

(4) Fasten all Lock Pins

(5) Check for squareness if two or more panels are replaced.

Note: For removal of Lock Pin and Collar, ACS recommends placing a piece of masking tape over the head of the pin to prevent it from flying off when the Collar is removed. Break rapidly towards the pin line. (Drilling pins out from Collar with 9/32 inch drill bit is permissible for pins that are not accessible to the pin removal tool or just difficult to remove.)



Recommended direction of Lock Pin removal: Parallel to line of fasteners as shown.

H. Panel Hole Damage

In the event of Lock Pin damages the outer skin of the panel or pulls through the panel edge holes, a Flat washer (ACS P/N 3000009, Mil spec P/N MS-27183-52 or equivalent) is recommended between the Lock Pin head and outer panel surface and between the Lock Collar and inside panel surface wherever applicable.

