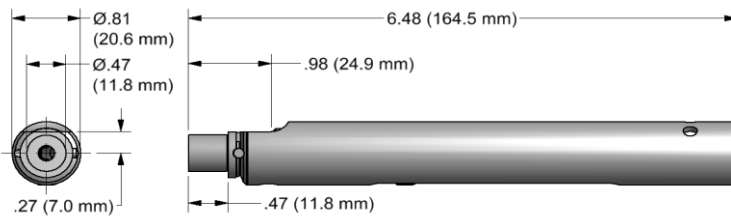


NOSE ASSEMBLY DATA SHEET



ASSEMBLY:

Notes:

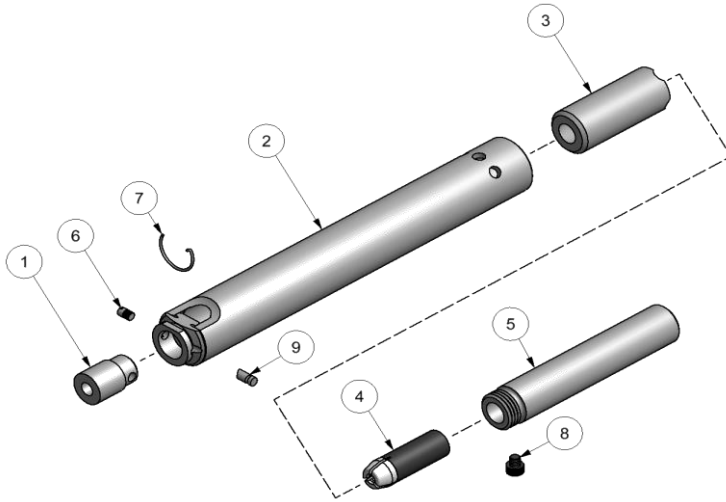
A. Apply Vibra-tite® p/n/ 405125 to all threads and allow it to set 20 minutes prior to assembly.

B. If nose assy is assembled as it is when purchased new, follow step 5 to attach to tool.

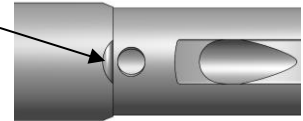
1. Place super grip jaw assy (4) into rear of collet (3).
2. Hand thread assembled collet (3) to drawbolt (5) and tighten. If rear radius on collet (3) isn't aligned with threaded hole on drawbolt (5) when tight, unthread collet (3) slightly until aligned. (See image below).
3. Slide assembled collet (3) and drawbolt (5) into anvil holder (2). Align threaded hole on drawbolt (5) with slot on anvil holder (2)
4. Insert screw (8) into threaded hole on drawbolt (5) and tighten.
5. Thread drawbolt (5) to piston on tool one full turn then align holes in anvil holder (2) with holes in nose fitting on tool and tighten two socket head cap screws to lock into place.

DISASSEMBLY:

Reverse assembly instructions.



Align radius on collet (3) with threaded hole on bottom of drawbolt (5)



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Type:			Fasteners:	Recommended Tool: GB740
Non Self-Releasing 10-32" Ø			GROUND STUD, M83454 & BACS53B	
Ref. No.	Qty.	Description	GS10-740C-52	
1	1	Nose Tip	13350	
2	1	Anvil Holder	13351	
3	1	Collet	20330	
4	1	Super-Grip Jaw Assembly	30656-CS	
5	1	Drawbolt	70316	
6	1	Screw	15509	
7	1	Retaining Ring	50313	
8	1	Socket Head Cap Screw	400046	
9	1	Ratchet Pin	15519	