



Your Elijah Tooling, Inc. Invert-A-Bolt™ (IVB) insertion tool has been manufactured to provide easy installation and removal of the fastener in the application for which it was purchased. We have some easy rules to follow to get maximum life out of your tool.

- Use a torque limiting pneumatic wrench to install the fastener. The product is available on the web-site, in the Fasteners Accessories section, P/N PRO-1.



- Don't skip this step. The fastener must be torqued such that it won't vibrate or in any other way screw itself back out of the receiving object.
- When using the torque limiting wrench, use the LOWEST setting (1) to install the fastener. This should amount to approximately the recommended 35-40 ft. lbs. that is suggested as a MAXIMUM torque. Do not exceed this torque as it may lead to damage of the insertion tool.
- Remember! The AA02, AA03, AA06, PL03 type products employ an outside left-hand thread. Turn the tool to the left to tighten. Turn to the right to loosen.
- When removing the fastener, use the lowest setting on the PRO-1 torque limiting wrench. If that doesn't work, move up to the 2nd lowest setting. By using these settings (and only those 2), it is possible to prevent damage to the insertion tool as well as eliminating "egging out" the holes in the face of the fastener.
- Using a regular torque wrench to install/ remove the fasteners IS NOT recommended. The side forces necessary to impart the torque can damage the insertion tool or the holes in the face of the fastener.
- The insertion tool is designed in such a way to make replacement of the drive pins very easy should one or more of the pins break. Simply screw out the pin using a hex wrench and insert the new drive pin. Before screwing in the new pin, squirt a small amount of Loctite (or equivalent) Penetrating Thread Locker fluid into the threads of the insertion tool. Let set for 20 minutes before usage. Replacement drive pins with Thread Locker may be purchased on the web-site, in the Fastener Accessories section.

- The drive pins are adjustable to match the situation. Simply insert a hex wrench into the back of the drive pin and turn the wrench until the desired depth of the pin is achieved. NOTE: we recommend the use of Penetrating Thread Locker on the pin threads if the depth is adjusted.
- The insertion tool comes installed with (6) drive pins. If the product in use is not a 6-pin version, just lower/remove the unnecessary pins as required.
- The replacement pins with Thread Locker can be purchased at a nominal cost, part number: AA02-AA03-Screw-Kit.



**WHAT INSERTION TOOL TO USE?**

PART NUMBER	INSERTION TOOL P/N	REPLACE-ABLE DRIVE PINS?
AA02-001-001 TYPE FASTENER	AA02-002-002	NO
AA02-XXX-001 TYPE FASTENER	AA02-004-004	YES
AA02-XXX-0X1 TYPE FASTENER	AA02-004-004	YES
AA02-XXX-1X1 TYPE FASTENER	AA02-004-004	YES
AA03-XXX-001 TYPE FASTENER	AA03-004-004	YES
AA03-XXX-0X1 TYPE FASTENER	AA03-004-004	YES
AA06-XXX-001 TYPE FASTENER	AA03-004-004	YES
AA06-015-021 TYPE FASTENER	AA02-004-004	YES
PL03-XXX-001 TYPE PREC. LOCATOR	AA03-004-004	YES
PL03-XXX-101 TYPE PREC. LOCATOR	AA03-004-004	YES

**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.

Insertion Tool P/N: AA03-004-004  
 For use with AA03, AA06, PL03 TYPE Products,  
 3-pin, 4-pin, 6-pin. Replaceable Pins.

