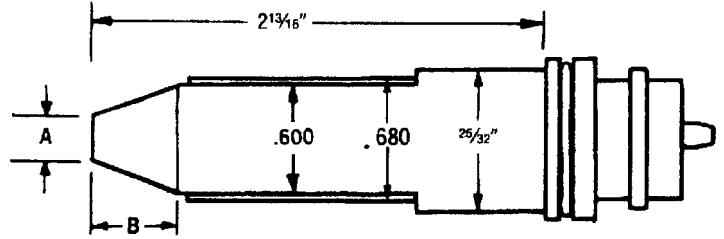


H681 PULLING HEAD

FOR THE 2000 SERIES CHERRYLOCK® RIVETS INSTRUCTION SHEET

- A separate pulling head is required for each diameter CherryLock® rivet.
- It is acceptable that countersunk (C) pulling heads be used for installing both universal and counter-sunk head CherryLock® rivets. These heads fit directly on all Cherry Hydro-shift Riveters.



AVAILABLE EXTENSIONS

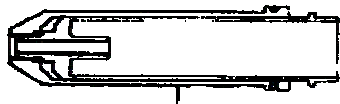
- H681 pulling heads may be obtained in four extended lengths to reach into difficult access areas. These are 2", 6", 12" & 24" extensions additional to the normal head length of 2 13/16".
- To order extension heads, specify correct pulling head number from the chart and add extension length required.
Example: H681-6C-E2 for 2"
H681-6C-E12 for 12"

| RIVET DIA | PULLING HEAD NUMBER | DIMENSIONS | |
|-----------|-------------------------------------|------------|-------|
| | | A | B |
| 3/32" | H681-3C Countersunk Head (MS 20426) | 0.163 | 0.332 |
| 1/8" | H681-4C Countersunk Head (MS 20426) | 0.208 | 0.341 |
| | H681-4F Countersunk Head (156°) | 0.43 | 0.358 |
| | H681-4S Countersunk Head (NAS 1097) | 0.174 | 0.341 |
| | H681-B166-4 Uni-Sink Head | 0.25 | 0.359 |
| 5/32" | H681-5C Countersunk Head (MS 20426) | 0.269 | 0.352 |
| | H681-5F Countersunk Head (156°) | 0.535 | 0.338 |
| | H681-5S Countersunk Head (HAS 1097) | 0.225 | 0.352 |
| | H681-B166-5 Uni-Sink Head | 0.313 | 0.377 |
| 3/16" | H681-6C Countersunk Head (MS 20426) | 0.335 | 0.386 |
| | H681-6F Countersunk Head (156°) | 0.625 | 0.367 |
| | H681-6S Countersunk Head (NAS 1097) | 0.281 | 0.386 |
| | H681-B166-6 Uni-Sink Head | 0.375 | 0.419 |
| 1/4 " | H681-8C Countersunk Head (MS20426) | 0.458 | 0.398 |
| | H681-8S Countersunk Head (MS1097) | 0.374 | 0.398 |

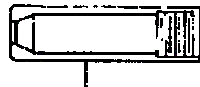
MOUNTING INSTRUCTIONS



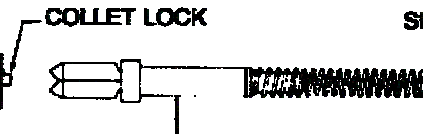
CAP



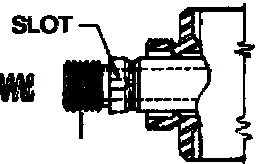
SLEEVE ASSEMBLY



COLLET



JAW ASSEMBLY



HEAD PISTON

1. Remove knurled cap from front of riveter head.
2. Place jaw assembly inside collet.
3. Insert spring end of jaw assembly into hole in 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 tightening is sufficient.

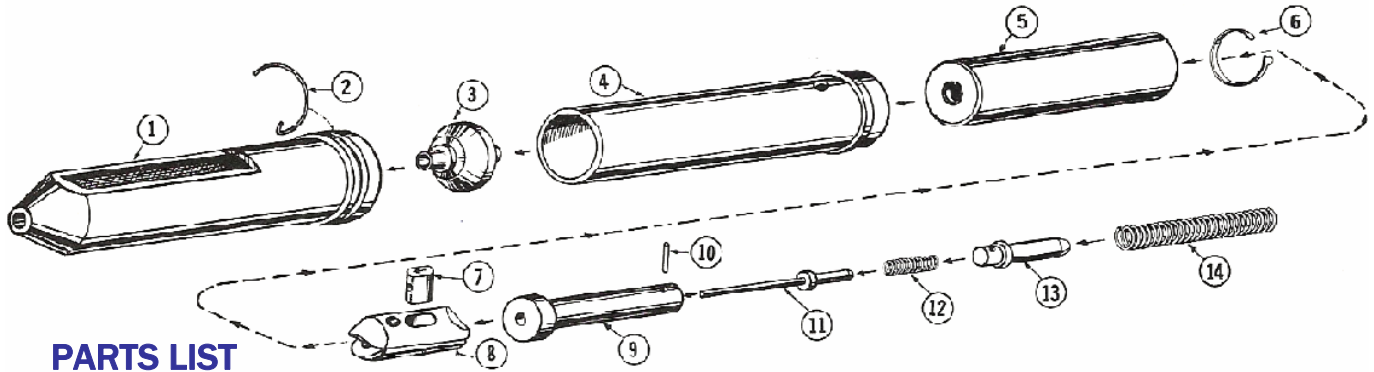
- Note: To remove collet, push collet lock back into collet (using a blunt pointed tool) while turning the collet counterclockwise.
4. Place sleeve assembly over collet and head piston. Slip knurled cap over the sleeve assembly and hand tighten onto end of riveter head.



CHERRY®
AEROSPACE

1224 East Warner Ave,
Santa Ana, CA 92705
Tel: 1-714-545-5511
www.cherryaerospace.com

H681 PULLING HEAD



PARTS LIST

| Rel. No. | Description | Qty Req. | Head Number | | | | |
|----------|--------------------------------------|----------|-------------|-----------|-----------|-----------|-----------|
| | | | H681-3 | H681-4 | H681-5 | H681-6 | H681-8 |
| 1 | Outer Sleeve, C'sunk Head (MS20426) | 1 | 681C6-3C | 681C6-4C | 681C6-5C | 681C6-6C | 681C6-8C |
| | Outer Sleeve, C'sunk Head (158°) | 1 | — | 681C6-4F | 681C6-5F | 681C6-6F | — |
| | Outer Sleeve, C'sunk Head (NAS 1097) | 1 | — | 681C6-4S | 681C6-5S | 681C6-6S | 681C6-8S |
| | Outer Sleeve, Uni-Sink Head | 1 | — | 681C86-4 | 681C86-5 | 681C86-6 | |
| 2 | Retainer | 1 | 680A25 | 680A25 | 680A25 | 680A25 | 680A25 |
| 3 | Anvil | 1 | 681B5-3 | 681B5-4 | 681B5-5 | 681B5-6 | 681B5-8 |
| 4 | Tube | 1 | 681A4 | 681A4 | 681A4 | 681A4 | 681A4 |
| 5 | Collet | 1 | 680A152 | 680A152 | 680A152 | 680A152 | 680A152 |
| 6 | Collet Lock | 1 | 680A152-3 | 680A152-3 | 680A152-3 | 680A152-3 | 680A152-3 |
| 7 | Stem Stop | 1 | 615A48 | 615A41 | 615A37 | 615A37 | 615A37 |
| 8 | Jaw. (pair) | 1 | 615B40-3 | 615B40-4 | 615B40-5 | 615B40-6 | 615B40-8 |
| 9 | Pusher | 1 | 680A30-1 | 680A30-1 | 680A30-2 | 680A30-2 | 680A30-2 |
| 10 | P i n | 1 | P-575 | P-575 | P-575 | P-575 | P-575 |
| 11 | Ejector Pin | 1 | 680A16-3 | 680A16-1 | 680A16-2 | 680A16-2 | 680A16-2 |
| 12 | Spring | 1 | P555 | P555 | 680A56 | 680A56 | 680A56 |
| 13 | Stop | 1 | 680A29 | 680A29 | 680A29 | 680A29 | 680A29 |
| 14 | Spring | 1 | 680A26 | 680A26 | 680A26 | 680A26 | 680A26 |

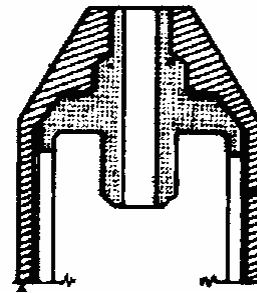
* {

| NATIONAL STOCK NUMBERS STANDARD STRAIGHT PULLING HEADS | |
|--|------------------|
| H681-B166-4 | 5130-01-089-8039 |
| H681B166-5 | 5130-01-089-2721 |
| H681-3C | 5130-01-154-6997 |
| H681-4C | 5130-00-083-6625 |
| H681-40 | 5130-00-083-6626 |
| H681-5C | 5130-00-083-6627 |
| H681-6C | 5130-01-021-7451 |
| H681-8C | 5130-00-083-6634 |

*These parts can be ordered individually or as an assembly for any pulling head listed.
Order: Pusher Assembly 680A13-3, -4, -5, -6, or -8.

MAINTENANCE AND REPAIR

- Keep the pulling head clean, especially around the riveting end, as adhesives, chips, sealants, etc., will cause slipping.
Note: At assembly be sure that stem stop (7) is replaced with arrow pointing forward, as shown in sketch on the right.
- To replace ejector pin (11) or ejector spring (12) it is necessary to first remove rollpin (10) and stop (13).
- Length of anvil (3) is critical and must within dimensions in the sketch on the right. If anvil protrudes more than .004 then the outer sleeve (1) is worn and must be replaced.



OUTER SLEEVE
COUNTERSUNK HEAD

WARRANTY

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

Seller shall not be liable under any circumstances for incidental, special or consequential damages arising in whole or in part from any breach by Seller, AND SUCH INCIDENTAL, SPECIAL, OR CONSEQUENTIAL DAMAGES ARE HEREBY EXPRESSLY EXCLUDED.

Our policy is one of continuous development. Specifications shown in this document may be subject to changes introduced after publication.

NOTE: The properties, strength, dimensions, installed characteristics and all other information in these materials are for guidance only to aid in the correct selection of the products described herein and is not intended or implied as part of the above warranty. All applications should be evaluated for functional stability and available samples of the described parts can be requested for installed tests, suitability and evaluations.

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



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