GB105BRBB

BLIND RIVET/BLIND BOLT REMOVAL KIT
FOR:

BLIND RIVETS
MLSP/MLS100, NAS1919, NAS1921

&

BLIND BOLTS
MS21140, MS21141, MS90353, MS90354

GB105BRBB
Digital Tool Manual

GAGE BILT TOOLS ARE AVAILABLE WORLDWIDE
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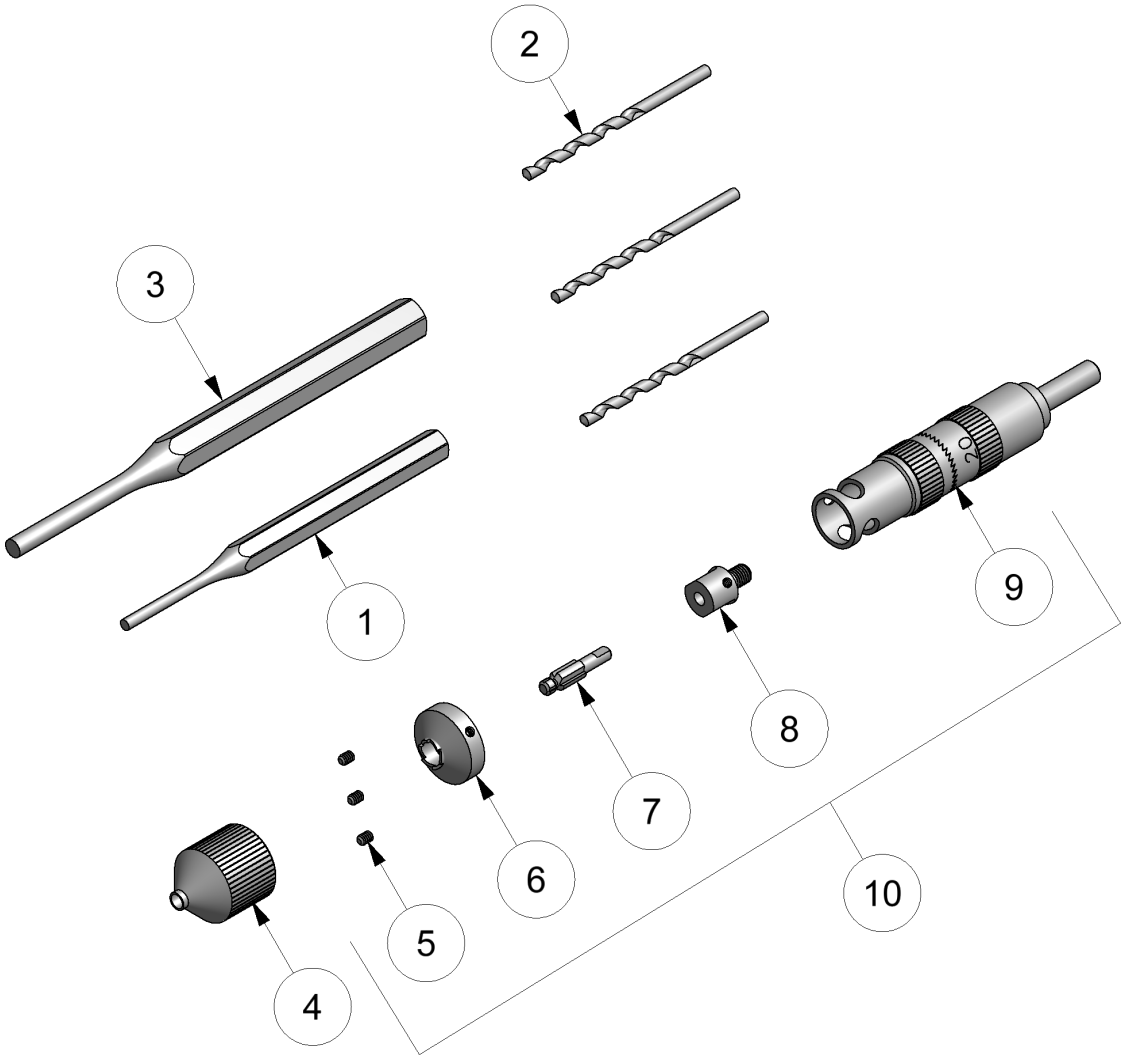
PARTS LIST



Ref. No.	Qty.	Description	GB105-24 1/8 BR Blind Rivet NAS-	GB105-25 5/32 BR Blind Rivet NAS-	GB105-50 5/32 BB Blind Bolt MS-	GB105-60 3/16 BB Blind Bolt MS-	GB105-80 1/4 BB Blind Bolt MS-
1	1	Pin Punch	403009	403010	403010	403010	403012
2	3	Drill	404384	404385	402999	403000	403001
3	1	Sleeve Punch	403011	403012	403012	403013	403015
4	1	Drill Bushing	105524	105521	105525	105526	105528
5	3	Set Screw	401775	401775	401775	401775	401775
6	1	Anti-Rotation Cap	105534	105535	105535	105535	105538
7	1	Cutter	105504	105501	105505	105506	105508
8	1	Cutter Holder	105514	105515	105515	105516	105516
9	1	Micro Limit Tool	105000	105000	105000	105000	105000
10	-	Micro Limit Tool Assembly (Includes Numbers 5-9)	105240	105250	105050	105060	105080

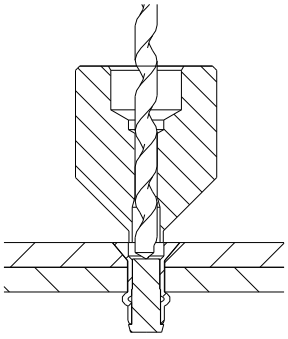
**GB105BRBB kit includes 2 (402443) Hex Keys*

1. The GB105BRBB blind rivet/blind bolt removal kit is for easy removal of MLSP/MLS100, NAS1919, NAS1921 blind rivets and MS21140, MS21141, MS90353, MS90354 blind bolts.

   Place drill and bushing squarely on lock collar and drill depths as follows:

Blind Rivet Size	Drill Diameter	Minimum Depth
1/8”	.0810 (404384)	.040
5/32”	.1015 (404385)	.050

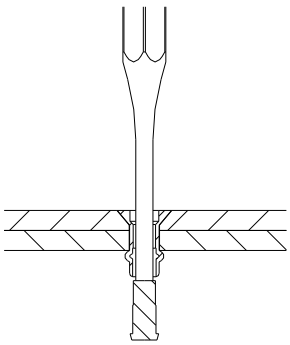
Blind Bolt Size	Drill Diameter	Minimum Depth	Length
5/32”	.0980 (402999)	.050 - .070	2.375
3/16”	.1200 (403000)	.070 - .090	2.750
1/4”	.1562 (403001)	.090 - .110	3.125



2. Using pin punch size as indicated below, knock out fastener. Remove lock collar and fastener with a pointed instrument.

Blind Rivet Size	Punch Size
1/8”	1/16” (403009)
5/32”	3/32” (403010)

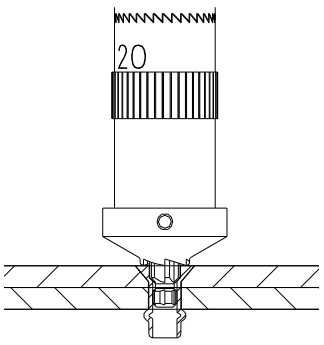
Blind Bolt Size	Punch Size
5/32”	3/32” (403010)
3/16”	3/32” (403010)
1/4”	5/32” (403012)



3. Counterbore sleeve by placing anti-rotation cap on head of fastener. Set micro-limit tool to within .005 to .015 less than the head height of rivet. Proceed with counterbore operation.

	Head Height	
Blind Rivet Size	Protruding Head	Countersunk Head
1/8”	.060	.040
5/32”	.075	.055

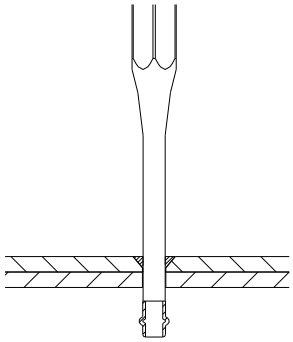
	Head Height	
Blind Bolt Size	Protruding Head	Countersunk Head
5/32”	.070	.070
3/16”	.135	.080
1/4”	.140	.105



4. Using sleeve punch size as indicated below, knock out fastener.

Blind Rivet Size	Punch Size
1/8”	1/8” (403011)
5/32”	5/32” (403012)

Blind Bolt Size	Punch Size
5/32”	5/32” (403012)
3/16”	3/16” (403013)
1/4”	1/4” (403015)



Nominal reamer size is the same diameter as bolt size. Punches are 4 inches

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.

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