

H750A-456



CHERRY®
AEROSPACE

CherryMax® STRAIGHT PULLING HEAD FOR THE G750A HAND RIVETER

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DIMENSIONAL DATA (SEE FIG. 1)

- Stroke: up to 3/4" (per riveter capability)

CHOICE OF RIVETERS

- The Pulling Head is recommended to be used with the G750A hand riveter.

MOUNTING INSTRUCTIONS (SEE PARTS LIST)

Note: use Loctite® 242 on threaded components.

- Place the compression spring (7) onto the front end to the drawbar. Place the O-ring (6) over the jaw follower (5). Insert the jaw follower subassembly into the front end of the riveter drawbar.

- Lube jaws (4) with Lubriplate® or similar light grease and place in collet (3). Place the return spring of the riveter (P-1315) over collet (3). Thread collet onto riveter drawbar.

Note: Use assembly tool (750-045) from Tool Kit to facilitate installation.

- Caution: Collet must be fully threaded onto the drawbar
- Screw nosepiece (1) into the sleeve (2) and thread into riveter piston.
- TIP: When reattaching the pulling head to the riveter, it is necessary to align the jaws.

To align the jaws:

1. Pump the handle several times.
 2. Place the rivet stem into the H750A-456 pulling head.
- Fully retract the piston while the rivet stem is in the pulling head.



Fig. 1

OPERATING INSTRUCTIONS

Before use, make sure that:

- Pulling Head is correctly mounted on the proper riveter
- Make sure tool is configured to the correct fastener (see Parts List)
- Make sure that the pressure the piston is fully retracted by depressing the return valve on the left side of the tool.
Caution: Jaw damage may result if the piston is not fully retracted before installing a rivet.

During Operation:

- Insert the rivet into the nosepiece of the pulling head, then insert the rivet into the prepared hole.
- Cycle the tool until the rivet stem breaks. TIP: Using short strokes makes it easier to operate the tool.
- Depress the return valve allowing the piston to fully retract, permitting the stem to fall from the front of the tool.
- 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 and make sure that the riveter piston fully returns.
- Should a stem get stuck, use pliers to remove it; if it is a persistent problem, inspect and replace the spring behind the jaws.

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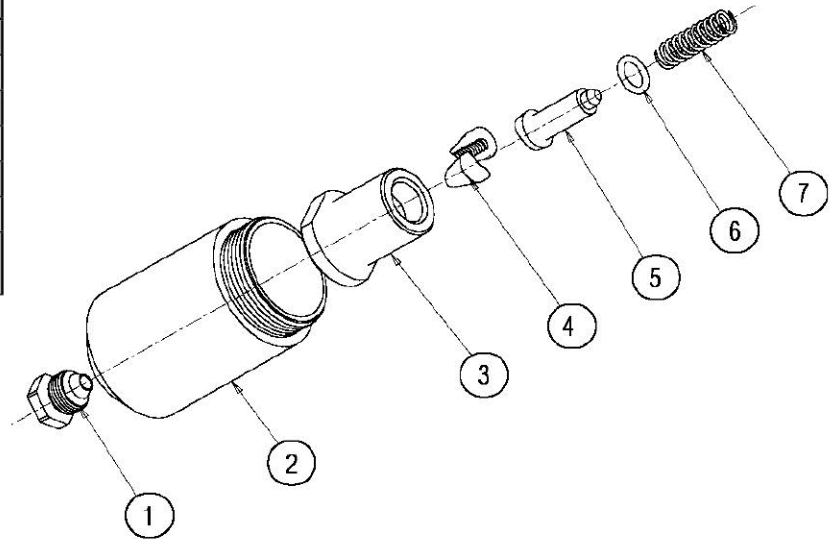
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PARTS LIST

ITEM No	PART NUMBER	DESCRIPTION	QTY.
1	750-019	NOSE PIECE	1
2	750-062	SLEEVE	1
3	750-066	COLLET	1
4	701B18	Jaws (Set of 2)	1 Set
5	750-067	JAW FOLLOWER	1
6	P-832	O-RING	1
7	P-1381	COMPRESSION SPRING	1



PREVENTATIVE MAINTENANCE

- Clean the nosepiece, jaw cavity and inspect jaws and spring every 500 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 4 and 5); see "Mounting Instructions" on the first page.

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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.

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

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