

FSRRK-568

NSN: 5130-01-670-1489

Blind Rivet & Blind Bolt Rivet Removal Kit

KIT SOLUTION

MOBILE

REMOVAL

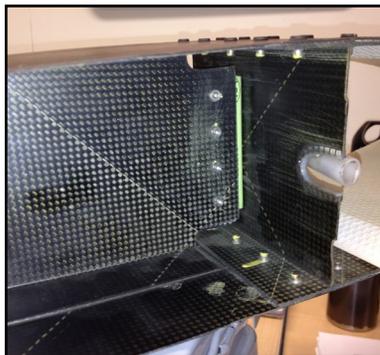
PREPARATION



Introducing the FSRRK-568 Blind Bolt, Hi-Lok and Blind Rivet Removal Kit. Developed for Unit Level maintenance for the repair of the Blackhawk and Apache Stabilators. This kit includes all the items required to remove 5/32", 3/16" and 1/4" diameter blind dome head and button head rivets. The kit is complete with micro-stop cages, specially developed head marking punches, special micro-stop anti-rotation feet and a variable speed air operated drill. The kit contains special threaded cobalt drills for removal and hole preparation. This kit is a perfect addition to the K-3000-MIL-1 Composite Material repair kit or the K-1000 Sheet Metal Mechanics Tool kit. Pat.Pending©

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Blackhawk Stabilator



Contract:
 GS-06F-0009L

FSRRK-568 Operating Instructions

Step 1: Assemble the punch and punch foot (per required diameter). Center the punch assembly over the head of the fastener that is to be removed. With a hammer, create anti-rotational indentations on the head of the fastener with a single sharp blow.

Step 2: Install the correct pilot drill bit and foot on the micro-stop cage. *See drill bit chart.* Set the depth so the countersink foot engages the anti-rotation indentations created with step 1. Using the drill provided in the kit remove the lock ring portion of the fastener.

Step 3: Install the correct finish drill bit into the micro-stop cage and set the depth to remove only the head of the fastener. *See drill bit chart.* Drill until only the head of the fastener is removed. (**See warning**)

Step 4: With a punch knock-out the remaining portion of the fastener.

Warning: *Drill 700 rpm only. Higher speeds may cause damage to the composite material.*



Step # 1



Step # 2



Step # 3



Step # 4

Drill Bit Chart

Fasteners	Punch Foot	Countersink Foot	Pilot Drill	Finish Drill
5/32" Blind Bolt (MS90354/MS21141S&U)	FRP-5/32	CSF-5/32	ALTD-30-X	ALTD-21-X
3/16" Blind Bolt (MS90354/MS21141S&U)	FRP-3/16	CSF-3/16	ALTD-13/64-X	ALTD-11-X
1/4" Blind Bolt (MS90354/MS21141S&U)	FRP-1/4	CSF-1/4	ALTD-17/64-X	ALTD-F-X
5/32" Blind Rivet (NAS1919S) Monel & Cres	FRP-5/32	CSF-5/32	ALTD-5/32-X	ALTD-20-X
3/16" Blind Rivet (NAS1919S) Monel & Cres	FRP-3/16	CSF-3/16	ALTD-3/16-X	ALTD-10-X
1/4" Blind Rivet (NAS1919S) Monel & Cres	FRP-1/4	CSF-1/4	ALTD-17/64-X	ALTD-F-X