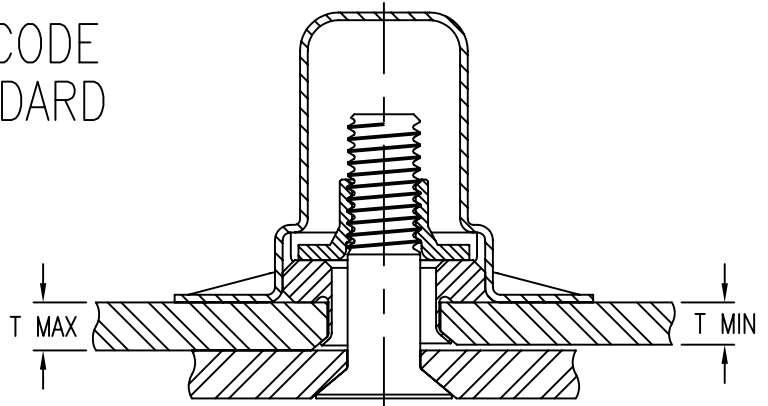
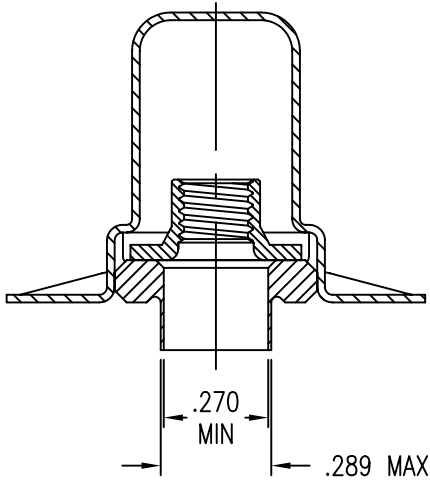
.XXXX ±.001

REVISED

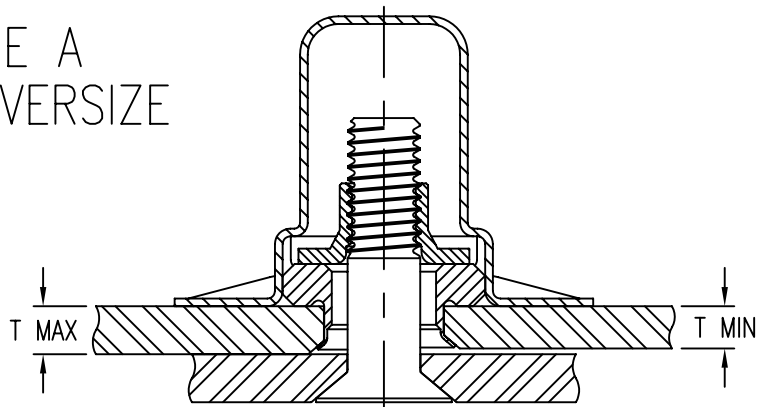
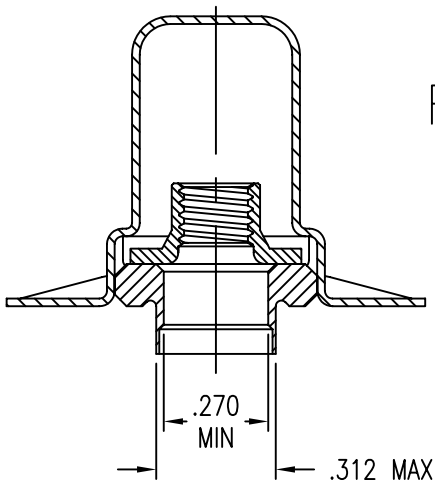
SCALE 1/1 16JUL04

SHEET 3 OF 4

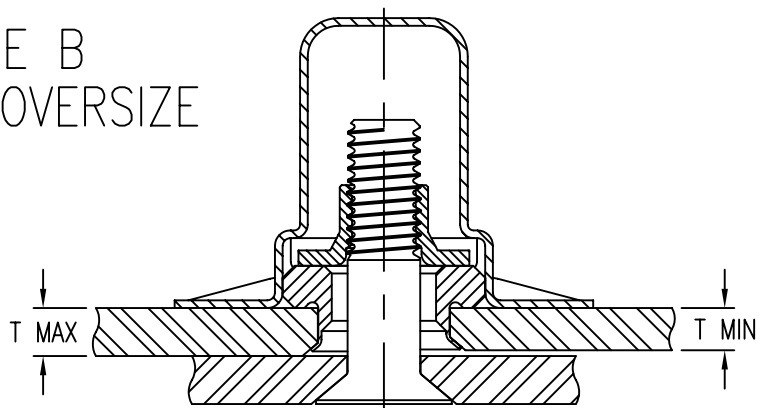
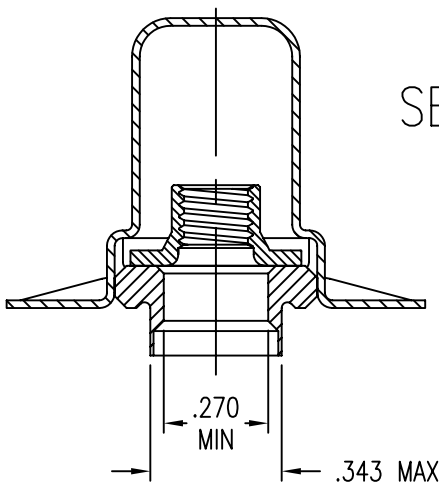
NO CODE
STANDARD



CODE A
FIRST OVERSIZE



CODE B
SECOND OVERSIZE



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REVISED	

TITLE			
NUTPLATE, EXTENDED FLOAT, SEALED, FLARE SLEEVE			
SIZE	CAGE CODE	DWG. NO.	REV.
A	66530	CB9530	0
SCALE	2/1	16JUL04	SHEET 4 OF 4