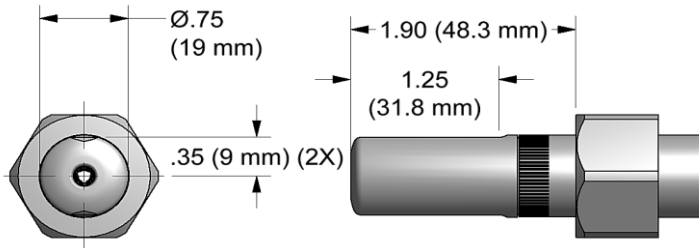


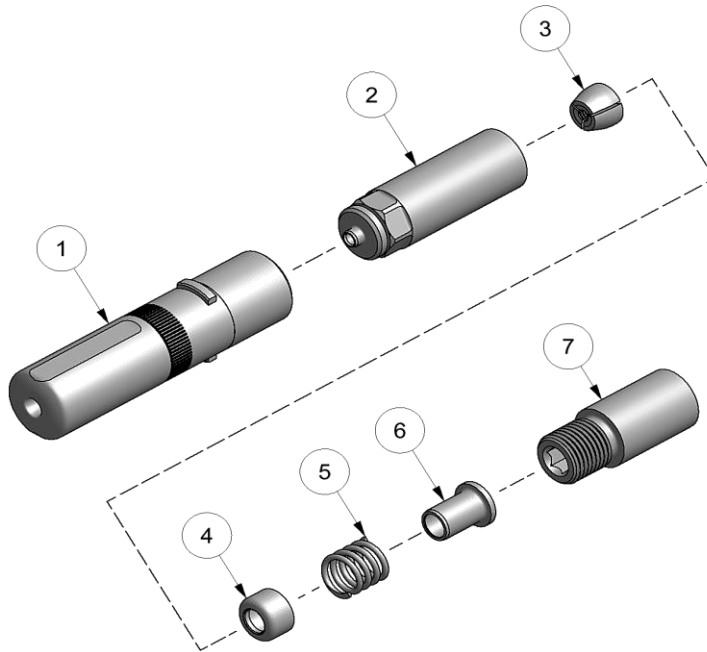
# NOSE ASSEMBLY DATA SHEET



## ASSEMBLY:

### Notes:

- Apply Vibra-tite® p/n/ 405125 to all threads and allow it to set 20 minutes prior to assembly.
- Tighten collet assy (2) and extension-collet (7) to 80-100 IN-LB torque.
- If nose assy is assembled as it is when purchased new, follow steps 3-5 to attach to tool.



- Place extension-collet (7) on a table with threads facing up. Place sleeve (6) on top of extension-collet (7). Then place spring (5) id onto sleeve (6). Place follower (4) onto spring (5) then jaw set (3) onto top of follower (4). Note directions in exploded view.
- Slide collet assy (2) over assembled parts then thread collet assy (2) to extension-collet (7) first by hand then tighten using hex key in front of collet-extension (7) and flats provided on collet assy (2).
- 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 assy (2).
- Slide retaining nut over ears on anvil (see exploded view) and tighten to tool. (Note: retaining nut stop not used on this nose assy).

## DISASSEMBLY:

Reverse assembly instructions.

1/04 REV 3/25

**GAGE BILT**  
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| Type:                    |      | Fastener:                                                            | Recommended Tool:             |
|--------------------------|------|----------------------------------------------------------------------|-------------------------------|
| Self-Releasing<br>1/8" Ø |      | NAS Shear and Tension Pull Type<br>Lockbolts, C6L® and GP® Lockbolts | GB731                         |
|                          |      |                                                                      | Alternate Tools:<br>GB2480(A) |
| Ref. No.                 | Qty. | Description                                                          | NAS04-730-20                  |
| 1                        | 1    | Anvil Assembly                                                       | 10411                         |
| 2                        | 1    | Collet Assembly                                                      | 20422                         |
| 3                        | 1    | Jaw Set                                                              | 30402                         |
| 4                        | 1    | Follower                                                             | 40883                         |
| 5                        | 1    | Spring                                                               | 50804                         |
| 6                        | 1    | Sleeve                                                               | 60827                         |
| 7                        | 1    | Extension-Collet                                                     | 70835                         |

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