

H83HL-5MB

PULLING HEAD FOR -5 DIA 130° MAXIBOLT™ TITANIUM FLUSH HEAD

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DIMENSIONAL DATA

(all measurements in Inches, see figure 1)

- Tool Weight (without riveter): .25 Lbs (.113 Kg).

CHOICE OF RIVETERS

- G83 or G84 Cherry® Riveters
- May be used with G84-LS Cherry® split riveters; use with adaptor 744-700.

MOUNTING INSTRUCTIONS

- Attach riveter to air source for correct piston positioning; on the hand riveters, make sure that the pressure has been released and that the correct adaptors are used.
- Push against the riveter piston and thread collet assembly onto the piston.
- Snap sleeve assembly onto riveter bayonet mount.

USAGE

- This tool was designed to install -5 Diameter 130° Titanium Maxibolt™ flush head fasteners (CR7774S-05).

BEFORE USE, MAKE SURE THAT:

- The correct pulling head is used and is properly mounted on the recommended riveter.
- Proper air source is connected (see riveter specification for recommended pressure).
- Make sure that the tool is clean and in good working condition
- Make sure that the nut is snug against the Polyurethane Spring (item 11); do not over-tighten.

DURING OPERATION

- Inspect the active area of the nosepiece regularly.
- Keep the tool clean, especially the nosepiece and jaws; pay special attention when sealants are used.
- If stem slippage occurs, the Jaws need to be either cleaned or replaced.

PREVENTATIVE MAINTENANCE

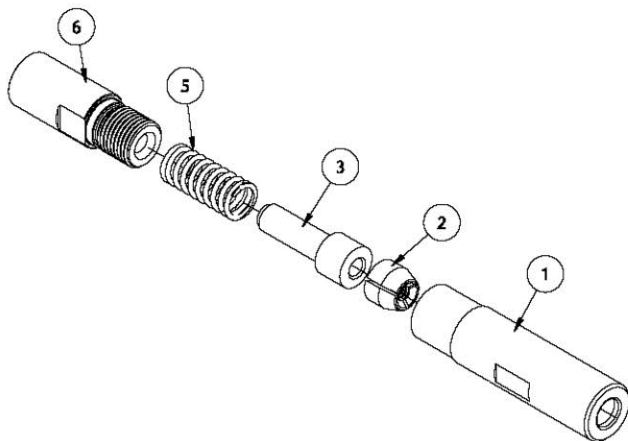
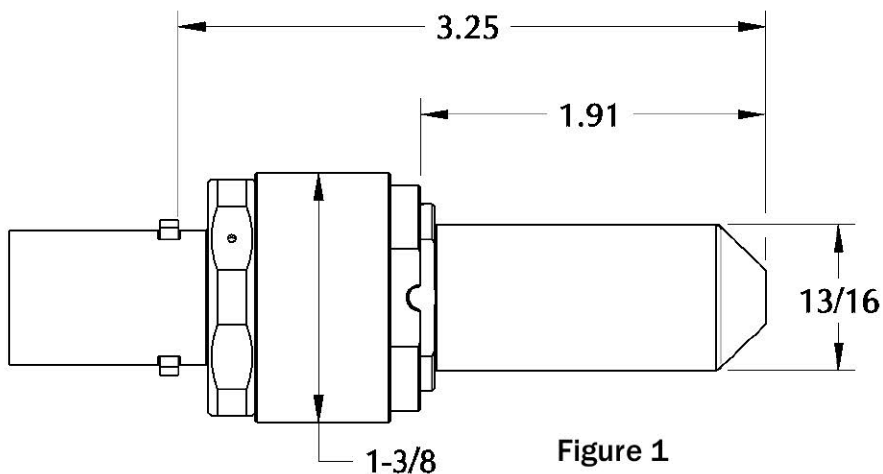
- Clean the Insert, jaws and jaw cavity every 1,000 installations, or whenever failures occurs.
- Lubricate outside configuration of the jaws with Lubriplate® or similar light lubricant.
- Inspect regularly and keep the active area clean and in good working condition.
- Replace worn or broken components.

ASSEMBLY / DISASSEMBLY PROCEDURE

Caution: Use Loctite® 242 on the threaded elements

Collet Assembly

- Grease the tapered area of the Jaws with Lubriplate®. Assemble as shown in the exploded view; make sure the jaws (2) are properly aligned.



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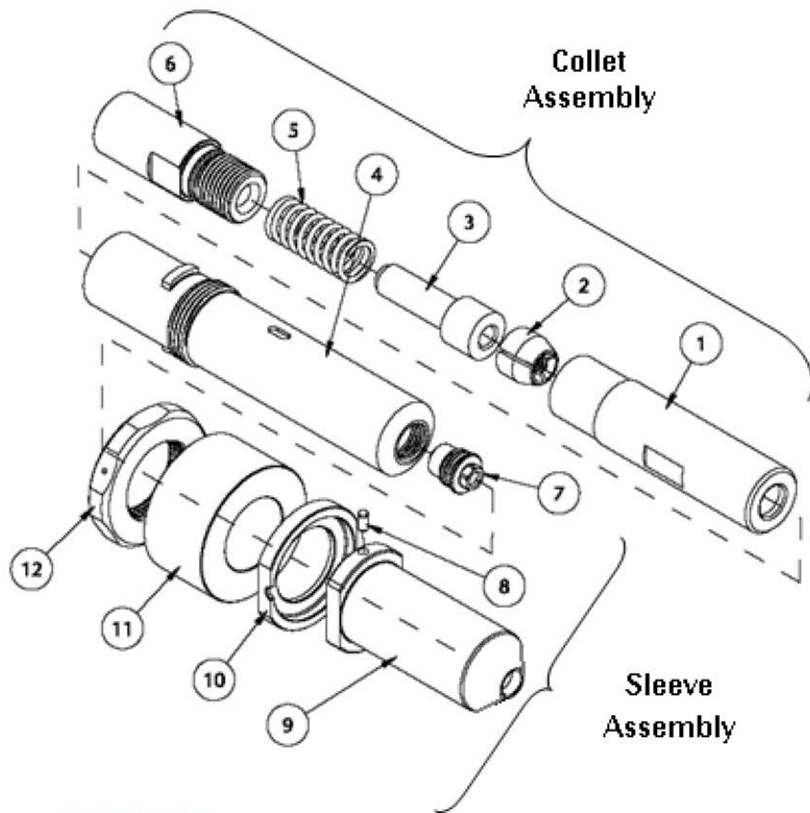
Sleeve Assembly

- Thread nosepiece (7) into sleeve (4).
- Thread load adjustment nut (12) over sleeve (4) as far as it goes.
- Push the polyurethane spring (item 11), retainer washer (item 10) and preload sleeve (item 9) onto the sleeve.
- Insert the collet assembly into the sleeve. Align retainer washer, sleeve and preload sleeve slots and press the dowel pin (8) to the collet inside; do not force. Rotate the retainer washer out of alignment, to prevent the dowel pin from disengaging during use. To disassemble remove the collet from inside and carefully press the dowel pin towards the center to remove it.

Preload Adjustment

- Thread the load adjustment nut (12) hand tight against the polyurethane spring (11) with the help of a wrench;
- To increase the pre-load, tighten the nut (12) against the polyurethane spring (11).
- Caution: if not properly tightened, the preload

element will lose its effectiveness!



PARTS LIST

12	652-074	LOAD ADJUSTMENT JUT	1
11	P-1438	POLYURETHANE SPRING	1
10	652-075	RETAINER WASHER	1
9	652-076	PRELOAD SLEEVE (H83HL-5MB)	1
8	P-1440	DOWEL PIN	1
7	652-071	NOSE PIECE, -5MB	1
6	652-069	DRAWBOLT ADAPTOR	2
5	P-1425	SPRING, COMPRESSION	1
4	652-070	SLEEVE, H83HL & H84HL	1
3	652-031	JAW FOLLOWER	1
2	744C75	JAWS, -5MB	1
1	652-030	COLLET	1
ITEM NUMBER	PART NUMBER	DESCRIPTION	QTY. PER ASSY.

GENERAL / TECHNICAL QUESTIONS

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