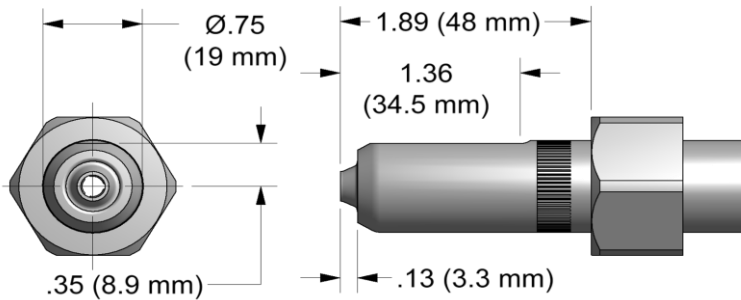
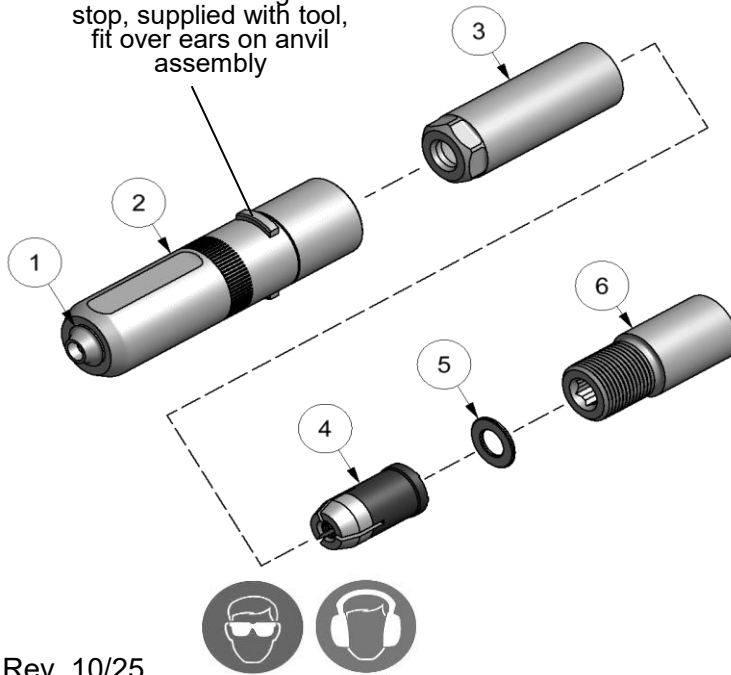


NOSE ASSEMBLY DATA SHEET



Slots on retaining nut stop, supplied with tool, fit over ears on anvil assembly



ASSEMBLY:

Notes:

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

B. Tighten collet (3) and extension-collet (6) to 80-100 IN-LBS. (.36 - .44 Kn) torque.

C. If nose assy is assembled as it is when purchased new, follow steps 3-5 to attach to tool.

1. Place extension-collet (6) on a flat surface with threads facing upward. Then place spacer (5) on top of extension-collet (6) then super grip jaw assembly (4) on top of spacer.

2. Hand thread collet (3) to extension-collet (6). Then tighten collet (3) to extension-collet (6) using hex key in front of collet-extension (6) and flats provided on collet (3) per "B" above.

3. Thread assembled collet (3) and extension-collet (6) onto piston of tool using flats provided and hex in rear of piston.

4. Slide anvil assembly (2) over collet (3).

5. Slide retaining nut stop and retaining nut over ears on anvil (see exploded view) and tighten nose assembly to tool.

DISASSEMBLY:

Reverse assembly instructions.

Rev. 10/25

GAGE BILT
MADE IN U.S.A.

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Type:		Fastener:	Recommended Tool:
Non Self-Releasing 1/4" Ø		NAS1900 S & U SERIES UNIMATIC® BLIND RIVET (SINGLE ACTION) WITH OR W/OUT DRIVE WASHER	GB722
			Alternate Tools: GB713 & GB2480(A)
Ref. No.	Qty.	Description	SMLS08-713-20
1	1	Anvil Insert	10868
2	1	Anvil Assembly (Inc. #1)	10939
3	1	Collet	20841
4	1	Super Grip Jaw Assembly	30653-CS
5	1	Spacer	60844
6	1	Extension-Collet	70823

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