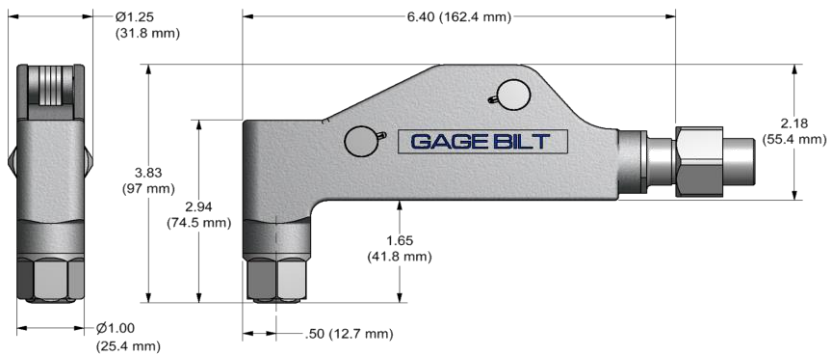


NOSE ASSEMBLY DATA SHEET



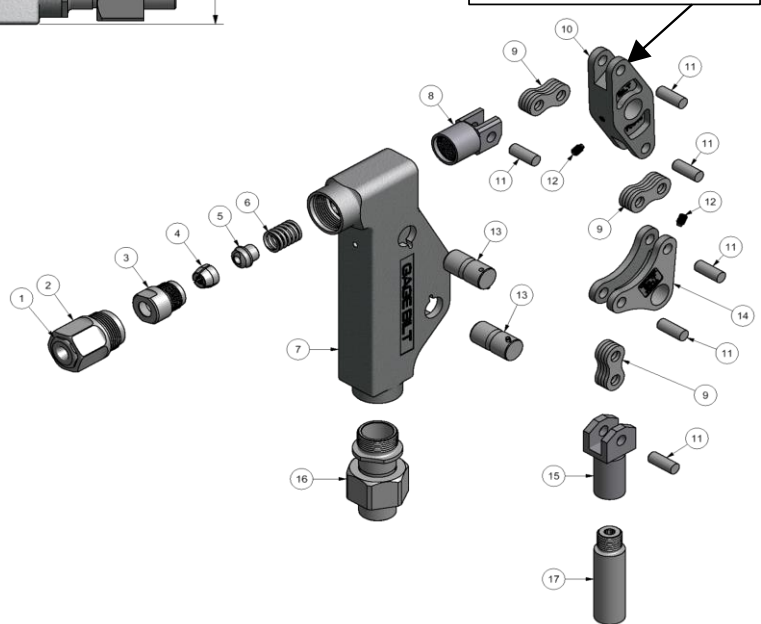
WHEN MOUNTING ON RIVETER:

Press & Hold in direction shown.

JAWS IN COLLET MAY NOT ALIGN PROPERLY TO ALLOW INSERTION OF FASTENER WHEN THE NOSE ASSEMBLY IS ATTACHED TO THE TOOL AND CYCLED WITHOUT A FASTENER.

IF THIS CONDITION SHOULD ARISE, REMOVE ANVIL & HOLDER ASSEMBLY 13556 AND MANUALLY INSERT BROKEN PINTAIL INTO JAWS. REATTACH ANVIL AND HOLDER ASSEMBLY 13556.

BROKEN PINTAIL WILL EITHER FALL OUT OR CAN BE EASILY REMOVED. TOOL IS READY TO RESUME WORK.



*USE ADAPTER 745751 WITH 745158 STROKE LIMITER

5/22 REV 6/22

GAGE BILT
MADE IN U.S.A.

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Type:	Fasteners:	Recommended Tool: GB722
Self Releasing 3/16" Ø	Commercial Lockbolt C6L®, Avdelok®	Alternate Tools: GB713 *GB745

Ref. No.	Qty.	Description	LB06-713-58RA
1	1	Anvil Insert	16003-1
2	1	Anvil & Holder Assy. (Inc. #1)	13556
3	1	Collet	28847
4	1	Chuck Jaw	30653-1
5	1	Follower	40311-4
6	1	Spring	A-1603
7	1	Frame	70864
8	1	Collet Bolt	70839
9	12	Link	70841
10	1	Lever	70843
11	6	Link Pin	70842
12	2	Set Screw	70844
13	2	Pivot Pin Assy	70845
14	1	Bellcrank	70846
15	1	Drawbolt	70847
16	1	Anvil Adapter Assy	70868
17	1	Extension-Collet	70875

MOUNTING INSTRUCTIONS

Notes:

1. Apply Vibra-tite® p/n 405125 to collet (3) threads and allow it to set 20 minutes prior to assembly.
2. Tighten extension-collet (17) to piston on tool 80-100 IN-LB torque.

Attach riveter to air source for correct piston positioning. Push the drawbolt assembly forward (see above), before mounting. While holding drawbolt in a forward position, thread the nose assembly onto the riveter, making sure that both internal and external threads are connected. Use the jam-nut to lock the pulling head in position. Cycle the tool to make sure it is functional.

DISASSEMBLY AND ASSEMBLY

Disassembly:

Loosen and remove holder (2) from frame assy (7). Unscrew collet (3) which contains jaws (4), follower (5) and spring (6) from collet bolt (8).

Remove 2 set screws (12) and push out two pivot pins (13) to permit removal of linkage. Remove link pin (11) from Collet bolt (8) and links (9) to disengage from lever (10).

Remove five link pins (11) to disassemble lever (10), links (9), bellcrank (14) and drawbolt (15).

Reassembly:

Reverse the procedure. Linkage, consisting of lever (10), links (9), bellcrank (14) and drawbolt (15) should be assembled as a subassembly before inserting lever (10) into collet bolt (8). MAKE SURE NOTCHES ON COLLET BOLT (8) ARE POINTING TOWARDS LEVER (10). This complete subassembly may then be inserted into frame (7) and retained by pivot pins (13).