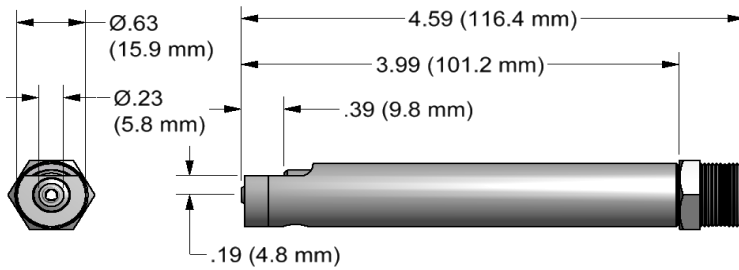


# NOSE ASSEMBLY DATA SHEET



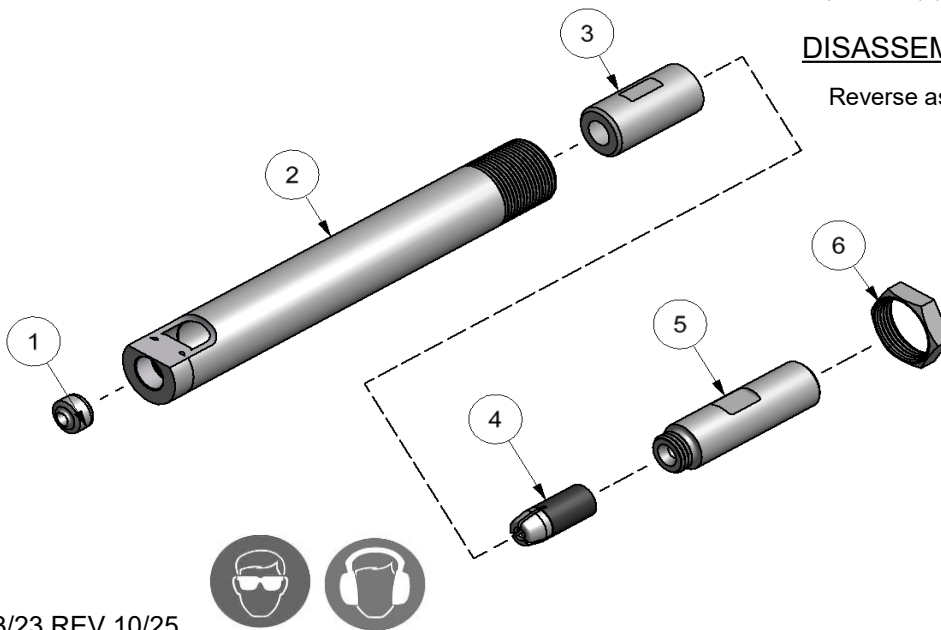
## ASSEMBLY:

### Notes:

- Apply Vibra-tite® p/n/ 405125 to all threads and allow it to set 20 minutes prior to assembly.
- Tighten collet (3) and drawbolt (5) to 80-100 IN-LBS. (.36 - 44 Kn) torque.
- If nose assy is assembled as it is when purchased new, follow steps 3-4 to attach to tool.
  - Place super grip jaw assy (4) into rear of collet (3). (Note direction in exploded view).
  - Thread assembled collet (3) to drawbolt (5) using flats provided and tighten.
  - Thread assembled collet (3) & drawbolt (5) to piston on tool.
  - Slide anvil & holder assy (2) over assembled collet (3) and drawbolt (5) and thread into tool. Tighten jam nut (6) to face of tool.

## DISASSEMBLY:

Reverse assembly instructions.



3/23 REV 10/25

\* Aluminum Only.

**GAGE BILT**  
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|                             |      |                                    |                                                                                                       |                               |
|-----------------------------|------|------------------------------------|-------------------------------------------------------------------------------------------------------|-------------------------------|
| Type:<br>Non Self-Releasing |      |                                    | NAS1900 S & U SERIES<br>UNIMATIC® BLIND RIVET<br>(SINGLE ACTION)<br><b>WITH OR W/OUT DRIVE WASHER</b> | Recommended Tool:<br>*GB55B   |
| 5/32" Ø (Aluminum Only)     |      |                                    |                                                                                                       | Alternate Tool:<br>*GB101A-54 |
| Ref.<br>No.                 | Qty. | Description                        |                                                                                                       | <b>SMLS05-54-43</b>           |
| 1                           | 1    | Anvil Driving                      |                                                                                                       | 10561                         |
| 2                           | 1    | Anvil & Holder Assembly (Incl. #1) |                                                                                                       | 13571                         |
| 3                           | 1    | Collet                             |                                                                                                       | 20332                         |
| 4                           | 1    | Super Grip Jaw Assembly            |                                                                                                       | 30529-S                       |
| 5                           | 1    | Drawbolt                           |                                                                                                       | 70342                         |
| 6                           | 1    | Locknut                            |                                                                                                       | 70411                         |

VIBRA-TITE® IS A REGISTERED TRADEMARK OF OAKLAND CORPORATION. UNIMATIC® IS A REGISTERED TRADEMARK OF HOWMET AEROSPACE.