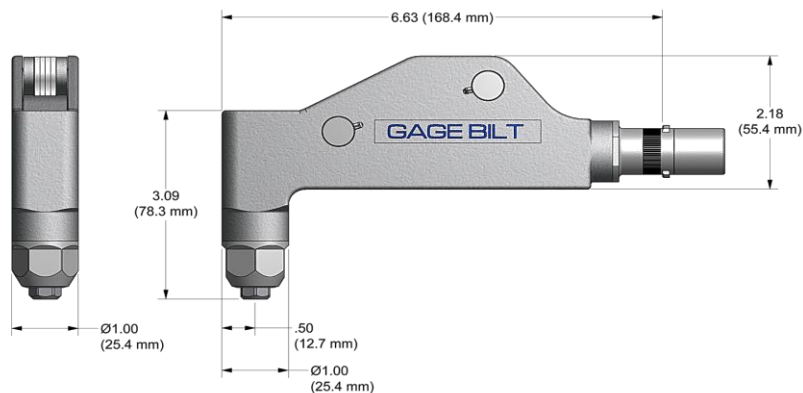
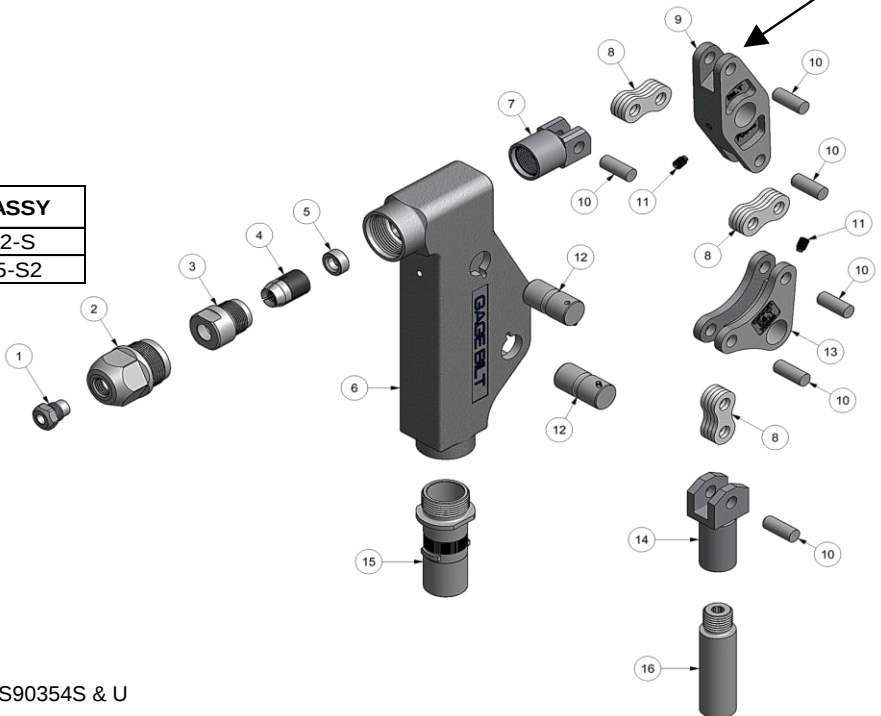


NOSE ASSEMBLY DATA SHEET



NOSE ASSY	NOSE TIP	JAW ASSY
UBB06-83-58RA	16041	30672-S
UBB08-83-58RA	18891	30865-S2



WHEN MOUNTING ON RIVETER:

Press & Hold in direction shown.



*105 P.S.I. REQUIRED FOR MS90353S & U & MS90354S & U

8/16 REV 1/18

GAGE BILT

MADE in USA

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

Type:	Fasteners:	
Single Action 3/16", *1/4" Ø	MS90353S & U & MS90354S & U MS21140S & U & MS21141S & U WITH DRIVE WASHER	Recommended Tool: G83 G84

Ref. No.	Qty.	Description	UBB-83-58RA
1	1	Nose Tip	SEE CHART
2	1	Holder	13424
3	1	Collet	28827
4	1	Super Grip Jaw Assy	SEE CHART
5	1	Spacer	60837
6	1	Frame	70864
7	1	Collet Bolt	70839
8	12	Link	70841
9	1	Lever	70843
10	6	Link Pin	70842
11	2	Set Screw	70844
12	2	Pivot Pin Assy	70845
13	1	Bellcrank	70846
14	1	Drawbolt	70847
15	1	Anvil Adapter	70867
16	1	Extension-Collet	70875

MOUNTING INSTRUCTIONS

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 (6). Unscrew collet (3) which contains jaws (4), and spacer (5) from collet bolt (7) and links (8) to disengage from lever (9).

Remove 2 set screws (11) and push out two pivot pins (12) to permit removal of linkage. Remove link pin (10) from Collet bolt (7) and links (8) to disengage from lever (9).

Remove five link pins (10) to disassemble lever (9), links (8), bellcrank (13) and drawbolt (14). Anvil Adapter (15) is secured to frame with Loctite® and need not be removed unless damaged.

Reassembly:

Reverse the procedure. Linkage, consisting of lever (9), links (8), bellcrank (13) and drawbolt (14) should be assembled as a subassembly before inserting lever (9) into collet bolt (7). **MAKE SURE NOTCHES ON COLLET BOLT (7) ARE POINTING TOWARDS LEVER (9).** This complete subassembly may then be inserted into frame (6) and retained by pivot pins (12).