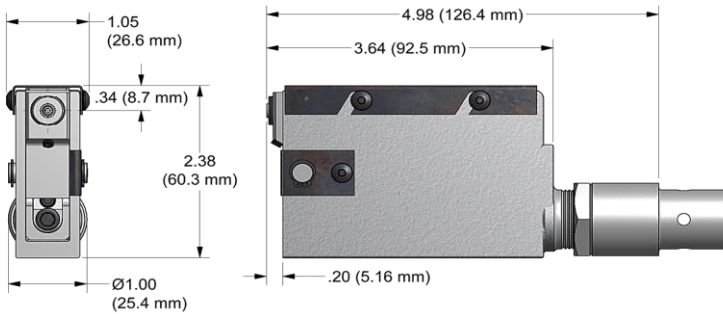


NOSE ASSEMBLY DATA SHEET

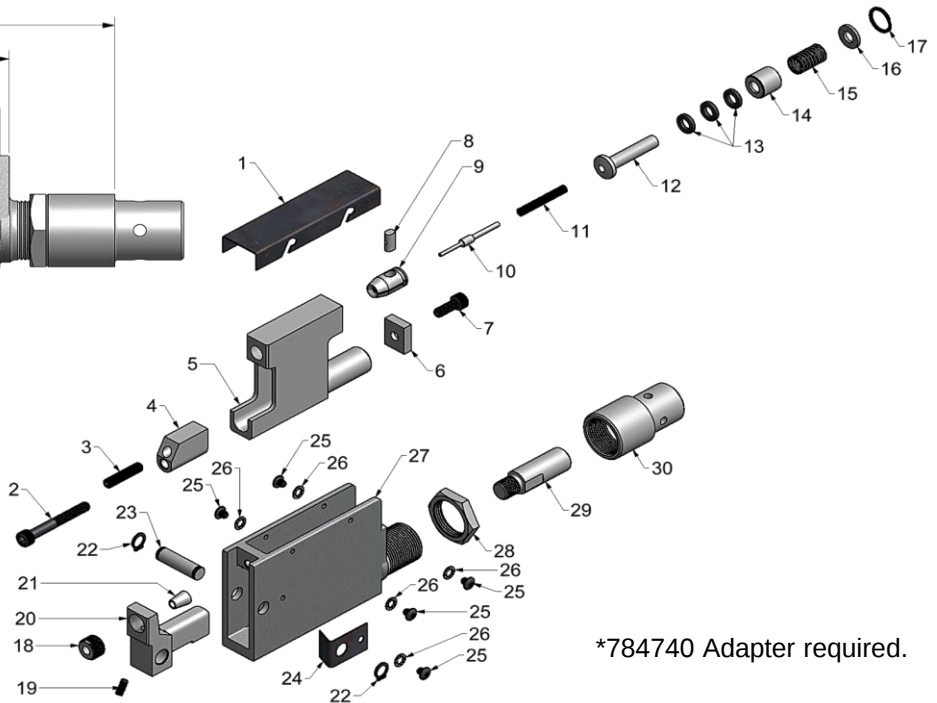


DISCRIPTION:

This is a mechanically shifting offset nose assembly designed for installing Cherrylock® 2000 series rivets up to 1/2" grip length in limited access areas. There is a separate nose assembly required for each head style (universal and countersunk) and each shank diameter. This nose assembly not to be used on bulbed Cherrylock® rivets.



REV. 8/18



*784740 Adapter required.

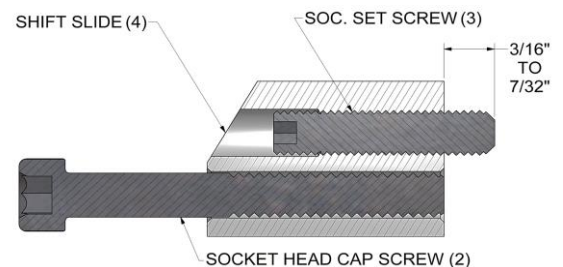
GAGE BILT MADE in USA

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:	Recommended Tool:
Single Action 3/16" Ø		Cherrylock® 2000 (Except Bulbed Cherrylock®)	GB740
			Alternate Tools: *GB784
Ref. No.	Qty.	Description	6U-640A-50
1	1	Cover	60402
2	1	Socket Head Cap Screw	400107
3	1	Soc. Set Screw	S402
4	1	Shift Slide	60403
5	1	Collet	60404
6	1	Stop Block	60813
7	1	Socket Head Cap Screw	400100
8	1	Stem Stop	70401
9	1	Jaw Assy (Incl. 400777 - O'ring)	30626
10	1	Ejector Pin	60406
11	1	Spring	50413
12	1	Follower	40407
13	3	O'ring	A-720
14	1	Spacer	55402
15	1	Spring	50410
16	1	Washer	50411
17	1	Retaining Ring	S405
18	1	Outer Anvil	10673
19	1	Soc. Set Screw	S924
20	1	Rocker Arm	60408
21	1	Inner Anvil	19607
22	2	Retaining Ring	S404
23	1	Pivot Pin	60409
24	1	Guard	60410
25	5	Button Head Cap Screw	S714
26	5	Washer - Internal #6	S42
27	1	Frame	60607
28	1	Jam Nut	70821
29	1	Adapter-Collet	60414
30	1	Sleeve Adapter	60415

ASSEMBLY INSTRUCTIONS:

1. Replace any broken or worn parts. When reassembling drawbolt, press in special washer (16) while inserting retaining ring (17). When retaining ring is in place turn special washer until its lug is positioned between the ends of the retaining ring.
2. If shift slide (4) has been removed from nose assembly for repair or replacement, it should be repositioned by turning screw (3) until it protrudes from the back of the slide 3/16" to 7/32". With the shift slide pressed snugly against rear of drawbolt (5), run cap screw (2) in until tight. Shift slide will then be in approximately the correct operating position, but may require minor adjustments as shown in the shift point adjustment instructions.
3. Apply a coating of high pressure grease, such as Lubriplate® 130AA, to the top and bottom of drawbolt (5) and to the bottom of rocker arm (20). Reassemble nose.



DISASSEMBLY:

1. Loosen jam nut (28) and remove adapter sleeve (30). Remove drawbolt adapter (29).
2. Remove four button head screws (25) and lift off cover (1).
3. Remove retaining ring (22), button screw (25), guard (24) and pivot pin (23). This will allow rocker arm (20), anvil (21) and drawbolt (5) to be removed from sleeve assembly (27).
4. To disassemble drawbolt, remove retaining ring (17) and washer (16). The stem stop (8), jaws (9), ejector (10), spring (11), follower (12), seat (13), spacer (14) and spring (15) will then come out of rear of drawbolt.
5. It is not usually necessary to remove the shift slide (4), stop block (6) or outer anvil (18), but if any of them have been damaged they may be removed by loosening screws (2), (7) and (19).

CLEANING NOSE ASSEMBLY:

It is important that the nose assembly be kept clean, especially around the riveting end, as adhesives, chips, sealants, etc. will clog the serrations of the jaws and cause slipping. The outer anvil and the inner anvil must be kept especially clean since foreign matter can build up and keep the anvil from going all the way forward to set the locking collar in the rivet.

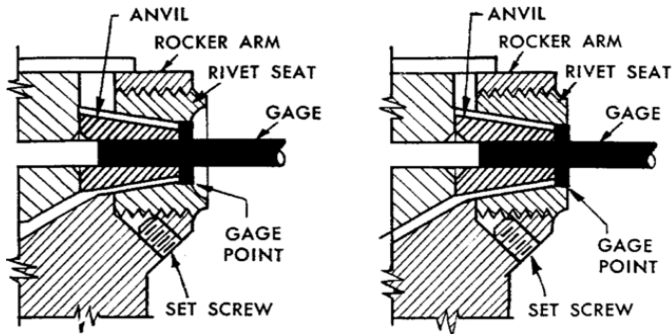
An occasional application of good grade high pressure grease, such as Lubriplate® 130AA, to the bottoms of the drawbolt and rocker arm will prolong the life of these parts.

ADJUSTING NOSE ASSEMBLY:

These nose assemblies are factory adjusted to properly install rivets in the A-Group (shorter lengths). If nose assembly has been disassembled for repair it will be necessary to readjust it. Gages can be purchased and are identified by their color: 3/16" No. 628-6 is blue.

INNER ANVIL ADJUSTMENT:

1. When adjusting nose assembly, either on or off tool, make sure the drawbolt (5) is in the full forward position.
2. Push rocker arm (20) back toward drawbolt so it will rest on shift slide (4).
3. Insert short end of setting gage into outer anvil (18) until inner face of gage collar rests against end of inner anvil (21) and anvil rests on crossbar in sleeve. Outer face of gage collar should be approximately .010 above face of countersunk head outer anvil or approximately .010 above bottom recess on universal head outer anvil.
4. If adjustment is required, loosen set screw (19) and turn outer anvil (18) for proper positioning.
5. Tighten set screw (19) snugly to prevent anvil from getting out of adjustment.



SHIFT-POINT ADJUSTMENT:

This adjustment determines the flushness of the broke pintail. After the lock ring is set, the pintail should fracture substantially flush with the rivet head.

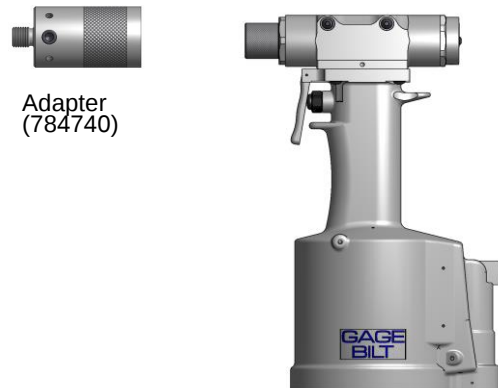
1. If the stem breaks below flush, loosen cap screw (2) and turn set screw (3) clockwise 1/4 turn (maximum). Tighten cap screw (2).
2. Test setting by installing rivet and repeat if necessary.
3. If stem breaks above flush, loosen cap screw (2) and turn set screw (3) counterclockwise 1/4 turn (maximum). Tighten cap screw (2).
4. Test setting by installing rivet and repeat if necessary.
5. If nose assembly is so far out of adjustment that it does not respond to these 1/4 turn adjustments, it may be quicker to remove the rocker arm (20) and shift slide (4) and reposition the adjusting screw (3) to its approximate starting position outlined under Assembly Instructions line 2.

INSTALLATION INSTRUCTIONS FOR ATTACHING TO THE GB740 TOOL:

1. Connect tool to air supply, making sure head piston of the tool is in its full forward position.
2. Screw pulling head onto piston assy (740409) on tool.
3. After pulling head is attached, then back off pulling head until hole in the adapter sleeve (60415) lines up with one of holes in nose fitting (740101) on tool.
4. Secure to tool using Soc. Hd. Cap Screws (401208) with lined up hole. Secure second screw in secondary location. See **GB740** tool manual.

INSTALLATION INSTRUCTIONS USING ADAPTER (784740) FOR ATTACHING TO GB784 TOOL:

1. Connect tool to air supply, making sure head piston of the tool is in its full forward position.
2. Install adapter (784740) onto tool.
Adapter (784740) screws onto head piston (784112) on tool.

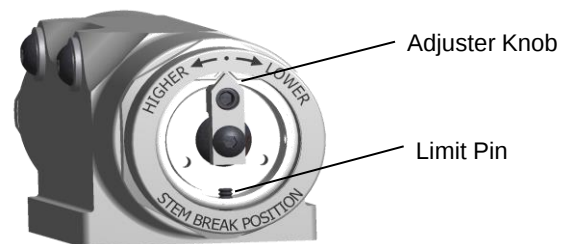


3. Attach the pulling head to the adapter (784740).
4. After pulling head is attached, then back off pulling head until hole in the adapter sleeve (60415) lines up with one of holes in nose assembly adapter (784740).
5. Secure to tool using Soc. Hd. Cap Screws (401208) with lined up hole. Secure second screw in secondary location.



Note: The shift point setting on the tool must be adjusted to compensate for the longer stroke when using adapters.

6. Remove limit pins.
7. Turn adjusting knob counter-clockwise until it stops.



The GB784 will now install Cherrylock® rivets up to 1/2" grip length. Before using a straight 681 series pulling head again, the tool must be re-adjusted using stroke setting gage (784159). See GB784 tool manual for instructions.