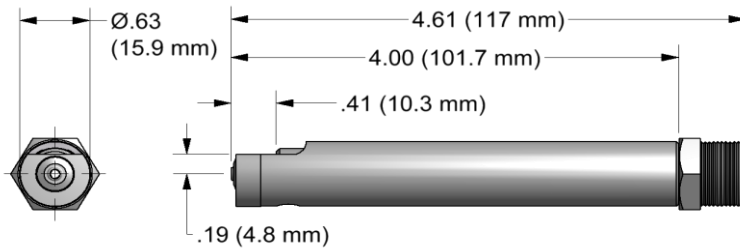


NOSE ASSEMBLY DATA SHEET



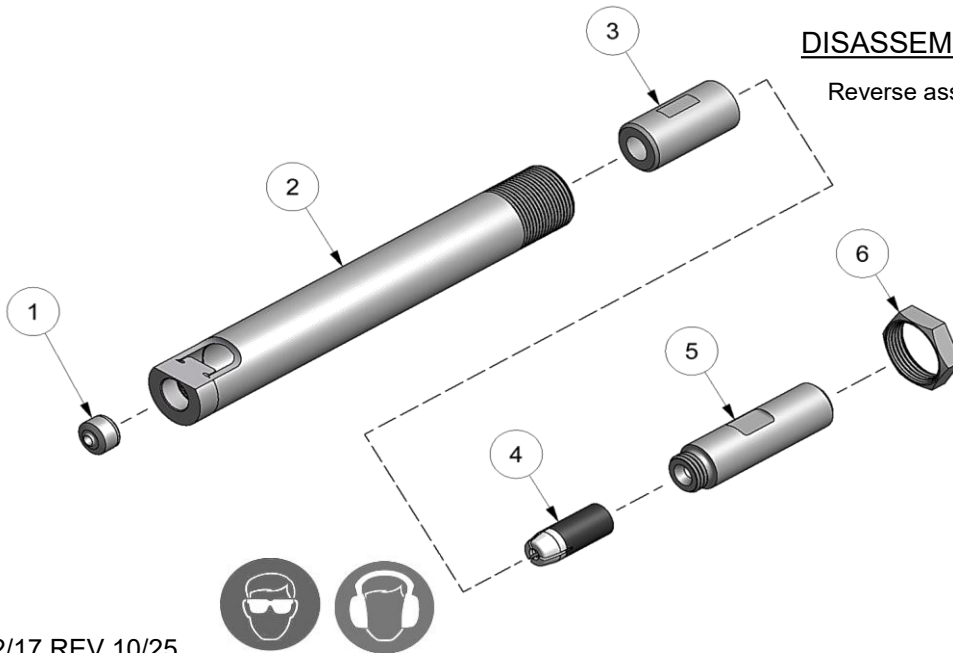
ASSEMBLY:

Notes:

- Apply Vibra-tite® p/n/ 405125 to all threads and allow it to set 20 minutes prior to assembly.
- Tighten collet (3) and drawbolt (5) to 80-100 IN-LBS. (.36 - 44 Kn) torque.
- If nose assy is assembled as it is when purchased new, follow steps 3 - 4 to attach to tool.
 - Place super grip jaw assy (4) into rear of collet (3).
 - Thread assembled collet (3) to drawbolt (5) using flats provided and tighten.
 - Thread assembled collet (3) & drawbolt (5) to piston on tool.
 - Slide anvil & holder assembly (2) over assembled collet (3) and drawbolt (5) and thread into tool. Tighten jam nut (6) to face of tool.

DISASSEMBLY:

Reverse assembly instructions.



2/17 REV 10/25

GAGE BILT
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Type: Non Self-Releasing			NAS1900 S & U SERIES UNIMATIC® BLIND RIVET (SINGLE ACTION) WITH OR W/OUT DRIVE WASHER	Recommended Tool: GB54B
1/8" Ø				Alternate Tool: GB55B & GB101A-54
Ref. No.	Qty.	Description		SMLS04-54-43
1	1	Anvil Insert		10470
2	1	Anvil & Holder Assembly (Incl. #1)		12390
3	1	Collet		20332
4	1	Super Grip Jaw Assembly		30418-S
5	1	Drawbolt		70342
6	1	Locknut		70411

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