R721-3-30
RIVETLESS NUT PLATE REMOVAL TOOL
Technical Data Sheet, Page 1 of 2

DIMENSIONAL DATA (all measurements in Inches, see figure 1)
• Tool Weight (without riveter): 0.4 Lbs (0.181 Kg).

CHOICE OF RIVETERS
• G704B Cherry® Riveter;
• G747 Cherry® Riveter
• G750A Cherry® Hand Riveter
  with adaptor 750A-088;
Note: It may require double triggering when used with G747.

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 pulling head onto both piston and housing of the riveter at the same time.
  -DO NOT tamper with the jam nut, as it controls the removal load.

USAGE
• This tool was designed to remove rivetless nut plate fasteners installed in Ø 0.253/0.249 holes (Ex: CNP03C3, having a #10-32 nut and 0.030” float)

BEFORE USE, MAKE SURE THAT:
• The correct removal tool 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 load control element (item 5); 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 sealants are used.
• If stem slippage occurs, the jaws need to be either cleaned or replaced.

REMOVAL PROCESS

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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.
- At assembly, tighten jam nut (item 7) snug against the load control element (item 5).

Do not overtighten and use Loctite® to lock the jam nut in place.

### PARTS LIST

<table>
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<th>ITEM NUMBER</th>
<th>PART NUMBER</th>
<th>DESCRIPTION</th>
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<td>747-076</td>
<td>REACTION CUP</td>
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<td>747-075</td>
<td>PULL MANDREL</td>
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<td>P-1423</td>
<td>COMPRESSION SPRING</td>
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<td>747-077</td>
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### GENERAL / TECHNICAL QUESTIONS

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

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