

# H701B-456

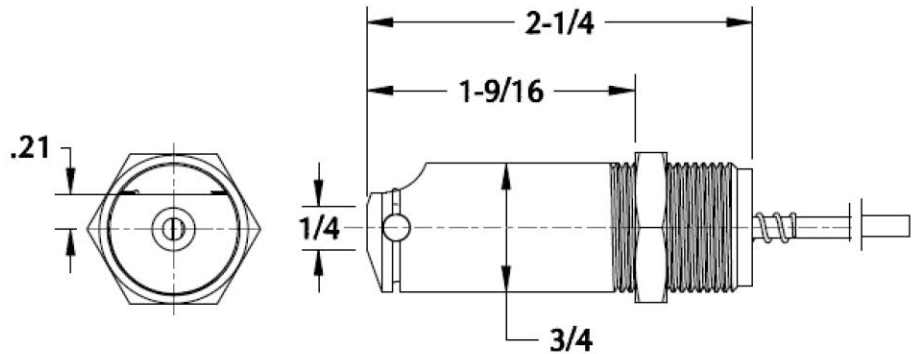
## Straight Pulling Head for CHERRYMAX® fasteners

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Fig. 1. Dimensional Data

#### DIMENSIONAL DATA (see Fig. 1)

- Weight: 0.15 Lbs.



#### CHOICE OF RIVETERS

- G746A (1850 Lbs @ 90 PSI, 7/8" stroke)
- G747 (2100 Lbs @ 90 PSI, 7/16 stroke)
- G704B (3100 Lbs @ 90 PSI, 1/2" stroke)
- G800 (4200 Lbs, 3/4" stroke, hand powered)

#### MOUNTING INSTRUCTIONS

- Attach Riveter to air source; place the spring into the riveter piston
- Carefully thread in and tighten the collet assembly onto the riveter piston
- Thread in the sleeve assy and lock it in by tightening the Jam Nut.

#### JAW ADJUSTMENT

The jaws can be adjusted to hold onto the stem in position at all times or to fully release it before and after fastener installation

- Push the fastener all the way through the nosepiece.
- To *grab onto the stem*: Unthread the sleeve while moving the fastener in and out until you feel the desired jaw hold.
- To release the stem: Thread the sleeve in until the stem is released
- After adjustment, lock in position by tightening the Jam Nut.

#### OPERATING INSTRUCTIONS

Before operating the tool, make sure that:

- Pulling Head is correctly mounted on the proper riveter
- Proper Air source is connected (see Riveter manual for air pressure).
- The Jaw follower must be replaced by the extended one (955-011) when installing 4 diameter fasteners to prevent stem shingling.

#### During Operation:

- 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.

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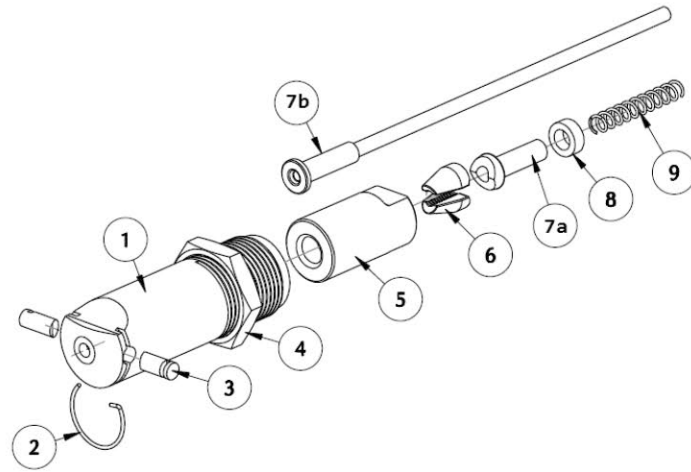
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#### PARTS LIST

ITEM No	PART NUMBER	DESCRIPTION	QTY.
1	701B21	SLEEVE	1
2	701B25	RETAINING SPRING	1
3	701B24	STEM STOP (FINGER)	1
4	671A16	JAM NUT	1
5	701B29A	COLLET	1
6	701B18	JAW SET (2 PCS)	1
7a	753A14A	JAW FOLLOWER	1
7b	955-011	EXTENDED JAW FOLLOWER	1
8	701A33	BUMPER	1
9	P-1155	COMPRESSION SPRING	1



Replace item 7a (753A14A- JAW FOLLOWER) with item 7b (955-011- EXTENDED JAW FOLLOWER) when installing 4 diameter fasteners to prevent stems from shingling inside the pulling head.

#### PREVENTATIVE MAINTENANCE

- Clean and inspect the nosepiece, jaws, collet & 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 (items 6 and 7a).

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