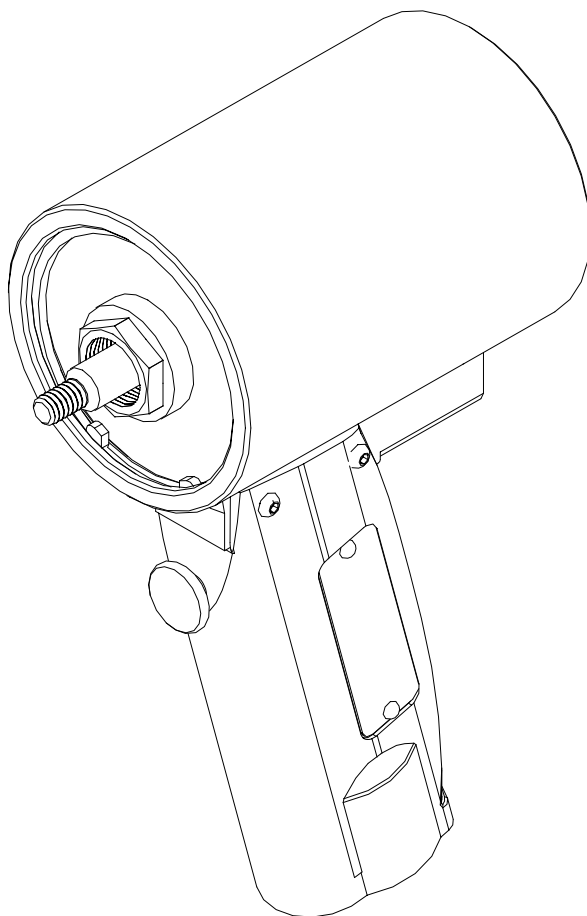


GB50

PNEUMATIC INSTALLATION TOOL



GAGE BILT
MADE IN U.S.A.

GAGE BILT PRODUCTS CORP.

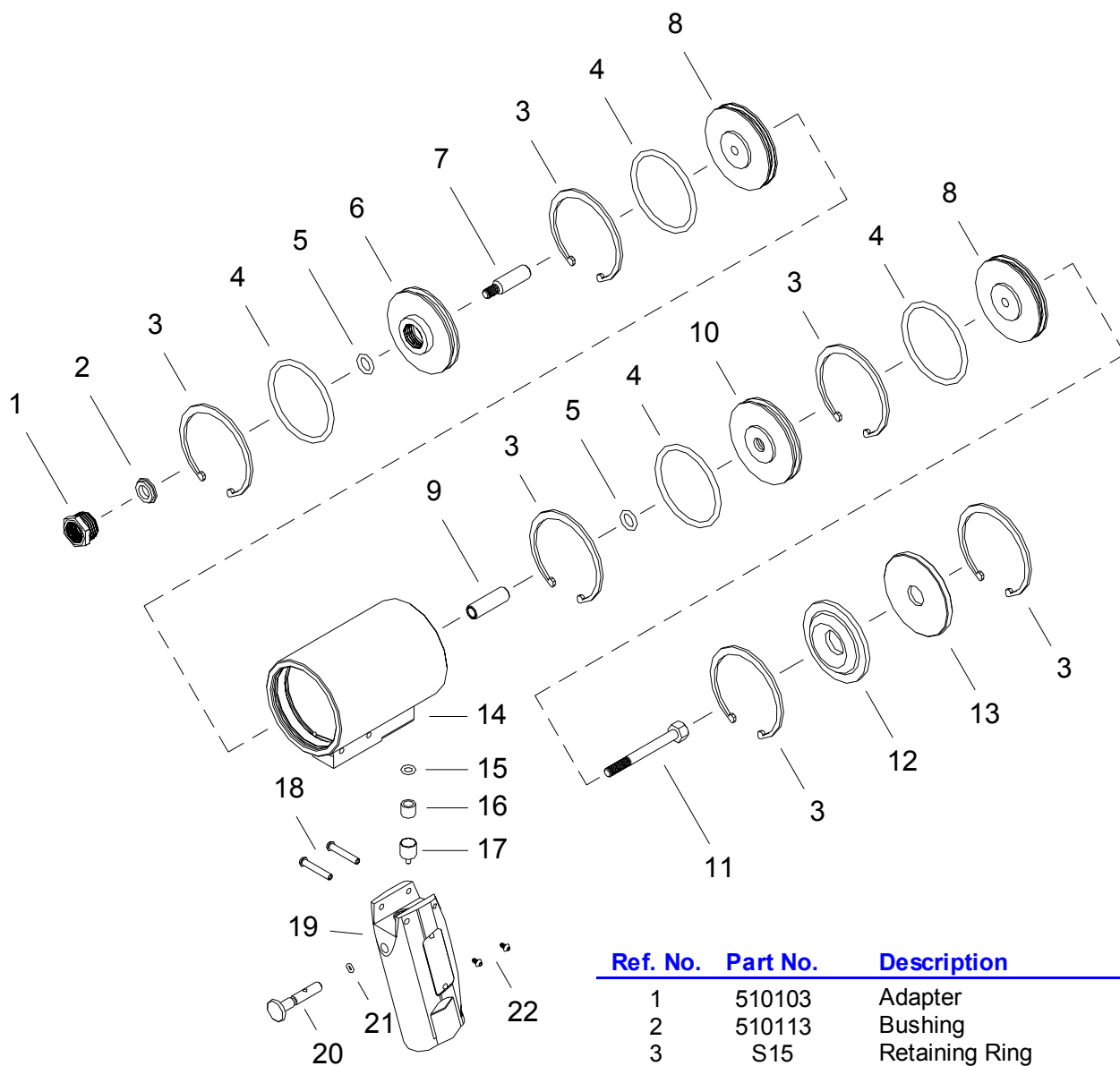
14500 Barber Drive

Warren, Mi 48088

(586) 771-7664

(586) 771-2665 Fax

e-mail: solutions@gagebilt.com / www.gagebilt.com



Ref. No.	Part No.	Description	Qty.
1	510103	Adapter	1
2	510113	Bushing	1
3	S15	Retaining Ring	6
4	400858	O'Ring	4
5	400807	O'Ring	2
6	510119	Front Seal	1
7	510117	Drawbolt	1
8	510101	Piston	2
9	510104	Sleeve	1
10	510102	Divider	1
11	500120	Connector Bolt	1
12	510114	Cushion	1
13	510118	Back Cap	1
14	500119	Cylinder Assembly	1
15	400782	O'Ring	1
16	510105	Seal	1
17	510125	Seat	1
18	510215	Dowel Screw	2
19	510320	Handle	1
20	510107	Trigger	1
21	400772	O'Ring	1
22	A-819	Button Head Screw	2

GB50 SELECTION CHART

FASTENER	DIA.	STRAIGHT	RIGHT ANGLE ¹	OFFSET
MS20600 SERIES MS/9SP/PT	3/32 1/8 5/32 ₃	3C-715A-43 4C-715A-43 5C-715A-43	3C-715B-44RA 4C-715B-44RA 5C-715B-44RA	3C-715-40OS 4C-715-40OS 5C-715-40OS
NUT PLATE RIVETS BACR15CC/CF/DA/DR	3/32 1/8	3NP-715A-43 4NP-715A-43	3NP-715B44RA 4NP-715B-44RA	3NP-715-40OS 4NP-715-40OS
"A" CODE NAS1398A, NAS1399A NAS1738A, NAS1739A	3/32 1/8 5/32 ₃	3A-715A-43 4A-715A-43 5A-715A-43	3A-715B-44RA 4A-715B-44RA 5A-715B-44RA	3A-715-40OS 4A-715-40OS 5A-715-40OS
NAS1919S & 1921S	1/8 5/32 ₃	SMLS04-715A-43 SMLS05-715A-43	SMLS05-715B-44RA SMLS05-715B-44RA	SMLS04-715A-40OS SMLS05-715A-40OS
UNIMATIO® SINGLE ACTION NAS1919U & NAS1621U NAS9301-NAS9312 BACR14FP/FR & BACR15GF/GK	1/8 5/32 ₃	UBR04-715A-43 UBR05-715A-43	UBR04-715-54RA UBR05-715-54RA	UBR04-715-40OS UBR05-715-40OS
NAS1919U & 1921U	1/8 5/32 ₃	456MAX-715-43 ₂	456MAX-715-54RA ₂	456MAX-715-40OS ₂
N, Q & E POP®, CLOSED END AVEX® & COMMERCIAL RIVETS	3/32 1/8 ₄ 5/32 ₃	3N-715E-43 4N-715E-43 5N-715E-43	3N-715-54RA 4N-715-54RA 5N-715-54RA	3N-715-40OS 4N-715-40OS 5N-715-40OS

THE GAGE BILT GB50 TOOL IS APPROVED TO INSTALL THE ABOVE FASTENERS.

- | |
|---|
| 1) RIGHT ANGLE NOSE ASSEMBLYS MAY REQUIRE MORE THAN ONE PULL. |
| 2) INSTALLS 1/8 & 5/32 DIAMETERS. |
| 3) ALUMINUM ONLY. |
| 4) ALUMINUM & STEEL ONLY. |

NOTE: THE LAST 2 DIGITS OF THE NOSE ASSEMBLY REPRESENTS THE LENGTH THE NOSE
EXTENDS FROM THE TOOL I.E. -20 = 2.0 INCHES

WARRANTY

Seller warrants that all goods covered by this catalog will conform to applicable specifications and will replace, or repair, F.O.B. our plant, any goods providing defective from faulty workmanship, or material, for 90 days from date of shipment.

Said warranty to remain in effect if and only if such goods are used in accordance with all instructions as to maintenance, operation, and use set forth in manuals and instruction sheets furnished by seller.

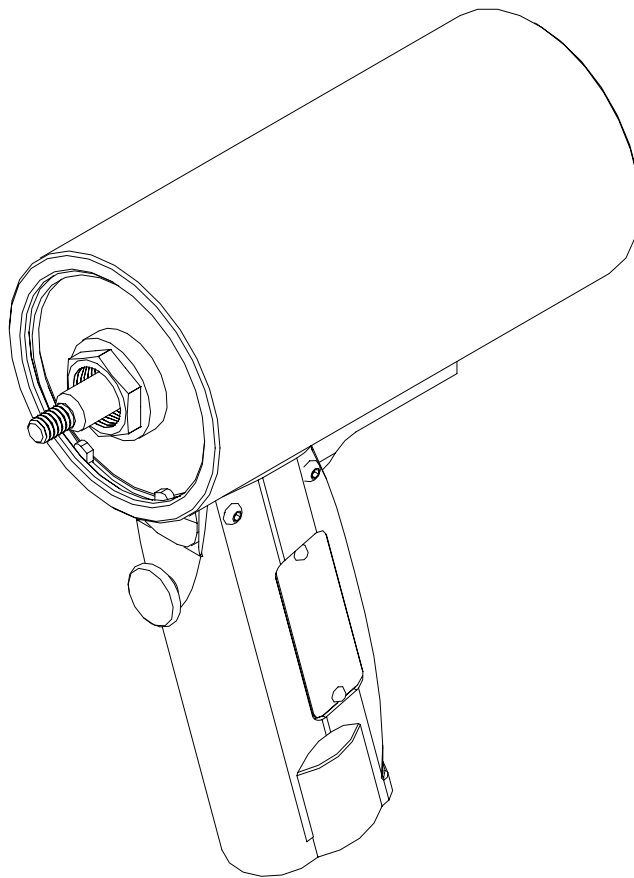
Sellers obligation under this warranty shall be limited to the repair or rework of the goods supplied or replacement thereof, at Seller's option, and in no case is to exceed the invoice value of said goods. Under no circumstances will seller be liable for incidental or consequential damages or for damages incurred by the buyer or subsequent user in repairing or replacing defective goods or if the goods covered by this warranty are reworked or subjected to any type of additional processing.

This warranty is void if Seller is not notified in writing of any rejections or defects within 90 days after the receipt of the material by the customer.

THIS WARRANTY IS MADE IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY.

GB51

PNEUMATIC INSTALLATION TOOL



GAGE BILT
MADE IN U.S.A.

GAGE BILT PRODUCTS CORP.

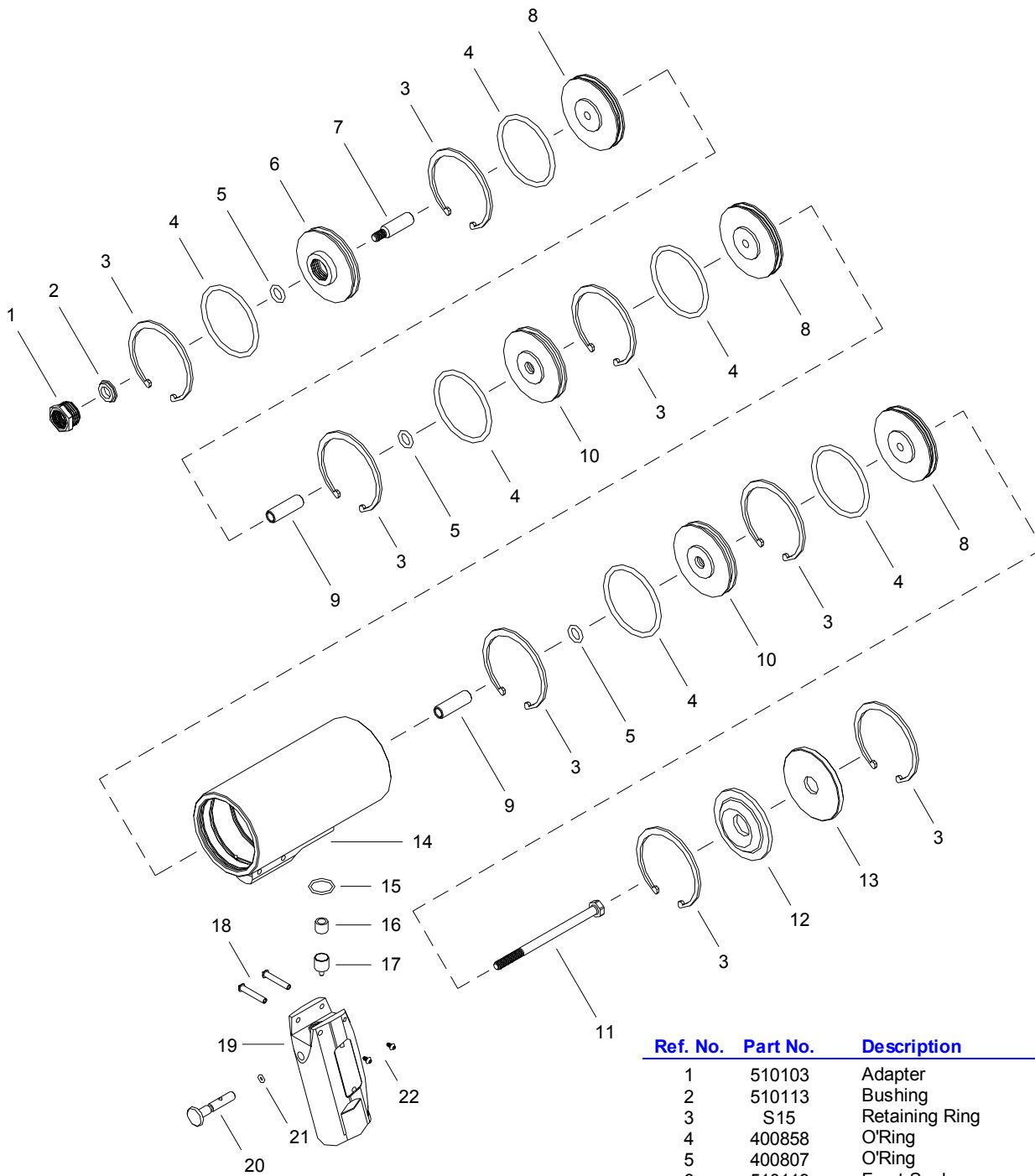
14500 Barber Drive

(586) 771-7664

Warren, Mi 48088

(586) 771-2665 Fax

e-mail: solutions@gagebilt.com / www.gagebilt.com



Ref. No.	Part No.	Description	Qty.
1	510103	Adapter	1
2	510113	Bushing	1
3	S15	Retaining Ring	8
4	400858	O'Ring	6
5	400807	O'Ring	3
6	510119	Front Seal	1
7	510117	Drawbolt	1
8	510101	Piston	3
9	510104	Sleeve	2
10	510102	Divider	2
11	S17	Connector Bolt	1
12	510114	Cushion	1
13	510118	Back Cap	1
14	510121	Head Assembly	1
15	400782	O'Ring	1
16	510105	Seal	1
17	510125	Seat	1
18	510215	Dowel Screw	2
19	510320	Handle	1
20	510107	Trigger	1
21	400772	O'Ring	1
22	A-819	Button Head Screw	2

GB51 SELECTION CHART

FASTENER	DIA.	STRAIGHT	RIGHT ANGLE ¹	OFFSET
MS20600 SERIES MS/9SP/PT BACR15CC/CF/DA/DR	3/32	3C-715A-43	3C-715B-44RA	3C-715-40OS
	1/8	4C-715A-43	4C-715B-44RA	4C-715-40OS
	5/32 ₃	5C-715A-43	5C-715B-44RA	5C-715-40OS
	3/16 ₃	6C-715A-43	6C-715B-44RA	6C-715-40OS
NUT PLATE RIVETS	3/32	3NP-715A-43	3NP-715B-44RA	3NP-715-40OS
	1/8	4NP-715A-43	4NP-715B-44RA	4NP-715-40OS
"A" CODE NAS1398A, NAS1399A NAS1740A, NAS1739A	3/32	3A-715A-43	3A-715B-44RA	3A-715-40OS
	1/8	4A-715A-43	4A-715B-44RA	4A-715-40OS
	5/32 ₃	5A-715A-43	5A-715B-44RA	5A-715-40OS
	3/16 ₅	6A-715A-43	6A-715B-44RA	6A-715-40OS
NAS1919S & 1921S	1/8	SMLS04-715A-43	SMLS04-715B-44RA	SMLS04-715A-40OS
	5/32 ₃	SMLS05-715A-43	SMLS05-715B-44RA	SMLS05-715A-40OS
	3/16 ₃	SMLS06-715A-43	SMLS06-715B-44RA	SMLS06-715A-40OS
UNIMATIC® SINGLE ACTION NAS1919U & NAS1621U NAS9301-NAS9312 BACR14FP/FR & BACR15GF/GK	1/8	UBR04-715A-43	UBR04-715-54RA	UBR04-715-40OS
	5/32 ₃	UBR05-715A-43	UBR05-715-54RA	UBR05-715-40OS
	3/16 ₃	UBR06-715A-43	UBR06-715-54RA	UBR06-715-40OS
NAS1919U & 1921U	1/8	456MAX-715-43 ₂	456MAX-715-54RA ₂	456MAX-715-40OS ₂
	5/32 ₃			
	3/16 ₃			
N, Q & E POP®, CLOSED END AVEX® & COMMERCIAL RIVETS	3/32	3N-715E-43	3N-715-54RA	3N-715-40OS
	1/8	4N-715E-43	4N-715-54RA	4N-715-40OS
	5/32 ₃	5N-715E-43	5N-715-54RA	5N-715-40OS
	3/16 ₃	6N-715E-43	6N-715-54RA	6N-715-40OS

THE GAGE BILT GB51 TOOL IS APPROVED TO INSTALL THE ABOVE FASTENERS.

1) RIGHT ANGLE NOSE ASSEMBLYS MAY REQUIRE MORE THAN ONE PULL.
2) INSTALLS 1/8, 5/32 & 3/16 DIAMETERS.
3) ALUMINUM ONLY.
4) ALUMINUM & STEEL ONLY.
5) SELF-PLUGGING ALUMINUM ONLY
*ALL COUNTERSUNK 'C' NOSE ASSEMBLIES MAY BE USED TO INTSALL BOTH UNIVERSAL & COUNTERSUNK HEAD RIVETS

NOTE: THE LAST 2 DIGITS OF THE NOSE ASSEMBLY REPRESENTS THE LENGTH THE NOSE EXTENDS FROM THE TOOL I.E. -20 = 2.0 INCHES

WARRANTY

Seller warrants that all goods covered by this catalog will conform to applicable specifications and will replace, or repair, F.O.B. our plant, any goods providing defective from faulty workmanship, or material, for 90 days from date of shipment.

Said warranty to remain in effect if and only if such goods are used in accordance with all instructions as to maintenance, operation, and use set forth in manuals and instruction sheets furnished by seller.

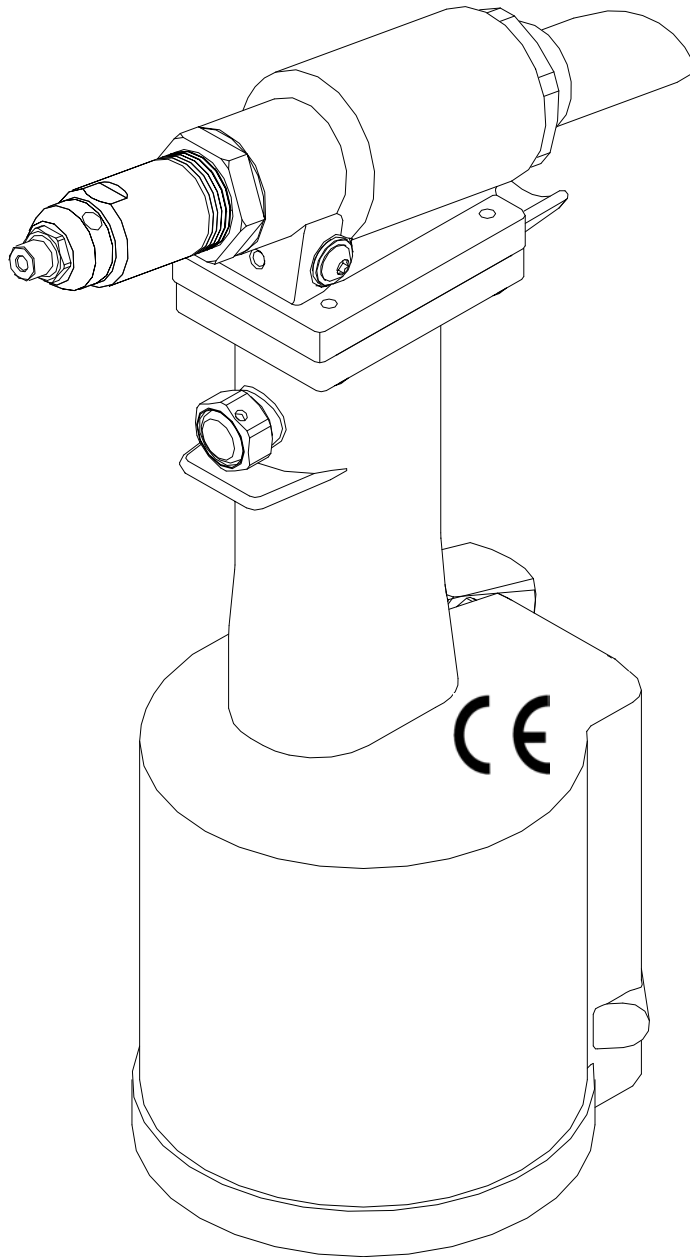
Sellers obligation under this warranty shall be limited to the repair or rework of the goods supplied or replacement thereof, at Seller's option, and in no case is to exceed the invoice value of said goods. Under no circumstances will seller be liable for incidental or consequential damages or for damages incurred by the buyer or subsequent user in repairing or replacing defective goods or if the goods covered by this warranty are reworked or subjected to any type of additional processing.

This warranty is void if Seller is not notified in writing of any rejections or defects within 90 days after the receipt of the material by the customer.

THIS WARRANTY IS MADE IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY.

GBP703D

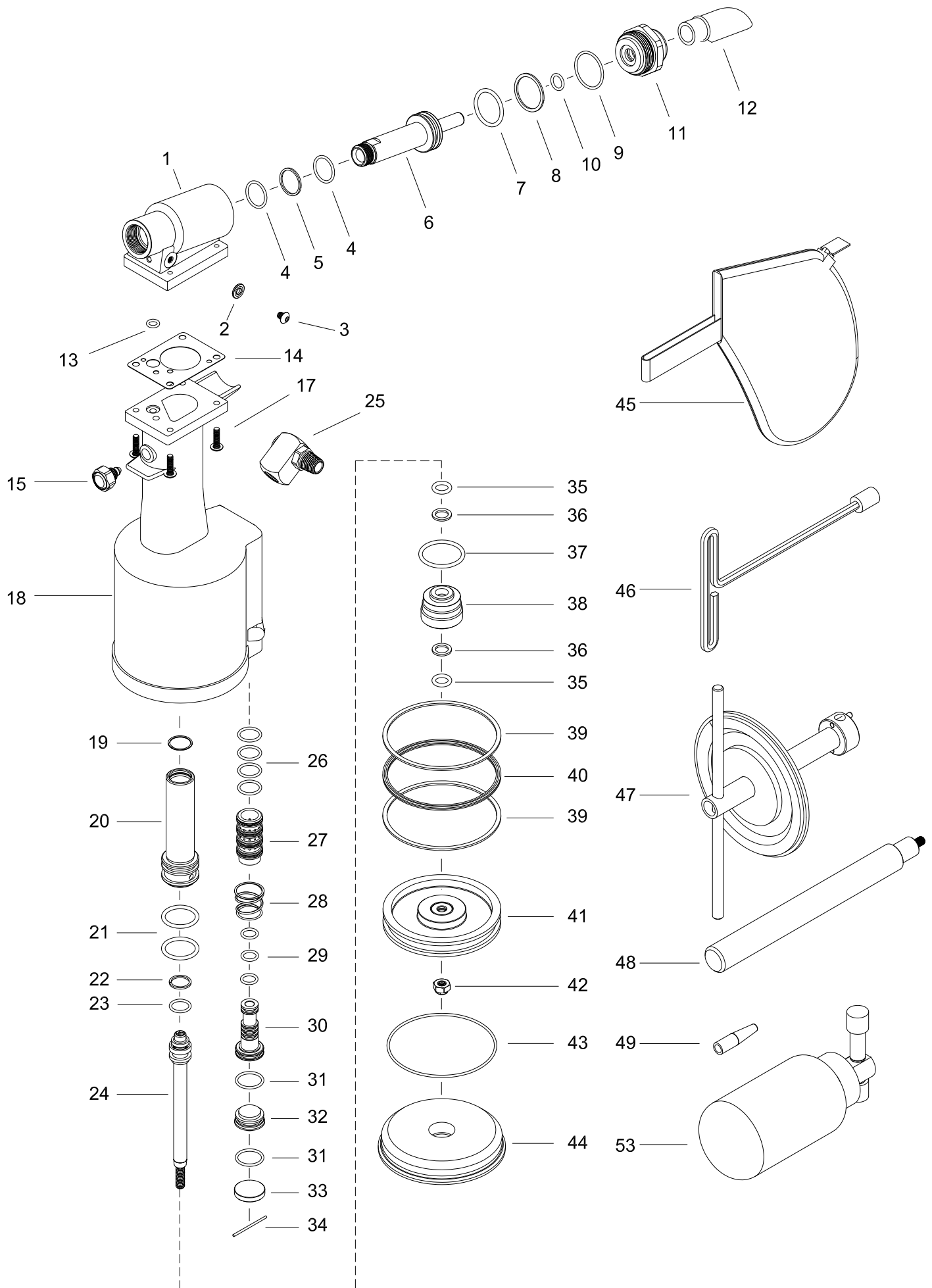
INSTALLATION TOOL



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14500 Barber Drive (586) 771-7664
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e-mail: solutions@gagebilt.com / www.gagebilt.com



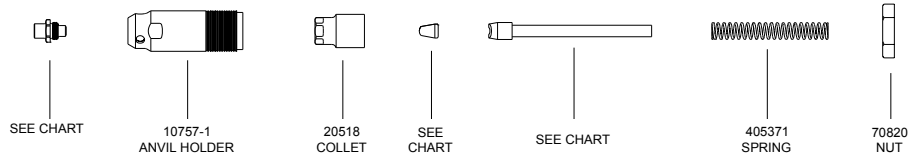
GBP703D Parts List

Ref. No.	Part No.	Description	Qty.
1	703109	Head-Cylinder Assembly	1
2*	S572	Stat-O-Seal	1
3*	402482	Button Head Socket Screw	1
4*	S834	O'Ring	2
5*	401089	Back-Up Ring	1
6	703307	Piston	1
7*	405891	O'Ring	1
8*	401110	Back-Up Ring	1
9*	400788	O'Ring	1
10*	S829	O'Ring	1
11	703114	Cap	1
12	200232	Deflector	1
13*	S832	O'Ring	1
14*	704129	Gasket	1
15	704130	Trigger Assy. (Inc. 400773)	1
16*	400773	O'Ring	1
17*	A-928	Button Head Cap Screw	4
18	704132	Handle	1
19*	S734	Reataining Ring	1
20	751131	Power Cylinder	1
21*	403805	O'Ring	2
22*	401102	Back-Up Ring	1
23*	S945	O'Ring	1
24	704138	Piston Rod Assy. (Inc 22 & 23)	1
25	A-249	Swivel	1
26*	400781	O'Ring	4
27	703139	Valve Sleeve	1
28*	704141	Spring	1
29*	400778	O'Ring	3
30	703142	Valve Spool Assembly	1
31*	400783	O'Ring	2
32	704145	Valve Plug	1
33*	704146	Muffler	1
34*	704244	Pin	1
35*	A-287	O'Ring	2
36*	S115	Back-Up Ring	2
37*	405757	O'Ring	1
38	704118	Packing Plug	1
39*	S731	Back-Up Ring	2
40*	S730	Quad Ring	1
41	704121	Air Piston Assembly	1
42*	400559	Flexlock Nut	1
43*	S725	O'Ring	1
44	704125	Base Cover	1
45**	704214	Stem Catcher Bag	1
46**	704149	Piston Rod Wrench	1
47**	704150	Packing Plug Wrench	1
48**	704151	Power Cylinder Tool	1
49**	704152	Seal Guide	1
50**	S1178	Valve Plug Extractor	1
51**	704162	Valve Spring Installation Tool (Not Shown)	1
52**	704163	Valve Sleeve Removal Tool (Not Shown)	1
53**	704153	Air Bleeder	1

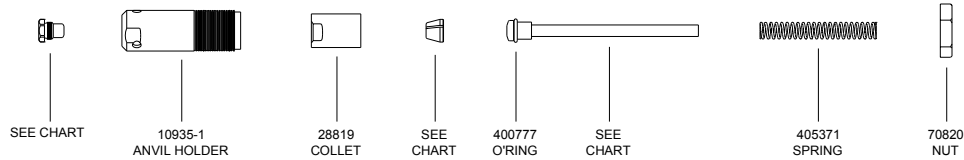
*Service Kit 703023 contains a complete set of O'Rings, Back-Up Rings, Wipers, Screws and Gaskets. These items should be kept on hand at all times.

**Ref. No.45-53 are not furnished with the tool, but are recommended for complete tool overhaul.

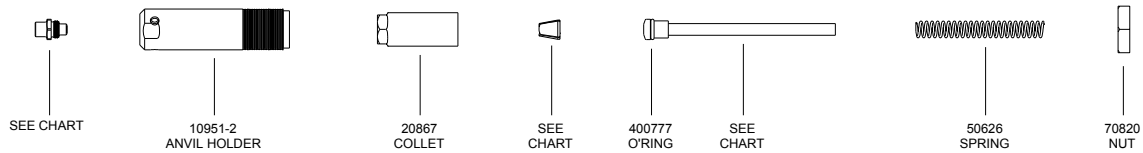
XX-703-18



XX-734-20



XX-743-24



RIVET	DIA.	NOSE ASSEMBLY	NOSE TIP 1	JAW	FOLLOWER	DESIGNATION
AVEX (1624 PROTRUDING HEAD)	3/16	AV6-743-24 2	10141	30824	40820	AV6
AVEX (1624 COUNTERSUNK HEAD)	3/16	6C-743-24 2	10141-1	30824	40820	6C
KLAMPTITE (STRUCTURAL) RIVET	3/16	6KT-703-18 1	10263	30617	40605	6KT
	1/4	8KT-743-24 2	10262	30824	40820	8KT
MACHINE SCREW RIVET	5MM	MS5M-703-18 1	10332	30617	40605	5MM
MONOBOLT RIVET	3/16	MB06-734A-20 2,5	10210	36801	40820	MB06
	1/4 3	MB08-734-20 2,5	10213	30833	40820	MB08
NUTPLATE RIVET	3/32	4N-703-18 1	10202	30617	40307	4N
	1/8	5N-703-18 1	10203	30617	40605	5N
OPEN END	3/32	3N-703-18 1	10247	30617	40307	3N
CLOSED END	1/8	4N-703-18 1	10202	30617	40307	4N
NAIL RIVET	5/32	5N-703-18 1	10203	30617	40605	5N
	3/16	6N-703-18 1	10204	30617	40605	6N
	1/4 3	8Z-743-24 2	10211	30824	40820	8Z
STAINLESS STEEL	5/32	5SS-743-24	10203	30849	40871	5SS
OPEN END, CLOSED END	3/16	6SS-743-24	10204	30849	40871	6SS
NAIL RIVET						
PLASTIC SPLIT RIVET	3/16	6P-703-18 1	10167	30617	40605	6P
	1/4	8P-743-24 2	10166	30824	40820	8P
T RIVET	3/16	6T-703-18 1	10209	30617	40605	6T
	1/4 3	8T-743-24 2	10286	30824	40820	8T
TLR RIVET	1/4	8TLR-743-24 2	10246	30617	40820	8TLR

SELECTION CHART FOR PROTRUDING HEAD ONLY

RIVET	DIA.	NOSE ASSEMBLY	NOSE TIP 1	JAW	FOLLOWER	DESIGNATION
MULTI-GRIP STRUCTURAL RIVET	3/16	PH6-734A-20 2,5	10248	36801	40820	PH6
	1/4 4	PH8-734-20 2,3,5	10205	30833	40820	PH8

1) YOU CAN CHANGE THE 703 NOSE ASSEMBLY (INCLUDED WITH TOOL) TO INSTALL OTHER FASTENERS BY PURCHASING NOSE TIP SHOWN AND USING APPROPRIATE FOLLOWER SHOWN.

2) NOSE ASSEMBLIES WITH A 743 DESIGNATION, I.E. 8Z-743-24, MUST BE ORDERED AS COMPLETE NOSE ASSEMBLY.

3) ALUMINUM RIVET STEEL MANDREL ONLY (100 PSI REQUIRED FOR ALL 1/4" STEEL RIVETS).

4) 1/4" ALUMINUM ONLY.

5) NOSE ASSEMBLIES WITH A 734 DESIGNATION, I.E. PH6-734-20, ARE FOR SERRATED STEM RIVETS ONLY. IF YOU ARE PULING BOTH SMOOTH AND SERRATED STEM RIVETS YOU MUST ORDER THE NOSE ASSEMBLY WITH A 743 DESIGNATION, I.E. MGL06-743-24.

NOTE: THE LAST 2 DIGITS OF THE NOSE ASSEMBLY REPRESENTS THE LENGTH THE NOSE EXTENDS FROM THE TOOL. I.E. -20 = 2.0 INCHES

GAGE BILT



DECLARATION OF CONFORMITY

WE DECLARE THAT THE EQUIPMENT SPECIFIED HEREIN
CONFORMS TO THE FOLLOWING STANDARDS AND DIRECTIVES.

EN292 part 1 and part 2

ISO 8662 part 1

ISO 3744

COUNCIL DIRECTIVE: 89/392/EEC, 91/368/EEC

93/44/EEC, 93/68/EEC

EQUIPMENT DESCRIPTION:

GBP700 SERIES FASTENER INSTALLATION TOOLS

MANUFACTURER:

GAGE BILT PRODUCTS CORP.

SIGNATURE:

NAME: BRUCE T. GODFREY

CHAIRMAN

WARREN, MI U.S.A.

JUNE 2003

WARRANTY

Seller warrants that all goods covered by this catalog will conform to applicable specifications and will replace, or repair, F.O.B. our plant, any goods providing defective from faulty workmanship, or material, for 90 days from date of shipment.

Said warranty to remain in effect if and only if such goods are used in accordance with all instructions as to maintenance, operation, and use set forth in manuals and instruction sheets furnished by seller.

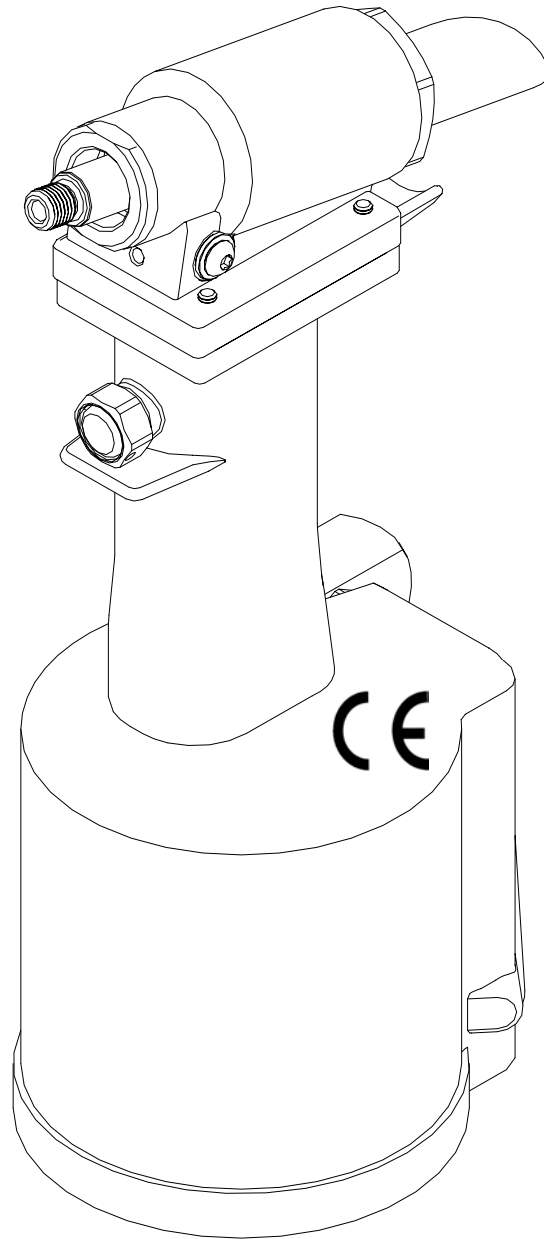
Sellers obligation under this warranty shall be limited to the repair or rework of the goods supplied or replacement thereof, at Seller's option, and in no case is to exceed the invoice value of said goods. Under no circumstances will seller be liable for incidental or consequential damages or for damages incurred by the buyer or subsequent user in repairing or replacing defective goods or if the goods covered by this warranty are reworked or subjected to any type of additional processing.

This warranty is void if Seller is not notified in writing of any rejections or defects within 90 days after the receipt of the material by the customer.

THIS WARRANTY IS MADE IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY.

GBP704E

INSTALLATION TOOL



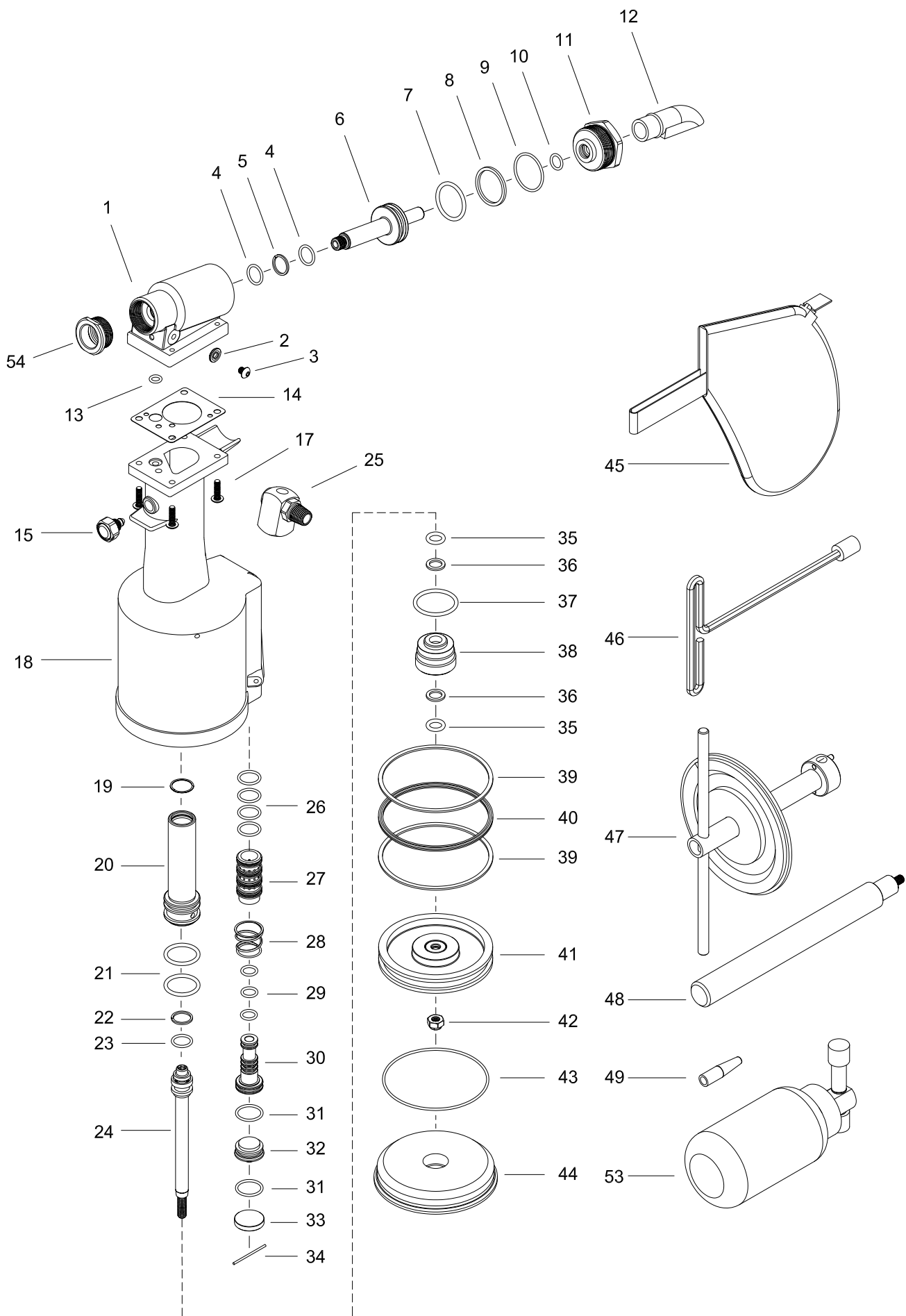
GAGE BILT
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14500 Barber Drive
Warren, Mi 48088

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(586) 771-2665 Fax

e-mail: solutions@gagebilt.com / www.gagebilt.com



GBP704E Parts List

Ref. No.	Part No.	Description	Qty.
1	704108	Head Cylinder Assembly	1
2*	S572	Stat-O-Seal	1
3*	402482	Button Head Socket Screw	1
4*	A-193	O'Ring	2
5*	401086	Back-Up Ring	1
6	704207	Head-Piston	1
7*	A-268	O'Ring	1
8*	S1000	Back-Up Ring	1
9*	400789	O'Ring	1
10*	S829	O'Ring	1
11	704112	Cap	1
12	200232	Deflector	1
13*	S832	O'Ring	1
14*	704129	Gasket	1
15	704130	Trigger Assy. (Inc. 400773)	1
16*	400773	O'Ring	1
17*	A-928	Button Head Cap Screw	4
18	704132	Handle	1
19*	S734	Retaining Ring	1
20	751131	Power Cylinder	1
21*	403805	O'Ring	2
22*	401102	Back-Up Ring	1
23*	S945	O'Ring	1
24	704138	Piston Rod Assy. (Inc 22 & 23)	1
25	A-249	Swivel	1
26*	400781	O'Ring	4
27	703139	Valve Sleeve	1
28*	704141	Spring	1
29*	400778	O'Ring	3
30	703142	Valve Spool Assembly	1
31*	400783	O'Ring	2
32	704145	Valve Plug	1
33*	704146	Muffler	1
34*	704244	Pin	1
35*	A-287	O'Ring	2
36*	S115	Back-Up Ring	2
37*	405757	O'Ring	1
38	704118	Packing Plug	1
39*	S731	Back-Up Ring	2
40*	S730	Quad Ring	1
41	704121	Air Piston Assembly	1
42*	400559	Flexlock Nut	1
43*	S725	O'Ring	1
44	704125	Base Cover	1
45**	704214	Stem Catcher Bag	1
46**	704149	Piston Rod Wrench	1
47**	704150	Packing Plug Wrench	1
48**	704151	Power Cylinder Tool	1
49**	704152	Seal Guide	1
50**	S1178	Valve Plug Extractor (Not Shown)	1
51**	704162	Valve Spring Installation Tool (Not Shown)	1
52**	704163	Valve Sleeve Removal Tool (Not Shown)	1
53**	704153	Air Bleeder	1
54	704101	Nose Fitting	1
55	A-991	Tee-Wrench (Not Shown)	1

*Service Kit 704024 contains a complete set of O'Rings, Back-Up Rings, Screws and gaskets. These items should be kept on hand at all times.

**Ref. No. 45-53 are not furnished with tool. 46-53 are recommended for complete tool overhaul.

Rev. 11/06

GBP704E SELECTION CHART

FASTENER	DIAMETER	STRAIGHT	RIGHT ANGLE (3)	OFFSET
NAS1919U NAS1921U MIL-R-7885 NAS9301-9312 BACR15FR/FP BACR15GJ/GK	1/8 5/32 3/16	456MAX-701-17 ⁽²⁾ 456MAX-749-35 ^(4,2)	456MAX-753-54 ⁽²⁾	456MAX-763A-43 ⁽²⁾
MS20600 SERIES MS/9SP/PT	3/32 ⁽¹⁾	3C-715A-43	3C-715B-44RA	3C-715-40OS
	1/8 ⁽¹⁾	4C-715A-43	4C-715B-44RA	4C-715-40OS
	5/32 ⁽¹⁾	5C-715A-43	5C-715B-44RA	5C-715-40OS
	3/16 ⁽¹⁾	6C-715A-43	6C-715B-44RA	6C-715-40OS
NUT PLATE BACR15CC/CF/DA/DR	3/32 ⁽¹⁾	3NP-715A-43	3NP-715B-44RA	3NP-715-40OS
	1/8 ⁽¹⁾	4NP-715A-43	4NP-715B-44RA	4NP-715-40OS
NAS1398A NAS1399A 'A' CODE	3/32 ⁽¹⁾	3A-715A-43	3A-715B-44RA	3A-715-40OS
	1/8 ⁽¹⁾	4A-715A-43	4A-715B-44RA	4A-715-40OS
	5/32 ⁽¹⁾	5A-715A-43	5A-715B-44RA	5A-715-40OS
	3/16 ⁽¹⁾	6A-715A-43	6A-715B-44RA	6A-715-40OS
GROUND STUD M83454 BACS53B1EA1/2	8/32 ⁽¹⁾	GS8-715A-43	GS8-715B-54RA	GS8-715-40OS
	10/32 ⁽¹⁾	GS10-715A-43	GS10-715A-54RA	GS10-715-40OS

THE GBP704E TOOL IS APPROVED TO INSTALL THE ABOVE FASTENERS.

1) THESE NOSE ASSEMBLIES REQUIRE 704001 ADAPTER.
2) ALL THREE DIAMETERS CAN BE INSTALLED WITH ONE NOSE ASSEMBLY.
3) RIGHT ANGLE NOSE ASSEMBLIES MAY REQUIRE MORE THAN ONE PULL.
4) FRONT END EJECTING NOSE ASSEMBLY.

NOTE: THE LAST 2 DIGITS OF THE NOSE ASSEMBLY REPRESENTS THE LENGTH THE NOSE
EXTENDS FROM THE TOOL I.E. -20 = 2.0 INCHES

GAGE BILT



DECLARATION OF CONFORMITY

WE DECLARE THAT THE EQUIPMENT SPECIFIED HEREIN
CONFORMS TO THE FOLLOWING STANDARDS AND DIRECTIVES.

EN292 part 1 and part 2

ISO 8662 part 1

ISO 3744

COUNCIL DIRECTIVE: 89/392/EEC, 91/368/EEC

93/44/EEC, 93/68/EEC

EQUIPMENT DESCRIPTION:

GBP700 SERIES FASTENER INSTALLATION TOOLS

MANUFACTURER:

GAGE BILT PRODUCTS CORP.

SIGNATURE:

NAME: BRUCE T. GODFREY

CHAIRMAN

WARREN, MI U.S.A.

JUNE 2003

WARRANTY

Seller warrants that all goods covered by this catalog will conform to applicable specifications and will replace, or repair, F.O.B. our plant, any goods providing defective from faulty workmanship, or material, for 90 days from date of shipment.

Said warranty to remain in effect if and only if such goods are used in accordance with all instructions as to maintenance, operation, and use set forth in manuals and instruction sheets furnished by seller.

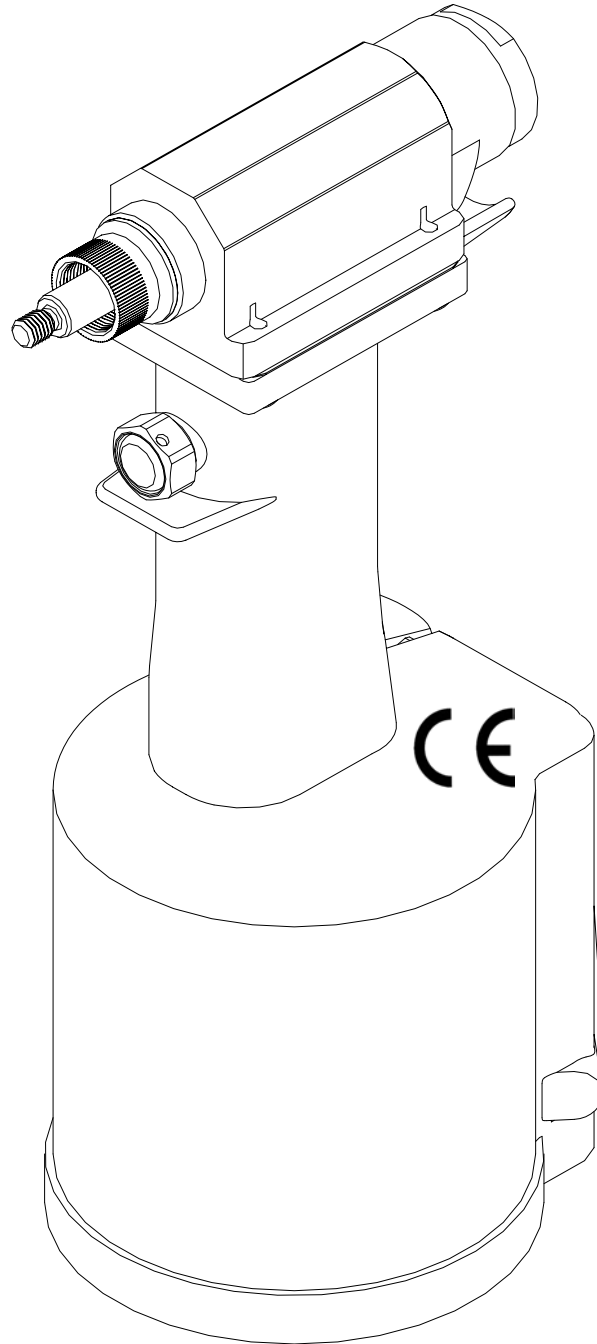
Sellers obligation under this warranty shall be limited to the repair or rework of the goods supplied or replacement thereof, at Seller's option, and in no case is to exceed the invoice value of said goods. Under no circumstances will seller be liable for incidental or consequential damages or for damages incurred by the buyer or subsequent user in repairing or replacing defective goods or if the goods covered by this warranty are reworked or subjected to any type of additional processing.

This warranty is void if Seller is not notified in writing of any rejections or defects within 90 days after the receipt of the material by the customer.

THIS WARRANTY IS MADE IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY.

GBP715C

INSTALLATION TOOL



GAGE BILT
MADE IN U.S.A.

GAGE BILT PRODUCTS CORP.

14500 Barber Drive

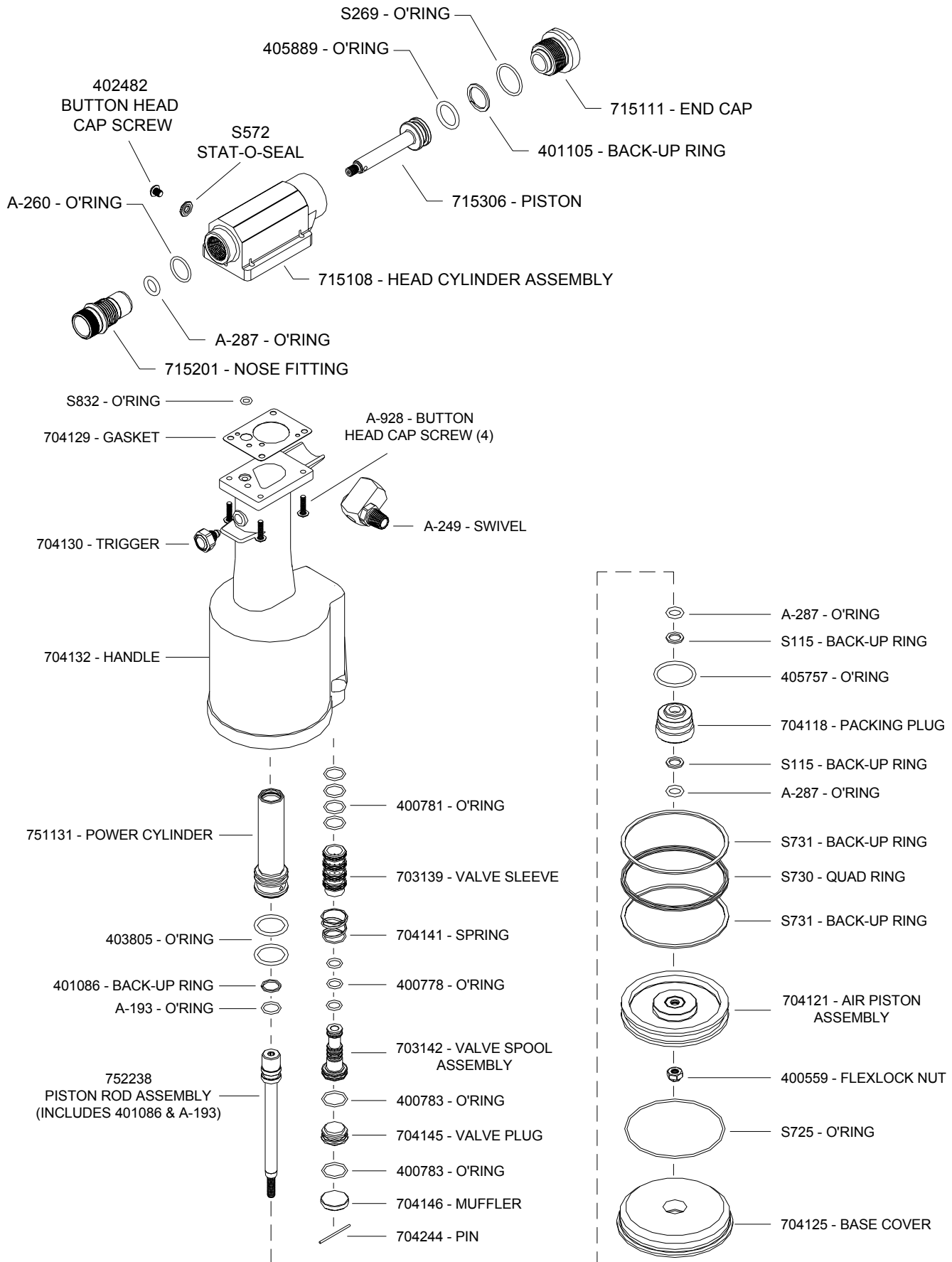
Warren, Mi 48088

e-mail: solutions@gagebilt.com / www.gagebilt.com

(586) 771-7664

(586) 771-2665 Fax

GBP715C PARTS LIST



GBP715C SELECTION CHART

FASTENER	DIA.	STRAIGHT	*RIGHT ANGLE ₁	OFFSET
MS20600 SERIES MS/9SP/PT BACR15CC/CF/DA	3/32	3C-715A-43	3C-715-54RA	3C-715-40OS
	1/8	4C-715A-43	4C-715-54RA	4C-715-40OS
	5/32 ₃	5C-715A-43	5C-715-54RA	5C-715-40OS
	3/16 ₃	6C-715A-43	6C-715-54RA	6C-715-40OS
NUT-PLATE BACR15DR	3/32	3NP-715A-43	3NP-715B-44RA	3NP-715-40OS
	1/8	4NP-715A-43	4NP-715B-44RA	4NP-715-40OS
A' CODE NAS1398A NAS1399A	3/32	3A-715A-43	3A-715-54RA	3A-715-40OS
	1/8	4A-715A-43	4A-715-54RA	4A-715-40OS
	5/32 ₃	5A-715A-43	5A-715-54RA	5A-715-40OS
	3/16 ₄	6A-715A-43	6A-715-54RA	6A-715-40OS
NAS1919S NAS1921S	1/8	SMLS04-715A-43	SMLS04-715-54RA	SMLS04-715A-40OS
	5/32 ₃	SMLS05-715A-43	SMLS05-715-54RA	SMLS05-715A-40OS
	3/16 ₃	SMLS06-715A-43	SMLS06-715-54RA	SMLS06-715A-40OS
UNIMATIC® SINGLE ACTION NAS1919U & NAS1621U NAS9301-NAS9312 BACR14FP/FR & BACR15GF/GK	1/8	UBR04-715A-43	UBR04-715-54RA	UBR04-715-40OS
	5/32 ₃	UBR05-715A-43	UBR05-715-54RA	UBR05-715-40OS
	3/16 ₃	UBR06-715A-43	UBR06-715-54RA	UBR06-715-40OS
NAS1919U NAS1921U	1/8	456MAX-715-43 2	456MAX-715-54RA 2	456MAX-715-40OS 2
	5/32 ₃			
	3/16 ₃			

THE GAGE BILT GBP715C TOOL IS APPROVED TO INSTALL THE ABOVE FASTENERS.

*ALL RIGHT ANGLE NOSE ASSEMBLIES REQUIRE 715113 STROKE LIMITER.
**ALL COUNTERSUNK 'C' NOSE ASSEMBLIES MAY USED TO INSTALL BOTH UNIVERSAL AND COUNTERSUNK HEAD RIVETS.
1) RIGHT ANGLE NOSE ASSEMBLIES MAY REQUIRE MORE THAN ONE PULL
2) INSTALLS 1/8, 5/32 & 3/16 DIAMETERS
3) ALUMINUM ONLY.
4) SELF-PLUGGING ALUMINUM ONLY.

NOTE: THE LAST 2 DIGITS OF THE NOSE ASSEMBLY REPRESENTS
THE LENGTH THE NOSE EXTENDS FROM THE TOOL I.E. -20 = 2.0 INCHES

GAGE BILT

DECLARATION OF CONFORMITY



WE DECLARE THAT THE EQUIPMENT SPECIFIED HEREIN
CONFORMS TO THE FOLLOWING STANDARDS AND DIRECTIVES.

EN292 part 1 and part 2
ISO 8662 part 1
ISO 3744
COUNCIL DIRECTIVE: 89/392/EEC, 91/368/EEC
93/44/EEC, 93/68/EEC

EQUIPMENT DESCRIPTION:
GBP700 SERIES FASTENER INSTALLATION TOOLS

MANUFACTURER:
GAGE BILT PRODUCTS CORP.

SIGNATURE: 

NAME: BRUCE T. GODFREY
CHAIRMAN
WARREN, MI U.S.A.
JUNE 2003

WARRANTY

Seller warrants that all goods covered by this catalog will conform to applicable specifications and will replace, or repair, F.O.B. our plant, any goods providing defective from faulty workmanship, or material, for 90 days from date of shipment.

Said warranty to remain in effect if and only if such goods are used in accordance with all instructions as to maintenance, operation, and use set forth in manuals and instruction sheets furnished by seller.

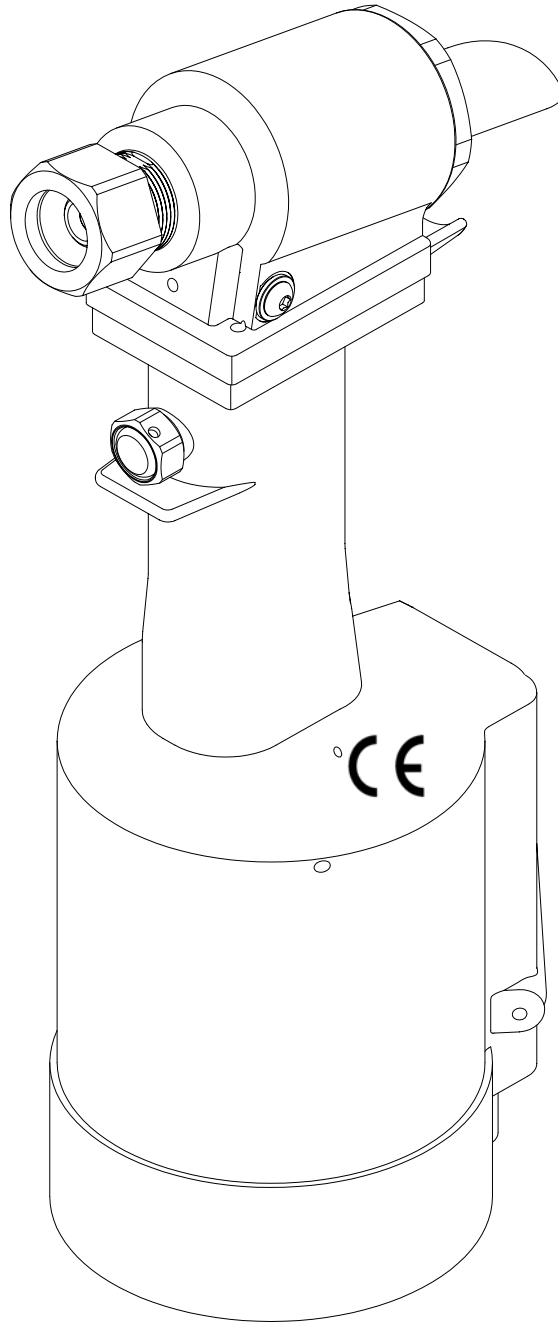
Sellers obligation under this warranty shall be limited to the repair or rework of the goods supplied or replacement thereof, at Seller's option, and in no case is to exceed the invoice value of said goods. Under no circumstances will seller be liable for incidental or consequential damages or for damages incurred by the buyer or subsequent user in repairing or replacing defective goods or if the goods covered by this warranty are reworked or subjected to any type of additional processing.

This warranty is void if Seller is not notified in writing of any rejections or defects within 90 days after the receipt of the material by the customer.

**THIS WARRANTY IS MADE IN LIEU OF ALL OTHER WARRANTIES,
EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY.**

GBP722

INSTALLATION TOOL



GAGE BILT
MADE IN U.S.A.

GAGE BILT PRODUCTS CORP.

14500 Barber Drive

Warren, Mi 48088

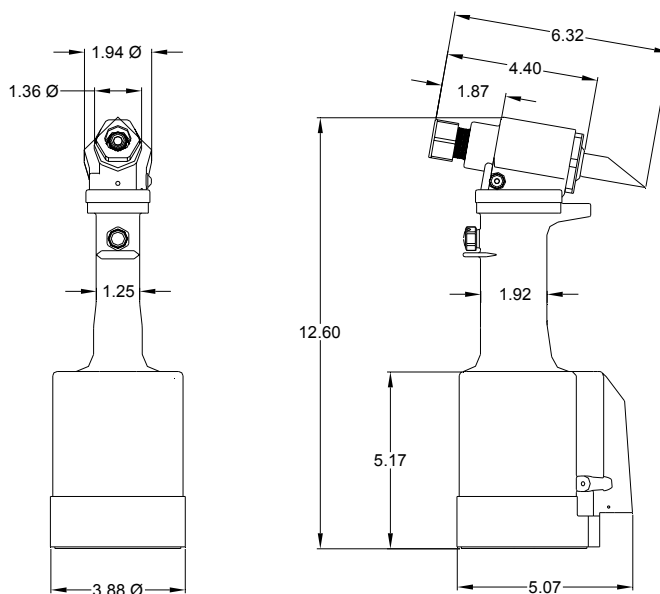
e-mail: solutions@gagebilt.com / www.gagebilt.com

(586) 771-7664

(586) 771-2665 Fax

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SPECIFICATIONS

Weight	- 5.50 lbs.
Air pressure req'd	- 90-120 p.s.i.
Air consumption	- .16 SCF/cycle (4.53 L/cycle)
Hydraulic fluid	- Automatic Transmission Fluid, Dextron III, or equivalent.
Setting stroke	- .590"
Rated pull load	- 4,800 lbs.
Noise level	- 78.4 dB (A)
Vibration	- less than 2.5 M/S ²



NOTE:

PLEASE READ THIS MANUAL BEFORE SERVICING OR USING THIS TOOL. COMPLETE WITH WARNINGS AND CAUTIONS TO PREVENT SEVERE PERSONAL INJURY OR DAMAGE THE TOOL.



CAUTION:

GAGE BILT TOOLS ARE APPROVED TO INSTALL HUCK®, AVDEL®, CHERRY®, POP® AND OTHER FASTENERS WHEN USED BY PERSONS WITH SPECIFIC TRAINING OF BLIND RIVET AND LOCKBOLT INSTALLATION EQUIPMENT.

WARNING

Do not pull fastener unless it is placed in an assembly, pin will eject forcibly when pintail breaks off. Severe personal injury may result.

WARNING

Do not operate without Stat-O-Seal (2) and cap screw (3). Pressurized hydraulic fluid may cause severe personal injury.

WARNING

When operating installation equipment always wear approved eye protection. Do not look in front of nose assembly or rear of tool when installing fastener.

WARNING

Always disconnect tool from power before performing any maintenance to any tool or nose assembly. Insure that all connections are proper and there are no visible leaks from tool or hoses before connecting to power.

WARNING

Do not operate if deflector, bottle, catcher bag or vacuum tube is removed or damaged, broken pintails may eject forcibly from rear of tool. Severe personal injury may result.

CAUTION

Insure that nose assembly and tip are properly matched for the fastener being installed.

WARNING

Installation of fasteners may exceed acceptable noise levels. Use approved hearing protection.

WARNING

Be sure there is adequate clearance for tool and operator's hands before proceeding. Keep fingers clear of any moving parts. Keep fingers clear from fasteners and installed materials. Severe personal injury may result.

CAUTION

Keep Nose Assemblies clean and free of chips and debris.

DESCRIPTION

The GBP722 is a pneumatic-hydraulic tool designed specifically for the efficient installation of a wide range of blind rivets. It weighs 5.50 lbs. and can be operated in any position with one hand. It has a .590" rivet setting stroke and a rated pull load of 4800 pounds with 90 psi air pressure at the air inlet.

The GBP722 riveter operates on a wide range of air pressure, with 90 to 100 psi providing the maximum efficiency. At 90 lbs air pressure, the GBP722 does not exceed 85 db (A) and consumes 3 cfm at 20 cycles a minute.

The air inlet is provided with 1/4-18 female pipe threads to accept the users air hose fitting.

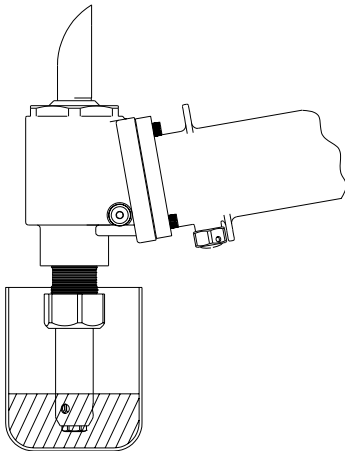
NOSE ASSEMBLIES ARE NOT FURNISHED WITH TOOL AND MUST BE ORDERED SEPARATELY. (See page 7 for nose assembly recommendations.)

MAINTENANCE

The performance of any tool depends upon good maintenance practices. Following these minimal requirements for service and care will extend the life of your tool.

- *Only use an air supply set at 90-120 lbs. equipped with a filter-regulator to prevent wear.
- *The tool will eventually lose some hydraulic oil. Keep the hydraulic system full and free of air by using the air bleeder (704153) on a regular basis.
- *Proper care by operator is necessary in maintaining full productivity and reducing downtime. Read all applicable tool manuals and nose assembly data sheets prior to operating tools.
- *Keep nose assemblies, especially jaws, clean and free of chips and debris.
- *For a complete overhaul, tool kit GBP704TK is recommended.

CLEANING AND LUBRICATING PROCEDURE



Daily cleaning and lubrication of nose assembly will greatly reduce downtime and increase life of components. Using sewing machine oil, or an equivalent cleaner/lubricant, follow instructions below.

1. Disconnect tool vacuum line (if equipped).
2. Point nose assembly into oil as shown.
3. Cycle tool 8-10 times and wipe dry.

TORQUE SPECIFICATIONS

Socket Head Cap Screws (A-928) = 40 inch lbs.

Packing Plug (704118) = 45 foot lbs.

Flexlock Nut (400559) = 40 inch lbs.

FILLING AND BLEEDING TOOL

WARNING

DO NOT CYCLE TOOL WITHOUT AIR BLEEDER, OR THE SCREW AND STAT-O-SEAL, INSTALLED IN TOOL HEAD. SEVERE PERSONAL INJURY MAY RESULT.

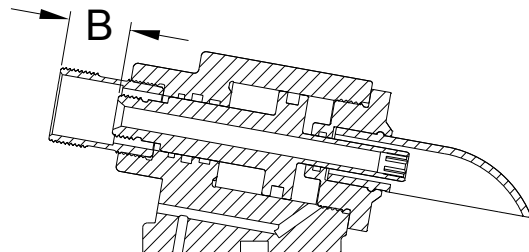
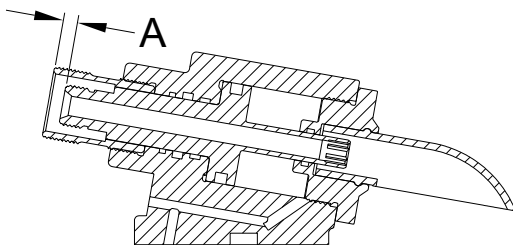
CAUTION

BEFORE FILLING HANDLE, AIR PISTON SHOULD BE ALL THE WAY DOWN.

To replace a small amount of oil in the tool, attach the air bleeder and connect tool to air line. Cycle a number of times. Disconnect air, remove the air bleeder, and reinstall the cap screw. This will insure the removal of any air from the hydraulic system and its replacement with fluid.

Should it become necessary to completely refill the tool (such as would be required after tool has been dismantled and reassembled), take the following steps after depressing trigger **AND DISCONNECTING THE AIR SUPPLY:**

1. Remove head assembly from handle assembly. Slowly push piston completely forward.
2. Fill handle and the oil passage on top of handle with automatic transmission fluid, ATF220 or equivalent. When looking at the top of the handle, the oil passage is the hole that is counterbored for (S832) o'ring.
3. Replace head assembly with care, insuring gasket (704129) and o'ring (S832) are properly installed. Tighten cap screws (A-928) uniformly to prevent leakage around gasket.
4. Remove screw (402482) and stat-o-seal (S572) install bleeder bottle (704153) and connect tool to air line, cycle ten to twenty times to fully circulate fluid through hydraulic system.
5. **DISCONNECT AIR FROM TOOL.** Remove bleeder bottle (704153) install screw (402482) and stat-o-seal (S572). Reconnect air and cycle tool 10 more times. Check tool stroke, if stroke (Dim 'B' - 'A') doesn't check .590" repeat steps 4 & 5.



TROUBLE SHOOTING

Providing all maintenance conditions have been met, follow this systematic approach to diagnosis.

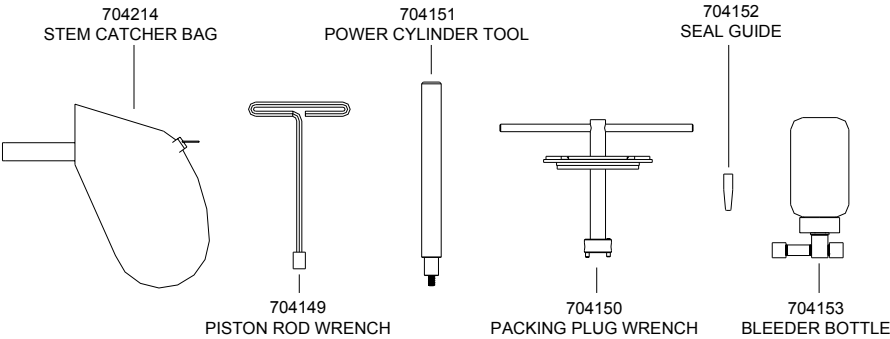
1. MORE THAN ONE PULL IS REQUIRED TO BREAK RIVET.
 - a) Tool needs to be bled. (See filling and bleeding instructions.)
 - b) Spring has fatigued, replace.
 - c) Jaws are stripped or packed with chips. Clean or replace.
2. SLOW OR PARTIAL OPERATION WHEN THE TRIGGER IS DEPRESSED
 - d) Head Piston Rings (A-1044) and (401113) could be worn or damaged. Replace.
 - e) Piston Rod Rings (A-914) and (731134) could be worn or damaged. Replace.
 - f) Muffler (704146) or filter inside spool (703142) may be plugged with dirt. Clean thoroughly and back-blow with compressed air.
 - g) Hole in metering screw in valve spool (703142) may be blocked or damaged. Hole diameter should be .028". Clear and size or replace.
3. NO OPERATION WHEN TRIGGER IS DEPRESSED
 - a) Tool seized due to mechanical failure or damaged parts.
4. OIL LEAKAGE
 - a) **DO NOT** OPERATE WITH OIL LEAKING FROM TOOL. HIGH PRESSURE OIL MAY CAUSE SEVERE PERSONAL INJURY.
 - b) Any oil leaking externally should be traced to its source. An o'ring or seal that leaks should be replaced.
5. AIR BYPASS FROM VALVE HOUSING
 - a) If the spring (704141) breaks or dislodges, air will flow freely through the muffler (704146). Replace or reset. Valve spring installation tool (704162) is recommended.
 - b) Check o'rings on valve sleeve (703139), valve spool (703142), and valve plug (704145). If worn or damaged, replace. Valve sleeve removal tool (704163) is recommended.
6. FASTENER STEM JAMMED IN NOSE ASSEMBLY
 - a) Nose assembly components require service. **DISCONNECT AIR FROM TOOL**, remove the nose from the tool and disassemble. Replace worn or broken parts. Clean the surface the jaws ride on.
 - b) Stems lodged side by side in the follower. Disassemble, remove stems, and reassemble.

OVERHAUL

The disassembly and re-assembly procedure can be accomplished by utilizing the following instructions and drawings. Use extreme care during disassembly and re-assembly not to mar or nick any smooth surface that comes in contact with seals. Before installing seals, always apply a good lubricant, such as Lubriplate, to the surfaces. It is recommended that tool kit (GBP704TK) be used to facilitate overhaul. A complete overhaul can be achieved by the use of Service Kit 722002 which contains a complete set of o-rings, back-up rings, screws, washers and gasket.

WARNING

DEPRESS TRIGGER AND DISCONNECT FROM AIR WITH HEAD PISTON IN THE REAR POSITION BEFORE OVERHAUL. SEVERE PERSONAL INJURY MAY OCCUR IF AIR HOSE IS NOT DISCONNECTED. **USE CAUTION** WHEN FORCING PISTON ROD ASSEMBLY DOWNWARD WITH HEAD ASSEMBLY REMOVED, HYDRAULIC FLUID WILL EJECT FORCIBLY FROM HANDLE.



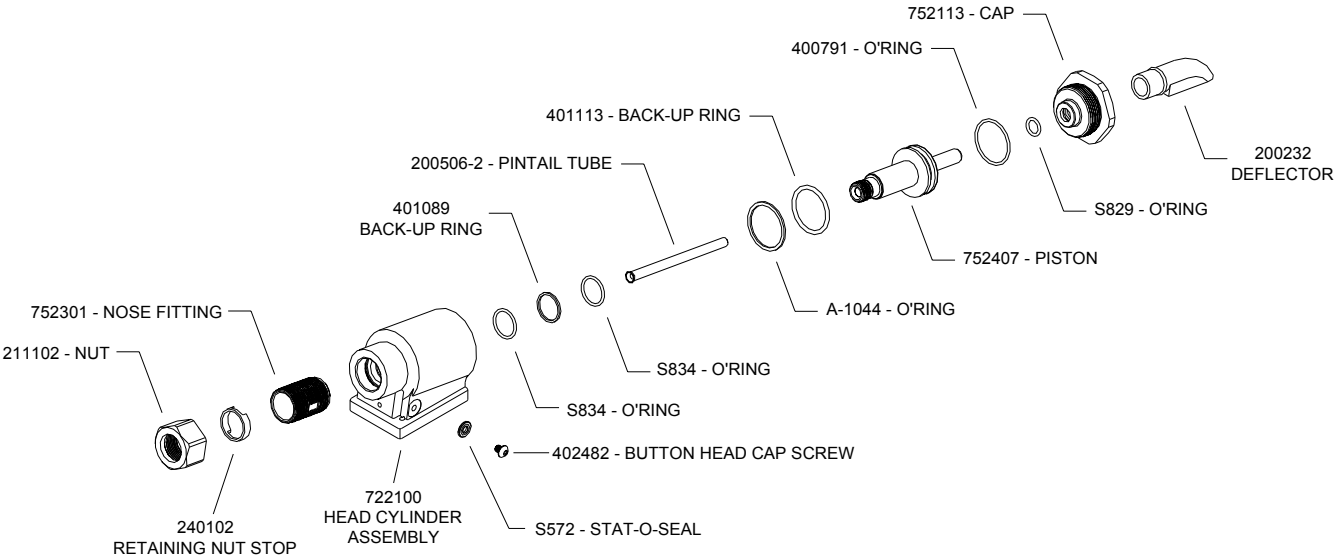
GBP704TK Service Tool Kit Includes:

Part No.	Description
704149	Piston Rod Wrench
704150	Packing Plug Wrench
704151	Power Cylinder Tool
704152	Seal Guide
S1178	Valve Extractor (Not Shown)
704162	Valve Spring Installation Tool (Not Shown)
704163	Valve Sleeve Removal Tool (Not Shown)

HEAD

Remove nose assembly from tool before attempting disassembly of head assembly. Remove end cap (752113). Push against threaded end of head piston (752407) to slide it out of head cylinder (722100). Be careful not to damage threads or cause burrs on polished piston rod surface.

The re-assembly sequence is the opposite of disassembly. (See Filling and Bleeding instructions.)
Apply loctite #242 and torque the four socket-head cap screws (A-928) uniformly to 40 inch lbs. to prevent leakage around the gasket.



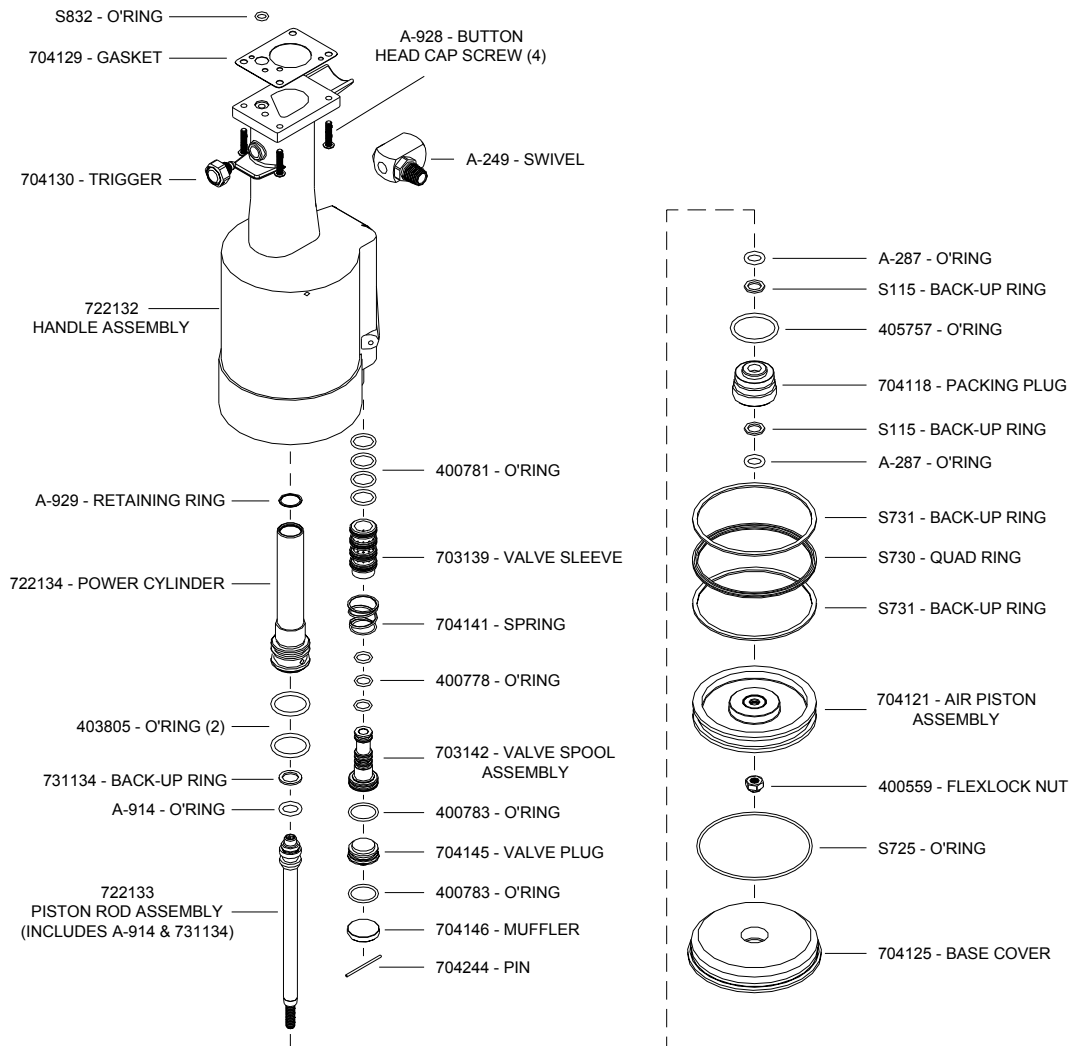
HANDLE

To inspect air cylinder bore, remove parts (704125) and (S725). Any further disassembly will require removal of the head assembly first. For complete disassembly, start by removing parts (704125) and (S725). Next, holding tool upright, remove four socket-head cap screws (A-928). Lift head assembly from handle (722132) and set aside o-ring (S832) and gasket (704129). Empty all hydraulic fluid into a container. Place piston rod wrench (704149) down into top of power cylinder, into the hex of piston rod assy. (722133). While holding this wrench, remove flexlock nut (400559) using a 7/16" socket wrench. Still holding piston rod wrench, remove air piston (704121) using packing plug wrench (704150), by turning counterclockwise. When air piston is completely freed from piston rod, tap or push on the piston rod wrench to eject air piston from bottom of handle. After removal of air piston, slide piston rod (722133) back up to the end of its travel. Using packing plug wrench (704150) remove packing plug (704118). With packing plug removed, power cylinder (722134) can be removed by pushing on power cylinder tool (704151) when inserted into top of power cylinder.

To reassemble the handle, reverse the above procedure, being certain that all o-rings are properly lubricated before installation. Torque packing plug (704118) to 45 foot lbs. Attach the seal guide (704152) to the piston rod (722133) and tap the piston rod through the packing plug (704118). Attach air piston (704121) and flexlock nut (400559) torque to 40 inch lbs. Attach air piston (704125) to piston rod (722133). With the piston rod in the down position, fill oil passage on top of handle with automatic transmission fluid, ATF220 or equivalent, when looking at top of handle the oil passage is the hole that has a counterbore for S832 o-ring. Replace gasket (704129) and o-ring (S832), just prior to replacing head assembly. (See Filling & Bleeding instructions.)

AIR VALVE

To disassemble, first disconnect tool from its air source. Remove pin (704244) and muffler (704146). Insert valve extractor (S1178) into end of valve plug (704145) and pull it out. Using the same procedure, pull out spool (703142). NOTE: It should never be necessary to remove valve sleeve (703139) unless the ports in the sleeve are plugged from contaminated air. If ports are plugged, use needle nose pliers to grasp end of spring (704141), turning clockwise and pulling to dislodge from groove in casting. NOTE: 704162 valve spring tool will facilitate the proper installation of the spring (704141), valve sleeve (703139) can be pulled out using valve sleeve removal tool 704163.



GBP722 SELECTION CHART

FASTENER	DIA.	STRAIGHT		*RIGHT ANGLE ,	**OFFSET
COMMERCIAL LOCKBOLTS	3/16	LB06-713-20			
	1/4	LB08-713-20			
MULTIGRIP LOCKBOLTS	3/16	MG06-713-20	MG06-713-60		
	1/4	MG08-713-20	MG08-713-60		
"S" TYPE BLIND BOLT MS90353S, MS90354S MS21140S, MS21141S	5/32	SB05-752B-20	SB05-752B-45	SB05-751B-54RA	SB05-752A-43OS
		SB05-752B-80			
	3/16	SB06-752B-20	SB06-752B-45	SB06-751B-54RA	SB06-752A-43OS
		SB06-752B-80			
"U" TYPE BLIND BOLT WITH LOCKING WASHER MS90353U & MS90354U MS21140U & MS21141U	5/32	UBB05-752B-20	UBB05-752B-45	UBB05-751B-54RA	UBB05-752A-43OS
		UBB05-752B-80			
	3/16	UBB06-752B-20	UBB06-752B-45	UBB06-751B-54RA	UBB06-752A-43OS
		UBB06-752B-80			
EN6122 & UAB130-EU EN6127 & UAB6127-EU EN6128 & UAB100-EU EN6129 & UABP-EU	1/8	UAB04-752B-20	UAB04-752B-45	UAB04-751B-54RA	UAB04-752A-43OS
		UAB568-713-21	UAB568-713-61	UAB05-751B-54RA	UAB05-752A-43OS
	5/32			UAB06-751B-54RA	UAB06-752A-43OS
	3/16				UAB08-204C-27OS
SINGLE ACTION BLIND RIVET NAS1919S NAS1921S	1/8	SMLS04-752B-20	SMLS04-752B-45	SMLS04-751B-54RA	SMLS04-752A-43OS
		SMLS04-752B-80			
	5/32	SMLS05-752B-20	SMLS05-752B-45	SMLS05-751B-54RA	SMLS05-752A-43OS
		SMLS05-752B-80			
UNIMATIO® SINGLE ACTION NAS1919U & NAS1621U NAS9301-NAS9312 BACR14FP/FR & BACR15GF/GK	3/16	SMLS06-752B-20	SMLS06-752B-45	SMLS06-751B-54RA	SMLS06-752A-43OS
		SMLS06-752B-80			
	1/4	SMLS08-713-20	SMLS08-713-45	SMLS08-751B-54RA	SMLS08-752A-43OS
"A" CODE NAS1398A & NAS1399A	1/8	UBR04-752B-20	UBR04-752B-45	UBR04-751B-54RA	UBR04-752A-43OS
		UBR04-752B-80			
	5/32	UBR05-752B-20	UBR05-752B-45	UBR05-751B-54RA	UBR05-752A-43OS
		UBR05-752B-80			
PROTRUDING HEAD, MULTI-GRIP BLIND RIVETS	3/16	UBR06-752B-20	UBR06-752B-45	UBR06-751B-54RA	UBR06-752A-43OS
		UBR06-752B-80			
	1/4	UBR08-713-20	UBR08-713-45		UBR08-752A-43OS
"A" CODE NAS1398A & NAS1399A	3/32	3A-352B-25		3A-751B-54RA	
		4A-752B-20	4A-752B-45	4A-751B-54RA	4A-752A-43OS
	5/32	5A-752B-20	5A-752B-45	5A-751B-54RA	5A-752A-43OS
		6A-752B-20	6A-752B-45	6A-751B-54RA	6A-752A-43OS
PROTRUDING HEAD, MULTI-GRIP BLIND RIVETS	3/16	SMLS08-713-20	SMLS08-713-45	SMLS08-751B-54RA	SMLS08-752A-43OS
	1/4				
COUNTERSUNK HEAD, MULTI-GRIP BLIND RIVETS	3/16	MGL06-752A-21	MGL06-752A-61	MGL06-751B-54RA	
	1/4	MGL08-752A-21	MGL08-752A-61		
MONOBOLT	3/16	6CN-752A-21	6CN-752A-61		
	1/4	8CN-752A-21	8CN-752A-61		
CONTAINER BOLT(R 12) HLPP, HLFM, HLPE, HLPS HLPSC & HLPSCM	3/16	MB06-752A-21	MB06-752A-61	MB06-751B-54RA	
	1/4	MB08-752A-21	MB08-752A-61		
BACR15FR-FP, BACR16GF-GK, NAS1919U & 1921U, NAS9301-9312	3/8	HT12-713-20			
	1/8	456MAX-752B-21	456MAX-752B-61		456MAX-751A-43OS
	5/32				
ASP 2, ASP PF, ASP 4 FF, ASP 2 F, ASP 2 LC	3/16	08MAX-752B-20	08MAX-752B-45		08MAX-204C-27OS
					08MAX-204C-37OS
	1/4				
NAS1719, NAS1720 NAS1721	13/64	ASP06-752B-20	ASP06-752B-45	ASP06-751B-54RA	ASP06-752A-43OS
		ASP06-752B-80			
	17/64	ASP08-752B-20	ASP08-752B-45	ASP08-751B-54RA	ASP08-752A-43OS
		ASP08-752B-80			
GROUND STUD, BACS53B	21/64	ASP10-713-20	ASP10-713-45		ASP10-204C-27OS
					ASP10-204C-37OS
	1/8	MBC04-752B-20	MBC04-752B-45	MBC04-751A-54RA	MBC04-752A-43OS
		MBC04-752B-80			
GROUND STUD, BACS53B	5/32	MBC05-752B-20	MBC05-752B-45	MBC05-751A-54RA	MBC05-752A-43OS
		MBC05-752B-80			
	3/16	MBC06-752B-20	MBC06-752B-45	MBC06-751A-54RA	MBC06-752A-43OS

THE GAGE BILT GBP722 IS APPROVED TO INSTALL THE ABOVE FASTENERS.

*ALL RIGHT ANGLE NOSE ASSEMBLIES REQUIRE 722140 STROKE LIMITER
**ALL OFFSET 204 SERIES NOSES REQUIRE 751204 ADAPTER
1) INSTALLS ALL THREE DIAMETERS.
2) ALUMINUM ONLY.
3) RIGHT ANGLE NOSE ASSEMBLIES MAY REQUIRE MORE THAN ONE PULL
4) INSTALLS 5/32, 3/16 & 1/4 DIAMETERS

NOTE: THE LAST 2 DIGITS OF THE NOSE ASSEMBLY REPRESENTS
THE LENGTH THE NOSE EXTENDS FROM THE TOOL I.E. -20 = 2.0 INCHES

GAGE BILT



DECLARATION OF CONFORMITY

WE DECLARE THAT THE EQUIPMENT SPECIFIED HEREIN
CONFORMS TO THE FOLLOWING STANDARDS AND DIRECTIVES.

EN292 part 1 and part 2

ISO 8662 part 1

ISO 3744

COUNCIL DIRECTIVE: 89/392/EEC, 91/368/EEC

93/44/EEC, 93/68/EEC

EQUIPMENT DESCRIPTION:

GBP700 SERIES FASTENER INSTALLATION TOOLS

MANUFACTURER:

GAGE BILT PRODUCTS CORP.

SIGNATURE: 

NAME: BRUCE T. GODFREY
CHAIRMAN
WARREN, MI U.S.A.
JUNE 2003

WARRANTY

Seller warrants that all goods covered by this catalog will conform to applicable specifications and will replace, or repair, F.O.B. our plant, any goods providing defective from faulty workmanship, or material, for 90 days from date of shipment.

Said warranty to remain in effect if and only if such goods are used in accordance with all instructions as to maintenance, operation, and use set forth in manuals and instruction sheets furnished by seller.

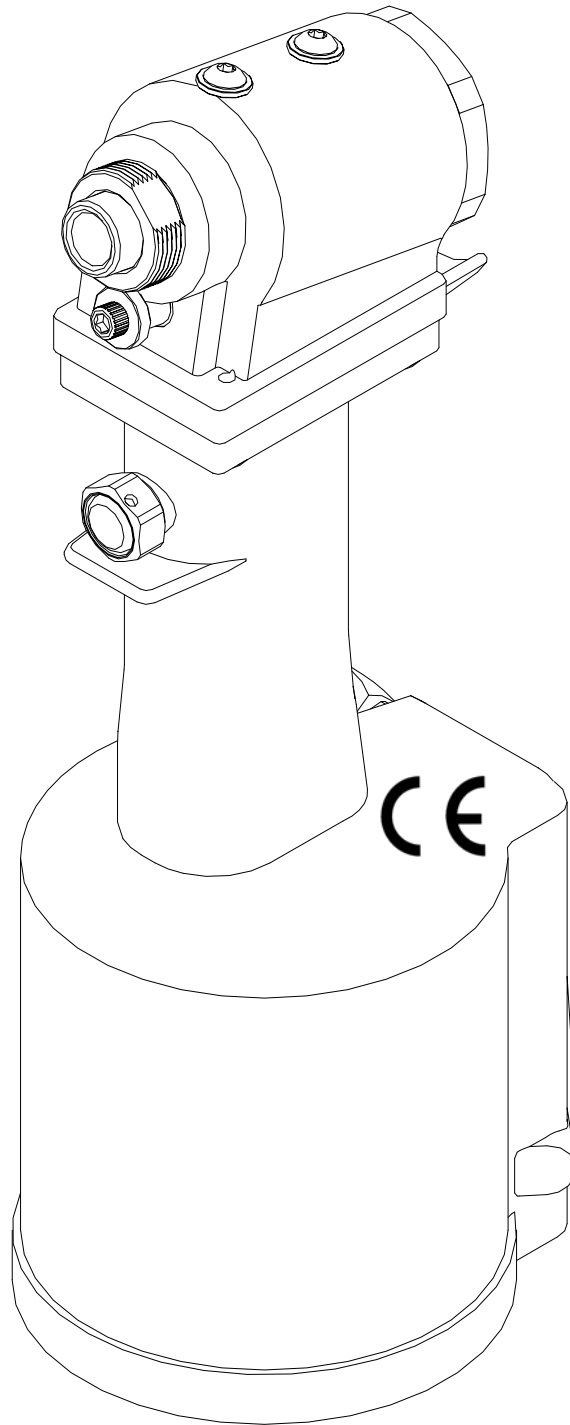
Sellers obligation under this warranty shall be limited to the repair or rework of the goods supplied or replacement thereof, at Seller's option, and in no case is to exceed the invoice value of said goods. Under no circumstances will seller be liable for incidental or consequential damages or for damages incurred by the buyer or subsequent user in repairing or replacing defective goods or if the goods covered by this warranty are reworked or subjected to any type of additional processing.

This warranty is void if Seller is not notified in writing of any rejections or defects within 90 days after the receipt of the material by the customer.

THIS WARRANTY IS MADE IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY.

GBP730EOS

INSTALLATION TOOL



GAGE BILT

GAGE BILT PRODUCTS CORP.

14500 Barber Drive

(586) 771-7664

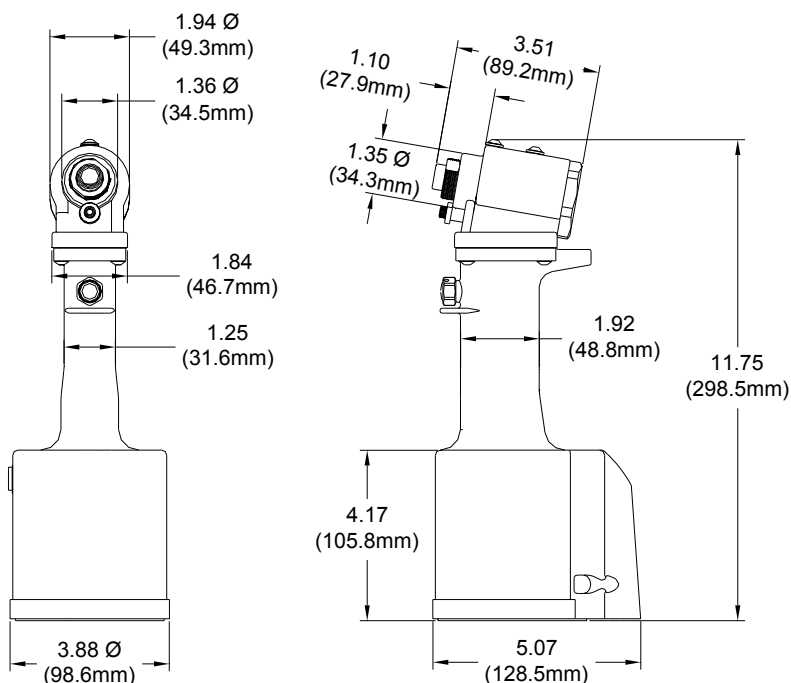
Warren, Mi 48088

(586) 771-2665 Fax

e-mail: solutions@gagebilt.com / www.gagebilt.com

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SPECIFICATIONS

Hand Held Weight	- 4.70 lbs.
Air pressure req'd	- 90-120 p.s.i.
Air consumption	- .16 SCF/cycle (4.53 L/cycle)
Hydraulic fluid	- Automatic Transmission Fluid, Dextron III, or equivalent.
Setting stroke	- .500"
Rated pull load	- 4,000 lbs.
Noise level	- 78.4 dB (A)
Vibration	- less than 2.5 M/S ²

NOTE:

PLEASE READ THIS MANUAL BEFORE SERVICING OR USING THIS TOOL. COMPLETE WITH WARNINGS AND CAUTIONS TO PREVENT SEVERE PERSONAL INJURY OR DAMAGE THE TOOL.

CAUTION:

GAGE BILT TOOLS ARE APPROVED TO INSTALL HUCK®, AVDEL®, CHERRY®, POP® AND OTHER FASTENERS WHEN USED BY PERSONS WITH SPECIFIC TRAINING OF BLIND RIVET AND LOCKBOLT INSTALLATION EQUIPMENT.

WARNING

Do not pull fastener unless it is placed in an assembly, pin will eject forcibly when pintail breaks off. Severe personal injury may result.

WARNING

Do not operate without Stat-O-Seal (S572) and cap screw (402482). Pressurized hydraulic fluid may cause severe personal injury.

WARNING

When operating installation equipment always wear approved eye protection. Do not look in front of nose assembly or rear of tool when installing fastener.

WARNING

Always disconnect tool from power before performing any maintenance to any tool or nose assembly. Insure that all connections are proper and there are no visible leaks from tool or hoses before connecting to power.

WARNING

Do not operate if deflector, bottle, catcher bag or vacuum tube is removed or damaged, broken pintails may eject forcibly from rear of tool. Severe personal injury may result.

CAUTION

Insure that nose assembly and tip are properly matched for the fastener being installed.

WARNING

Installation of fasteners may exceed acceptable noise levels. Use approved hearing protection.

WARNING

Be sure there is adequate clearance for tool and operator's hands before proceeding. Keep fingers clear of any moving parts. Keep fingers clear from fasteners and installed materials. Severe personal injury may result.

CAUTION

Keep Nose Assemblies clean and free of chips and debris.

DESCRIPTION

Covered under Patent No. 5,485,727

The GBP730EOS is a pneumatic-hydraulic tool designed specifically for the efficient installation of a wide range of blind rivets and lockbolts. It weighs 5 lbs. and can be operated in any position with one hand. It has a .500" rivet setting stroke and a rated pull load of 4000 pounds with 90 psi air pressure at the air inlet.

The GBP730EOS riveter operates on a wide range of air pressure, with 90 to 100 psi providing the maximum efficiency. At 90 lbs. air pressure, the GBP730EOS does not exceed 85 db (A) and consumes 3.9 cfm at 20 cycles per minute.

The air inlet is provided with 1/4-18 female pipe threads for accepting the user's air hose fitting.

NOSE ASSEMBLIES ARE NOT FURNISHED WITH THIS TOOL AND MUST BE ORDERED SEPARATELY (SEE PAGE 8).

MAINTENANCE

The performance of any tool depends upon good maintenance practices. Following these minimal requirements for service and care will extend the life of your tool.

- *Only use an air supply set at 90-120 lbs. equipped with a filter-regulator to prevent wear.

- *The tool will eventually lose some hydraulic oil. Keep the hydraulic system full and free of air by using the air bleeder (745163) on a regular basis.

- *Proper care by operator is necessary in maintaining full productivity and reducing downtime. Read all applicable tool manuals and nose assembly data sheets prior to operating tools.

- *Keep nose assemblies, especially jaws, clean and free of chips and debris.

- *For a complete overhaul, tool kit GBP730CTK is recommended.

TORQUE SPECIFICATIONS

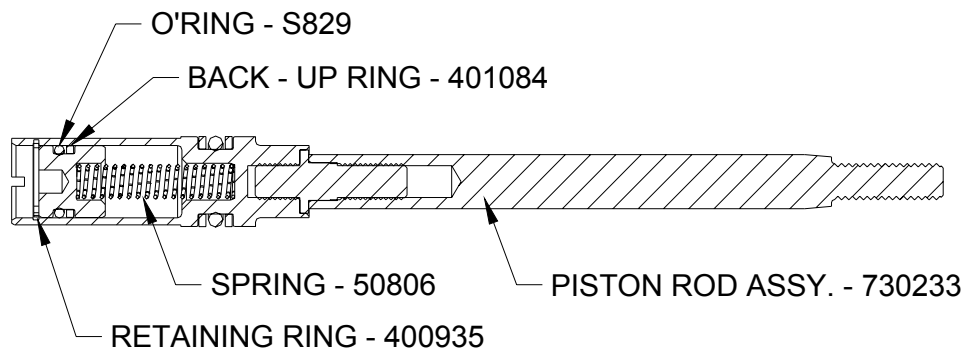
Button Head Cap Screws (A-928) = 40 inch lbs.

Packing Plug (704118) = 45 foot lbs.

Flexlock Nut (400059) = 40 inch lbs.

WARNING

This tool incorporates a patented hydraulic relief valve. When overhauling tool, o'ring (S829), back-up ring (401084), retaining ring (400935) and spring (50806) must be replaced. Failure to do so could result in SEVERE PERSONAL INJURY!



FILLING AND BLEEDING INSTRUCTIONS

WARNING:

Do not cycle tool without screws or bleeder bottle installed in tool head. Severe personal injury may occur.

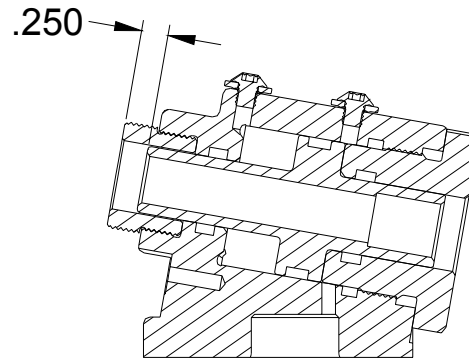
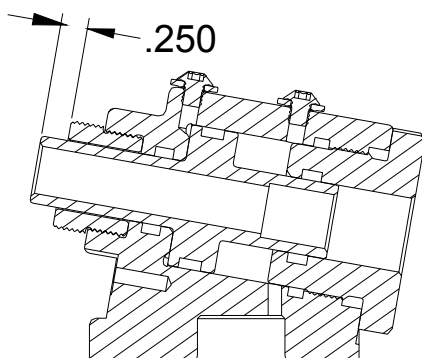
To replace a small amount of oil in the tool follow steps 19 and 20 below.

Should it become necessary to completely refill the tool (as would be required after tool has been dismantled and reassembled), take the following steps.

1. Ensure air piston is at the full bottom of stroke by pushing power piston rod down.
2. Fill power cylinder and oil passage to the top.
3. Place gasket and o'ring on top of the handle.
4. Push head piston in head cylinder until it stops.
5. Press head cylinder down on top of handle, being careful not to tear o'ring on top of power cylinder, install screws and tighten evenly.
6. Remove front screw and seal from top of head. Attach 4oz. bottle assy (745163).
7. Squeeze bottle gently until no air rises into bottle. (Be careful not to move head piston when filling with oil).
8. Remove 4oz. bottle assy. (745163) from front hole. Replace screw and stat-o-seal. Remove rear screw and stat-o-seal and attach 4 oz. bottle assy. (745163) Repeat step 7.
9. Remove 4oz. bottle assy. (745163) from rear hole, install screw and stat-o-seal.
10. Reattach 4oz. bottle assy. (745163) to front bleeder hole and connect to air.
11. Cycle tool 10 times holding trigger down for 5 seconds between cycles.
12. Remove 4oz. bottle assy. (745163), replace screw and stat-o-seal.
13. Cycle tool 10 times, check stroke (see below), if piston does not come completely forward (see below), or does not have a .500 stroke follow steps 14-21. If stroke checks O.K. and piston comes completely forward (see below) the bleeding procedure is complete. If not, continue.
14. Disconnect air while piston is in rear position.
15. Remove screw and stat-o-seal from both front and rear holes.
16. Gently push piston in until it stops.
17. If fluid is not at top of rear hole, attach 4oz. bottle (745163) and repeat step 7.
18. Remove 4oz. bottle assy. (745163), replace rear screw and stat-o-seal.
19. Attach 4oz. bottle assy. (745163) to front hole, connect air.
20. Cycle 10 times, remove 4oz. bottle assy. (745163), replace screw and stat-o-seal.
21. Repeat step 13.

CAUTION: Use CAUTION when removing screws and 4oz bottle assy. hydraulic fluid may be under pressure.

WARNING: Failure to follow these instructions carefully may result in severe personal injury.



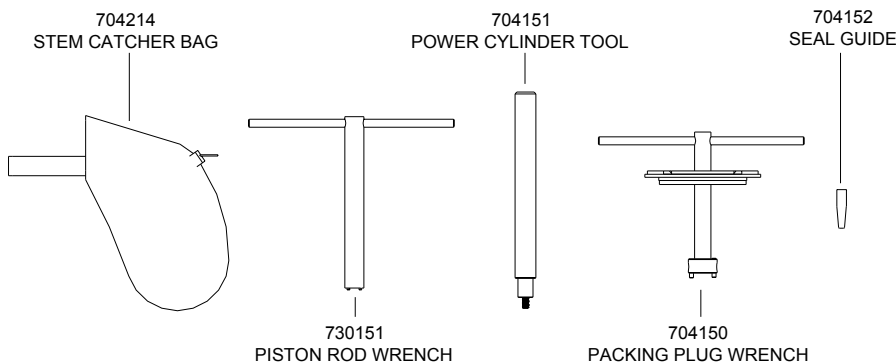
TROUBLE SHOOTING

Providing all maintenance conditions have been met, follow this systematic approach to diagnosis.

1. MORE THAN ONE PULL IS REQUIRED TO BREAK RIVET.
 - a) Tool needs to be bled. (See filling and bleeding instructions.)
 - b) Spring has fatigued, replace.
 - c) Jaws are stripped or packed with chips. Clean or replace.
 - d) Incorrect nose tip.
2. SLOW OR PARTIAL OPERATION WHEN THE TRIGGER IS DEPRESSED
 - e) Head Piston Rings (405757) and (401113) could be worn or damaged. Replace.
 - f) Piston Rod Rings (S945) and (401102) could be worn or damaged. Replace.
 - g) Muffler (704146) or filter inside spool (703142) may be plugged with dirt. Clean thoroughly and back-blow with compressed air.
 - h) Hole in metering screw in valve spool (703142) may be blocked or damaged. Hole diameter should be .028". Clear and size or replace.
3. NO OPERATION WHEN TRIGGER IS DEPRESSED
 - a) Tool seized due to mechanical failure or damaged parts.
4. OIL LEAKAGE
 - a) **DO NOT** OPERATE WITH OIL LEAKING FROM TOOL. HIGH PRESSURE OIL MAY CAUSE SEVERE PERSONAL INJURY.
 - b) Any oil leaking externally should be traced to its source. An o'ring or seal that leaks should be replaced.
5. AIR BYPASS FROM VALVE HOUSING
 - a) If the spring (704141) breaks or dislodges, air will flow freely through the muffler (704146). Replace or reset. Valve spring installation tool (704162) is recommended.
 - b) Check o'rings on valve sleeve (703139), valve spool (703142), and valve plug (704145). If worn or damaged, replace. Valve sleeve removal tool (704163) is recommended.
6. FASTENER STEM JAMMED IN NOSE ASSEMBLY
 - a) Nose assembly components require service. **DISCONNECT AIR FROM TOOL**, remove the nose from the tool and disassemble. Replace worn or broken parts. Clean the surface the jaws ride on.
 - b) Stems lodged side by side in the follower. Disassemble, remove stems, and reassemble.
 - c) Incorrect follower.

OVERHAUL

The disassembly and re-assembly procedure can be accomplished by utilizing the following instructions and drawings. Use extreme care during disassembly and re-assembly not to mar or nick any smooth surface that comes in contact with seals. Before installing seals, always apply a good lubricant, such as Lubriplate, to the surfaces. It is recommended that tool kit (GBP730CTK) be used to facilitate overhaul. A complete overhaul can be achieved by the use of Service Kit 730905 which contains a complete set of o'rings, back-up rings, screws, washers and gasket.



GBP730CTK Service Tool Kit

Part No.	Description
730151	Piston Rod Wrench
704150	Packing Plug Wrench
704151	Power Cylinder Tool
704152	Seal Guide
745163	Fill Bottle Assembly (Not Shown)
S1178	Valve Extractor (Not Shown)
704162	Valve Spring Installation Tool (Not Shown)
704163	Valve Sleeve Removal Tool (Not Shown)

WARNING

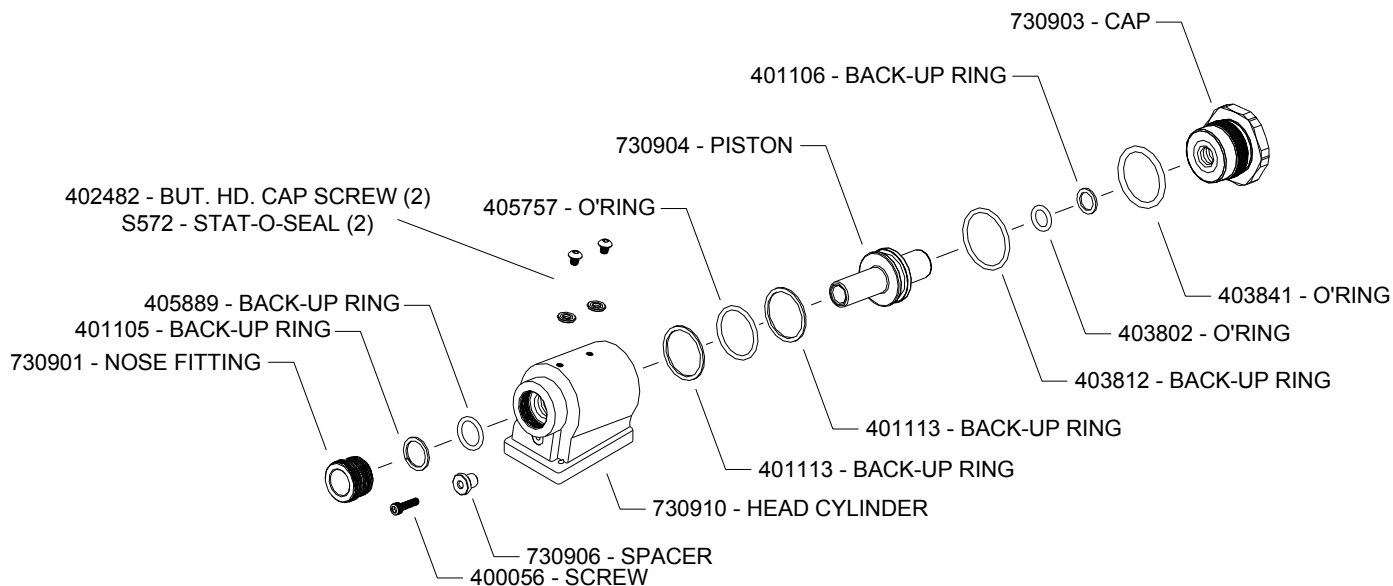
DEPRESS TRIGGER AND DISCONNECT FROM AIR WITH HEAD PISTON IN THE REAR POSITION BEFORE OVERHAUL. SEVERE PERSONAL INJURY MAY OCCUR IF AIR HOSE IS NOT DISCONNECTED. **USE CAUTION** WHEN FORCING PISTON ROD ASSEMBLY DOWNWARD WITH HEAD CYLINDER ASSEMBLY REMOVED, HYDRAULIC FLUID WILL EJECT FORCIBLY FROM HANDLE.

HEAD

Remove nose assembly from tool before attempting disassembly of head assembly.

Remove end cap (730903). Push against threaded end of head piston (730904) to slide it out of head cylinder (730910). Be careful not to damage threads or cause burrs on polished piston rod surface.

The re-assembly sequence is the opposite of disassembly. (See Filling and Bleeding instructions.) Apply Loctite #242 and torque the four button-head cap screws (A-928) uniformly to 40 inch lbs. to prevent leakage around the gasket.



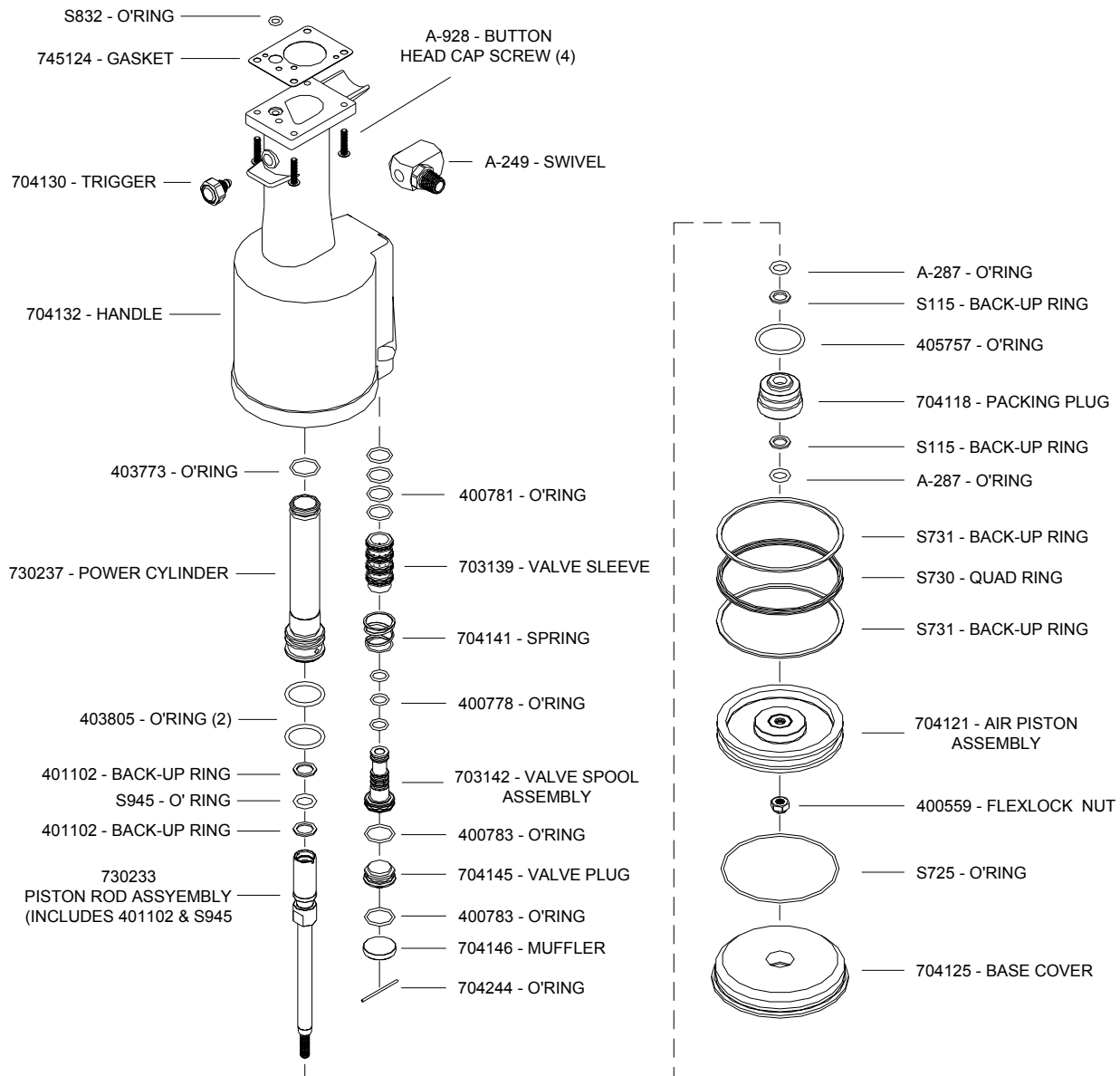
HANDLE

To inspect air cylinder bore, remove base cover (704125). Any further disassembly will require removal of the head cylinder (730902) first. For complete disassembly, start by removing base cover (704125). Next, holding tool upright, remove four button-head cap screws (A-928). Lift head cylinder (730902) from handle (704132) and set aside o-ring (S832) and gasket (745124). Empty all hydraulic fluid into a container. Place piston rod wrench (730151) down into top of power cylinder (730237), into slot of piston rod assy. (730233). While holding this wrench, remove flexlock nut (400059) using a 7/16" socket wrench. Still holding piston rod wrench, remove air piston (704121) using packing plug wrench (704150), by turning counterclockwise. When air piston is completely free from piston rod, tap or push on the piston rod wrench to eject air piston from bottom of handle. After removal of air piston, slide piston rod (730233) back up to the end of its travel. Using packing plug wrench (704150) remove packing plug (704118). With packing plug removed, power cylinder (730237) can be removed by pushing on power cylinder tool (704151) when inserted into top of power cylinder.

To reassemble the handle, reverse the above procedure, being certain that all o-rings are properly lubricated before installation. Torque packing plug (704118) to 45 foot lbs. Attach the seal guide (704152) to the piston rod (730233) and tap the piston rod through the packing plug (704118). Attach air piston (704121) and flexlock nut (400059) torque flexlock nut to 40 inch lbs. Attach air piston (704121) to piston rod (730233). With the piston rod in the down position, fill oil passage on top of handle with automatic transmission fluid, ATF220 or equivalent, when looking at top of handle the oil passage is the hole that has a counterbore for S832 o-ring. Replace gasket (745124) and o-ring (S832), just prior to replacing head cylinder (730902). (See Filling & Bleeding instructions).

AIR VALVE

To disassemble, first disconnect tool from its air source. Remove pin (704244) and muffler (704146). Insert valve extractor (S1178) into end of valve plug (704145) and pull it out. Using the same procedure, pull out spool (703142). NOTE: It should never be necessary to remove valve sleeve (703139) unless the ports in the sleeve are plugged from contaminated air. If ports are plugged, use needle nose pliers to grasp end of spring (704141), turning clockwise and pulling to dislodge from groove in casting. NOTE: 704162 valve spring tool will facilitate the proper installation of the spring (704141), valve sleeve (703139) can be pulled out using valve sleeve removal tool 704163.



GBP730EOS SELECTION CHART

FASTENER	DIA.	STANDARD	STRADDLE NOSE (2)	LONG
LOCKBOLT, NAS SHEAR PULL TYPE, NAS TENSION PULL TYPE, NASS = SHEAR & GP NAST = TENSION	5/32" 3/16" 1/4"	NAST05-204B-25OS NASS05-204B-25OS NAS06-204B-25OS NAS08-204B-25OS	NAST05-204B-30OS NASS05-204B-30OS NAS06-204B-30OS NAS08-204B-30OS	NAST05-204B-34OS NASS05-204B-34OS NAS06-204B-34OS NAS08-204B-34OS
MGP	4mm 5mm	MGP4-204B-25OS MGP5-204B-25OS	MGP4-204B-30OS MGP5-204B-30OS	MGP4-204B-34OS MGP5-204B-34OS
Lightweight Groove Proportion LOCKBOLT	5/32" 3/16" 1/4"	LGP05-204B-25OS LGP06-204B-25OS LGP08-204B-25OS	LGP05-204B-30OS LGP06-204B-30OS LGP08-204B-30OS	LGP05-204B-34OS LGP06-204B-34OS LGP08-204B-34OS
MLGP	4mm 5mm	MLGP4-204B-25OS MLGP5-204B-25OS	MLGP4-204B-30OS MLGP5-204B-30OS	MLGP4-204B-34OS MLGP5-204B-34OS
SINGLE ACTION BLIND RIVET NAS1919S & U, NAS1921S & U	1/8" 5/32" 3/16" 1/4"	SMLS04-204C-27OS SMLS05-204C-27OS SMLS06-204C-27OS SMLS08-204C-27OS		SMLS04-204C-37OS SMLS05-204C-37OS SMLS06-204C-37OS SMLS08-204C-37OS
SINGLE ACTION BLIND BOLT MS90353S & U, MS90354S & U MS12140S & U, MS21141S & U	5/32" 3/16" 1/4"	SB05-204C-27OS SB06-204C-27OS SB08-204C-27OS		SB05-204C-37OS SB06-204C-37OS SB08-204C-37OS
BACR15FR-FP, BACR16GF-GK, NAS1919U & 1921U, NAS9301-9312	1/8" 5/32" 3/16" 1/4"	456MAX-204A-27 (1) 08MAX-204C-27OS		456MAX-204A-37 (1) 08MAX-204C-37OS
"A" CODE NAS1398A & NAS1399A	1/8" 5/32" 3/16" 1/4"	4A-204C-27OS 5A-204C-27OS 6A-204C-27OS SMLS08-204C-27OS		4A-204C-37OS 5A-204C-37OA 6A-204C-37OS SMLS08-204C-37OS
ASP 2, ASP PF, ASP 4 FF, ASP 2 F, ASP 2 LC	13/64" 17/64" 21/64"	ASP06-204C-27OS ASP08-204C-27OS ASP10-204C-27OS		ASP06-204C-37OS ASP08-204C-37OS ASP10-204C-37OS
NAS1719, NAS1720, NAS1721 & MBC	1/8" 5/32" 3/16"	MBC04-204C-27OS MBC05-204C-27OS MBC06-204C-27OS		MBC04-204C-37OS MBC05-204C-37OS MBC06-204C-37OS
GROUND STUD, BACS53B	13/64" 17/64"	GS8-204C-32OS GS10-204C-32OS		GS8-204C-42OS GS10-204C-42OS

THE GBP730EOS IS APPROVED TO INSTALL THE ABOVE FASTENERS.

1) INSTALLS 1/8", 5/32" AND 3/16" DIAMETERS.

2) -30 STRADDLE NOSES ARE DESIGNED TO REACH OVER THE COLLAR.

NOTE: TO REDUCE STROKE TO .375 UNLOADING VALVE (206110) AND STROKE LIMITER (206112) ARE AVAILABLE.

NOTE: THE LAST 2 DIGITS OF THE NOSE ASSEMBLY REPRESENTS THE LENGTH THE NOSE ASSEMBLY EXTENDS FROM THE TOOL. (I.e. -25 = 2.5 inches)

GAGE BILT



DECLARATION OF CONFORMITY

WE DECLARE THAT THE EQUIPMENT SPECIFIED HEREIN
CONFORMS TO THE FOLLOWING STANDARDS AND DIRECTIVES.

EN292 part 1 and part 2

ISO 8662 part 1

ISO 3744

COUNCIL DIRECTIVE: 89/392/EEC, 91/368/EEC

93/44/EEC, 93/68/EEC

EQUIPMENT DESCRIPTION:

GBP700 SERIES FASTENER INSTALLATION TOOLS

MANUFACTURER:

GAGE BILT PRODUCTS CORP.

SIGNATURE:

NAME: BRUCE T. GODFREY

CHAIRMAN

WARREN, MI U.S.A.

JUNE 2003

WARRANTY

Seller warrants that all goods covered by this catalog will conform to applicable specifications and will replace, or repair, F.O.B. our plant, any goods providing defective from faulty workmanship, or material, for 90 days from date of shipment.

Said warranty to remain in effect if and only if such goods are used in accordance with all instructions as to maintenance, operation, and use set forth in manuals and instruction sheets furnished by seller.

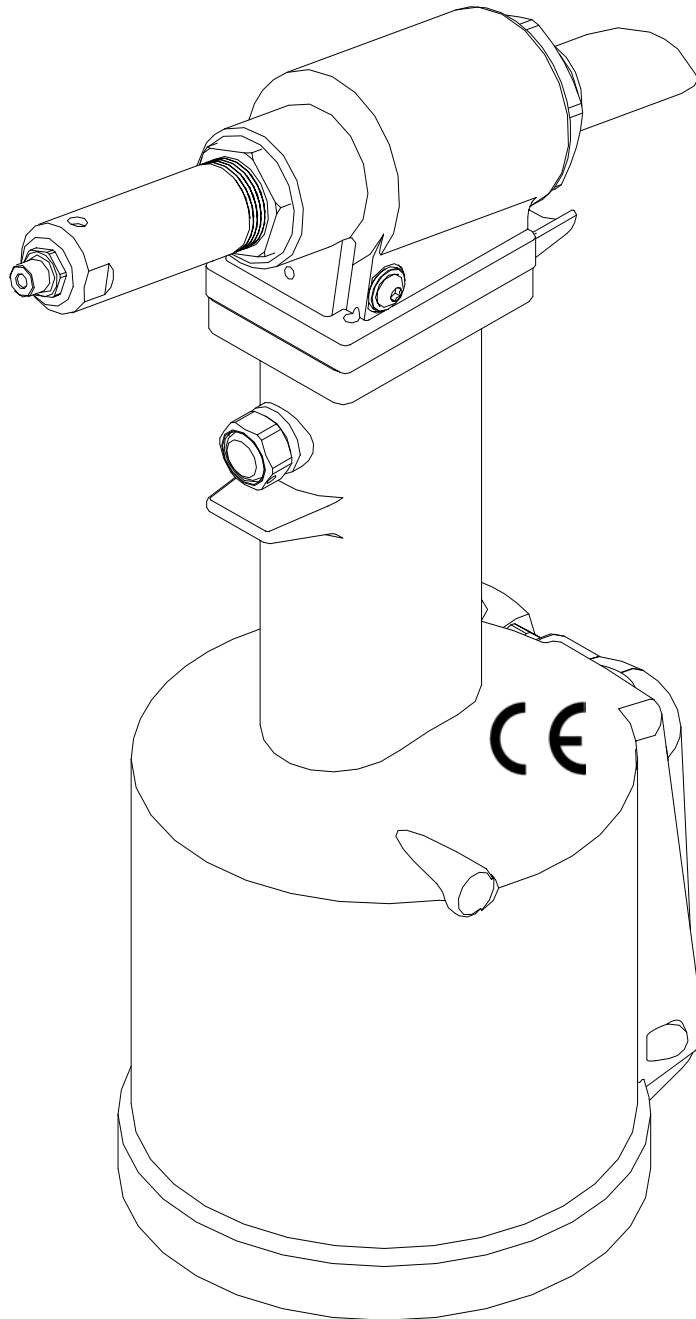
Sellers obligation under this warranty shall be limited to the repair or rework of the goods supplied or replacement thereof, at Seller's option, and in no case is to exceed the invoice value of said goods. Under no circumstances will seller be liable for incidental or consequential damages or for damages incurred by the buyer or subsequent user in repairing or replacing defective goods or if the goods covered by this warranty are reworked or subjected to any type of additional processing.

This warranty is void if Seller is not notified in writing of any rejections or defects within 90 days after the receipt of the material by the customer.

THIS WARRANTY IS MADE IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY.

GBP743C

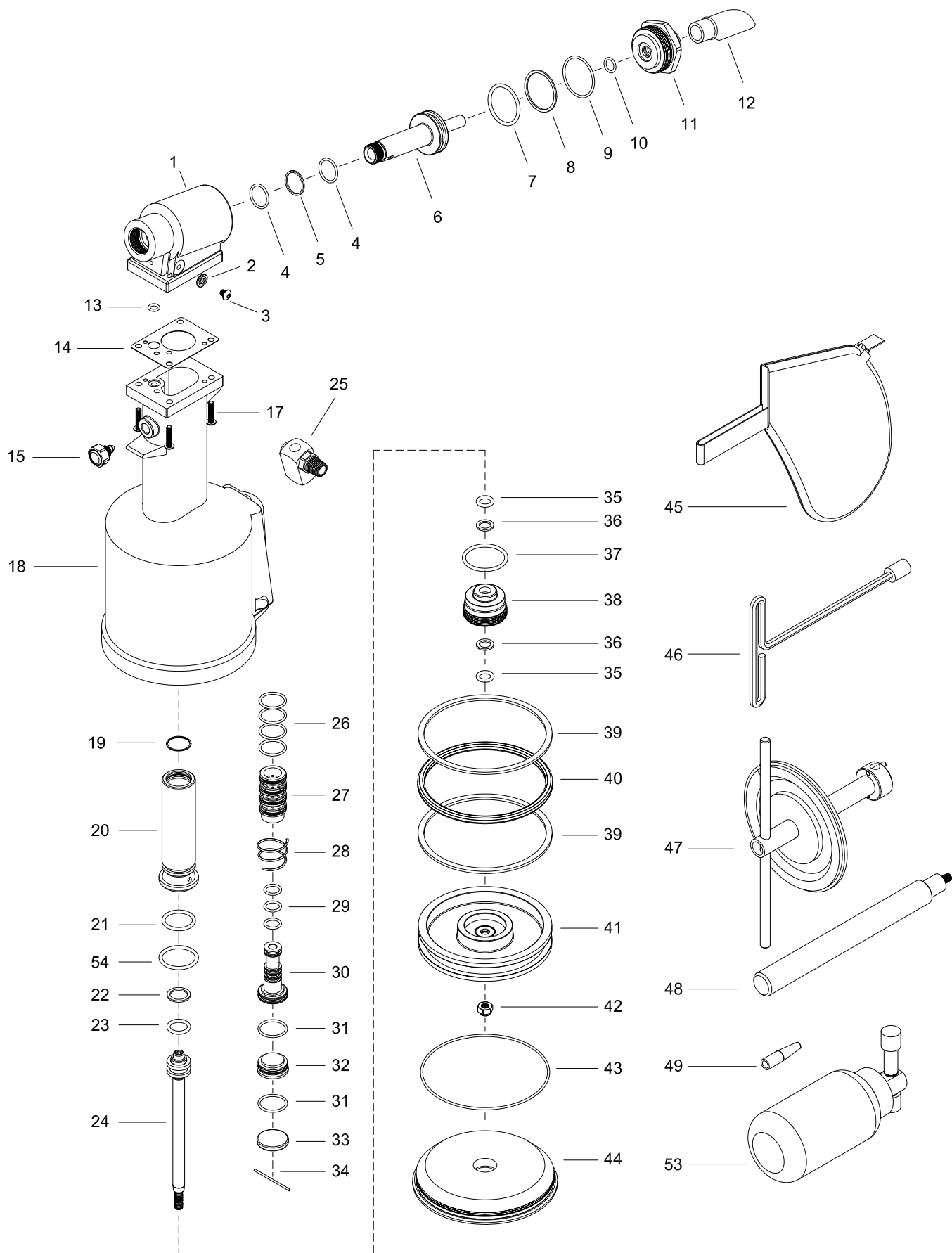
INSTALLATION TOOL



GAGE BILT
MADE IN U.S.A.

GAGE BILT PRODUCTS CORP.

14500 Barber Drive (586) 771-7664
Warren, Mi 48088 (586) 771-2665 Fax
e-mail: solutions@gagebilt.com / www.gagebilt.com



GBP743C Parts List

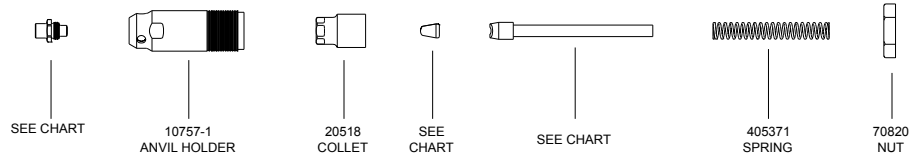
Ref. No.	Part Number	Description	Qty.
1	743108	Head Cylinder Assembly	1
2*	S572	Stat-O-Seal	1
3*	402482	Button Head Socket Screw	1
4*	S834	O'Ring	2
5*	401089	Back-Up Ring	1
6	743307	Piston	1
7*	A-269	O'Ring	1
8*	401114	Back-Up Ring	1
9*	400792	O'Ring	1
10*	S829	O'Ring	1
11	743114	Cap	1
12	200232	Deflector	1
13*	S832	O'Ring	1
14*	704129	Gasket	1
15	704130	Trigger Assembly (Inc. 16)	1
16*	400773	O'Ring	1
17*	402479	Button Head Cap Screw	4
18	744129	Handle	1
19*	S885	Retaining Ring	1
20	743131	Power Cylinder	1
21*	403805	O'Ring	1
22*	S908	Back-Up Ring	1
23*	A-201	O'Ring	1
24	744136	Piston Rod Assembly (Inc. 22 & 23)	1
25	A-249	Swivel	1
26*	400784	O'Ring	4
27	743144	Valve Sleeve	1
28*	744144	Spring	1
29*	400779	O'Ring	3
30	743142	Valve Spool Assembly	1
31*	400785	O'Ring	2
32	744142	Valve Plug	1
33*	744143	Muffler	1
34*	744149	Pin	1
35*	A-287	O'Ring	2
36*	S115	Back-Up Ring	2
37*	A-271	O'Ring	1
38	744118	Packing Plug	1
39*	S909	Back-Up Ring	2
40*	401462	Quad Ring	1
41	744121	Air Piston Assembly	1
42*	400559	Flexlock Nut	1
43*	S12	O'Ring	1
44	744124	Base Cover	1
45**	704214	Stem Catcher Bag	1
46**	704149	Piston Rod Wrench	1
47**	704150	Packing Plug Wrench	1
48**	704151	Power Cylinder Tool	1
49**	704152	Seal Guide	1
50**	S1178	Valve Extractor	1
51**	744151	Valve Spring Installation Tool (Not Shown)	1
52**	744152	Valve Sleeve Removal Tool (Not Shown)	1
53**	704153	Air Bleeder	1
54*	S892	O'Ring	1

*Service Kit 743007 contains a complete set of O'Rings, Back-Up Rings, Screws and Gaskets.

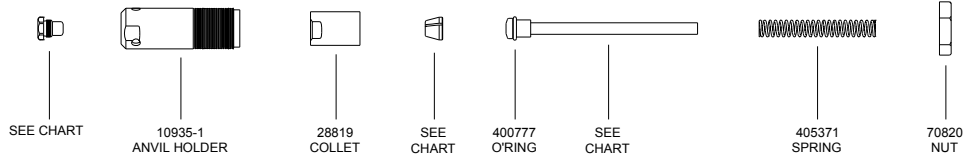
These items should be kept on hand at all times.

**Ref No. 45-53 are not furnished. 46-53 are recommended for complete tool overhaul.

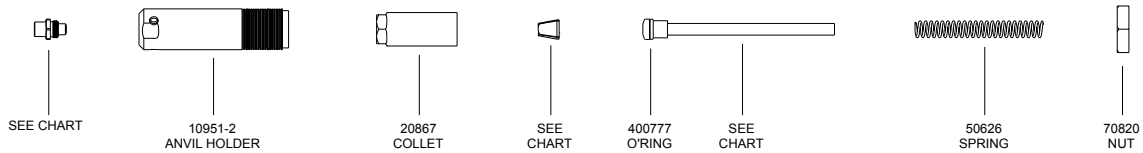
XX-703-18



XX-734-20



XX-743-24



RIVET	DIA.	NOSE ASSEMBLY	NOSE TIP	JAW	FOLLOWER	DESIGNATION
AVEX (1624 PROTRUDING HEAD)	3/16	AV6-743-24 ¹	10141	30824	40820	AV6
AVEX (1624 COUNTERSUNK HEAD)	3/16	6C-743-24 ¹	10141-1	30824	40820	6C
BULB-TITE (STRUCTURAL) RIVET	1/4	BT08-743-24 ¹	10391	30824	40820	BT08
	9/32	BT09-743-24 ¹	10289	30824	40901	BT09
KLAMPTITE (STRUCTURAL) RIVET	3/16	6KT-743-24 ¹	10263	30824	40820	6KT
	1/4	8KT-743-24 ¹	10262	30824	40820	8KT
MACHINE SCREW RIVET	5MM	MS5M-743-24 ¹	10332	30824	40820	5MM
MONOBOLT RIVET	3/16	MB06-734A-20 ^{2,3}	10210	36801	40820	MB06
	1/4	MB08-734-20 ^{2,3}	10213	30833	40820	MB08
OPEN END CLOSED END NAIL RIVET	3/32	3N-703-18 ²	10247	30617	40307	3N
	1/8	4N-703-18 ²	10202	30617	40307	4N
	5/32	5N-703-18 ²	10203	30617	40605	5N
	3/16	6N-743-24 ¹	10204	30824	40820	6N
	1/4	8Z-743-24 ¹	10211	30824	40820	8Z
STAINLESS STEEL OPEN END, CLOSED END NAIL RIVET	5/32	5SS-743-24	10203	30849	40871	5SS
	3/16	6SS-743-24	10204	30849	40871	6SS
PLASTIC SPLIT RIVET	3/16	6P-743-24 ¹	10167	30824	40820	6P
	1/4	8P-743-24 ¹	10166	30824	40820	8P
T RIVET	3/16	6T-743-24 ¹	10209	30824	40820	6T
	1/4	8T-743-24 ¹	10286	30824	40820	8T
TLR RIVET	1/4	8TLR-743-24 ¹	10246	30824	40820	8TLR

SELECTION CHART FOR PROTRUDING HEAD ONLY

RIVET	DIA.	NOSE ASSEMBLY	NOSE TIP	JAW	FOLLOWER	DESIGNATION
MULTI-GRIP STRUCTURAL RIVET	3/16	PH6-734A-20 ^{2,3}	10248	36801	40820	PH6
	1/4	PH8-734-20 ^{2,3}	10205	30833	40820	PH8

1) YOU CAN CHANGE THE 743 NOSE ASSEMBLY (INCLUDED WITH TOOL) TO INSTALL OTHER FASTENERS BY PURCHASING NOSE TIP SHOWN AND USING APPROPRIATE FOLLOWER SHOWN.

2) NOSE ASSEMBLIES WITH A 703 AND 734 DESIGNATION, I.E. 5N-703-18, MUST BE ORDERED AS COMPLETE NOSE ASSEMBLY.

3) NOSE ASSEMBLIES WITH A 734 DESIGNATION, I.E. PH6-734-20, ARE FOR SERRATED STEM RIVETS ONLY. IF YOU ARE PULING BOTH SMOOTH AND SERRATED STEM RIVETS YOU MUST ORDER THE NOSE ASSEMBLY WITH A 743 DESIGNATION, I.E. MGL06-743-24.

NOTE: THE LAST 2 DIGITS OF THE NOSE ASSEMBLY REPRESENTS THE LENGTH THE NOSE EXTENDS FROM THE TOOL I.E. -20 = 2.0 INCHES

GAGE BILT



DECLARATION OF CONFORMITY

WE DECLARE THAT THE EQUIPMENT SPECIFIED HEREIN
CONFORMS TO THE FOLLOWING STANDARDS AND DIRECTIVES.

EN292 part 1 and part 2

ISO 8662 part 1

ISO 3744

COUNCIL DIRECTIVE: 89/392/EEC, 91/368/EEC

93/44/EEC, 93/68/EEC

EQUIPMENT DESCRIPTION:

GBP700 SERIES FASTENER INSTALLATION TOOLS

MANUFACTURER:

GAGE BILT PRODUCTS CORP.

SIGNATURE:

NAME: BRUCE T. GODFREY

CHAIRMAN

WARREN, MI U.S.A.

JUNE 2003

WARRANTY

Seller warrants that all goods covered by this catalog will conform to applicable specifications and will replace, or repair, F.O.B. our plant, any goods providing defective from faulty workmanship, or material, for 90 days from date of shipment.

Said warranty to remain in effect if and only if such goods are used in accordance with all instructions as to maintenance, operation, and use set forth in manuals and instruction sheets furnished by seller.

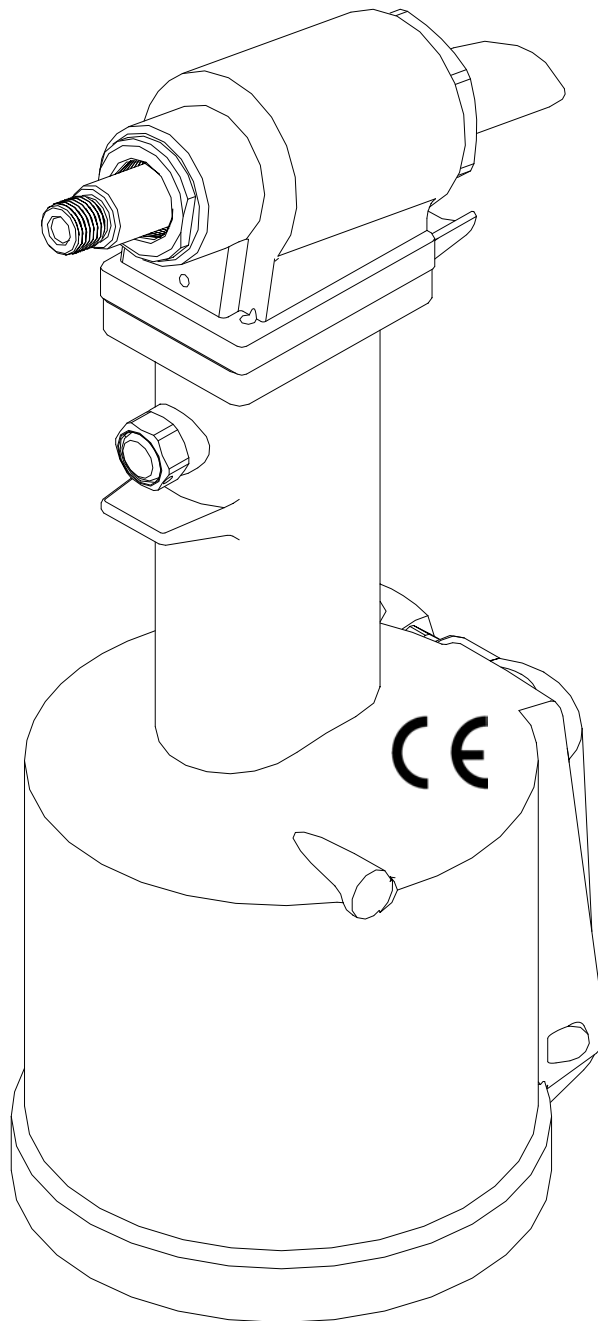
Sellers obligation under this warranty shall be limited to the repair or rework of the goods supplied or replacement thereof, at Seller's option, and in no case is to exceed the invoice value of said goods. Under no circumstances will seller be liable for incidental or consequential damages or for damages incurred by the buyer or subsequent user in repairing or replacing defective goods or if the goods covered by this warranty are reworked or subjected to any type of additional processing.

This warranty is void if Seller is not notified in writing of any rejections or defects within 90 days after the receipt of the material by the customer.

**THIS WARRANTY IS MADE IN LIEU OF ALL OTHER WARRANTIES,
EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY.**

GBP744D

INSTALLATION TOOL



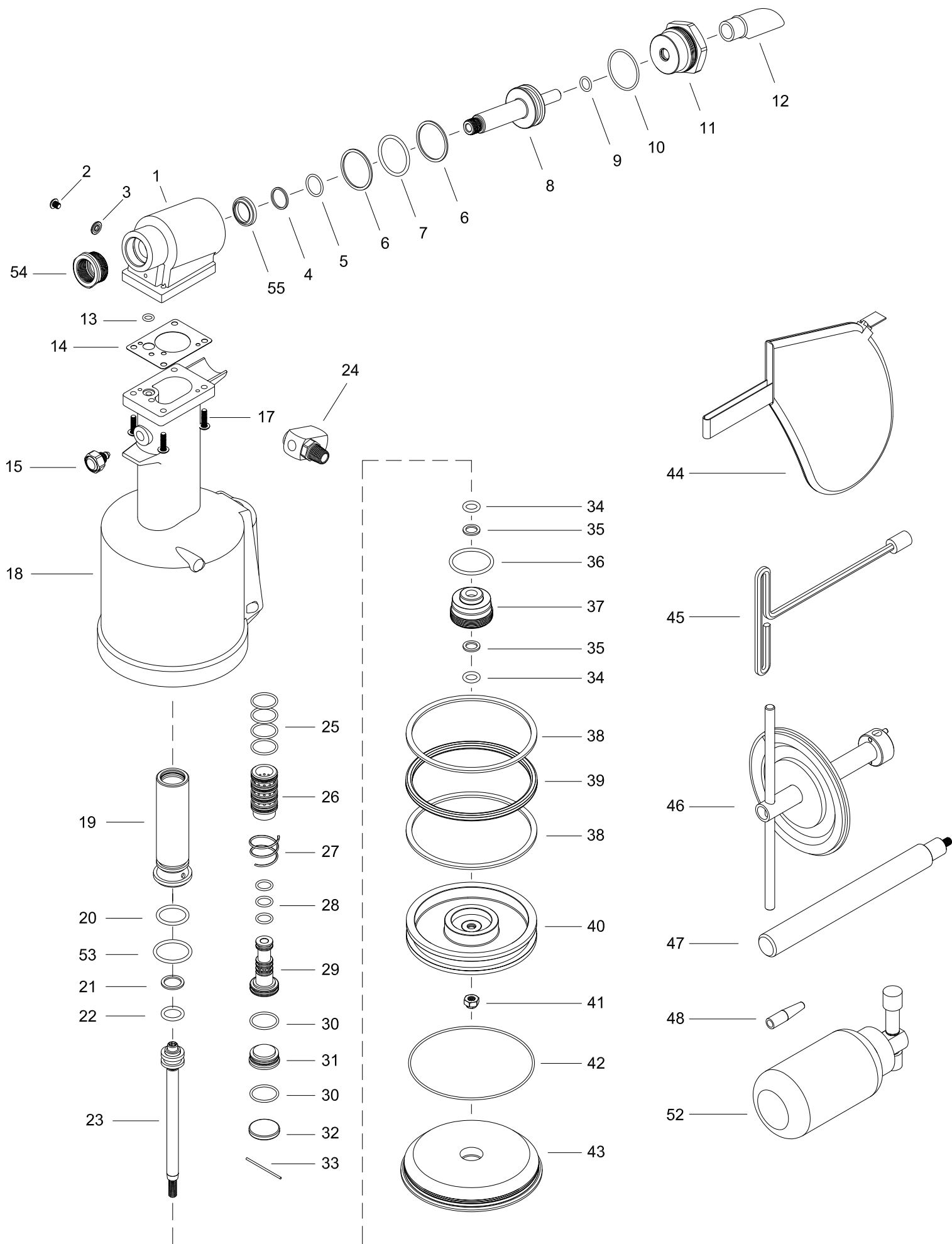
GAGE BILT
MADE IN U.S.A.

GAGE BILT PRODUCTS CORP.

14500 Barber Drive
Warren, Mi 48088

(586) 771-7664
(586) 771-2665 Fax

e-mail: solutions@gagebilt.com / www.gagebilt.com



GBP744D Parts List

Ref. No.	Part Number	Description	Qty.
1	744103	Head Cylinder Assembly	1
2*	402482	Button Head Socket Screw	1
3*	S572	Stat-O-Seal	1
4*	401088	Back-Up Ring	1
5*	A-260	O'Ring	1
6	401114	Back-Up Ring	2
7*	A-269	O'Ring	1
8*	744209	Piston	1
9*	S829	O'Ring	1
10*	400792	O'Ring	1
11	744214	Cap	1
12	200232	Deflector	1
13*	S832	O'Ring	1
14*	704129	Gasket	1
15	704130	Trigger Assembly (Inc. 16)	1
16*	400773	O'Ring	1
17*	402479	Buttont Head Cap Screw	4
18	744129	Handle	1
19	743131	Power Cylinder	1
20*	403805	O'Ring	1
21*	S908	Back-Up Ring	1
22*	A-201	O'Ring	1
23	740136	Piston Rod Assembly (Inc. 21 & 22)	1
24	A-249	Swivel	1
25*	400784	O'Ring	4
26	743144	Valve Sleeve	1
27*	744144	Spring	1
28*	400779	O'Ring	3
29	743142	Valve Spool Assembly	1
30*	400785	O'Ring	2
31	744142	Valve Plug	1
32*	744143	Muffler	1
33*	744149	Pin	1
34*	A-287	O'Ring	2
35*	S115	Back-Up Ring	2
36*	A-271	O'Ring	1
37	744118	Packing Plug	1
38*	S909	Back-Up Ring	2
39*	401462	Quad Ring	1
40	744121	Air Piston Assembly	1
41*	400559	Flexlock Nut	1
42*	S12	O'Ring	1
43	744124	Base Cover	1
44**	704214	Stem Catcher Bag	1
45**	704149	Piston Rod Wrench	1
46**	704150	Packing Plug Wrench	1
47**	704151	Power Cylinder Tool	1
48**	704152	Seal Guide	1
49**	S1178	Valve Extractor (Not Shown)	1
50**	744151	Valve Spring Installation Tool (Not Shown)	1
51**	744152	Valve Sleeve Removal Tool (Not Shown)	1
52**	704153	Air Bleeder	1
53*	S892	O'Ring	1
54*	744101	Nose Fitting	1
55*	A-523	Wiper	1

*Service Kit 744009 contains a complete set of O'Rings, Back-Up Rings, Screws and Gaskets.

These items should be kept on hand at all times.

**Ref No. 44-53 are not furnished. 45-52 are recommended for complete tool overhaul.

GBP744D SELECTION CHART

NOSE ASSEMBLY

FASTENER	DIA.	Straight	Right Angle	Offset
CHERRYMAX®	1/8	456MAX-701-17 ^{1,2}	456MAX-753-54 ^{1,2}	456MAX-763A-43 ^{1,2}
ALLMAX®	5/32	456MAX-744-20 ¹		456MAX-744-50OS ¹
HUCKMAX®	3/16	456MAX-749-35 ^{1,2,3}		
HUCK-CLINCH®	1/4	08MAX-744-20		08MAX-744-50OS
MIL-R-7885				
NAS9301-9312				
BACR15FR/FR				
BACR15GJ/GK				

- 1) ALL THREE DIAMETERS CAN BE INSTALLED WITH ONE NOSE ASSEMBLY.
- 2) NOSE ASSEMBLIES REQUIRE THE 744704 ADAPTER.
- 3) FRONT END EJECTING NOSE ASSEMBLY.
- 4) RIGHT ANGLE NOSE ASSEMBLY MAY REQUIRE MORE THAN 1 PULL.

CHERRYMAX® IS A REGISTERED TRADEMARK OF CHERRY TEXTRON.
HUCKMAX® & HUCK-CLINCH® ARE A REGISTERED TRADEMARK OF HUCK INT'L. INC.
ALLMAX® IS A REGISTERED TRADEMARK OF ALLFAST FASTENING SYSTEMS.

GAGE BILT



DECLARATION OF CONFORMITY

WE DECLARE THAT THE EQUIPMENT SPECIFIED HEREIN
CONFORMS TO THE FOLLOWING STANDARDS AND DIRECTIVES.

EN292 part 1 and part 2

ISO 8662 part 1

ISO 3744

COUNCIL DIRECTIVE: 89/392/EEC, 91/368/EEC

93/44/EEC, 93/68/EEC

EQUIPMENT DESCRIPTION:

GBP700 SERIES FASTENER INSTALLATION TOOLS

MANUFACTURER:

GAGE BILT PRODUCTS CORP.

SIGNATURE: 

NAME: BRUCE T. GODFREY
CHAIRMAN
WARREN, MI U.S.A.
JUNE 2003

WARRANTY

Seller warrants that all goods covered by this catalog will conform to applicable specifications and will replace, or repair, F.O.B. our plant, any goods providing defective from faulty workmanship, or material, for 90 days from date of shipment.

Said warranty to remain in effect if and only if such goods are used in accordance with all instructions as to maintenance, operation, and use set forth in manuals and instruction sheets furnished by seller.

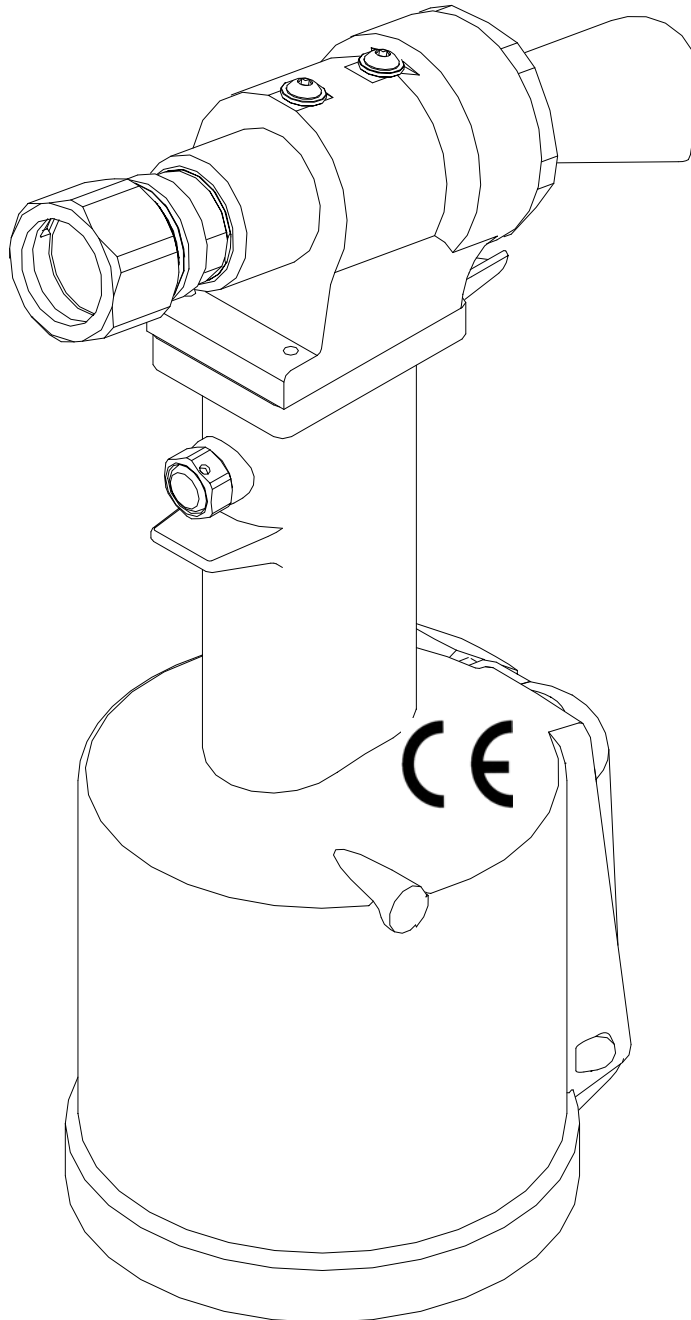
Sellers obligation under this warranty shall be limited to the repair or rework of the goods supplied or replacement thereof, at Seller's option, and in no case is to exceed the invoice value of said goods. Under no circumstances will seller be liable for incidental or consequential damages or for damages incurred by the buyer or subsequent user in repairing or replacing defective goods or if the goods covered by this warranty are reworked or subjected to any type of additional processing.

This warranty is void if Seller is not notified in writing of any rejections or defects within 90 days after the receipt of the material by the customer.

**THIS WARRANTY IS MADE IN LIEU OF ALL OTHER WARRANTIES,
EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY.**

GBP745D

INSTALLATION TOOL

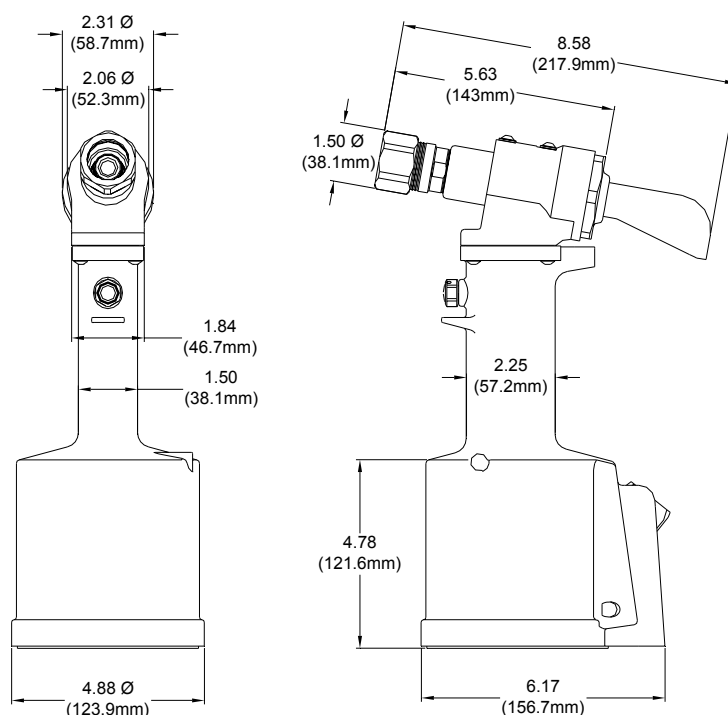


GAGE BILT
MADE IN U.S.A.

GAGE BILT PRODUCTS CORP.
14500 Barber Drive (586) 771-7664
Warren, Mi 48088 (586) 771-2665 Fax
e-mail: solutions@gagebilt.com / www.gagebilt.com

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SPECIFICATIONS

Hand Held Weight	- 7.20 lbs.
Air pressure req'd	- 90-120 p.s.i.
Air consumption	- .29 SCF/cycle (8.21 L/cycle)
Hydraulic fluid	- Automatic Transmission Fluid, Dextron III, or equivalent.
Setting stroke	- .620"
Noise level	- Less than 80 dB (A)
Rated pull load	- 6,300 lbs.
Vibration	- less than 2.5 M/S ²



NOTE:

PLEASE READ THIS MANUAL BEFORE SERVICING OR USING THIS TOOL. COMPLETE WITH WARNINGS AND CAUTIONS TO PREVENT SEVERE PERSONAL INJURY OR DAMAGE THE TOOL.



CAUTION:

GAGE BILT TOOLS ARE APPROVED TO INSTALL HUCK®, AVDEL®, CHERRY®, POP® AND OTHER FASTENERS WHEN USED BY PERSONS WITH SPECIFIC TRAINING OF BLIND RIVET AND LOCKBOLT INSTALLATION EQUIPMENT.

WARNING

Do not pull fastener unless it is placed in an assembly, pin will eject forcibly when pintail breaks off. Severe personal injury may result.

WARNING

Do not operate without Stat-O-Seal (S572) and cap screw (745107). Pressurized hydraulic fluid may cause severe personal injury.

WARNING

When operating installation equipment always wear approved eye protection. Do not look in front of nose assembly or rear of tool when installing fastener.

WARNING

Always disconnect tool from power before performing any maintenance to any tool or nose assembly. Insure that all connections are proper and there are no visible leaks from tool or hoses before connecting to power.

WARNING

Do not operate if deflector, bottle, catcher bag or vacuum tube is removed or damaged, broken pintails may eject forcibly from rear of tool. Severe personal injury may result.

CAUTION

Insure that nose assembly and tip are properly matched for the fastener being installed.

WARNING

Installation of fasteners may exceed acceptable noise levels. Use approved hearing protection.

WARNING

Be sure there is adequate clearance for tool and operator's hands before proceeding. Keep fingers clear of any moving parts. Keep fingers clear from fasteners and installed materials. Severe personal injury may result.

CAUTION

Keep Nose Assemblies clean and free of chips and debris.

DESCRIPTION

Covered under Patent No. 5,485,727

The GBP745D is a pneumatic-hydraulic tool designed specifically for the efficient installation of a wide range of blind rivets, lockbolts and MAGNA-GRIP® fasteners. It weighs just over 7 lbs. and can be operated in any position with one hand. It has a .620" rivet setting stroke and a rated pull load of 6300 pounds with 90 psi air pressure at the air inlet.

The GBP745D riveter operates on a wide range of air pressure, with 90 to 120 psi providing the maximum efficiency. At 90 lbs. air pressure, the GBP745D does not exceed 82 db (A) and consumes 6.0 cfm at 20 cycles per minute.

The air inlet is provided with 1/4-18 female pipe threads for accepting the user's air hose fitting.

Nose Assemblies that were designed for the model 353 installation tool mount directly on the GBP745D without the use of an adapter.

Nose Assemblies that were designed for the model 352 installation tool will attach to the GBP745D with the use of the 353352 nose assembly adapter.

NOSE ASSEMBLIES ARE NOT FURNISHED WITH THIS TOOL AND MUST BE ORDERED SEPARATELY (SEE PAGE 8).

MAINTENANCE

The performance of any tool depends upon good maintenance practices. Following these minimal requirements for service and care will extend the life of your tool.

- *Only use an air supply set at 90-120 lbs. equipped with a filter-regulator to prevent wear.

- *The tool will eventually lose some hydraulic oil. Keep the hydraulic system full and free of air by using the air bleeder (745163) on a regular basis.

- *Proper care by operator is necessary in maintaining full productivity and reducing downtime. Read all applicable tool manuals and nose assembly data sheets prior to operating tools.

- *Keep nose assemblies, especially jaws, clean and free of chips and debris.

- *For a complete overhaul, tool kit GBP745CTK is recommended.

TORQUE SPECIFICATIONS

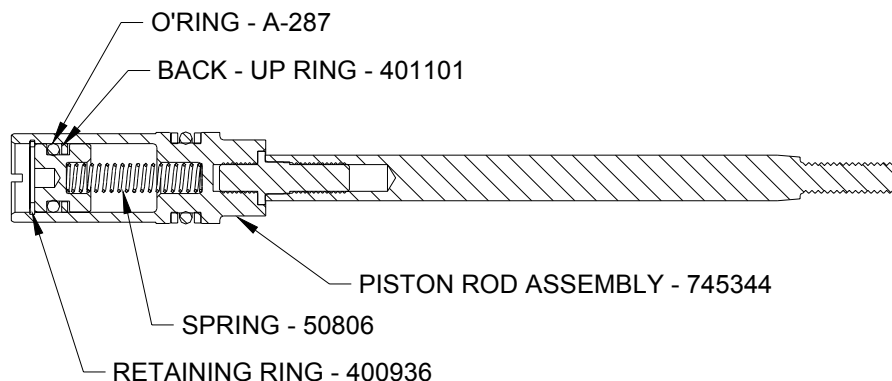
Button Head Cap Screws (402479) = 40 inch lbs.

Packing Plug (744118) = 45 foot lbs.

Flexlock Nut (400559) = 40 inch lbs.

WARNING

This tool incorporates a patented hydraulic relief valve. When overhauling tool, o'ring (A-287), back-up ring (401101), retaining ring (400936) and spring (50806) must be replaced. Failure to do so could result in **SEVERE PERSONAL INJURY!**



FILLING AND BLEEDING INSTRUCTIONS

WARNING:

Do not cycle tool without screws or bleeder bottle installed in cylinder head. Severe personal injury may occur.

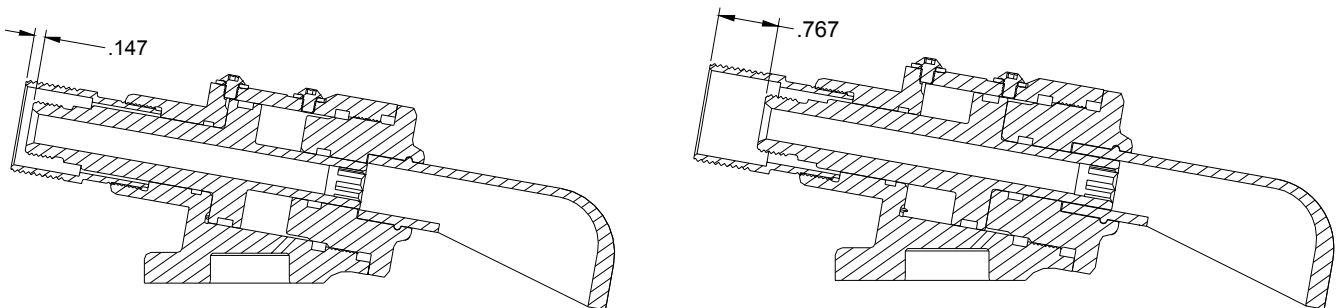
To replace a small amount of oil in the tool follow steps 19 and 20 below.

Should it become necessary to completely refill the tool (as would be required after tool has been dismantled and reassembled), take the following steps.

1. Ensure air piston is at the full bottom of stroke by pushing power piston rod down.
2. Fill power cylinder and oil passage to the top.
3. Place gasket and o'ring on top of the handle.
4. Push head piston in head cylinder until it stops.
5. Press head cylinder down on top of handle, being careful not to tear o'ring on top of power cylinder, install screws and tighten evenly.
6. Remove front screw and seal from top of head. Attach 4oz. bottle assy (745163).
7. Squeeze bottle gently until no air rises into bottle. (Be careful not to move head piston when filling with oil).
8. Remove 4oz. bottle assy. (745163) from front hole. Replace screw and stat-o-seal. Remove rear screw and stat-o-seal and attach 4 oz. bottle assy. (745163) Repeat step 7.
9. Remove 4oz. bottle assy. (745163) from rear hole, install screw and stat-o-seal.
10. Reattach 4oz. bottle assy. (745163) to front bleeder hole and connect to air.
11. Cycle tool 10 times holding trigger down for 5 seconds between cycles.
12. Remove 4oz. bottle assy. (745163), replace screw and stat-o-seal.
13. Cycle tool 10 times, check stroke (see below), if piston does not come completely forward (see below), or does not have a .620 stroke follow steps 14-21. If stroke checks O.K. and piston comes completely forward (see below) the bleeding procedure is complete. If not, continue.
14. Disconnect air while piston is in rear position.
15. Remove screw and stat-o-seal from both front and rear holes.
16. Gently push piston in until it stops.
17. If fluid is not at top of rear hole, attach 4oz. bottle (745163) and repeat step 7.
18. Remove 4oz. bottle assy. (745163), replace rear screw and stat-o-seal.
19. Attach 4oz. bottle assy. (745163) to front hole, connect air.
20. Cycle 10 times, remove 4oz. bottle assy. (745163), replace screw and stat-o-seal.
21. Repeat step 13.

CAUTION: Use CAUTION when removing screws and 4oz bottle assy. hydraulic fluid may be under pressure.

WARNING: Failure to follow these instructions carefully may result in severe personal injury.



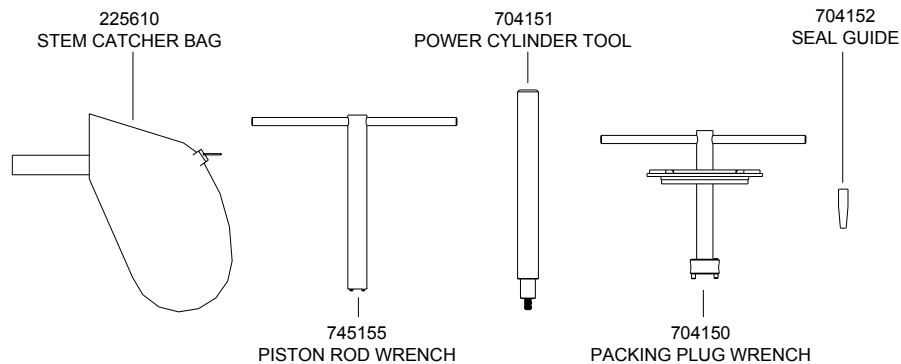
TROUBLE SHOOTING

Providing all maintenance conditions have been met, follow this systematic approach to diagnosis.

1. MORE THAN ONE PULL IS REQUIRED TO BREAK RIVET.
 - a) Tool needs to be bled. (See filling and bleeding instructions.)
 - b) Spring has fatigued, replace.
 - c) Jaws are stripped or packed with chips. Clean or replace.
 - d) Incorrect nose tip.
2. SLOW OR PARTIAL OPERATION WHEN THE TRIGGER IS DEPRESSED
 - e) Head Piston Rings (403815) and (401119) could be worn or damaged. Replace.
 - f) Piston Rod Rings (S908) and (A-201) could be worn or damaged. Replace.
 - g) Muffler (744143) or filter inside spool (743142) may be plugged with dirt. Clean thoroughly and back-blow with compressed air.
 - h) Hole in metering screw in valve spool (743142) may be blocked or damaged. Hole diameter should be .028". Clear and size or replace.
3. NO OPERATION WHEN TRIGGER IS DEPRESSED
 - a) Tool seized due to mechanical failure or damaged parts.
4. OIL LEAKAGE
 - a) **DO NOT** OPERATE WITH OIL LEAKING FROM TOOL. HIGH PRESSURE OIL MAY CAUSE SEVERE PERSONAL INJURY.
 - b) Any oil leaking externally should be traced to its source. An o'ring or seal that leaks should be replaced.
5. AIR BYPASS FROM VALVE HOUSING
 - a) If the spring (744144) breaks or dislodges, air will flow freely through the muffler (744143). Replace or reset. Valve spring installation tool (744151) is recommended.
 - b) Check o'rings on valve sleeve (743144), valve spool (743142), and valve plug (744142). If worn or damaged, replace. Valve sleeve removal tool (744152) is recommended.
6. FASTENER STEM JAMMED IN NOSE ASSEMBLY
 - a) Nose assembly components require service. **DISCONNECT AIR FROM TOOL**, remove the nose from the tool and disassemble. Replace worn or broken parts. Clean the surface the jaws ride on.
 - b) Stems lodged side by side in the follower. Disassemble, remove stems, and reassemble.
 - c) Incorrect follower.

OVERHAUL

The disassembly and re-assembly procedure can be accomplished by utilizing the following instructions and drawings. Use extreme care during disassembly and re-assembly not to mar or nick any smooth surface that comes in contact with seals. Before installing seals, always apply a good lubricant, such as Lubriplate, to the surfaces. It is recommended that tool kit (GBP745CTK) be used to facilitate overhaul. A complete overhaul can be achieved by the use of Service Kit 745010 which contains a complete set of o'rings, back-up rings, screws, washers and gasket.



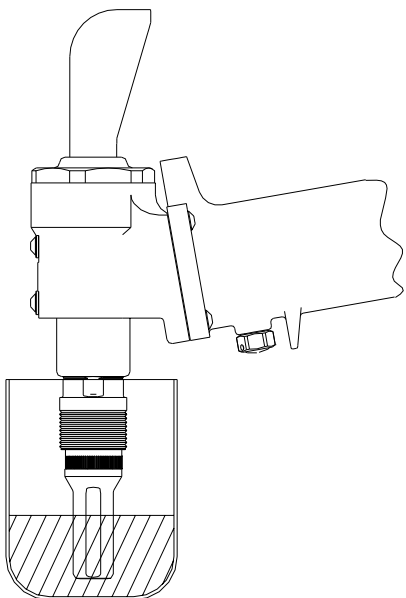
GBP745CTK Service Tool Kit

Part No.	Description
745155	Piston Rod Wrench
704150	Packing Plug Wrench
704151	Power Cylinder Tool
704152	Seal Guide
745163	Fill Bottle Assembly (Not Shown)
S1178	Valve Extractor (Not Shown)
744151	Valve Spring Installation Tool (Not Shown)
744152	Valve Sleeve Removal Tool (Not Shown)

WARNING

DEPRESS TRIGGER AND DISCONNECT FROM AIR WITH HEAD PISTON IN THE REAR POSITION BEFORE OVERHAUL. SEVERE PERSONAL INJURY MAY OCCUR IF AIR HOSE IS NOT DISCONNECTED. **USE CAUTION** WHEN FORCING PISTON ROD ASSEMBLY DOWNWARD WITH HEAD CYLINDER ASSEMBLY REMOVED, HYDRAULIC FLUID WILL EJECT FORCIBLY FROM HANDLE.

LUBRICATING AND CLEANING PROCEDURE



Daily cleaning and lubrication of nose assembly will greatly reduce downtime and increase life of components. Using sewing machine oil, or an equivalent cleaner/lubricant, follow instructions below.

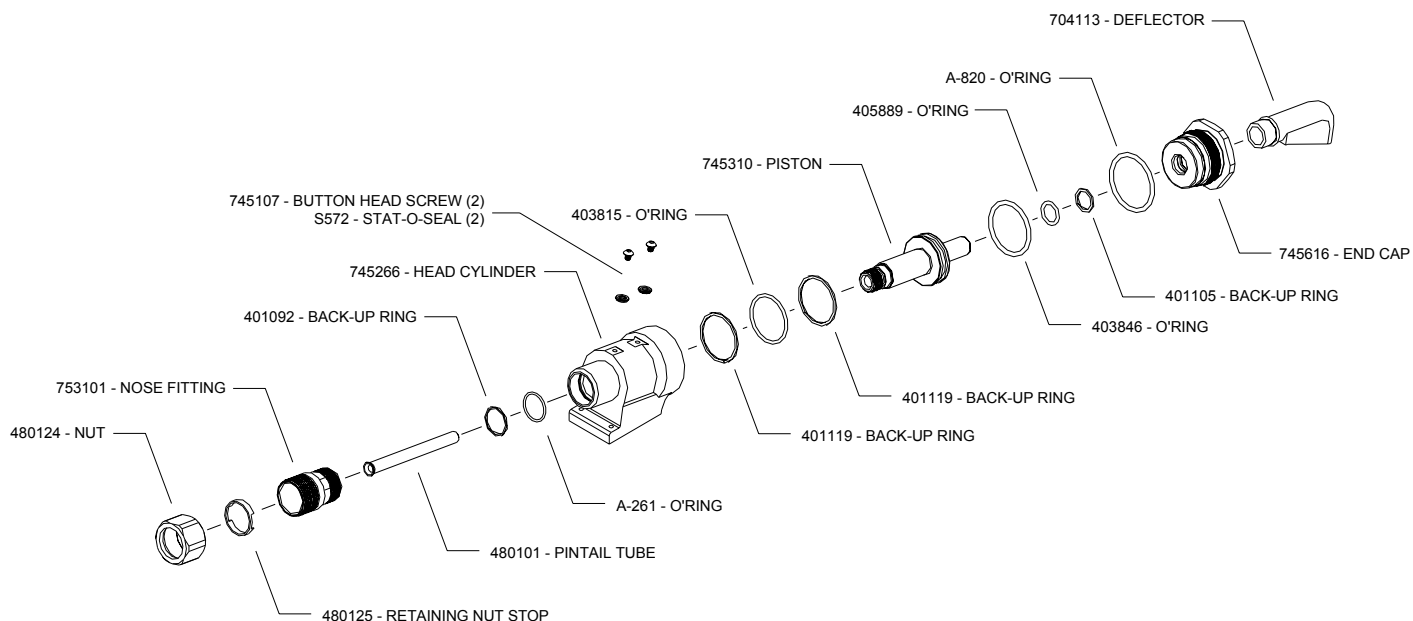
1. Disconnect tool vacuum line (if equipped).
2. Point nose assembly into oil as shown.
3. Cycle tool 8-10 times and wipe dry.

HEAD

Remove nose assembly from tool before attempting disassembly of head assembly.

Remove end cap (745616). Push against threaded end of head piston (745310) to slide it out of head cylinder (745266). Be careful not to damage threads or cause burrs on polished piston rod surface.

The re-assembly sequence is the opposite of disassembly. (See Filling and Bleeding instructions.) Apply Loctite #242 and torque the four button-head cap screws (402479) uniformly to 40 inch lbs. to prevent leakage around the gasket.



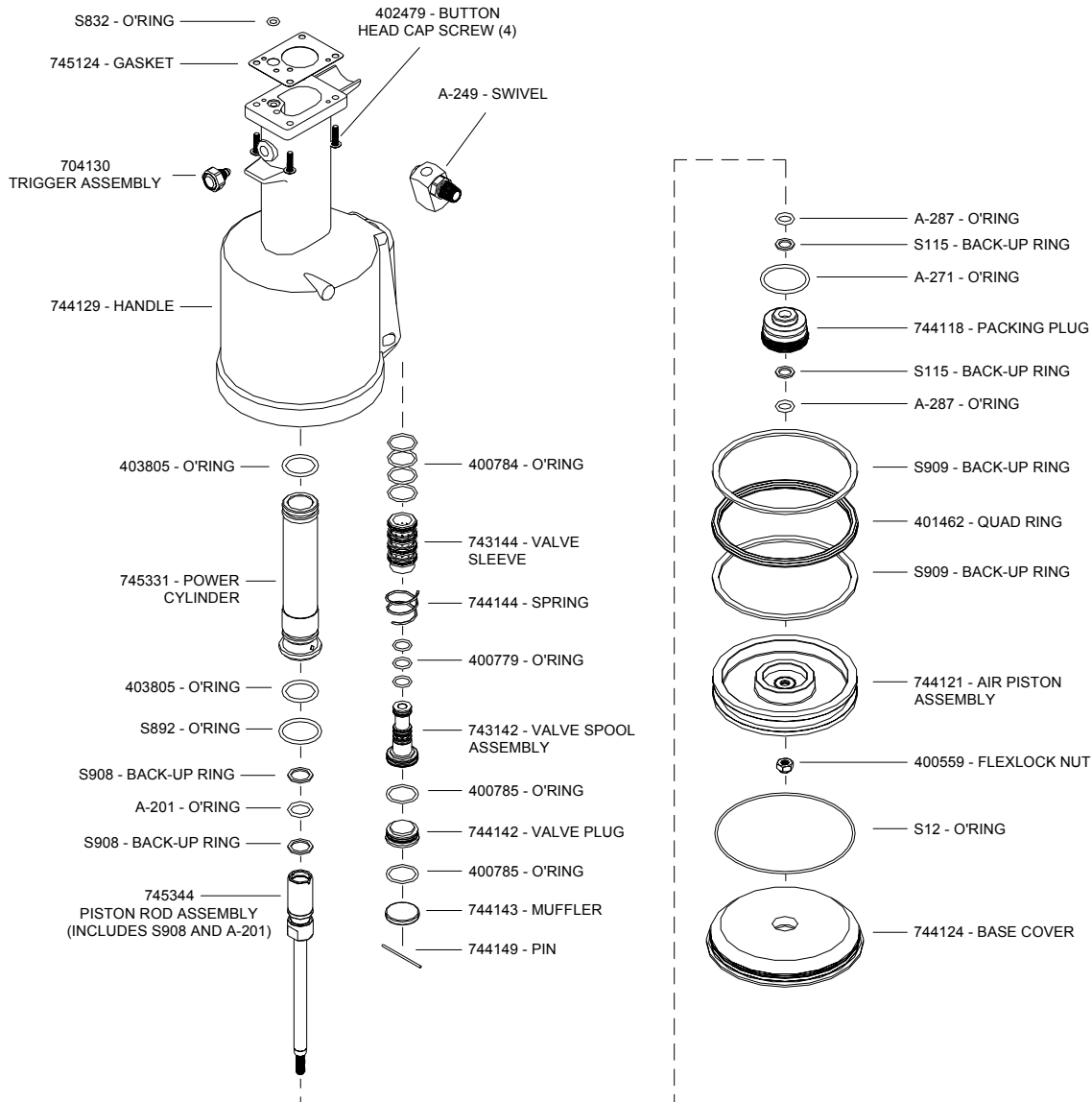
HANDLE

To inspect air cylinder bore, remove base cover (744124). Any further disassembly will require removal of the head cylinder (745266) first. For complete disassembly, start by removing base cover (744124). Next, holding tool upright, remove four button-head cap screws (402479). Lift head cylinder (745266) from handle (744129) and set aside o-ring (S832) and gasket (745124). Empty all hydraulic fluid into a container. Place piston rod wrench (745155) down into top of power cylinder (745331), into slot of piston rod assy. (745344). While holding this wrench, remove flexlock nut (400559) using a 7/16" socket wrench. Still holding piston rod wrench, remove air piston (744121) using packing plug wrench (704150), by turning counterclockwise. When air piston is completely free from piston rod, tap or push on the piston rod wrench to eject air piston from bottom of handle. After removal of air piston, slide piston rod (745344) back up to the end of its travel. Using packing plug wrench (704150) remove packing plug (744118). With packing plug removed, power cylinder (745331) can be removed by pushing on power cylinder tool (704151) when inserted into top of power cylinder.

To reassemble the handle, reverse the above procedure, being certain that all o-rings are properly lubricated before installation. Torque packing plug (744118) to 45 foot lbs. Attach the seal guide (704152) to the piston rod (745344) and tap the piston rod through the packing plug (744118). Attach air piston (744121) and flexlock nut (400559) torque flexlock nut to 40 inch lbs. Attach air piston (744121) to piston rod (745344). With the piston rod in the down position, fill oil passage on top of handle with automatic transmission fluid, ATF220 or equivalent, when looking at top of handle the oil passage is the hole that has a counterbore for (S832) o-ring. Replace gasket (745124) and o-ring (S832), just prior to replacing head cylinder (745266). (See Filling & Bleeding instructions.)

AIR VALVE

To disassemble, first disconnect tool from its air source. Remove pin (744149) and muffler (744143). Insert valve extractor (S1178) into end of valve plug (744142) and pull it out. Using the same procedure, pull out spool (743142). NOTE: It should never be necessary to remove valve sleeve (743144) unless the ports in the sleeve are plugged from contaminated air. If ports are plugged, use needle nose pliers to grasp end of spring (744144), turning clockwise and pulling to dislodge from groove in valve chamber. NOTE: 744151 valve spring tool will facilitate the proper installation of the spring (744144), valve sleeve (743144) can be pulled out using valve sleeve removal tool 744152.



SELECTION CHART FOR GBP745D

FASTENER	DIA.	STRAIGHT		*OFFSET	
'A' CODE NAS1398 & NAS1399 'A' NAS1438 & NAS1439 'A'	1/8	4A-745B-23	4A-745B-48	4A-752A-43OS	
	5/32	5A-745B-23	5A-745B-48	5A-752A-43OS	
	3/16	6A-745B-23	6A-745B-48	6A-752A-43OS	
	1/4	SMLS08-755-23	SMLS08-755-48	SMLS08-752A-43OS	
2 ASP & ASP PF ASP FF & ASP F ASP-LC	13/64	ASP06-745B-23	ASP06-745B-48	ASP06-752A-43OS	
	17/64	ASP08-745B-23	ASP08-745B-48	ASP08-752A-43OS	
	21/64	ASP10-755-23	ASP10-755-48	ASP10-204C-37OS	
BLIND OVERSIZE MANDREL	1/4	BOM08-745C-23			
COMMERCIAL LOCKBOLTS C6L ADV ELOK	3/16	NAS06-745B-12		NAS06-204B-25OS	NAS06-204B-30OS
		NAS06-755-23	NAS06-755-48	NAS06-204B-34OS	
	1/4	NAS08-745B-12		NAS08-204B-25OS	NAS08-204B-30OS
		NAS08-745B-23	NAS08-745B-48	NAS08-205A-31	NAS08-204B-34OS
	5/16	LB10-745C-26	NAS10-756-48	NAS10-205A-31	
	3/8	LB12-756-26	NAS12-756-48	NAS12-205A-31	
LIGHTWEIGHT GROOVE PROPORTION LOCKBOLTS	5/32	LGP05-745B-12		LGP05-204B-25OS	LGP05-204B-30OS
		LGP05-755-23	LGP05-755-48	LGP05-204B-34OS	
	3/16	LGP06-745B-12		LGP06-204B-25OS	LGP06-204B-30OS
		LGP06-755-23	LGP06-755-48	LGP06-204B-34OS	
	1/4	LGP08-745B-12		LGP08-204B-25OS	LGP08-204B-30OS
		LGP08-745B-23	LGP08-745B-48	LGP08-204B-34OS	LGP08-205A-31
	5/16	LGP10-745B-12			
		LGP10-756-26	LGP10-756-48	LGP10-205C-31	
LOCKBOLT NAS SHEAR PULL TYPE NAS TENSION PULL TYPE & GROOVE PROPORTION NASS = NAS SHEAR NAST = NAS TENSION	5/32	NASS05-745B-12	NAST05-745B-12	NASS05-204B-25OS	NAST05-204B-20OS
		NASS05-755-23	NAST05-755-23	NASS05-204B-30OS	NAST05-204B-30OS
		NASS05-755-48	NAST05-755-48	NASS05-204B-34OS	NAST05-204B-34OS
	3/16	NAS06-745B-12		NAS06-204B-25OS	NAS06-204B-30OS
		NAS06-755-23	NAS06-755-48	NAS06-204B-34OS	
	1/4	NAS08-745B-12		NAS08-204B-25OS	NAS08-204B-30OS
		NAS08-745B-23	NAS08-745B-48	NAS08-204B-34OS	NAS08-205A-31
	5/16	NAS10-745B-12		NAS10-205A-31	
		NAS10-755-26	NAS10-756-48		
	3/8	NAS12-745B-12		NAS12-205A-31	
		NAS12-756-26	NAS12-756-48		
MULTI-GRIP LOCKBOLT	3/16	MG06-745-48			
	1/4	MG08-745-48			
	5/16	MG10-756-28			
	3/8	MG12-756-28			
PT/MS/9SP MS20600 & MS20601	1/4	PT08-745-48			
NAS1919U & NAS1921U NAS90301-9312 BACR15FR/FP & BACR15GJ/GK M7885	1/8	456MAX-752A-21	456MAX-752A-61	456MAX-751A-43OS	
	5/32	456MAX-752A-21	456MAX-752A-61	456MAX-751A-43OS	
	3/16	456MAX-752A-21	456MAX-752A-61	456MAX-751A-43OS	
	1/4	08MAX-745B-23	08MAX-745B-48	08MAX-204C-27OS	08MAX-204C-37OS
"S" TYPE BLIND BOLT MS21140S & MS21141S MS90353S & MS90354S	5/32	SB05-745B-23	SB05-745B-48	SB05-752A-43OS	
	3/16	SB06-745B-23	SB06-745B-48	SB06-752A-43OS	
	1/4	SB08-755-23	SB08-755-48	SB08-204C-27OS	SB08-204C-37OS
	5/16	SB10-756-28	SB10-756-48	SB10-205A-35	
	3/8	SB12-756-28	SB12-756-48	SB12-205A-35	
"U" TYPE BLIND BOLT W/ LOCKING WASHER MS90353U & MS90354U MS21140U & MS21141U	5/32	UBB05-745B-23	UBB05-745B-48	UBB05-752A-43OS	
	3/16	UBB06-745B-23	UBB06-745B-48	UBB06-752A-43OS	
	1/4	UBB08-755-23	UBB08-755-48	UBB08-204C-27OS	UBB08-204C-37OS
	5/16	UBB10-756-28	UBB10-756-48	UBB10-205A-35	
	3/8	UBB12-756-28	UBB12-756-48	UBB12-205A-35	
EN6122 & UAB130-EU EN6127 & UAB6127-EU EN6128 & UAB100-EU EN6129 & UABP-EU	1/8	UAB04-745B-23	UAB04-745B-48	UAB04-752A-43OS	
	5/32	UAB568-713-21	UAB568-713-61	UAB05-752A-43OS	
	3/16			UAB06-752A-43OS	
	1/4			UAB08-204C-27OS	UAB08-204C-37OS
SINGLE ACTION BLIND RIVET NAS1919S & NAS1919U NAS1921S & NAS1621U	1/8	SMLS04-745B-23	SMLS04-745B-48	SMLS04-752A-43OS	
	5/32	SMLS05-745B-23	SMLS05-745B-48	SMLS05-752A-43OS	
	3/16	SMLS06-745B-23	SMLS06-745B-48	SMLS06-752A-43OS	
	1/4	SMLS08-755-23	SMLS08-755-48	SMLS08-752A-43OS	
UNIMATIC® SINGLE ACTION NAS1919U & NAS1621U NAS9301-NAS9312 BACR14FP/FR & BACR15GF/GK	1/8	UBR04-745B-23	UBR04-745B-48	UBR04-752A-43OS	
	5/32	UBR05-745B-23	UBR05-745B-48	UBR05-752A-43OS	
	3/16	UBR06-745B-23	UBR06-745B-48	UBR06-752A-43OS	
	1/4	UBR08-755-23	UBR08-755-48	UBR08-752A-43OS	

THE GAGE BILT GBP745D TOOL IS APPROVED TO INSTALL THE ABOVE FASTENERS

*ALL OFFSET 204 SERIES NOSES REQUIRE 353204 ADAPTER, & ALL OFFSET 205 SERIES NOSES REQUIRE 353205 ADAPTER.
1) ALL MATERIALS EXCEPT TITANIUM & STAINLESS.
2) 100 PSI REQUIRED FOR STEEL.
3) ALUMINUM ONLY.
4) 100 PSI REQUIRED FOR ALLOY (MS90353 & 4).
5) GENERAL PURPOSE LOCKBOLTS ONLY.
6) INSTALLS 5/32, 3/16 & 1/4 DIAMETERS.

NOTE: THE LAST 2 DIGITS OF THE NOSE ASSEMBLY REPRESENTS THE LENGTH THE NOSE
EXTENDS FROM THE TOOL. I.E. -20 = 2.0 INCHES

GAGE BILT



DECLARATION OF CONFORMITY

WE DECLARE THAT THE EQUIPMENT SPECIFIED HEREIN
CONFORMS TO THE FOLLOWING STANDARDS AND DIRECTIVES.

EN292 part 1 and part 2

ISO 8662 part 1

ISO 3744

COUNCIL DIRECTIVE: 89/392/EEC, 91/368/EEC

93/44/EEC, 93/68/EEC

EQUIPMENT DESCRIPTION:

GBP700 SERIES FASTENER INSTALLATION TOOLS

MANUFACTURER:

GAGE BILT PRODUCTS CORP.

SIGNATURE: 

NAME: BRUCE T. GODFREY
CHAIRMAN
WARREN, MI U.S.A.
JUNE 2003

WARRANTY

Seller warrants that all goods covered by this catalog will conform to applicable specifications and will replace, or repair, F.O.B. our plant, any goods providing defective from faulty workmanship, or material, for 90 days from date of shipment.

Said warranty to remain in effect if and only if such goods are used in accordance with all instructions as to maintenance, operation, and use set forth in manuals and instruction sheets furnished by seller.

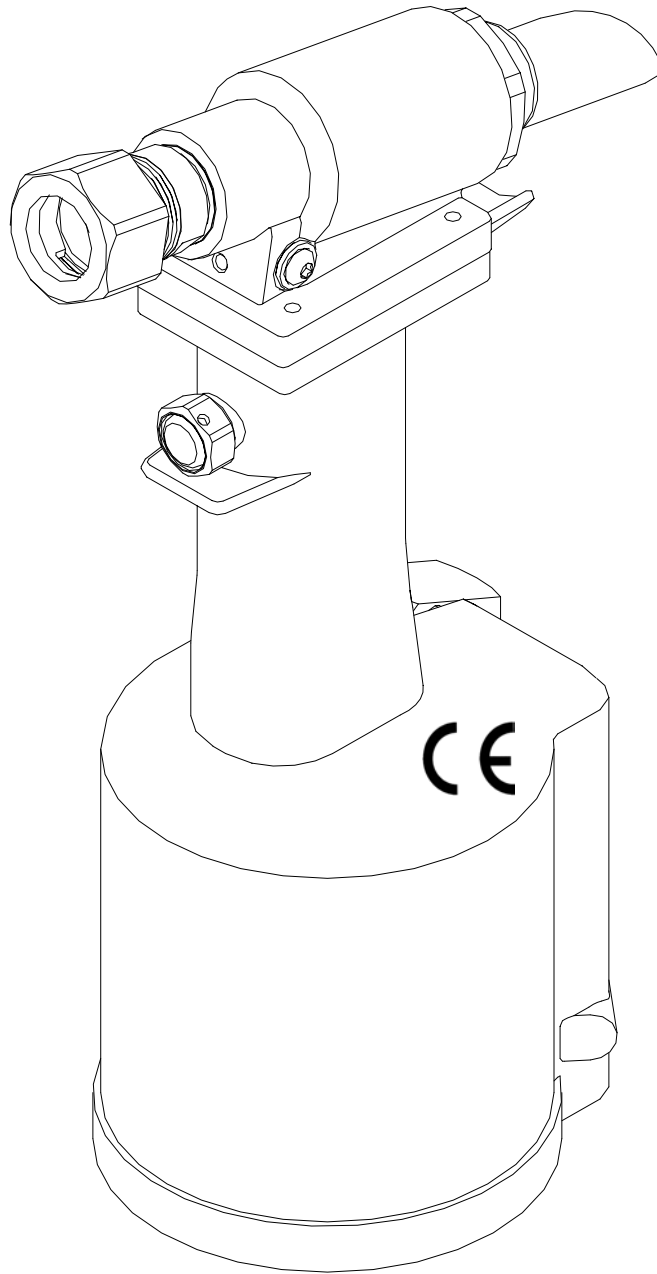
Sellers obligation under this warranty shall be limited to the repair or rework of the goods supplied or replacement thereof, at Seller's option, and in no case is to exceed the invoice value of said goods. Under no circumstances will seller be liable for incidental or consequential damages or for damages incurred by the buyer or subsequent user in repairing or replacing defective goods or if the goods covered by this warranty are reworked or subjected to any type of additional processing.

This warranty is void if Seller is not notified in writing of any rejections or defects within 90 days after the receipt of the material by the customer.

**THIS WARRANTY IS MADE IN LIEU OF ALL OTHER WARRANTIES,
EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY.**

GBP751C

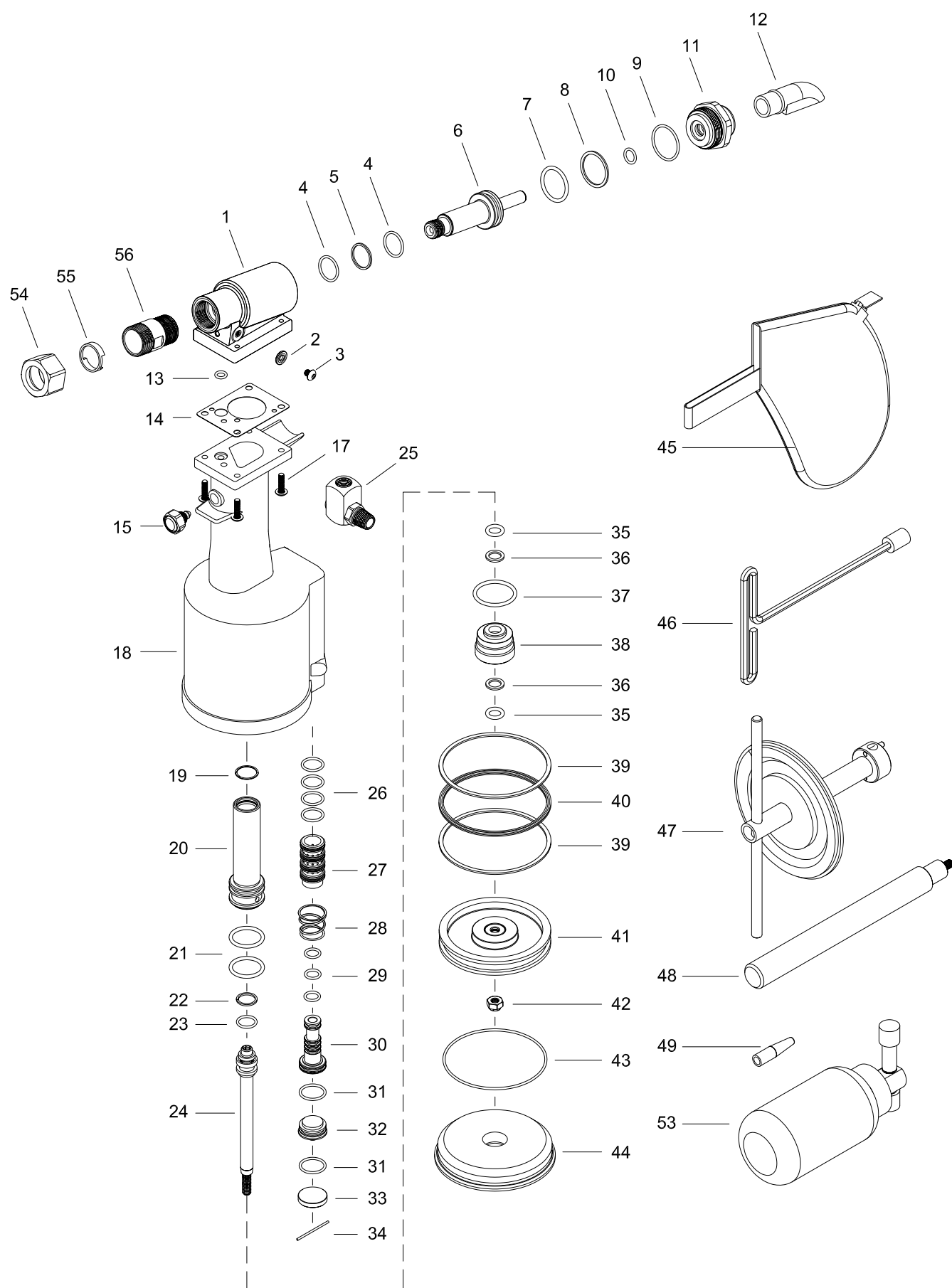
INSTALLATION TOOL



GAGE BILT
MADE IN U.S.A.

GAGE BILT PRODUCTS CORP.

14500 Barber Drive (586) 771-7664
Warren, Mi 48088 (586) 771-2665 Fax
e-mail: solutions@gagebilt.com / www.gagebilt.com



GBP751C Parts List

Ref. No.	Part No.	Description	Qty.
1	703109	Head Cylinder Assembly	1
2*	S572	Stat-O-Seal	1
3*	402482	Button Head Socket Screw	1
4*	S834	O'Ring	2
5*	401089	Back-Up Ring	1
6	751207	Piston	1
7*	405891	O'Ring	1
8*	401110	Back-Up Ring	1
9*	400788	O'Ring	1
10*	S829	O'Ring	1
11	703114	Cap	1
12	200232	Deflector	1
13*	S832	O'Ring	1
14*	704129	Gasket	1
15	704130	Trigger Assy. (Inc. 400773)	1
16*	400773	O'Ring	1
17*	A-928	Button Head Cap Screw	4
18	704132	Handle Assembly	1
19*	S734	Retaining Ring	1
20	751131	Power Cylinder	1
21*	403805	O'Ring	2
22*	401102	Back-Up Ring	1
23*	S945	O'Ring	1
24	704138	Piston Rod Assy. (Inc. 22 & 23)	1
25	A-249	Swivel	1
26*	400781	O'Ring	4
27	703139	Valve Sleeve	1
28*	704141	Spring	1
29*	400778	O'Ring	3
30	703142	Valve Spool Assembly	1
31*	400783	O'Ring	2
32	704145	Valve Plug	1
33*	704146	Muffler	1
34*	704244	Pin	1
35*	A-287	O'Ring	2
36*	S115	Back-Up Ring	2
37*	405757	O'Ring	1
38	704118	Packing Plug	1
39*	S731	Back-Up Ring	2
40*	S730	Quad Ring	1
41	704121	Air Piston Assembly	1
42*	400559	Flexlock Nut	1
43*	S725	O'Ring	1
44	704125	Base Cover	1
45**	704214	Stem Catcher Bag	1
46**	704149	Piston Rod Wrench	1
47**	704150	Packing Plug Wrench	1
48**	704151	Power Cylinder Tool	1
49**	704152	Seal Guide	1
50**	S1178	Valve Plug Extractor	1
51**	704162	Valve Spring Installation Tool (Not Shown)	1
52**	704163	Valve Sleeve Removal Tool (Not Shown)	1
53**	704153	Air Bleeder	1
54	211102	Nut	1
55	240102	Retaining Nut Stop	1
56	751201	Nose Fitting	1
57***	A-992	Tee-Wrench (Not Shown)	1

*Service Kit 751008 contains a complete set of O'Rings, Back-Up Rings, Screws and Gaskets. These items should be kept on hand at all times.

**Ref. No. 45-53 are not furnished with tool, but are recommended for complete tool overhaul.

***Used at rear of tool for nose assembly attachment.

Rev 11/06

GBP751C SELECTION CHART

FASTENER	DIA.	STRAIGHT		*RIGHT ANGLE ₁	**OFFSET
"S" TYPE BLIND BOLT MS90353S & MS90354S MS21140S & MS21141S	5/32	SB05-752B-20 SB05-752B-80	SB05-752B-45	SB05-751B-54RA	SB05-752A-43OS
"U" TYPE BLIND BOLT W/ LOCKING WASHER MS90353U & MS90354U MS21140U & MS21141U	5/32	UBB05-752B-20 UBB05-752B-80	UBB05-752B-45	UBB05-751B-54RA	UBB05-752A-43OS
EN6122 & UAB130-EU EN6127 & UAB6127-EU EN6128 & UAB100-EU EN6129 & UABP-EU	5/32	UAB568-713-21	UAB568-713-61	UAB05-751B-54RA	UAB05-752A-43OS
SINGLE ACTION BLIND RIVET NAS1919S NAS1921S	1/8	SMLS04-752B-20	SMLS04-752B-45	SMLS04-751B-54RA	SMLS04-752A-43OS
	5/32	SMLS05-752B-20	SMLS05-752B-45	SMLS05-751B-54RA	SMLS05-752A-43OS
	3/16	SMLS06-752B-20	SMLS06-752B-45	SMLS06-751B-54RA	SMLS06-752A-43OS
	1/4 ₃	SMLS08-752B-20	SMLS08-752B-45		SMLS08-752A-43OS ₃
UNIMATIC® SINGLE ACTION NAS1919U & NAS1621U NAS9301-NAS9312 BACR14FP/FR & BACR15GF/GK	1/8	UBR04-752B-20	UBR04-752B-45	UBR04-751B-54RA	UBR04-752A-43OS
	5/32	UBR05-752B-20	UBR05-752B-45	UBR05-751B-54RA	UBR05-752A-43OS
	3/16	UBR06-752B-20	UBR06-752B-45	UBR06-751B-54RA	UBR06-752A-43OS
	1/4 ₃	UBR08-713-20	UBR08-713-45		UBR08-752A-43OS ₃
"A" CODE NAS1398A & NAS1399A	3/32	3A-352B-25		3A-751B-54RA	
	1/8	4A-752B-20	4A-752B-45	4A-751B-54RA	4A-752A-43OS
	5/32	5A-752B-20	5A-752B-45	5A-751B-54RA	5A-752A-43OS
	3/16	6A-752B-20	6A-752B-45	6A-751B-54RA	6A-752A-43OS
NUT PLATE RIVETS BACR15DR MS20600-MS20605	3/32	4N-352-21	4N-352-61	4N-751B-54RA	3NP-752A-43OS
	1/8	5N-352-21	5N-352-61	5N-751B-54RA	4NP-752A-43OS
BACR15FR-FP, BACR16GF-GK, NAS1919U & 1921U, NAS9301-9312	1/8				
	5/32	456MAX-752B-21 ₂	456MAX-752B-61 ₂	456MAX-751B-54RA ₂	456MAX-751A-43OS ₂
	3/16				
ASP 2, ASP PF, ASP 4 FF, ASP 2 F, ASP 2 LC	13/64	ASP06-752B-20	ASP06-752B-45	ASP06-751B-54RA	ASP06-752A-43OS
NAS1719, NAS1720 NAS1721	1/8	MBC04-752B-20	MBC04-752B-45	MBC04-751A-54RA	MBC04-752A-43OS
	5/32	MBC05-752B-20	MBC05-752B-45	MBC05-751A-54RA	MBC05-752A-43OS
	3/16	MBC06-752B-20	MBC06-752B-45	MBC06-751A-54RA	MBC06-752A-43OS
GROUND STUD, BACS53B	8/32	GS8-752B-20	GS8-752B-45	GS8-751B-54RA	GS8-752A-43OS
	10/32	GS10-752B-20	GS10-752B-45	GS10-752A-54RA	GS10-752A-43OS
OPEN END, CLOSED END, C'SUNK, PROTRUDING HEAD COMMERCIAL NAIL RIVETS	3/32	3N-352-21	3N-352-61	3N-751B-54RA	
	1/8	4N-352-21	4N-352-61	4N-751B-54RA	
	5/32	5N-352-21	5N-352-61	5N-751B-54RA	
	3/16	6N-352-21	6N-352-61	6N-751B-54RA	

THE GAGE BILT GBP751C TOOL IS APPROVED TO INSTALL THE ABOVE FASTENERS

*ALL RIGHT ANGLE NOSES REQUIRE 751153 STROKE LIMITER.
**ALL OFFSET 204 SERIES NOSES REQUIRE 751204 ADAPTER.
1) RIGHT ANGLE NOSE ASSEMBLYS MAY REQUIRE MORE THAN ONE PULL.
2) INSTALLS ALL THREE DIAMETERS.
3) ALUMINUM ONLY.

NOTE: THE LAST 2 DIGITS OF THE NOSE ASSEMBLY REPRESENTS THE LENGTH
THE NOSE EXTENDS FROM THE TOOL I.E. -20 = 2.0 INCHES

GAGE BILT



DECLARATION OF CONFORMITY

WE DECLARE THAT THE EQUIPMENT SPECIFIED HEREIN
CONFORMS TO THE FOLLOWING STANDARDS AND DIRECTIVES.

EN292 part 1 and part 2

ISO 8662 part 1

ISO 3744

COUNCIL DIRECTIVE: 89/392/EEC, 91/368/EEC

93/44/EEC, 93/68/EEC

EQUIPMENT DESCRIPTION:

GBP700 SERIES FASTENER INSTALLATION TOOLS

MANUFACTURER:

GAGE BILT PRODUCTS CORP.

SIGNATURE: 

NAME: BRUCE T. GODFREY
CHAIRMAN
WARREN, MI U.S.A.
JUNE 2003

WARRANTY

Seller warrants that all goods covered by this catalog will conform to applicable specifications and will replace, or repair, F.O.B. our plant, any goods providing defective from faulty workmanship, or material, for 90 days from date of shipment.

Said warranty to remain in effect if and only if such goods are used in accordance with all instructions as to maintenance, operation, and use set forth in manuals and instruction sheets furnished by seller.

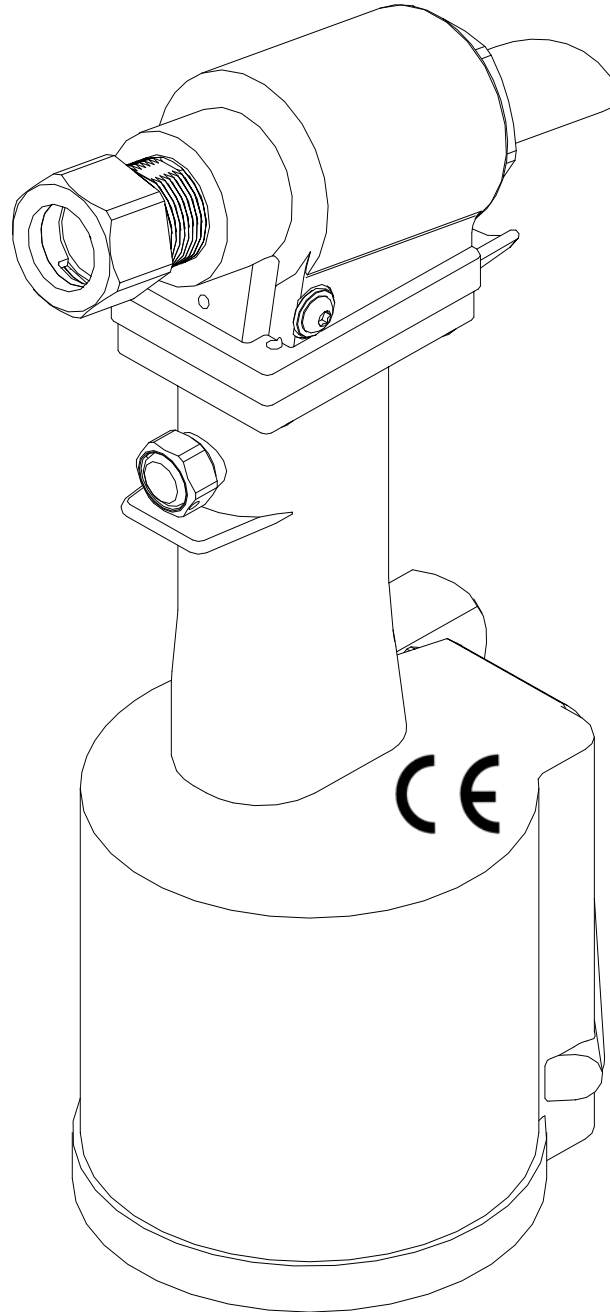
Sellers obligation under this warranty shall be limited to the repair or rework of the goods supplied or replacement thereof, at Seller's option, and in no case is to exceed the invoice value of said goods. Under no circumstances will seller be liable for incidental or consequential damages or for damages incurred by the buyer or subsequent user in repairing or replacing defective goods or if the goods covered by this warranty are reworked or subjected to any type of additional processing.

This warranty is void if Seller is not notified in writing of any rejections or defects within 90 days after the receipt of the material by the customer.

THIS WARRANTY IS MADE IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY.

GBP752E

INSTALLATION TOOL



GAGE BILT

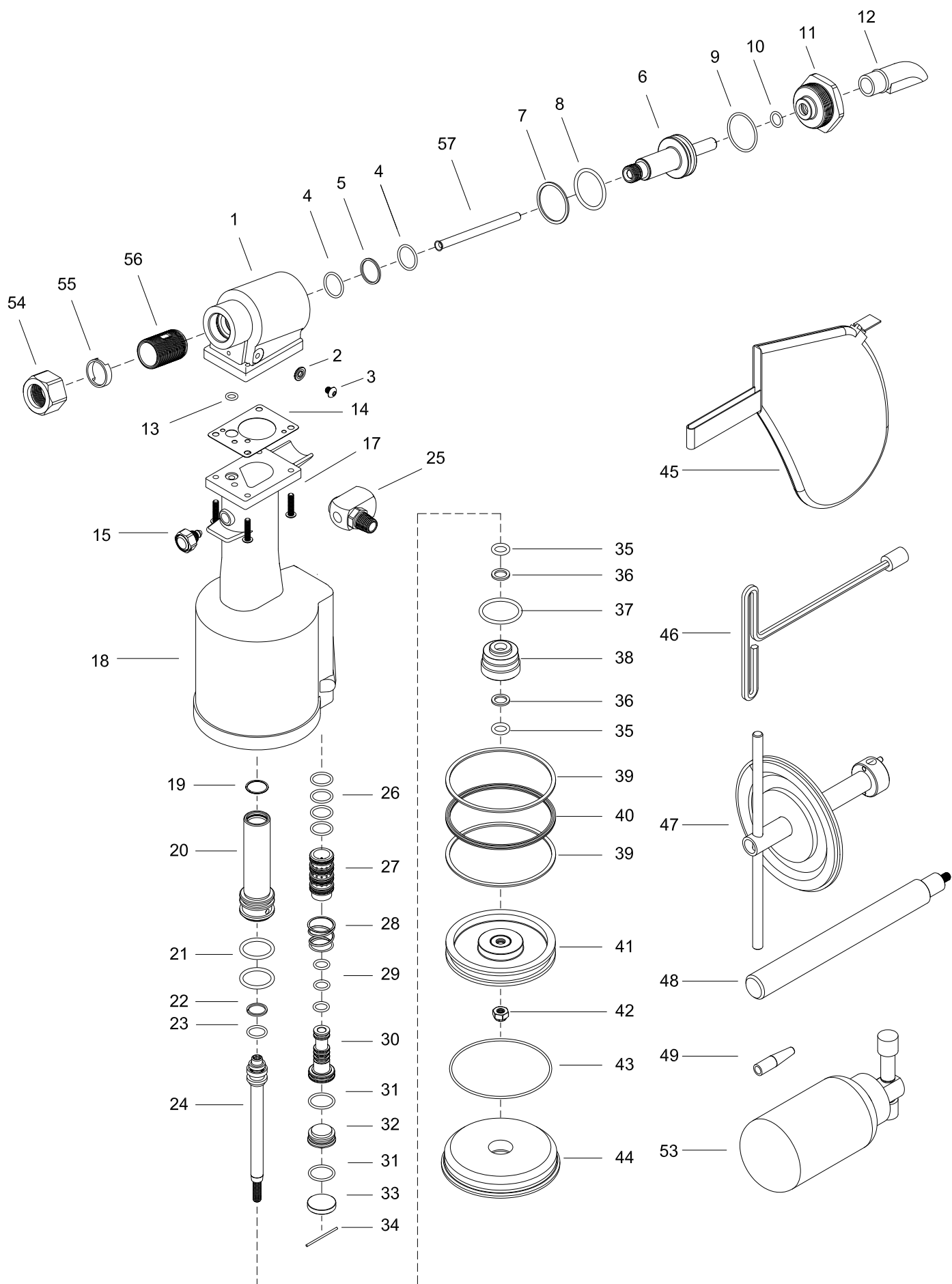
MADE IN U.S.A.

GAGE BILT PRODUCTS CORP.

14500 Barber Drive

Warren, Mi 48088

(586) 771-7664
(586) 771-2665 Fax
e-mail: solutions@gagebilt.com / www.gagebilt.com



GBP752E Parts List

Ref. No.	Part No.	Description	Qty.
1	752115	Head Cyclinder Assembly	1
2*	S572	Stat-O-Seal	1
3*	402482	Button Head Socket Screw	1
4*	S834	O'Ring	2
5*	401089	Back-Up Ring	1
6	752407	Piston	1
7*	A-1044	O'Ring	1
8*	401113	Back-Up Ring	1
9*	400791	O'Ring	1
10*	S829	O'Ring	1
11	752113	Cap	1
12	200232	Deflector	1
13*	S832	O'Ring	1
14*	704129	Gasket	1
15	704130	Trigger Assy. (Inc. 400773)	1
16*	400773	O'Ring	1
17*	A-928	Button Head Cap Screw	4
18	704132	Handle Assembly	1
19*	S734	Retaining Ring	1
20	751131	Power Cylinder	1
21*	403805	O'Ring	2
22*	401102	Back-Up Ring	1
23*	S945	O'Ring	1
24	704138	Piston Rod Assy. (Inc. 22 & 23)	1
25	A-249	Swivel	1
26*	400781	O'Ring	4
27	703139	Valve Sleeve	1
28*	704141	Spring	1
29*	400778	O'Ring	3
30	703142	Valve Spool Assembly	1
31*	400783	O'Ring	2
32	704145	Valve Plug	1
33*	704146	Muffler	1
34*	704244	Pin	1
35*	A-287	O'Ring	2
36*	S115	Back-Up Ring	2
37*	405757	O'Ring	1
38	704118	Packing Plug	1
39*	S731	Back-Up Ring	2
40*	S730	Quad Ring	1
41	704121	Air Piston Assembly	1
42*	400559	Flexlock Nut	1
43*	S725	O'Ring	1
44	704125	Base Cover	1
45**	704214	Stem Catcher Bag	1
46**	704149	Piston Rod Wrench	1
47**	704150	Packing Plug Wrench	1
48**	704151	Power Cylinder Tool	1
49**	704152	Seal Guide	1
50**	S1178	Valve Plug Extractor	1
51**	704162	Valve Spring Installation Tool (Not Shown)	1
52**	704163	Valve Sleeve Removal Tool (Not Shown)	1
53**	704153	Air Bleeder	1
54	211102	Nut	1
55	240102	Retaining Nut Stop	1
56	752301	Nose Fitting	1
57****	200506-2	Pintail Tube	1
58***	A-993	Tee-Wrench (Not Shown)	1

*Service Kit 752019 contains a complete set of O'Rings, Back-Up Rings, Screws and Gaskets. These items should be kept on hand at all times.

**Ref. No. 45-53 are not furnished with tool, but are recommended for complete tool overhaul.

***Used at rear of tool for nose assembly attachment.

****Pintail tube (200506-2) is necessary for use with blind rivets smaller than 5/32 diameter.

REV. 12/06

GBP752E SELECTION CHART

FASTENER	DIA.	STRAIGHT		*RIGHT ANGLE	**OFFSET
COMMERCIAL LOCKBOLTS	3/16	LB06-713-20			
	1/4	LB08-713-20			
MULTIGRIP LOCKBOLTS	3/16	MG06-713-20	MG06-713-60		
	1/4	MG08-713-20	MG08-713-60		
"S" TYPE BLIND BOLT MS90353S & MS90354S MS21140S & MS21141S	5/32	SB05-752B-20	SB05-752B-45	SB05-751B-54RA	SB05-752A-43OS
		SB05-752B-80			
	3/16	SB06-752B-20	SB06-752B-45	SB06-751B-54RA	SB06-752A-43OS
		SB06-752B-80			
"U" TYPE BLIND BOLT WITH LOCKING WASHER MS90353U & MS90354U MS21140U & MS21141U	5/32	UBB05-752B-20	UBB05-752B-45	UBB05-751B-54RA	UBB05-752A-43OS
		UBB05-752B-80			
	3/16	UBB06-752B-20	UBB06-752B-45	UBB06-751B-54RA	UBB06-752A-43OS
		UBB06-752B-80			
EN6122 & UAB130-EU EN6127 & UAB6127-EU EN6128 & UAB100-EU EN6129 & UABP-EU	5/32	UAB568-713-21	UAB568-713-61	UAB05-751B-54RA	UAB05-752A-43OS
	3/16			UAB06-751B-54RA	UAB06-752A-43OS
SINGLE ACTION BLIND RIVET NAS1919S & NAS1921S	1/8	SMLS04-752B-20	SMLS04-752B-45	SMLS04-751B-54RA	SMLS04-752A-43OS
	5/32	SMLS05-752B-20	SMLS05-752B-45	SMLS05-751B-54RA	SMLS05-752A-43OS
	3/16	SMLS06-752B-20	SMLS06-752B-45	SMLS06-751B-54RA	SMLS06-752A-43OS
	1/4	SMLS08-713-20	SMLS08-713-45		SMLS08-752A-43OS
UNIMATIC® SINGLE ACTION NAS1919U & NAS1621U NAS9301-NAS9312 BACR14FP/FR & BACR15GF/GK	1/8	UBR04-752B-20	UBR04-752B-45	UBR04-751B-54RA	UBR04-752A-43OS
	5/32	UBR05-752B-20	UBR05-752B-45	UBR05-751B-54RA	UBR05-752A-43OS
	3/16	UBR06-752B-20	UBR06-752B-45	UBR06-751B-54RA	UBR06-752A-43OS
	1/4	UBR08-713-20	UBR08-713-45		UBR08-752A-43OS
"A" CODE NAS1398A & NAS1399A	3/32	3A-352B-25		3A-751B-54RA	
	1/8	4A-752B-20	4A-752B-45	4A-751B-54RA	4A-752A-43OS
	5/32	5A-752B-20	5A-752B-45	5A-751B-54RA	5A-752A-43OS
	3/16	6A-752B-20	6A-752B-45	6A-751B-54RA	6A-752A-43OS
	1/4	SMLS08-713-20			SMLS08-752A-43OS
NUT PLATE RIVETS BACR15DR	3/32	4N-352-21	4N-352-61	4N-751B-54RA	**3NP-752A-43OS
	1/8	5N-352-21	5N-352-61	4NP-751B-54RA	**4NP-752A-43OS
BACR15FR-FP, BACR16GF-GK, NAS1919U & 1921U, NAS9301-9312	1/8	2 456MAX-752B-21	2 456MAX-752B-61	2 456MAX-751B-54RA	2 456MAX-751A-43OS
	5/32				
	3/16				
	1/4	08MAX-752B-20	08MAX-752B-45		08MAX-204C-27OS 08MAX-204C-37OS
ASP 2, ASP PF, ASP 4 FF, ASP 2 F, ASP 2 LC	13/64	ASP06-752B-20	ASP06-752B-45	ASP06-751B-54RA	ASP06-752A-43OS
	17/64	ASP08-752B-20	ASP08-752B-45		ASP08-752A-43OS
NAS1719, NAS1720 NAS1721	1/8	MBC04-752B-20	MBC04-752B-45	MBC04-751A-54RA	MBC04-752A-43OS
	5/32	MBC05-752B-20	MBC05-752B-45	MBC05-751A-54RA	MBC05-752A-43OS
	3/16	MBC06-752B-20	MBC06-752B-45	MBC06-751A-54RA	MBC06-752A-43OS
GROUND STUD, BACS53B	8/32	GS8-752B-20	GS8-752B-45	GS8-751B-54RA	GS8-752A-43OS
	10/32	GS10-752B-20	GS10-752B-45	GS10-752A-54RA	GS10-752A-43OS
OPEN END, CLOSED END, C'SUNK, PROTRUDING HEAD COMMERCIAL NAIL RIVETS	3/32	3N-352-21	3N-352-61	3N-751B-54RA	
	1/8	4N-352-21	4N-352-61	4N-751B-54RA	
	5/32	5N-352-21	5N-352-61	5N-751B-54RA	
	3/16	6N-352-21	6N-352-61	6N-751B-54RA	

THE GAGE BILT GBP752E SERIES TOOLS ARE APPROVED TO INSTALL THE ABOVE FASTENERS

*ALL RIGHT ANGLE NOSES REQUIRE 752140 STROKE LIMITER.

**ALL OFFSET 204 SERIES NOSES REQUIRE 751204 ADAPTER.

1) RIGHT ANGLE NOSE ASSEMBLY'S MAY REQUIRE MORE THAN ONE PULL.

2) INSTALLS 1/8, 5/32 & 3/16 DIAMETERS

3) INSTALLS 5/32 & 3/16 DIAMETERS

NOTE: THE LAST 2 DIGITS OF THE NOSE ASSEMBLY REPRESENTS THE LENGTH THE NOSE
EXTENDS FROM THE TOOL I.E. -20 = 2.0 INCHES

GAGE BILT



DECLARATION OF CONFORMITY

WE DECLARE THAT THE EQUIPMENT SPECIFIED HEREIN
CONFORMS TO THE FOLLOWING STANDARDS AND DIRECTIVES.

EN292 part 1 and part 2

ISO 8662 part 1

ISO 3744

COUNCIL DIRECTIVE: 89/392/EEC, 91/368/EEC

93/44/EEC, 93/68/EEC

EQUIPMENT DESCRIPTION:

GBP700 SERIES FASTENER INSTALLATION TOOLS

MANUFACTURER:

GAGE BILT PRODUCTS CORP.

SIGNATURE: 

NAME: BRUCE T. GODFREY
CHAIRMAN
WARREN, MI U.S.A.
JUNE 2003

WARRANTY

Seller warrants that all goods covered by this catalog will conform to applicable specifications and will replace, or repair, F.O.B. our plant, any goods providing defective from faulty workmanship, or material, for 90 days from date of shipment.

Said warranty to remain in effect if and only if such goods are used in accordance with all instructions as to maintenance, operation, and use set forth in manuals and instruction sheets furnished by seller.

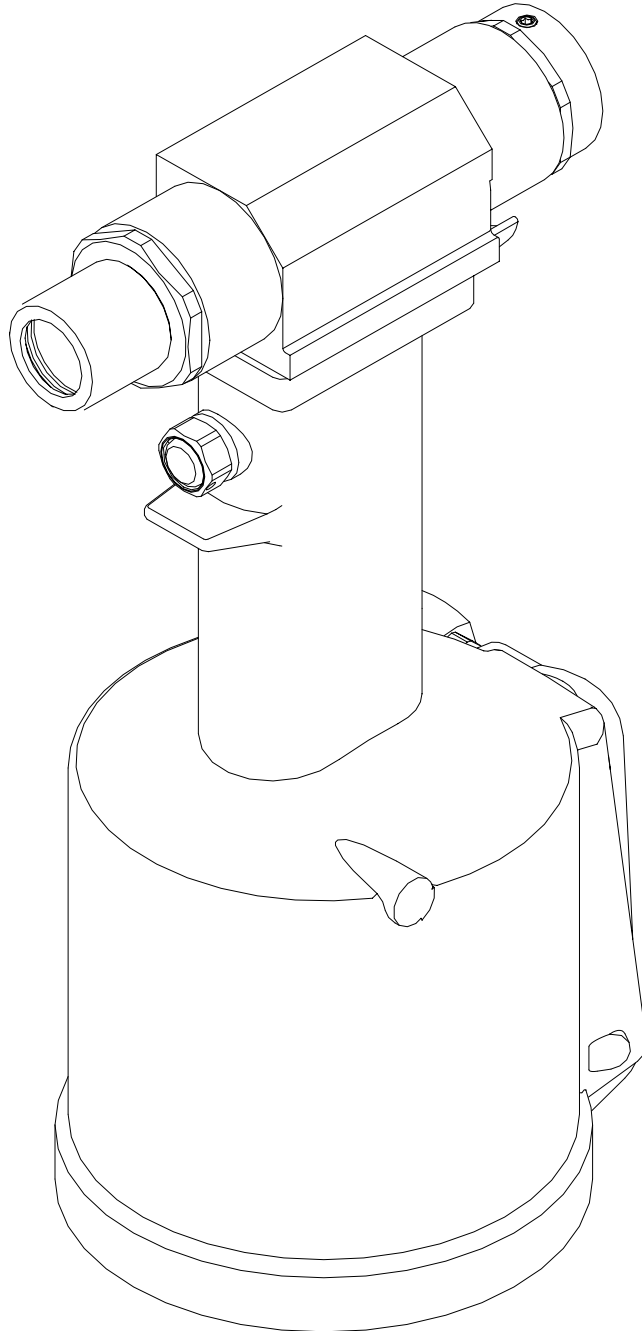
Sellers obligation under this warranty shall be limited to the repair or rework of the goods supplied or replacement thereof, at Seller's option, and in no case is to exceed the invoice value of said goods. Under no circumstances will seller be liable for incidental or consequential damages or for damages incurred by the buyer or subsequent user in repairing or replacing defective goods or if the goods covered by this warranty are reworked or subjected to any type of additional processing.

This warranty is void if Seller is not notified in writing of any rejections or defects within 90 days after the receipt of the material by the customer.

THIS WARRANTY IS MADE IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY.

GBP784B

INSTALLATION TOOL



GAGE BILT
MADE IN U.S.A.

GAGE BILT PRODUCTS CORP.

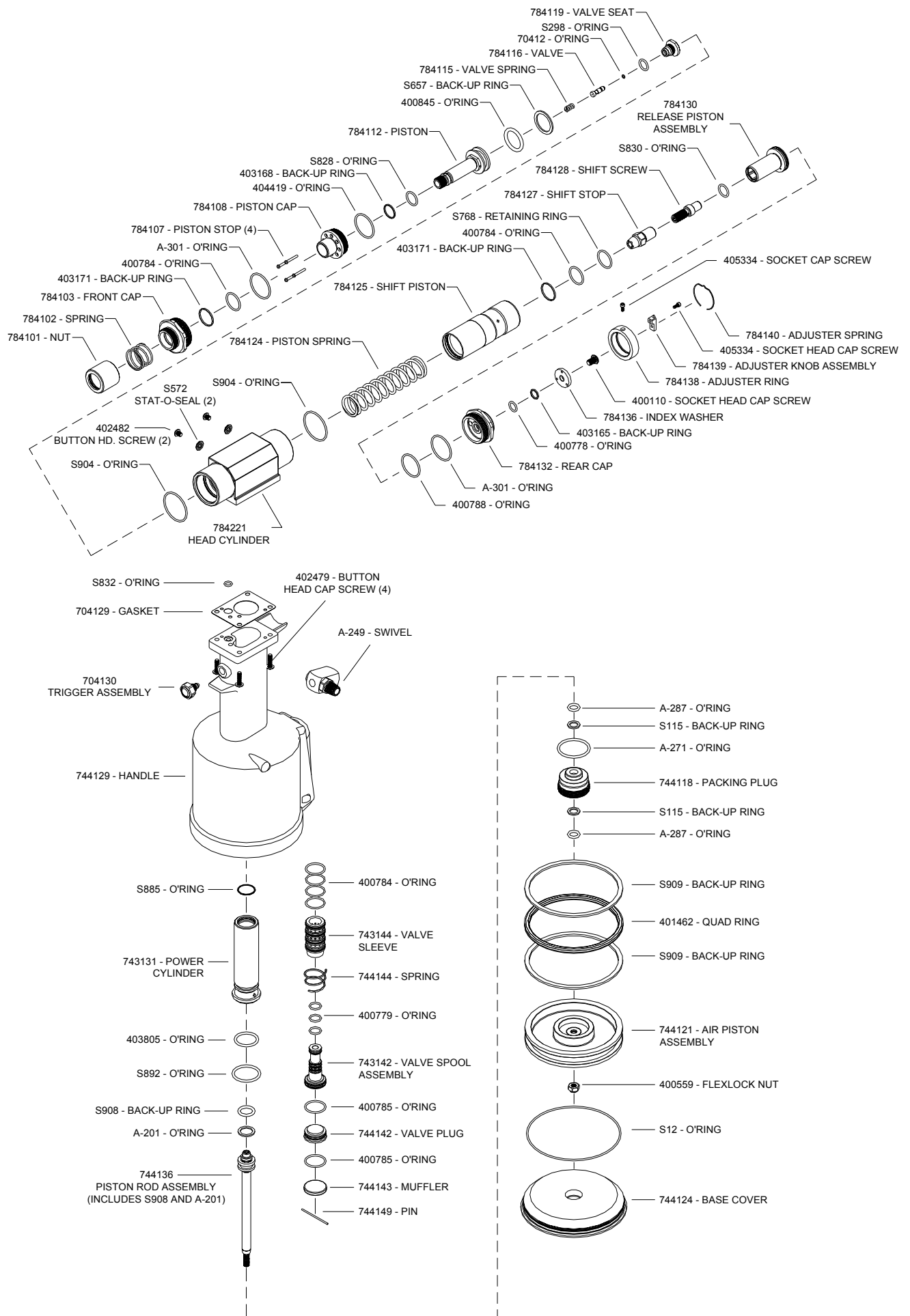
14500 Barber Drive

Warren, Mi 48088

e-mail: solutions@gagebilt.com / www.gagebilt.com

(586) 771-7664

(586) 771-2665 Fax

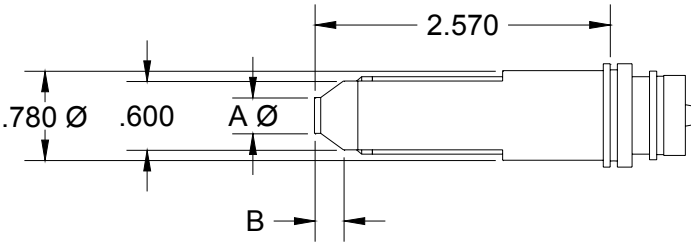


NOSE ASSEMBLIES:

Nose assemblies are not furnished with the tool and must be purchased separately. In ordering heads be sure to specify the shank diameter and head style (universal or countersunk) of the rivets to be installed.

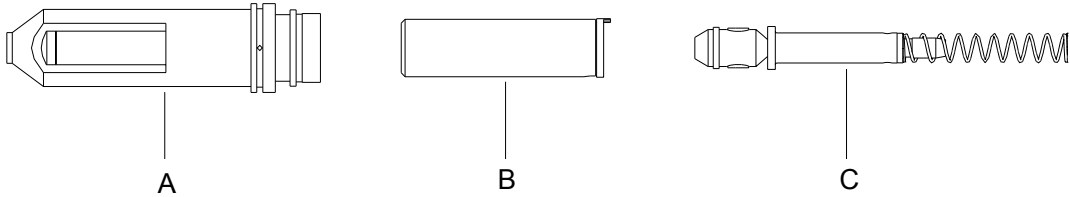
The following pulling heads will fit directly on the GBP784B Riveter. (NOTE: Cherry 681 series pulling heads fit directly on the GBP784B)

**681 PULLING HEADS
FOR 2000 SERIES CHERRYLOCK RIVETS
CONFORMING TO NAS 1400 & NAS 1740**



RIVET DIAMETER	NOSE ASSEMBLY	DIMENSION	
		A	B
3/32"	3U-681-25	.188	.348
3/32"	3C-681-25	.163	.332
1/8"	4U-681-25	.250	.341
1/8"	4C-681-25	.208	.377
5/32"	5U-681-25	.313	.377
5/32"	5C-681-25	.269	.352
3/16"	6U-681-25	.375	.418
3/16"	6C-681-25	.335	.386
1/4"	8U-681-25	.500	.452
1/4"	8C-681-25	.458	.398

INSTALLING 681 PULLING HEAD ON RIVETER



1. Remove knurled cap from front of riveter head.
2. Place jaw assembly (C) inside collet (B).
3. Insert spring end of jaw assembly into hole of head piston. Apply enough pressure to engage collet threads. Turn until collet bottoms on shoulder of piston and collet lock snaps into slot in piston. Hand tight is sufficient.

NOTE: To remove collet, push collet lock back into collet (using a blunt pointed tool) turning the collet clockwise.

4. Place sleeve assembly (A) over collet and head piston. Slip knurled cap over the sleeve assembly and hand tighten onto end of riveter head.

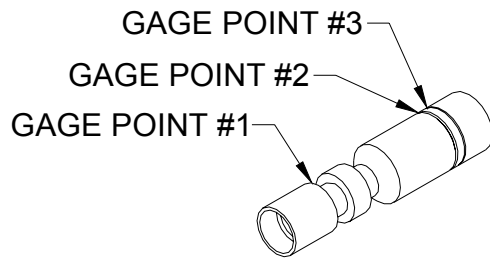
SETTING THE SHIFT POINT:

The shift point must be adjusted to insure the flushness of the rivet stem after installation. To Adjust:

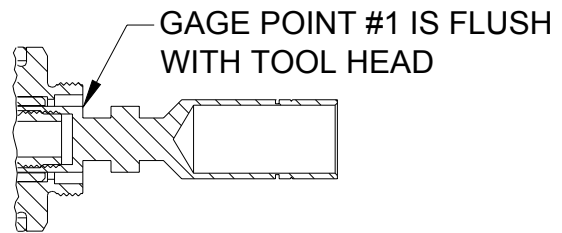
1. Connect the tool to a clean dry air source of 90 psi to 120 psi. Remove nut.
2. Hand tighten small end of 784159 gage onto piston.
3. Depress trigger and hold. Gage point #1 should line up with face of front cap as shown. Release Trigger.
4. To increase gage protrusion turn adjuster knob clockwise or counter-clockwise to decrease gage protrusion. Tool must be rechecked after making adjustments.

NOTE: Adjustment can only be made by one-half turn in either direction.

CAUTION: Trigger must be released before turning adjuster knob.



784159 - SETTING GAGE



SHIFT PISTON CHECK:

The shift piston should be checked to insure that the shift stroke is complete.

1. Connect the tool to a clean dry air source of 90 psi to 120 psi. Remove nut.
2. Install large unthreaded end of 784159 gage over threads on piston until it seats on pistons shoulder, gage point #2 must line up with front of tool as shown in figure A.
3. Depress and hold trigger. The piston should shift gage in forward position exposing gage point #3 in front of tool head as shown in figure B.
4. If tool fails to meet the above check it should be overhauled.

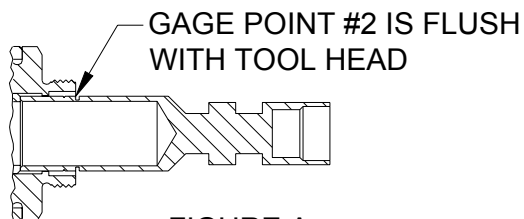


FIGURE A

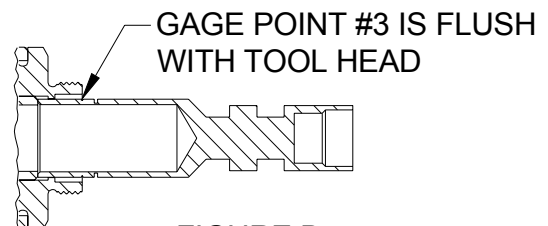
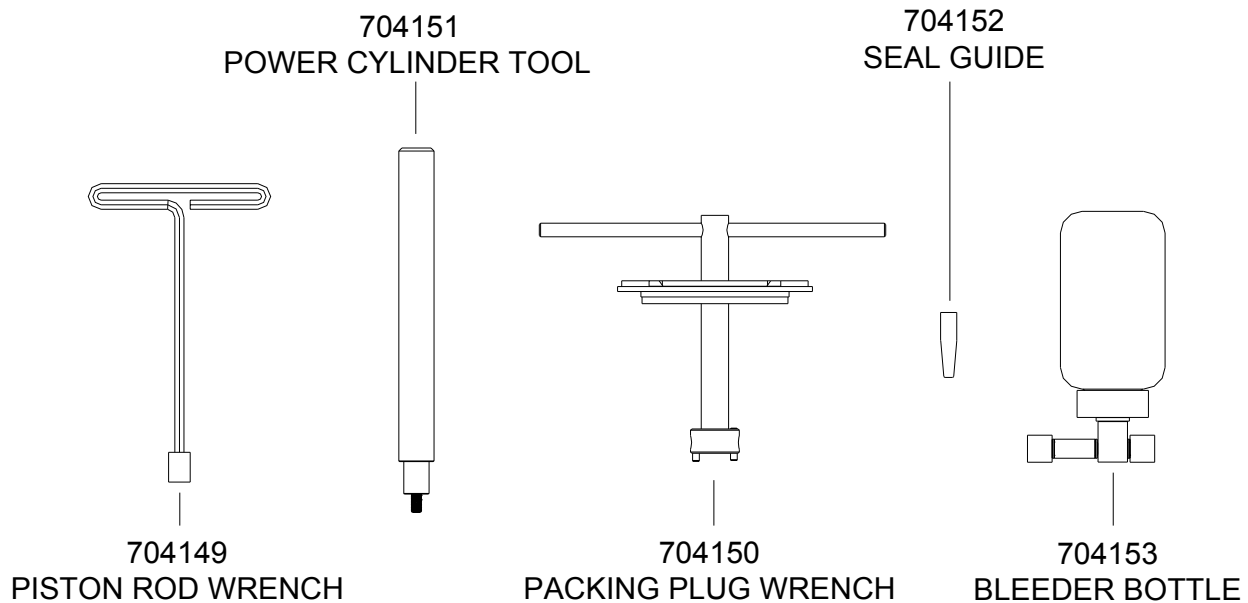


FIGURE B



GBP743ATK Service Tool Kit

Part No.	Description
704149	Piston Rod Wrench
704150	Packing Plug Wrench
704151	Power Cylinder Tool
704152	Seal Guide
S1178	Valve Extractor (Not Shown)
744151	Valve Spring Installation Tool (Not Shown)
744152	Valve Sleeve Removal Tool (Not Shown)

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Said warranty to remain in effect if and only if such goods are used in accordance with all instructions as to maintenance, operation, and use set forth in manuals and instruction sheets furnished by seller.

Sellers obligation under this warranty shall be limited to the repair or rework of the goods supplied or replacement thereof, at Seller's option, and in no case is to exceed the invoice value of said goods. Under no circumstances will seller be liable for incidental or consequential damages or for damages incurred by the buyer or subsequent user in repairing or replacing defective goods or if the goods covered by this warranty are reworked or subjected to any type of additional processing.

This warranty is void if Seller is not notified in writing of any rejections or defects within 90 days after the receipt of the material by the customer.

THIS WARRANTY IS MADE IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY.