



# Acme Conformal Launch Lugs

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Acme brings launch lug design into the 21st century with its extensive line of Conformal Launch Lugs. These lugs feature an integral, rounded base that fits your airframe tube precisely. The close fit of the conformal base maximizes the shear strength inherent in adhesive bonds, and the 6061-T6 extruded aluminum construction guarantees structural integrity.

Acme currently has 19 Conformal launch lug designs available to suit your airframe and launcher requirements, including:

Eleven sizes to fit a wide variety of HPR industry standard airframe tube sizes, accommodating standard HPR launch rod diameters, and

Eight sizes to fit a wide variety of HPR industry standard airframe tube sizes, accommodating popular HPR rail launchers.

Each Acme Conformal Launch Lug kit comes with 2 lugs of the specified size, 2 sheets of 3M sheet adhesive, and installation instructions.

## Acme Conformal Launch Lug Installation Instructions

Acme Conformal Launch Lugs are designed and precision extruded with a rounded base that closely fits the most popular industry standard airframe tubes. To verify closeness of fit, place the lug axially on the airframe tube and view the lug-to-tube fit from the end of the airframe tube. For airframe tubes of off-nominal diameters, it may be necessary to sand the lug base slightly to optimize the fit. This is easily done by holding or taping a piece of fine-grit sandpaper onto the airframe tube, and sanding the lug base by rubbing the lug on the sandpaper in a direction parallel to the length of the airframe tube. The better the lug-to-tube fit, the stronger the adhesive bond; always check the fit before adhesive bonding, and sand to fit if necessary.

Remove any burrs and sharp edges on the launch lug(s) with fine-grit sandpaper, and clean all surfaces to be bonded (except paper) with isopropyl alcohol.

Locate the lug(s) on the airframe tube at the desired location, and verify that they are aligned (coaxial) if more than one lug is being installed. Mark the lug installation location on the airframe tube by tracing around the lug using a permanent ink pen (Sharpie or similar).

For lug bonding using cyanoacrylate (CA) adhesives, follow the adhesive manufacturer's application instructions. Note that CA adhesives generally work best on relatively smooth, non-porous surfaces, such as metal, plastics, fiberglass, etc.

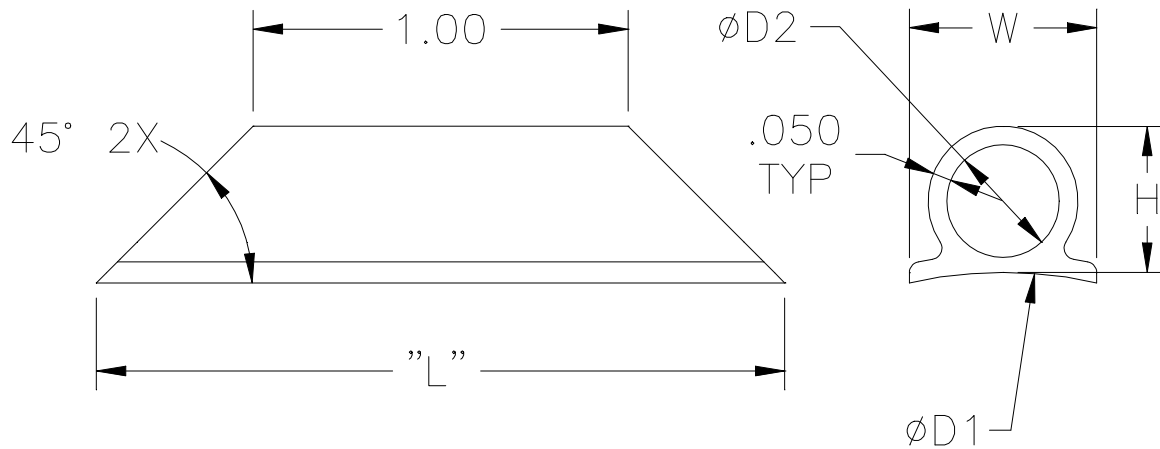
For lug bonding using the 3M sheet adhesive supplied with Acme Conformal Launch Lugs, peel the liner from one side of the sheet adhesive, and apply the adhesive to the lug base. Trim any excess (overlapping) adhesive from around the edges of the lug using an Exacto or similar knife. Peel the liner from the adhesive now on the lug, and install the lug onto the airframe tube at the predetermined location. It is very important to firmly clamp the lug onto the airframe tube, and to leave the clamp in place for 24 hours (minimum); the longer the clamping time, the stronger the adhesive bond.

After the adhesive (CA or sheet adhesive) has fully cured, filleting material may be applied around the periphery of the installed launch lugs, to smoothly fair the lugs to the airframe. Lightly scuff sand the launch lug(s) with extra fine sandpaper in preparation for painting, and clean with isopropyl alcohol. Epoxy or enamel finishes are recommended.



# Acme Conformal Launch Lugs

## Dimensions: Rod Launcher Lugs



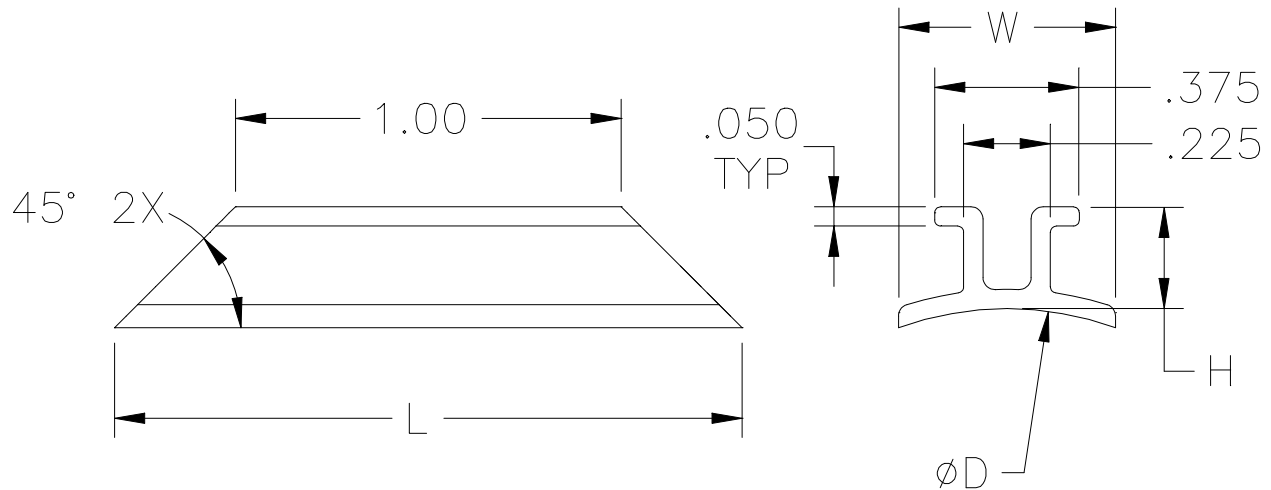
Part No.	D1 (in)	D2 (in)	H (in)	W (in)	L (in)	Weight (lbs)
1.64/.25	1.64	0.30	0.42	0.50	1.86	0.01
1.64/.25X	1.64	0.30	0.52	0.62	2.16	0.02
2.26/.25	2.26	0.30	0.42	0.50	1.84	0.01
2.26/.38	2.26	0.42	0.52	0.62	2.12	0.02
2.26/.38X	2.26	0.42	0.68	0.80	2.50	0.02
3.10/.38	3.10	0.42	0.52	0.62	2.10	0.02
3.10/.50	3.10	0.55	0.65	0.75	2.38	0.02
4.00/.50	4.00	0.55	0.65	0.75	2.38	0.02
4.00/.75	4.00	0.80	0.90	1.00	2.92	0.04
6.15/.75	6.15	0.80	0.90	1.00	2.95	0.04
7.67/.75	7.67	0.80	0.90	1.00	2.98	0.04

1.64/.25X and 2.26/.38X feature extended lugs to clear fin canisters, motor retainers, etc.



# Acme Conformal Launch Lugs

## Dimensions: Rail Launcher Lugs



Part No.	D (in)	H (in)	W (in)	L (in)	Weight (lbs)
1.64/R	1.64	0.26	0.56	1.62	0.01
1.64/RX	1.64	0.38	0.62	1.90	0.02
2.26/R	2.26	0.26	0.62	1.62	0.01
2.26/RX	2.26	0.44	0.75	2.00	0.02
3.10/R	3.10	0.26	0.68	1.60	0.01
4.00/R	4.00	0.26	0.75	1.60	0.01
6.15/R	6.15	0.26	0.82	1.58	0.01
7.67/R	7.67	0.26	0.88	1.58	0.01

1.64/RX and 2.26/RX feature extended lugs to clear fin canisters, motor retainers, etc.