H83HL-5MB
PULLING HEAD FOR -5 DIA 130° MAXIBOLT™ TITANIUM FLUSH HEAD
Technical Data Sheet, Page 1 of 2

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 bayonnet 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.
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 loose its effectiveness!

GENERAL / TECHNICAL QUESTIONS
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<th>ITEM</th>
<th>PART NUMBER</th>
<th>DESCRIPTION</th>
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<td>652-075</td>
<td>RETAINER WASHER</td>
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<tr>
<td>11</td>
<td>P-1438</td>
<td>POLYURETHANE SPRING</td>
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<tr>
<td>12</td>
<td>652-074</td>
<td>LOAD ADJUSTMENT JUT</td>
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<td>9</td>
<td>652-076</td>
<td>PRELOAD SLEEVE (H83HL-5MB)</td>
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<td>8</td>
<td>P-1440</td>
<td>DOWEL PIN</td>
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<td>7</td>
<td>652-071</td>
<td>NOSE PIECE, -5MB</td>
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<td>6</td>
<td>652-069</td>
<td>DRAWBOLT ADAPTOR</td>
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<td>5</td>
<td>P-1425</td>
<td>SPRING, COMPRESSION</td>
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<td>4</td>
<td>652-070</td>
<td>SLEEVE, H83HL &amp; H84HL</td>
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<tr>
<td>3</td>
<td>652-031</td>
<td>JAW FOLLOWER</td>
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<tr>
<td>2</td>
<td>744C75</td>
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<tr>
<td>1</td>
<td>652-030</td>
<td>COLLET</td>
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