

## KL6M SCALAR MOUNTING BRACKETS

30-April-2020

1. Find the center of the cake pan, and cut out the square. The center can be found by using a carpenter's square as shown in Figure 1a. Mark where the square intersects the edge of the pan, and connect the points. Then do the same at 90 degrees. Then place the septum feed over the lines and line up the corners as shown in Figure 1b. Mark and cut out the square.

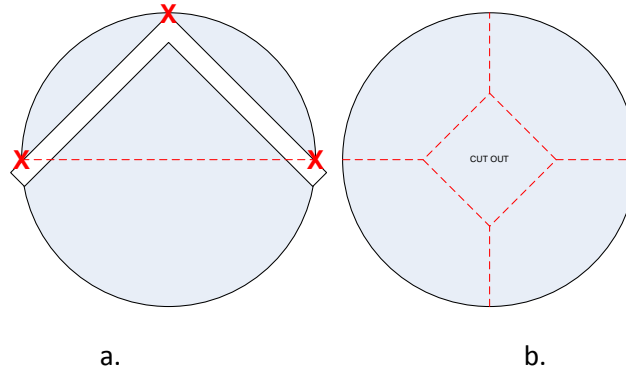


FIGURE 1. CAKE PAN PREPARATION

2. Mark and Drill the holes in the cake pan. Place the bracket on the septum feed. Put the pan on a flat surface upside down and place the feed into the square hole. Position and tighten the brackets as evenly as possible. Mark the centers of the elongated mounting holes, remove the pan and drill the holes with a 3/16" bit. I suggest you mark the position of the bracket so you can remount it the same way. It is hand made so it will fit the best if you put it back the same way you take it off.
3. Prepare the holes. The cake pan material is thin, so it is not feasible to countersink the holes. Instead, we will draw the material into a cone shape by tightening a 10-32 flat Philips screw in the hole backed by the aluminum form supplied (see Figure 2).

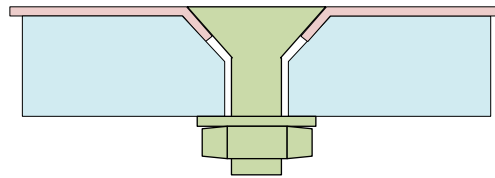


FIGURE 2. CAKE PAN HOLE PREPARATION

Complete the assembly by installing all the screws and tightening. The 1/4" bolts can be loosened to allow movement of the scalar for final adjustments.

4. 18" X 3" Fat Daddio Cake pans can be obtained from Amazon.com, search for part number PRD-183.

**Do not overtighten anything! Just enough to compress the lock washer.**