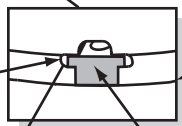


INSERT T-NUT ASSEMBLY TOOL BETWEEN THE T-NUT AND THE EDGE OF THE HAT AT THE CUTOUT RADIUS UP TO THE FLAT SPOT ON THE T-NUT TOOL SHAFT



BOTTOM EDGE OF HAT

T-NUT - TORQUE PER SPECIFICATIONS AT RIGHT

FLAT SPOT ON T-NUT TOOL



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DS-392B REV DATE: 04-19-11

## Instructions for Use of T-Nut Assembly Tool

Assemble rotor to hat via t-nuts and washers, initially "finger tighten only".

Insert t-nut tool into slot between t-nut and hat up to the flat spot on the t-nut tools shaft (this ensures that the t-nut will load normal to the hat face and provide maximum load transfer, increase material life and allow optimum amount of axial float).

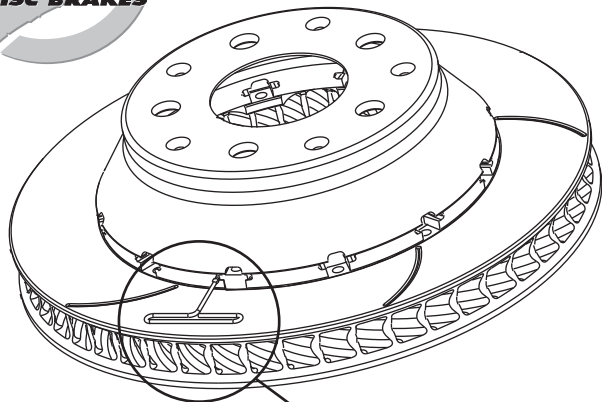
Torque bolts to applicable specification:

- 1/4-28 = 120 in-lbs.
- 5/16-24 = 220 in-lbs.

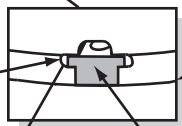
Remove t-nut tool and insert into next t-nut slot. Repeat until all t-nuts have been tightened and torqued to proper specification.

**Note:** Safety wiring of hat and rotor assembly is highly recommended.

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