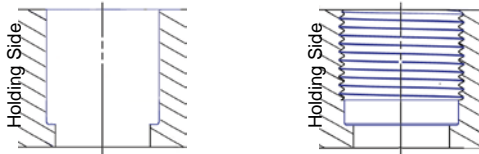


Your Elijah Tooling, Inc. Invert-A-Bolt™ (IVB) fastener has been manufactured to provide low cost, high value performance combined with ease of use. The IVB fastener is a patented product, ideal for connecting two materials or objects together especially when an unobtrusive connection is desired. The IVB fastener features finishes that improve appearance and reduce rust as well as providing closely held tolerances on threads and internal dimensions to insure that it meets your exacting expectations. The IVB fastener is equipped with a cap that covers the stud and fills the hole in the top of the housing. The cap should be used whenever the IVB fastener is not engaged so as to limit the accumulation of debris in the product. The caps are sold separately.

**OPERATING INSTRUCTIONS**

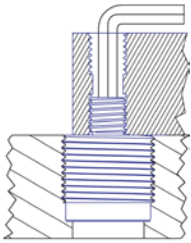
Usage of your IVB fastener requires simple preparation of the "holding" side for the housing threads and preparation of the "receiving" side for the stud threads. For Flush Mount:

- 1 Prepare the "holding" side in the following manner:**  
 Drill a 3/4" diameter (thru) hole  
 C'Bore .92/.928" x .015"R  
 to a depth of 1.152"  
 Tap (or Thread)  
 1"-12UNF-2B-LH  
 to a depth of .950"



- 2 Prepare the "receiving" side for the stud threads:**  
 Tap Drill F" (.257) diameter thru. C'sink .45 dia. x 45 degrees. Tap 5/16"-18 UNC-2A .50" deep.

Once the "holding" side and the "receiving" side have been prepped, simply screw your IVB fastener into the 1"-12 threaded hole with P/N AA02-004-004 insertion tool. Torque to 35-40 ft. lbs. Recommended: in-line torque limiting wrench such as that shown at [http://www.invert-a-bolt.com/shop\\_accessories.shtml](http://www.invert-a-bolt.com/shop_accessories.shtml). Place the "receiving" side 5/16"-18 tapped hole directly above the IVB fastener. Reach through the 5/16"-18 hole with your hex head wrench until contacting the hex head broach in the IVB stud. Start turning counter-clockwise lifting your hex head wrench at the same time. The stud will proceed into the 5/16"-18 tapped hole. Tighten until the stud is fully engaged (approximately .40 inches into the "receiving" side).



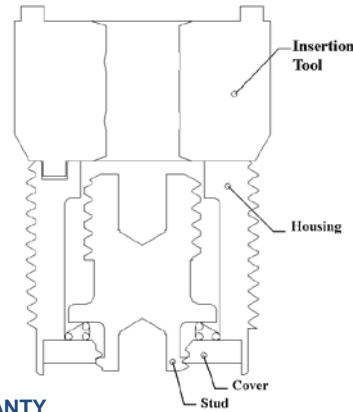
Use a feeler gauge to insure that the "receiving" side material is pulled down properly.

**REPLACEMENT PARTS & MAINTENANCE**

Periodically remove IVB fastener, disassemble by removing the cover in the base of the product, blow out the IVB fastener to clean out accumulated metal chips and debris. Reassemble. Reinstall. (See the refurbishment kit instructions for how to perform the refurbishment). If necessary, refurbishment parts to replace the internal components of IVB fastener are available for sale at [www.invert-a-bolt.com](http://www.invert-a-bolt.com).

If necessary, AA02-250-021RFB Refurbishment Kit is used to replace the internal components of the IVB fastener and is available on our website, [www.invert-a-bolt.com](http://www.invert-a-bolt.com)

*Cross section of IVB fastener with insertion tool*



**LIMITED WARRANTY**

We warrant that within 90 days from the date of shipment, if the product manufactured by us and sold by us (or an authorized distributor) is in the possession of the original buyer, we will replace or repair, at our option, free of charge, any part or parts which upon examination are found to be defective in workmanship or material, and not due to normal wear, provided that, upon our request, the product or parts thereof are returned to our location, with accompanying documentation that the product has been installed, used and maintained in accordance with instructions and has not been subject to abuse. We shall not be liable or responsible for any expense or liability for repairs, additions, or modifications made upon the product without our written consent.

This warranty is in lieu of all other express or implied warranties (including without limitation any warranty of merchantability or fitness for a particular purpose.) In no event shall we be liable for any indirect, special, or consequential damages (including, but not limited to, lost profits or other damages from loss of production) caused by defective material, or by unsatisfactory performance of the product, or by any other breach of contract by us.

The Elijah Tooling, Inc. Warranty shall apply in all cases to all products manufactured by us and sold by us. Elijah Tooling, Inc. reserves the right to modify or change the design of products shown in this specification/instruction sheet, without notice. Such modifications or changes may include, but are not limited to, changes in finish, materials, specifications, etc., from descriptions and illustrations of products listed herein.

**Proviso:** The IVB fastener is not certified to any specification. If loading is a concern, you should perform your own load analysis prior to usage in an application. Shear and Tensile Load information for some Invert-A-Bolt™ products is available on our website at [www.invert-a-bolt.com](http://www.invert-a-bolt.com). The IVB fastener should be used in only two positions – fully engaged and fully dis-engaged.

Fastener P/N: AA02-250-021  
 5/16"-18 dia. Stud x 1-12 dia left hand Housing  
 .330 stud stickout, 7/64" hex

