



Vertical Mount Ashtray Assembly Manual for -2 Style.

(A0.75BLK-2S Shown)

Document Number	CCC-AM-01VMA2 RevC - (CCQS 912)
Affected Items:	Custom Cupholders' Vertical Mount Ashtrays
Affected Part Numbers:	A0.75BLK-2, A0.75BLK-2S, A0.50BLK-2S

NOTE:

**THESE INSTRUCTIONS SHOULD BE READ THOROUGHLY
BEFORE BEGINNING ASSEMBLY OF ANY OF THE
VERTICAL MOUNT ASHTRAYS.**

A. Parts List

Item	Parts in each kit (P/N)	A0.75BLK-2	A0.75BLK-2S	A0.50BLK-2S	Description	Material
Ashtray Main Components						
1	A0.75BLK-2_FRNT1	1	-	-	Front Receptacle	6061-T6
1	A0.75BLK-2_FRNT2	-	1	1	Front Receptacle (shown)	6061-T6
2	A0.75BLK-2_BCK1	1	-	-	Back Receptacle	6061-T6
2	A0.75BLK-2_BCK2	-	1	1	Back Receptacle (shown)	6061-T6
3	A0.75BLK-2_CS1	1	1	1	Case	6061-T6
4	A0.50BLK-2_BZL			1	Bezel – Included in A0.50BLK-2(S) kits only (not shown)	6061-T6
Parts Bag						
5	A0.75BLK-1_RB1-PINMOD	1	1	1	Bottom Rotating Pin Modified 5-40 x 3/16 socket head screw	18-8 SS,
6	4-40 x 3/16 socket head set screw, dog point (black)	1	1	1	Top Rotating Pin	Steel, Black Oxidized
7	4-40 x 3/16 socket head set screw	1	1	1	Side Stop Pin	18-8 SS
8a	NAS 620	2	2	2	Washer - NAS 620 (Thick, approx. 0.028")	18-8 SS
8b	NAS 620	2	2	2	Washer - NAS 620 (Thin, approx. 0.014")	18-8 SS
9	SPRCLP_.020-.955-.745	1	1	1	Bottom Spring Clip	0.020 301 SS
10	SPRCLP_.010-.25-.715	2	2	2	Side Spring Clip (Bent Ends)	0.010 301 SS
11	AD32ABS201 Blind Rivet	4	4	4	3/32" Blind Rivet	Aluminum
12	Aluminum Tape	1	1	1	Self-adhesive aluminum tape dot, 3/4" dia.	Aluminum Tape
13	*P/N Sticker (not shown)	1	1	1	Self-adhesive sticker	Sticker
Documents						
14	CCC-AM-01VMA2- Basic	1	1	1	Basic Assembly Layout	Document



Required Tools	Qty
* Hex L-Key Short Arm, 0.050"	1
* Hex L-Key Long Arm, 3/32"	1
Tapered Hand Tap, 4-40	1
** Tapered Hand Tap, 5-40	1
Blind Rivet Tool	1
Detailed Assembly Manual (This Document)	1

Adhesives Required	Qty
Loctite 222 Thread Lock <i>Henkel Corp Industrial</i> <i>1001 Trout Brook Crossing</i> <i>Rocky Hill, CT 06067</i> <i>Phone: (860) 571-5100</i>	A/R

- * Included with order. (Might be packaged separately).
- ** These items are only needed if plating thickness is excessive and tapped holes must be re-tapped.

1) ASSEMBLY INSTRUCTIONS

Final Finish Note:

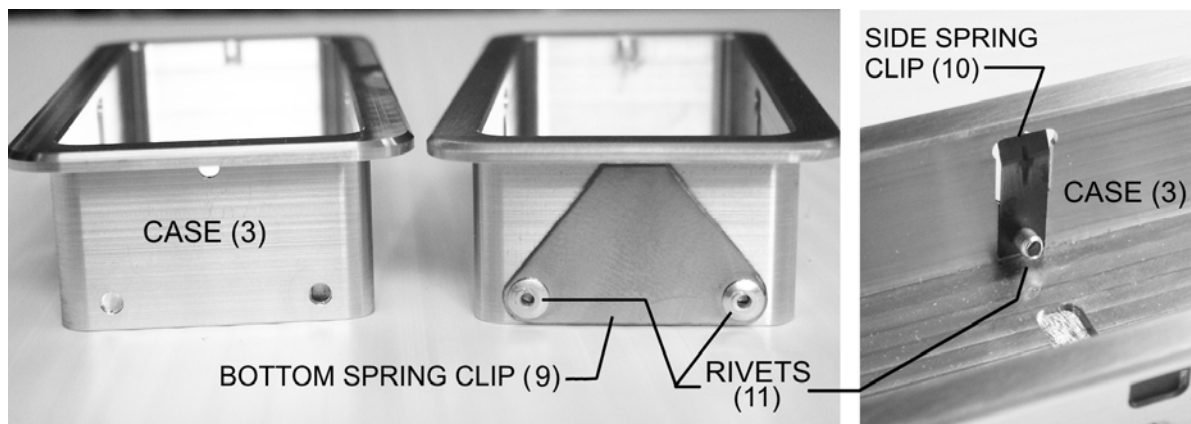
If the ashtray Case (3) is to receive a final finish coating (electroplating, painting, powder coat, etc.) the finishing should be done prior to beginning assembly.

If a final finish coating is applied, the two side holes and the bottom holes that will receive the 3/32" blind rivets may have to be re-drilled with a 0.096 diameter (#41) drill to remove the finish thickness.

1) Case

a) Bottom Spring Clip (9)

Locate the Bottom Spring Clip (9) on the outside end of the Case (3) with the three holes. Align the holes in the clip with the two larger holes on the flat area. Using two included #AD32 Blind Rivets (11) fasten the clip to the outside of the case (see picture #1 below). The clip must cover the smaller hole located immediately beneath the flange but not rub on the underside of the flange.



Picture #1

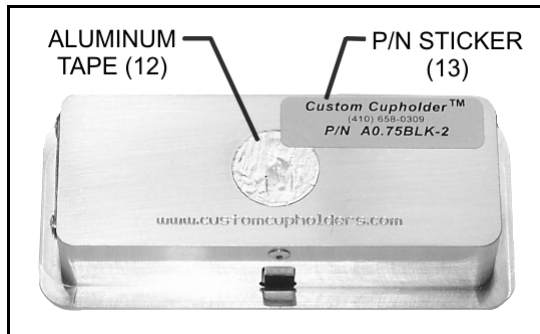
Picture #2

b) Side Spring Clips (10)

From inside the case, align the hole in the Side Spring Clip (10) with the smaller hole in the side of the Case. The bent tabs of the Side Spring Clips must face outward through the cutout. Using an included #AD32 Blind Rivet inserted from the outside of the Case, fasten the Side Spring Clips to the Case (see picture #2 above).

A. ASSEMBLY INSTRUCTIONS (cont.)

- c) Aluminum Foil Tape
Remove the backing and adhere the piece of Aluminum Tape (12) to the back of the Case over top of the center cutout. (see picture #3 below)
- d) Part Number Sticker
Attach the self-adhesive Part Number Sticker to the back of the Case. Or use a permanent marker to imprint the Part Number to the back of Case (see picture #3 below).

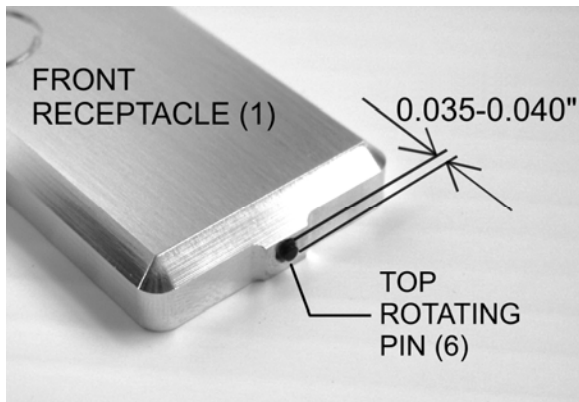


Picture #3

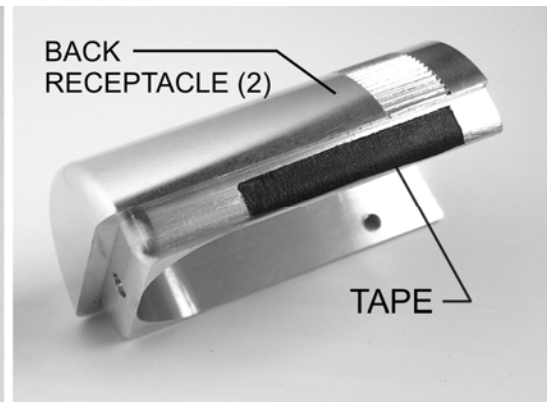
2) **Receptacle Assembly**

Note: If the Front and Back Receptacle pieces have received a final finish coating (electroplate, paint, powder coat, etc.) the holes in the top and bottom of the Front Receptacle (1) may need to be re-tapped. Use a #5-40 hand tap for the bottom hole and a #4-40 for the top hole.

- a) Working from the inside of the Front Receptacle (1), apply Loctite 222 to the Top Rotating Pin (6) threads and install it into the top hole using a 0.050" Hex Key. The dog point of the pin must be on the outside of the Front Receptacle. Adjust until there is between 0.035" and 0.040" of the Pin protruding above the top surface (see picture #4 below).
***Note: Using a thread locker on this part is critical.**



Picture #4

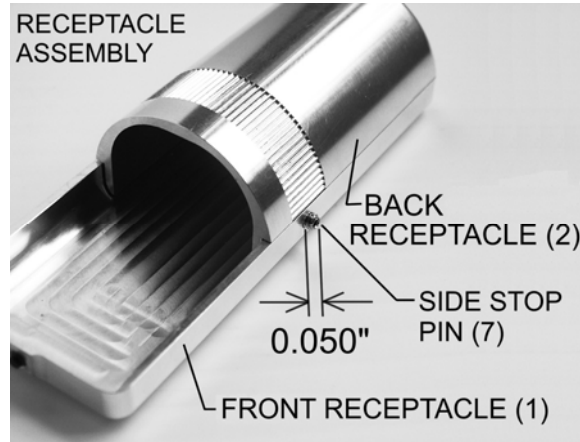


Picture #5

- b) The Front and Back Receptacle pieces have been manufactured with an 0.008" clearance allowance between the surfaces for final finishing thickness. Once the pieces have received their final finishing (electroplating, anodizing, powder coating, etc.) place the two pieces together to gauge how much tolerance gap is left between the sides of the Front and Back Receptacles. Before completing (c) below, it is recommended that in order to center the Back Receptacle inside the Front Receptacle, narrow strips of masking tape be placed on the Back Receptacle side flange that is away from the side hole. (see picture #5 above). This will help hold the two receptacle pieces centered while tapping the side holes and will give a more secure assembly.

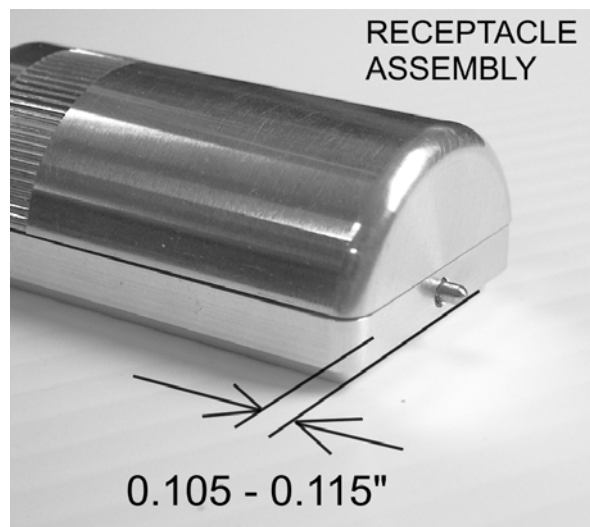
A. ASSEMBLY INSTRUCTIONS (cont.)

- c) After adding the tape side spacer indicated above in item #b, hold the Front and Back Receptacle pieces firmly together with the side holes aligned. Tap through the matched side holes at the same time using a 4x40 tapered hand tap.
- d) Apply a drop of Loctite 222 to the Side Stop Pin (7) threads and install it from the outside of the Receptacle Assembly into the tapped hole created in item #c above. Use a 0.050" hex key. Adjust until there is 0.050" of the pin protruding out of the Receptacle Assembly (see picture #7 below).



Picture #7

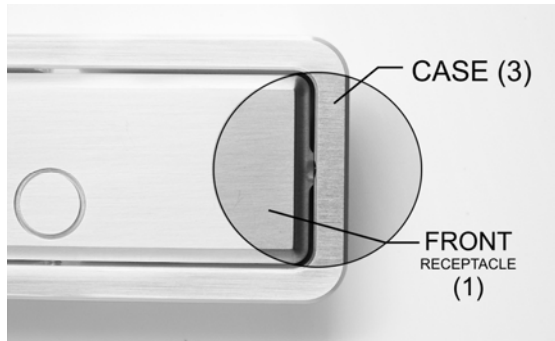
- e) Install the Bottom Rotating Pin (5), along with spacer Washers (8), from the inside of the Receptacle Assembly into the bottom holes using a 3/32" hex key. Initially, use one thick (8a) and one thin (8b) washer for trial fit. (The kit includes four spacer Washers; two thick (8a) and two thin (8b.) to help properly adjust the extension of the Bottom Rotating Pin (5). When installed with the proper thickness of washers, the Rotating Pin should protrude from the Receptacle Assembly 0.105" to 0.115". (see picture #8 below).



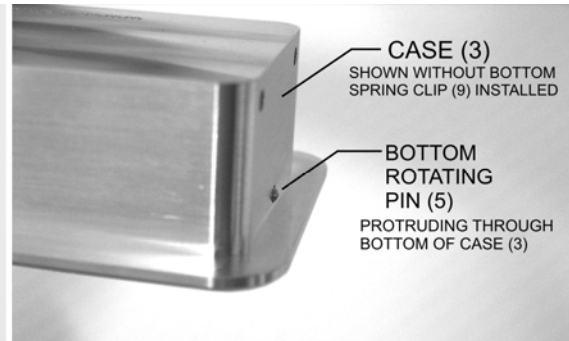
Picture #8

A. ASSEMBLY INSTRUCTIONS (cont.)

- f) When the proper number of spacer washers have been determined trial fit the Receptacle Assembly into the Case. With the Receptacle assembly installed into the Case and the boss at the top of the Front Receptacle resting on the inside of the Case (see picture #9 below), the tip of the Bottom Rotating Pin should be protruding through the bottom of the Case just enough that the Bottom Spring Clip is exerting a slight amount of constant pressure on the tip of the Bottom Rotating Pin (see picture #10 below).



Picture #9



Picture #10

- g) Once it is determined the Bottom Rotating Pin is protruding the required amount remove the Bottom Rotating Pin, apply a drop of Loctite 222 to the Bottom Rotating Pin threads and re-install it along with the required spacer Washers. Do not over tighten.
- h) Reinstall the Receptacle Assembly into the Case to check the following items for proper operation and adjustment.
- i) **Side Spring Clips:**
When rotating the Receptacle Assembly the Side Spring Clips (10) should not be rubbing on the side of the Receptacle Assembly. If they do, bend the clips very slightly toward the outside of the Case.
- ii) **Amount of force need to open and close the Receptacle Assembly:**
The amount of force required to rotate the Receptacle Assembly into the open or closed detent position can be adjusted by screwing the Side Stop Pin (7) in or out. Screwing into the Receptacle Assembly will decrease the force and screwing out will increase the force. Only small adjustments – less than ½ rotation - are necessary to make changes in the required force.
- iii) **Top Rotating Pin:**
During installation and removal of the Receptacle Assembly from the Case the Top Rotating Pin (6) should clear the top inside of the Case by the minimum amount necessary. The amount of extension of the Pin outside of the Front Receptacle as shown in picture #4 should be maintained. Too little extension will cause the Receptacle Assembly not to be securely retained in the Case.

C. OPERATION AND ADJUSTMENT OF RECEPTACLE ASSEMBLY

The Custom Cupholders VMA Ashtrays are precision machined assemblies with close tolerance moving parts and should only require very small adjustment for proper operation.

NOTE: The pictures below may show a different shaped ashtray assembly however the operation will be similar.



Picture #10



Picture #11

1) To install Receptacle Assembly into Case

With the Receptacle Assembly turned partly closed locate the Bottom Receptacle Pin into the hole in the bottom of the Case. Push down on the Receptacle Assembly and tilt inward (see picture #10 above). Make sure the Side Stop Pin is inside the Case opening. Align the Top Receptacle Pin with the hole in the top of the Case and release downward pressure (see picture #11 above).

2) To remove Receptacle Assembly from Case

With the Receptacle Assembly turned almost fully open push down on the Receptacle Assembly to release the Top Rotating Pin from the Case. Tilt the Receptacle inward and remove.

3) Receptacle Assembly Operation and Adjustment

To open or close the Receptacle Assembly, rotate the assembly 180 degrees until it clicks into either the open or closed position. To increase the amount of force needed to rotate the Receptacle Assembly into the open or closed detent position, adjust the Side Stop Pin (7) by unscrewing it. To decrease the force required, screw the stop pin in. Only small adjustments – less than ½ rotation - are necessary to make changes in the required force.

NOTE: The side clips (10) should not rub on the sides of the receptacle assembly during rotation. If this is happening remove the receptacle and gently bend the side clips outward until they clear the knurled area. Re-adjust the Side Stop Pin.

C. INSTALLATION OF ASHTRAY ASSEMBLY INTO VERTICAL PANEL

Because of the many different mounting possibilities, Custom Cupholders Company does not guarantee any specific mounting method. It is the responsibility of the final installer to meet any and all structural and operational requirements.

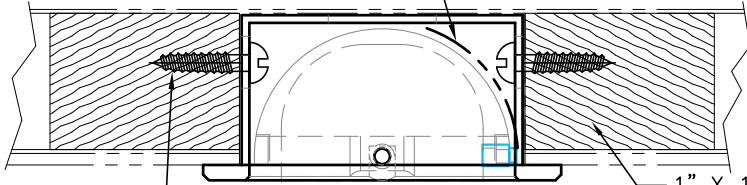
- 1) Cutouts in vertical surface.
 - a) For ashtrays A0.75BLK-2 and A0.75BLK-2S use the back of the Case as a template for the cutout. .
 - b) For ashtrays A0.50BLK-2 use either the back of the Case or the inside of the Bezel as a template for the cutout.
- 2) To allow for proper operation of the three Spring Clips, provide 0.063” localized relief areas in the mounting panel at each of the three Spring Clip locations.
- 3) See drawing number A0.75BLK-2x_INSTALL, “Suggested Installation Method, Vertical Mount Ashtray, at the end of this manual for further reference.

INSTALLATION

THIS ATTACHMENT METHOD IS PROVIDED ONLY AS A REFERENCE. BECAUSE OF THE MANY DIFFERENT POSSIBILITIES FOR MOUNTING CUSTOM CUPHOLDERS COMPANY DOES NOT GUARANTEE THIS OR ANY SPECIFIC MOUNTING METHOD. IT IS THE RESPONSIBILITY OF THE FINAL INSTALLER TO MEET ANY AND ALL STRUCTURAL AND OPERATIONAL REQUIREMENTS.

EPOXY BONDING OF THE BACK OF THE CASE TO THE SKIN OF THE BULKHEAD MAY BE USED IN ADDITION TO SCREW FASTENERS.

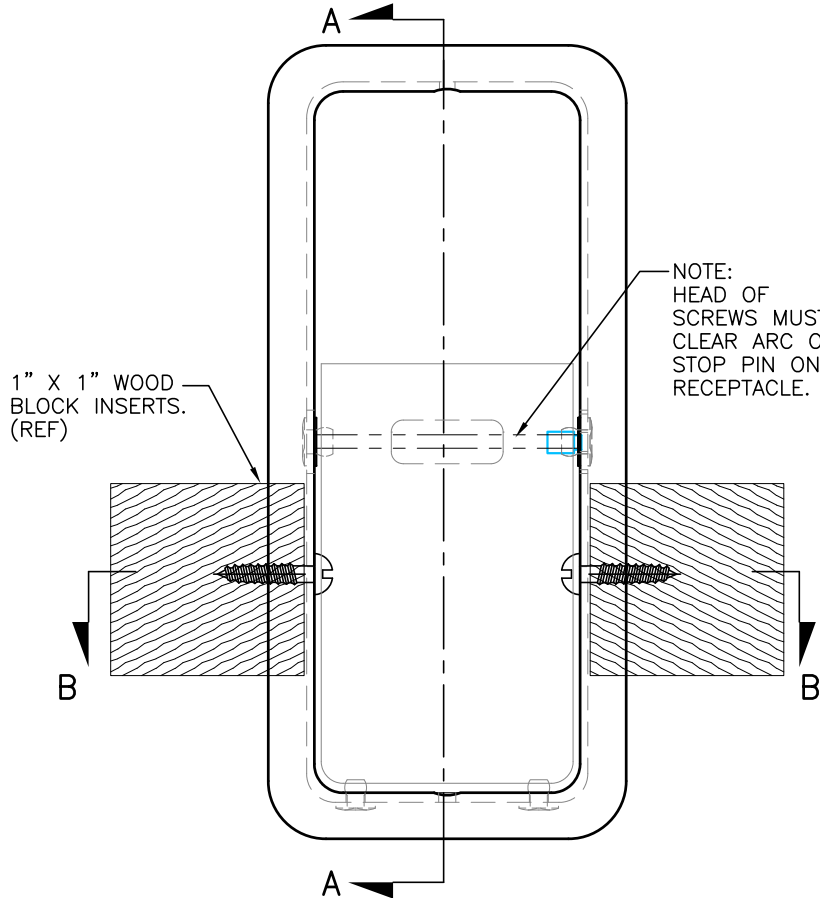
NOTE:
HEAD OF SCREW MUST CLEAR ARC OF STOP PIN ON RECEPTACLE.



#4 x 1/2 WOOD SCREW OVAL HEAD 2 PLCS.

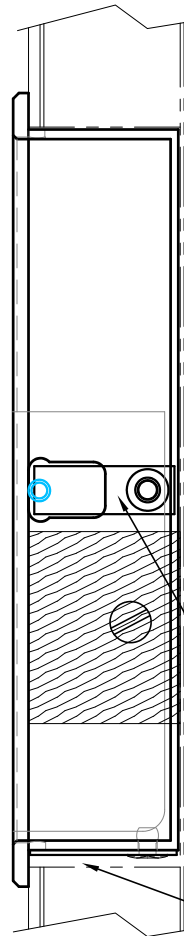
SECTION B-B
SPRING CLIPS AND RIVETS NOT SHOWN FOR CLARITY

1" X 1" WOOD BLOCK INSERTS. THK. A/R. 2 PLCS.



1" X 1" WOOD BLOCK INSERTS. (REF)

NOTE:
HEAD OF SCREWS MUST CLEAR ARC OF STOP PIN ON RECEPTACLE.



NOTE:
ALLOW MIN. .063" LOCALIZED CLEARANCE BETWEEN SPRING CLIPS AND BULKHEAD CUTOUT FOR PROPER OPERATION. 3 PLCS.

SECTION A-A

ALTHOUGH THIS DRAWING DEPICTS A 3/4" THICK VERTICAL PANEL THE MOUNTING CONCEPTS PRESENTED APPLY TO OTHER PANEL THICKNESSES.

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DIMENSIONS IN INCHES
DECIMAL TOLERANCES:
X;.XX = +/- 0.020
X;.XXX = +/- 0.002
ANGLES = +/- 0.50 DEG
RMS FINISH 320/
EXCEPT AS NOTED

DESIGN 06/15/11 Custom Cupholders Company

DRAWN P.O. Box 2020

STRESS North East

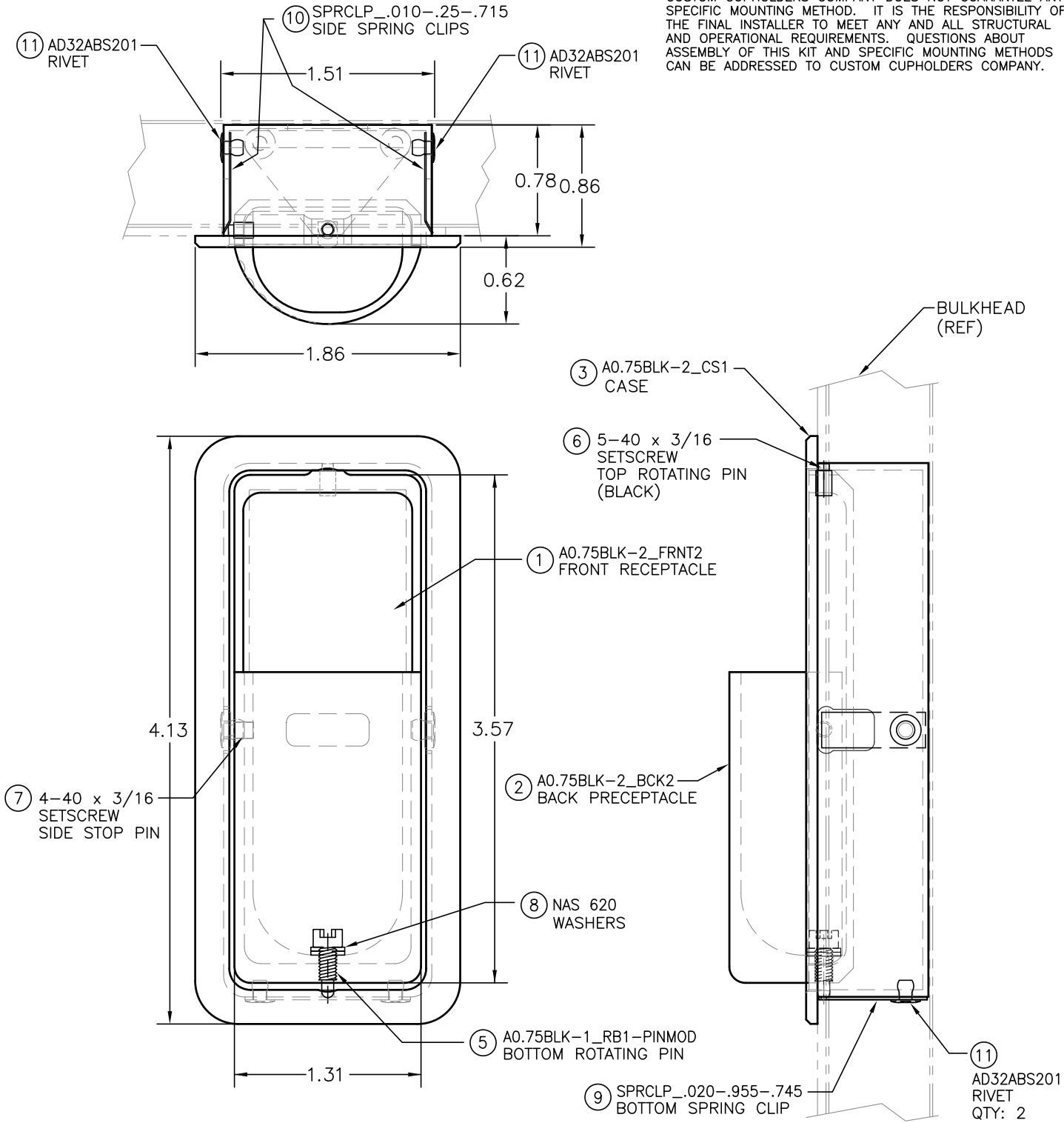
DATE Maryland 21901

SUGGESTED INSTALLATION METHOD
-2 SERIES VERTICAL MOUNT ASHTRAY CASE
(.75 THK. BULKHEAD SHOWN)

SCALE: FULL SHEET: 1 OF 1 DRWG # A0.75BLK-2x_INSTALL

REV: -

CUSTOM CUPHOLDERS COMPANY DOES NOT GUARANTEE ANY SPECIFIC MOUNTING METHOD. IT IS THE RESPONSIBILITY OF THE FINAL INSTALLER TO MEET ANY AND ALL STRUCTURAL AND OPERATIONAL REQUIREMENTS. QUESTIONS ABOUT ASSEMBLY OF THIS KIT AND SPECIFIC MOUNTING METHODS CAN BE ADDRESSED TO CUSTOM CUPHOLDERS COMPANY.



NOTE: RECEPTACLE ASSEMBLY SHOWN IN OPEN POSITION

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 DIMENSIONS IN INCHES
 DECIMAL TOLERANCES:
 X.XX = +/- 0.020
 X.XXX = +/- 0.002
 ANGLES = +/- 0.50 DEG
 RMS FINISH 32
 EXCEPT AS NOTED

DESIGN	06/15/11	Custom Cupholders Company
DRAWN		P.O. Box 2020
STRESS		North East
DATE		Maryland 21901

VERTICAL MOUNT ASHTRAY BASIC ASSEMBLY