

# 110 FLANGE HOG®



## USER MANUAL



DISCONNECT POWER SUPPLY BEFORE SERVICING



UNDERSTAND ALL INSTRUCTIONS BEFORE USING

# ESCO Tool Guarantee

Guarantee: The manufacturer guarantees its products to be free from defects in material or workmanship for a period of one year from date of shipment from its factory. Said guarantee will not apply if equipment is used in conditions of service for which it is not recommended. The manufacturer is not responsible for damage to its products through improper use, physical damage, poor operating practice, or normal wear.

If any device is found unsatisfactory under the guarantee, the buyer must notify ESCO Tool in writing and after receipt of shipping instructions, buyer must return it directly to ESCO Tool, 75 October Hill Road, Holliston, MA 01746, USA, shipping charges prepaid. Such equipment will be replaced or put in satisfactory operating condition, free of all charges except transportation. The correction of any factory defect by repair or replacement by the manufacturer shall constitute fulfillment of all obligations to the purchaser. Manufacturer's guarantee is void if unauthorized repairs are made to its products.

Manufacturer shall not be liable for consequential damage in case of failure to meet the conditions of any guarantee or shipping schedule, nor will claims for labor, loss of profit, repairs, or other expenses incidental to replacement be allowed.

No other representations, guarantees or warranties, expressed or implied, are made by the manufacturer in connection with the manufacture and sale of its equipment.

## *Hold Harmless Agreement*

Customer agrees to defend, indemnify and hold ESCO Tool, its owners, agents, officers, and/or employees free and harmless from and against any and all claims, liabilities, losses, costs and out of pocket expenses (including attorney's fees) arising out of, or in connection with the ESCO Tool equipment, its use or transportation, or out of operations conducted by customer, its agents, employees, contractors, representatives, guests or invitees, including, but not limited to, active and/or passive negligence.

## CONTENTS

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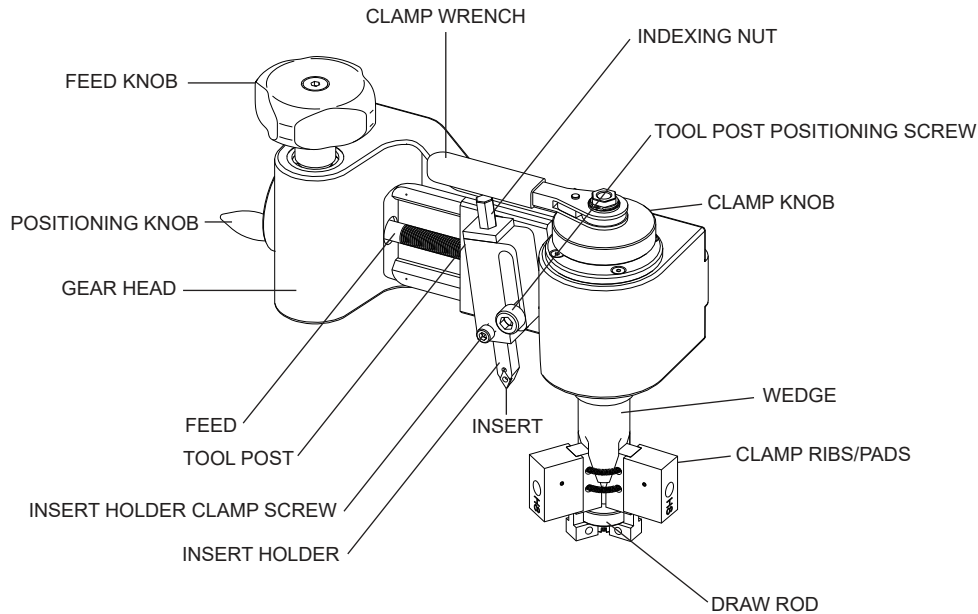
<b>INSTRUCTION FOR PUTTING IN TO USE</b> .....	1
UNPACKING.....	1
ILLUSTRATED DESCRIPTION OF FUNCTION.....	1
LIST OF CONTENTS.....	1
<b>SAFETY PRECAUTIONS</b> .....	2
PRECAUTIONS AND USE OF PERSONAL PROTECTIVE EQUIPMENT.....	2
SPECIAL SAFETY PRECAUTIONS.....	2
TOOL LIMITS.....	2
EXPLANATION OF SYMBOLS.....	3
DISCLAIMER.....	3
OPERATING ERGONOMICS.....	3
<b>OPERATING INSTRUCTIONS</b> .....	3
IDENTIFICATION OF OPERATING CONTROLS AND THEIR USE.....	3
SELECTION OF PROPER TOOLING.....	4
MOUNTING THE TOOL TO THE WORK.....	5
MOUNTING WITH NO WEDGE OR WITH SMALL WEDGE.....	5
MOUNTING WITH LARGE WEDGE.....	5
LEVELING.....	6
OPERATION OF TOOL.....	6
<b>MAINTENANCE AND SERVICING</b> .....	8
REGULAR CLEANING AND LUBRICATION.....	8
USER SERVICE.....	8
SERVICING BY MANUFACTURER OR AGENT.....	8
<b>CLAMP RIB CHART / QUICK REFERENCE</b> .....	9
<b>ASSEMBLY DRAWINGS</b> .....	9
PACKAGING.....	10
GEAR HEAD.....	11
FEEDS & WEDGES.....	13
DRAW RODS.....	14
CLAMP RIBS/PADS.....	15
TOOL POST.....	16
INSERT HOLDER.....	16

## Instructions for putting into use

### Unpacking

1. Use caution when handling the tool. Cutting blades are sharp. Typically they are protected, however, exposed blades can cause injury.
2. Clean any excess oil, grease or rust preventative from the surface of the tool.

### Illustrated description of function



### List of contents

- Gear Head Assembly
- Feed Assembly (stock or smooth)
- Wedge Assembly, 1-1/4
- Wedge Assembly, 5-1/4
- Draw Rod Assembly, 3/4
- Draw Rod Assembly, 1-1/4
- Draw Rod Assembly, 5-1/4
- G-rib Kit (G-04 - G-06)
- H-rib Kit (H-01 - H-08)
- Tool Post Assembly
- Insert Holder Assembly, Straight
- Insert Holder Assembly, Double Pocketed
- Insert Screws
- Hand Tool Set
- User Manual
- Case Assembly

## Safety precautions

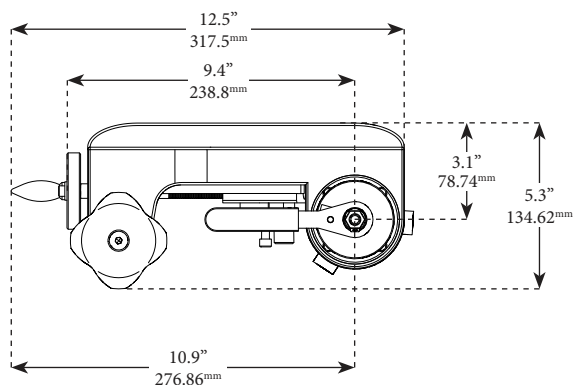
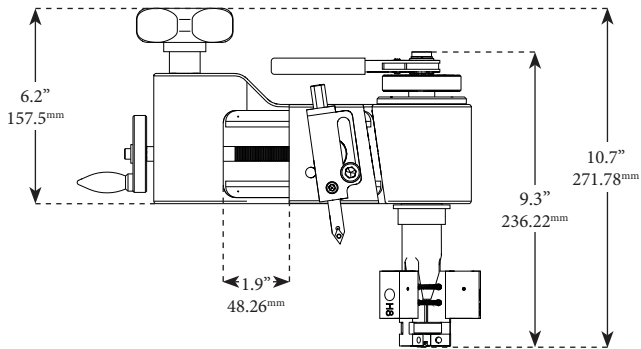
### Precautions and use of personal protective equipment

1. Power tools are not insulated for coming into contact with electric power sources.
2. Tool must not be used in an explosive atmosphere.
3. Do not use tool in a manner other than stated. Use other than stated in the instructions is forbidden.
9. Personal protective garments should include but not be limited to...
  - a. Safety glasses
  - b. Work gloves
  - c. Work boots, or shoes
  - d. Protective clothing
  - e. Hearing protection when operator is exposed to long periods of use
10. Have all nearby persons wear safety glasses with side shields.

### Special safety precautions

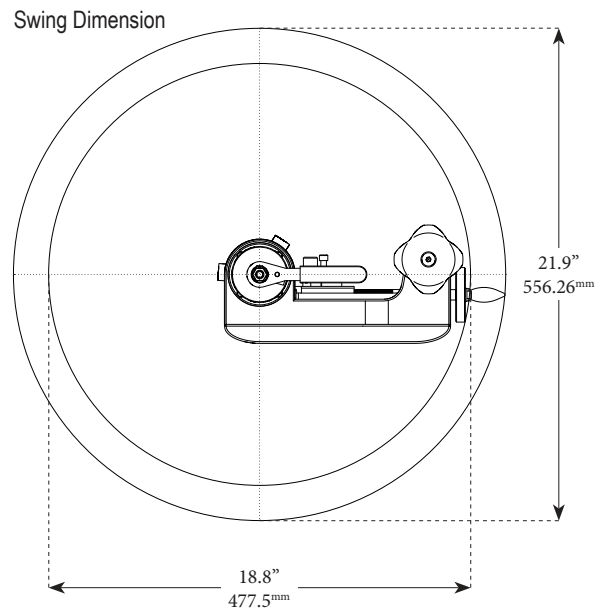
2. Do not modify or defeat safety devices.
3. Cutting blades are sharp and can cause serious injury. Use caution when handling.
4. Chips can be hot and sharp. Be careful when clearing from tool.
5. Moving and stationary parts can pinch or cause serious injury. Pay extra attention to rotating cutting blades as they cannot be adequately guarded.
6. During use, machinery may separate, lurch or fall.

### Tool limits



**CLAMPING RANGE: 0.895" - 10.391"**

**CUTTING RANGE: 0.900" - 12.750"**



### Explanation of symbols



Caution (refer to accompanying documents).



Safety glasses must be worn.



Protective gloves, cutting blades and chips can be hot and sharp.



Work boots, or shoes



Protective clothing



Hearing protection



Pinch points

### Disclaimer

1. If the equipment is used in a manner not specified by ESCO Tool, the protection provided by the equipment may be impaired.

### Operating ergonomics

1. Tool must be mounted at a reasonable working height.
2. Tool may be used in any orientation.
3. Operator must be in a position not to be injured as the machinery may separate, lurch or fall. Operator must have both feet on a stable platform. Reaching or leaning is not acceptable operating ergonomics.

### Operating Instructions

#### Identification of operating controls and their use

(All tools have similar manner controls except as noted.)

## Feed knob

- Used to rotate the tool and feed the carriage.
- Pull up to disengage from feed/positioning knob.

## Positioning knob

- Used to position carriage on feed.

## Gear head

- Houses all internal components.

## Feed

- Used to feed carriage.
- Can be changed for different finishes.

## Tool post

- Holds the insert holder and is mounted to the carriage.

## Insert holder clamp screw

- Used to lock Insert holder in place, once it has been adjusted.

## Insert holder

- Holds the insert and is actuated with indexing nut.

## Insert

- Used to cut material from flange surfaces.

## Draw rod

- Actuates the clamping mechanism.

## Clamp ribs/pads

- Used to mount the tool to the inside diameter of facing application.

## Wedge

- Clamps to the mandrel and provides a surface for the clamp ribs to ride on.

## Clamp knob

- Used to actuate clamping mechanism for rough/quick actuating.

## Tool post positioning screw

- Used to mount tool post to the carriage after rough adjustment into position.

## Indexing nut

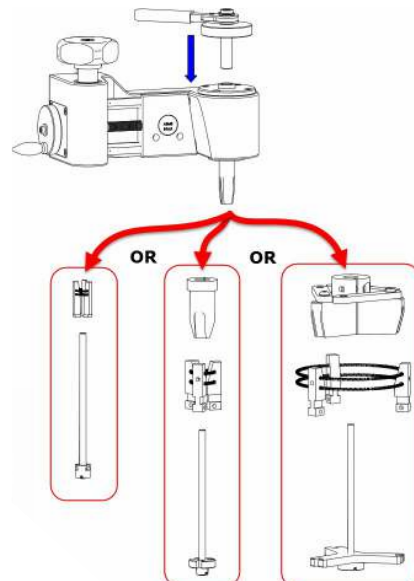
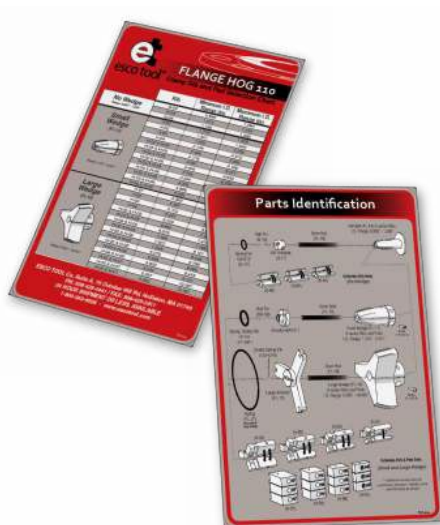
- Used to advance/extract insert holder for fine adjustments.

## Clamp wrench

- Used to tighten clamping mechanism, once tool is positioned and centered.

## Selection of proper tooling

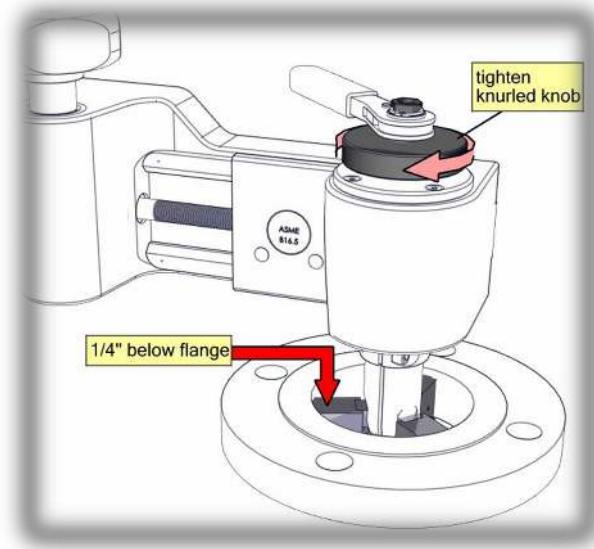
1. Measure I.D. of flange.
2. Consult "Clamp Rib & Pad Selection Chart".
  - a. This provides all information necessary for fitting tool to flange.
3. Assemble hardware selected from chart.
  - a. See "Parts Identification" side of chart for assistance in assembling components.



## Mounting the tool to the work

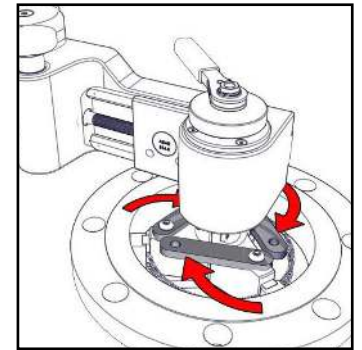
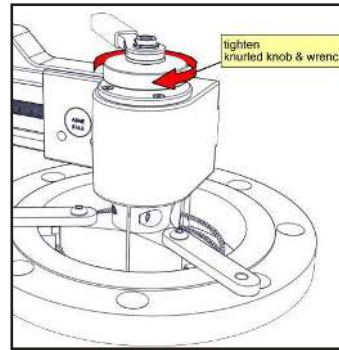
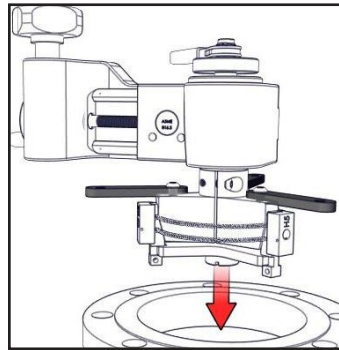
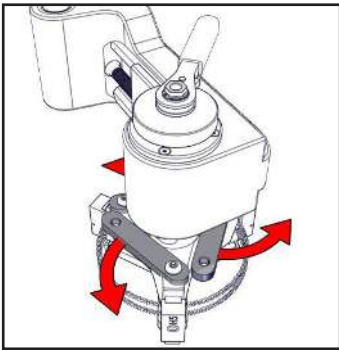
### Mounting without wedge OR with small wedge

1. Insert tool into flange. (see images below)
2. Rotate knurled knob clockwise to tighten ribs.
  - a. As the ribs expand, move the Flange Hog from side-to-side and front-to-back to ensure tool alignment with the pip.
3. Use the clamp wrench to secure tool to flange.



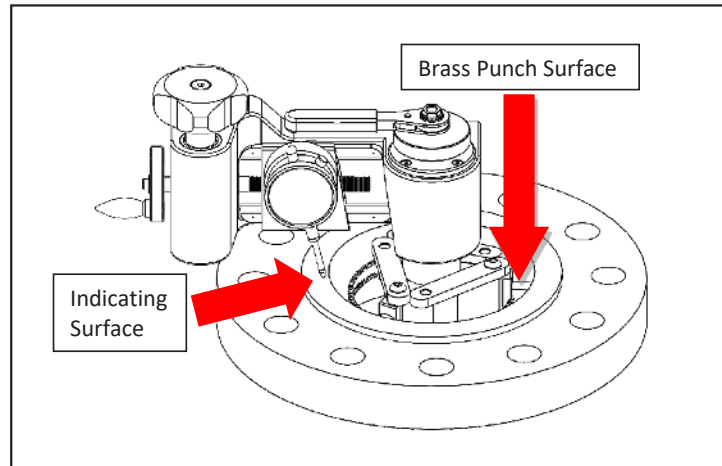
### Mounting with large wedge

1. Confirm that fingers are fastened radial from the mandrel. (see images below)
2. Insert tool into flange.
3. Rotate knurled knob and wrench clockwise to secure tool to flange.
4. Retract flange fingers.



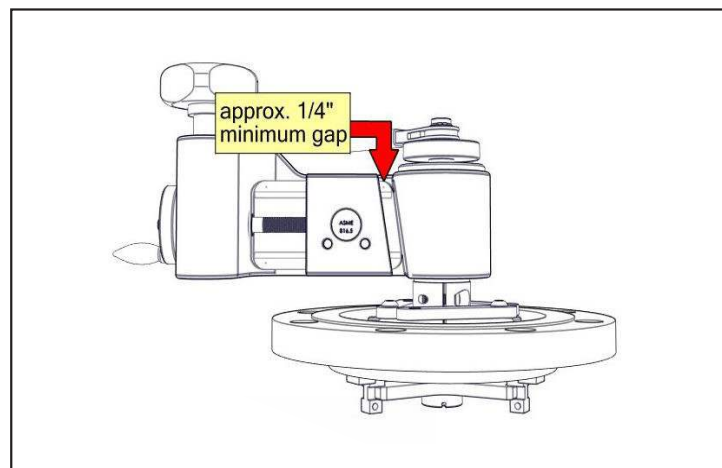
### Leveling

1. Attach indicator to carriage and indicate off of the raised surface of the flange.
2. Rotate the tool and identify high and low areas.
3. Using a brass punch and hammer, lightly hit the tops of the pad(s) closest to high points until indicator reads zero.
4. Check levelness with indicator again. If still unlevel, repeat step 3.
5. Repeat procedure until the indicator reads less than .005" of travel



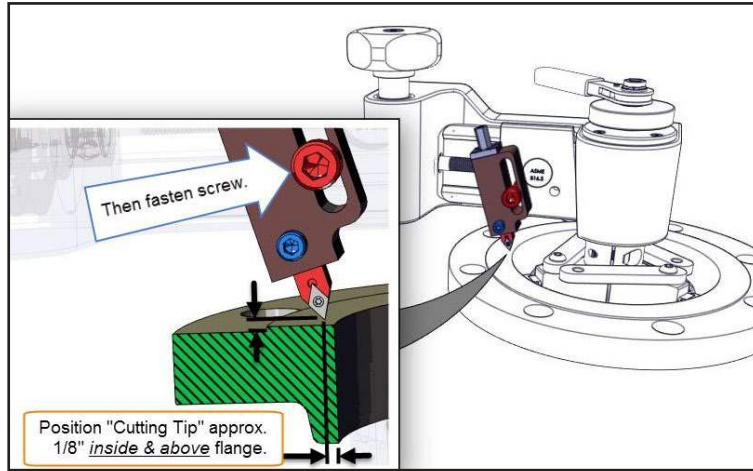
### Operation of tool

1. Start the carriage towards the mandrel side of the tool. Leave roughly a 1/4" gap between the body and the carriage.

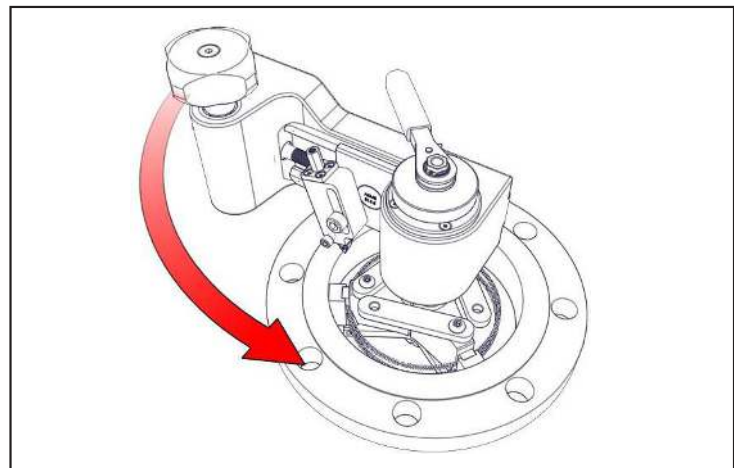
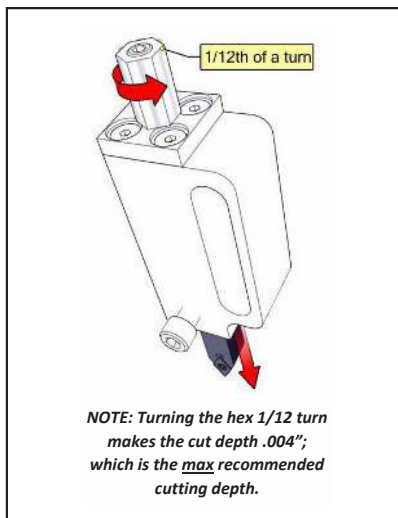


2. Attach the tool post assembly to the carriage, using 1 of the 2 screw holes.
  - a. Make sure the insert holder is at least half way retracted into the tool post.
  - b. When attaching the tool post to the carriage, position the cutting top above and just barely to the inside of the flange raised face. Fasten the screw.
  - c. Using the indexing nut (turning counter clockwise), index the tip towards the flange.
    - i. cutting tip should lightly scratch flange raised face; not dig into surface.
3. SWING TEST: Swing tool 1x in order to verify the tip of the tool does not cut the face of the flange.

*NOTE: If tool cuts flange, tool should be reattached / leveled to flange. Then repeat swing test.*



4. Once swing test is confirmed, move the carriage to most inside position so that the cutting tip is no longer above the raised face, but is above the inside diameter.
5. Turn indexing nut counter clockwise 1/12 of a turn. (see image)
6. Tighten screw to lock insert holder in place, once depth is set.
7. Face flange by rotating tool in a counter clockwise continuous motion.
  - a. NEVER STOP OR REVERSE DIRECTION UNTIL FLANGE HAS BEEN FULLY FACED.



## Maintenance and servicing

### Regular cleaning and lubrication

3. Lubrication for storage
  - b. Wipe tool down using soft cloth removing all dirt, grease, oil and chips.
  - c. Lightly coat tool with rust preventive.

### User service

1. No special training is required for tool maintenance.
  - a. Factory service or assistance is always available, contact us at the numbers below.
  - b. Complete drawings and parts lists are provided in section six.
    - i. No special tools are required to perform complete service.

### Servicing by manufacturer or agent

1. Factory service, return the tool to the Factory address listed below.
2. Agent service, if applicable return tool to the Agent listed below.
  - a. If unsure of Agent contact the factory.

## CLAMP RIB CHART

MANDREL	CLAMP RIB ASM	I.D. RANGE (IN)	I.D. RANGE (MM)
FL-13 (MANDREL, 3/4)	G-04	.90 - 1.09	22.73 - 27.79
	G-05	1.02 - 1.22	25.78 - 30.89
	G-06	1.12 - 1.34	28.91 - 34.01
FL-11 (WEDGE, 1-1/4)	H-01	1.32 - 1.63	33.40 - 41.38
	H-02	1.52 - 1.94	38.63 - 49.28
	H-03	1.83 - 2.26	46.43 - 57.30
	H-04	2.15 - 2.58	54.56 - 65.41
	H-02 & H-05	2.46 - 2.88	62.59 - 73.23
	H-03 & H-05	2.78 - 3.20	70.51 - 81.26
	H-04 & H-05	3.09 - 3.51	78.51 - 89.33
	H-02 & H-08	3.41 - 3.83	86.49 - 97.36
	H-03 & H-08	3.72 - 4.15	94.59 - 105.59
	H-04 & H-08	4.04 - 4.47	102.72 - 113.64
	H-02 & H-06	4.36 - 4.80	110.85 - 121.82
	H-03 & H-06	4.69 - 5.12	119.02 - 130.00
	H-04 & H-06	5.01 - 5.44	127.20 - 138.20
FL-12 (WEDGE, 5-1/4)	H-01	5.30 - 5.57	134.62 - 141.58
	H-02	5.40 - 5.90	137.84 - 149.76
	H-03	5.72 - 6.22	145.34 - 158.01
	H-04	6.05 - 6.55	153.59 - 166.27
	H-02 & H-05	6.33 - 6.83	160.76 - 173.38
	H-03 & H-05	6.65 - 7.15	168.96 - 181.84
	H-04 & H-05	6.98 - 7.48	177.19 - 189.87
	H-02 & H-08	7.30 - 7.80	185.37 - 198.01
	H-03 & H-08	7.62 - 8.12	193.60 - 206.27
	H-04 & H-08	7.95 - 8.45	201.83 - 214.53
	H-02 & H-06	8.27 - 8.77	210.06 - 222.73
	H-03 & H-06	8.60 - 9.09	218.31 - 230.99
	H-04 & H-06	8.92 - 9.42	226.57 - 239.24
	H-02 & H-07	9.24 - 9.74	234.75 - 247.42
	H-03 & H-07	9.57 - 10.07	243.00 - 255.70
H-04 & H-07	9.89 - 10.39	251.26 - 263.93	

## FLANGE HOG INSERT



## KIT CONTENTS

PART#	DESCRIPTION
<b>FL-110</b>	<b>FLANGE HOG 110, COMPLETE KIT</b>
FL-201-01	(1) GEAR HEAD ASM, FL
FL-26-01	(1) FEED ASM, STOCK
FL-11	(1) WEDGE ASM, 1-1/4
FL-12	(1) WEDGE ASM, 5-1/4
G-17-10	(1) DRAW ROD ASM, 3/4
MG-57-10	(1) DRAW ROD ASM, 1-1/4
FL-15-01	(1) DRAW ROD ASM, 5-1/4
GRK-04-06	(1) G-RIB KIT (G-04 - G-06)
FHRK-01-08	(1) H-RIB KIT, (H-01 - H-08)
FL-37	(1) TOOL POST ASM
FL-40	(1) INSERT HOLDER ASM, STR
FL-55	(1) INSERT HOLDER ASM, DP
FL-06	(2) INSERT SCREW
300-FL-01	(1) HAND TOOL SET, FL
	(1) USER MANUAL
CC18-FL-01	(1) CASE ASM, FL

## PACKAGING ASSEMBLIES

**PART #:** CC18-FL-01

**DESCRIPTION:** CASE ASM, FL

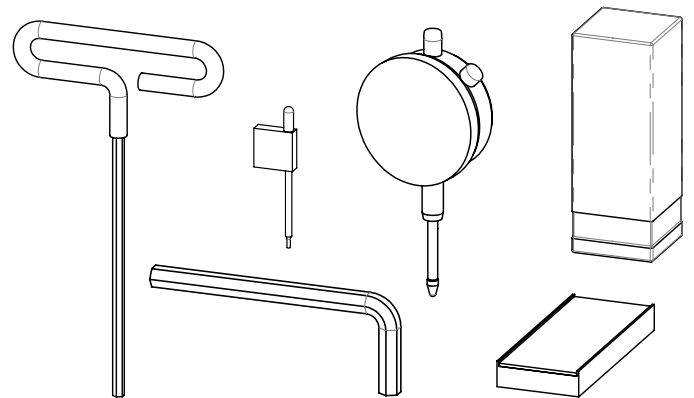
ITEM #	QTY	PART #	DESCRIPTION
1	1	CC18	CASE, CC18
2	1	FP-CC18-01	FOAM, TOP
3	1	FP-CC18-02	FOAM, FL
4	1	FLD.002A	LBL, FL CASE TOP
5	1	FLD.003A	LBL, FL CASE BOT

## HAND TOOL SETS

**PART #:** 300-FL-01

**DESCRIPTION:** HAND TOOL SET, FL

ITEM #	QTY	PART #	DESCRIPTION
1	1	281-0012	TH HEX (3/16)
2	1	278-0808	HEX KEY (8MM)
3	1	287-0007	TORX KEY (T7)
4	1	FL-48A	DIAL INDICATOR (MAG-BACK)
5	1	FL-09	INSERT HOLDER CASE
6	1	FLD.004	SIZING CHART
7	1	FL-09	INSERT CASE, FL-05

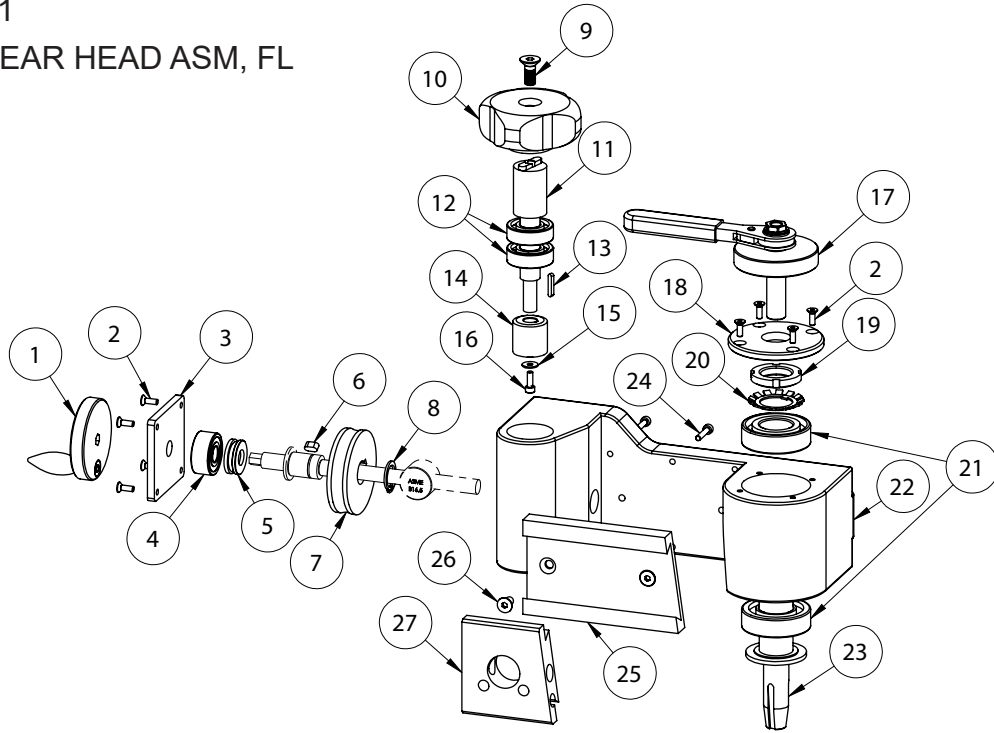


# FLANGE HOG 110

## ASSEMBLY DRAWINGS - GEAR HEAD

**PART #:** FL-201-01

**DESCRIPTION:** GEAR HEAD ASM, FL



ITEM #	QTY	PART #	DESCRIPTION
1*	1	FL-24	POSITIONING KNOB ASM
2	8	112-5812	FHCS (M4-0.7 X 12)
3	1	FL-25	COVER PLATE
4	1	311-049	BALL BEARING
5	1	318-007	THRUST BEARING ASM
6	1	FL-22	KEY
7	1	FL-30	GEAR
8	1	190-018	EXTERNAL RETAINING RING
9	1	112-6320	FHCS (M8-1.25 X 20)
10	1	FL-21	KNOB
11	1	FL-20	KNOB SHAFT
12	2	311-017	BALL BEARING
13	1	FL-19	KEY
14	1	FL-31	GEAR
15	1	161-005	WASHER
16	1	110-5812	SHCS (M4-0.7 X 12)
17*	1	FL-16-01	CLAMP WRENCH ASM
18	1	FL-32	CAP
19	1	FL-50	LOCK NUT
20	1	FL-51	LOCK WASHER
21	2	314-001	ANGULAR CONTACT BEARING
22	1	FL-33	HOUSING
23	1	FL-13	MANDREL
24	6	110-5820	SHCS (M4-0.7 X 20)
25	1	FL-56	LINEAR GUIDE
26	2	110-6112	SHCS (M6-1 X 12)
27*	1	FL-36	CARRIAGE ASM

**PART #:** FL-201-01

**DESCRIPTION:** GEAR HEAD ASM, FL

\* **PART #:** FL-24  
**DESCRIPTION:** POSITIONING KNOB ASM

ITEM #	QTY	PART #	DESCRIPTION
1	1	113-6120	LHCS (M6-1 X 20)
2	1	FL-24A	POSITIONING KNOB BASE
3	1	FL-24B	POSITIONING KNOB HANDLE
4	1	161-006	WASHER
5	1	110-6008	SHCS (M5-0.8 X 8)

\* **PART #:** FL-16-01  
**DESCRIPTION:** CLAMP WRENCH ASM

ITEM #	QTY	PART #	DESCRIPTION
1*	1	211-059	EXTERNAL RETAINING RING
2	1	G-64	WRENCH ASM
3	4	FL-16	DRAW ROD NUT (5/16-18)
4	1	165-035	WASHER

\* **PART #:** G-64  
**DESCRIPTION:** WRENCH ASM

ITEM #	QTY	PART #	DESCRIPTION
1	1	G-64B	WRENCH
2	1	G-64A	GRIP

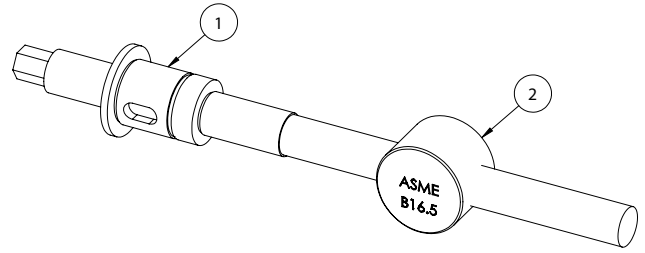
\* **PART #:** FL-36  
**DESCRIPTION:** CARRIAGE ASM

ITEM #	QTY	PART #	DESCRIPTION
1	1	FL-36A	CARRIAGE
2	2	115-5810	FBHCS (M4-0.7 X 10)
3	1	FL-57	GIBB

## PART #: FL-26-01

### DESCRIPTION: FEED ASM, STOCK

FINISH: 250-500 MICROINCHES AVERAGE ROUGHNESS

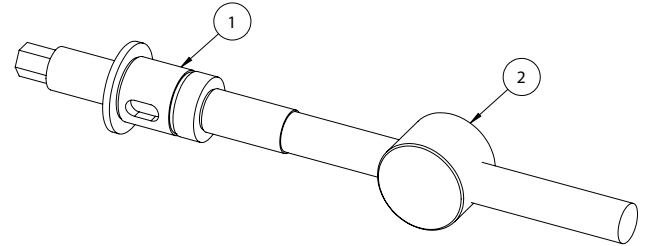


ITEM #	QTY	PART #	DESCRIPTION
1	1	FL-26	FEED SHAFT, STOCK
2	1	FL-28	FEED NUT, STOCK

## PART #: FL-27-01

### DESCRIPTION: FEED ASM, SMOOTH

FINISH: 125-250 MICROINCHES AVERAGE ROUGHNESS

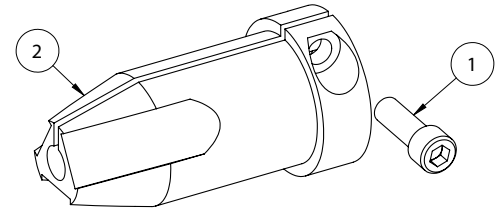


ITEM #	QTY	PART #	DESCRIPTION
1	1	FL-27	FEED SHAFT, SMOOTH
2	1	FL-29	FEED NUT, SMOOTH

## PART #: FL-11

### DESCRIPTION: WEDGE ASM, 1-1/4

DRAW ROD ASM: MG-57-10  
RIB SERIES: H-RIBS  
USED ON FL-13 MANDREL

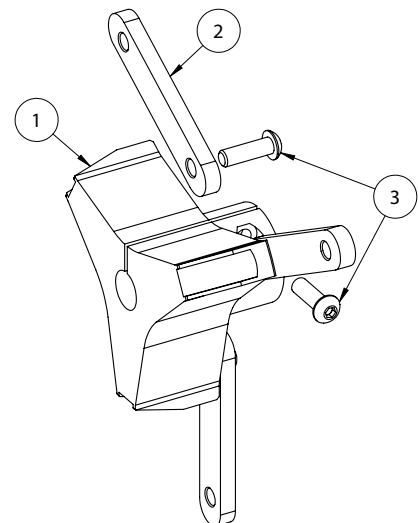


ITEM #	QTY	PART #	DESCRIPTION
1	1	110-2012	SHCS (1/4-20 X 3/4)
2	1	FL-11A	WEDGE, 1-1/4

## PART #: FL-12

### DESCRIPTION: WEDGE ASM, 5-1/4

DRAW ROD ASM: FL-15-01  
RIB SERIES: H-RIBS  
USED ON FL-13 MANDREL



ITEM #	QTY	PART #	DESCRIPTION
1	1	FL-12A	WEDGE, 5-1/4
2	3	FL-14	ALIGNMENT FINGER
3	4	111-2216	BHCS (5/16-18 X 1)

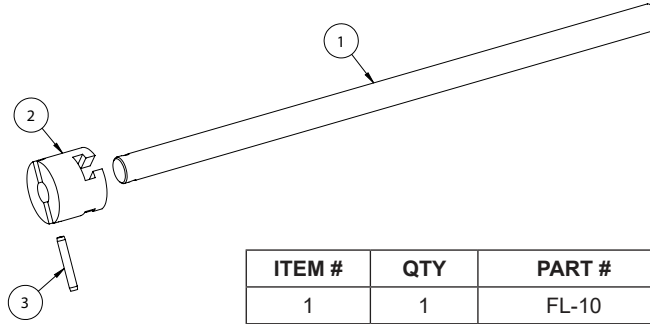
# FLANGE HOG 110

## ASSEMBLY DRAWINGS - DRAW RODS

**PART #:** G-17-10

**DESCRIPTION:** DRAW ROD ASM, 3/4

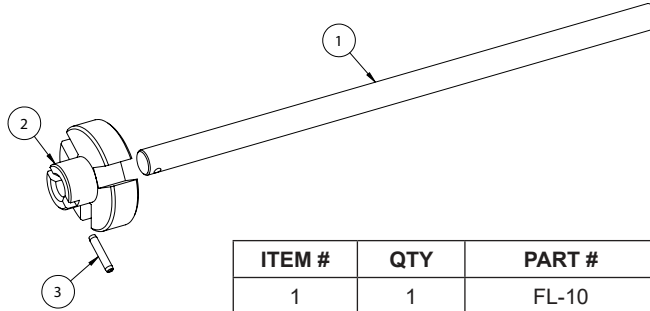
RIB SERIES: G-RIBS  
USED ON FL-13 MANDREL



ITEM #	QTY	PART #	DESCRIPTION
1	1	FL-10	DRAW ROD (5/16-18 X 7)
2	1	G-17	ACTUATOR, 3/4
3	1	134-4210	SSP (3/32 X 5/8)

**PART #:** MG-57-10

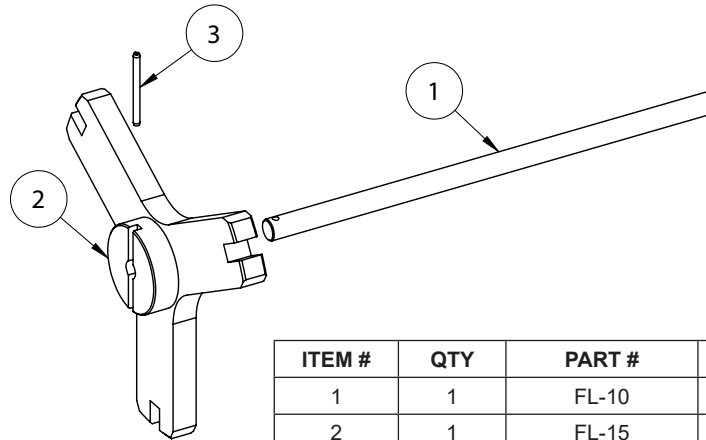
**DESCRIPTION:** DRAW ROD ASM, 1-1/4



ITEM #	QTY	PART #	DESCRIPTION
1	1	FL-10	DRAW ROD (5/16-18 X 7)
2	1	MG-57	ACTUATOR, 1-1/4
3	1	134-4208	SSP (3/32 X 1/2)

**PART #:** FL-15-01

**DESCRIPTION:** DRAW ROD ASM, 5-1/4

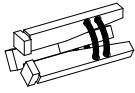


ITEM #	QTY	PART #	DESCRIPTION
1	1	FL-10	DRAW ROD (5/16-18 X 7)
2	1	FL-15	ACTUATOR, 5-1/4
3	1	134-4218	SSP (3/32 X 1-1/8)

## G-RIB ASSEMBLIES

**PART #:** G-04

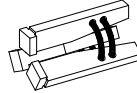
**DESCRIPTION:** CLAMP RIB ASM (.875-1.030)



QTY	PART #	DESCRIPTION
3	G-04_PART	CLAMP RIB
2	G-14	SPRING (G-04 - G-13)

**PART #:** G-05

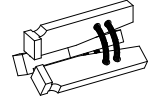
**DESCRIPTION:** CLAMP RIB ASM (1.000-1.155)



QTY	PART #	DESCRIPTION
3	G-05_PART	CLAMP RIB
2	G-14	SPRING (G-04 - G-13)

**PART #:** G-06

**DESCRIPTION:** CLAMP RIB ASM (1.125-1.280)

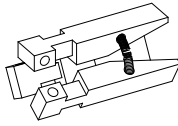


QTY	PART #	DESCRIPTION
3	G-06_PART	CLAMP RIB
2	G-14	SPRING (G-04 - G-13)

## H-RIB/PAD ASSEMBLIES

**PART #:** H-01

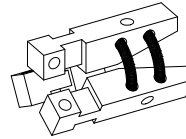
**DESCRIPTION:** CLAMP RIB ASM (1.250-1.600)



QTY	PART #	DESCRIPTION
3	H-01_PART	CLAMP RIB
1	H-14B	SPRING (H-01 - H-04)

**PART #:** H-02

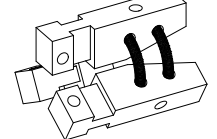
**DESCRIPTION:** CLAMP RIB ASM (1.525-1.925)



QTY	PART #	DESCRIPTION
3	H-02_PART	CLAMP RIB
2	H-14B	SPRING (H-01 - H-04)

**PART #:** H-03

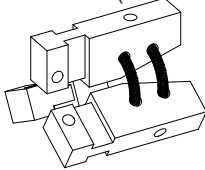
**DESCRIPTION:** CLAMP RIB ASM (1.850-2.250)



QTY	PART #	DESCRIPTION
3	H-03_PART	CLAMP RIB
2	H-14B	SPRING (H-01 - H-04)

**PART #:** H-04

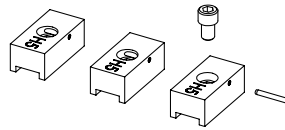
**DESCRIPTION:** CLAMP RIB ASM (2.175-2.575)



QTY	PART #	DESCRIPTION
3	H-04_PART	CLAMP RIB
2	H-14B	SPRING (H-01 - H-04)

**PART #:** H-05

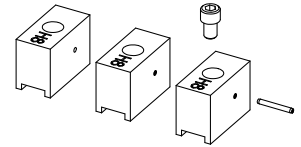
**DESCRIPTION:** CLAMP PAD SET



QTY	PART #	DESCRIPTION
3	H-00-05	CLAMP PAD ASM
	134-4212	SSP (3/32 X 3/4)
	110-2006	SHCS (1/4-20 X 3/8)

**PART #:** H-08

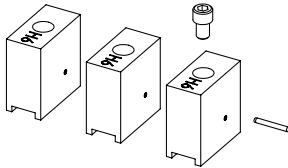
**DESCRIPTION:** CLAMP PAD SET



QTY	PART #	DESCRIPTION
3	H-00-08	CLAMP PAD ASM
	134-4212	SSP (3/32 X 3/4)
	110-2006	SHCS (1/4-20 X 3/8)

**PART #:** H-06

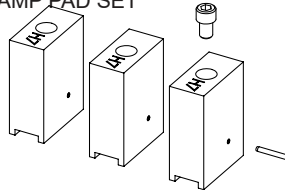
**DESCRIPTION:** CLAMP PAD SET



QTY	PART #	DESCRIPTION
3	H-00-06	CLAMP PAD ASM
	134-4212	SSP (3/32 X 3/4)
	110-2006	SHCS (1/4-20 X 3/8)

**PART #:** H-07

**DESCRIPTION:** CLAMP PAD SET



QTY	PART #	DESCRIPTION
3	H-00-07	CLAMP PAD ASM
	134-4212	SSP (3/32 X 3/4)
	110-2006	SHCS (1/4-20 X 3/8)

## RIB KITS

**PART #:** GRK-04-06

**DESCRIPTION:** G-RIB KIT (G-04 - G-06)

ITEM #	QTY	PART #	DESCRIPTION
1	1	G-04	CLAMP RIB ASM (.875-1.030)
2	1	G-05	CLAMP RIB ASM (1.000-1.155)
3	1	G-06	CLAMP RIB ASM (1.125-1.280)

**PART #:** FLRK-01-08

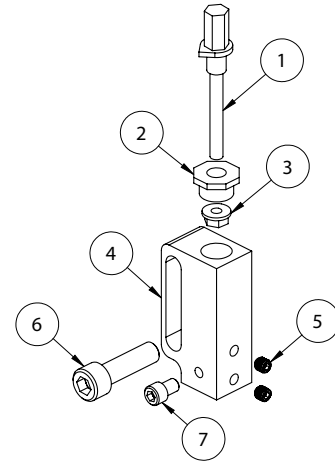
**DESCRIPTION:** H-RIB KIT, FL (H-01 - H-08)

ITEM #	QTY	PART #	DESCRIPTION
1	1	H-01	CLAMP RIB ASM (1.250-1.600)
2	1	H-02	CLAMP RIB ASM (1.525-1.925)
3	1	H-03	CLAMP RIB ASM (1.850-2.250)
4	1	H-04	CLAMP RIB ASM (2.175-2.575)
5	1	H-05	CLAMP PAD SET
6	1	H-06	CLAMP PAD SET
7	1	H-07	CLAMP PAD SET
8	1	H-08	CLAMP PAD SET
9	4	H-14B	SPRING (H-01 - H-04)
10	4	FL-17	SPRING

**PART #:** FL-37

**DESCRIPTION:** TOOL POST ASM

ITEM #	QTY	PART #	DESCRIPTION
1	1	FL-37B	INDEX THREAD
2	1	FL-37D	TOOL POST CAP
3	1	176-061	LOCK NUT
4	1	FL-37A	TOOL POST HOUSING
5	2	129-2104NL	SHSS (1/4-28 X 1/4)
6	1	110-6535	SHCS (M10-1.5 X 35)
7	1	110-2006	SHCS (1/4-20 X 3/8)

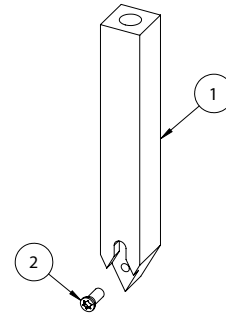


**PART #:** FL-40

**DESCRIPTION:** INSERT HOLDER ASM, STR

INSERT: FL-05  
ATTACHES TO FL-37 TOOL POST

ITEM #	QTY	PART #	DESCRIPTION
1	1	FL-40A	INSERT HOLDER, STR
2	3	FL-06	INSERT SCREW

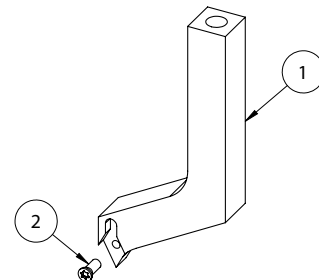


**PART #:** FL-55

**DESCRIPTION:** INSERT HOLDER ASM, DP

INSERT: FL-05  
ATTACHES TO FL-37 TOOL POST

ITEM #	QTY	PART #	DESCRIPTION
1	1	FL-55A	INSERT HOLDER, DP
2	3	FL-06	INSERT SCREW



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