



MICROSTOP COUNTERSINK KIT





MICROSTOP COUNTERSINK KIT

OVERVIEW

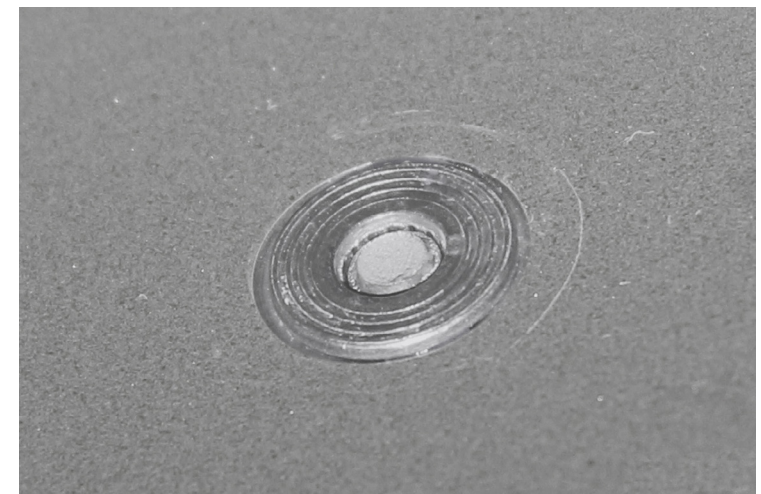
Use the Microstop Countersink Kit to countersink holes for countersunk rivets (upper image) so that the rivet sits flush to the surface of the surrounding material (lower right image).

NOTE

Adjust the depth of the countersink cage assembly on scrap material before attempting to countersink a hole on a vehicle being repaired.



Microstop Countersink Kit (Tesla part number 1065944-00-A)

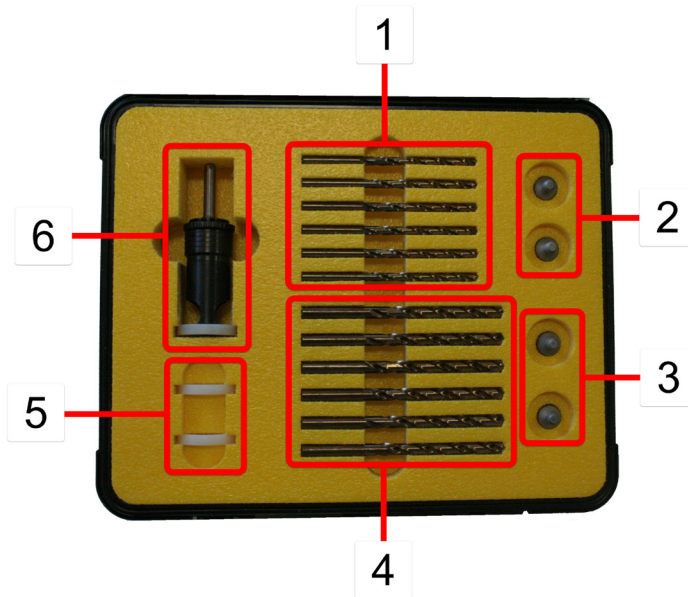




MICROSTOP COUNTERSINK KIT

OVERVIEW

Kit Contents



	Description	Tesla Part Number
1	Pilot bits for 4.8 mm (3/16 in) rivets (x6)	1065969-00-A
2	Countersink bits for 4.8 mm (3/16 in) rivets (x2)	1065946-00-A
3	Countersink bits for 6.5 mm (1/4 in) rivets (x2)	1065948-00-A
4	Pilot bits for 6.5 mm (1/4 in) rivets (x6)	1065970-00-A
5	Nylon feet (x2)	1065966-00-A
6	Countersink cage assembly (x1)	1065945-00-A
	Storage case	1065971-00-A

The Countersink Cage Assembly



1	Shaft
2	Locking ring
3	Cage
4	Countersink bit
5	Nylon foot
6	Chuck



MICROSTOP COUNTERSINK KIT

USING THE TOOL

1 Use a drill with the appropriate size pilot bit to drill a pilot hole in a piece of scrap material.

Pilot bit sizes:

- 4.8 mm (3/16 in)
- 6.5 mm (1/4 in)

CAUTION

When performing a repair, drill holes far enough away from corners and other obstructions to provide enough clearance (approximately 18 mm or 11/16 in) for the countersink cage assembly.

CAUTION

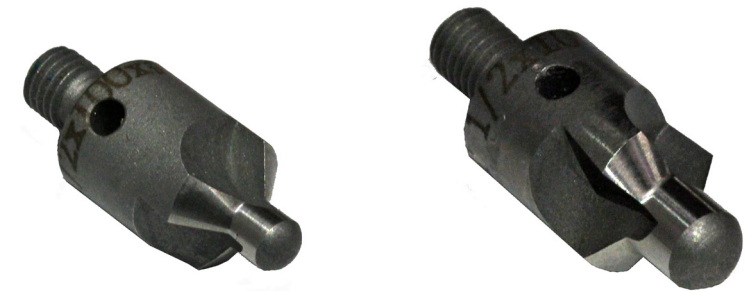
Always use the countersunk rivet size specified in the applicable repair procedure.



2 Select the appropriate countersink bit.

Countersink bit sizes:

- 4.8 mm (3/16 in)
- 6.5 mm (1/4 in)

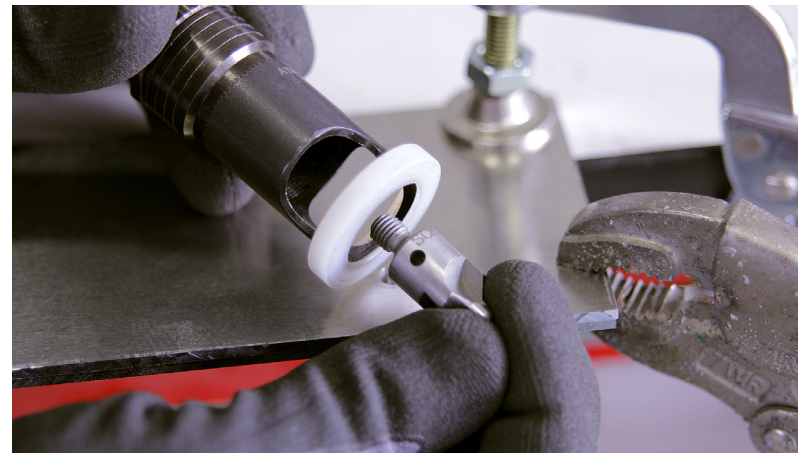




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USING THE TOOL

- 3 Screw the countersink bit into the threaded insert of the countersink cage.





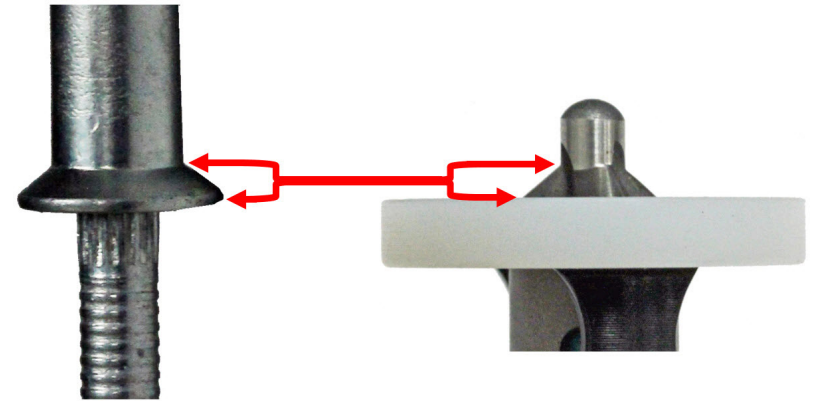
MICROSTOP COUNTERSINK KIT

USING THE TOOL

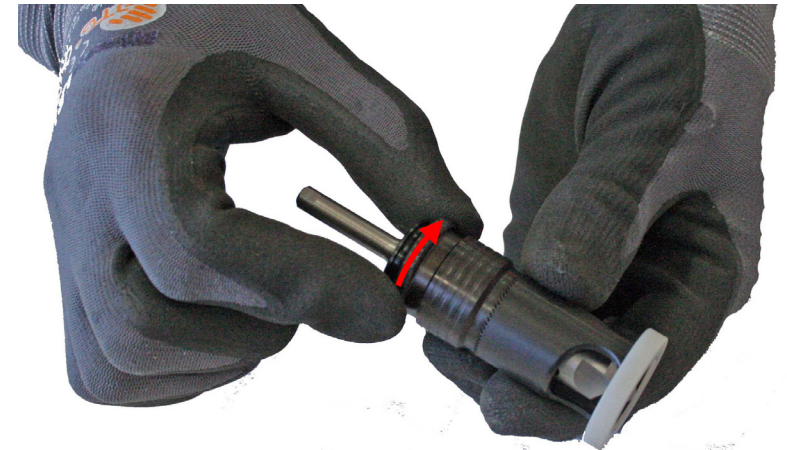
4 Adjust the countersink cage assembly so that the distance that the angled portion of the cutting bit protrudes from the nylon foot when the shaft is fully extended is slightly less than the distance of the angled portion of the countersunk rivet.

CAUTION

Adjust the countersink cage assembly so that the initial countersink depth is slightly less than the rivet to avoid over-countersinking the hole.



A Loosen the locking ring.





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USING THE TOOL

4

Adjust the countersink cage assembly (continued).

B

Pull the chuck back to disengage it from the cage.



C

Adjust the cage by turning it counterclockwise to shorten it or clockwise to lengthen it.



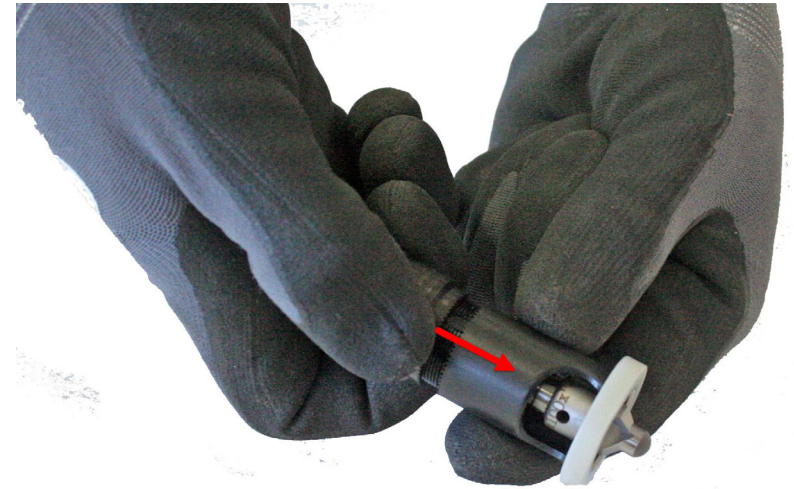


MICROSTOP COUNTERSINK KIT

USING THE TOOL

4 Adjust the countersink cage assembly (continued).

D Release the chuck.



E Check the depth setting by pushing the shaft forward to the limit of its extension. Repeat steps B–D until the cage is in the desired position.





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USING THE TOOL

4 Adjust the countersink cage assembly (continued).

F Tighten the locking ring.



5 Install the countersink cage assembly onto the drill.





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USING THE TOOL

6

Use the drill with the countersink cage assembly to countersink the hole drilled previously.

NOTE

Continue drilling until the shaft of the countersink cage assembly reaches the end of its travel and no more debris comes out of the hole.





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USING THE TOOL

7

Insert a countersunk rivet into the hole.

If the rivet head protrudes above the surface of the material (as shown in the upper image), repeat steps 4 and 6 until the rivet sits flush with the surface of the material (as shown in the lower image).





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USING THE TOOL

- 8 Use a drill with the appropriate size pilot bit to drill holes in the repair area.



- 9 Use a drill with the adjusted countersink cage assembly to countersink the holes in the repair area.

NOTE

Continue drilling until the countersink cage assembly reaches the end of its travel and no more debris comes out of the hole.

