

URGENT INSTRUCTION SUPPLEMENT

APPARATUS MOUNTING SCREW HOLE PUNCHING
WITH THE R-3183 SHEET METAL HAND PUNCH

1. GENERAL

It is the intent of this UIS to inform Installation of an improved method of forming apparatus mounting screw holes in qualifying mounting plates and equipment units.

The improved method utilizes the R-3183 Sheet Metal Hand Punch versus the standard drilling method. Punching is preferred over drilling because it is more efficient and eliminates the danger of apparatus contamination caused by drilling chips.

The R-3183 Punch may be used when all of the following conditions are met:

- I. The hole location must be 1-3/4" or less from the edge of the material.
- II. Any flanges which must be punched over must be less than 5/16" high.
- III. The R-3183 Punch can be used to form the holes listed below into the following types of sheet metal.

<u>Material</u>	<u>Hole Sizes</u>
0.90" Mild Steel	3/32" - 1/8"
0.41" Mild Steel	3/32" - 9/32"

2. SPECIFIC

CRI's 1B006-8, and 1B007-8 provide for a field retrofit of printed wiring board assemblies to the J1B001AW-1, and J1B001AR-1 TSPS Trunk Units, respectively.

The mounting screw holes to secure the PWB Assembly to the Trunk Unit should be located via the hole template as shown in the CRI instructions. The positions of these holes should be center-punched directly into the Trunk Unit.

Since this application satisfies all of the punch criteria for a 1/8" hole through these Trunk Units, the R-3183 Punch should be used.

Once the 1/8" punch and die are installed into the punch body the die should be adjusted to minimize the tool handgrip span and still allow the punch to completely punch through the metal. A piece of electrical tape should be fastened to the bottom of the punch die to secure the die adjustment and constrain the resulting punch slugs from the adjacent apparatus.

When all of the required holes are punched the PWB Assemblies should be fastened to the trunk units with the screws, washers, and nuts specified in the CRI's.

Engineering Planning Manager
(Installation)