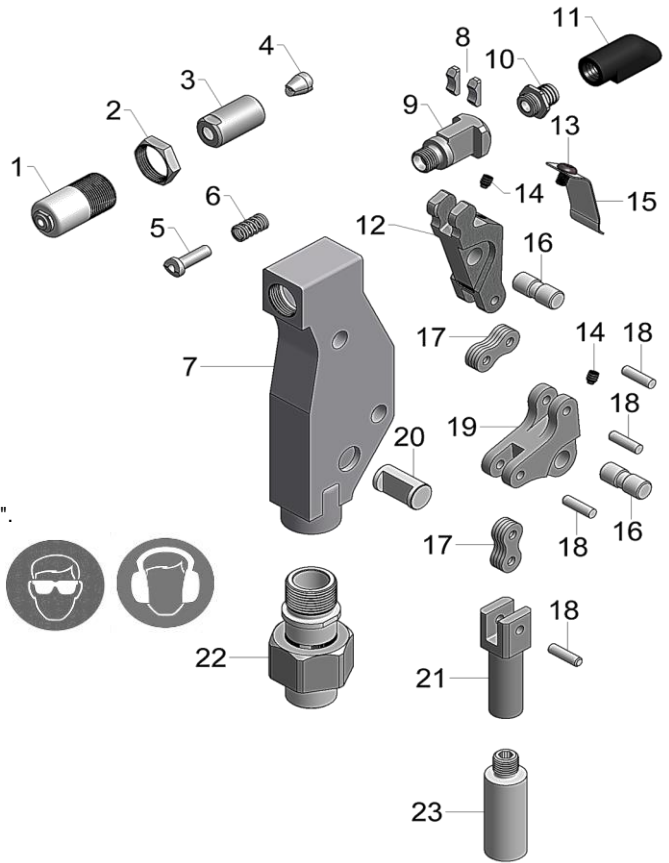
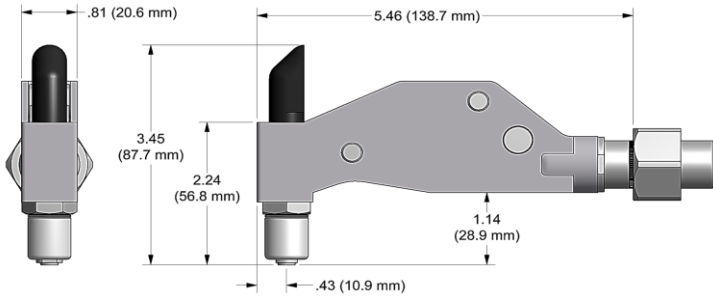


NOSE ASSEMBLY DATA SHEET



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.

*GB731 USE 731154 STROKE LIMITER.
 **RECOMMENDED FOR MAINTENANCE APPLICATIONS ONLY.
 ***RIGHT ANGLE NOSE ASSEMBLIES REQUIRE MORE THAN ONE "PULL".

3/12 REV. 8/17

GAGE BILT
 MADE in USA

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Type:	Fasteners:	Recommended Tool: GB751
Self-Releasing Front Ejecting 1/8", 5/32" & 3/16" Ø	UNIMATIC® SINGLE ACTION NAS1919S & U/NAS1921S & U WITH DRIVE WASHER	
		Alternate Tool: *GB731

Ref. No.	Qty.	Description	456UBR-751D-54RA
1	1	Sleeve Ass'y	10420
2	1	Jam Nut	70411
3	1	Collet	20513
4	1	Jaw Set	30513
5	1	Follower	40506-1
6	1	Spring	50427
7	1	Frame	75310
8	2	Shoe Bearing	75311
9	1	Collet Bolt	70486-1
10	1	Barbed Retainer	70575
11	1	Deflector	61107
12	1	Lever	75313
13	1	But. Hd Screw	402471
14	2	Set Screw	75315
15	1	Guard	75316
16	2	Pivot Pin	75317
17	8	Link	75318
18	4	Link Pin	75319
19	1	Bell Crank	75320
20	1	Guide Pin	75321
21	1	Drawbolt	75322
22	1	Adapter Assembly	70459
23	1	Extension-Collet	70463

ATTACHMENT:

Engage 1 or 2 threads of extension-collet (23) onto head piston, then insert adapter assy (22) into end of head cylinder and turn clockwise until snug. Rotate nose assembly to desired position and tighten adapter assy nut (22) securely.

After attaching the nose assembly to the riveter, adjust sleeve assy (1) by loosening jam nut (2), then insert largest diameter rivet to be installed in sleeve and rotate sleeve until jaws just grab pintail. Tighten jam nut (2) securely. By this sleeve adjustment, the nose assembly can be made to release or to hold the pintail after installation.

DISASSEMBLY:

Loosen jam nut (2) and remove sleeve (1). Unscrew collet (3) which contains jaws (4), follower (5) & spring (6) from collet bolt (9).

Remove screw (13) and guard (15). Remove 2 set screws (14) and push out 2 pivot pins (16) to permit removal of linkage. Shoe bearings (8) and collet bolt (9) will disengage from lever (12).

Remove 4 link pins (18) to disassemble lever (12), links (17), bell crank (19) and drawbolt (21).

Remove guide pin (20) from frame (7). Adapter assy (22) is secured to frame with Loctite® and need not be removed unless damaged.

REASSEMBLY:

Reverse the procedure. Linkage, consisting of lever (12), links (17), bell crank (19) and drawbolt (21) should be assembled as a subassembly before inserting lever (12) into shoe bearings (8) and collet bolt (9). MAKE SURE NOTCHES ON COLLET BOLT (9) ARE POINTING TOWARDS LEVER (12). This complete subassembly may then be inserted into frame (7) and retained by guide pin (20) and pivot pins (16).