

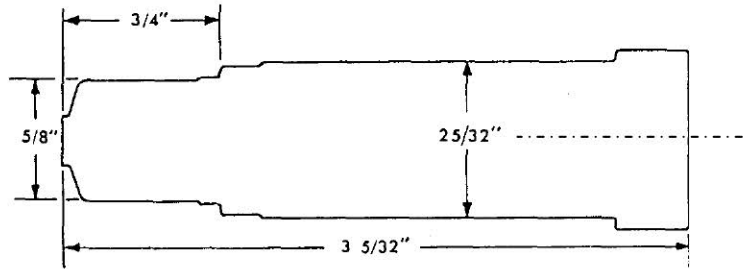
H680B200A PULLING HEAD

INSTRUCTION SHEET

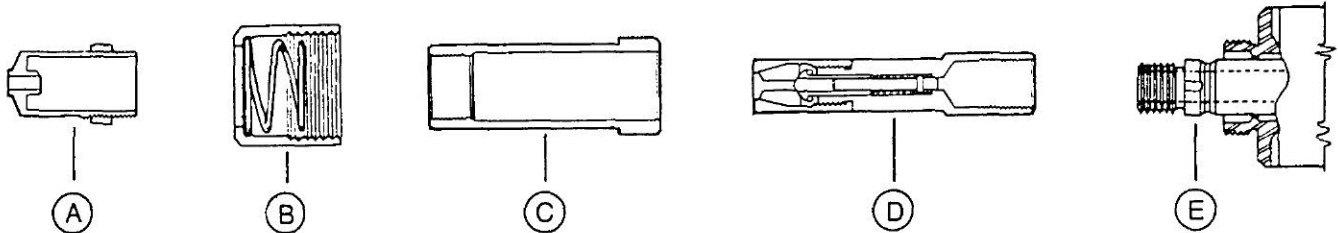


CHERRY[®]
AEROSPACE

- The H680B200A Pulling Head is designed to enable the Cherrylock[®] hydroshift riveting tools, such as G684, G685B-S, G686B-S, G689, G700 and G784 to install CherryMAX[®] rivets.
- The H680B200A Pulling Head will install either head style (universal or countersink) and all diameters of (1/8, 5/32 & 3/16) of CherryMAX[®] rivets.
- The H680B200A Pulling Head fits directly on all Cherrylock[®] hydroshift riveters without the need of an adapter.



Mounting Instructions



1. Remove knurled cap B from front of rivet.
2. Engage collet adapter D internal threads to riveter head piston E .
Rotate until collet adapter bottoms on shoulder of piston. Hand tightening is sufficient.
Jaws and collet assembly are included in the collet adapter.
3. Place sleeve adapter C over collet adapter D and head piston E.
Slip knurled cap B over sleeve adapter and hand tighten onto end of riveter head.
4. Sleeve A with jam nut is then engaged to sleeve adapter C and hand tightened with the jam nut.

USATCO U.S. Air Tool Company, Inc.

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

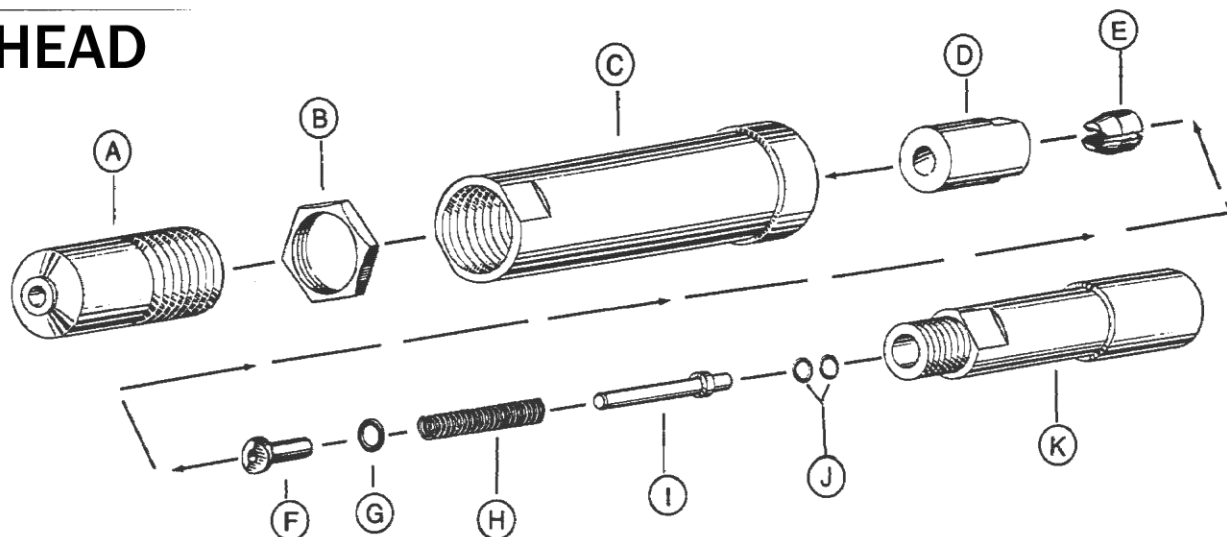
Info@usatco.com

NSN 5130-01-044-7198

H680B200A

PULLING HEAD

INSTRUCTION SHEET



Parts List

Ref.	Part Number	Description	Qty.
A	753B12	Sleeve	1
B	753A-18	Jam Nut	1
C	680B202	Sleeve Adapter	1
D	753A13A	Collet	1
E	701B18	Jaws	1 set
F	753A14A	Jaw Follower	1

Ref.	Part No.	Description	Qty. Req.
G	P-293	O-Ring	1
H	P-1003	Spring	1
I	753A15	Stem Stop	1
J	P-706	O-Ring	2
K	680B201	Collet Adapter	1

PREVENTATIVE MAINTENANCE

- Clean the Nosepiece, Jaw Cavity and inspect Jaws and 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
- 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

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