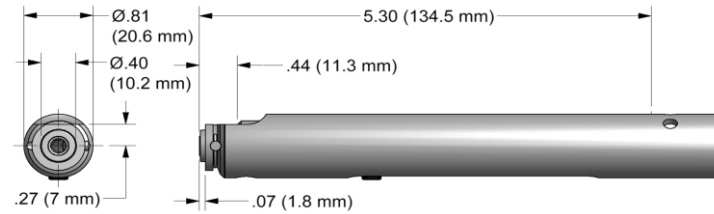


NOSE ASSEMBLY DATA SHEET



ASSEMBLY:

Notes:

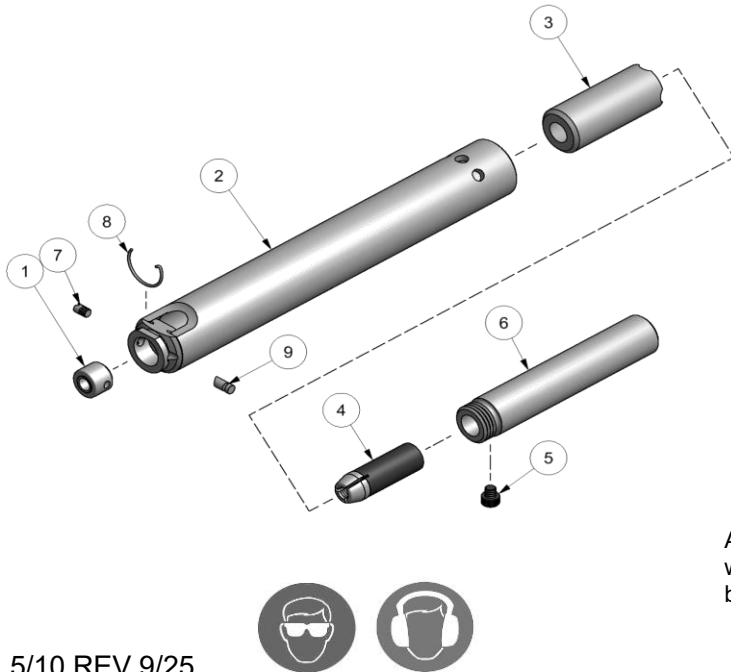
A. Apply Vibra-tite® p/n/ 405125 to all threads and allow it to set 20 minutes prior to assembly.

B. If nose assy is assembled as it is when purchased new, follow steps 5 to attach to tool.

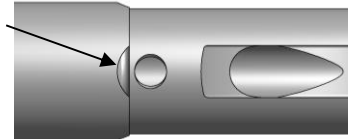
1. Insert super grip jaw assembly (4) into collet (3).
2. Thread assembled collet (3) to drawbolt (6). If rear radius on collet (3) isn't aligned with threaded hole on drawbolt (6) when tight, unthread collet (3) slightly until aligned. (See image below).
3. Slide assembled collet (3) and drawbolt (6) into anvil holder (2). Align threaded hole on drawbolt (6) with slot on anvil holder (2).
4. Insert screw (5) into threaded hole on drawbolt (6) and tighten.
5. Thread drawbolt (6) to piston on tool and align the 3 rear holes on anvil holder (2) with holes in nose fitting on tool and tighten two s.h.c.s. to lock into place.

DISASSEMBLY:

Reverse assembly instructions.



Align radius on collet (6) with threaded hole on bottom of drawbolt (10)



5/10 REV 9/25

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Type:		Fastener:	Recommended Tool: GB740
Single Action 1/4" Ø		"A" CODE NAS1398A, NAS1399A NAS1738A, NAS1739A	
Ref. No.	Qty.	Description	8A-740B-52
1	1	Anvil-Insert Universal	10393
2	1	Anvil Holder	13351
3	1	Collet	20330
4	1	Super Grip Jaw Assembly	30864-CS
5	1	Screw	400046
6	1	Drawbolt	70316
7	1	Screw	15509
8	1	Spring-Retaining	50313
9	1	Ratchet Pin	15519