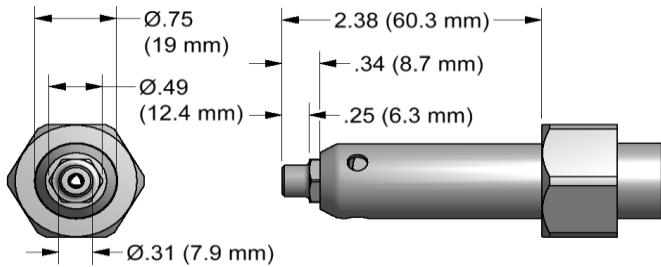
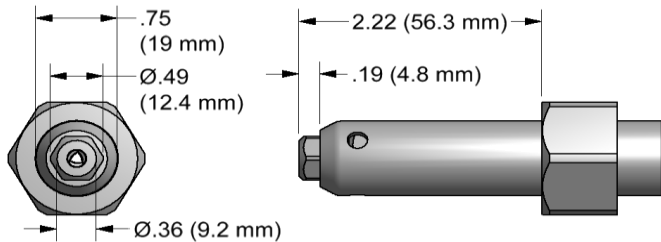


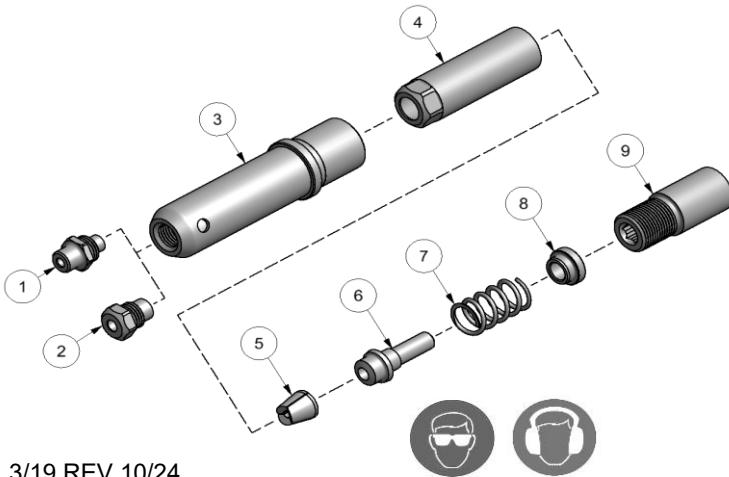
NOSE ASSEMBLY DATA SHEET



WITH 10204 (6N) NOSETIP



WITH 10211-1 (8N) NOSETIP



ASSEMBLY:

Notes:

A. Apply Vibra-tite® p/n/ 405125 to all threads and allow it to set 20 minutes prior to assembly.

B. Tighten collet (4) and extension-collet (9) to 80-100 IN-LB torque.

C. If nose assy is assembled as it is when purchased new, follow steps 5-7 to attach to tool.

1. Place extension-collet (9) on a flat work surface hex side up.
2. Place cap (8) on extension-collet (9). Note direction from exploded view.
3. Place spring (7) on top of cap (8). Insert follower (6) thru spring (7) and into cap (8) and extension-collet (9). Place jaw set (5) into rear of collet (4).
4. Slide collet (4) over assembled parts and thread collet (4) to extension-collet (9). Snug tighten assembled parts using 9/16" wrench on collet (4) and 1/4" hex key in rear on extension-collet (9).
5. Thread assembled collet (4) and extension-collet (9) onto piston assy on tool and snug with 9/16" wrench on collet (4) and hex key into rear of piston of tool.
6. Slide anvil holder assy (3) over assembled collet (4) and extension-collet (9).
7. Slide retaining nut from tool (retaining nut stop not used in this nose assembly) over anvil holder assy (3) and tighten.

DISASSEMBLY:

Reverse assembly instructions.

3/19 REV 10/24

These noses are not recommended for stainless steel rivets

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Type:		Fastener:	Recommended Tool:
Self-Releasing		N, Q & E, POP®, CLOSED END, AVEX®, MAGNA-LOK®, MAGNA-BULB®, HEMLOK®, BULB-TITE® (NON-STRUCTURAL) & ULTRA-GRIP® COMMERCIAL RIVETS	GB722
			Alternate Tools: GB713 & GB2480(A)
Ref. No.	Qty.	Description	68N-713-21
1	1	Nose Tip (6N)	10204
2	1	Nose Tip (8N)	10211-1
3	1	Anvil Holder	10942
4	1	Collet	20413
5	1	Jaw Set	30856
6	1	Follower	40889-2
7	1	Spring	50421
8	1	Cap	40810
9	1	Extension-Collet	70823

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