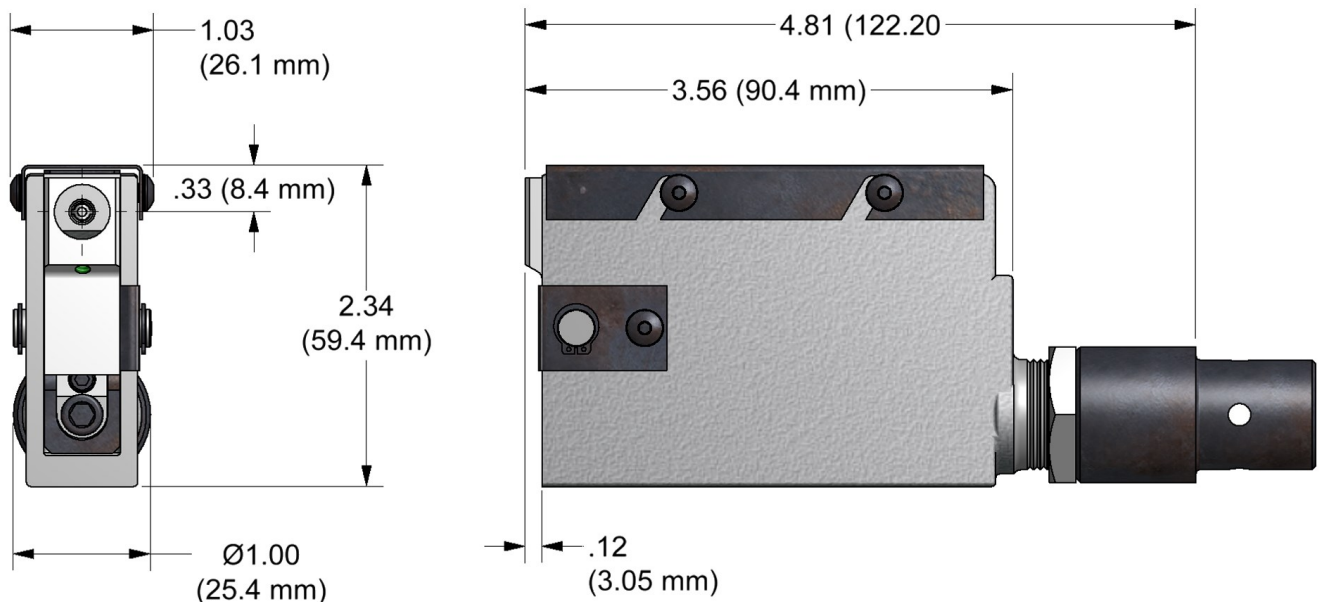


640A-50 OFFSET NOSE ASSEMBLIES FOR 2000 SERIES CHERRYLOCK® RIVETS

DESCRIPTION

This is a mechanically shifting offset nose assembly designed for installing Cherrylock® 2000 series rivets up to 1/2" grip length in limited access areas. There is a separate nose assembly required for each head style (universal and countersunk) and each shank diameter. These nose assemblies should not be used on bulbed Cherrylock® rivets larger than 5/32" diameter.



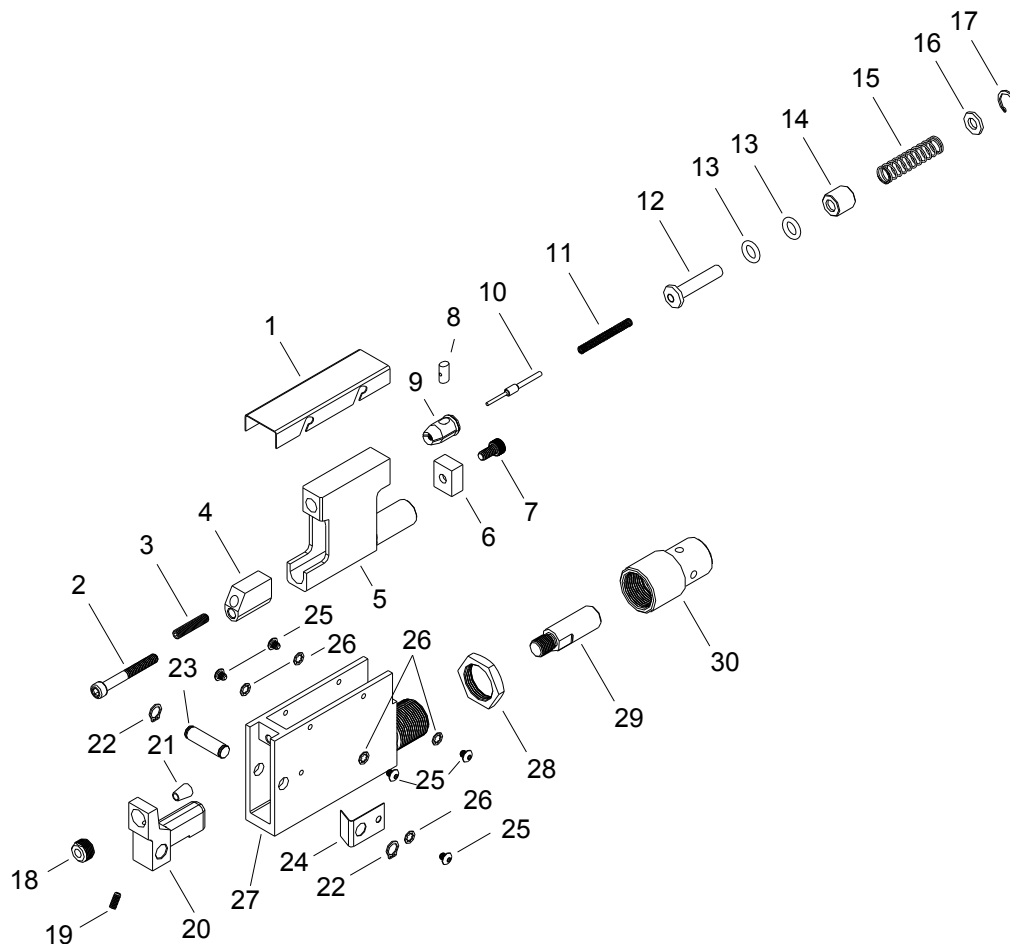
These nose assemblies fit directly on the GB740 Installation Tool

(See installation instructions for attaching to GB784 Tool on page 4)

***For 5/32"-1/4" only— To install 1/8" CherryLOCK rivets use GB715 and 615A-61 nose assembly.**

RIVET DIA.	NOSE ASSEMBLY	
5/32"	5C-640A-50	Countersunk Head
	5U-640A-50	Universal Head
3/16"	6C-640A-50	Countersunk Head
	6U-640A-50	Universal Head
1/4"	8C-640A-50	Countersunk Head
	8U-640A-50	Universal Head

PARTS LIST FOR 640A PULLING HEAD



Ref. No.	Qty.	Description	Nose Assemblies					
			5U-640A-50	5C-640A-50	6U-640A-50	6C-640A-50	8U-640A-50	8C-640A-50
1	1	Cover	60402	60402	60402	60402	60402	60402
2	1	Cap Screw	400107	400107	400107	400107	400107	400107
3	1	Set Screw	S402	S402	S402	S402	S402	S402
4	1	Shift Slide	60403	60403	60403	60403	60403	60403
5	1	Collet	60404	60404	60404	60404	60404	60404
6	1	Stop Block	60508	60508	60813	60813	60813	60813
7	1	Cap Screw	400100	400100	400100	400100	400100	400100
8	1	Stem Stop	70401	70401	70401	70401	70401	70401
9	1	Jaws (Inc. 400777 O'Ring)	30526	30526	30626	30626	30830	30830
10	1	Ejector Pin	60406	60406	60406	60406	60406	60406
11	1	Ejector Spring	50413	50413	50413	50413	50413	50413
12	1	Follower	40407	40407	40407	40407	40407	40407
13	2	Bumper	A-720	A-720	-	-	-	-
13	3	Bumper	-	-	A-720	A-720	A-720	A-720
14	1	Spacer	55402	55402	55402	55402	55402	55402
15	1	Jaw Spring	50410	50410	50410	50410	50410	50410
16	1	Washer	50411	50411	50411	50411	50411	50411
17	1	Retaining Ring	S405	S405	S405	S405	S405	S405
18	1	Outer Anvil	10546	10547	10673	10674	10859	10860
19	1	Set Screw	S924	S924	S924	S924	S924	S924
20	1	Rocker Arm	60408	60408	60408	60408	60408	60408
21	1	Inner Anvil	19507	19507	19607	19607	19805	19805
22	2	Retaining Ring	S404	S404	S404	S404	S404	S404
23	1	Pivot Pin	60409	60409	60409	60409	60409	60409
24	1	Guard	60410	60410	60410	60410	60410	60410
25	5	Button Head Cap Screw	S714	S714	S714	S714	S714	S714
26	5	Washer	S42	S42	S42	S42	S42	S42
27	1	Frame	60511	60511	60607	60607	60815	60815
28	1	Jam Nut	70821	70821	70821	70821	70821	70821
29	1	Collet Adapter	60414	60414	60414	60414	60414	60414
30	1	Adapter	60415	60415	60415	60415	60415	60415

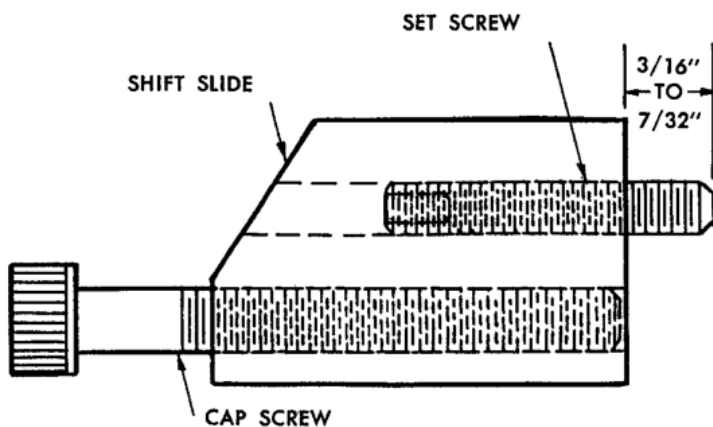


MAINTENANCE, REPAIR AND ADJUSTMENTS



ASSEMBLY INSTRUCTIONS

1. Replace any broken or worn parts. When reassembling drawbolt, press in special washer (16) while inserting retaining ring (17). When retaining ring is in place turn special washer until its lug is positioned between the ends of the retaining ring.
2. If shift slide (4) has been removed from nose assembly for repair or replacement, it should be repositioned by turning screw (3) until it protrudes from the back of the slide $3/16"$ to $7/32"$. With the shift slide pressed snugly against rear of drawbolt (5), run cap screw (2) in until tight. Shift slide will then be in approximately the correct operating position, but may require minor adjustments as shown in the shift point adjustment instructions.
3. Apply a coating of high pressure grease, such as Lubriplate® 130AA, to the top and bottom of drawbolt (5) and to the bottom of rocker arm (20). Reassemble nose.



DISASSEMBLY INSTRUCTIONS

1. Loosen jam nut (28) and remove adapter sleeve (30). Remove drawbolt adapter (29).
2. Remove four button head screws (25) and lift off cover (1).
3. Remove retaining ring (22), button screw (25), guard (24) and pivot pin (23). This will allow rocker arm (20), anvil (21) and drawbolt (5) to be removed from sleeve assembly (27).
4. To disassemble drawbolt, remove retaining ring (17) and washer (16). The stem stop (8), jaws (9), ejector (10), spring (11), follower (12), seat (13), spacer (14) and spring (15) will then come out of rear of drawbolt.
5. It is not usually necessary to remove the shift slide (4), stop block (6) or outer anvil (18), but if any of them have been damaged they may be removed by loosening screws (2), (7) and (19).

CLEANING NOSE ASSEMBLY

It is important that the nose assembly be kept clean, especially around the riveting end, as adhesives, chips, sealants, etc. Will clog the serrations of the jaws and cause slipping. The outer anvil and the inner anvil must be kept especially clean since foreign matter can build up and keep the anvil from going all the way forward to set the locking collar in the rivet.

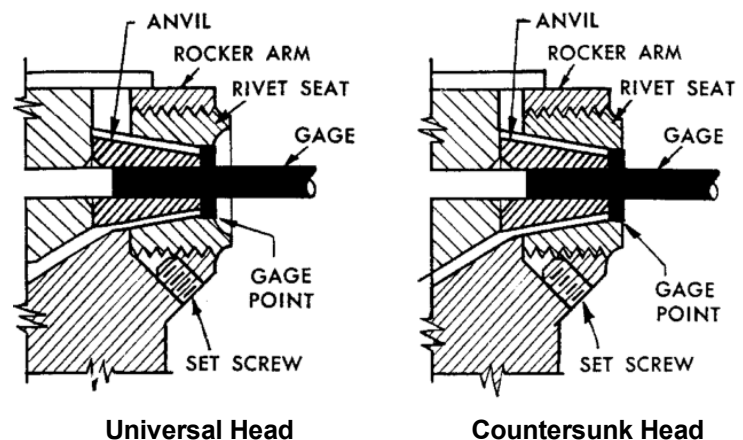
An occasional application of good grade high pressure grease, such as Lubriplate 130AA, to the bottoms of the drawbolt and rocker arm will prolong the life of these parts.

ADJUSTING NOSE ASSEMBLY

These nose assemblies are factory adjusted to properly install rivets in the A-Group (shorter lengths). If nose assembly has been disassembled for repair it will be necessary to readjust it. Gages can be purchased and are identified by their color: $1/8"$ No. 628-4 is green; $5/32"$ No. 628-5 is red; $3/16"$ No. 628-6 is blue; and $1/4"$ No. 628-8 is plain.

INNER ANVIL ADJUSTMENT

1. When adjusting nose assembly, either on or off tool, make sure the drawbolt (5) is in the full forward position.
2. Push rocker arm (20) back toward drawbolt so it will rest on shift slide (4).
3. Insert short end of setting gage into outer anvil (18) until inner face of gage collar rests against end of inner anvil (21) and anvil rests on crossbar in sleeve. Outer face of gage collar should be approximately .010 above face of countersunk head outer anvil or approximately .010 above bottom recess on universal head outer anvil.
4. If adjustment is required, loosen set screw (19) and turn outer anvil (18) for proper positioning.
5. Tighten set screw (19) snugly to prevent anvil from getting out of adjustment.



SHIFT-POINT ADJUSTMENT

This adjustment determines the flushness of the broke pintail. After the lock ring is set, the pintail should fracture substantially flush with the rivet head.

1. If the stem breaks below flush, loosen cap screw (2) and turn set screw (3) clockwise $1/4$ turn (maximum). Tighten cap screw (2).
2. Test setting by installing rivet and repeat if necessary.
3. If stem breaks above flush, loosen cap screw (2) and turn set screw (3) counterclockwise $1/4$ turn (maximum). Tighten cap screw (2).
4. Test setting by installing rivet and repeat if necessary.
5. If nose assembly is so far out of adjustment that it does not respond to these $1/4$ turn adjustments, it may be quicker to remove the rocker arm (20) and shift slide (4) and reposition the adjusting screw (3) to its approximate starting position outlined under Assembly Instructions line 2.

INSTALLATION INSTRUCTIONS FOR ATTACHING TO GB740 TOOL

1. Connect tool to air supply, making sure head piston of the tool is in its full forward position.
2. Screw pulling head onto piston assy (740409) on tool.
3. After pulling head is attached, then back off pulling head until hole in the adapter sleeve (60415) lines up with one of holes in nose fitting (740101) on tool.
4. Secure to tool using Soc. Hd. Cap Screws (401208) with lined up hole. Secure second screw in secondary location. See GB740 tool manual.

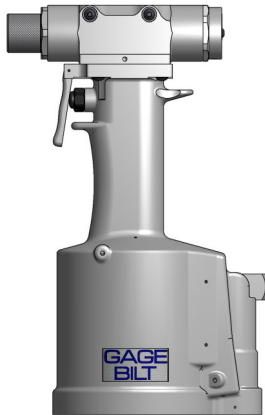
INSTALLATION INSTRUCTIONS USING 784740 ADAPTER FOR ATTACHING TO GB784 TOOL

**For 5/32"-1/4" only
To install 1/8" CherryLOCK rivets use
GB715 and 615A-61 nose assembly*

1. Connect tool to air supply, making sure head piston of the tool is in its full forward position.
2. Install adapter (784740) onto tool.
Adapter (784740) screws onto head piston (784112) on tool.



Adapter
(784740)



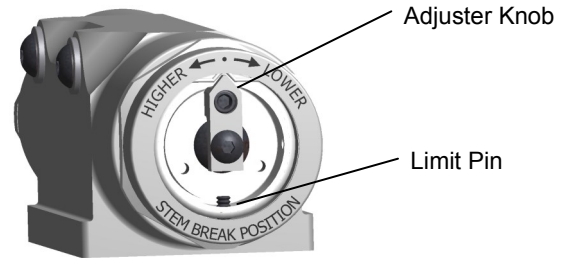
INSTALLATION INSTRUCTIONS USING 784740 ADAPTER FOR ATTACHING TO GB784 TOOL cont.

3. Attach the pulling head to the adapter (784740).
4. After pulling head is attached, then back off pulling head until hole in the adapter sleeve (60415) lines up with one of holes in nose assembly adapter (784740).
5. Secure to tool using Soc. Hd. Cap Screws (401208) with lined up hole. Secure second screw in secondary location.



Note: The shift point setting on the tool must be adjusted to compensate for the longer stroke when using adapters.

6. Remove limit pins.
7. Turn adjusting knob counter-clockwise until it stops.



The GB784 will now install Cherrylock rivets up to 1/2" grip length. Before using a straight 681 series pulling head again, the tool must be re-adjusted using stroke setting gage (784159). See GB784 tool manual for instructions.

WARRANTY

Seller warrants that all goods covered by this catalog will conform to applicable specifications and will replace or repair, EXW our plant, any goods providing defective from faulty workmanship, or material, for 1 year from date of shipment.

Said warranty to remain in effect if, and only if, such goods are used in accordance with all instructions as to maintenance, operation and use, set forth in manuals and instruction sheets furnished by seller.

Sellers obligation under this warranty shall be limited to the repair or rework of the goods supplied or replacement thereof, at Seller's option, and in no case is to exceed the invoice value of said goods. Under no circumstances will the seller be liable for incidental or consequential damages or for damages incurred by the buyer or subsequent user in repairing or replacing defective goods or if the goods covered by this warranty are reworked or subjected to any type of additional processing.

This warranty is void if Seller is not notified in writing of any rejections or defects within 1 year after the receipt of the material by the customer.

THIS WARRANTY IS MADE IN LIEU OF ALL OTHER WARRANTIES EXPRESSED OR IMPLIED, INCLUDING MERCHANTABILITY.