

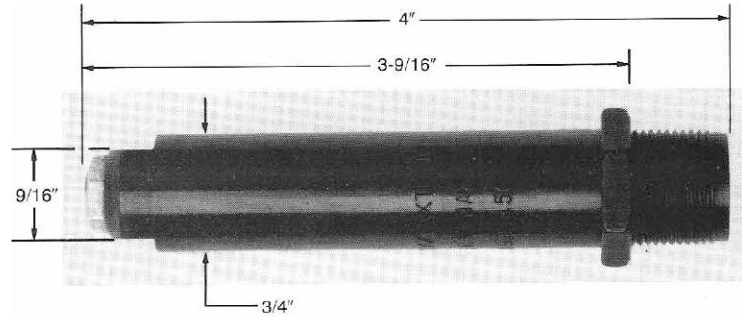
H749A-456

CHERRYMAX® PULLING HEAD

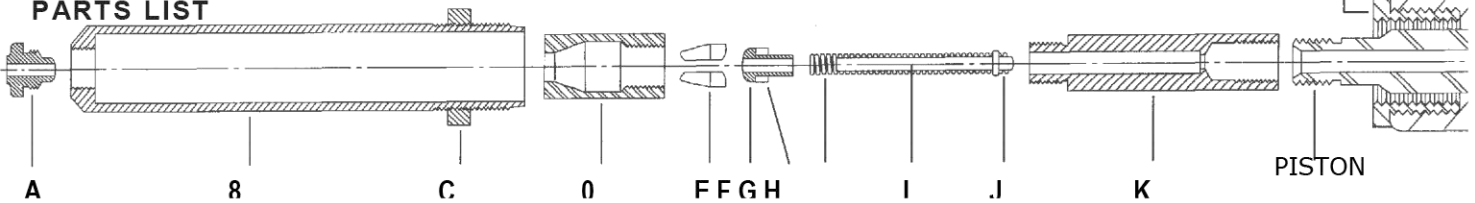
INSTRUCTION SHEET

DESCRIPTION

- The H749A-456 Pulling Head fits directly on G749 model hand riveters.
- It will install Bulbed CherryMAX® and wiredraw CherryMax® "A" rivets 1/8", 5/32" and 3/16" nominal and oversize diameters, in all materials, head styles and grip lengths (wiredraw CherryMax up to 1/2").
- Exceptions: CR4172/73-6 and CR4272/73-6 (not installed by the current pulling head).



PARTS LIST



REF.	PART NO.	DESCRIPTION	QTY. REQ.
A	749A28A	Nosepiece	1
B	749B26A	Sleeve	1
C	671A16	Jam Nut	1
D	701 B29A	Collet	1
E	701B18	Jaws (pair)	1 set
F	753A14A	Jaw Follower	1

REF.	PART NO.	DESCRIPTION	QTY. REQ.
G	701 A33	Bumper	1
H	P-1155	Spring	1
I	749A27	Stem Stop	1
J	P-706	O-Ring	2
K	749A25	Collet Bolt	1

- Slip O-rings (J) over short end of stem stop (I) and spring (H) over long end of stem stop. Place these parts inside collet bolt (K). Slip bumper (G) over jaw follower (F).
- Place jaws (E) and jaw follower (F) inside collet (D) and thread collet to collet bolt (K) (it may be necessary to insert a spent rivet stem in the jaws to guide stem stop (I) into jaw follower (F)).
- Screw collet and collet bolt assembly onto end of drawbolt piston. Tighten securely, with a wrench
- Screw nosepiece (A) into sleeve (B) and thread sleeve into nose fitting of riveter until it bottoms. Tighten jam nut (C) securely.
- In case of damage to the pulling head, dismantle and replace with parts selected from list below.

PREVENTATIVE MAINTENANCE

- Clean the nosepiece, jaw cavity and inspect jaws and spring every 500 installations or whenever a failure occurs; replace the spring and Jaws if worn.
- Lubricate outside configuration of the jaws with Lubriplate® or similar light grease.
- Replace worn or broken components. When re-assembling align the jaws with the jaw follower as shown in the exploded view.
- Use Loctite® 242 (removable) on all threaded components.

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

USATCO U.S. Air Tool Company, Inc.

Info@usatco.com

Eastern Division60 Fleetwood Ct., Ronkonkoma, NY 11779-6907 tel: (631) 471-3300 fax: (631) 471-3308

Western Division1219 W. Mahalo Place, Rancho Dominguez, CA 90220-5446 tel: (310) 632-5400 fax: (310) 632-3900

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