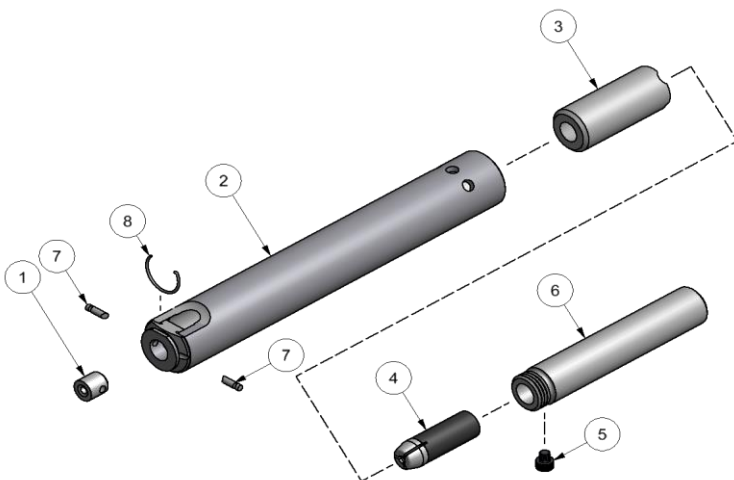
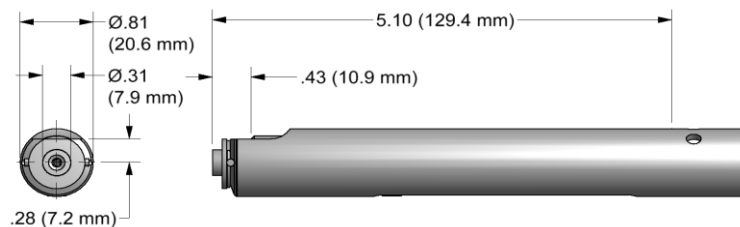


NOSE ASSEMBLY DATA SHEET



ASSEMBLY:

Notes:

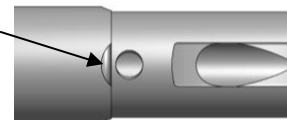
- A. Apply Vibra-tite® p/n/ 405125 to all threads and allow it to set 20 minutes prior to assembly.
- B. If nose assy is assembled as it is when purchased new, follow step 5 to attach to tool.

1. Place super grip jaw assy (4) into rear of collet (3).
2. Hand thread assembled collet (3) to drawbolt (6) and tighten. If rear radius on collet (3) isn't aligned with threaded hole on drawbolt (6) when tight, unthread collet (3) slightly until aligned. (See image below).
3. Slide assembled collet (3) and drawbolt (6) into anvil holder (2). Align threaded hole on drawbolt (6) with slot on anvil holder (2).
4. Insert screw (5) into threaded hole on drawbolt (6) and tighten.
5. Thread drawbolt (6) to piston on tool one full turn then align holes on anvil holder (2X) with holes in nose fitting on tool and tighten two s.h.c.s. to lock into place.

DISASSEMBLY:

Reverse assembly instructions.

Align radius on collet (3) with threaded hole on bottom of drawbolt (6)



Rev. 2/26



GAGE BILT
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Type:		Fastener:		Recommended Tool: GB740
Single Action 1/8 & 5/32 Ø		Universal Head MS20600, Cherry® 9000 Huck® PT, SP & MS RV200 & RV500		
Ref. No.	Qty.	Description	4U-740B-52	5U-740B-52
1	1	Anvil-Insert Universal	10388	10390
2	1	Anvil Holder	10954	10954
3	1	Collet	20330	20330
4	1	Super Grip Jaw Assembly	30545-CS	30545-CS
5	1	Screw	400046	400046
6	1	Drawbolt	70316	70316
7	2	Stem Stop	15503	15501
8	1	Spring-Retaining	50302	50302

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