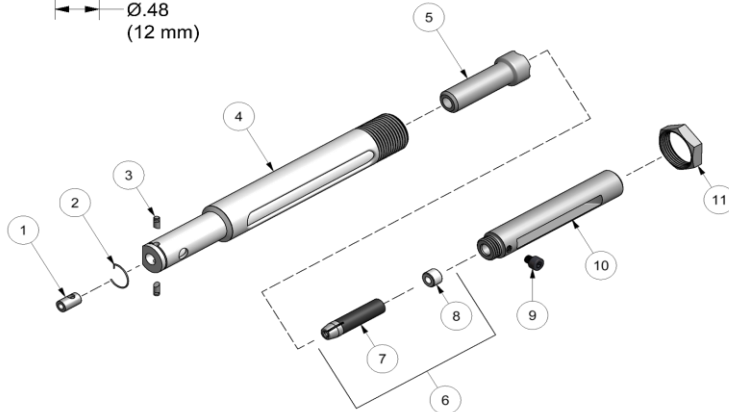
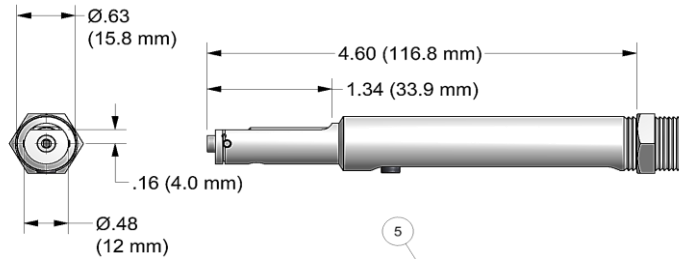


NOSE ASSEMBLY DATA SHEET



Effective FOD Control (foreign object damage/debris). Install catcher bag on the front of the riveter to catch spent pintail stems. Place nose assembly through grommet on catcher bag and easily fasten catcher bag to tool using the Velcro strap. Features an easily emptied zippered pouch.

Use catcher bag 500610 for XX-51-46 straight nose assemblies

Catcher bag sold separately

POINT NOSE ASSEMBLY DOWN WHEN ATTACHING

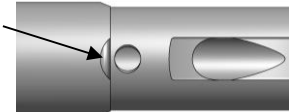
Notes:

- Apply Vibra-tite® p/n/ 405125 to all threads and allow it to set 20 minutes prior to assembly.
 - If nose assy is assembled as it is when purchased new, follow step 5 to attach to tool.
- Place super grip jaw assy (7) into rear of collet (5). Then place spacer (8) onto rear of super grip jaw assy (7).
 - Hand thread assembled collet (5) to drawbolt (10) and tighten. If rear radius on collet (5) isn't aligned with threaded hole on drawbolt (10) when tight, unthread collet (5) slightly until aligned. (See image below).
 - Slide assembled collet (5) and drawbolt (10) into anvil holder (4). Align threaded hole on drawbolt (10) with slot on anvil holder (4).
 - Insert screw (9) into threaded hole on drawbolt (10) and tighten.
 - Thread drawbolt (10) to piston on tool one full turn then thread anvil holder (4) into tool until it stops. Tighten jam nut (11) to face of tool.

DISASSEMBLY:

Reverse assembly instructions.

Align radius on collet (5) with threaded hole on bottom of drawbolt (10)



12/16 REV 4/25



*GB704 REQUIRES 704001 ADAPTER

GAGE BILT

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Type:		Fastener:	Recommended Tool:
Single Action Non Self-Releasing 1/8" Ø		MS20600, CHERRY® 9000 HUCK® PT, SP & MS OLYMPIC RV200 & RV500 NAS1919S & U / NAS1921S & U (WITH DRIVE WASHER)	GB50
			Alternate Tools: GB51, *GB704 & GB715
Ref. No.	Qty.	Description	4C-51-46AIS
1	1	Nose Tip	10334
2	1	Retaining Ring	50308
3	2	Ratchet Pin	15521-1
4	1	Anvil-Holder	10318
5	1	Collet	20326
6	1	Jaw Assembly	30428-A2
7	1	Super Grip Jaw Assembly	30428-CS
8	1	Spacer	40461
9	1	Screw	70303
10	1	Drawbolt	70301
11	1	Locknut	70411

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