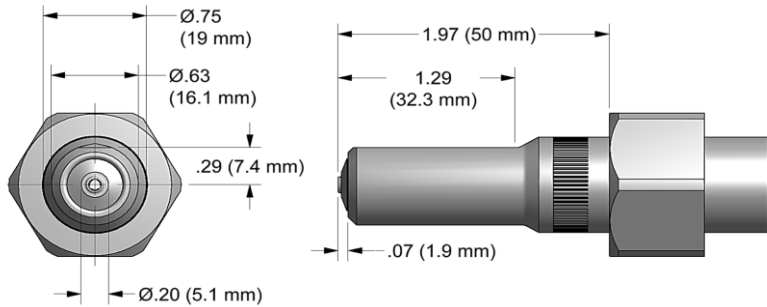


NOSE ASSEMBLY DATA SHEET



ASSEMBLY:

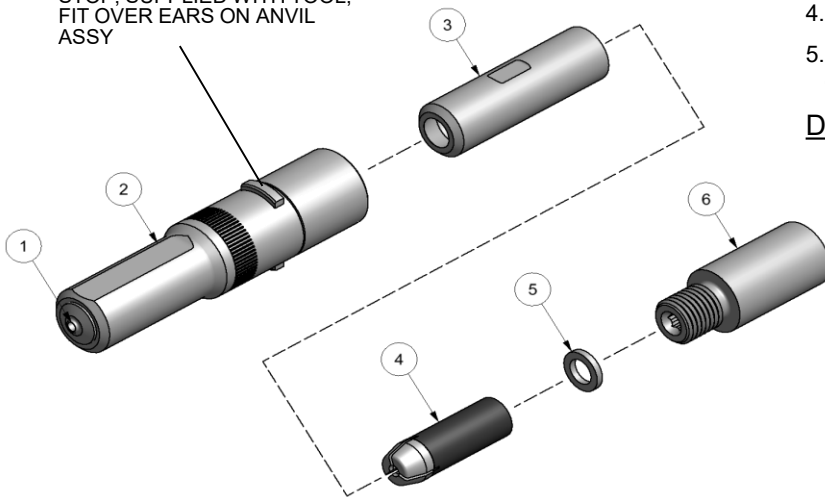
Notes:

- 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 & holder 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.

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



Rev. 10/25

*Anvil assembly consists of #1 and 35208 retainer.

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Type:		Fasteners:		Recommended Tool: GB751	
Non Self-Releasing 1/8" & 5/32" Ø		NAS1900 S & U SERIES UNIMATIC® BLIND RIVET (SINGLE ACTION) WITH OR W/OUT DRIVE WASHER		Alternate Tools: GB722 & GB2480(A)	
Ref. No.	Qty.	Description		SMLS04-752C-20	SMLS05-752C-20
1	1	Anvil Insert		10485	15596
2	1	Anvil Assembly (Inc. #1)		17746	17747
3	1	Collet		20727	20727
4	1	Super-Grip Jaw Assembly		30425-S	30545-CS
5	1	Spacer		40465	70572
6	1	Extension-Collet		70550	70550

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