


TOOL LIST FOR INSTALLING IT6810 IMPACT TRANSMITTER

1. CENTER PUNCH
2. SMALL BALL PEEN HAMMER
3. HALF INCH VARIABLE SPEED DRILL MOTOR
4. 3/16" (#12) DRILL BIT
5. 1" AIRCRAFT COUNTERBORE WITH 3/16" PILOT
6. CUTTING FLUID, TAP MAGIC OR EQUAL
7. 7/32" (#3) DRILL BIT
8. 1/4-28 NF TAPER AND BOTTOM TAP
9. TAP HANDLE
10. OIL OR LIGHT GREASE
11. 3/32" ALLEN WRENCH
12. TORQUE WRENCH CALIBRATED IN INCH POUNDS

INSTALLATION PROCEDURE

1. CENTER PUNCH HOLE LOCATION.
2. DRILL PILOT HOLE 3/16" DIAMETER BY 3/8" DEEP HOLE ON PUNCH MARK.
3. REMOVE METAL SHAVINGS.
4. USING 1" AIRCRAFT COUNTERBORE WITH A 3/16" PILOT SHAFT, SPOT FACE MACHINE MONITORING LOCATION TO A SMOOTH UNIFORM SURFACE.
5. DRILL OUT THE CENTER HOLE USING THE 7/32" (#3) DRILL BIT
6. TAP HOLE WITH 1/4-28 NF TAPERED TAP.
7. REMOVE TAP AND METAL SHAVINGS.
8. CONTINUE TAPPING 1/4-28 NF BOTTOM TAP.
9. REMOVE TAP AND DEBURR.
10. REMOVE METAL SHAVINGS.
11. APPLY OIL OR LIGHT GREASE TO IT6810 THRU BOLT AND MATING SURFACE.
12. INSTALL IT6810 THRU BOLT AND TORQUE TO 50-60 in/lbs.

		TITLE:	
		IT6810 IMPACT XMTR Instructions for 1/4-28 Threaded Mounting	
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