

# Threaded Hole

## Installation

### ⚠ CAUTION ⚠

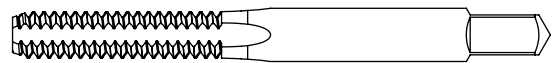
Do **NOT** overtighten any mounting screws!  
If you have any questions, please contact iZone Imaging  
toll free: (888) 464-9663

### DIRECTIONS

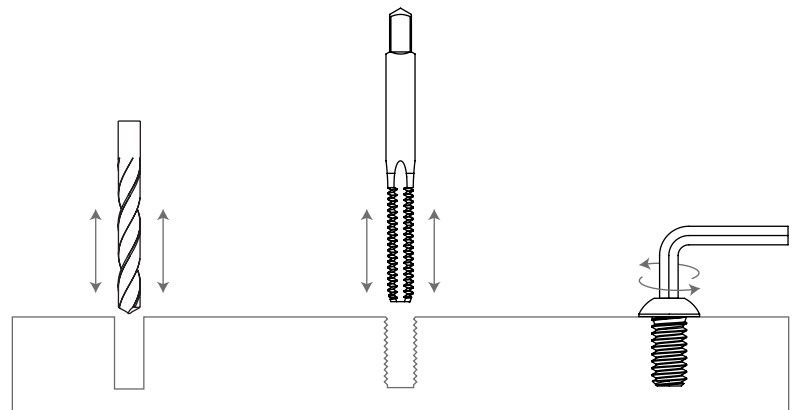
1. Utilizing the drill guide, set the depth of drill bit not to exceed 3/8" or 0.360 +/- 0.015 inches. You may also set the depth by attaching the precision drill guide, placing the drill/tap in the drill, and then placing it on top of the flat surface of the CHPL where the bit/tap is over the edge of the panel. Then view it from the side to make sure that the bit/ tap does not extend past the depth of the panel.
2. Use a tape measure and pencil to mark the center of all hole locations on the back of your panel.
3. Use a center point punch to create a drill starter hole. Place the punch on the marked hole location and make a starter divot for the drill bit.
4. Drill holes to the pre-set depth. Clean holes out by blowing air into them to remove any debris.
5. Remove the drill bit from the drill and replace it with the tap.
6. Spray an oil base (tapping fluid) into the hole. Set drill to low speed and carefully drill until the tap reaches the bottom of the hole. Stop when you feel resistance. Use caution because the tap can pull all the way through the face of the panel.
7. Using a 5/32" allen wrench, screw hex head bolt into the holes while mounting the bracket or mounting plate.
8. Turn to tighten the screw only until snug. Tighten the screw carefully, remembering not to overtighten. Overtightening can pull the screw through the panel, causing the face of the panel to pop out.

### TOOLS REQUIRED

- Standard power drill
- Precision drill guide (to set depth) purchase at home improvement centers
- 7/32" or #7 drill bit
- 1/4" Bottoming tap with threaded pattern for 1/4"- 20 machine screws
- Measuring tape and pencil to mark hole locations
- Center point punch



1/4" Bottoming Tap with threaded pattern for 1/4"-20 machine screws



**Note:** If drilling **thru-holes** in the field, you'll need to drill through the face of the panel using a center punch to start the hole. The size of the bit depends on the size of the hole desired. Make sure to use a brand new drill bit. Put masking tape on the face of the panel where the holes are to be drilled to help prevent chipping. Lay the panel on a hard surface that can be drilled into. Drill through the panel and directly into the hard surface.