



Flush Recess

Dimple Dies

FLUSH RECESS DIMPLE DIES ARE DESIGNED TO ADD DETAIL AND STRENGTH AROUND A COUNTERSUNK FASTENER WHILE MAINTAINING A FLUSH HEAD. THESE DIMPLES ONLY MAKE THE METAL GO DOWNWARD, LEAVING THE HEAD OF THE BOLT FLUSH WITH THE TOP OF THE PANEL. THEY ARE DESIGNED TO FIT STANDARD 82 DEGREE COUNTERSUNK FASTENERS. SIZES: #10, 1/4", 5/16", 3/8" (ALL OF THESE DIES WILL WORK WITH OUR HF-D100 HYDRAULIC INSTALLATION TOOL!)

TO INSTALL:

- 1) PUNCH OR DRILL THE SIZE HOLE THAT CORRESPONDS WITH THE DIMPLE YOU WANT TO USE. *MAKE SURE THE HOLE IS ROUND WITH NO SPLITS OR BURRS!
- 2) INSERT THE MALE DIE OVER THE CORRESPONDING SHAFT OF OUR HF-D100 HYDRAULIC INSTALLATION TOOL (OR USE A BOLT, NOT PROVIDED) A PRESS OR BENCH VISE IS REQUIRED FOR THE SMALLER SIZES.
- 3) INSERT THREADED STUD (ALIGNMENT BOLT/PIN) THROUGH THE HOLE IN YOUR PANEL,
- 4) INSTALL THE FEMALE DIMPLE DIE ON THE BACK SIDE OF PANEL BY THREADING IT ON TO STUD. (SMALLER DIES HAVE NO THREADS, ONLY AN ALIGNMENT PIN-USE PRESS OR VISE)
- 5) PUMP THE HF-D100 UNTIL THE DIMPLE IS COMPLETELY INSTALLED (DON'T OVER PUMP IT! THIS COULD BREAK THE MANDREL OR BLOW OUT THE SEAL IN THE TOOL) USE ANTI SEIZE ON BOLT THREADS AND DIES.
- 6) PRESS THE RELEASE BOTTOM ON THE HF-D100,
- 7) REMOVE FEMALE DIMPLE DIE, AND STUD FROM PANEL. IF THE DIES STICK TO THE PANEL TAP LIGHTLY ON THE SIDE OF THE DIES WITH A BRASS HAMMER TO REMOVE.

THESE DIMPLE DIES ARE CNC MACHINED FROM 4140 STEEL AND ARE RATED FOR UP TO 16GA MILD STEEL, 18GA STAINLESS STEEL, OR 14GA ALUMINUM MADE IN TEXAS!

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