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Z-Spec Grommet Installation Instructions for GA style Grommets and Oval Head Studs

MilSpec developed this style of grommet flaring tool at the request of A&P mechanics because they were tired of working with the original style tools that did the job but, were hard to manage. So, we came up with the C-clamp version. The tools work the same way but, are far more easily handled and mechanic friendly. This style tool allows Beech Bonanza owners to change fasteners in Bonanza cowings without removing the cowing or the fastener mounting brackets which saves a lot of time and hassle.

Flaring grommets is a two step process, the initial staking of the grommet and then the final crimping with the stud installed. * **Note:** the attachments in this set may look different than the picture below, but the process is the same regardless of which size set of attachments you are using. **We recommend** that the attachments be lubricated with oil or grease prior to flaring the grommet in order to help the grommet release from the tool after it has been flared.

Initial Staking: Take a look at Fig. 1. First, you will snap attachment "A" into the top part of the clamp and put Attachment "B" on to the bottom (screw) part of the clamp. Then place the grommet in the panel hole as shown in Fig. 2. **Note that the wide (flared) end of the grommet is placed on attachment "B".** Turn the screw handle clockwise until the grommet is properly seated on both attachments. Once the grommet is properly seated give the screw handle one turn or so just to start the flaring of the aluminum grommet. See Fig. 3. You do not want to flare it too much, just enough so that the grommet starts to form properly and will not fall out of the panel hole when you take the tool off. Once the initial staking is done, turn the screw handle counter clockwise to remove the clamp and take out the attachments.

Final Crimping: Now snap attachment "C" into the top of the clamp and place attachment "D" on the bottom of the clamp. Next insert the fastener stud through the grommet. Place the clamp and turn the screw handle clockwise so that the attachments seat on the fastener stud properly. If using wing head studs, make sure the wing goes in the milled slot of attachment "C". See Fig. 4. Then continue turning the screw handle until the grommet is fully crimped and you are satisfied with the installation. Finally, turn the screw handle counter clockwise and remove the tool. Proceed around the panel(s) repeating this process at all of the necessary locations. **Maintenance:** Lubricate the clamp screw and the hole at the top of the clamp regularly. If you have any questions or need additional information, please let us know. Thank you for using Genuine MilSpec Products.

