

Right Angle Pulling Head for CherryMAX® fasteners

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

- Tool weight (without riveter): 2.1 Lbs (0.9 Kg)

CHOICE OF RIVETERS

- **G744** Cherry Riveters (no adaptation necessary)
- **G83** or **G84** Riveters with Adapters P/N 744-200

ADAPTOR INSTRUCTIONS

- Remove the bayonet adapter from riveter (if present)
- Thread and tighten adapter 744-200 onto the Pulling Head

MOUNTING INSTRUCTIONS

- Attach riveter to air source for correct piston positioning.
- Push the drawbolt assembly forward (see Figure 1), before mounting
- While holding drawbolt in a forward position, thread the pulling head onto the riveter, making sure that both internal and external threads are connected.
- Use the jam-nut to lock the pulling head in position.
- Cycle the tool to make sure it is functional.

BEFORE USE, CHECK IF:

- The pulling head is correctly mounted and the proper riveter is selected.
- Proper air source is connected (see riveter specification for recommended pressure).
- The appropriate nose piece is used and the tool is clean and in good working condition.
- The jaws provide enough clearance for the stem to fully engage in the tool freely; if the serrated stems get stuck inside of the jaws, the pulling head was mounted on the riveter incorrectly. See "Mounting Instructions".

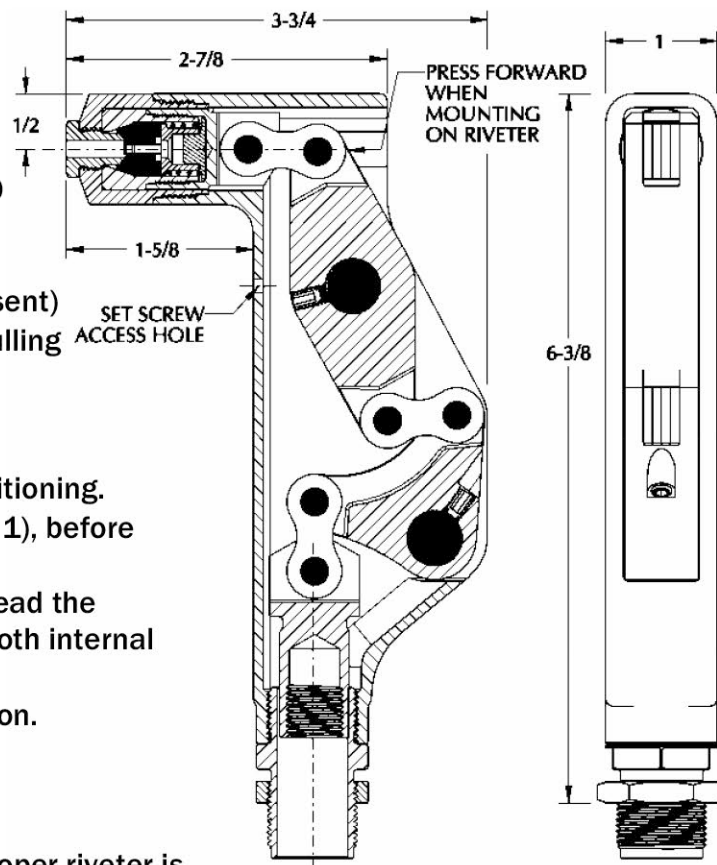
USAGE

- This tool was designed to install "-8" diameter CherryMAX® fasteners.

DURING OPERATION

- Inspect the active area of the nosepiece regularly.
- Remove the broken stem by hand after each installation and dispose of them; if the broken stems get stuck, the jaws do not open enough. Make sure the pulling head is correctly mounted.
- Keep the tool clean, especially the nosepiece and jaws; pay special attention when used with sealants and adhesives.
- If stem slippage occurs, the Jaws need to be either cleaned or replaced.

Figure 1



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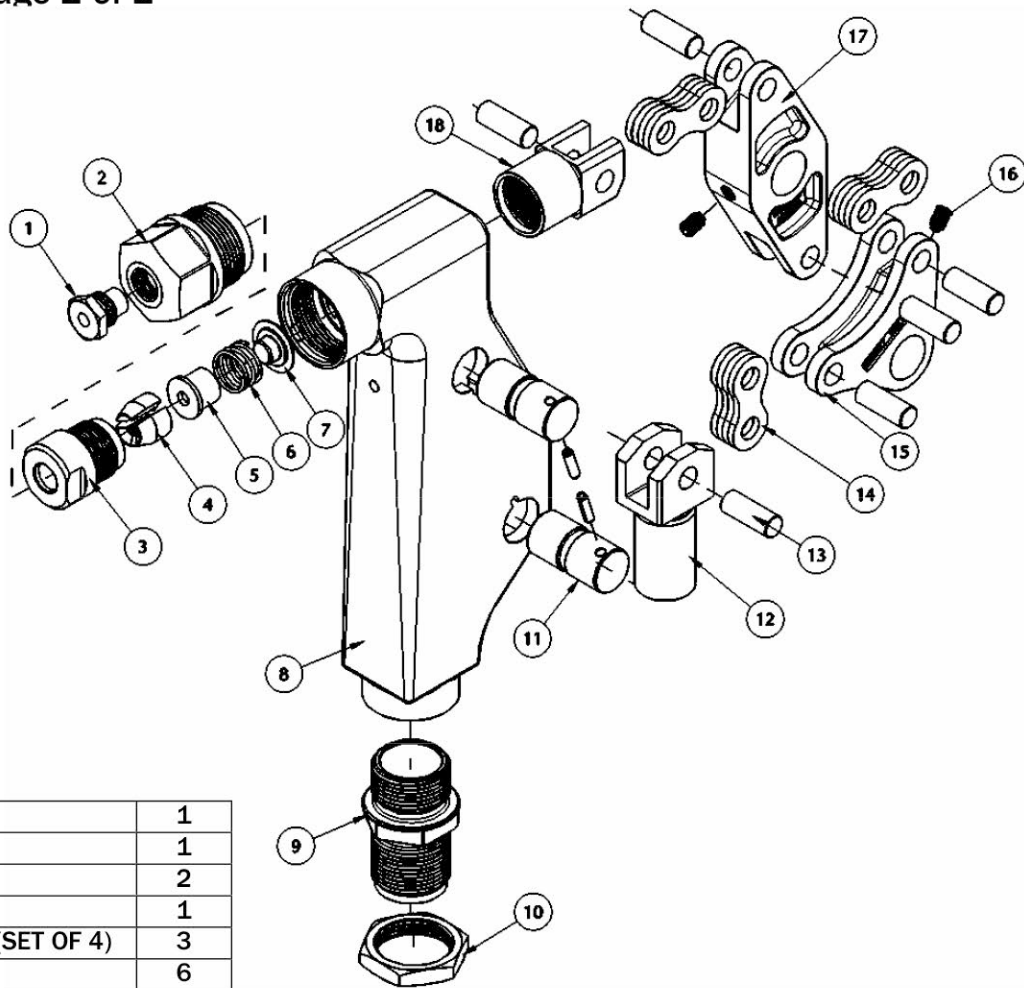
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PREVENTATIVE MAINTENANCE

- Inspect active area regularly and keep it clean, in good condition
- Clean the insert, jaws and jaw cavity inside the collet every 1,000 installations.
- Lubricate outside configuration of the jaws with Lubriplate® or similar light grease.
- Use Loctite® 242 (removable) on threaded components as shown.
- At assembly, thread in the set screws tightly (item 16), then back them off ¼ of a turn.



PARTS LIST

18	828B6	COLLET BOLT	1
17	828B3	LEVER	1
16	P-930	SET SCREW	2
15	828B4	BELL CRANK	1
14	828B15	LINK PLATES (SET OF 4)	3
13	828B14	LINK PIN	6
12	828B5	DRAWBOLT	1
11	828B13	PIVOT PIN ASSEMBLY	2
10	642A64	JAM NUT	1
9	828B7	ADAPTER FITTING	1
8	828B2	FRAME	1
7	828B11	GUIDE BUTTON	1
6	828A12	COMPRESSION SPRING	1
5	828B21	JAW FOLLOWER	1
4	563C35	JAWS (SET OF 3)	1
3	828C9	COLLET	1
2	828C8	SLEEVE	1
1	828C16	-8 NOSEPIECE	1
ITEM NO.	PART NUMBER	DESCRIPTION	QTY. PER ASSY.

LOCTITE® is a registered trademark of Henkel Corporation.
LUBRIPATE® 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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