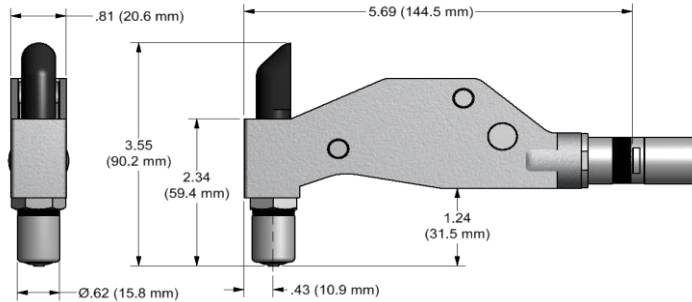


# NOSE ASSEMBLY DATA SHEET



## CAUTION!

Do not operate if pintail deflector is removed. Pintail may eject forcibly. SEVERE PERSONAL INJURY MAY RESULT.

\*RIGHT ANGLE NOSE ASSEMBLIES REQUIRE MORE THAN ONE "PULL".

\*\*G83 USE 830140 STROKE LIMITER.

\*\*\*G84 USE 840140 STROKE LIMITER.



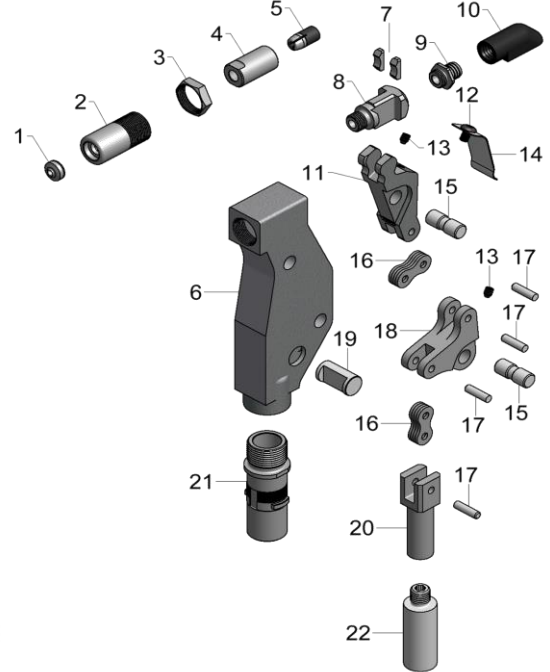
3/25 REV 10/25

## GAGE BILT MADE in USA

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| Type:                    | Fasteners:                                                                                            | Recommended Tool: |
|--------------------------|-------------------------------------------------------------------------------------------------------|-------------------|
| Single Action<br>5/32" Ø | NAS1900 S & U SERIES<br>UNIMATIC® BLIND RIVET<br>(SINGLE ACTION)<br><b>WITH OR W/OUT DRIVE WASHER</b> | **G83 & ***G84    |

| Ref. No. | Qty. | Description              | SMLS05-83A-54RA |
|----------|------|--------------------------|-----------------|
| 1        | 1    | Nose Tip                 | 15596           |
| 2        | 1    | Anvil Holder             | 10115           |
| 3        | 2    | Jam Nut                  | 70411           |
| 4        | 1    | Collet                   | 20327           |
| 5        | 1    | Super Grip Jaw Assembly  | 30529-S4        |
| 6        | 1    | Frame                    | 75310           |
| 7        | 2    | Shoe Bearing             | 75311           |
| 8        | 1    | Drawbolt Collet          | 70486           |
| 9        | 1    | Barbed Retainer          | 70575           |
| 10       | 1    | Deflector                | 61107           |
| 11       | 1    | Lever                    | 75313           |
| 12       | 1    | Button Head Cap Screw    | 402471          |
| 13       | 2    | Set Screw                | 75315           |
| 14       | 1    | Guard                    | 75316           |
| 15       | 2    | Pivot Pin                | 75317           |
| 16       | 8    | Link                     | 75318           |
| 17       | 4    | Link Pin                 | 75319           |
| 18       | 1    | Bellcrank                | 75320           |
| 19       | 1    | Guide Pin                | 75321           |
| 20       | 1    | Drawbolt                 | 75322           |
| 21       | 1    | Adapter Fitting Assembly | 70442           |
| 22       | 1    | Extension-Collet         | 70463           |



## ATTACHMENT:

Screw extension-collet (22) onto head piston and adapter fitting assy (21) into nose adapter.

After attaching the nose assembly to the riveter, adjust anvil holder (2) by loosening jam nut (3), then insert largest diameter rivet to be installed in anvil holder and rotate anvil holder until jaws just grab pintail. Tighten jam nut (3) securely. By this anvil holder adjustment, the nose assembly can be made to release or to hold the pintail after installation.

## DISASSEMBLY:

Loosen jam nut (3) and remove anvil holder (2). Unscrew collet (4) which contains super grip jaw assy (5) from drawbolt collet (8).

Remove button head cap screw (12) and guard (14). Remove two set screws (13) and push out two pivot pins (15) to permit removal of linkage. Shoe bearings (7) and drawbolt collet (8) will disengage from lever (11).

Remove four link pins (17) to disassemble lever (11), links (16), bellcrank (18) and drawbolt (20).

Remove guide pin (19) from frame (6). Adapter fitting assy (21) is secured to frame with Loctite® and need not be removed unless damaged.

## REASSEMBLY:

Reverse the procedure. Linkage, consisting of lever (11), links (16), bellcrank (18) and drawbolt (20) should be assembled as a subassembly before inserting lever (11) into shoe bearings (7) and drawbolt collet (8). MAKE SURE NOTCHES ON COLLET BOLT (8) ARE POINTING TOWARDS LEVER (11). This complete subassembly may then be inserted into frame (6) and retained by guide pin (19) and pivot pins (15).