

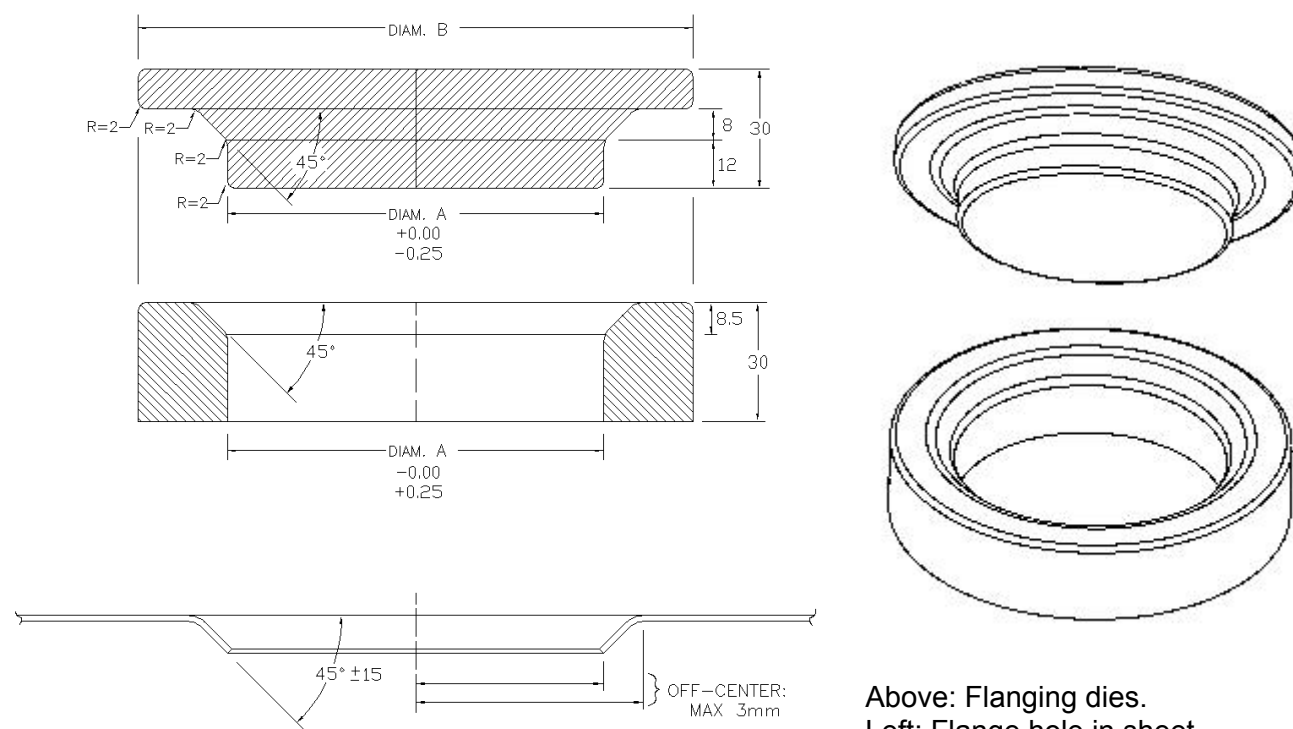
FLAGNED LIGHTENING HOLES

CS #305

The holes F.51, F.65, etc. are cut out to the “flycut” diameter, then flanged with the following tools:

FLAGNED HOLE	F.51	F.65	F.95	F.115
FLYCUT DIAMETER =	51.5mm	65.5mm	95.5mm	115.5mm
DIE DIAM. A =	51mm	65mm	95mm	115mm
DIE DIAM. B =	82mm	110mm	140mm	170mm

Carbon steel flanging die (male & female): finish with Emory cloth, R=2mm



Above: Flanging dies.
Left: Flange hole in sheet.

Place the cut out sheet on the female die, insert the male die (self-centering) and use any press to create the flange (even a 3/4" bolt and two plates, or a heavy vise will do a good job on the relatively thin sheet metal used).