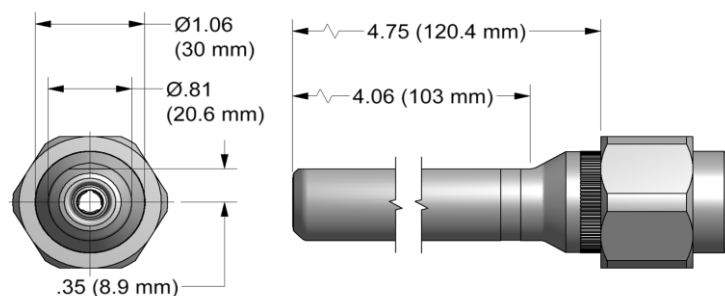


NOSE ASSEMBLY DATA SHEET



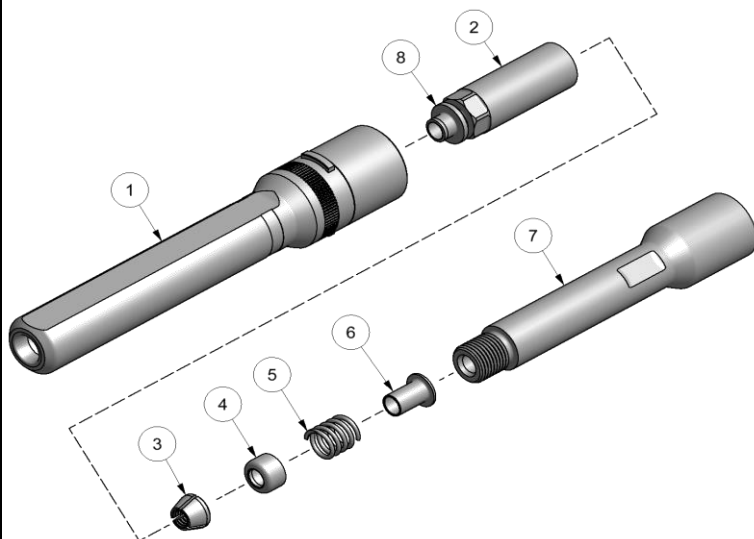
ASSEMBLY:

Notes:

- Apply Vibra-tite® p/n/ 405125 to all threads and allow it to set 20 minutes prior to assembly.
 - Tighten collet assy (2) and extension-collet (7) to 80-100 IN-LB torque.
 - If nose assy is assembled as it is when purchased new, follow steps 5-6 to attach to tool.
- Place extension-collet (7) on a table with threads facing upward.
 - Slide spring (5) around sleeve (6) then place follower (4) onto opposite end of spring (5).
 - Stack assembled follower (4), spring (5) and sleeve (6) onto standing extension-collet (7). Place jaw set (3) onto top of follower (4). (See exploded view).
 - Slide collet assy (2) over stacked assembly and hand tighten. Tighten assembled collet (2) to extension-collet (7) using flats provided per note "B" above.
 - Thread assembled collet and extension-collet to piston on tool using flats provided and hex key in rear of piston on tool.
 - Slide retaining nut over ears on anvil (1) (Note: retaining nut stop not used on self releasing nose assemblies) and tighten to tool.

DISASSEMBLY:

Reverse assembly instructions.



Rev. 3/25

*Anvil Assembly includes 35308 retainer.

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Type:		Fastener:	Recommended Tool:
Self-Releasing 1/4" Ø		NAS Shear and Tension Pull Type Lockbolts, C6L® and GP® Lockbolts	GB745
			Alternate Tools: GB756 & GB2581(A)
Ref. No.	Qty.	Description	NAS08-353-48
1	1	*Anvil Assembly	18802
2	1	Collet Assy (Incl. #8)	20897
3	1	Jaw Set	30858
4	1	Follower	40883
5	1	Spring	50804
6	1	Sleeve	60825
7	1	Extension-Collet	70837
8	1	Release & Ejector (Included with #2)	80813

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