

# Drilling template Grande Forge

Available diameters :

Skyport: Ø 42,4 or 60,3 mm - New York: Ø 38,1 or 50,8 mm



## CONTENTS OF THE BOX :

2 positioning blocks

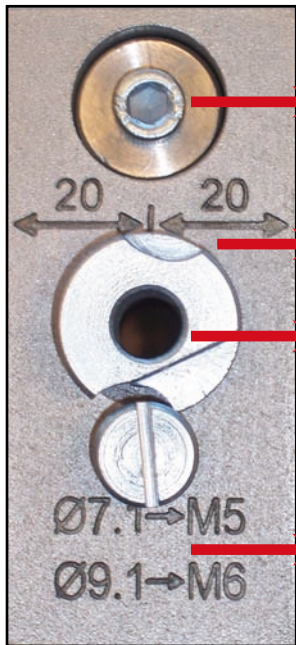
1 Allen key for tightening the tubes

2 drill guide bushings

2 spare rubbers (blocks the tube without scratching it while tightening)



Following instructions are valid for the  $\varnothing 42,4$  of the Skyport range only.  
For other  $\varnothing$  they vary.



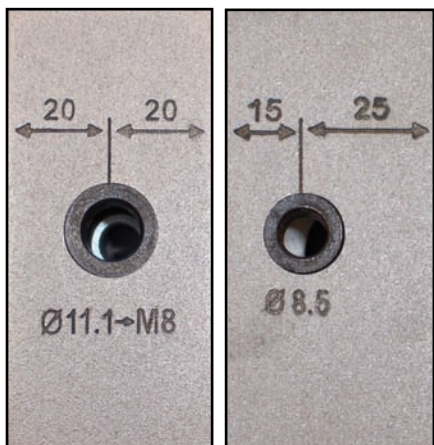
Tightening screw for tube (Allen key supplied).  
Compresses and distorts the rubber during tightening the stainless steel tube.

20 mm between the edge of the template and the centre of the drilling point.

Removable bushing (for guiding)

Set nut M5 = drill of  $\varnothing 7,1$   
Set nut M6 = drill of  $\varnothing 9,1$


$\varnothing 7,1 \rightarrow M5$   
 $\varnothing 9,1 \rightarrow M6$



Set nut M8 = drill of  $\varnothing 11,1$

$\varnothing 8,5$  = passage of the expansion sleeve press screw.

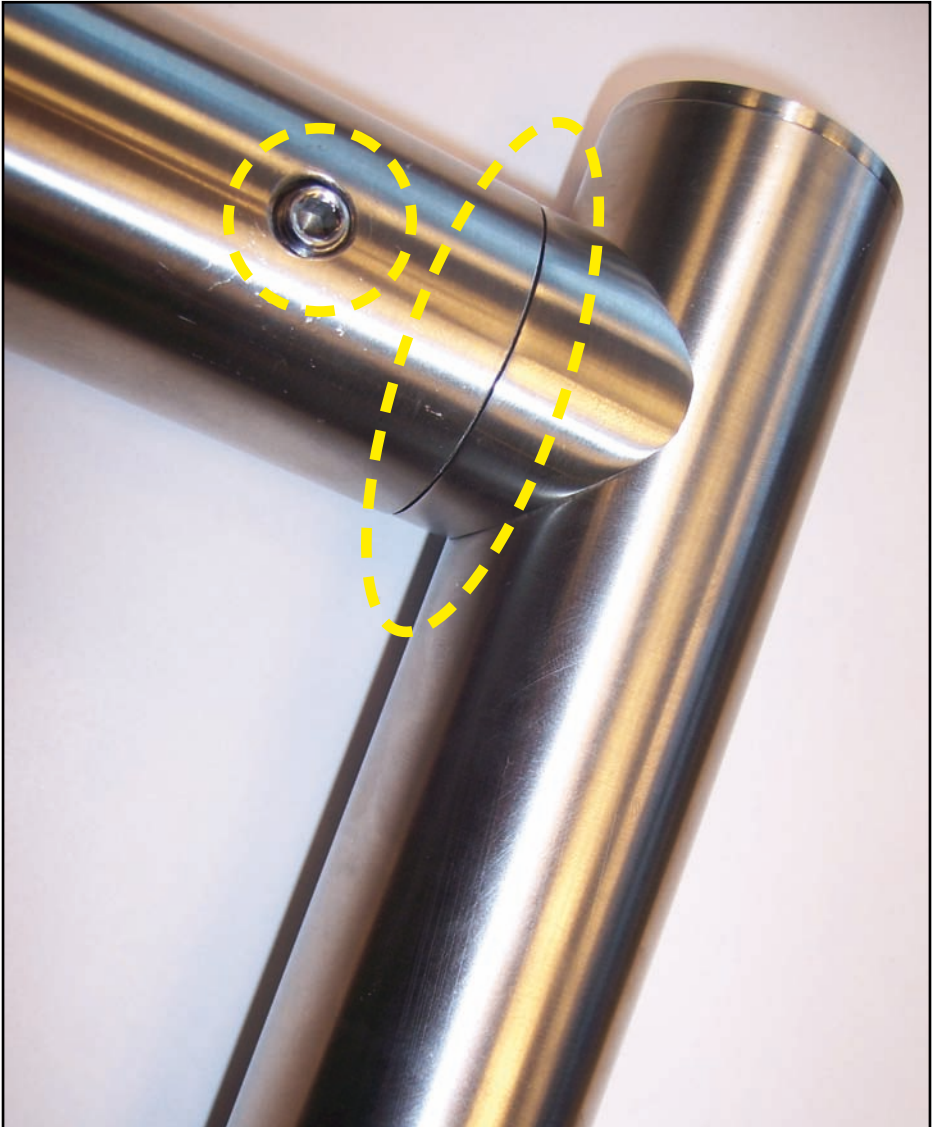
$\varnothing 11,1 \rightarrow M8$   
 $\varnothing 8,5$



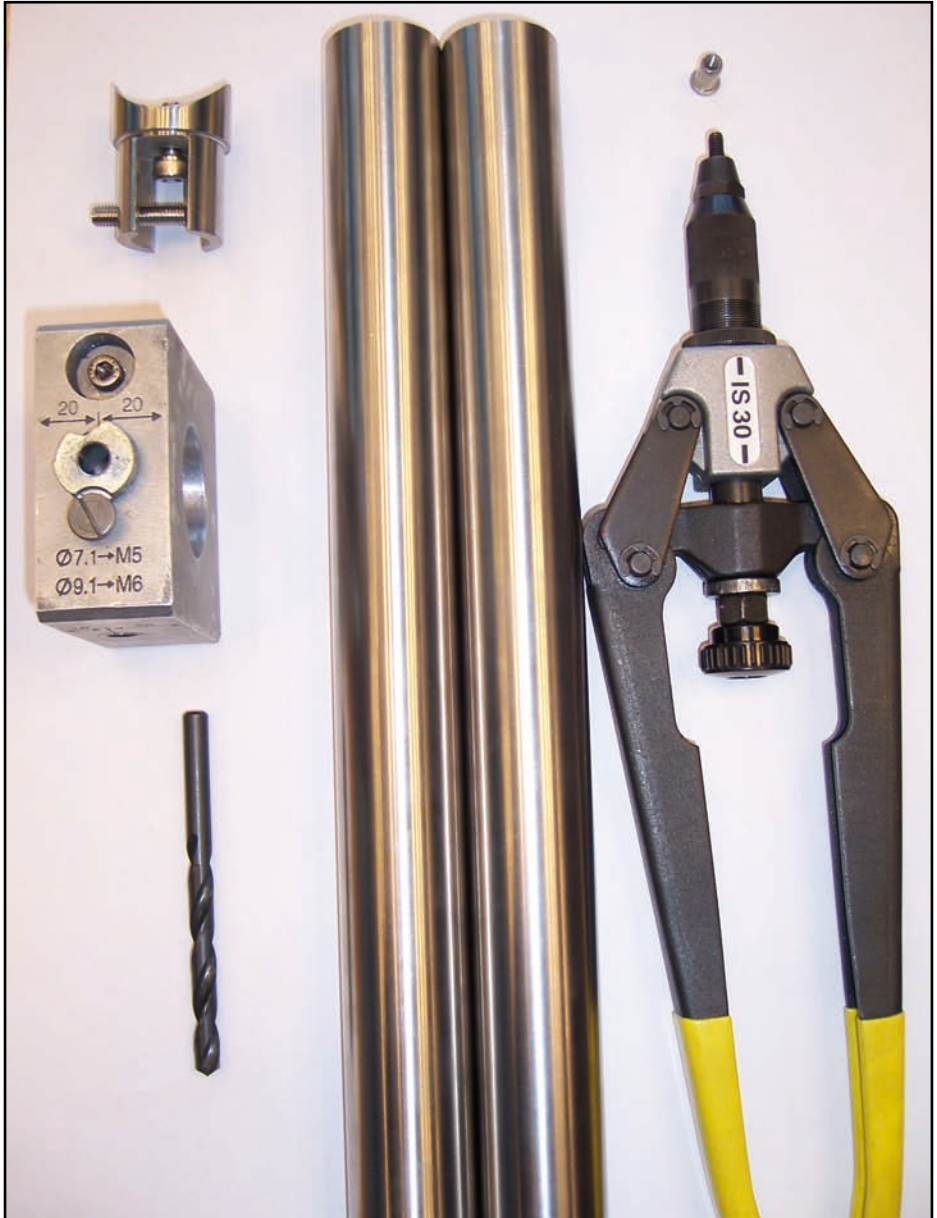
Removable bushings

- $\varnothing 9,1$ mm
- $\varnothing 7,1$ mm.

**Example no. 1 of use for the drilling template :**  
**Assembling of a lateral fitting from the Skyport range (Ø 42,4)**

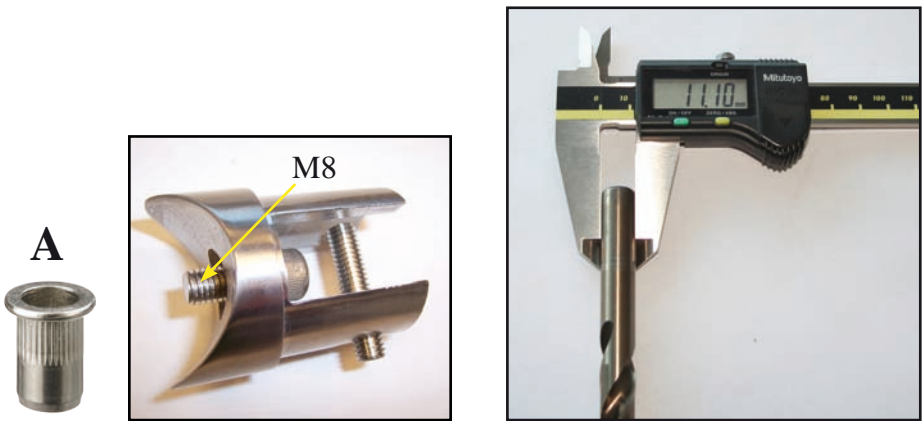


Required elements (please note that the tubes and set nuts are sold separately, the crimping tong is not included in our catalogue) :

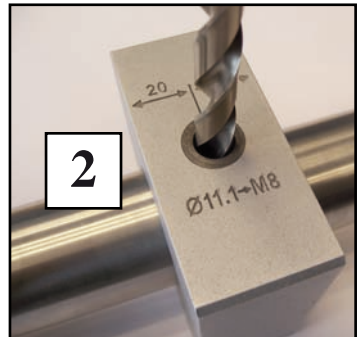
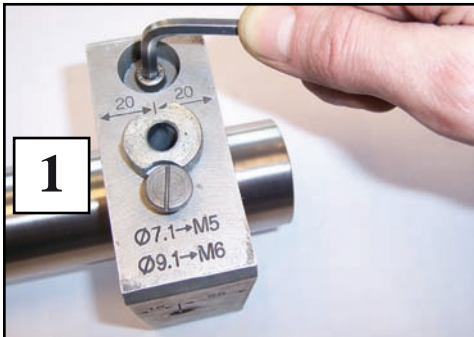


## FITTING OF THE RIVET NUT

To fix the lateral fitting, first place the blind rivet nut (A) on the tube. As the lateral fitting has an M8 fixing screw, use a drill of  $\text{Ø}=11,1$  mm (as shown on page 1).

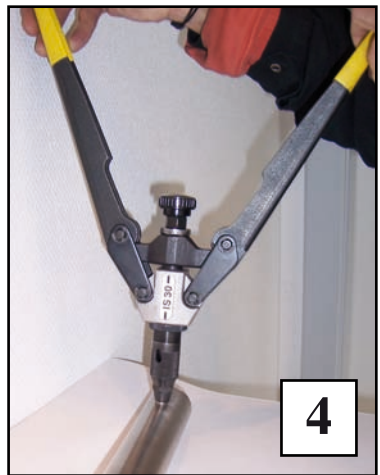
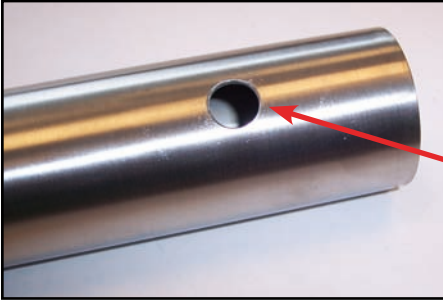


Tighten the tube in the template with the supplied Allen key (1), then bore a hole with the drill of 11,1 mm (2).





Place the blind rivet nut into the hole and crimp (4).

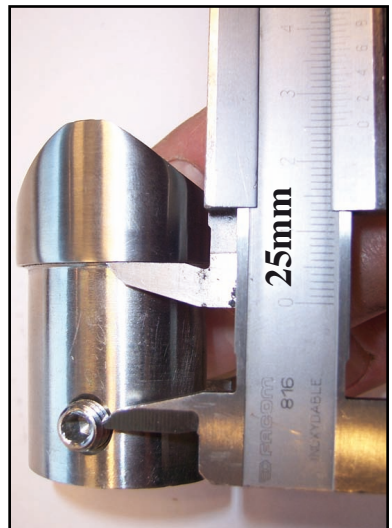
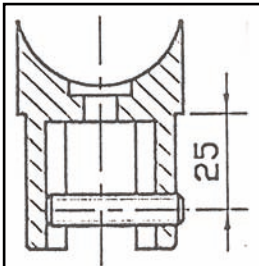




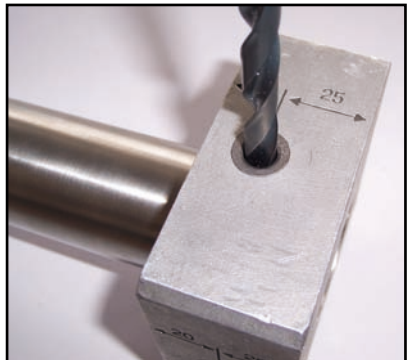
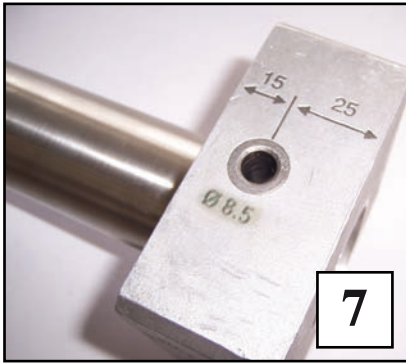
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## DRILLING OF THE HOLE FOR THE PRESS SCREW

For tube  $\varnothing = 42,4$  mm, drill at 25 mm.

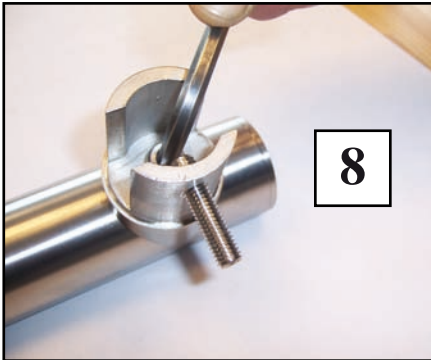


Use the template as shown on picture 7. Position the tube at template level, bore 25 mm from the edge (with a drill of  $\text{Ø} 8,5\text{mm}$ ) in order to place the fitting in the appropriate tube.





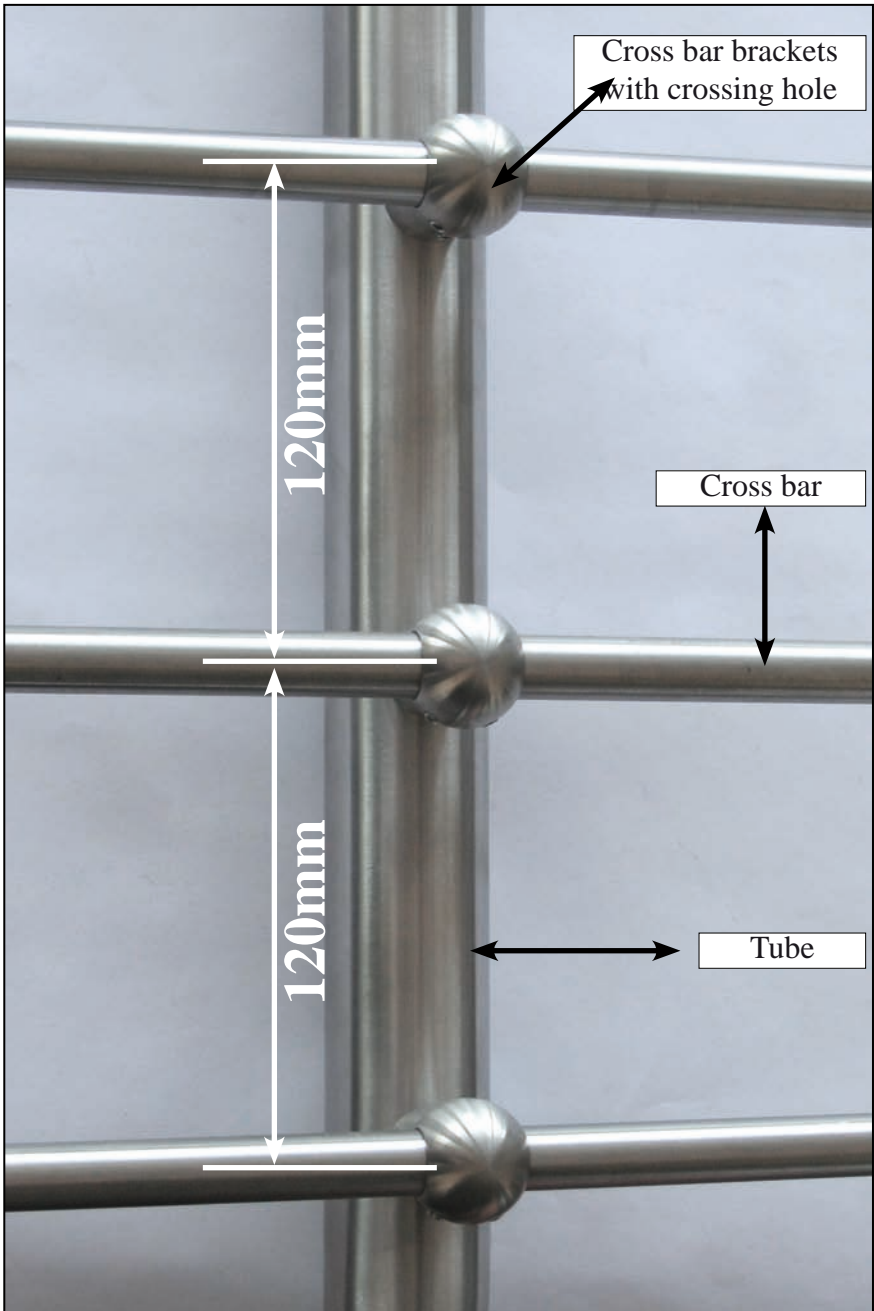
First fix B into A (picture 8) then both items into C (picture 9).





**Example no. 2 of use for the drilling template :**

Fixing of cross bars



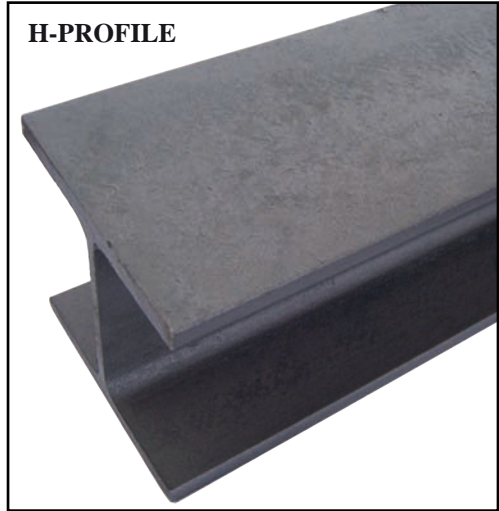
How to make a series of holes of 120 mm interspace in order to fix cross bar brackets with crossing holes (A) :

Use both drilling templates. One of the templates is used as a mark to bore the first hole. It remains fixed on the tube.

Shift the second template 120 mm forward (between the centres of the two drilling holes) and bore. The process can be repeated as many times as there are holes to bore.

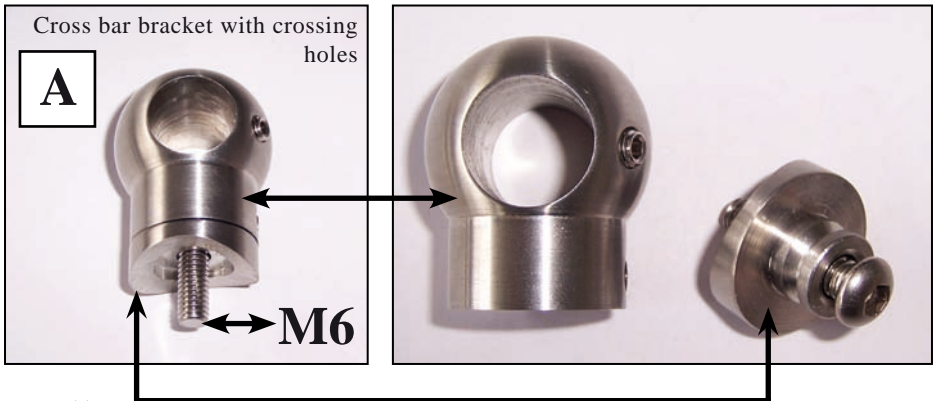
**ADVICE :**

To guarantee an optimum line of the holes, use a flat surface to install the drilling templates such as an H-profile (see opposite picture).

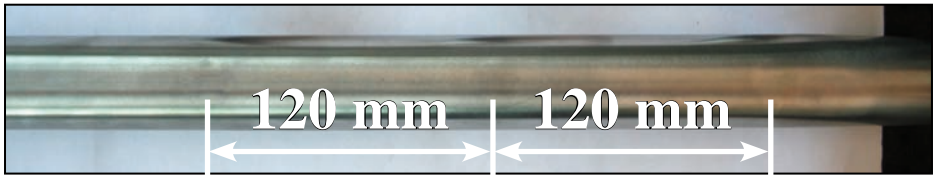


**The fixing on the tube of cross bar brackets with crossing holes requires 5 steps :**

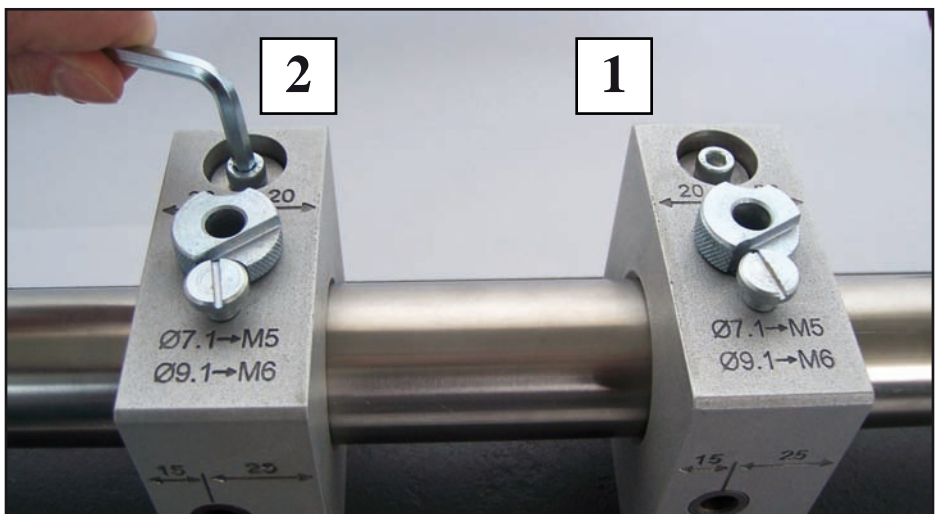
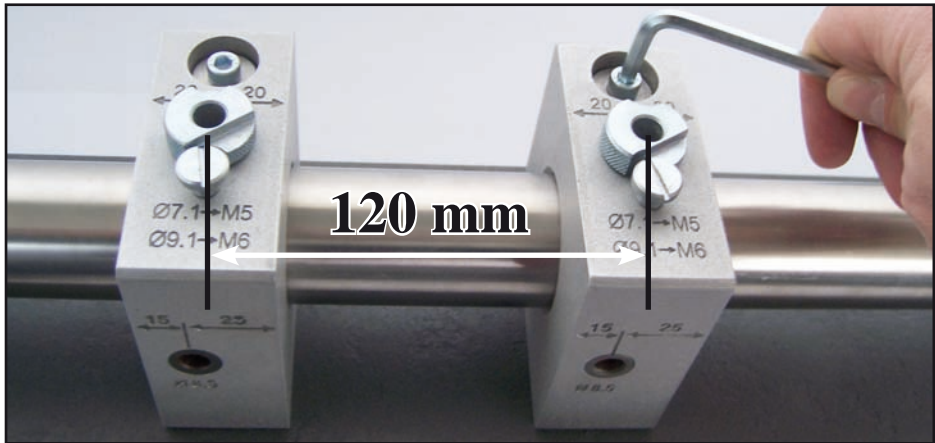
1. **Determining the hole placement on the tube (positioning, tightening of the templates)**
2. **Boring of the holes (and choice of the correct side of the template to use)**
3. **Fixing of the blind rivet nuts into the tube**
4. **Fixing of the cross bar brackets with crossing holes into the rivet nuts**
5. **Fixing of the cross bars into the brackets**



## 1. Determining the hole placement on the tube



One template is used as a mark to bore the first hole. It remains fixed on the tube (1). Then shift the second template (2) 120 mm forward (between the centres of the two drilling holes) and bore.





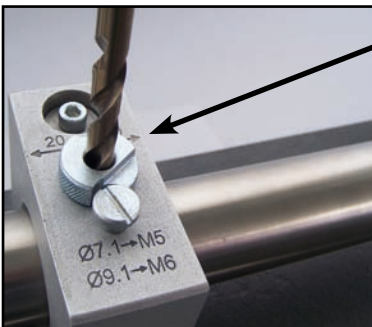
## 2. Boring of the holes (and determination of the correct side of the template to use)



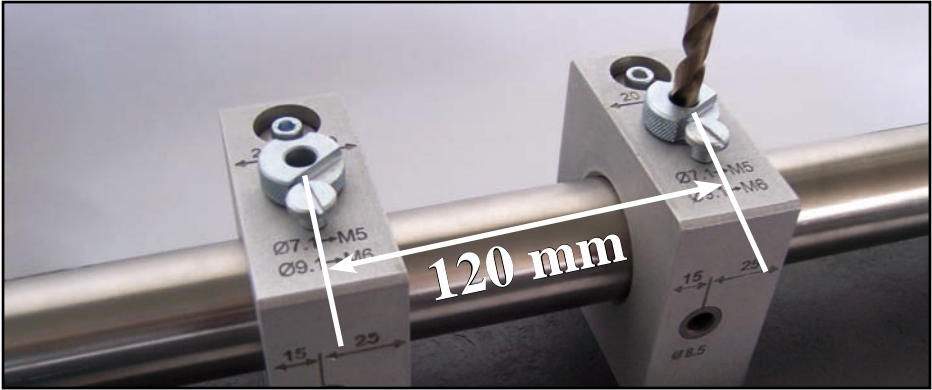
As the fixing screw of the cross bar bracket with crossing hole is an M6, use the corresponding blind rivet nut with an outside diameter of 9,1 mm.



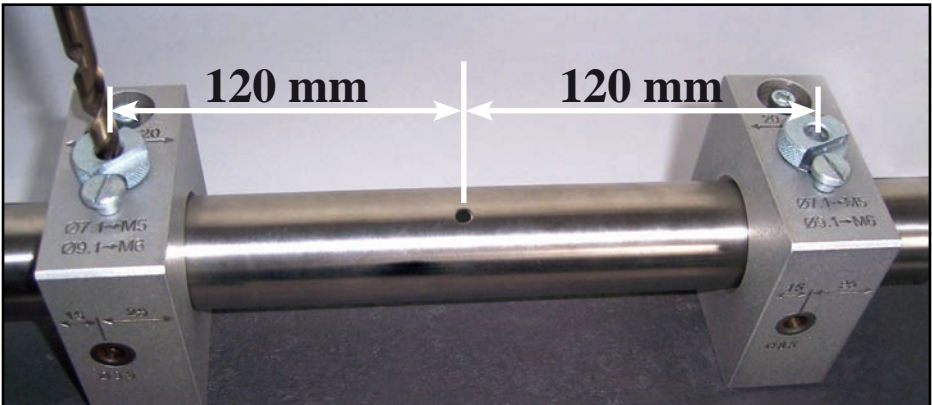
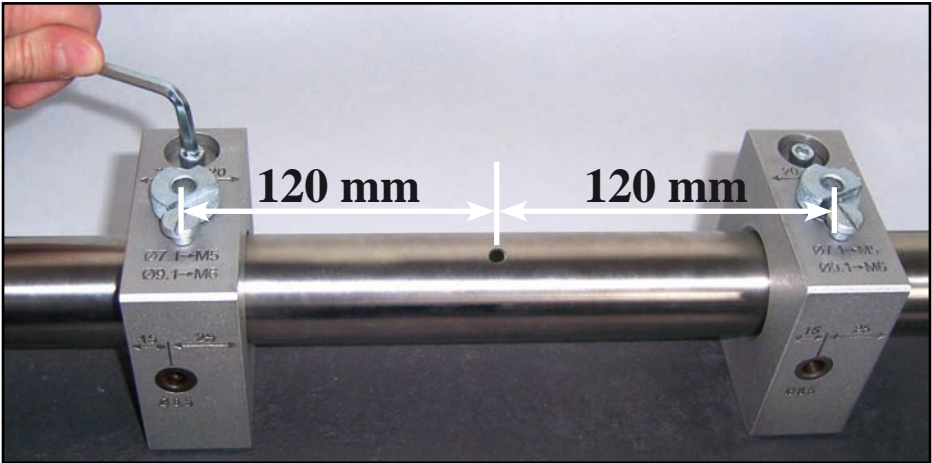
Bore a hole through the tube with a drill of 9,1 mm in order to put the blind rivet nuts.



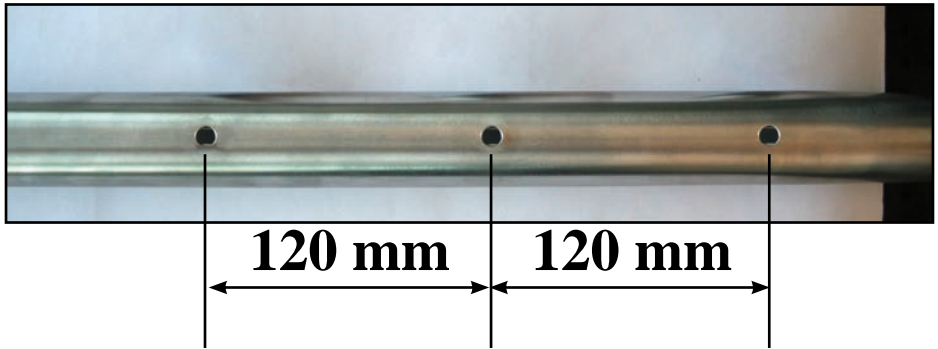
Use the bushing Ø 9,1 mm



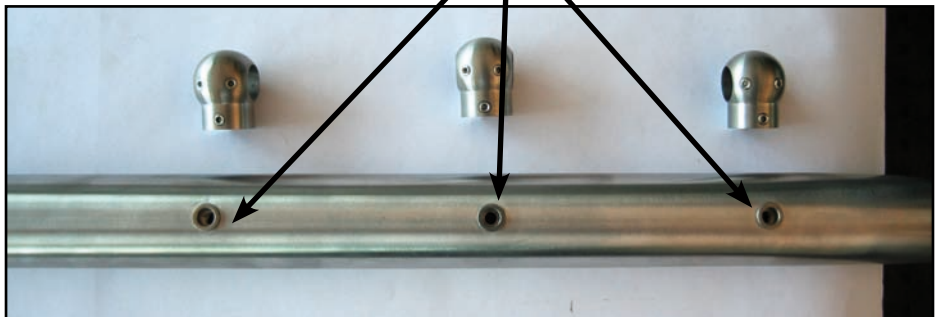
Bore the first two holes then shift the second template 120 mm forward to bore the third hole.



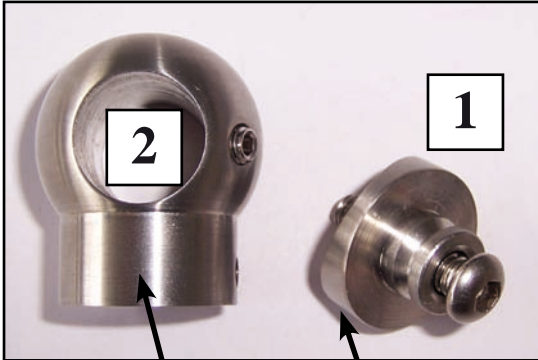
You should have three holes of 120 mm interspace.



### 3. Fixing of the blind rivet nuts into the tube

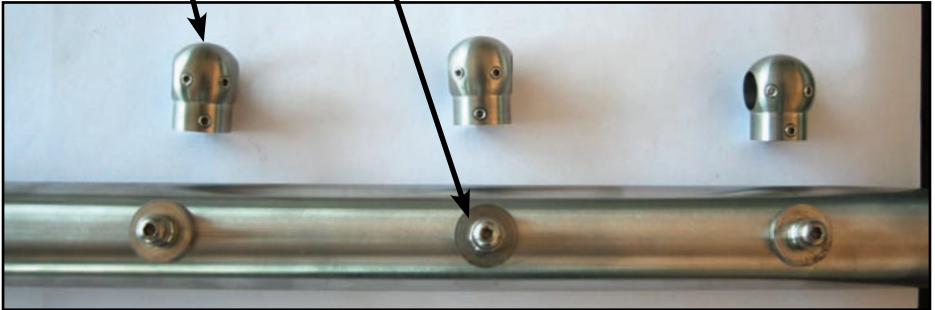


#### 4. Fixing of the cross bar brackets with crossing holes into the rivet nuts



First screw the lower part (1) into the blind rivet nut with an Allen key.

Fix the upper part (2) onto the lower part.



## 5. Fixing of the cross bars into the brackets

Slip the cross bars into the brackets and tighten with an Allen key.

