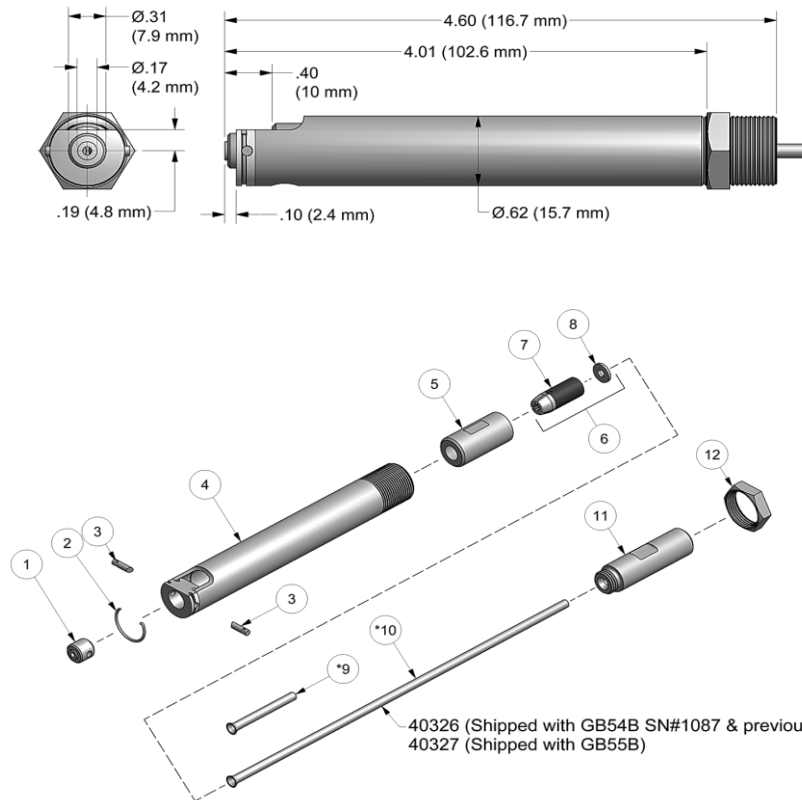


NOSE ASSEMBLY DATA SHEET



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 - .44 Kn) 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). Note direction in exploded view. 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 4/25

GAGE BILT
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Type: Single Action Non Self-Releasing		Fasteners: NUT PLATE RIVETS MS20600 SERIES CCR224/264/274 MS/9SP/PT BACR15CC/CF/DA/DR	Recommended Tool: GB54B	
3/32" Ø			Alternate Tool: GB55B & GB101A-54	
Ref. No.	Qty.	Description	3C-54-43	
1	1	Anvil Insert	10383	
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	

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