

H746 Series

Straight Pulling Head for standard MBC blind rivets

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DIMENSIONAL DATA (see Fig. 1)

- Weight: 0.2 Lbs

CHOICE OF RIVETERS

- Use with the following Cherry Riveters:
G747: compact, light weight,
2200 Lbs force; **7/16"** stroke,
G704B: **3100 Lbs** force; **1/2"** stroke
G746A: **1850 Lbs** force; **7/8"** stroke

MOUNTING INSTRUCTIONS (see Fig 2)

- Attach Riveter to air source; place the spring into the riveter piston
- Thread and tighten the collet assembly onto the riveter piston
- Thread in the sleeve assy and lock it in by tightening the Jam Nut.

USAGE (each pulling head is sold separately):

H746-4MBC Pulling Head installs **1/8"** Standard MBC
H746-5MBC Pulling Head installs **5/32"** Standard MBC
H746-6MBC Pulling Head installs **3/16"** Standard MBC

JAW ADJUSTMENT

The jaws can be adjusted to hold onto the stem in position at all times or to fully release it before and after fastener installation

- Push the fastener all the way through the nose piece.
- *To grab onto the stem:* Unthread the sleeve while moving the fastener in and out until you feel the desired jaw hold.
- *To release the stem:* Thread the sleeve in until the stem is released
- After adjustment, lock in position by tightening the Jam Nut.

OPERATING INSTRUCTIONS

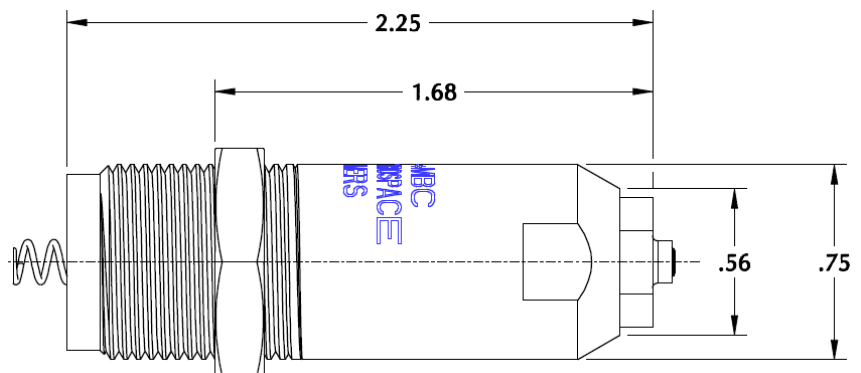
Before operating the tool, make sure that:

- Pulling head is correctly mounted on the proper riveter
- Proper air source is connected (see riveter manual for air pressure).
- Make sure that a proper nose piece, jaw and jaw follower are used; see table 1 for selection and fastener capability.

During Operation:

- Inspect the active area of the nosepiece regularly.
- Keep the tool clean, especially the nosepiece and jaws; pay special attention when sealants and adhesives are used.
- If stem slippage occurs, clean or replace the jaws.

Fig 1. Dimensional Data



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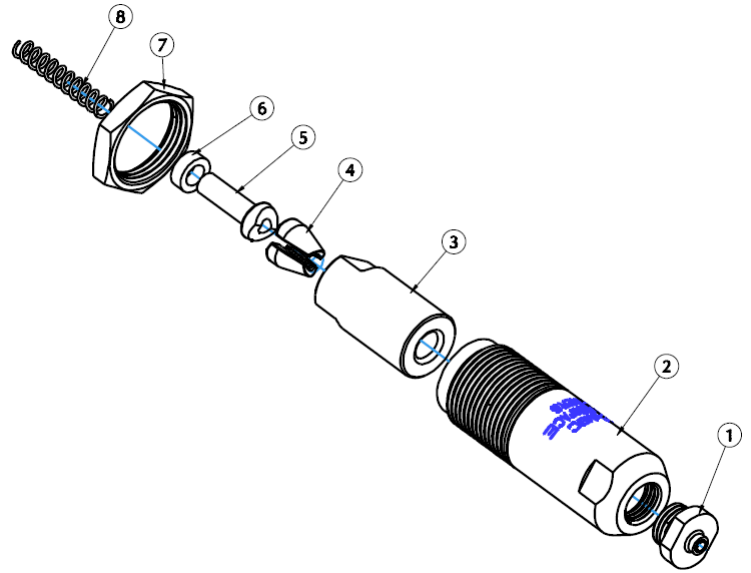
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PARTS LIST

ITEM No	PART NUMBER	DESCRIPTION	QTY.
1	TABLE	Nosepiece	1
2	TABLE	Sleeve	1
3	701B29A	Collet	1
4	701B18	Jaw Set	1
5	753A14A	Jaw Follower	1
6	701A33	Bumper	1
7	671A16	Jam Nut	1
8	P-1155	Compression Spring	1



PULLING HEAD ASSY NO.	NOSEPIECE	SLEEVE
ITEM NO	1	2
H746-4MBC	845-032	845-031-4
H746-5MBC	845-028	845-031-5
H746-6MBC	845-029	845-031-6

PREVENTATIVE MAINTENANCE

- Clean and inspect the nosepiece, jaws, collet & spring every 1000 installations or whenever a failure occurs; replace spring and jaws if worn.
- Lubricate outside configuration of the jaws with Lubriplate® or similar light grease.
- Inspect regularly and keep active area clean and in good working condition.
- Replace worn or broken components.
- When re-assembling align the jaws with the jaw follower as shown in the exploded view (items 4 and 5); use Loctite® 242 (removable) on all threaded components except as shown.

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WARRANTY

Seller warrants the goods conform to applicable specifications and drawings and will be manufactured and inspected according to generally accepted practices of companies manufacturing industrial or aerospace fasteners. In the event of any breach of the foregoing warranty, Buyer's sole remedy shall be to return defective goods (after receiving authorization from Seller) for replacement or refund of the purchase price, at the Seller's option. Seller agrees to any freight costs in connection with the return of any defective goods, but any costs relating to removal of the defective or nonconforming goods or installation of replacement goods shall be Buyer's responsibility. SELLER'S WARRANTY DOES NOT APPLY WHEN ANY PHYSICAL OR CHEMICAL CHANGE IN THE FORM OF THE PRODUCT IS MADE BY BUYER. THE FOREGOING EXPRESS WARRANTY AND REMEDY ARE EXCLUSIVE AND ARE IN LIEU OF ALL OTHER WARRANTIES AND REMEDIES; ANY IMPLIED WARRANTY AS TO QUALITY, FITNESS FOR PURPOSE, OR MERCHANTABILITY IS HEREBY SPECIFICALLY DISCLAIMED AND EXCLUDED BY SELLER. This warranty is void if seller is not notified in writing of any rejection of the goods within ninety (90) days after receipt of the goods by buyer.

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



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