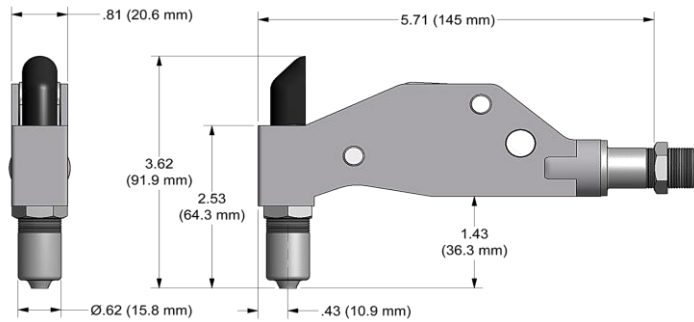


NOSE ASSEMBLY DATA SHEET



*NOT FOR 1/4 INCONEL NAS 1398/1399A

**RECOMMENDED FOR MAINTENANCE APPLICATIONS ONLY.

***TWEEZERS ARE RECOMMENDED FOR INSERTING JAWS INTO COLLET.

****RIGHT ANGLE NOSE ASSEMBLIES REQUIRE MORE THAN ONE "PULL".

1/05 REV 9/25

GAGE BILT MADE in USA

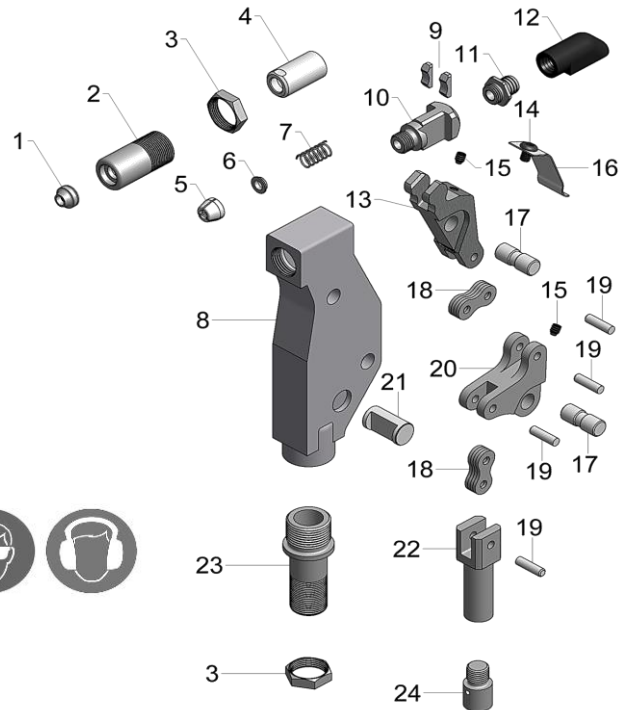
44766 Centre Court Clinton Twp. MI 48038 USA

Ph: +1 (586) 226-1500 Fax: +1 (586) 226-1505

solutions1@gagebilt.com / www.gagebilt.com

Type:	Fasteners:	Recommended Tool:
Single Action 1/4" Ø	"A" CODE NAS1398A, NAS1399A NAS1738A, NAS1739A	GB740 with 740715 adapter

Ref. No.	Qty.	Description	8A-715A-54RA
1	1	Anvil-Driving	10868
2	1	Anvil Holder	10115
3	2	Jam Nut	70411
4	1	Collet	20563
5	1	Jaw Set	30851
6	1	Follower	48806
7	1	Spring	50301
8	1	Frame	75310
9	2	Shoe Bearing	75311
10	1	Drawbolt Collet	70486
11	1	Barbed Retainer	70575
12	1	Deflector	61107
13	1	Lever	75313
14	1	Button Head Cap Screw	402471
15	2	Set Screw	75315
16	1	Guard	75316
17	2	Pivot Pin	75317
18	8	Link	75318
19	4	Link Pin	75319
20	1	Bellcrank	75320
21	1	Guide Pin	75321
22	1	Drawbolt	75322
23	1	Adapter Assy	70458
24	1	Extension-Collet	70457



ATTACHMENT:

Apply VIBRA-TITE® to all threads and let set for 20 minutes prior to assembly.

Disconnect air supply from tool. Hold back of drawbolt-collet (10) down with thumb. Thread anvil holder (2) into frame (8) until it bottoms out on collet (4). Loosen approximately 1/4 turn and tighten jam nut (3) securely to frame (8). Engage one or two threads of extension-collet (24) onto piston assy located on tool, then insert adapter assy (23) into end of head cylinder assy located on tool and turn clockwise until snug. Rotate nose assembly to desired position and tighten jam nut (3) securely. Reconnect air supply to tool.

DISASSEMBLY:

Loosen jam nut (3) and remove anvil holder (2). Unscrew collet (4) which contains jaw set (5) from drawbolt-collet (10).

Remove button head cap screw (14) and guard (16). Remove two set screws (15) and push out two pivot pins (17) to permit removal of linkage. Shoe bearings (9) and drawbolt-collet (10) will disengage from lever (13).

Remove four link pins (19) to disassemble lever (13), links (18), bellcrank (20) and drawbolt (22).

Remove guide pin (21) from frame (8). Adapter Assy (23) is secured to frame with Loctite® and need not be removed unless damaged.

REASSEMBLY:

Reverse the procedure. Linkage, consisting of lever (13), links (18), bellcrank (20) and drawbolt (22) should be assembled as a subassembly before inserting lever (13) into shoe bearings (9) and drawbolt-collet (10). MAKE SURE NOTCHES ON DRAWBOLT-COLLET (10) ARE POINTING TOWARDS LEVER (13). This complete subassembly may then be inserted into frame (8) and retained by guide pin (21) and pivot pins (17).