

NOSE ASSEMBLY DATA SHEET

POINT NOSE ASSEMBLY DOWN WHEN ATTACHING TO TOOL

ASSEMBLY:

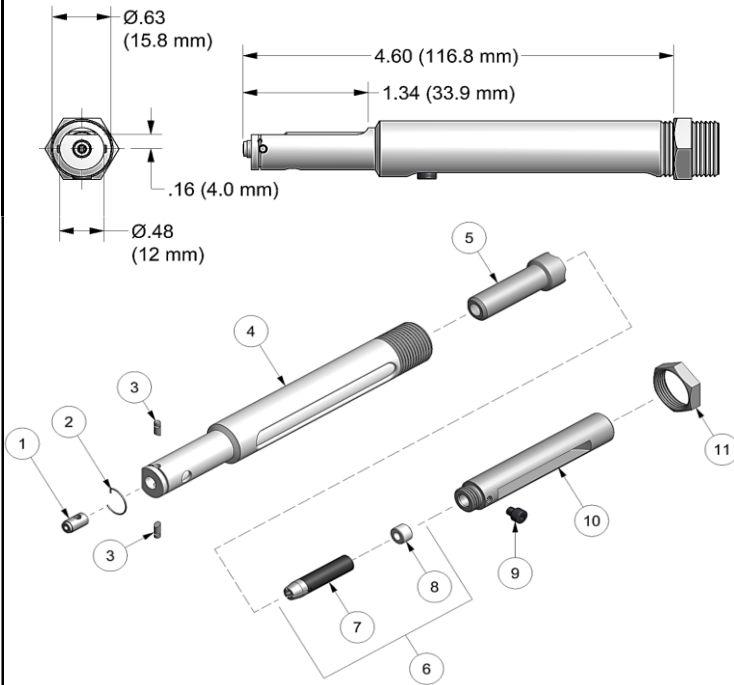
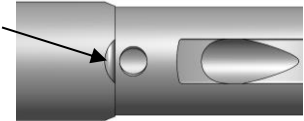
Notes:

- Apply Vibra-tite® p/n/ 405125 to all threads and allow it to set 20 minutes prior to assembly.
 - If nose assy is assembled as it is when purchased new, follow step 5 to attach to tool.
- Place super grip jaw assy (7) into rear of collet (5). Then place spacer (8) onto rear of super grip jaw assy (7).
 - Hand thread assembled collet (5) to drawbolt (10) and tighten. If rear radius on collet (5) isn't aligned with threaded hole on drawbolt (10) when tight, unthread collet (5) slightly until aligned. (See image below).
 - Slide assembled collet (5) and drawbolt (10) into anvil holder (4). Align threaded hole on drawbolt (10) with slot on anvil holder (4).
 - Insert screw (9) into threaded hole on drawbolt (10) and tighten.
 - Thread drawbolt (10) to piston on tool one full turn then thread anvil holder (4) into tool until it stops. Tighten jam nut (11) to face of tool.

DISASSEMBLY:

Reverse assembly instructions.

Align radius on collet (5) with threaded hole on bottom of drawbolt (10)



Effective FOD Control (foreign object damage/debris). Install catcher bag on the front of the riveter to catch spent pintail stems. Place nose assembly through grommet on catcher bag and easily fasten catcher bag to tool using the Velcro strap. Features an easily emptied zippered pouch.

Use catcher bag 500610 for XX-51-46 straight nose assemblies

Catcher bag sold separately



1/99 Rev. 9/25

GAGE BILT
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Type: Single Action Non Self-Releasing			Fasteners: "A" CODE NAS1398A, NAS1399A NAS1738A, NAS1739A	Recommended Tool: GB50
3/32" Ø				Alternate Tools: GB51 & GB715
Ref. No.	Qty.	Description	3A-51-46	
1	1	Anvil Insert	10153	
2	1	Retaining Ring	50308	
3	2	Ratchet Pin	15520	
4	1	Anvil Holder	10318	
5	1	Collet	20326	
6	1	Jaw Assembly (Incl. 7 & 8)	30315-A2	
7	1	Super Grip Jaw Assembly	30315-CS	
8	1	Spacer	40306	
9	1	Socket Head Cap Screw	70303	
10	1	Drawbolt	70301	
11	1	Jam Nut	70411	

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