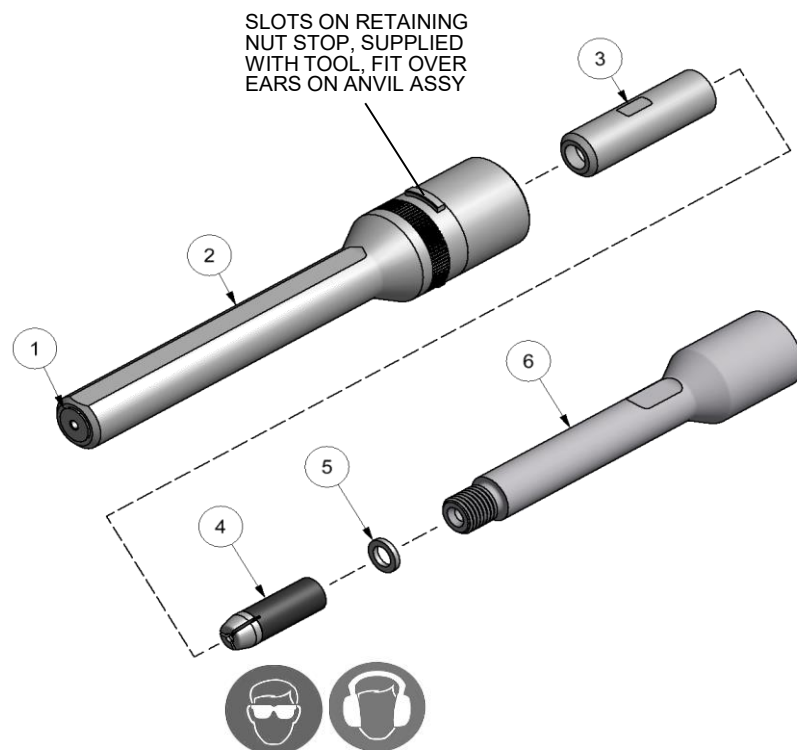
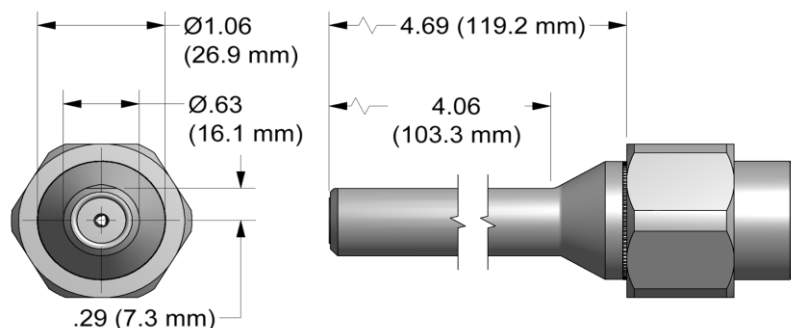


NOSE ASSEMBLY DATA SHEET



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 extension-collet (6) 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 (6) on table with threads facing up. Place spacer (5) on top of extension-collet (6) then place super grip jaw assy (4) on top of spacer (5).
 - Slide collet (3) over super grip jaw assy (4) and spacer (5) and thread collet (3) to extension-collet (6) first by hand then tighten using flats provided.
 - Thread assembled collet (3) and extension-collet (6) onto piston of tool using flats provided and hex in rear of piston.
 - Slide anvil & holder assembly (2) over collet (3).
 - Slide retaining nut stop and retaining nut over ears on anvil (see exploded view) and tighten to tool.

DISASSEMBLY:

Reverse assembly instructions.

10/19 Rev 10/25

*Anvil Assembly includes 35308 retainer.

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:
Non Self-Releasing 1/8" Ø		NAS1900 S & U SERIES UNIMATIC® BLIND RIVET (SINGLE ACTION) WITH DRIVE WASHER	GB745
			Alternate Tools: GB756 & GB2581(A)
Ref. No.	Qty.	Description	UBR04-745C-48
1	1	Anvil-Driver	10486
2	1	Anvil & Holder Assembly	13024
3	1	Collet	20727
4	1	Super-Grip Jaw Assembly	30425-S
5	1	Spacer	40465
6	1	Extension-Collet	70553

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