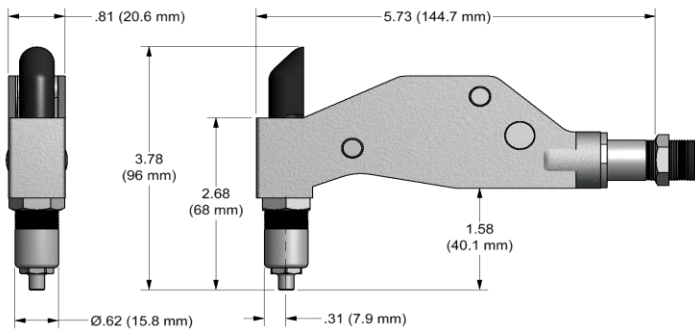


NOSE ASSEMBLY DATA SHEET



CAUTION!

Do not operate if pintail deflector is removed. Pintail may eject forcibly. SEVERE PERSONAL INJURY MAY RESULT.

*RIGHT ANGLE NOSE ASSEMBLIES REQUIRE MORE THAN ONE "PULL".

7/23

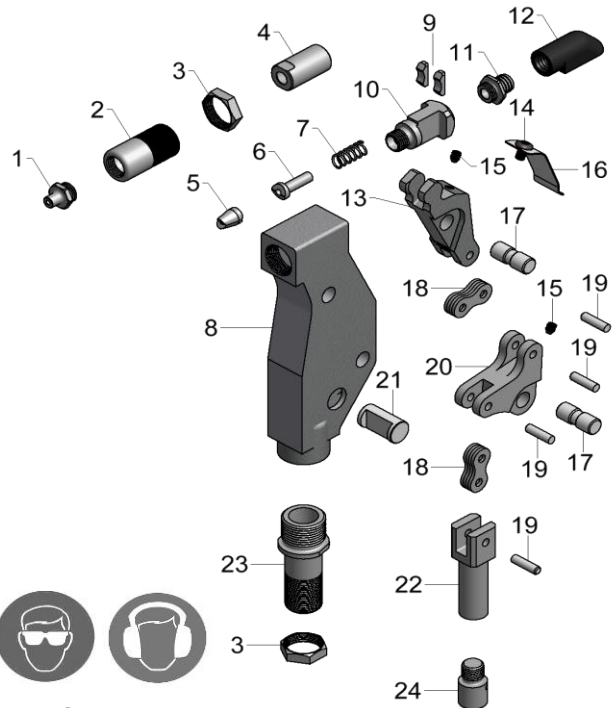
GAGE BILT

MADE in USA

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Type:	Fasteners:	Recommended Tool: GB715
Single Action Self Releasing 1/8" Ø	N, Q & E, POP®, CLOSED END, AVEX® & COMMERCIAL RIVETS	
		Alternate Tool: GB51

Ref. No.	Qty.	Description	4N-715-54RA
1	1	Nose Tip	10202
2	1	Anvil Holder	10125
3	1	Jam Nut	70411
4	1	Collet	20327
5	1	Jaw Assy	30617
6	1	Follower	40506
7	1	Spring	50420
8	1	Frame	75310
9	2	Shoe Bearing	75311
10	1	Drawbolt-Collet	70486-1
11	1	Barbed Retainer	70575
12	1	Deflector	61107
13	1	Lever	75313
14	1	Button Head Cap Screw	402471
15	2	Set Screw	75315
16	1	Guard	75316
17	2	Pivot Pin	75317
18	8	Link	75318
19	4	Link Pin	75319
20	1	Bell Crank	75320
21	1	Guide Pin	75321
22	1	Drawbolt	75322
23	1	Adapter-Frame	70458
24	1	Collet Extension	70457



ATTACHMENT:

Apply VIBRA-TITE® to all threads and let set for 20 minutes prior to assembly.

Disconnect air supply from tool. Hold back of drawbolt-collet (10) down with thumb. Thread anvil holder (2) into frame (8) until it bottoms out on collet (4). Loosen approximately 1/4 turn and tighten jam nut (3) securely to frame (8). Engage one or two threads of collet extension (24) onto piston assembly located on tool, then insert adapter-frame (23) into end of head cylinder assembly located on tool and turn clockwise until snug. Rotate nose assembly to desired position and tighten jam nut (3) securely. Reconnect air supply to tool.

DISASSEMBLY:

Loosen jam nut (3) and remove anvil holder (2). Unscrew collet (4) which contains jaw set (5) from drawbolt-collet (10).

Remove button head cap screw (14) and guard (16). Remove two set screws (15) and push out two pivot pins (17) to permit removal of linkage. Shoe bearings (9) and drawbolt-collet (10) will disengage from lever (13).

Remove four link pins (19) to disassemble lever (13), links (18), bellcrank (20) and drawbolt (22).

Remove guide pin (21) from frame (8). Adapter-frame (23) is secured to frame with Loctite® and need not be removed unless damaged.

REASSEMBLY:

Reverse the procedure. Linkage, consisting of lever (13), links (18), bellcrank (20) and drawbolt (22) should be assembled as a subassembly before inserting lever (13) into shoe bearings (9) and drawbolt-collet (10). MAKE SURE NOTCHES ON DRAWBOLT-COLLET (10) ARE POINTING TOWARDS LEVER (13). This complete subassembly may then be inserted into frame (8) and retained by guide pin (21) and pivot pins (17).