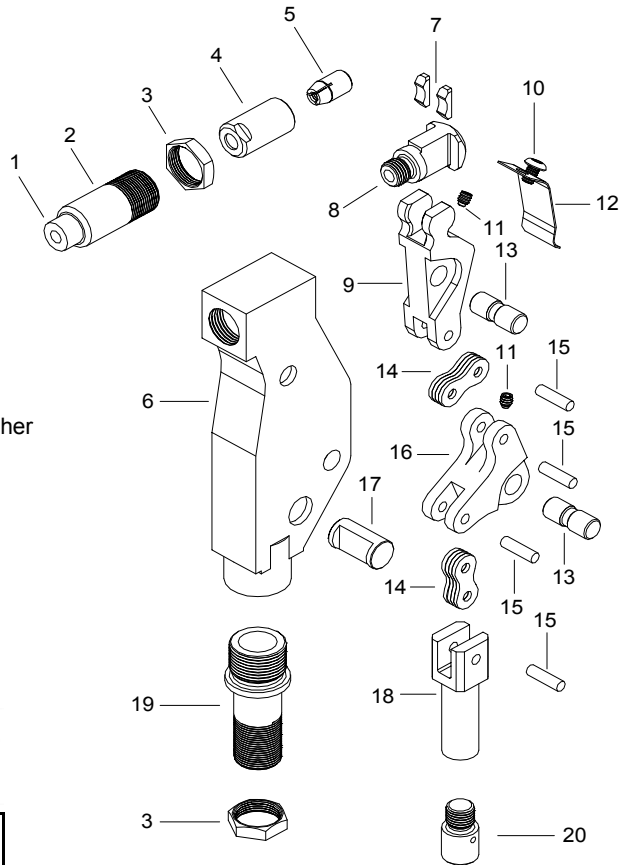
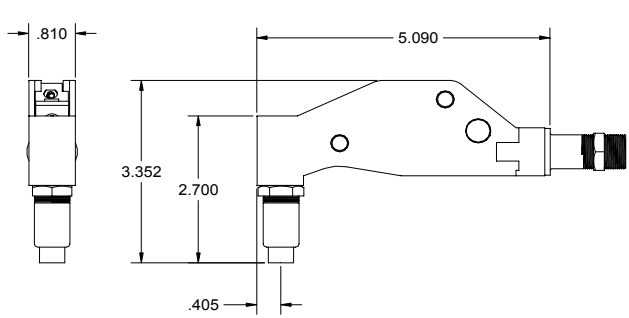


NOSE ASSEMBLY DATA SHEET



CAUTION!

Pintails may eject forcibly. This nose is for closed access applications. If used in open access applications, 704214 catcher bag is recommended TO PREVENT SEVERE PERSONAL INJURY.

*USE 715113 STROKE LIMITER

**RIGHT ANGLE NOSE ASSEMBLIES REQUIRE MORE THAN ONE "PULL".



Rev. 12/08

GAGE BILT

MADE IN U.S.A.

GAGE BILT Inc.

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Type:	Fasteners:	Recommended Tool: GB752 WITH 352715 ADAPTER
Single Action 10-32 Ø	GROUNDING STUD M83454 BACS53B1EA1/2	

ATTACHMENT:

Engage 1 or 2 threads of extension (20) onto head piston, then insert adapter fitting (19) into end of head cylinder and turn clockwise until snug. Rotate nose assembly to desired position and tighten jam nut (3) securely.

After attaching the nose assembly to the riveter, adjust sleeve (2) by loosening jam nut (3), then insert rivet to be installed in sleeve and rotate sleeve until jaws just grab pintail. Tighten jam nut (3) securely. By this sleeve adjustment, the nose assembly can be made to release or to hold the pintail after installation.

DISASSEMBLY:

Loosen jam nut (3) and remove sleeve (2). Unscrew collet (4) which contains super-grip jaw assembly (5) from collet bolt (8).

Remove screw (10) and guard (12). Remove 2 set screws (11) and push out 2 pivot pins (13) to permit removal of linkage. Shoe bearings (7) and collet bolt (8) will disengage from lever (9).

Remove 4 link pins (15) to disassemble lever (9), links (14), bell crank (16) and drawbolt (18).

Remove guide pin (17) from frame (6). Adapter fitting (19) is secured to frame with Loctite® and need not be removed unless damaged.

REASSEMBLY:

Reverse the procedure. Linkage, consisting of lever (9), links (14), bell crank (16) and drawbolt (18) should be assembled as a subassembly before inserting lever (9) into shoe bearings (7) and collet bolt (8). MAKE SURE NOTCHES ON COLLET BOLT (8) ARE POINTING TOWARDS LEVER (9). This complete subassembly may then be inserted into frame (6) and retained by guide pin (17) and pivot pins (13).

No.	Qty.	Description	GS10-715-54RA
1	1	Nose Tip	11049
2	1	Sleeve	10115
3	2	Jam Nut	70411
4	1	Collet	20513
5	1	Super-Grip Jaw Assy.	30656-S5
6	1	Frame	75310
7	2	Shoe Bearing	75311
8	1	Collet Bolt	70443
9	1	Lever	75313
10	1	But. Hd Screw	402471
11	2	Set Screw	75315
12	1	Guard	75316
13	2	Pivot Pin	75317
14	8	Link	75318
15	4	Link Pin	75319
16	1	Bell Crank	75320
17	1	Guide Pin	75321
18	1	Drawbolt	75322
19	1	Adapter Assembly	70458
20	1	Collet Extension	70457