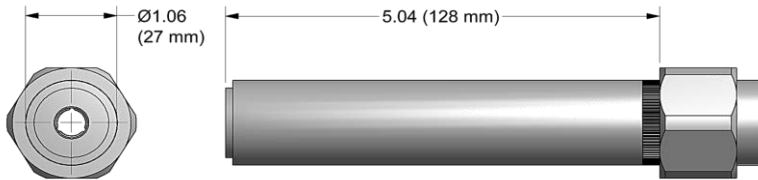


NOSE ASSEMBLY DATA SHEET



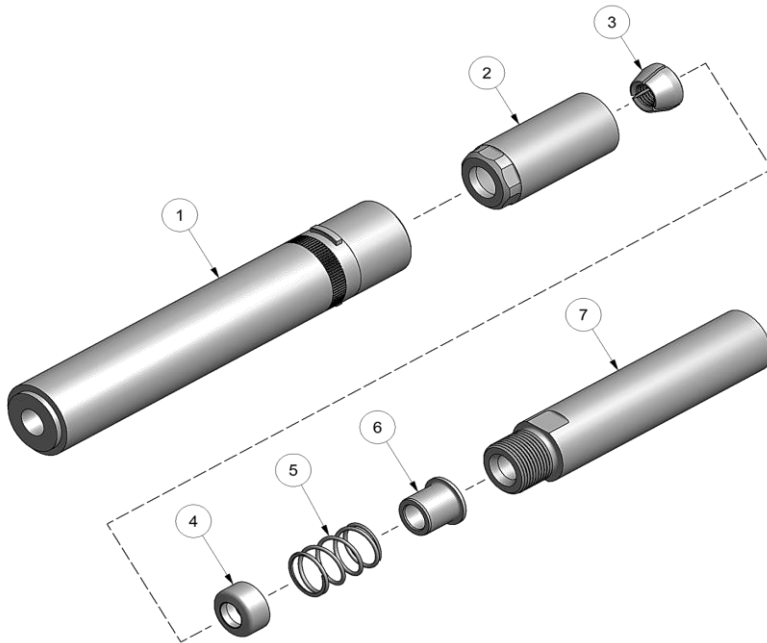
ASSEMBLY:

Notes:

- Apply Vibra-tite® p/n/ 405125 to all threads and allow it to set 20 minutes prior to assembly.
 - Tighten collet (2) and extension-collet (4) to 80-100 IN-LB torque.
 - If nose assy is assembled as it is when purchased new, follow steps 3-5 to attach to tool.
- Insert jaw assy (3) into rear of collet (2). (Note direction in exploded view). Then place spring (5) into follower (4) and slide sleeve (6) into opposite end of spring (5).
 - Insert follower (4), spring (5) and sleeve (6) into rear of collet (2) and flush against rear of jaw assy (3). Thread collet (2) to extension-collet (7) using flats provided on extension-collet (7) and flats provided on collet (2).
 - Thread assembled collet (2) and extension-collet (7) onto piston of tool using flats provided and hex in rear of piston.
 - Slide holder assy (1) over collet (2).
 - Slide retaining nut over ears on anvil (see exploded view) and tighten to tool. (Note: retaining nut stop not used on this nose assy).

DISASSEMBLY:

Reverse assembly instructions.



10/12 REV 8/19

GAGE BILT
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Type:		Fastener:	Recommended Tool:
Self-Releasing 3/8" Ø		Hi-Lite® Pull-Stem	GB745
			Altrnate Tools: GB756 or GB2581(A)
Ref. No.	Qty.	Description	HL12-756-53
1	1	Insert & Holder Assy	11244
2	1	Collet	21250
3	1	Jaw Assy	31226-1
4	1	Follower	41221
5	1	Spring	51213
6	1	Sleeve	61215
7	1	Extension-Collet	71220