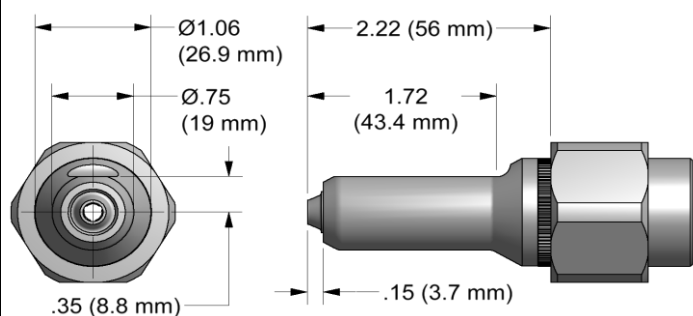
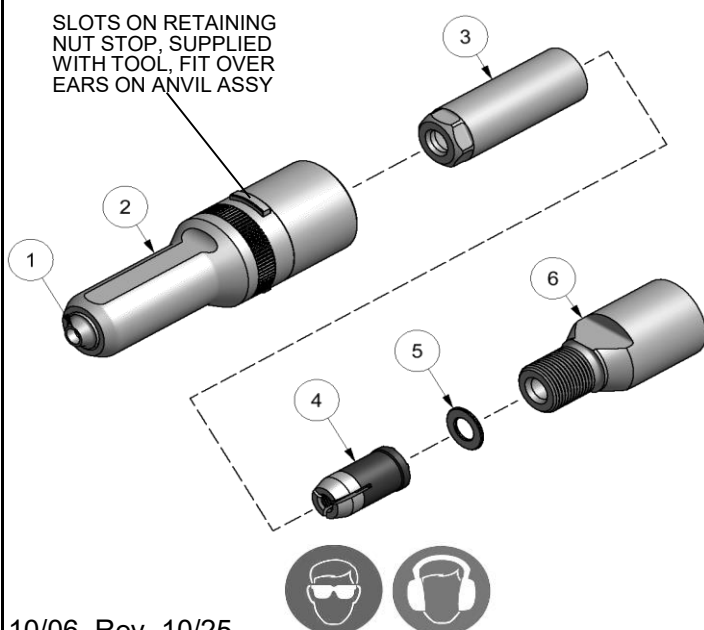


NOSE ASSEMBLY DATA SHEET



SLOTS ON RETAINING NUT STOP, SUPPLIED WITH TOOL, FIT OVER EARS ON ANVIL ASSY



ASSEMBLY:

Notes:

- Apply Vibra-tite® p/n/ 405125 to all threads and allow it to set 20 minutes prior to assembly.
 - Tighten collet (3) and extension-collet (6) to 80 - 100 IN-LBS. (.36 - .44 Kn) torque.
 - If nose assy is assembled as it is when purchased new, follow steps 3 - 5 to attach to tool.
- Insert super grip jaw assy (4) into rear of collet (3). Place spacer (5) on rear of super grip jaw assy (4).
 - Thread collet (3) to extension-collet (6) using hex key in front of collet-extension (6) and flats provided on collet (3).
 - Thread assembled collet (3) and extension-collet (6) onto piston of tool using flats provided and hex in rear of piston.
 - Slide anvil assembly (2) over collet (3).
 - Slide retaining nut stop and retaining nut over ears on anvil (see exploded view) and tighten to tool.

DISASSEMBLY:

Reverse assembly instructions.

10/06 Rev. 10/25

GAGE BILT
MADE in USA

44766 Centre Court Clinton Twp. MI 48038 USA
Ph: +1 (586) 226-1500 Fax: +1 (586) 226-1505
solutions1@gagebilt.com / www.gagebilt.com

Type:		Fastener:	Recommended Tool:
Non Self-Releasing 1/4" Ø		NAS1900 S & U SERIES UNIMATIC® BLIND RIVET (SINGLE ACTION) WITH OR W/OUT DRIVE WASHER	GB745
			Alternate Tools: GB756 & GB2581(A)
Ref. No.	Qty.	Description	SMLS08-755-23
1	1	Anvil Insert	10868
2	1	Anvil Assembly (Inc. #1)	19965
3	1	Collet	20841
4	1	Super-Grip Jaw Assembly	30653-CS
5	1	Spacer	60844
6	1	Extension-Collet	70832

VIBRA-TITE® IS A REGISTERED TRADEMARK OF OAKLAND CORPORATION. UNIMATIC® IS A REGISTERED TRADEMARK OF HOWMET AEROSPACE.