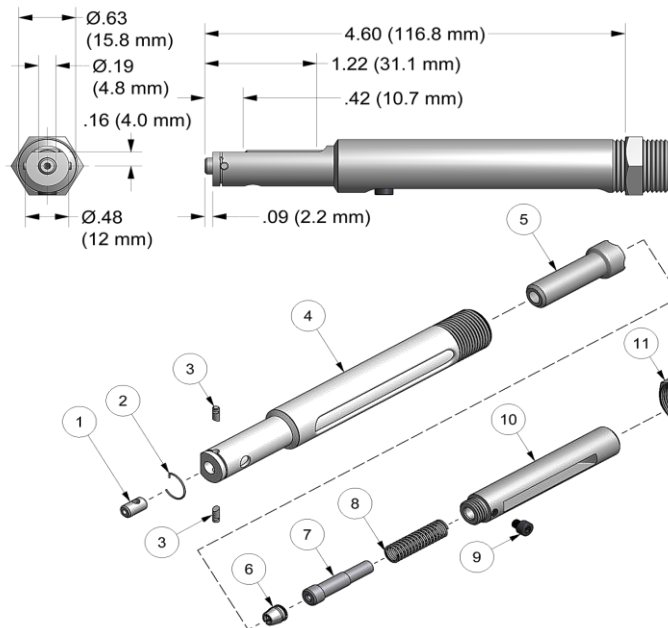


NOSE ASSEMBLY DATA SHEET



POINT NOSE ASSEMBLY DOWN WHEN ATTACHING TO TOOL

ASSEMBLY:

Notes:

- A. Apply Vibra-tite® p/n/ 405125 to all threads and allow it to set 20 minutes prior to assembly.
- B. If nose assy is assembled as it is when purchased new, follow step 5 to attach to tool.
1. Place chuck jaws (6) into rear of collet (5). Place follower (7) thru spring (8) i.d. then place assembled parts against rear of chuck jaws (6).
2. 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).
3. Slide assembled collet (5) and drawbolt (10) into anvil holder (4). Align threaded hole on drawbolt (10) with slot on anvil holder (4).
4. Insert screw (9) into threaded hole on drawbolt (10) and tighten.
5. 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.

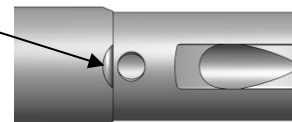


Effective FOD Control (foreign object damage/debris). Install catcher bag on the front of the riveter to catch spent pintail stems. Place nose assembly through grommet on catcher bag and easily fasten catcher bag to tool using the Velcro strap. Features an easily emptied zippered pouch.

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

Catcher bag sold separately

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



10/19 REV 10/25



GAGE BILT
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Type:		Fastener:	Recommended Tool:
Single Action Non Self-Releasing 3/32" Ø		NUT PLATE RIVETS MS20600 SERIES CCR224/264/274 MS/9SP/PT BACR15CC/CF/DA/DR	GB50
			Alternate Tools: GB51 & GB715
Ref. No.	Qty.	Description	3C-51-46JFS
1	1	Anvil Insert	10333
2	1	Retaining Ring	50308
3	2	Pin-Racket	15520
4	1	Anvil-Holder	10318
5	1	Collet	20326
6	1	Jaw Assembly	30308
7	1	Follower	40320
8	1	Spring	50307
9	1	Socket Head Cap Screw	70303
10	1	Drawbolt	70301
11	1	Jam Nut	70411

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