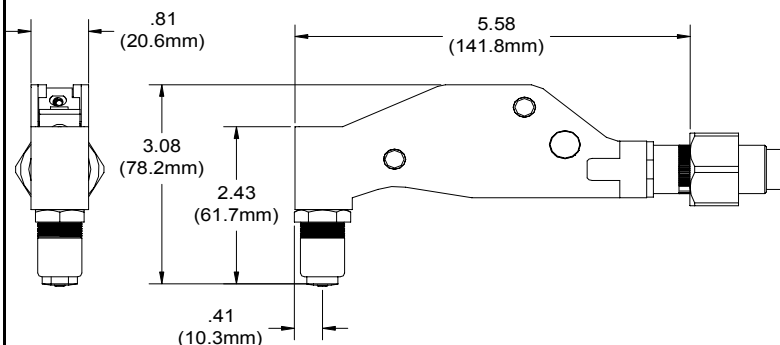


NOSE ASSEMBLY DATA SHEET



CAUTION!

Pintails may eject forcibly. This nose is for closed access applications. If used in open access applications, 704214 catcher bag is recommended TO PREVENT SEVERE PERSONAL INJURY.

Nose Assembly	Anvil-Driving
MBC04-751B-54RA	10251
MBC05-751B-54RA	10252
MBC06-751B-54RA	10253

12/12 *MOST FASTENERS REQUIRE MORE THAN ONE PULL.

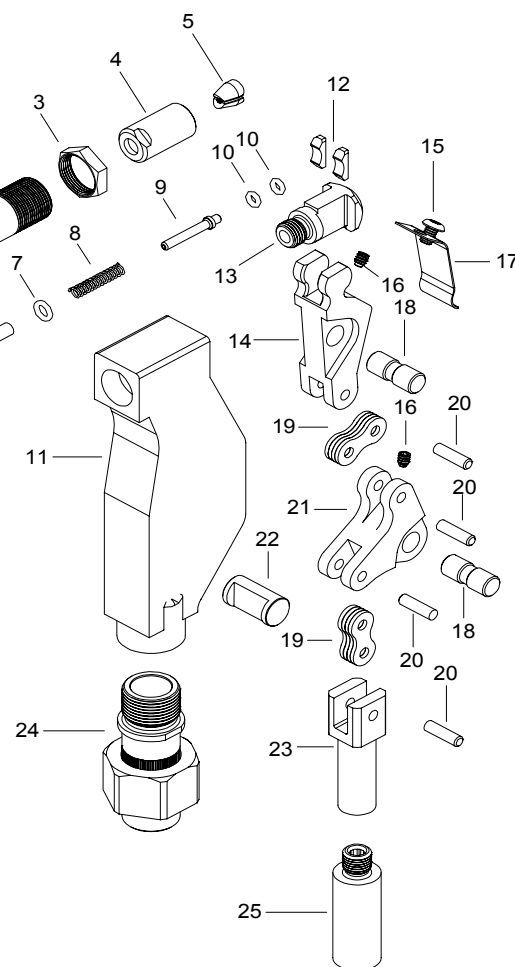
GAGE BILT

GAGE BILT Inc.

44766 Centre Court (586) 226-1500
Clinton Twp., MI 48038 (586) 226-1505 Fax
e-mail: solutions@gagebilt.com / www.gagebilt.com

Type:	Fasteners:	Recommended Tool:
Single Action 1/8", 5/32 & 3/16" Ø	NAS1719 NAS1720 NAS1721 MBC®	GB751

Ref. No.	Qty.	Description	MBC-751B-54RA
1	1	Anvil-Driving	See Chart
2	1	Sleeve	10125
3	1	Jam Nut	70411
4	1	Collet	20513
5	1	Jaw Set	30513
6	1	Follower	40506
7	1	O'Ring	400774
8	1	Spring	50505
9	1	Stem Stop	70408
10	2	O'Ring	A-1034
11	1	Frame	75310
12	2	Shoe Bearing	75311
13	1	Collet Bolt	75312
14	1	Lever	75313
15	1	But. Hd Screw	402471
16	2	Set Screw	75315
17	1	Guard	75316
18	2	Pivot Pin	75317
19	8	Link	75318
20	4	Link Pin	75319
21	1	Bell Crank	75320
22	1	Guide Pin	75321
23	1	Drawbolt	75322
24	1	Adapter Assembly	70459
25	1	Collet Extension	70463



ATTACHMENT:

Engage 1 or 2 threads of extension (25) onto head piston, then insert adapter fitting (24) into end of head cylinder and turn clockwise until snug. Rotate nose assembly to desired position and tighten nut (24) securely.

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

DISASSEMBLY:

Loosen jam nut (3) and remove sleeve (2). Unscrew collet (4) which contains jaws (5), follower (6), o'ring (7), spring (8), stem stop (9) and o'rings (10) from collet bolt (13).

Remove screw (15) and guard (17). Remove 2 set screws (16) and push out 2 pivot pins (18) to permit removal of linkage. Shoe bearings (12) and collet bolt (13) will disengage from lever (14).

Remove 4 link pins (20) to disassemble lever (14), links (19), bell crank (21) and drawbolt (23).

Remove guide pin (22) from frame (11). Adapter fitting (24) is secured to frame with Loctite® and need not be removed unless damaged.

REASSEMBLY:

Reverse the procedure. Linkage, consisting of lever (14), links (19), bell crank (21) and drawbolt (23) should be assembled as a subassembly before inserting lever (14) into shoe bearings (12) and collet bolt (13). MAKE SURE NOTCHES ON COLLET BOLT (13) ARE POINTING TOWARDS LEVER (14). This complete subassembly may then be inserted into frame (11) and retained by guide pin (22) and pivot pins (18).