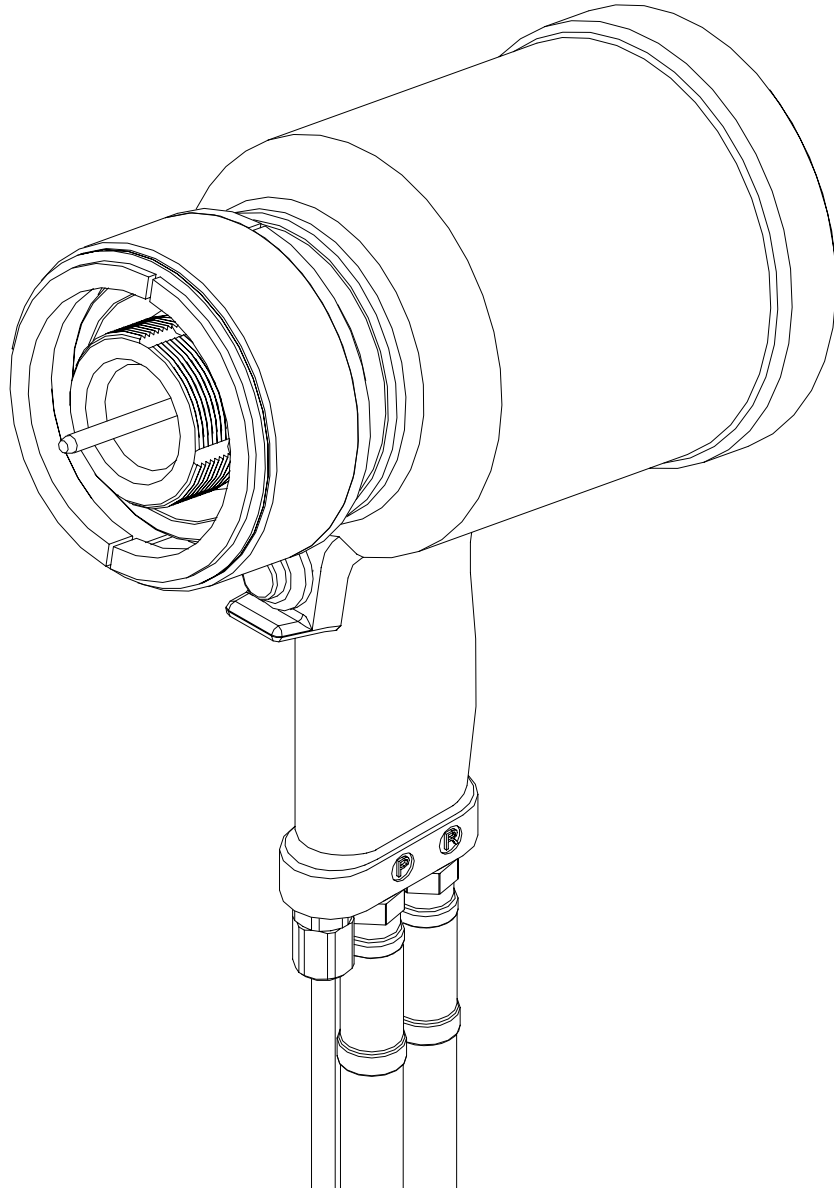


GBP2630

HYDRAULIC INSTALLATION TOOL



GAGE BILT
MADE IN U.S.A.

GAGE BILT PRODUCTS CORP.

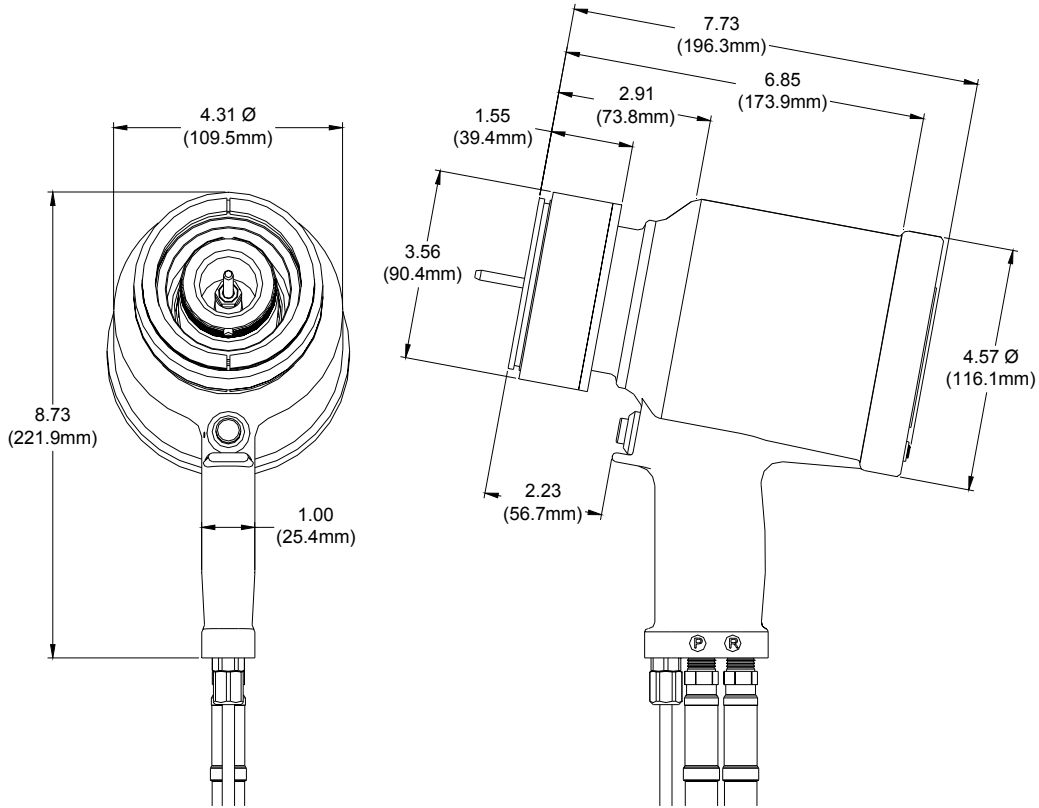
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SPECIFICATIONS

Weight	- 22.4 lbs.
Hyd. Pressure Req'd.	- 7,400 psi PULL 3,200 psi RETURN
Hyd. Power Source	- GBP940 Powerunit or equivalent.
Hydraulic Fluid	- Fire resistant hydraulic fluid conforming with OSHA regulation 1926.302.
Setting Stroke	- 1.970"
Rated Pull Load	- 55,940 lbs. @ 7,400 psi



NOTE:

PLEASE READ THIS MANUAL BEFORE SERVICING OR USING THIS TOOL. COMPLETE WITH WARNINGS AND CAUTIONS TO PREVENT SEVERE PERSONAL INJURY OR DAMAGE THE TOOL.



CAUTION:

GAGE BILT TOOLS ARE APPROVED TO INSTALL HUCK®, AVDEL®, CHERRY®, POP® AND OTHER FASTENERS WHEN USED BY PERSONS WITH SPECIFIC TRAINING OF BLIND RIVET AND LOCKBOLT INSTALLATION EQUIPMENT.

WARNING

Do not pull fastener unless it is placed in an assembly, pin will eject forcibly when pintail breaks off. Severe personal injury may result.

WARNING

Always disconnect tool from powerunit before performing any maintenance to any tool or nose assembly. Insure that all connections are proper and there are no visible leaks from tool or hoses before connecting to power.

WARNING

When operating installation equipment always wear approved eye protection. Do not look in front of nose assembly or rear of tool when installing fastener.

CAUTION

Insure that nose assembly and tip are properly matched for the fastener being installed.

WARNING

Installation of fasteners may exceed acceptable noise levels. Use approved hearing protection.

CAUTION

Keep Nose Assemblies clean and free of chips and debris.

WARNING

Be sure there is adequate clearance for tool and operator's hands before proceeding. Keep fingers clear of any moving parts. Keep fingers clear from fasteners and installed materials. Severe personal injury may result.

WARNING

Hydraulic power units that deliver high pressure for the "PULL" and "RETURN" and are not equipped with relief valves are specifically not recommended and may be dangerous.

DESCRIPTION

The GBP2630 is a hydraulic installation tool capable of installing 7/8" lockbolts and 20mm MHP 10.9 lockbolts. It weighs 22.4 lbs and can be operated in any position with one hand. It has a 1.906" rivet setting stroke and a rated pull load of 55,940 lbs @ 7,400 psi.

Normal operating pressure is set at 7,400 psi PULL pressure and 3,200 psi RETURN pressure, enabling the tool to pull all the fasteners listed on the selection chart without adjusting pressures. Powerunit may be set to the pressures only needed to pull your specific fastener using 942280 pressure setting gauge. The tool comes equipped with 24" hoses and electric cord kit complete with quick disconnects.

NOSE ASSEMBLIES ARE NOT FURNISHED WITH THE TOOL AND MUST BE ORDERED SEPARATELY.

OPERATION

When the tool is connected to a powerunit, operation is controlled by a button in the handle. When the button is depressed, a directional valve in the powerunit directs fluid to the front side of the piston forcing it and the nose assembly collet rearward. This action causes the jaws to clamp onto the fastener pintail and pull the sheets together. The anvil is forced forward, swaging the collar into locking grooves of the fastener. Further force breaks the pintail off, approximately flush with the collar.

When the button is released the directional valve reverses fluid flow to the back of the piston and pushes the nose assembly off of the swaged fastener. The pintail ejector hydraulically pushes the spent pintail out of the nose assembly.

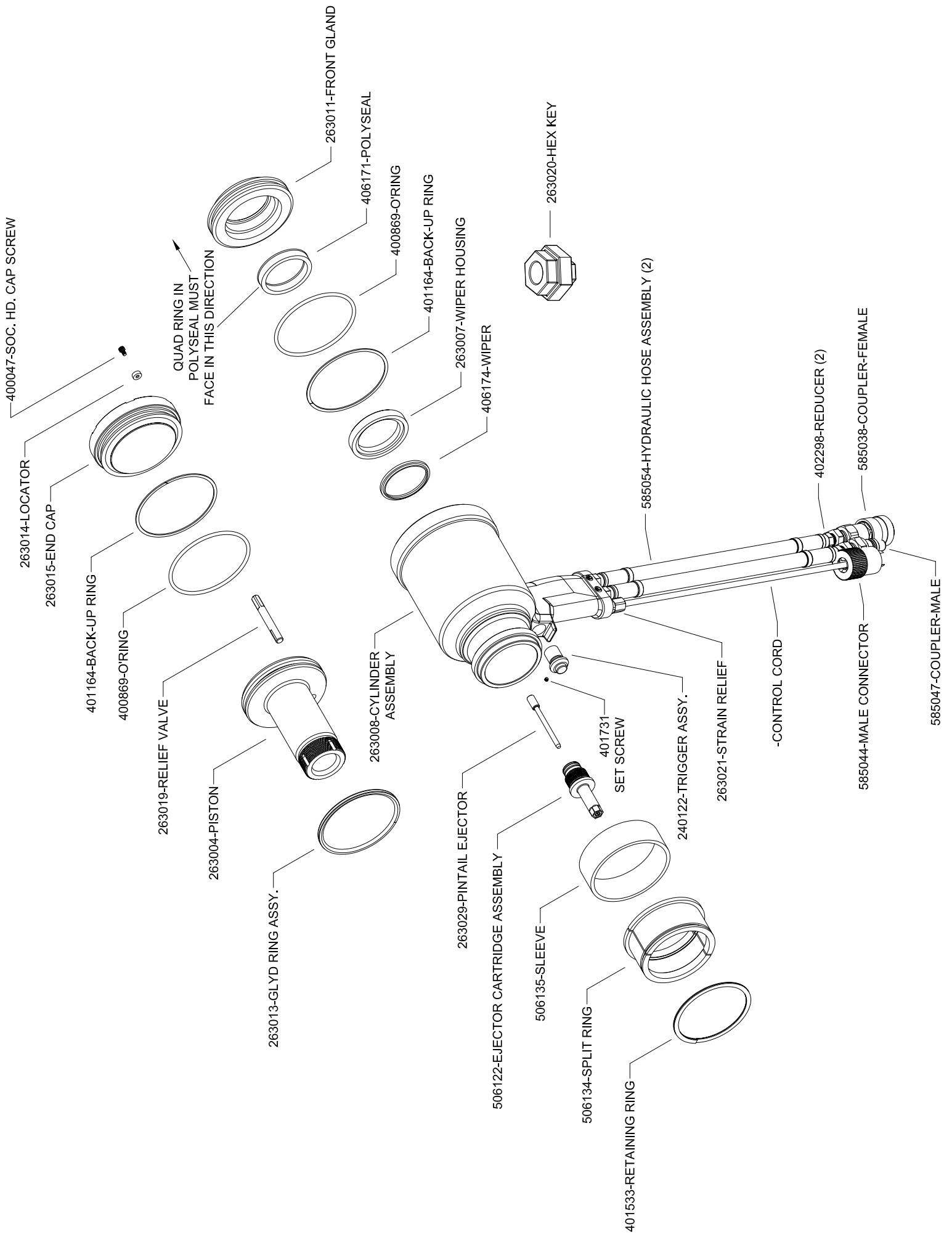
MAINTENANCE

The performance of any tool depends upon good maintenance practices. Following these minimal requirements for service and care will extend the life of your tool.

- *Only use a hydraulic power source equipped with relief valves and pressures set within specified limits.
- *Keep hydraulic system free of dirt. Avoid letting couplers contact a dirty floor.
- *Do not use as a hammer to force fasteners into holes or otherwise abuse tool.
- *Proper care by operators is necessary in maintaining full productivity and reducing downtime.

WARNING

Be sure powerunit is disconnected before cleaning, or when replacing worn or damaged components. Severe personal injury may occur if power source is not disconnected.



TROUBLE SHOOTING

Providing all maintenance conditions have been met, follow this systematic approach to diagnosis.

1. NO OPERATION WHEN TRIGGER IS DEPRESSED

- a.) Check Powerunit power source.
- b.) Control cord may be loose or damaged.
- c.) Faulty trigger. Replace.
- d.) Check hydraulic couplings; repair or replace.

2. SLOW OR PARTIAL OPERATION WHEN TRIGGER IS DEPRESSED

- a.) Low hydraulic pressure. Check powerunit, adjust.
- b.) Cylinder Piston Glyd Ring Assy. (263013) could be worn or damaged. Replace.
- c.) Excessive wear or scoring on moving parts. Check and replace faulty parts.

3. TOOL OPERATES IN REVERSE

- a.) Tool stops in back position. Hydraulic hoses are reversed. Correct.

4. HYDRAULIC OIL OVERHEATS

- a.) Powerunit motor rotation reversed. Electrical connections reversed. See powerunit instruction manual.
- b.) Restrictions in either hydraulic lines, hoses or couplings. Check and tighten, clean or replace.

5. OIL LEAKAGE

- a.) Hydraulic oil leaks from connections. Tighten threaded connections. Do not use teflon tape.
- b.) Oil leaks from tool. Determine source of leak and replace worn or defective O'Rings and back-up rings.

6. PINTAIL GROOVES STRIPPED DURING PULL STROKE

- a.) Nose Assembly must be pushed onto fastener fully.
- b.) Chips may have collected in chuck jaws. Disassemble nose assembly, clean jaws in mineral spirits using a sharp pointed object.
- c.) Chuck jaws may be worn or damaged. Replace.
- d.) Pintail too short for jaws to properly grip. Select proper grip length fastener.
- e.) Excessive gap between sheets. Reduce gap before attempting to install fastener.

7. NOSE ASSEMBLY WON'T ACCEPT FASTENER PINTAIL

- a.) Spent fastener stem may be jammed in pulling head. Disassemble and check for worn or broken parts in nose assembly. Replace defective parts and clean before reassembling.

OVERHAUL

If a tool is performing poorly or leaking badly, a complete overhaul may be necessary. Service Kit GBP2630KS contains a complete set of O'Rings, back-up rings and screws.

Perform overhaul in a clean, well lit area using care not to scratch or nick any smooth surface that comes in contact with an O'Ring. Use of Lubriplate (GBP part no. 402723) or other lubricant is recommended during reassembly to prevent tearing or distorting of O'Rings.

Disconnect hydraulic hoses (585054) and electrical cord () from powerunit. Remove couplers (585038 & 585047) from hoses (585054) and drain. Remove retaining ring (401533), split ring (506134) and nose assembly. Remove screw (400047) locator (263014) and using hex key (263020) remove end cap (263015). Push piston (263004) rearward to expose front gland (263011), polyseal (406171), wiper housing (263007) and wiper (406174). Remove these items then remove piston (263004).

Clean parts in mineral spirits or other O'Ring compatible solvent being sure to clean O'Ring grooves. Inspect components for scoring, excessive wear or damage.

Reassembly sequence is opposite of disassembly. Be sure relative positions of O'Rings and back-up rings are as shown in exploded view and part list. Relief valve must be installed with four flats towards the rear of the cylinder. Coat hose fitting threads with a non-hardening teflon thread compound such as Slicite (GBP part no. 403237). DO NOT USE TEFLON TAPE.

GBP2630 SELECTION CHART

FASTENER	DIA.	NOSE ASSEMBLY
LOCKBOLT HIGH TENSILE PULL TYPE C50L	7/8"	28-2630-28
MHP 10.9	20mm	HP20MM-2630-28

THE GBP2630 IS APPROVED TO INSTALL THE ABOVE FASTENERS.

NOTE: THE LAST 2 DIGITS OF THE NOSE ASSEMBLY REPRESENTS THE LENGTH THE NOSE ASSEMBLY EXTENDS FROM THE TOOL. (I.e. -28 = 2.8 inches)

WARRANTY

Seller warrants that all goods covered by this catalog will conform to applicable specifications and will replace, or repair, F.O.B. our plant, any goods providing defective from faulty workmanship, or material, for 90 days from date of shipment.

Said warranty to remain in effect if and only if such goods are used in accordance with all instructions as to maintenance, operation, and use set forth in manuals and instruction sheets furnished by seller.

Sellers obligation under this warranty shall be limited to the repair or rework of the goods supplied or replacement thereof, at Seller's option, and in no case is to exceed the invoice value of said goods. Under no circumstances will seller be liable for incidental or consequential damages or for damages incurred by the buyer or subsequent user in repairing or replacing defective goods or if the goods covered by this warranty are reworked or subjected to any type of additional processing.

This warranty is void if Seller is not notified in writing of any rejections or defects within 90 days after the receipt of the material by the customer.

THIS WARRANTY IS MADE IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY.