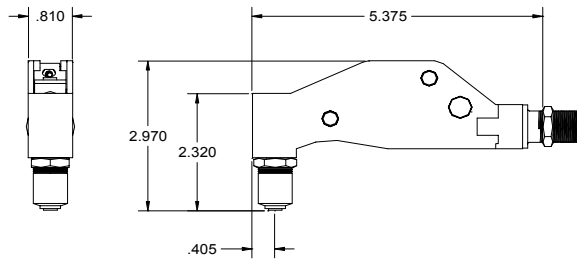


NOSE ASSEMBLY DATA SHEET



CAUTION!

Pintails may eject forcibly. This nose is for closed access applications. If used in open access applications, 704214 catcher bag is recommended TO PREVENT SEVERE PERSONAL INJURY.

*REQUIRES 730715 ADAPTER.

**TWEEZERS ARE RECOMMENDED FOR INSERTING JAWS INTO COLLET.

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

Nose Assembly	Nose Tip	Jaw Set
GS8-715-54RA	18847	30545
GS10-715-54RA	11049	30656

Rev. 12/07

GAGE BILT

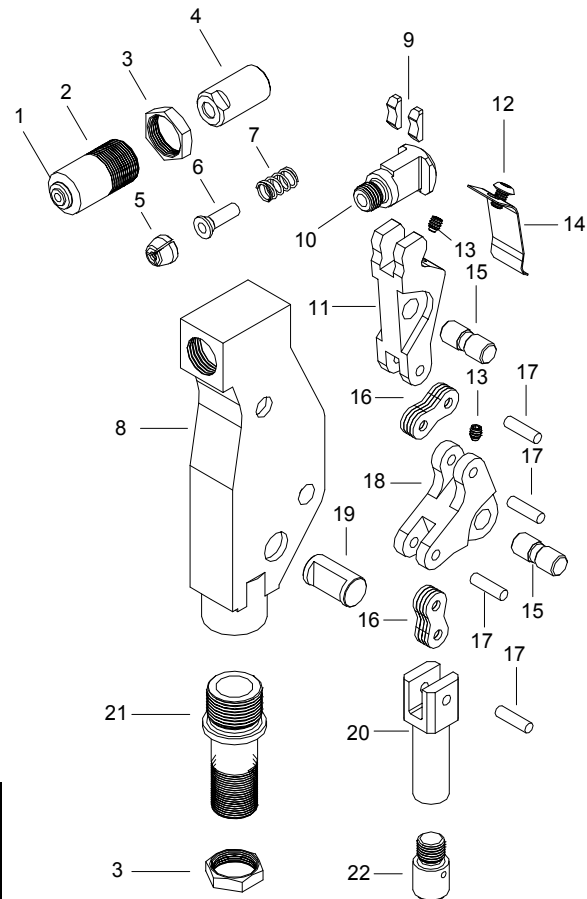
MADE IN U.S.A.

GAGE BILT PRODUCTS CORP.

14500 Barber Drive (586) 771-7664
Warren, Mi 48088 (586) 771-2665 Fax
e-mail:solutions@gagebilt.com / www.gagebilt.com

Type:	Fasteners:	Recommended Tool:
Non Self-Releasing Single Action 8-32 & 10-32 Ø	GROUND STUD M83454 BACS53B1EA1/2	GBP715C
		Alternate Tool: *GBP751C

No.	Qty.	Description	GSX-715-54RA
1	1	Nose Tip	See Chart
2	1	Sleeve	10115
3	2	Jam Nut	70411
4	1	Collet	20563
5	1	Jaw Set	See Chart
6	1	Tube	40445
7	1	Wave Spring	A-958
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 Assembly	70458
22	1	Collet Adapter	70457



ATTACHMENT:

Screw collet adapter (22) onto head piston adapter fitting (21) into nose adapter and hand tighten nut.

DISASSEMBLY:

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