Right Angle Pulling Head for BlindBolt® (MaxiBolt®) fasteners

TECHNICAL DATA SHEET, Page 1 of 2

DIMENSIONAL DATA (all measurements in Inches, see Figure 1)
- Tool Weight (without riveter): 2.1 Lbs (0.9 Kg)

CHOICE OF RIVETERS
- G744 Cherry® riveter (no adaptation necessary)
- G83 or G84 riveters with adapter 744-200

ADAPTOR INSTRUCTIONS
- Remove the Bayonet Mount from riveter (if present)
- Thread and tighten adapters P/N 744-200 onto the Pulling Head

MOUNTING INSTRUCTIONS
- Attach the 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 (“U” or “S” type – see component table).
- The tool is clean and in good working condition.
- The jaws provide enough clearance for the Blind Bolt® serrated area 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 “-5” diameter Blind Bolt® (MaxiBolt®) 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.
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 1/4 of a turn.

PARTS LIST

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<tr>
<th>ITEM NO.</th>
<th>PART NUMBER</th>
<th>DESCRIPTION</th>
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<td>COLLET BOLT</td>
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<td>17</td>
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TS-H828-5MB, Rev. B, Date: 12/14/07, DCR: 07-1472