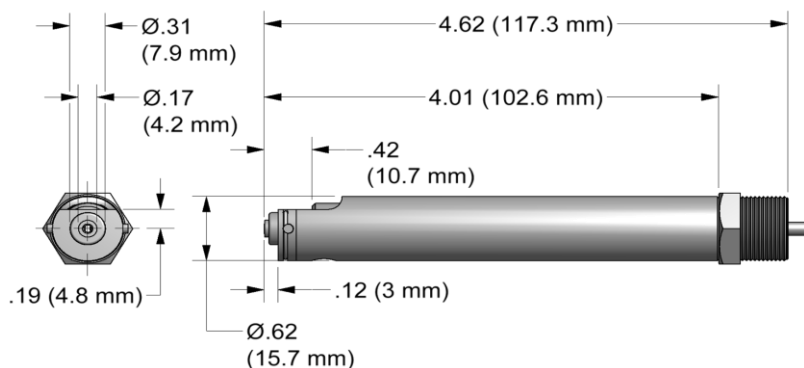


NOSE ASSEMBLY DATA SHEET



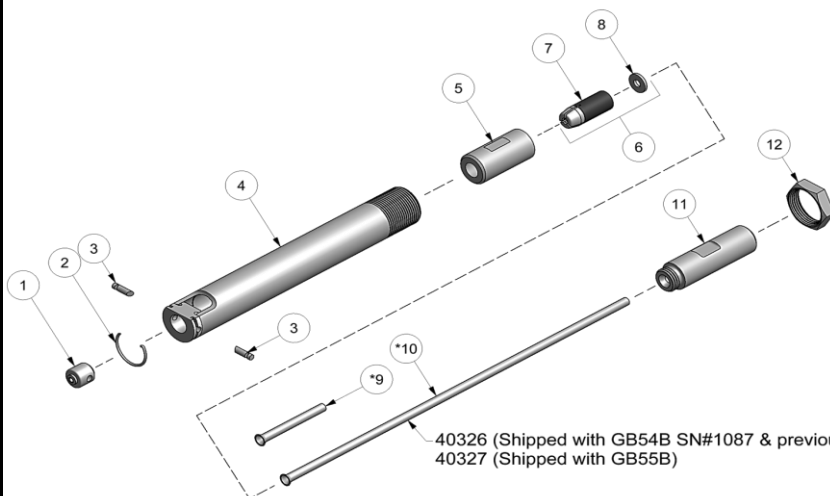
ASSEMBLY:

Notes:

- Apply Vibra-tite® p/n/ 405125 to all threads and allow it to set 20 minutes prior to assembly.
- Tighten collet (5) and drawbolt (11) to 80-100 IN-LBS. (.36 - .44Kn) torque.
- If nose assy is assembled as it is when purchased new, follow steps 3-5 to attach to tool.
 - Insert pintail tube (9) or (10 if req'd) thru i.d. of drawbolt (11). Note direction in exploded view.
 - Place super grip jaw assy (7) into rear of collet (5). Then place spacer (8) onto rear of super grip jaw assy (7).
 - With pintail tube (9) or (10 if req'd) thru i.d. of drawbolt (11), thread assembled collet (5) to drawbolt (11) using flats provided.
 - Slide pintail tube thru piston i.d. on tool and thread assembled collet (5) & drawbolt (11) to piston on tool.
 - Slide anvil & holder assy (4) over assembled collet (5) and drawbolt (11) and thread into tool. Tighten jam nut (12) to face of tool.

DISASSEMBLY:

Reverse assembly instructions.



*Used for 3/32" ø only. Pintail tube (9) or (10 if req'd) must be inserted into drawbolt (11) before assembling nose.

12/13 REV 9/25

GAGE BILT
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Type: Single Action Non Self-Releasing		Fasteners: "A" CODE NAS1398A, NAS1399A NAS1738A, NAS1739A	Recommended Tool: GB54B
3/32" Ø			Alternate Tool: GB55B & GB101A-54
Ref. No.	Qty.	Description	3A-54-43
1	1	Anvil Insert	10303
2	1	Spring-Ratchet Pin	50302
3	2	Ratchet Pin	15504
4	1	Anvil & Holder Assembly	13499
5	1	Collet	20332
6	1	Jaw Assembly (Inc. 7 & 8)	30314-A4
7	1	Super Grip Jaw Assembly	30314-S12
8	1	Spacer	A-1713
9	1	*Pintail Tube (3/32 ø Only. Use w/ GB54B SN#1088 & above)	40329
10	1	*Pintail Tube (3/32 ø Only. Shipped with GB54B Tool SN#1031 - 1087)	40326 (Sold Separate)
10	1	*Pintail Tube (3/32 ø Only. Shipped with GB55B Tool)	40327 (Sold Separate)
11	1	Drawbolt	70342
12	1	Locknut	70411

VIBRA-TITE® IS A REGISTERED TRADEMARK OF OAKLAND CORPORATION.