

H747-456

Compact Universal Straight Pulling Head

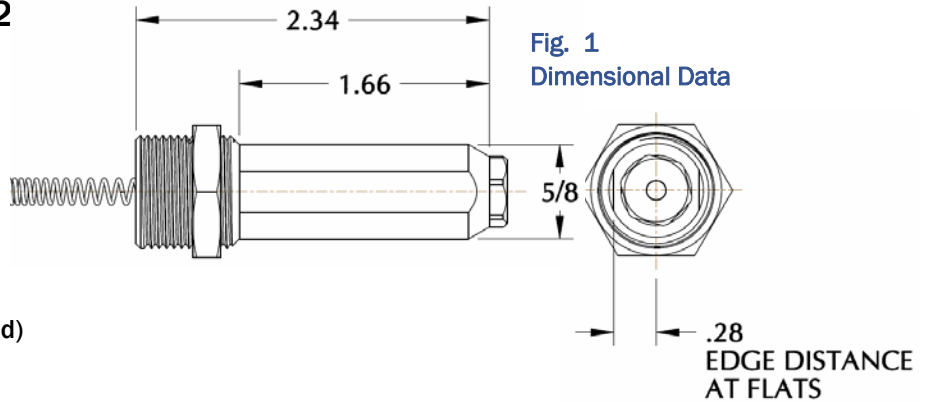
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DIMENSIONAL DATA (see Fig. 1)

- Weight: 0.15 Lbs

CHOICE OF RIVETERS

- G746A (1850 Lbs @ 90 PSI, 7/8" stroke)
- G747 (2100 Lbs @ 90 PSI, 7/16 stroke)
- G704B (3100 Lbs @ 90 PSI, 1/2" stroke)
- G800 (4200 Lbs, 3/4" stroke, hand powered)



MOUNTING INSTRUCTIONS (see Fig 2)

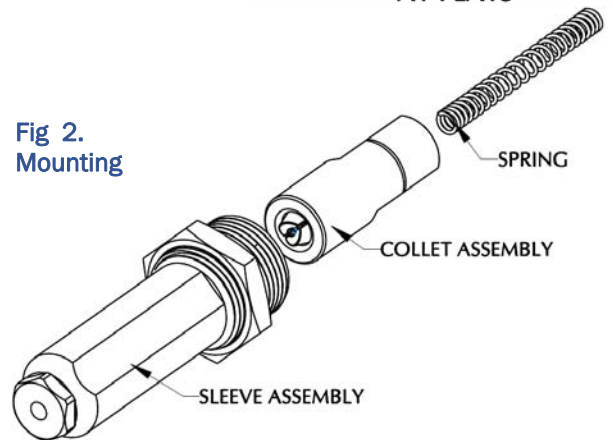
- Attach Riveter to air source; place the spring into the riveter piston
- Thread and tighten the collet assembly onto the riveter piston
- Thread in the sleeve assy and lock it in by tightening the Jam Nut.

JAW ADJUSTMENT

The jaws can be adjusted to hold onto the stem in position at all times or to fully release it before and after fastener installation

- Push the fastener all the way through the nose piece.
- *To grab onto the stem:* Unthread the sleeve while moving the fastener in and out until you feel the desired jaw hold.
- *To release the stem:* Thread the sleeve in until the stem is released
- After adjustment, lock in position by tightening the Jam Nut.

Fig 2. Mounting

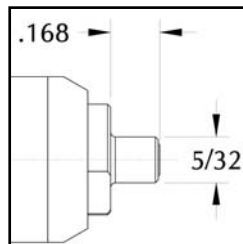


OPERATING INSTRUCTIONS

Before operating the tool, make sure that:

- Pulling Head is correctly mounted on the proper riveter
- Proper Air source is connected (see Riveter manual for air pressure).
- Make sure that a proper Nosepiece, jaw and jaw follower are used; see table 1 for selection and fastener capability.
 - Jaw follower 955-011 is necessary for smaller diameter fasteners to prevent stem shingling.

Fig. 3
782-3E
Extended Nosepiece



During Operation:

- Inspect the active area of the nosepiece regularly.
- Keep the tool clean, especially the nosepiece and jaws; pay special attention when sealants and adhesives are used.
- If stem slippage occurs, clean or replace the jaws.

Table 1: Nose Piece Selection Guide

JAW P/N	JAW FOLLOWER	NOSE PIECE	INSTALLS THE FOLLOWING PRODUCTS	
*701B18	*753A14A	*782-456	CherryMAX, CherryMAX AB: -4, -5, -6 (except 6 all aluminum) Blindbolt "S" type: -04 & -05 MBC Lock Creator: -4, -5, -6 NAS1900 "U" type: -4 & -5	
		886-004	CherryLOCK "A" Code: -4	
		886-005	CherryLOCK "A" Code: -5	
		782-4NAS	NAS1900, -4 (no shift washer)	
		782-5NAS	NAS1900, -5 (no shift washer)	
		782-5BB	Blindbolt "U" Type: -05	
		783-4MBC	Standard MBC: -4	
		782-5MBC	Standard MBC: -5	
		955-011	886-003	3 dia. CherryLOCK "A" Code
			782-3E	Extended 3 dia. CherryLOCK "A" Code, see figure 3
782-3	3/32" SPR & -3 pull thru NP Rivets			
782-010	886-002	886-006	6 Dia CherryLOCK "A" Code	
		782-6MBC	Standard MBC: -6	
		782-6AL	CherryMAX "AB" -6 Alum, NAS1900 "U" Type -4, -5, -6	
		782-6NAS	NAS1900, -6 (no shift washer)	



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PARTS LIST

ITEM No	PART NUMBER	DESCRIPTION	QTY.
1	782-456	Nosepiece (see table 1)	1
2	800-033	Sleeve	1
3	671A16	Jam Nut	1
4	753A13A	Collet	1
5	701B18	Jaw Set (see table 1)	1
6	753A14A	Jaw Follower (see table 1)	1
7	800-032	Drawbar	1
8	P-1483	Compression Spring	1

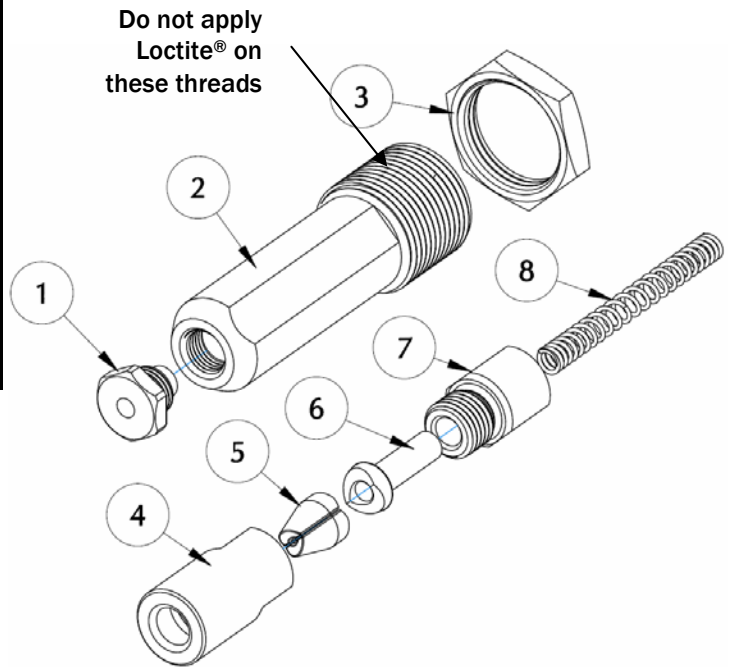
Items 1, 5 & 6 are fastener type and size dependent. See Table 1 for a guide on fastener capability and component selection.

PREVENTATIVE MAINTENANCE

- Clean and inspect the nosepiece, jaws, collet & spring every 1000 installations or whenever a failure occurs; replace spring and jaws if worn.
- Lubricate outside configuration of the jaws with Lubriplate® or similar light grease.
- Inspect regularly and keep active area clean and in good working condition.
- Replace worn or broken components.
- When re-assembling align the jaws with the jaw follower as shown in the exploded view (items 5 and 6); use Loctite® 242 (removable) on all threaded components except as shown.

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