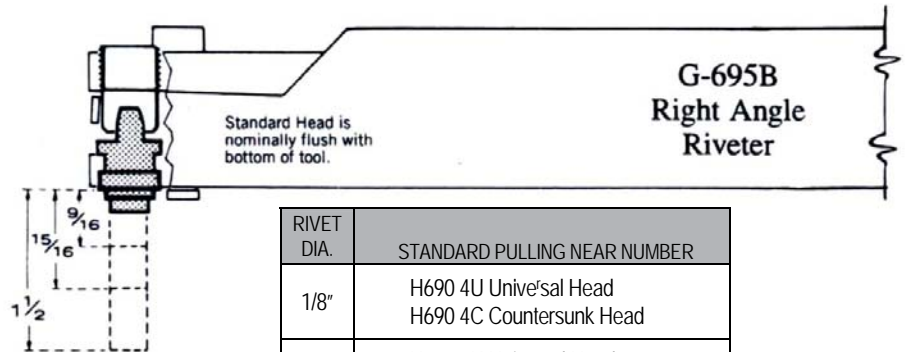


H690 Right Angle Pulling Head

FOR 2000 SERIES CHERRYLOCK®
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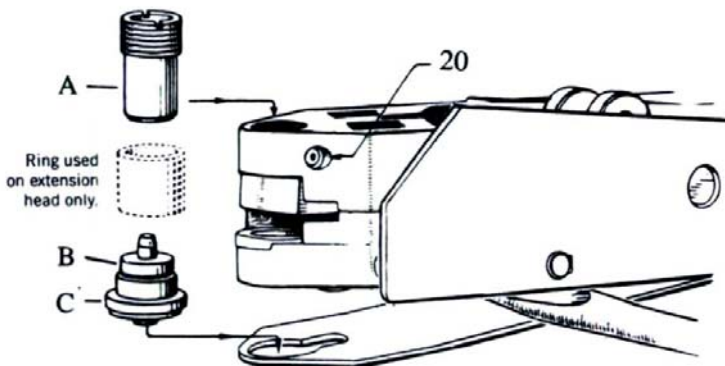
There is a separate pulling head required for each head style (universal or countersunk) and each shank diameter of Cherrylock® Rivets. These heads fit directly onto the Cherry® G-695 Right Angle Riveters.



RIVET DIA.	STANDARD PULLING HEAD NUMBER
1/8"	H690 4U Universal Head H690 4C Countersunk Head
5/32"	H690 5U Universal Head H690-5C Countersunk Head
3/16"	H690 6U Universal Head H690 6C Countersunk Head
1/4"	H690-8U Universal Head H690-8C Countersunk Head

Note: These pulling heads are also available in 9/16", 15/16" and 1 1/2" extensions. To order, specify proper pulling head and add length of extension to part number such as: H690-4U- 15/16"

MOUNTING INSTRUCTIONS



1. Place lock ring anvil (B) into nose piece (C) and, using a screwdriver, pry the bottom leaf spring open far enough to insert the anvil and nose assembly. Release the leaf spring and it will hold the assembly in place.
2. If an extension nose piece (9/16", 15/16 or 1 1/2") is used, there is an additional part, a ring, that is placed on top of the lock ring anvil (B) before it and the nose piece are inserted into the leaf spring. When inserting the longer nose extensions, it is advisable to loosen the set screws holding the leaf spring rather than prying it open.
3. Remove set screw (20) and thread jaw holder assembly (A) into upper frame using flat wrench 690A62 included with tool, until only about 1/16" protrudes.
4. Replace screw (20), but do not tighten until pulling head has been adjusted.



CHERRY®
AEROSPACE

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Santa Ana, CA 92705
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www.cherryaerospace.com

H690

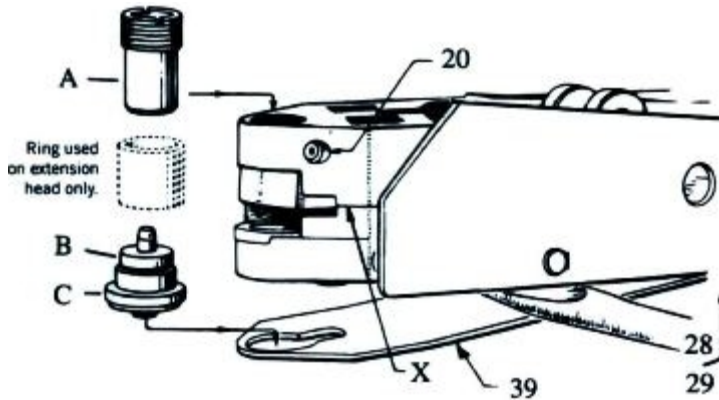
Right Angle Pulling Head

FOR 2000 SERIES CHERRYLOCK®

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ADJUSTING H690 PULLING HEAD



When pulling heads are changed it is necessary to readjust with gages furnished for this purpose. The gages may be identified by their color: 628-4 (Ø 1/8") green; 628-5 (Ø 5/32") red; 628-6 (Ø 3/16") blue and 628-8 (Ø 1/4") plain.

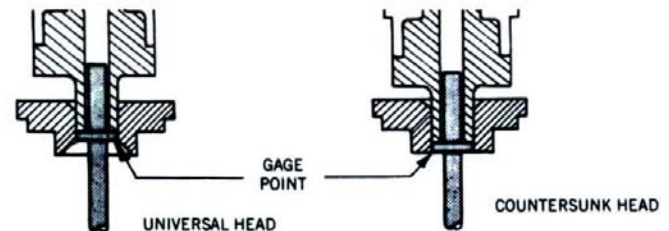
Adjust as following:

SHIFT POINT SETTING

1. Loosen set screw (20) and push long end of proper size gage into pulling head nose (C).
2. If gage falls out freely, turn jaw holder assembly (A) counter-clockwise with 690A62 flat wrench until you feel the jaws engage the serrations on the gage stem. Release jaw pressure slightly by turning assembly (A) approximately one-quarter to one-half turn clockwise and then tighten set screw (20) snugly.
3. In use, the rivet stems should fracture flush with the rivet head. If they do not, loosen set screw (20) and turn the jaw assembly holder (A) one-quarter of a turn at a time, in either direction, until desired flushness is obtained. Tighten set screw (20).

LOCK RING ANVIL SETTING

1. Pry frame members apart and insert a piece of 1/4" drill rod at point marked "X" to allow clearance while setting and checking lock ring anvil.
2. Select proper gage and insert short end into nose piece (C).
3. Loosen jam nut (29) through clearance hole in bottom leaf spring (39) and turn adjusting screw (28) until top of gage collar is flush with face of the countersunk head nose piece or flush with the bottom of the universal head.



4. When anvil adjustment is completed, hold adjusting screw (28) to prevent it from turning and tighten jam nut (29) securely. Remove 1/4" drill rod from between frame members.
5. It is advisable to install a few rivets in test plates of the same material thickness, hole size, etc., as the production part to be sure the pulling head settings are correct before starting production work.

Note: H690 pulling heads do not eject the spent stems

ADJUSTING H690 PULLING HEAD

Make certain the pulling head is kept clean, especially around the riveting end, as adhesives, chips, sealants, etc., will clog up the serrations of the jaws and cause slipping. The top of the lock ring anvil must be kept clean, as foreign materials can build up and keep it from going all the way forward to set the locking ring in the rivet.

STANDARD OR 9/16" EXTENSION HEADS

To replace jaws (4) or spring (7) on standard or 9/16" pulling heads, remove the retaining ring (9). When reassembling head, make sure

the lug on special washer (8) is positioned between the ends of the retaining ring (9).

15/16" OR 1 1/2" EXTENSION HEADS

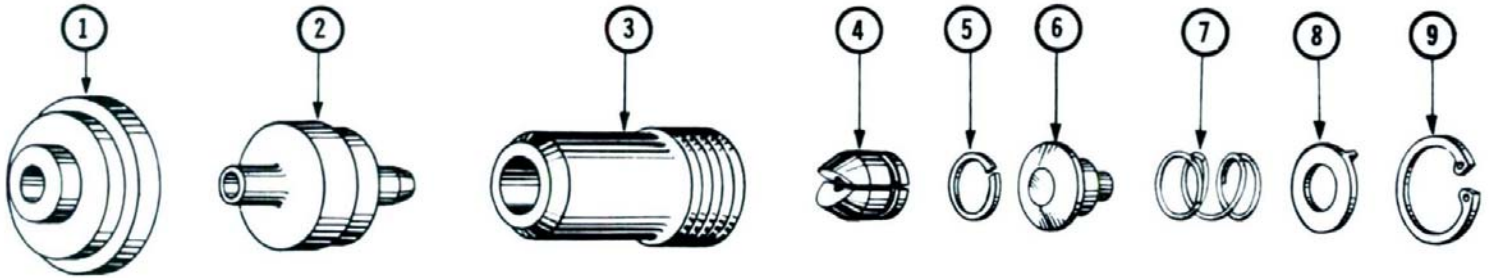
To replace jaws (4) or spring (7) on either the 15/16 or 1 1/2" extension pulling heads, remove the extension (8) by unthreading from the jaw holder (3). If it becomes necessary to replace the Belleville washers (9), be sure that they are assembled with their convex surfaces together. All parts should be tightened securely.



H690

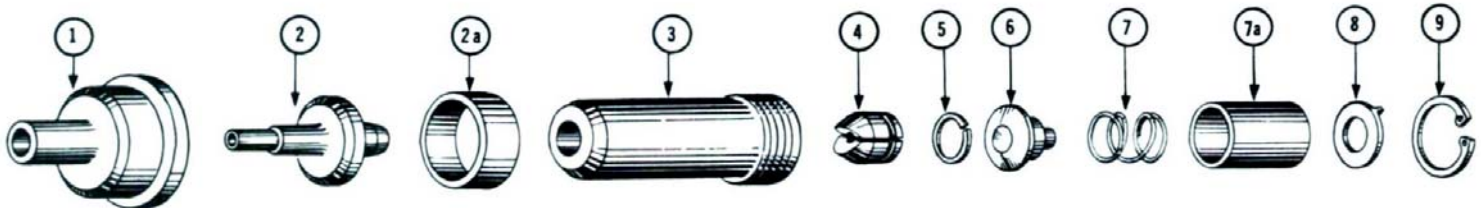
Right Angle Pulling Head

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STANDARD PULLING HEAD PART NUMBERS

Ref. No.	Description	Qty	Pulling Head No.							
			H690-4U	H690-4C	H690-5U	H690-5C	H690-6U	H690-6C	H690-8U	H690-8C
1	Nose	1	690B9-4U	690B15-4C	690B9-5U	690B15-5C	690B9-6U	690B15-6C	690B9-8U	690B15-8C
2	Anvil	1	690B7-4	690B7-4	690B7-5	690B7-5	690B7-6	690B7-6	690B7-8	690B7-8
3	Jaw Holder	1	690B6	690B6	690B6	690B6	690B6	690B6	690B6	690B6
4	Jaws (pair)	1	690B10-4	690B10-4	690B10-5	690B10-5	690B10-6	690B10-6	690B10-8	690B10-8
5	Retaining Ring	1	P-251	P-251	P-251	P-251	P-251	P251	P-251	P-251
6	Follower	1	690A17	690A17	690A17	690A17	690A17	690A17	690A17	690A17
7	Jaw Spring	1	690A20	690A20	690A20	690A20	690A20	690A20	690A20	690A20
8	Washer	1	690A16	690A16	690A16	690A16	690A16	690A16	690A16	690A16
9	Retaining Ring	1	P-600	P-600	P-600	P-600	P-600	P-600	P-600	P-600



9/16" EXTENSION HEAD PART NUMBERS

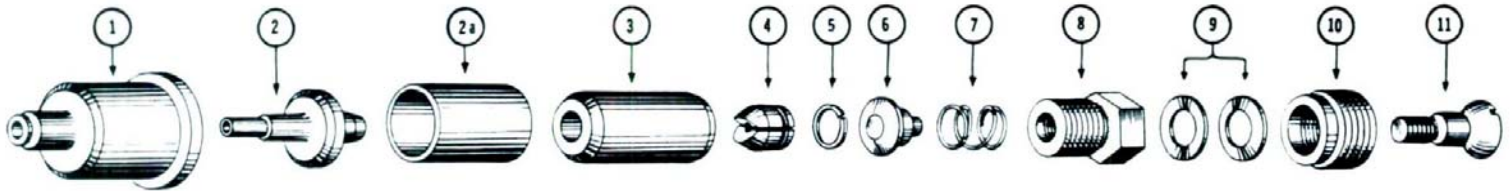
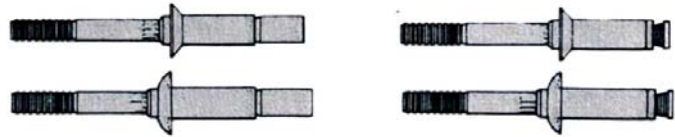
Ref. No.	Description	Qty.	Pulling Head No.							
			H690-4U 9/16	H690-4C 9/16	H690-5U 9/16	H690-5C 9/16	H690-6U 9/16	H690-6C 9/16	H690-8U 9/16	H690-8C 9/16
1	Nose	1	690B32-4U 9/16	690B31-4C 9/16	690B32-5U 9/16	690B3-5C 9/16	690B32-6U 9/16	690B31-6C 9/16	690B32-8U 9/16	690B31-8C 9/16
2	Anvil	1	690B33-4	690B33-4	690B33-5	690B33-5	690B33-6	690B33-6	690B33-8	690B33-8
2a	Ring	1	690A35-9/16	690A35-9/16	690A35-9/16	690A35-9/16	690A35-9/16	690A35-9/16	690A35-9/16	690A35-9/16
3	Jaw Holder	1	690B34	690B34	690B34	690B34	690B34	690B34	690B34	690B34
4	Jaws (pair)	1	690B10-4	690B10-4	690B10-5	690B10-5	690B10-6	690B10-6	690B10-8	690B10-8
5	Retaining Ring	1	P-251	P-251	P-251	P-251	P-251	P-251	P-251	P-251
6	Follower	1	690A17	690A17	690A17	690A17	690A17	690A17	690A17	690A17
7	Jaw Spring	1	690A20	690A20	690A20	690A20	690A20	690A20	690A20	690A20
7a	Tube	1	690A36	690A36	690A36	690A36	690A36	690A36	690A36	690A36
8	Washer	1	690A16	690A16	690A16	690A16	690A16	690A16	690A16	690A16
9	Retaining Ring	1	P-600	P-600	P-600	P-600	P-600	P-600	P-600	P-600



H690

Right Angle Pulling Head

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15/16" EXTENSION HEAD PART NUMBERS

Ref. No.	Description	Qty.	Pulling Head No.							
			H690-4U 15/16	H690-4C 15/16	H690-5U 15/16	H690-5C 15/16	H690-6U 15/16	H690-6C 15/16	H690-8U 15/16	H690-8C 15/16
1	Nose	1	690B32-4U15/16	690B31-4C15/16	690B32-5U15/16	690B31-5C15/16	690B32-6U15/16	690B31-6C15/16	690B32-8U15/16	690B31-8C15/16
2	Anvil	1	690B33-4	690B33-4	690B33-5	690B33-5	690B33-6	690B33-6	690B33-8	690B33-8
2a	Ring	1	690A35-15/16	690A35-15/16	690A35-15/16	690A35-15/16	690A35-15/16	690A35-15/16	690A35-15/16	690A35-15/16
3	Jaw Holder	1	690B42	690B42	690B42	690B42	690B42	690B42	690B42	690B42
4	Jaws (pair)	1	690B10-4	690B10-4	690B10-5	690B10-5	690B10-6	690B10-6	690B10-8	690B10-8
5	Retaining Ring	1	P-251	P-251	P-251	P-251	P-251	P-251	P-251	P-251
6	Follower	1	690A46	690A46	690A46	690A46	690A46	690A46	690A46	690A46
7	Jaw Spring	1	690A20	690A20	690A20	690A20	690A20	690A20	690A20	690A20
8	Extension	1	690A43-15/16	690A43-15/16	690A43-15/16	690A43-15/16	690A43-15/16	690A43-15/16	690A43-15/16	690A43-15/16
9	Belleville Washer	2	690A47	690A47	690A47	690A47	690A47	690A47	690A47	690A47
10	Ball Seat	1	690A44	690A44	690A44	690A44	690A44	690A44	690A44	690A44
11	Ball Screw	1	690A45	690A45	690A45	690A45	690A45	690A45	690A45	690A45

1 1/2" EXTENSION HEAD PART NUMBERS

Ref. No.	Description	Qty.	Pulling Head No.							
			H690-4U 1 1/2	H690-4C 1 1/2	H690-5U 1 1/2	H690-5C 1 1/2	H690-6U 1 1/2	H690-6C 1 1/2	H690-8U 1 1/2	H690-8C 1 1/2
1	Nose	1	690B32-4U1 1/2	690B31-4C 1 1/2	690B32-5U1 1/2	690B31-5C1 1/2	690B32-6U1 1/2	690B31-6C1 1/2	690B32-8U1 1/2	690B31-8C1 1/2
2	Anvil	1	690B33-4	690B33-4	690B33-5	690B33-5	690B33-6	690B33-6	690B33-8	690B33-8
2a	Ring	1	690A35-1 1/2	690A35-1 1/2	690A35-1 1/2	690A35-1 1/2	690A35-1 1/2	690A35-1 1/2	690A35-1 1/2	690A35-1 1/2
3	Jaw Holder	1	690B42	690B42	690B42	690B42	690B42	690B42	690B42	690B42
4	Jaws (pair)	1	690B10-4	690B10-4	690B10-5	690B10-5	690B10-6	690B10-6	690B10-8	690B10-8
5	Retaining Ring	1	P-251	P-251	P-251	P-251	P-251	P-251	P-251	P-251
6	Follower	1	690A46	690A46	690A46	690A46	690A46	690A46	690A46	690A46
7	Jaw Spring	1	690A20	690A20	690A20	690A20	690A20	690A20	690A20	690A20
8	Extension	1	690A43-1 1/2	690A43-1 1/2	690A43-1 1/2	690A43-1 1/2	690A43-1 1/2	690A43-1 1/2	690A43-1 1/2	690A43-1 1/2
9	Belleville Washer	2	690A47	690A47	690A47	690A47	690A47	690A47	690A47	690A47
10	Ball Seat	1	690A44	690A44	690A44	690A44	690A44	690A44	690A44	690A44
11	Ball Screw	1	690A45	690A45	690A45	690A45	690A45	690A45	690A45	690A45

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 ONE (1) YEAR AFTER INITIAL USE BY BUYER OF ANY POWER RIVETER OR NINETY (90) DAYS AFTER INITIAL USE OF ANY OTHER PRODUCT.

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