

H83HL-6MB

PULLING HEAD FOR -6 DIA 130° MAXIBOLT™ TITANIUM FLUSH HEAD

Technical Data Sheet, Page 1 of 2

DIMENSIONAL DATA

(all measurements in Inches, see figure 1)

- Tool Weight (without riveter): .33 Lbs (.150 Kg).

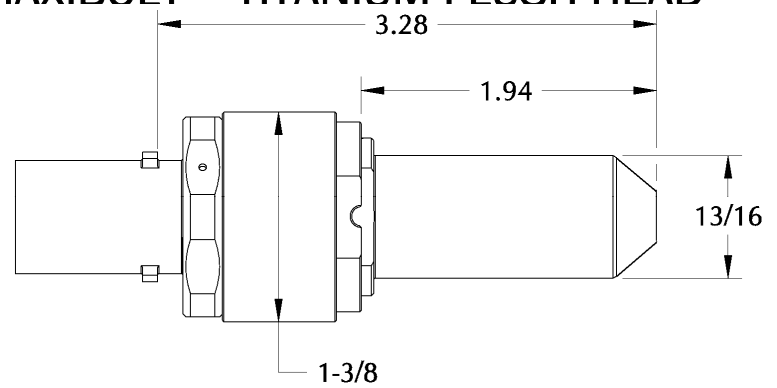


Figure 1

CHOICE OF RIVETERS

- **G83 or G84 Cherry® Riveters**
- May be used with **G84-LS Cherry® split riveters**; use with adaptor 744-700.

MOUNTING INSTRUCTIONS

- Attach riveter to air source for correct piston positioning; on the hand riveters, make sure that the pressure has been released and that the correct adaptors are used.
- Push against the riveter piston and thread collet assembly onto the piston.
- Snap sleeve assembly onto riveter bayonet mount.

USAGE

- This tool was designed to install -6 Diameter 130° Titanium Maxibolt™ flush head fasteners (CR7774S-06).

BEFORE USE, MAKE SURE THAT:

- The correct pulling head is used and is properly mounted on the recommended riveter.
- Proper air source is connected (see riveter specification for recommended pressure).
- Make sure that the tool is clean and in good working condition
- Make sure that the nut is snug against the Polyurethane Spring (item 11); do not over-tighten.

DURING OPERATION

- Inspect the active area of the nosepiece regularly.
- Keep the tool clean, especially the nosepiece and jaws; pay special attention when sealants are used.
- If stem slippage occurs, the Jaws need to be either cleaned or replaced.

PREVENTATIVE MAINTENANCE

- Clean the Insert, jaws and jaw cavity every 1,000 installations, or whenever failures occurs.
- Lubricate outside configuration of the jaws with Lubriplate® or similar light lubricant.
- Inspect regularly and keep the active area clean and in good working condition.
- Replace worn or broken components.

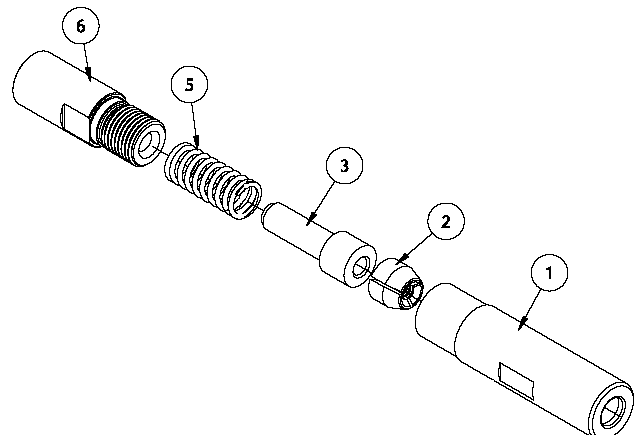
ASSEMBLY / DISASSEMBLY PROCEDURE

Caution: Use Loctite® 242 on the threaded elements

Collet Assembly

Grease the tapered area of the Jaws with Lubriplate®.

Assemble as shown in the exploded view; make sure the jaws (2) are properly aligned.



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

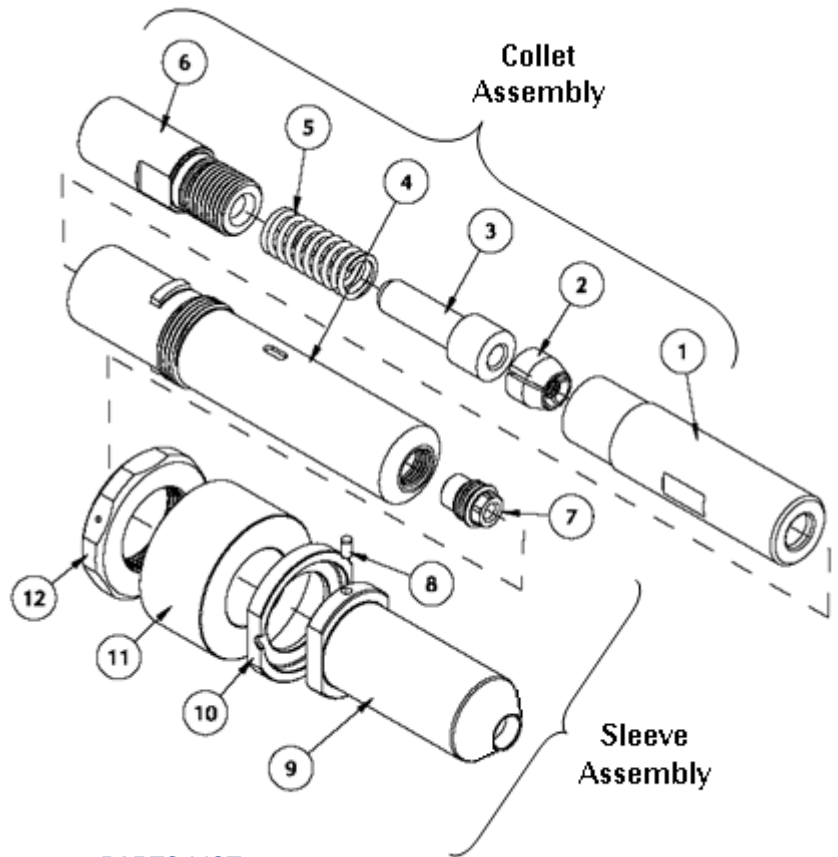
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Sleeve Assembly

- Thread nosepiece (7) into sleeve (4).
 - Thread load adjustment nut (12) over sleeve (4) as far as it goes.
 - Push the polyurethane spring (item 11), retainer washer (item 10) and preload sleeve (item 9) onto the sleeve.
 - Insert the collet assembly into the sleeve. Align retainer washer, sleeve and preload sleeve slots and press the dowel pin (8) to the collet inside; do not force. Rotate the retainer washer out of alignment, to prevent the dowel pin from disengaging during use.
- To disassemble remove the collet from inside and carefully press the dowel pin towards the center to remove it.



Preload Adjustment

- Thread the load adjustment nut (12) hand tight against the polyurethane spring (11) with the help of a wrench;
- To increase the pre-load, tighten the nut (12) against the polyurethane spring (11).
- Caution: if not properly tightened, the preload element will lose its effectiveness!

PARTS LIST

12	652-074	LOAD ADJUSTMENT JUT	1
11	P-1438	POLYURETHANE SPRING	1
10	652-075	RETAINER WASHER	1
9	652-077	PRELOAD SLEEVE (H83HL-6MB)	1
8	P-1440	DOWEL PIN	1
7	652-072	NOSE PIECE, -6MB	1
6	652-069	DRAWBOLT ADAPTOR	2
5	P-1425	SPRING, COMPRESSION	1
4	652-070	SLEEVE, H83HL & H84HL	1
3	652-031	JAW FOLLOWER	1
2	744C76	JAWS, -6MB	1
1	652-030	COLLET	1
ITEM NUMBER	PART NUMBER	DESCRIPTION	QTY. PER ASSY.

GENERAL / TECHNICAL QUESTIONS

1224 E. Warner Avenue
 Santa Ana, CA 92705 USA
 1-714-850-6022 (Phone)
 1-714-850-6093 (Fax)

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