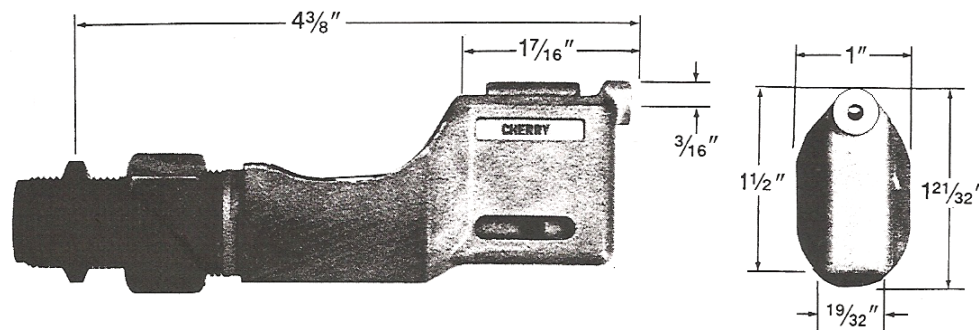


H781-456

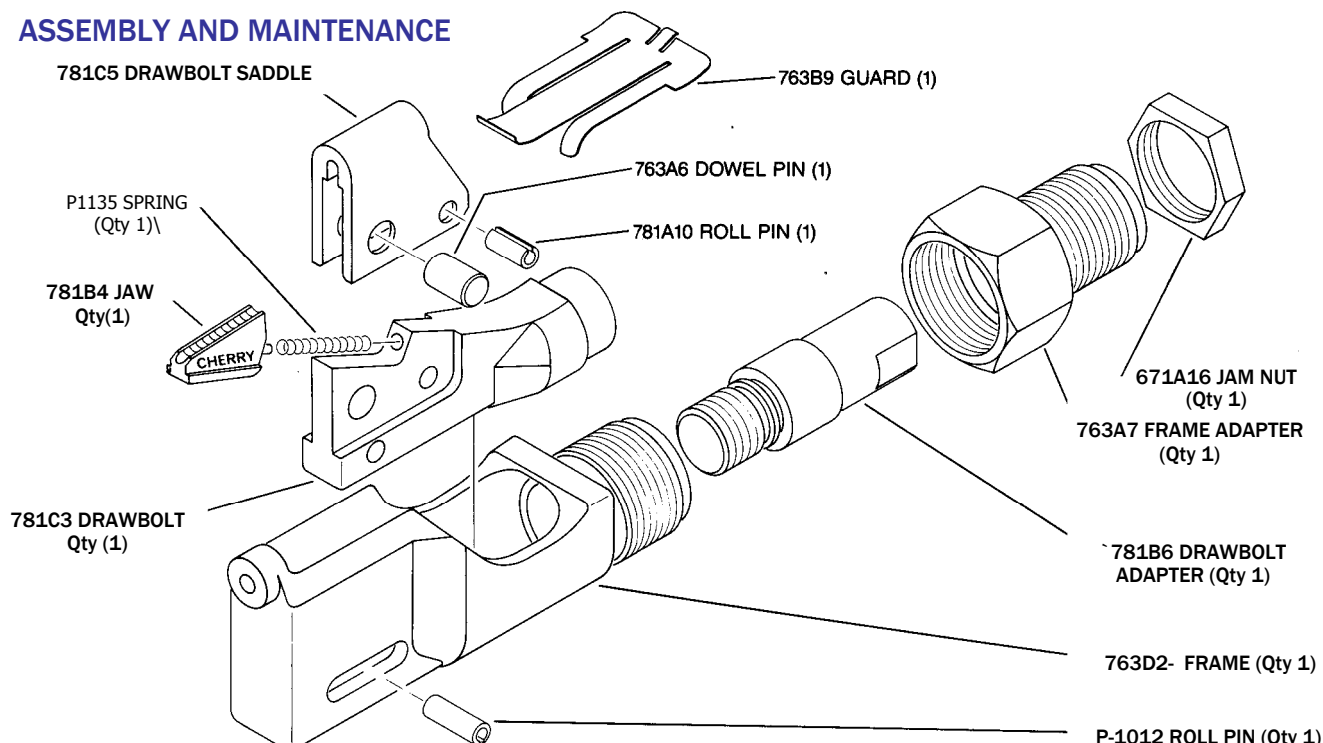
OFFSET PULLING HEAD

INSTRUCTION SHEET



- The H781-456 Offset Pulling Head fits directly on the G701, G704B, G746, G747 and G749 CherryMax® riveters and to the G750A hand riveter with 750A-088 adapter.
- It installs 1/8", 5/32" and 3/16" CherryMax® rivets in all materials, head styles and grip lengths.
- May be used with Hydro-shift riveters (G784, G685S, G686S, G689, G700 and G784) with the 680B205 Adapter.

ASSEMBLY AND MAINTENANCE



- Lubricate **DRAWBOLT** regularly with a few drops of light oil between **JAW** and **FRAME**.
- Keep the pulling head clean, especially around the riveting end, as adhesives, chips, sealants, etc., may cause the rivet stem to slip.

Disassembly:

- Remove **FRAME ADAPTER** and **JAM NUT** which will expose end of **DRAWBOLT ADAPTER**.
- Using 1/2" wrench on flats, remove **DRAWBOLT ADAPTER**.
- Remove **GUARD** and **ROLL PIN** which allows **DRAWBOLT** and **JAW** assembly to be lifted out of frame.

- Remove **DOWEL PIN** and **ROLL PIN** to dismantle the jaw assembly.

To re-assemble:

- Reverse the procedure, inserting **SPRING** and **JAW** into **DRAWBOLT**, adding **DRAW-BOLT SADDLE** held in place with **DOWEL PIN** and **ROLL PIN**. This sub-assembly is then placed **INSIDE FRAME** and is held there by inserting **ROLL PIN** and **GUARD**.
- Place Loctite® 242 sealant on threads of **DRAW-BOLT ADAPTER** and inside threads of **FRAME ADAPTER** and tighten snugly in place. Replace **JAM NUT**.



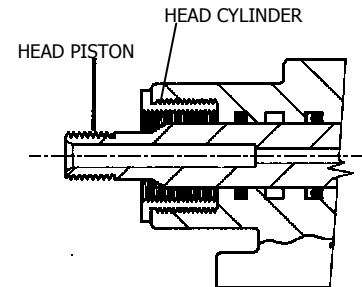
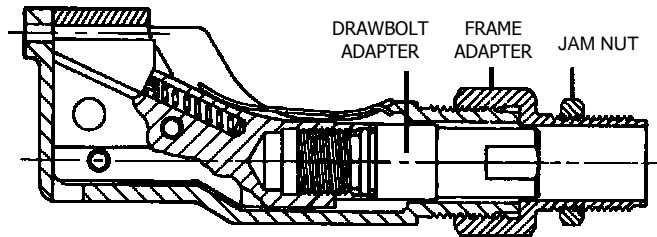
CHERRY®
AEROSPACE

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Tel: 1-714-545-5511
www.cherryaerospace.com

H781-456

OFFSET PULLING HEAD

INSTRUCTION SHEET



MOUNTING INSTRUCTIONS

The H781-456 Offset Pulling Head has been designed to allow the mechanic to install CherryMax® fasteners in areas where a straight pulling head would not provide suitable access. It is intended for limited access applications and should be used in that mode. TAF recommends the use of the H701 B-456 straight pulling head in place of the H781-456, for routine installations with adequate access.

ATTACHMENT TO CHERRYMAX TOOLS

1. Attach riveter (G704B, G746A, OR G747) to an air line
2. Begin attachment by threading the drawbolt adapter (781B6) to the head piston of the tool.
continue until the threads bottom out.
3. Connect the frame adapter (763A7) to the head casting of the riveter.
Caution: A gap between the saddle (781C5) and the frame (763D2) should be maintained of approximately .150" as this will allow the 1/8" diameter CherryMax stems to install without slippage. If slippage does occur, discard the rivet, and open the gap between the frame and the saddle (by repeating steps 2 and 3). The adjustment must be made during the initial attachment; it can not be made by backing the pulling head away from the riveter. Use a new rivet to complete the installation. For 5/32" and 3/16" CherryMax® fasteners the gap should be closed down to allow the stem to pass into the jaw and saddle, with some resistance being felt during the insertion process.
4. Make sure that the jam nut (671A16) is secured after adjustment.

After each installation the stem of the next fastener will force the previous stem out or almost out of the jaws. If the stem is stuck, pull it out and discard it in a proper receptacle to avoid FOD.



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Use the .150" dimension as a starting point to set up the H781-456 for 1/8" CherryMax® fasteners



Close down for 5/32" and 3/16" CherryMax® Fasteners



Adjustment should provide resistance to be felt when inserting the 5/32" and 3/16" stems into the pulling 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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