Wrench Hole in Specified Position

**Example of Alteration Code**

- **Alteration Code Specification Method**
  - Alteration Code specified in 0.5mm increments (from Left End)
  - Extrusion Series
    - 8 Series: 7.0\(\text{mm}\)
    - 6 Series: 5.6\(\text{mm}\)
    - 6-45 Series: 8\(\text{mm}\)

**Alteration Code Example**

<table>
<thead>
<tr>
<th>Code</th>
<th>Function</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>AH</td>
<td>Horizontal</td>
<td>1-Side Slot 3 Flats</td>
</tr>
<tr>
<td>AV</td>
<td>Vertical</td>
<td>1-Side Slot 3 Flats</td>
</tr>
<tr>
<td>AP</td>
<td>Crisscross (Horizontal + Vertical)</td>
<td>1-Side Slot 3 Flats</td>
</tr>
<tr>
<td>BP</td>
<td></td>
<td>1-Side Slot 3 Flats</td>
</tr>
<tr>
<td>CP</td>
<td></td>
<td>1-Side Slot 3 Flats</td>
</tr>
<tr>
<td>DP</td>
<td></td>
<td>1-Side Slot 3 Flats</td>
</tr>
<tr>
<td>EP</td>
<td></td>
<td>1-Side Slot 3 Flats</td>
</tr>
</tbody>
</table>

**Fastener Reference**

- HFS\#-SN-3030-BH6020
- HFS\#-SN-3030-BH6020-AV100-BV6020

**Note**

- See the table below for the applicable extrusions and alteration changes. Indicated with "-" in the table are not applicable.

**Alterations Needed for Various Joints**

- **Tapping Joint Drilling**
  - Wrench Hole: Bd
  - P668 A wrench access hole is needed for a Tapping Joint.

- **Screw Joint Drilling**
  - Wrench Hole: Bd
  - P669 For a Single Joint, a wrench access hole on one extrusion, and a D Hole (P668) on the other extrusion are needed.

**Standard of Extrusion Position**

- Wrench method of the extrusion, with the distance to the weld or weldless is a basis to determine right and left is shown as follows.
  1. On the vertical length: Flat side down, when flat side down and another flat side right
  2. On the horizontal length: Flat side down and another flat side right

- Example of 1: Example of 2: Example of 3: "L"-Shaped

- With the extrusion on the vertical length and also has a flat side, AH has the priority.

**Hole(s) on Smooth Surfaces**

- Specifying Wrench Access Holes on the flat surface direction provides holes on the flat surface also. To maintain the smoothness of the flat surface without wrench access holes, use of Simple Joint Kts is recommended. P667