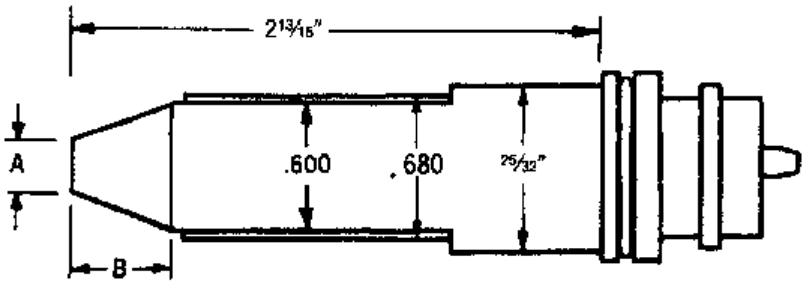
H681 PULLING HEAD

FOR THE 2000 SERIES CHERRYLOCK® RIVETS (DOUBLE ACTION)

INSTRUCTION SHEET

- A separate pulling head is required for each diameter CherryLock® rivet.
- It is acceptable that countersunk (C) pulling heads be used for installing both universal and counter-sunk head CherryLock® rivets. These heads fit directly on all Cherry Double Action Riveters (Ex: G700, G784, G689)

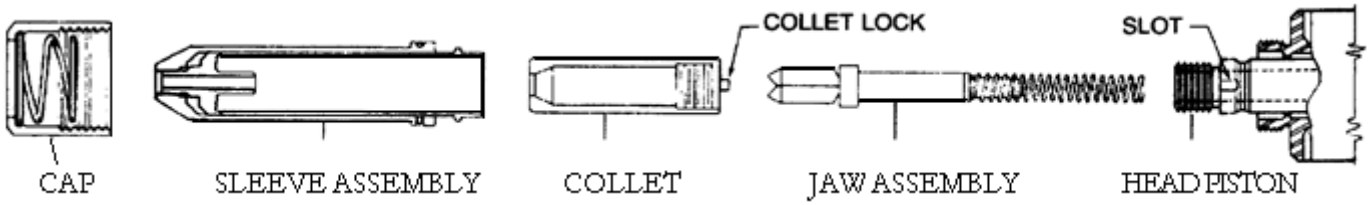


AVAILABLE EXTENSIONS

- H681 pulling heads may be obtained in four extended lengths to reach difficult to access areas.
  These are 2", 6", 12" & 24" extensions additional to the normal head length of 2 13/16".
- To order extension heads, specify correct pulling head number from the chart and add extension length required.
  Example: H681-6C-E2 for 2"
  H681-6C-E12 for 12"

RIVET DIA	PULLING HEAD NUMBER	DIMENSIONS	
		A	B
3/32"	H681-3C Countersunk Head (MS 20426)	0.163	0.332
1/8"	H681-4C Countersunk Head (MS 20426)	0.208	0.341
	H681-4F Countersunk Head (156°)	0.43	0.358
	H681-4S Countersunk Head (NAS 1097)	0.174	0.341
	H681B166-4 Uni-Sink Head	0.25	0.359
5/32"	H681-5C Countersunk Head (MS 20426)	0.269	0.352
	H681-5F Countersunk Head (156°)	0.535	0.338
	H681-5S Countersunk Head (HAS 1097)	0.225	0.352
	H681B166-5 Uni-Sink Head	0.313	0.377
3/16"	H681-6C Countersunk Head (MS 20426)	0.335	0.386
	H681-6F Countersunk Head (156°)	0.625	0.367
	H681-6S Countersunk Head (NAS 1097)	0.281	0.386
	H681B166-6 Uni-Sink Head	0.375	0.419
1/4 "	H681-8C Countersunk Head (MS20426)	0.458	0.398
	H681-8S Countersunk Head (MS1097)	0.374	0.398

MOUNTING INSTRUCTIONS



1. Remove knurled cap from front of riveter head.
2. Place jaw assembly inside collet.
3. Insert spring end of jaw assembly into hole in head piston. Apply enough pressure to engage collet threads. Turn until collet bottoms on shoulder of piston and collet lock snaps into slot in piston. Hand tightening is sufficient.

   Note: To remove collet, push collet lock back into collet (using a blunt pointed tool) while turning the collet counterclockwise.
4. Place sleeve assembly over collet and head piston. Slip knurled cap over the sleeve assembly and hand tighten onto end of riveter head.

CHERRY® AEROSPACE

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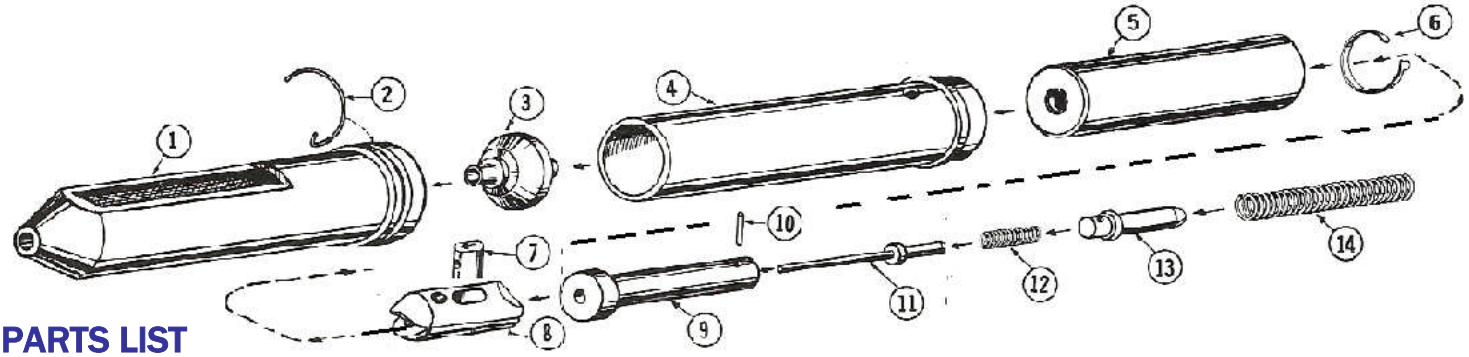
INSTRUCTION SHEET



PARTS LIST

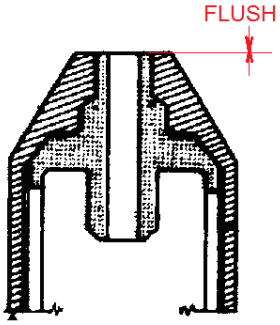
Rel. No.	Description	Qty Req.	Head Number				
			H681-3	H681-4	H681-5	H681-6	H681-8
1	Outer Sleeve, C'sunk Head (MS20426)	1	681C6-3C	681C6-4C	681C6-5C	681C6-6C	681C6-8C
	Outer Sleeve, C'sunk Head (158°)	1	—	681C6-4F	681C6-5F	681C6-6F	—
	Outer Sleeve, C'sunk Head (NAS 1097)	1	—	681C6-4S	681C6-5S	681C6-6S	681C6-8S
	Outer Sleeve, Uni-Sink Head	1	—	681C86-4	681C86-5	681C86-6	
2	Retainer	1	680A25	680A25	680A25	680A25	680A25
3	Anvil	1	681B5-3	681B5-4	681B5-5	681B5-6	681B5-8
4	Tube	1	681A4	681A4	681A4	681A4	681A4
5	Collet Assembly	1	680A152	680A152	680A152	680A152	680A152
6	Collet Lock (included in the Collet Assy.)	1	680A152-3	680A152-3	680A152-3	680A152-3	680A152-3
7	Stem Stop	1	615A48	615A41	615A37	615A37	615A37
* 8	Jaw. (pair)	1	615B40-3	615B40-4	615B40-5	615B40-6	615B40-8
* 9	Pusher	1	680A30-1	680A30-1	680A30-2	680A30-2	680A30-2
* 10	Pin	1	P-575	P-575	P-575	P-575	P-575
* 11	Ejector Pin	1	680A16-3	680A16-1	680A16-2	680A16-2	680A16-2
* 12	Spring	1	P555	P555	680A56	680A56	680A56
* 13	Stop	1	680A29	680A29	680A29	680A29	680A29
* 14	Spring	1	680A26	680A26	680A26	680A26	680A26

NATIONAL STOCK NUMBERS STANDARD STRAIGHT PULLING HEADS	
H681B166-4	5130-01-089-8039
H681B166-5	5130-01-089-2721
H681-3C	5130-01-154-6997
H681-4C	5130-00-083-6625
H681-5C	5130-00.083-6627
H681-6C	5130-01-021-7451
H681-8C	5130-00-083-6634

*These parts can be ordered separate or as part of the Pusher Assembly P/N:
680A13-3 for -3 diameter Cherrylock
680A13-4 for -4 diameter Cherrylock
680A13-5 for -5 diameter Cherrylock
680A13-6 for -6 diameter Cherrylock
680A13-8 for -8 diameter Cherrylock

MAINTENANCE AND REPAIR

- Keep the pulling head clean, especially around the riveting end, as adhesives, chips, sealants, etc., will cause slipping.
  Note: At assembly **be sure that stem stop** (7) **is replaced with arrow pointing forward**, as shown in the exploded view above.
- To replace ejector pin (11) or spring (12), first remove pin (10) and stop (13).
- The flushness of Anvil (3) is critical (see sketch on the right). If the anvil protrudes .004" or more out of the outer sleeve (1), then the sleeve is worn or damaged and must be replaced.



ANVIL/SLEEVE ALIGNMENT FOR COUNTERSUNK HEAD CONFIGURATION

WARRANTY

Seller warrants the goods conform to applicable specifications and drawings and will be manufactured and inspected according to generally accepted practices of companies manufacturing industrial or aerospace fasteners. In the event of any breach of the foregoing warranty, Buyer's sole remedy shall be to return defective goods (after receiving authorization from Seller) for replacement or refund of the purchase price, at the Seller's option. Seller agrees to any freight costs in connection with the return of any defective goods, but any costs relating to removal of the defective or nonconforming goods or installation of replacement goods shall be Buyer's responsibility. SELLER'S WARRANTY DOES NOT APPLY WHEN ANY PHYSICAL OR CHEMICAL CHANGE IN THE FORM OF THE PRODUCT IS MADE BY BUYER. THE FOREGOING EXPRESS WARRANTY AND REMEDY ARE EXCLUSIVE AND ARE IN LIEU OF ALL OTHER WARRANTIES AND REMEDIES; ANY IMPLIED WARRANTY AS TO QUALITY, FITNESS FOR PURPOSE, OR MERCHANTABILITY IS HEREBY SPECIFICALLY DISCLAIMED AND EXCLUDED BY SELLER. This warranty is void if seller is not notified in writing of any rejection of the goods within ninety (90) days after receipt of the goods by buyer.
Seller shall not be liable under any circumstances for incidental, special or consequential damages arising in whole or in part from any breach by Seller, AND SUCH INCIDENTAL, SPECIAL, OR CONSEQUENTIAL DAMAGES ARE HEREBY EXPRESSLY EXCLUDED.
Our policy is one of continuous development. Specifications shown in this document may be subject to changes introduced after publication.
NOTE: The properties, strength, dimensions, installed characteristics and all other information in these materials are for guidance only to aid in the correct selection of the products described herein and is not intended or implied as part of the above warranty. All applications should be evaluated for functional stability and available samples of the described parts can be requested for installed tests, suitability and evaluations.

For more information please contact our Technical Services Department at tel. 714-850-6022

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