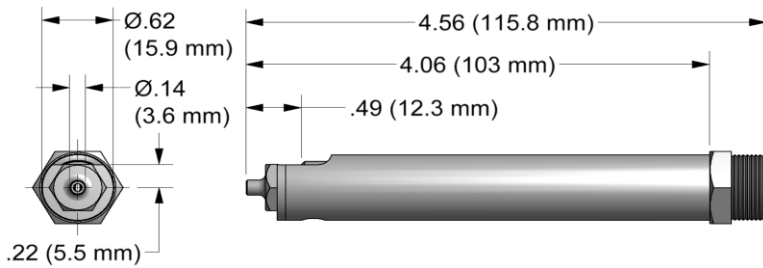


NOSE ASSEMBLY DATA SHEET



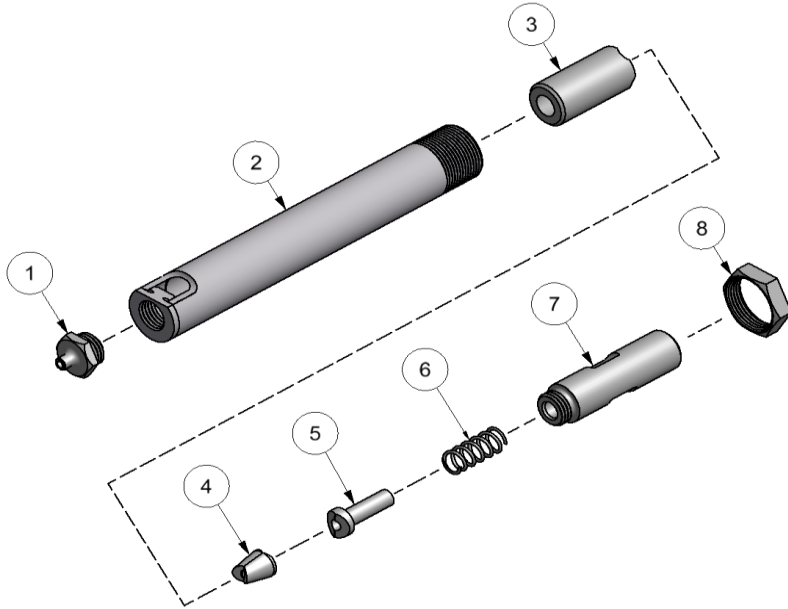
ASSEMBLY:

Notes:

- Apply Vibra-tite® p/n/ 405125 to all threads and allow it to set 20 minutes prior to assembly.
 - Tighten collet (3) and extension-collet (7) to 80-100 IN-LBS. (.36 - 44 Kn) torque.
 - If nose assy is assembled as it is when purchased new, follow steps 4-5 to attach to tool.
- Place extension-collet (7) on a flat surface with outer threads facing upward.
 - Place Spring (6) around tube dia. of follower (5). Place follower (5) into i.d. of extension-collet (7) then place jaw set (4) carefully onto follower (5).
 - Carefully place collet (3) over assembled parts and hand tighten collet (3) to extension-collet (7). Torque collet (3) to extension-collet (7) using note "B" above.
 - Hand tighten assembled parts to piston on tool then tighten using flats provided.
 - Thread anvil holder (2), which contains jam nut (8), snugly onto end of tool. Tighten jam nut (8) securely.

DISASSEMBLY:

Reverse assembly instructions.



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GAGE BILT
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Type: Self-Releasing			Fastener: N, Q & E POP®, CLOSED END AVEX® & COMMERCIAL RIVETS	Recommended Tool: GB54B	
3/32" Ø				Alternate Tool: GB55B & GB101A-54	
Ref. No.	Qty.	Description			3N-54-43
1	1	Nose Tip			10247
2	1	Anvil Holder			13521
3	1	Collet			20301
4	1	Jaw Assembly			30311
5	1	Follower			40506
6	1	Spring			50420
7	1	Drawbolt			70342-1
8	1	Jam Nut			70411

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