

R721-4-60 RIVETLESS NUT PLATE REMOVAL TOOL

PATENT PENDING

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DIMENSIONAL DATA (all measurements in Inches, see figure 1)

- Tool weight (without riveter): 0.4 Lbs (0.181 Kg).

CHOICE OF RIVETERS

- G704B Cherry® Riveter;
- G747 Cherry® Riveter
- G750A Cherry® Hand Riveter with adaptor 750A-088

Note: May require double

triggering when used with G747.

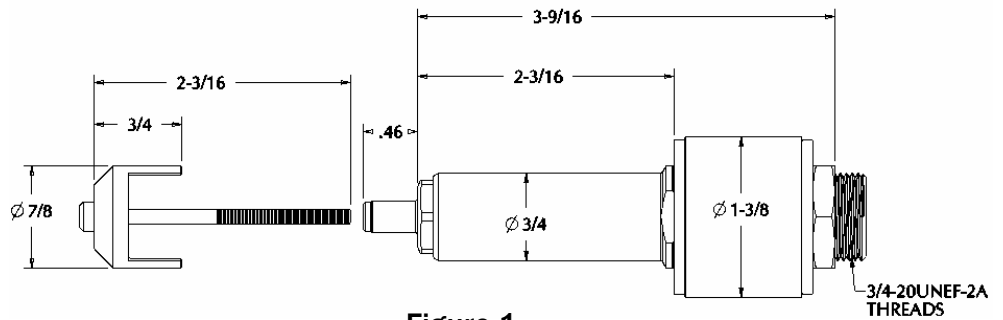


Figure 1

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 pulling head onto both piston and housing of the riveter at the same time.
- DO NOT tamper with the jam nut, as it controls the removal load.

USAGE

- This tool was designed to remove rivetless nut plate fasteners installed in \varnothing 0.343/0.347 holes

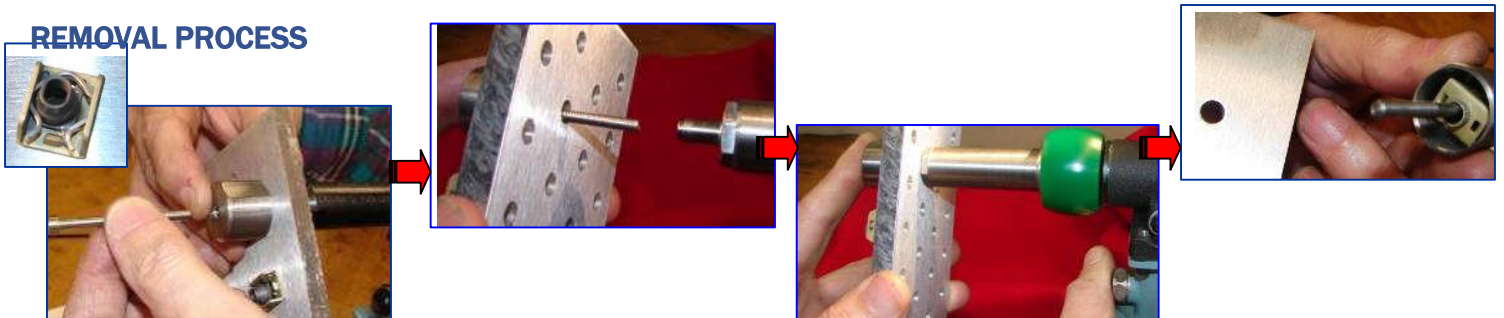
BEFORE USE, MAKE SURE THAT:

- The correct removal tool 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 load control element; 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 sealants are used.
- If stem slippage occurs, the jaws need to be either cleaned or replaced.

REMOVAL PROCESS



CHERRY®
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TS-H721-4-60 Rev: A Date: 02/05/07 CR: 07-0097

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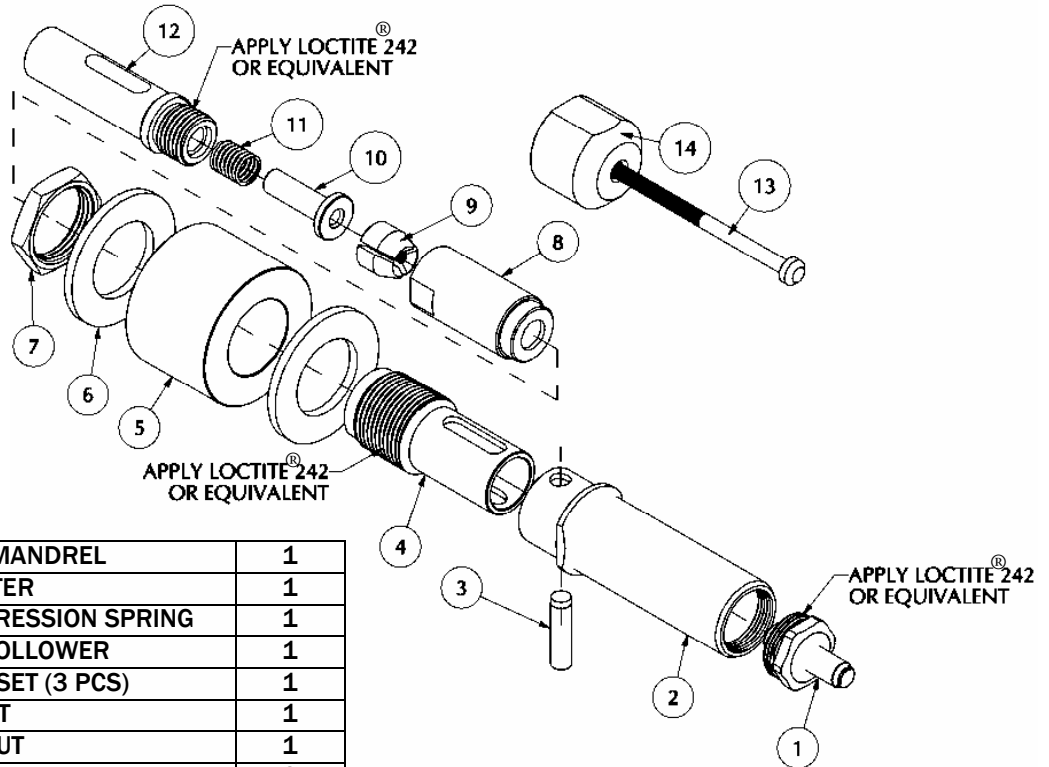
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PREVENTATIVE MAINTENANCE

- 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.
- At assembly, tighten jam nut (item 7) snug against the load control element (item 5).
Do not over-tighten and use Loctite® to lock the jam nut in place.



PARTS LIST

13	747-075	PULL MANDREL	1
12	747-088	ADAPTER	1
11	P-1423	COMPRESSION SPRING	1
10	747-049	JAW FOLLOWER	1
9	563C35	JAWS SET (3 PCS)	1
8	747-048	COLLET	1
7	671A16	JAM NUT	1
6	P-1437	WASHER	2
5	P-1439	LOAD CONTROL ELEMENT	1
4	747-090	SLEEVE EXTENSION	1
3	P-143	DOWEL PIN	1
2	747-089	SLEEVE	1
1	747-094	NOSEPIECE, INSERT	1
ITEM NUMBER	PART NUMBER	DESCRIPTION	QTY. PER ASSY.

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LUBRIPLATE® is a registered trademark of Fiske Brothers Refining Co.

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



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