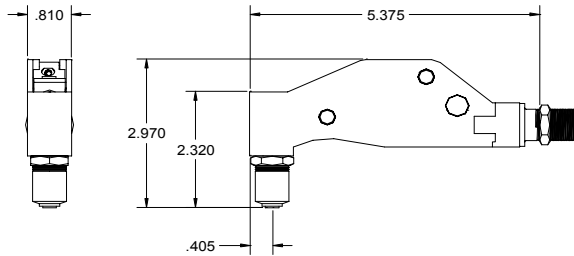


NOSE ASSEMBLY DATA SHEET



Nose Assembly	Nose Tip	Jaw Set
SMLS04-715-54RA	10426	30425
SMLS05-715-54RA	10563	30532
SMLS06-715-54RA	10684	30656

*RECOMMENDED FOR MAINTENANCE APPLICATIONS ONLY.

**TWEEZERS ARE RECOMMENDED FOR INSERTING JAWS INTO COLLET.

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



3/02 Rev. 12/07

GAGE BILT

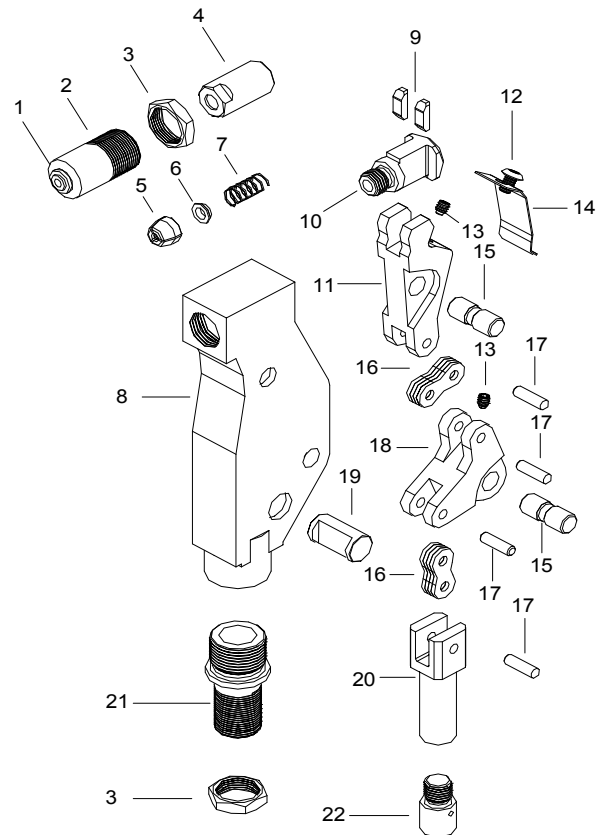
MADE IN U.S.A.

GAGE BILT Inc.

44766 Centre Court (586) 226-1500
Clinton Twp., MI 48038 (586) 226-1505 Fax
e-mail:solutions@gagebilt.com / www.gagebilt.com

Type:	Fasteners:	Recommended Tool:
Single Action 1/8", 5/32" & 3/16" Ø	BLIND RIVET (SINGLE ACTION) WITH OR W/OUT DRIVE WASHER NAS1900 S & U SERIES	GB715

Ref. No.	Qty.	Description	Part Number
1	1	Anvil-Driving	See Chart
2	1	Sleeve	10115
3	2	Jam Nut	70411
4	1	Collet	20563
5	1	Jaw Set	See Chart
6	1	Follower	48806
7	1	Spring	50301
8	1	Frame	75310
9	2	Shoe Bearing	75311
10	1	Collet Bolt	70443
11	1	Lever	75313
12	1	But. Hd Screw	402471
13	2	Set Screw	75315
14	1	Guard	75316
15	2	Pivot Pin	75317
16	8	Link	75318
17	4	Link Pin	75319
18	1	Bell Crank	75320
19	1	Guide Pin	75321
20	1	Drawbolt	75322
21	1	Adapter-Frame	70458
22	1	Collet Extension	70457



ATTACHMENT:

Engage 1 or 2 threads of drawbolt (20) onto head piston, then insert adapter fitting (21) into end of head cylinder and turn clockwise until snug. Rotate nose assembly to desired position and tighten jam nut (22) securely.

After attaching the nose assembly to the riveter, adjust sleeve (2) by loosening jam nut (3), then insert largest diameter rivet to be installed in sleeve and rotate sleeve until jaws just grab pintail. Tighten jam nut (3) securely. By this sleeve adjustment, the nose assembly can be made to release or to hold the pintail after installation.

DISASSEMBLY:

Loosen jam nut (3) and remove sleeve (2). Unscrew collet (4) which contains jaws (5), follower (6), spring (7) from collet bolt (10).

Remove screw (12) and guard (14). Remove 2 set screws (13) and push out 2 pivot pins (15) to permit removal of linkage. Shoe bearings (9) and collet bolt (10) will disengage from lever (11).

Remove 4 link pins (17) to disassemble lever (11), links (16), bell crank (18) and drawbolt (20).

Remove guide pin (19) from frame (8). Adapter fitting (21) is secured to frame with Loctite® and need not be removed unless damaged.

REASSEMBLY:

Reverse the procedure. Linkage, consisting of lever (11), links (16), bell crank (18) and drawbolt (20) should be assembled as a subassembly before inserting lever (11) into shoe bearings (9) and collet bolt (10). **MAKE SURE NOTCHES ON COLLET BOLT (10) ARE POINTING TOWARDS LEVER (11).** This complete subassembly may then be inserted into frame (8) and retained by guide pin (19) and pivot pins (15).