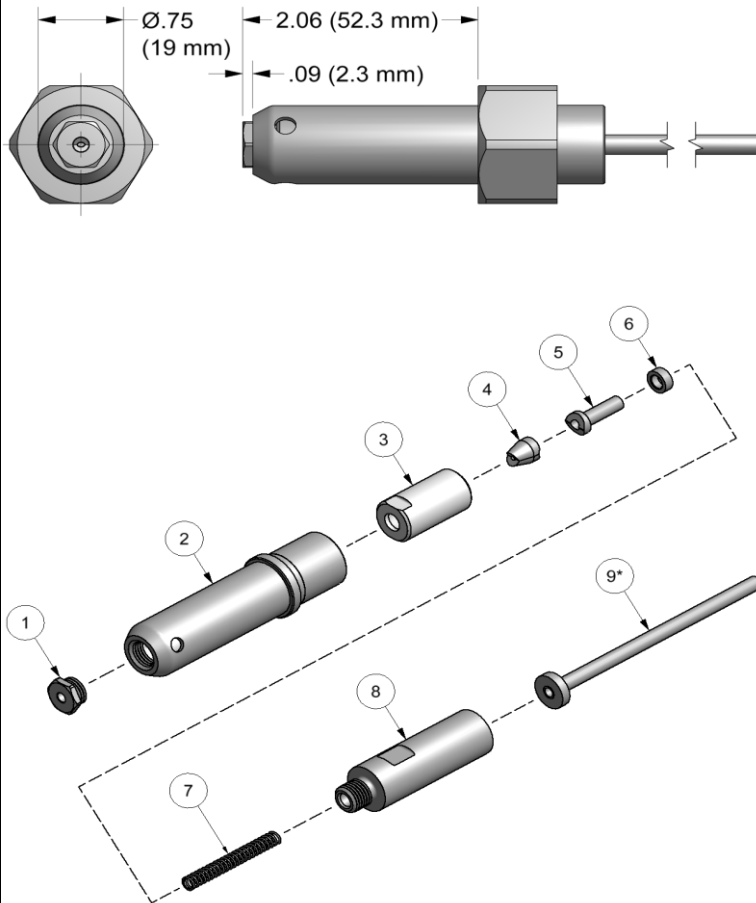


NOSE ASSEMBLY DATA SHEET



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 (8) to 80 - 100 IN-LBS. (.36 - .44 Kn) torque.
- If nose assy is assembled as it is when purchased new, follow steps 4 - 6 to attach to tool.

- Drop chuck jaws (4) into rear of collet (3).
- Slide bumper (6) over follower and push flush with o.d. Drop follower (5) into rear of collet (3) and onto rear of chuck jaws (4). (Note position in exploded view).
- Thread collet (3) to extension-collet (8). Snug with 9/16" wrench to extension-collet (8) using flats. Drop spring (7) into rear of extension-collet (8).
- Insert pintail tube (9) into i.d. of piston on tool. Thread assembled parts to piston. Snug with 9/16" wrench using flats of collet (3) and hex key into rear of piston of tool.

- Slide anvil holder assembly (1) over assembled parts attached to piston on tool.
- Slide retaining nut from tool onto anvil holder assy (2) and tighten nose assy to tool.

DISASSEMBLY:

Reverse assembly instructions.



1/08 Rev. 10/25

*Remove for -6 NAS1919/21S & U.

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Type:		Fastener:	Recommended Tool:
Non Self-Releasing 1/8", 5/32" & 3/16" Ø		NAS1900 S & U SERIES UNIMATIC® BLIND RIVET (SINGLE ACTION) WITH DRIVE WASHER	GB751
			Alternate Tools: GB722 & GB2480(A)
Ref. No.	Qty.	Description	456UBR-751A-21
1	1	Nose Tip	10206-1
2	1	Anvil-Holder Assembly	10942-4
3	1	Collet	70105
4	1	Jaw Set	30513
5	1	Follower	40506-1
6	1	Bumper	70108
7	1	Spring	50316
8	1	Extension-Collet	70466
9*	1	Pintail Tube	40446

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