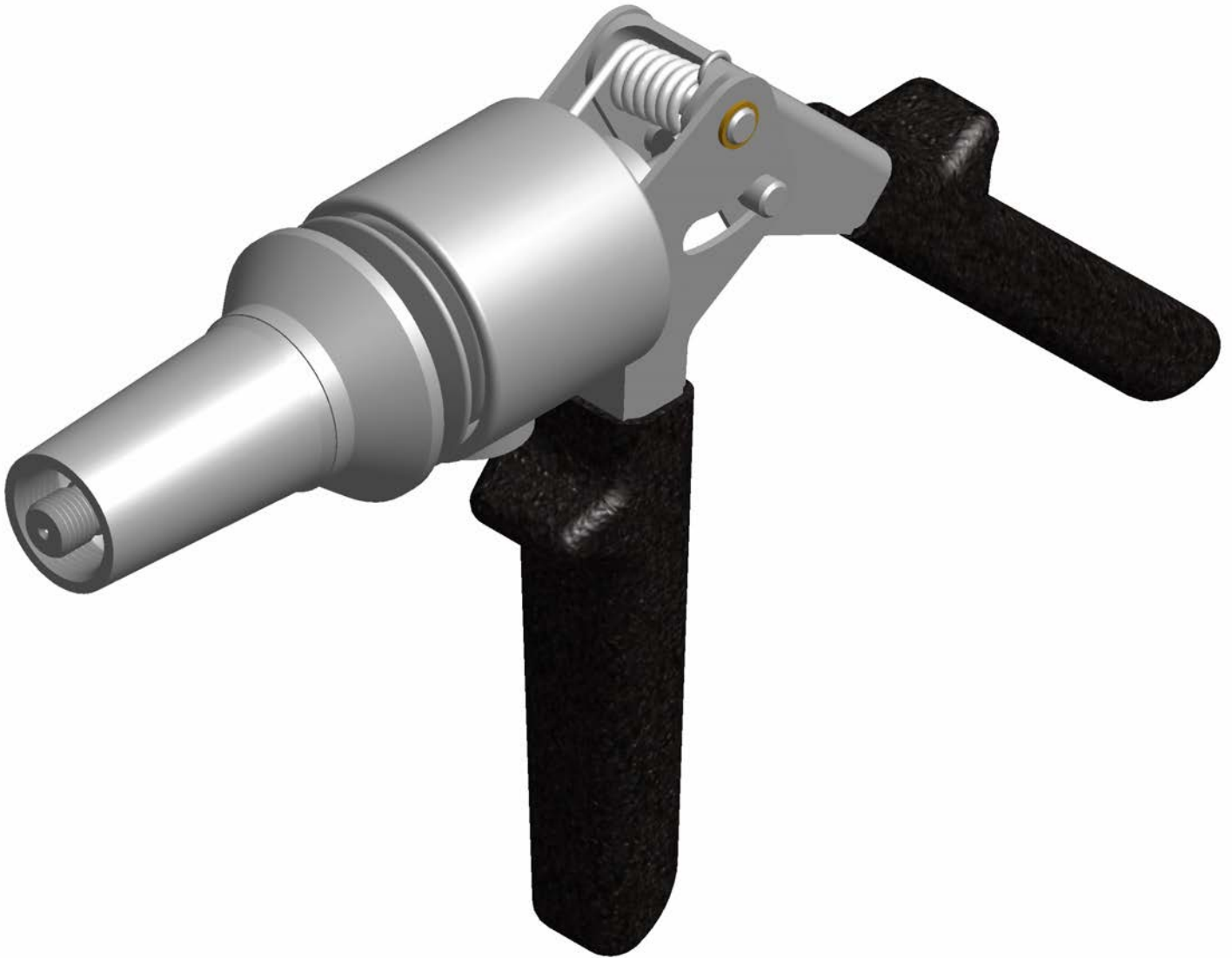


ORIGINAL INSTRUCTIONS

GB456A

HYDRAULIC HAND RIVETER



GAGE BILT
 **MADE in USA**

 **INNOVATIVETOOLING**
On the leading edge of Aircraft Tooling
 800-832-7009
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 innovativetooling.com

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WARRANTY

Seller warrants that all goods covered by this catalog will conform to applicable specifications and will replace or repair, EXW our plant, any goods providing defective from faulty workmanship, or material, for 1 year 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 the 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 1 year after the receipt of the material by the customer.

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

WARNING:

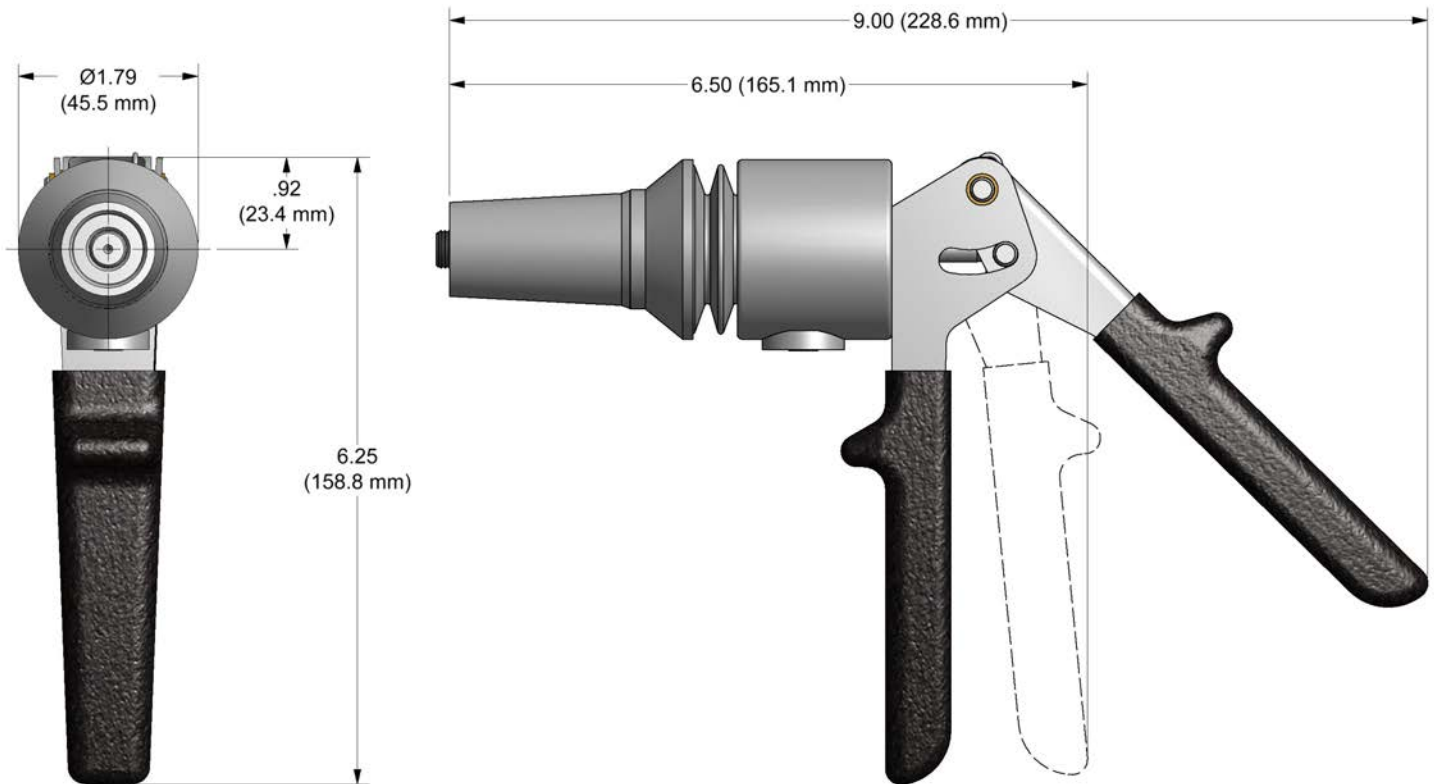
DO NOT PUMP TOOL WHEN THE SPRING IS NOT IN PLACE, TO RETRACT TOOL WITH NO SPRING, BRING HANDLES TOGETHER, PUSH THE BUTTON WITH MIDDLE FINGER OR FREE HAND, PLACE THUMB AND FIRST FINGER OF SAME HAND ON FRONT OF PROTECTIVE SHIELD AND FORCE IT TO THE FULL RETRACTED POSITION, RELEASE BUTTON AND HANDLES.

DESCRIPTION

The GB456A is a hydraulic hand riveter designed specifically for the most efficient installation of all 1/8", 5/32", 3/16" and 1/4" diameter Cherrymax® and High Clinch® rivets. It weighs 20 .5 oz.(.58kg) and is 6-1/4" high x 6" long x 1 3/4" wide without a pulling head. The GB456A has a .5/8" (15.88mm) max. stroke and a minimum rated pull load of 3,500 lbs. (15.6 kN)

The Hydraulic system is sealed and oil should not be added. If the tool should be damaged and leaks oil, CONTACT YOUR LOCAL DISTRIBUTOR OR GAGE BILT. INC.

NOSE ASSEMBLIES ARE NOT FURNISHED WITH THIS TOOL AND MUST BE ORDERED SEPARATELY.



SPECIFICATIONS

Hand Held Weight	- 20.5 oz. (0.58 kg)
Power source	- Hand operated. Two Valve, cylindrical hydraulic pump assembly, with pressure relief valve.
Hydraulic oil	- Chevron AW Machine Oil 10 ISO-10 or equivalent
Setting stroke Max.	- 5/8" (15.88 mm)
Rated pulling force Max.	- 3,500 lbs. (15.6 kN)

SAFETY WARNINGS



**PLEASE READ THIS MANUAL BEFORE
SERVICING OR USING THIS TOOL.**



WARNINGS:

**MUST BE UNDERSTOOD TO AVOID
SEVERE PERSONAL INJURY**

CAUTIONS:

**SHOW CONDITIONS THAT WILL
DAMAGE EQUIPMENT OR STRUCTURE**

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.

CAUTION

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

WARNING

When operating, repairing or overhauling tool, wear approved eye protection. Do not look in front of nose assembly or rear of tool when installing fastener.

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.

CAUTION

Tool is not to be used as a hammer.

CAUTION

Do not use beyond the design intent.

WARNING

Do not place hands or fingers between nose assy and work piece when installing fastener.

WARNING

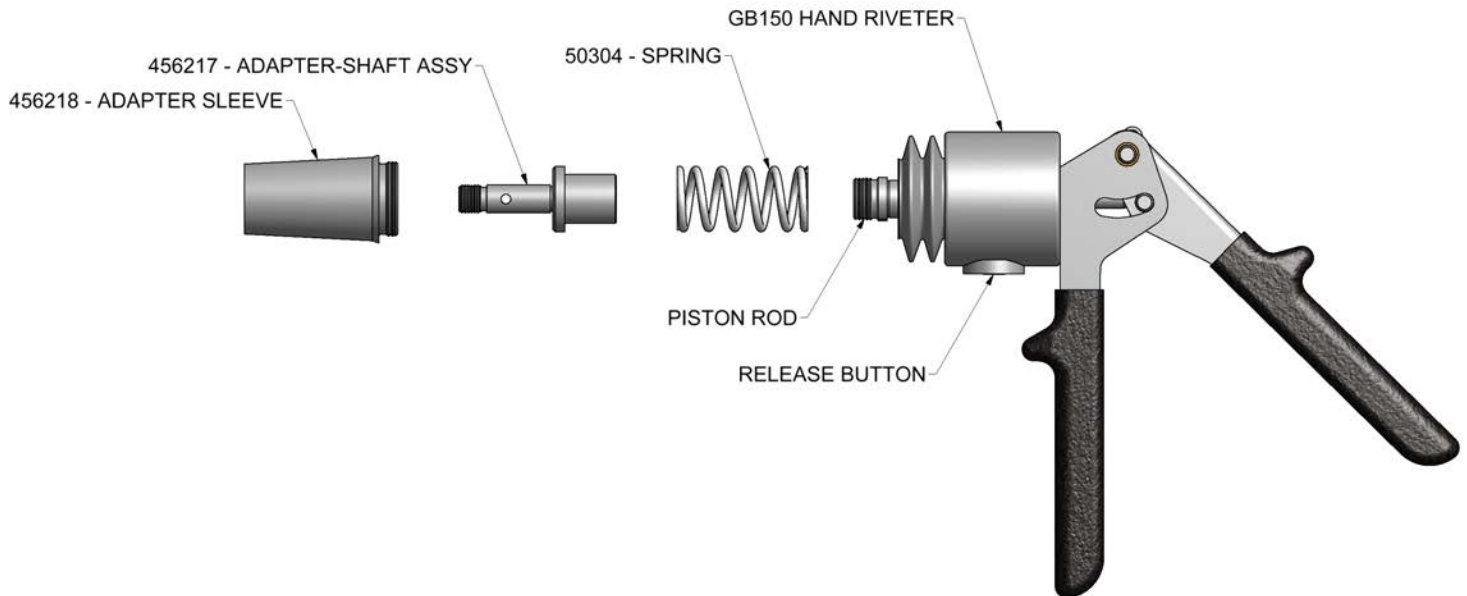
Tool must be maintained in a safe working condition at all times and examined on a daily basis for damage or wear. Any repair should be done by qualified personnel trained on Gage Bilt procedures.

WARNING

Do not use tool in explosive atmosphere.

GB456A PARTS LIST

⚠ WARNING: Do not squeeze handle together without Adapter-Shaft Assembly (456217) and the Spring (50304) being installed on tool.



456219-ADAPTER ASSEMBLY

1. Insert adapter shaft assembly (456217) into end of spring (50304).
2. Insert other end of spring (50304) over piston rod and thread hand tight until it stops.
3. Place adapter sleeve (456218) over assembly and thread hand tight into tool.

*Refer to pulling head data sheets for installation and adjustments.

HOW TO USE THE GB456A

1. Attached correct nose assembly to tool.
2. Install fastener into work.
3. Install fastener into nose assembly.
4. Squeeze handles together repeatedly until fastener breaks
5. Reset tool by pressing and holding the release button in while squeezing handles together until tool is fully retracted.
6. Remove pintail.
7. Repeat steps 1-6.

*Refer to pulling head data sheets for installation and adjustments.

DAILY MAINTENANCE

- ⚠ WARNING:** Tool must be maintained in a safe working condition at all times and examined on a daily basis for damage or wear.
- ⚠ WARNING:** Excessive contact with hydraulic oil and lubricants should be avoided.
- ⚠ WARNING:** Maintenance personnel **MUST** read and understand all warnings and cautions.
- ⚠ WARNING:** Read SDS documents for all applicable materials.

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.

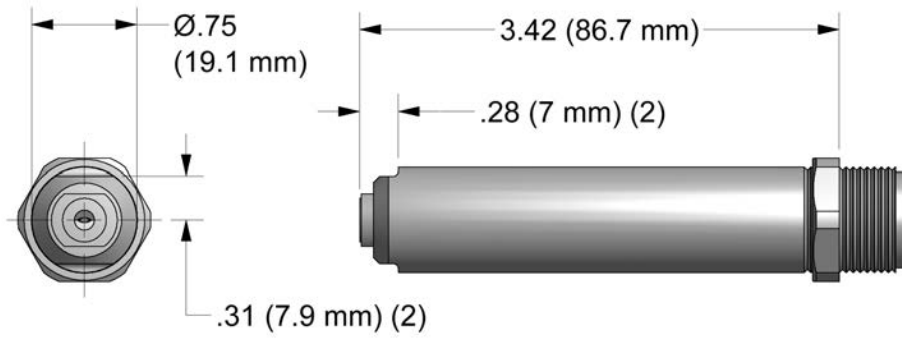
- *Proper care by operator is necessary in maintaining full productivity and reducing downtime. Read all applicable tool manuals and nose assembly data sheets prior to operating tools.
- *Keep nose assemblies, especially jaws, clean and free of chips and debris. Lube jaws and collet surfaces that jaws ride on with light machine oil on a daily basis.
- *Check tool daily for damage or hydraulic leaks.
- *Check that nose components have not vibrated loose. Tighten if necessary.

TROUBLESHOOTING

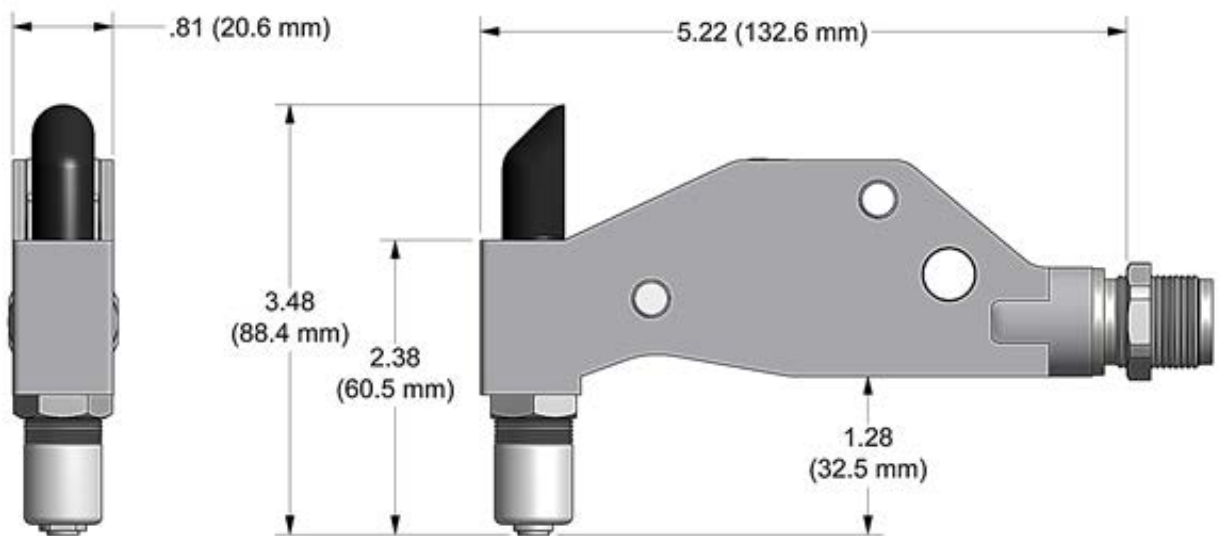
Providing all maintenance conditions have been met, follow this systematic approach to diagnosis.

1. RIVET PINTAIL IS STUCK IN TOOL—SEE STEP (5) UNDER HOW TO USE.
 - a) Point tool downward and lightly tap nose assembly against hard surface while squeezing handles. Press release button.
 - b) Disassemble and remove pintail and re-assemble.
2. TOOL WILL NOT REVERSE
 - a) Squeeze handles until there is a slight give, then press release button while still squeezing handles.
 - b) Disassemble and remove any foreign objects and re-assemble.
3. FASTENER DOES NOT PULL RIVET
 - a) Ensure Nose Assembly is properly attached.
 - b) Replace Jaw Assembly.
4. RIVET DOES NOT FIT TOOL
 - a) Ensure proper nose assembly is on tool
5. TOOL IS LEAKING HYDRAULIC OIL
 - a) The Hydraulic system is sealed and oil should not be added. If the tool should be damaged and leaks oil. CONTACT YOUR LOCAL DISTRIBUTOR OR GAGE BILT. INC.

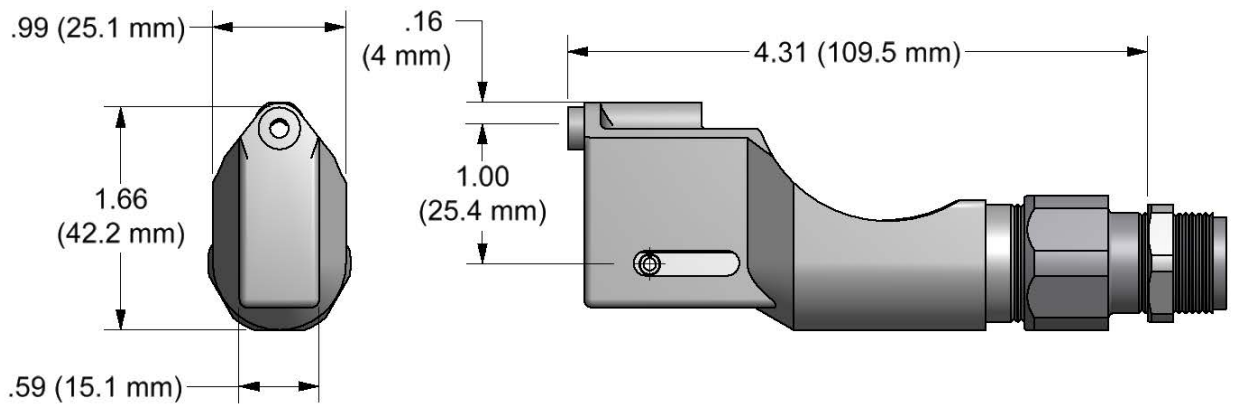
NOSE ASSEMBLIES



456MAX-749-35



456MAX-704-54RA



456MAX-704-43OS

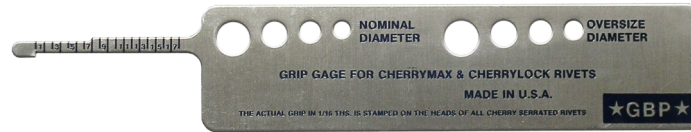
This unit complies to EN 792-1 Standards

RECOMMENDED ACCESSORIES FOR CHERRYMAX® RIVETS

269G3 GRIP GAGE

A simple, self-explanatory gage for determining proper rivet grip length and material thickness.

GRIP GAGE FOR CHERRYMAX® AND CHERRYLOCK® RIVETS
269G3 (Similar to #269C3)



Riveter Kits Available

Contact Gage Bilt to customize your riveter kit today.

