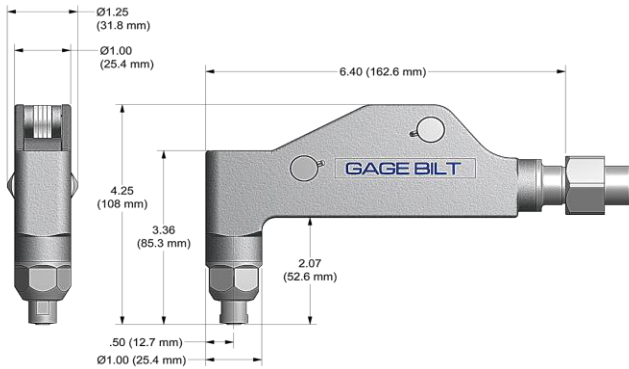
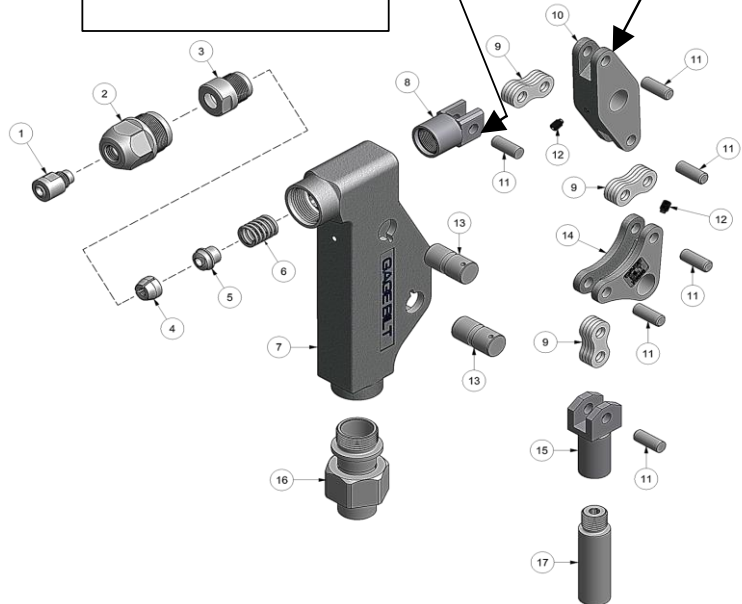


NOSE ASSEMBLY DATA SHEET



WHEN ASSEMBLING TO NOSE ASSY:
CHAMFERS ON PART MUST BE FACING DOWN

WHEN MOUNTING ON RIVETER:
Press & Hold lever (10) in direction shown.



9/11 Rev. 10/25

GAGE BILT
MADE in USA

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Type:		Fasteners:	Recommended Tool:
Single Action 1/4" Ø		NAS1900 S & U SERIES UNIMATIC® BLIND RIVET (SINGLE ACTION) WITH OR W/O DRIVE WASHER	
Ref. No.	Qty.	Description	SMLS08-713B -58RA
1	1	Nose Tip	18880
2	1	Holder	13424
3	1	Collet	28830
4	1	Jaw Set	30872
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 Assembly	70845
14	1	Bellcrank	70846
15	1	Drawbolt	70847
16	1	Anvil Adapter Assembly	70868
17	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 (7). Unscrew collet (3) which contains jaws (4), follower (5) and spring (6) from collet bolt (8).

Remove two 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). Apply Vibra-TITE® to set screws (12) when reassembling linkage. **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). Apply Loctite® 242 to threads on Anvil Adapter Assy (16) and Collet Extension (17) during reassembly.