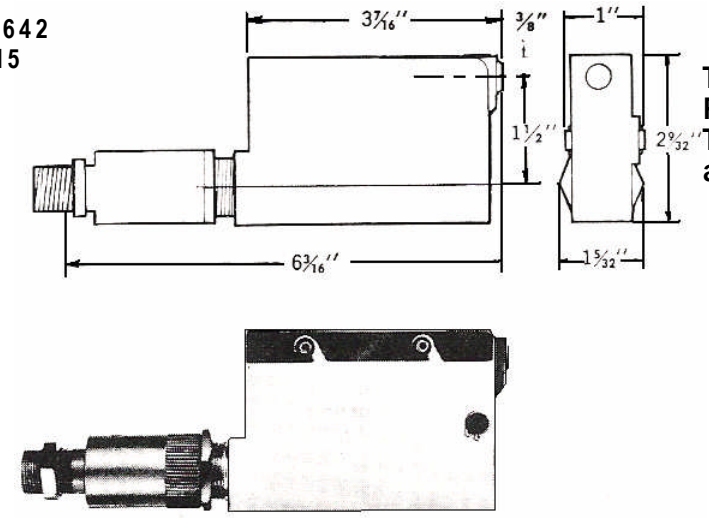
H642 PULLING HEADS

- These Offset Pulling Heads are designed for installing CHERRYLOCK® Rivets up to 1/2" grip length in limited access areas.
- There is a separate pulling head required for each rivet head style and each shank diameter (universal or countersunk). These heads should not be used on Bulbed CherryLock® Rivets larger than 5/32" diameter.
- These heads fit directly on Cherry Riveters G-11, G-15 and G-36. They will also fit the G-684 and G-784 Hydro-shift Riveters by using the adapter and special adjusting instructions outlined on page 4.

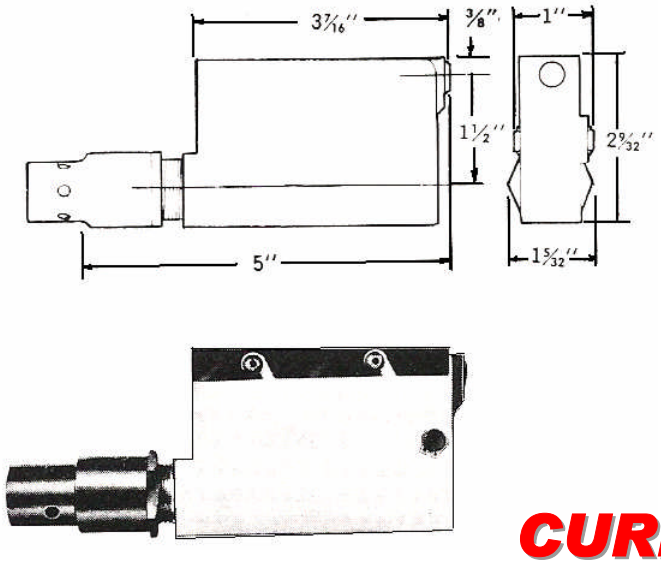
H642
(15



These heads fit directly on Cherry® Riveters G-11, G-15 and G-36. They also fit on G684 and G784 riveters with appropriate adapters (see page 4)

RIVET DIAMETER	PULLING HEAD NUMBER	
1/8"	H642-4 U15	UNIVERSAL HEAD
	H642-4C15	COUNTERSUNK HEAD
5/32"	H642-5U15	UNIVERSAL HEAD
	H642-5C15	COUNTERSUNK HEAD
3/16"	H642-6U15	UNIVERSAL HEAD
	H642-6C15	COUNTERSUNK HEAD

H642 (40 SERIES)



These heads fit directly on Cherry® Riveters G-40, G-55 and G-86.

RIVET DIAMETER	PULLING HEAD NUMBER	
1/8"	H642-4 U40	UNIVERSAL HEAD
	H642-4C40	COUNTERSUNK HEAD
5/32 "	H642-5U40	UNIVERSAL HEAD
	H642-5C40	COUNTERSUNK HEAD
3/16 "	H642-6U40	UNIVERSAL HEAD
	H642-6C40	COUNTERSUNK HEAD
1/4 "	H642-8U40	UNIVERSAL HEAD
	H642-8C40	COUNTERSUNK HEAD

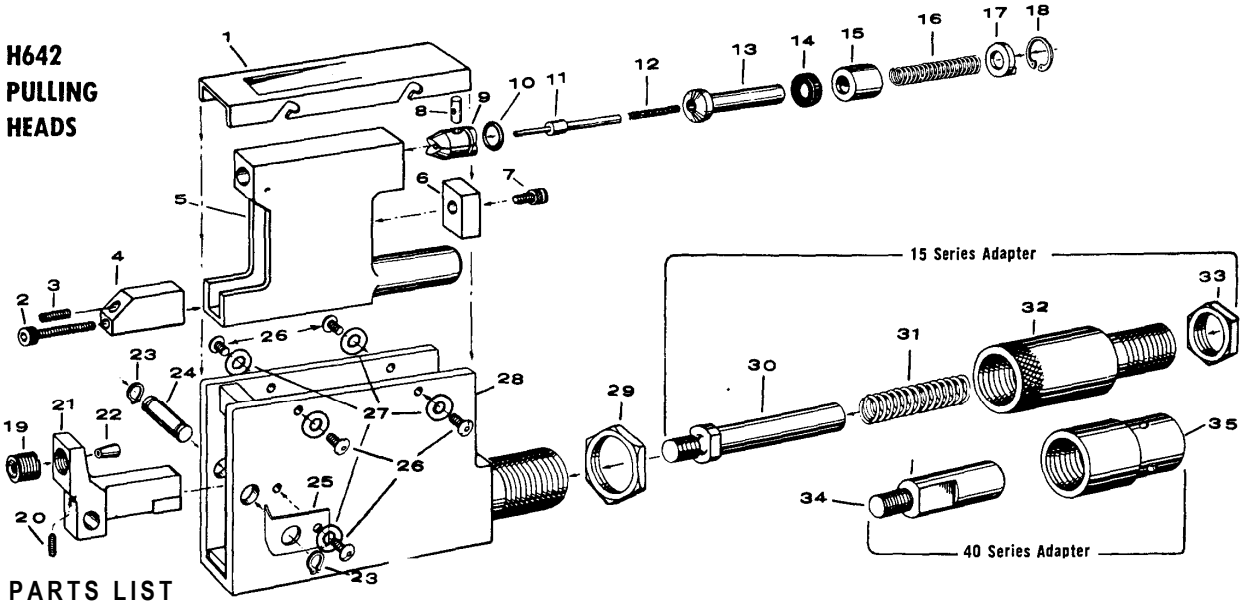
CURRENTLY UNDER CHANGE

Contact Document Control for Status

CHERRY® AEROSPACE

1224 East Warner Ave,
Santa Ana, Ca 92705
Tel: 1-714-545-5511
www.cherryaerospace.com

H642 PULLING HEADS



PARTS LIST

Ref. No.	DESCRIPTION	ITEM	1/8" Universal Heads H642-4U15 H642-4U40	1/8" Countersunk Heads H6421-4C15 H6421-4C40	5/32" Universal Heads H642-5U15 H642-5U40	5/32" Countersunk Heads H642-5C15 H642-5C40	3/16" Universal Heads H642-6U15 H642-6U40	3/16" Countersunk Heads H6421-6C15 H642-6C40	1/4" Universal Heads — H642-8U40	1/4" Countersunk Heads —• H642-8C40
1	Cover	1	642861-1	642661-1	642661-1	64266111	642861-1	642861-1	642B61-1	64266111
2	Cap Screw, 10-32 X 11/2	1	P-56	6156	P-56	P-56	6156	6156	6156	6156
3	Set Screw, 10-32 X 7/8"	1	P-402	6402	61402	P-402	61402	6402	6402	P-402
4	Shift Slide	1	642465-1	642465-1	64246511	64246511	64246511	64246511	64246511	642465-1
5	Drawbolt	1	642652	642852	642852	642652	642652	642652	642652	642852
6	Stop Block	1	642A33-5	642A33-5	642A33-5	642A33-5	642A33-8	642A33-8	642A33-8	642A33-8
7	Cap Screw, 10-32 X 3/8"	1	P-90	P-90	P-90	P-90	P-90	P-90	P-90	P-90
8	Stem Stop	1	642A23	642A23	642A23	642A23	642A23	642A23	642A23	642A23
9	Jaws (pair) (Includes P-383)	1	642B13-4	642B13-4	642B13-5	642B13-5	642B13-6	642B13-6	642B13-8	642B13-8
10	0-Ring	1	P-383	P-383	P-383	P-383	P-383	P-383	P-383	P-383
11	Stem Ejector	1	642A15	642A15	642A15	642A15	642A15	642A15	642A15	642A15
12	Ejector Spring	1	P-518	P-518	P-518	P-518	P-518	P-518	P-518	P-518
13	Follower	1	642A17	642A17	642A17	642A17	642A17	642A17	642A17	642A17
14	Seat	1	620A44	620A44	620A44	620A44	—	—	—	—
14	Seat	**2**	—	—	_	_	620A44	620A44	620A44	620A44
15	Spacer	1	642A14-4	642A14-4	642A14-5	642A14-5	642A14-6	642A14-6	642A14-8	642A14-8
16	Jaw Spring	1	642A16	642A16	642A16	642A16	642A16	642A16	642A16	642A16
17	Washer	1	642A18	642A18	642A18	642A18	642A18	642A18	642A18	642A18
18	Retaining Ring, Truarc **5000-51**	1	P-405	P405	P405	642A14-4	P-405	P405	6405	61405
19	Rivet Seat	1	642B58-4	642B58-4	642B58-5	642B58-5	642B58-6	642B58-6	642B58-8	642B58-8
20	Set Screw, 6-32 x 5/16	1	P-924	P-924	P-924	P-924	P-924	61924	P-924	P-924
21	Rocker Arm	1	642B53	642B53	642B53	642B53	642B53	642B53	642B53	642B53
22	Anvil	1	642A60-4	642A60-4	642A60-5	642A60-5	642A60-6	642A60-6	642A60-8	642A60-8
23	Retaining Ring, Truarc **5100128**	2	P-404	P-404	P-404	P-404	61404	P-404	P-404	P-404
24	Trunion Pin	1	642A32	642A32	642A32	642A32	642A32	_ 642A32	642A32	642A32
25	Guard	1	642A41	642A41	642A41	642A41	642A41	642A41	642A41	642A41
26	Button Head Screw 6-32 2 5132	5	P-714	P-714	P-714	P-714	P-714	P-714	P-714	P-714
27	Shakeproof Washer, #6	5	6142	P-42	P-42	P-42	P-42	P-42	P-42	P-42
28	Sleeve Assembly	1	642B55-4	642B55-4	642B55-5	642B55-5	642B55-6	642B55-6	642B55-8	642B55-8
29	Jam Nut	1	642464	642464	642464	642464	642A64	642A64	642A64	642A64

• **NOTE: THE H642 (15 SERIES) AND H642 (40 SERIES) HEADS ARE IDENTICAL EXCEPT FOR THE FOLLOWING ADAPTER PARTS:**

	Ref.	Description	Qty	Part Number
H642 (40 SERIES)	34	Drawbolt Adapter	1	642A62-1
	35	Sleeve Adapter	1	642A62-2

	Ref. no.	Description	Qty	Part number
H642 (15 SERIES)	30	Drawbolt Adapter	1	642A63-1
	31	Spring	1	560A20
	32	Sleeve Adapter	1	642A63-2
	33	Jam Nut	1	G6JN

CHERRY® AEROSPACE

1224 East Warner Ave,
Santa Ana, Ca 92705
Tel: 1-714-545-5511
www.cherryaerospace.com

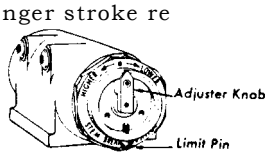
INSTALLING H642 PULLING HEADS ON RIVETER

Make sure the drawbolt of the tool is in the fully forward position. Connect power tool to air supply before attaching pulling head.

Thread the pulling head onto the drawbolt and tighten the jam nut (on 15 Series) or set screw (on 40 Series) to secure it to the tool.

To use the H642 (15 Series) head on G-684 or G-784 Hydro-shift Riveters, first install a 680B46 adapter to the riveter and then attach the pulling head.

The shift point setting on the riveter must then be adjusted to compensate for the longer stroke required for the adapter as follows:



1. Remove limit pin
2. Turn adjuster knob counter-clockwise until it stops.

Tool will now install Cherrylock rivets up to 1/2" grip length. Before using a straight H681 pulling head again, the riveter must be readjusted using a 680A159 setting gage. Reverse steps 1 & 2 above and adjust riveter until gage point is flush with tool head.

MAINTENANCE AND REPAIR

It is important that the head be kept clean, especially around the riveting end, as adhesives, chips, sealants, etc., will clog the serrations of the jaws and cause slipping. The rivet seat and the lock ring anvil must be kept especially clean since foreign matter can build up and keep the anvil from going all the way forward to set the locking collar in the rivet..

An occasional application of a good grade of high pressure grease, such as Lubriplate 130A, to the bottoms of the drawbolt and rocker arm will prolong the life of those parts.

DISASSEMBLY INSTRUCTIONS

A. Loosen jam nut (29) and remove adapter sleeve (32) or (35). Remove drawbolt adapter (30) or (34).

B. Remove four button head screws (26) and lift off cover (1).

C. Remove retaining ring (23) button screw (26), guard (25) and trunion pin (24). This will allow rocker arm (21), anvil (22) and drawbolt (5) to be removed from sleeve assembly (27).

D. To disassemble drawbolt remove retaining ring (18) and washer (17). The stem stop (8), jaws (9), 0-Ring (10), ejector (11), spring (12), follower (13), seat (14), spacer (15) and spring (16) will then come out rear of drawbolt.

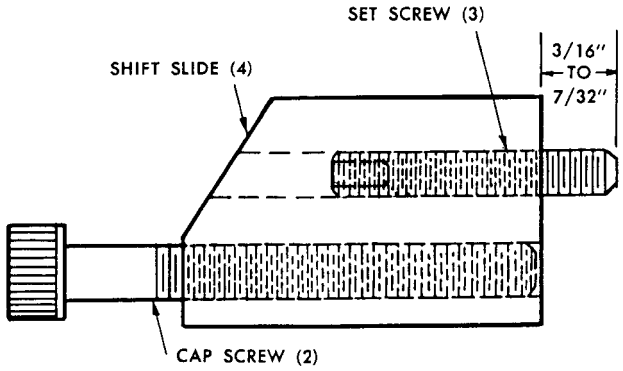
E. It is not usually necessary to remove the shift slide (4), stop block (6) or rivet seat (19), but if any of them have been damaged they may be removed by loosening screws (2), (7) and (20).

ASSEMBLY INSTRUCTIONS

A. Replace any broken or worn parts. In reassembling drawbolt, press in on special washer (17) while inserting retaining ring (18). When retaining ring is in place turn special washer until its lug is positioned between the ends of the retaining ring.

B. If shift slide (4) has been removed from pulling head for repair or replacement, it should be repositioned by turning screw (3) until it protrudes from the back of the slide 3/16 to 7/32 of an inch. With the shift slide pressed snugly against rear of drawbolt (5), run cap screw (2) in until it is tight. Shift slide will then be in approximately the correct operating position, but may require minor adjustments as outlined in Shift Point Adjustment instructions on- the following page.

C. Apply a coating of high pressure grease, such as Lubriplate™ 130AA, to the top and bottom of drawbolt (5) and to the bottom of rocker arm (21). Reassemble head.



CHERRY® AEROSPACE

1224 East Warner Ave,
Santa Ana, Ca 92705
Tel: 1-714-545-5511
www.cherryaerospace.com

ADJUSTING PULLING HEAD

These pulling heads are factory adjusted to properly install rivets in the A-Group (shorter lengths). If head has been disassembled for repair it will be necessary to readjust it. Gages are furnished for this purpose and may be identified by their color:

1/8" diameter, No. 628-4 is green; 5/32" diameter, No. 628-5 is red; 3/16" diameter, No. 628-6 is blue and 1/4" diameter, No. 628-8 is plain.
Two separate adjustments are necessary, and are to be performed in the following order:

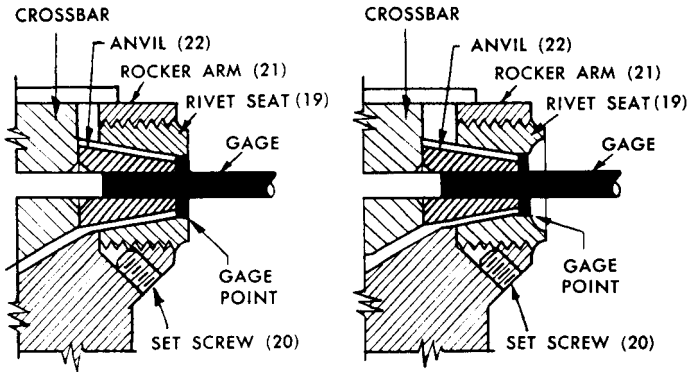
LOCK RING ANVIL ADJUSTMENT

A. When adjusting pulling head, either on or off the tool, make sure that the drawbolt (5) is in the full forward position.

B. Push rocker arm (21) back toward drawbolt so it rests on shift slide (4).

C. Loosen set screw (20). Insert short end of setting gage into rivet seat (19) until inner face of gage collar rests against end of anvil (22) and anvil rests on crossbar in sleeve. Turn rivet seat (19) until outer face of gage collar is flush with face of countersunk head rivet seat or flush with bottom recess of universal head rivet seat.

D. When gage is flush, rotate rivet seat (19) counterclockwise one complete turn.



COUNTERSUNK HEAD **UNIVERSAL HEAD**

E. Tighten set screw (20) snugly to prevent anvil from getting out of adjustment.

SHIFT POINT ADJUSTMENT

This adjustment determines the flushness of break of the rivet stem. After the lock ring is inserted the rivet stem should fracture substantially flush with the rivet head.

A. If stem breaks below flush, loosen cap screw (2) and turn set screw (3) clockwise 1/4 turn (max.). Tighten cap screw (2).

B. Test setting by installing rivet and repeat if necessary.

C. If stem breaks above flush, loosen cap screw (2) and turn set-screw (3) counterclockwise 1/4 turn (max.). Tighten cap screw (2).

Test setting by installing rivet and repeat if necessary.

If pulling head is so far out of adjustment that it does not respond to these 1/4 turn corrections, it may be quicker to remove the rocker arm (21) and shift slide (4) and reposition the adjusting screw (3) to its approximate starting position as outlined under Assembly Instruction "B" on the previous page.

CHERRY® AEROSPACE

1224 East Warner Ave,
Santa Ana, Ca 92705
Tel: 1-714-545-5511
www.cherryaerospace.com