R721-5-60
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: May require double triggering when used with G747.

MOUNTING INSTRUCTIONS
- Attach rivet 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 0.404/0.408 holes

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
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

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<th>DESCRIPTION</th>
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<td>REACTION CUP</td>
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GENERAL / TECHNICAL QUESTIONS

1224 E. Warner Avenue
Santa Ana, CA 92705 USA
1-714-850-6022 (Phone)
1-714-850-6093 (Fax)

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

USATCO U.S. Air Tool Company, Inc. Info@usatco.com
Eastern Division ..................................60 Fleetwood Crt., Ronkonkoma, NY 11779-6907 tel: (631) 471-3300 fax: (631) 471-3308
Western Division ................................1219 W. Mahalo Place, Rancho Dominguez, CA 90220-5446 tel: (310) 632-5400 fax: (310) 632-3900

TS-H721-5-60 Rev: A Date: 02/05/07 CR: 07-0097