



Flip-Lid Ashtray Assembly Manual

(A3.00FLA1-1.50 Shown)

Document Number	CCC-AM-01FLA Rev. L - (CCQS 916)
Affected Items:	Custom Cupholders' Flip-Lid Ashtray Insert
Affected Part Numbers:	A2.75FLA1, A2.88FLA1, A3.00FLA1, A3.25FLA2 and A3.30FLA1. All depths and all bottom cups.

NOTE:

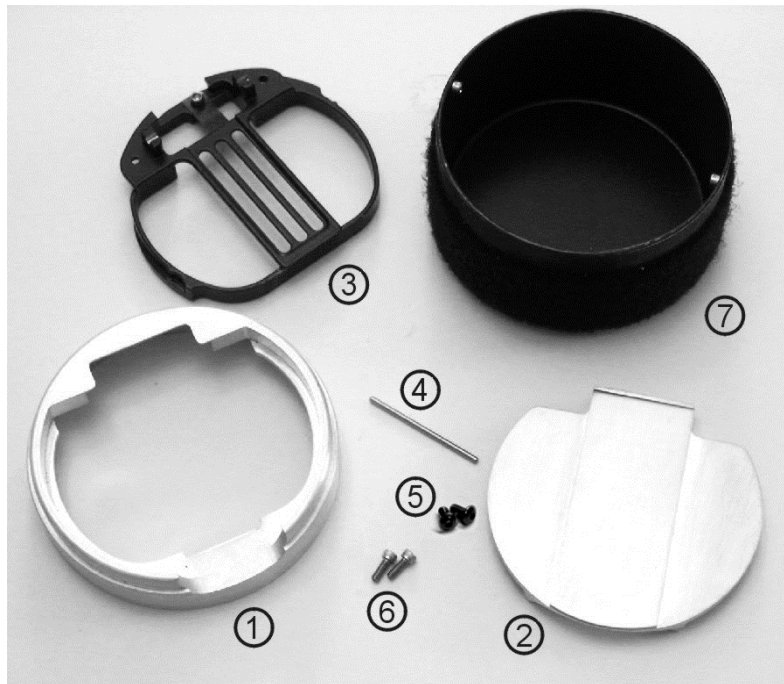
THESE INSTRUCTIONS SHOULD BE READ THOROUGHLY BEFORE BEGINNING ASSEMBLY OF ANY OF THE FLIP-LID ASHTRAYS.

THIS PRODUCT MAY ALSO BE RETURNED TO CUSTOM CUPHOLDERS FOR ASSEMBLY AT NO CHARGE.

A. Parts List

Item	Parts in Kit (P/N)	Qty	Description	Material	KIT# A2.75FLA1	KIT# A2.88FLA1	KIT# A3.00FLA1	KIT# A3.25FLA2	KIT# A3.30FLA1
1	A2.75FP-RIM-1	1	Rim	6061T6	X				
1	A2.88FP-RIM-1	1	Rim	6061T6		X			
1	A3.00FP-RIM-1	1	Rim	6061T6			X		
1	A3.30FP-RIM-1	1	Rim	6061T6				X	X
2	A2.75FP-LID-1	1	Lid	6061T6	X	X			
2	A3.00FP-LID-1	1	Lid	6061T6			X		
2	A3.30FP-LID-1	1	Lid	6061T6				X	X
3	A2.75FP-INS-1ASY	1	Inside Trim Piece Assembly	Assembly	X	X			
3	A3.00FP-INS-1ASY	1	Inside Trim Piece Assembly	Assembly			X		
3	A3.30FP-INS-1ASY	1	Inside Trim Piece Assembly	Assembly				X	X
4	Dowel Pin	1	1/16" Diameter, 1.00" Length. McMaster Carr # 90145A423	SS 18-8	X	X			
4	Dowel Pin	1	1/16" Diameter, 1.25" Length. McMaster Carr # 90145A425	SS 18-8			X	X	X
5	Round Head Slotted Machine Screw	2	Lid Detent Stop Screw. 2-56 x 1/8 or 3/16" Length. McMaster # 97263A703 or 97263A704	Nylon	X	X	X	X	X
6	Socket Head Cap Screw	2	Inside Trim Assy. Attachment Screws. 2-56 x 3/16" or 1/4 Length. McMaster # 92196A076 or 92196A077	SS 18-8	X	X	X	X	X
7	A2.75FP-CUP-1ASY	1	Bottom Cup Assembly. Depth & style indicated in Top Assembly P/N.	Assembly	X				
7	A2.88FP-CUP-1ASY	1	Bottom Cup Assembly. Depth & style indicated in Top Assembly P/N.	Assembly		X			
7	A3.00FP-CUP-1ASY	1	Bottom Cup Assembly. Depth & style indicated in Top Assembly P/N.	Assembly			X		
7	A3.25FP-CUP-2ASY	1	Bottom Cup Assembly. Depth & style indicated in Top Assembly P/N.	Assembly				X	
7	A3.30FP-CUP-1ASY	1	Bottom Cup Assembly. Depth & style indicated in Top Assembly P/N.	Assembly					X

NOTE: Item #7: Other custom Bottom Cup Assemblies may be available and used. P/N's shown are standard items.



NOTES:

Item # 3:

If delivered unassembled refer to CCC-AM-01FLA Addendum 1.a for assembly instructions.

Item # 7:

If delivered unassembled refer to CCC-AM-01FLA Addendum 2.a for assembly instructions.

Required Tools	Supplier
Hex L-Key Long Arm, 5/64"	McMaster-Carr www.mcmaster.com P/N 7122A41
Small standard screwdriver	Customer supplied

Possible Tools & Materials	Supplier
0.0630" Reamer	McMaster P/N 8803A142
Loctite 222 Thread Lock	Henkel Corp Industrial 1001 Trout Brook Crossing Rocky Hill, CT 06067 Phone: (860) 571-5100

B. ASSEMBLY WARNINGS

- 1) **All major components of this ashtray are machined from aluminum. Care should be taken with all fasteners so as not to strip the small, tapped holes in the aluminum or to break off the fastener in the hole. The latter is especially true with the nylon Detent Stop Screws (#5).**

C. IMPORTANT ASSEMBLY NOTES

- 1) Ashtray components are shipped in a loosely assembled state however all parts are easily removable for final finishing of the rim and the lid (electroplating, painting, powder coat, etc). After final finishing follow the instructions below for final assembly and adjustment.
- 2) Any final finishing (electroplating, painting, powder coat, etc.) must be done prior to beginning final assembly.
- 3) If the Lid (#2) receives a final finish coating (electroplating, painting, powder coat, etc.) the hole for the Hinge Pin (#4) should be carefully re-reamed with a 0.0630" reamer to clear away any finish material from inside the hole. During assembly, the Hinge Pin should be a very close tolerance fit into the hole in the lid. Accuracy is critical as too large of a hole will allow slop in the lid operation. Also, the two (2) tapped holes in the back edge of the Lid may have to be re-tapped to clear the applied final finish coating. Use a 2x56 bottoming tap.
- 4) If the Rim (#1) receives a final finish coating (electroplating, painting, powder coat, etc.) the two (2) tapped holes in the underside of the Rim and may have to be re-tapped to clear the finish coating. Use a 2x56 tap bottoming tap. Be very careful re-tapping as the tolerances to the top of the rim are very close. Over-tapping may dimple the metal on the top of the rim.
- 5) Standard finished Inside Trim Piece Assemblies are black powder coated, assembled, and then tested prior to shipping. This is done to ensure each FLA unit will work properly when assembled. It is possible there will be wear marks on the Spring Clips and around the screw holes of the assembly from this procedure. These marks will not be seen once the ashtray unit is assembled.

D. ASSEMBLY INSTRUCTIONS

1) Lid

a) Hinge Pin (#4)

NOTE: Please read Important Assembly Note #3 in section C above.

Insert the Hinge Pin into one of the holes in the side of the lid – see picture #2. Locate the Hinge Pin in the hole until it is centered in the lid and approximately 1/8" of the Hinge Pin sticks out on each side of the Lid (see picture #3). The Hinge Pin should be a very close tolerance slip fit into the hole in the lid. If the pin is a tight fit re-ream. Take great care as the Hinge Pin is a small diameter and can be easily bent by applying too much pressure.

D. ASSEMBLY INSTRUCTIONS (cont.)

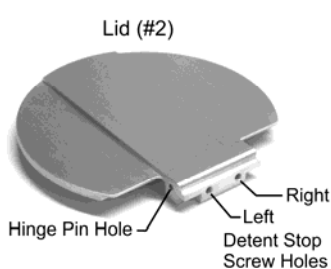
b) Detent Stop Screws (#5)

NOTE: Please read Important Assembly Note #3 in section C above.

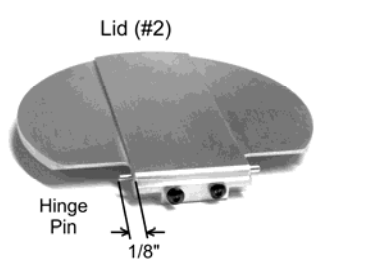
DO NOT FORCE TIGHTEN THE NYLON SCREWS. THEY CAN EASILY BE BROKEN OFF INSIDE THE TAPPED HOLE. Clean the threaded areas or use one of the included shorter screws if necessary

Screw the two Detent Stop Screws into the two holes on the back of the lid – see picture #2
-The right side Stop Screw (see picture #4) controls the opening pressure and should be initially threaded in until it will go in no further. This Stop Screw may be adjusted once the ashtray top pieces are assembled.

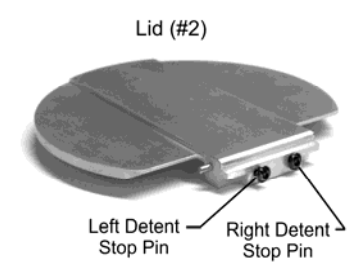
-The left side Stop Screw (see picture #4) controls the hold-open pressure and should be initially set so the underside of the head is approx. 0.040" from the lid surface. This Stop Screw will be adjusted just prior to final assembly of the top pieces.



Picture #2



Picture #3

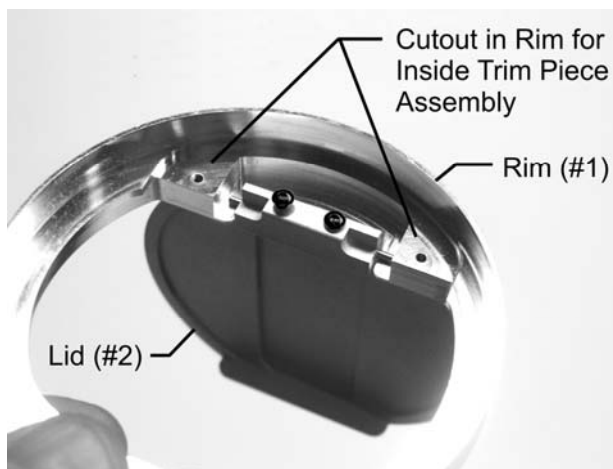


Picture #4

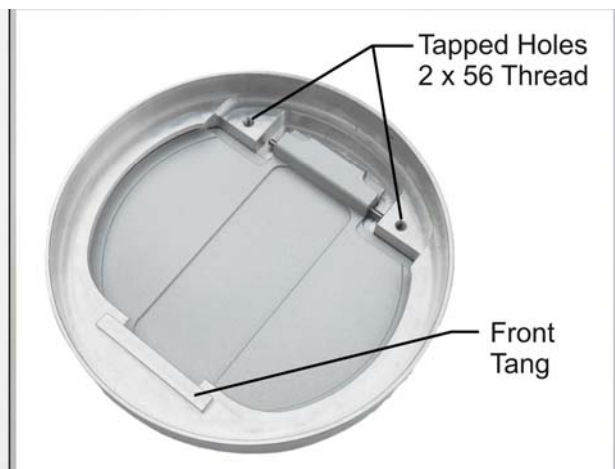
2) Top Assembly

NOTE: Please read Important Assembly Note #4 in section C above.

- a) While holding the Rim (#1) upside-down insert the Lid (#2) up through the opening in the Rim so the Hinge Pin (#4) is trapped on the inside of the Rim rear flange (see picture #5 & 6).



Picture #5



Picture #6

- b) With the Rim (#1) still upside-down, insert the Inside Trim Piece Assembly (#3) so the front lip goes underneath the front tang on the Rim (picture #7) and the back of the Inside Trim Piece Assembly nestles into the cutout in the back underside of the Rim (picture #5).

D. ASSEMBLY INSTRUCTIONS (cont.)



Picture #7

- c) At this point, hold the assembly together using one of your fingers to apply slight pressure on the Inside Trim Piece Assembly (#3) into the Rim (#1). Try operating the lid to determine if the hold-open Stop Screw (left side, picture #4) needs adjustment. There should be a slight “spring-loaded” force to keep the Lid open. Screwing the Stop Screw in will decrease the force. Screwing the Stop Screw out will increase the force. If adjustment is needed, remove the Inside Trim Piece Assembly, adjust the left Stop Screw in the Lid, and then reassemble. Try opening the Lid again. Repeat Inside Trim Piece Assembly removal and Stop Screw adjustment as needed.
- d) Once the Lid (#2) spring-loaded hold open pressure has been adjusted properly attach the Inner Assembly (#3) into the Rim (#1) using two (2) Attachment Screws (#6) (see picture #7).
- e) Try operating the Lid to determine if the hold-closed Stop Detent Pin (#5) (right side, picture #4) needs adjustment. The lid should require an approximate 4 ounces of force to open. Adjust the Stop Screw as required to achieve this setting. Screwing the Stop Screw in will decrease the force required. Screwing the Stop Screw out will increase the force required. This adjustment can be made with the top pieces assembled

3) Bottom Cup Assembly and Operation

The Bottom Cup Assembly (#7) comes standard in a black satin powder coat and depending on the design, may be wrapped with black Velcro loop. To facilitate cleaning, the Bottom Cup Assembly threads on/off to the Top Assembly with a quick-turn design. If included loose in the ashtray kit, the black vinyl non-skid pad may be adhered to the bottom of the ashtray to increase height or provide a non-skid surface.

E. INSTALLATION OF ASHTRAY ASSEMBLY

The FLA Ashtray series is designed as a cupholder insert and is not intended to be a stand-alone permanently mounted fixture. Each size of FLA Ashtray has been custom tailored to fit into a specific size of cupholder.

Some ashtray assemblies have been specifically designed to use a Velcro wrap to provide a snug friction fit. If the Ashtray Assembly does not provide a tight enough fit into the cupholder carefully peel off the Velcro wrap and apply a few wraps of masking type tape under the Velcro to provide a larger diameter surface. Reinstall the Velcro wrap.

Revision Schedule

Date	Rev.	Explanation
15 Aug 2007		Original
10 Oct 2007	A	Changed reamer from 0.0625" to 0.0630"
15 Dec 2007	B	Added additional parts description.
01 June 2008	C	Added A3.30FLA1 assembly.
15 Sept 2008	D	Added notes pertaining to item #6, 2x56, 1/4"long Socket Head Cap Screw.
15 Oct 2008	E	Changed item #6 length. Added Inside Trim Piece and Bottom Cup Assy Addendums.
15 July 2010	F	Changed item #5, set screw to round head nylon fastener
15 Mar 2011	G	Add warnings for nylon Detent Stop Screws
22 May 2012	H	Added information for assembly P/N A3.00FLA1-G250
16 June 2013	I	Corrected bottom cup P/N for assembly P/N A3.00FLA1-G250
06 June 2016	J	P/N A3.00FLA1-G250 removed from matrix. Bottom cups listed as general assemblies.
01 May 2018	K	Updated pictures and descriptions
17 Feb 2020	L	Corrected McMaster P/N's of 1/16" diameter dowel pins (#4 in parts matrix)

**Thank you for purchasing this Custom Cupholders product.
If you have questions as to the assembly or installation of this Ashtray Assembly
please contact the Custom Cupholders Company for more information.**