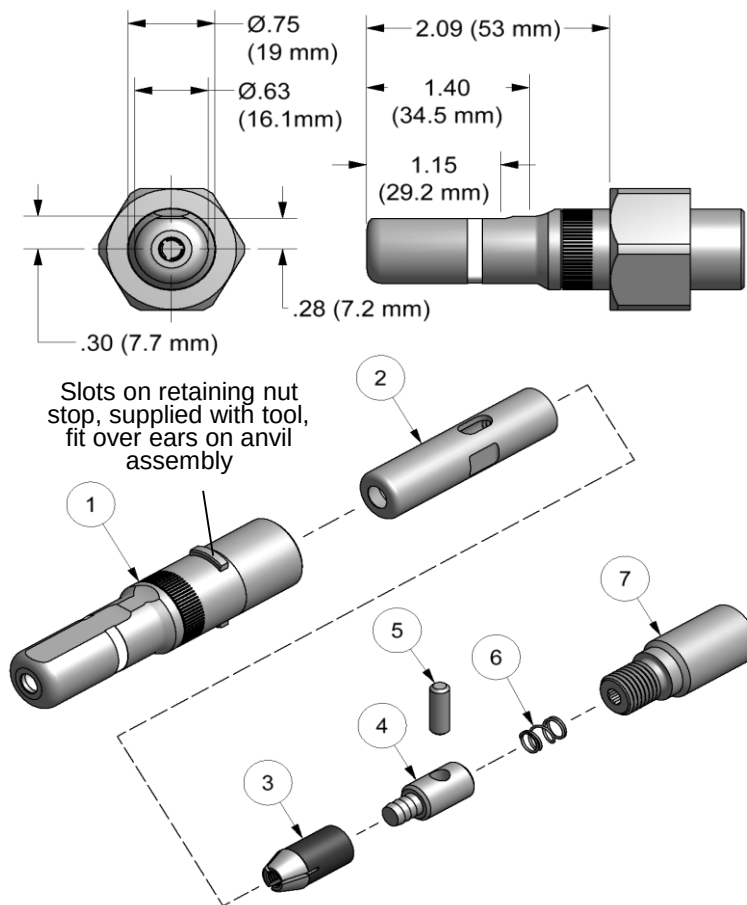


NOSE ASSEMBLY DATA SHEET



ASSEMBLY:

Note:

- Apply Vibra-tite® p/n/ 405125 to all threads and allow it to set 20 minutes prior to assembly.
 - Tighten collet (2) and extension-collet (7) to 80-100 IN-LB torque.
 - If nose assy is assembled as it is when purchased new, follow steps 4-6 to attach to tool
- Insert barbed guide (4) into rear of super grip jaw assy (3). Insert assembled barbed guide (4) and super grip jaw assy (3) into rear of collet (2) aligning hole in barbed guide (4) with slot in collet (2). (Note direction in exploded view).
 - Insert cross pin (5) into slot of collet (2) and thru barbed guide (4). Insert spring into rear of barbed guide (4).
 - Thread collet (2) to extension-collet (7) using flats provided on collet (2) and extension-collet (7).
 - Thread assembled collet (2) and extension-collet (7) onto piston of tool using flats provided and hex in rear of piston.
 - Slide anvil assy (1) over collet (2).
 - Slide retaining nut stop & retaining nut over ears on anvil (see exploded view) and tighten to tool.

DISASSEMBLY:

Reverse assembly instructions.

*Pull-in applications require the installation tool to be operated at a lower psi air pressure so the pintail doesn't break off. Air pressure recommendations below are for titanium fasteners only. Refer to fastener manufacturer for formula to figure air pressure required for all other materials. Pre-set regulators are available please contact Gage Bilt. When using hydraulic tool contact Gage Bilt for powerunit settings.

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**Anvil Assembly includes 35208 retainer.

***White band designates nose assemblies for pull-in fasteners

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Type:		Fasteners:		Recommended Tool: *GB751 (56±3 PSI) (GB751 Recommended for Titanium Only)
Self-Releasing 5/32 Ø		LGP® Lockbolts ASNA2391-2 ASNA2392-2		
Ref. No.	Qty.	Description		LGP05-713-21PI
1	1	Anvil Assy		15594
2	1	Collet		20592
3	1	Super-Grip Jaw Assy		30551-CS
4	1	Barbed Guide		40560
5	1	Cross Pin		70576
6	1	Spring		406031
7	1	Extension-Collet		70577