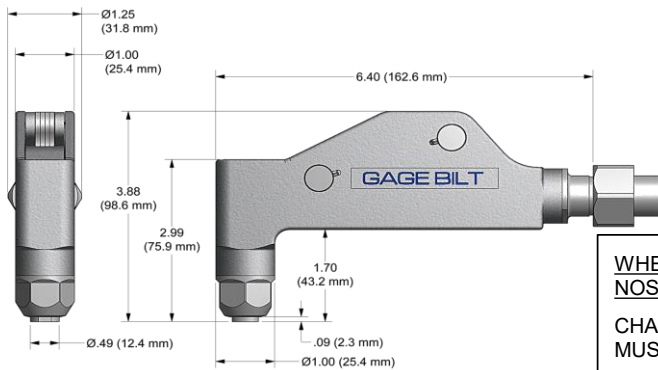
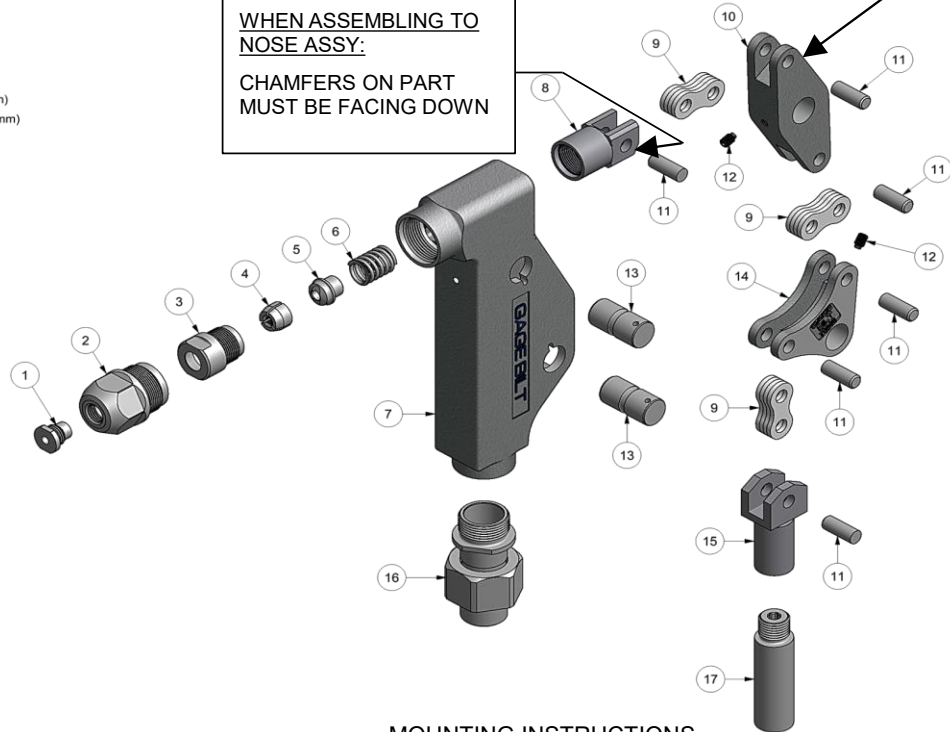


NOSE ASSEMBLY DATA SHEET



WHEN ASSEMBLING TO NOSE ASSY:
CHAMFERS ON PART MUST BE FACING DOWN

WHEN MOUNTING ON RIVETER:
Press & Hold in direction shown.



11/23 REV 10/25



GAGE BILT
MADE in USA

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Type:		Fasteners:	Recommended Tool:
Single Action 3/16"Ø		MS90353S & U / MS90354S & U MS21140S & U / MS21141S & U MAXI-BOLT®, BACB30YY, YU, & YT, CR7000 SERIES BLIND BOLT (SINGLE ACTION) WITH DRIVE WASHER	GB722
			Alternate Tool: GB713
Ref. No.	Qty.	Description	UBB06-713B-58RA
1	1	Nose Tip	16041
2	1	Holder	13424
3	1	Collet	28830
4	1	Chuck Jaw	30865
5	1	Follower	40311-4
6	1	Spring	A-1603
7	1	Frame	70864
8	1	Collet Bolt	70839
9	12	Link	70841
10	1	Lever	70843
11	6	Link Pin	70842
12	2	Set Screw	70844
13	2	Pivot Pin Assembly	70845
14	1	Bellcrank	70846
15	1	Drawbolt	70847
16	1	Anvil Adapter	70868
17	1	Extension-Collet	70875

MOUNTING INSTRUCTIONS

Apply Vibra-tite® p/n/ 405125 to all threads and allow it to set 20 minutes prior to assembly.

Attach riveter to air source for correct piston positioning. Push the drawbolt assembly forward (see above), before mounting. While holding drawbolt in a forward position, thread the nose assembly onto the riveter, making sure that both internal and external threads are connected. Use the jam-nut to lock the pulling head in position. Cycle the tool to make sure it is functional.

DISASSEMBLY AND ASSEMBLY

Disassembly:

Loosen and remove holder (2) from frame assy (7). Unscrew collet (3) which contains jaws (4), follower (5), and spring (6) from collet bolt (8).

Remove 2 set screws (12) and push out two pivot pins (13) to permit removal of linkage. Remove link pin (11) from Collet bolt (8) and links (9) to disengage from lever (10).

Remove five link pins (11) to disassemble lever (10), links (9), bellcrank (14) and drawbolt (15). Anvil Adapter (16) is secured to frame with Loctite® and need not be removed unless damaged.

Reassembly:

Reverse the procedure. Linkage, consisting of lever (10), links (9), bellcrank (14) and drawbolt (15) should be assembled as a subassembly before inserting lever (10) into collet bolt (8). MAKE SURE NOTCHES ON COLLET BOLT (8) ARE POINTING TOWARDS LEVER (10). This complete subassembly may then be inserted into frame (7) and retained by pivot pins (13).