

ORIGINAL INSTRUCTIONS

G750A

Patent Number 5425164

HAND HYDRAULIC RIVETER
NSN 5120-01-432-9361

MANUAL



CHERRY®
AEROSPACE

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Description

The Cherry G750A hand hydraulic riveting tool provides the versatility of a pneumatic-hydraulic riveter but with the lightweight, high pull strength ratio not found in other hand riveters.

It has a unique 2-stage hydraulic power cylinder that provides the user with the ease of pulling the handle without the strain normally endured to install a high strength fastener. This patented 2-stage power feature allows the user to squeeze the handle throughout the increase power requirement, without feeling the need to squeeze harder to install the fastener.

The Cherry G750A hand riveter can install a variety of blind fastener styles, diameters, head configurations, and material combinations without changing the pulling head or adjusting the tool. With the standard pulling head it can install CherryMAX® and SST® blind rivets in -4, -5, -6, diameters. It is also capable of installing -8 dia CherryMAX®, -04, -05, -06 dia. MaxiBolt blind bolts or threaded inserts by simply changing the pulling head.



Specifications

Weight	1.9 lbs.
Stroke	.750"
Pulling Capacity	3800/4400 lbs.
Overall Height	6.4"
Overall Length	7.5"

Fluid used

Use automatic transmission fluid Type "A" (no substitutes). CHERRY® recommends using ATF, Dexron III oil.

DEXRON III OIL SAFETY DATA

FIRST AID

Skin: Wash thoroughly with soap and water as soon as possible. Casual contact requires no immediate attention. If irritation develops, consult a physician.

Ingestion: Seek medical attention immediately. DO NOT INDUCE VOMITING.

Eyes: Flush with copious amounts of water. If irritation develops, consult a physician.

Inhalation: No significant adverse health effects are expected to occur on short term exposure. Remove from contaminated area. Apply artificial respiration if needed. If unconscious, consult physician.

FIRE: Suitable extinguishing media: CO₂, dry powder, foam or water fog. DO NOT use water jets.

ENVIRONMENT: Waste Disposal: In accordance with local, state and federal regulations.

Spillage: Prevent entry into drains, sewers and water courses. Soak up with diatomaceous earth or other inert material. Store the spent fluid in appropriate containers for disposal.

HANDLING: Eye protection required. Protective gloves recommended. Chemically resistant boots and apron recommended. Use in well ventilated area.

COMBUSTIBILITY: It is slightly combustible when heated above flash point. It will release flammable vapors which can burn in open or be explosive in confined spaces if exposed to source of ignition.

STORAGE: Avoid storage near open flame or other sources of ignition.

PROPERTIES

Specific gravity	0.863
Weight per gallon	7.18 lbs.
Open flash point	>200°C (392°F)

HOW TO USE THE G750A

1. For CherryMAX[®] and Maxibolt Use

- A. Make sure tool is configured to the correct fastener. See pages 4, 9 & 10.
- B. The piston should be fully retracted by depressing the return valve on the left side of the tool.

Caution: *Jaw damage may result if the piston is not fully retracted before installing a rivet.*

TIP: When reattaching the H750A-456 pulling head to the G750A, it is necessary to align the jaws, first pump the handle several times. Second, place a rivet stem into the H750A-456 pulling head. Last, fully retract the piston while the rivet stem is in the H750A-456 pulling head.

- C. Insert the rivet into the nosepiece of the pulling head, then insert the rivet into the prepared hole.
- D. Cycle the tool until the rivet stem breaks. TIP: Using short strokes makes it easier to operate the tool.
- E. Depress the return valve allowing the piston to fully retract, permitting the stem to fall from the front of the tool.

2. Use with the threaded Insert “Rivnuts”

- A. Be sure you have the proper size adapter for the threaded insert to be installed—the difference is the pull-up stud and the anvil. See page 10.
- B. If tool is of pressure regulator type 750-112 (see pg.6), adjust the pressure regulator by loosening the locknut on the right side of tool. Rotate counterclockwise, all the way out. This will leave the pressure regulator wide open—no pulling action will take place.
- C. Screw the threaded insert into the pull up stud.
- D. Place the threaded insert into the prepared hole in a test plate of the proper thickness.
- E. Rotate the knob of the pressure regulator clockwise in small increments and begin cycling the tool. You will notice the insert starting to collapse. The amount of upset will be determined by the amount of pressure established by the control valve. You can fine tune the adjustment until the proper upset is achieved. At this point, lock in the setting with the locknut.
- F. The tool is now ready to be used in a production environment and will perform consistently.

USING THE ADAPTER

(See page 9 for G750A assembly drawings)

When installing the 750A-088 adapter, remove the outer sleeve (66) and collet (65) with spring (27), Jaws (64), jaw follower (63), and jaw follower spring (61).

The large collet spring (27) must be positioned over the drawbar extension adapter before threading on the drawbar (17). (This spring can be removed from the collet by turning counterclockwise.) Install the outer portion of the adapter sleeve making certain of full thread engagement on both parts.

When replacing the outer sleeve (750-016), cycle the lever one or two times allowing easier thread engagement.

Before installing the accessory heads, make certain the drawbar is fully extended to ensure full thread engagement.

The tool is now ready to accept the H753A-456 or H781-456. (See page 6)

MAINTENANCE DISASSEMBLY

To facilitate assembly, it is recommended that you have on hand a Cherry G750KT Tool Kit. The G750KS Service Kit contains replacement O-rings, jaws, jaw follower, bumper, bladder, seals and springs to replace worn or damaged parts.

For complete disassembly of the G750A tool, please follow the instructions indicated.

Unscrew sleeve (66) and remove. If piston rotates while loosening sleeve, pump tool to end of stroke and continue to remove. Carefully remove screws (4) and (33) vent plug (35), and bladder (34). **CAUTION: Screws (4) & (33) are under pressure and will spray.**

Drain the remaining fluid by depressing release knob (44).

Use collet cap (750-045) to remove collet (65) and remove nut lock (18) spring base (26) piston return spring (27) jaw follower spring (61) bumper ring (62) jaw follower (63) and jaws (64). Screw the sleeve (66) into the piston (19) and pull the piston out of the housing. Using a 7/8" hex deep socket wrench, unscrew nut (30) then unscrew drawbar (17) and remove. **Note: The drawbar (17) has a left hand thread. (Turn clockwise to remove).**

When removing the drawbar from the housing, usually the nut (30) and the insert (14) will stay with it. These items can be separated once removed from the housing. Remove the spring (60). Depress the lever (6) to push the plunger (8) through the housing, then remove the plunger. Remove screw (29) and remove shell (28). Remove screw (31) pin (5) and lever (6).

If necessary, remove screw (58), ball (11), ball guide (54) spring (57) and O-ring (3). Remove cartridge cover (48) using 7/8" wrench. Remove spacer (47), spring (46) and shift pin (45).

Using a small, flat screw driver to hold the poppet (40) to prevent rotation, unscrew the knob (44) and remove the spring (43).

NOTE: The knob (44) is Lock-Tite sealed at the factory and may require extra effort to unscrew. Using a 3/8" diameter rod, push gently on shift spool (37) and remove with poppet (40) seals (10,9,38,39,41) and (42). Poppet (40) can be separated from the shift spool once removed from the housing by applying

thumb pressure on the threaded end. **NOTE: seals (41, 42) must be removed from the small diameter end of the spool.** If necessary, unscrew spring retainer screw (51) and remove spring (52) and ball (53).

CAUTION: Do not open or remove set screws (2). These are permanently factory sealed plugs.

All parts should be cleaned and inspected for damage or wear. O-rings, seals and springs should be replaced as needed.

ASSEMBLY

When replacing O-rings and seals use assembly tools from the G750KT Tool Kit to avoid damage to the seals. Lubricate all seals and O-rings before installation.

Replace O-ring (36) on vent plug (35) pull bladder (34) over end of vent plug (35) then place O-ring (20) over bladder (34) and carefully insert into housing cavity. Thread vent plug into housing.

Place O-ring (3) on screw (4) and screw into housing.

Place O-ring (56) on insert (55) and screw the insert into the cavity located under the Cherry logo. Place ball (11) and ball guide (54) and washer (59) on the ball guide stem (54). Place spring (57) on top of the washer into the cavity of the insert (55). Place O-ring (3) on the screw (58) and place in the cavity to contain the above components. **NOTE: If tool does not develop maximum power, additional washers (59) are required.**

NOTE: If your tool is the G750A-080R, the adjustable knob (750-095), will replace the screw (58) and O-ring (3). This adjustable control valve is intended to prevent the stripping of the insert threads by restricting the pulling force.

Place O-rings (39), (9) and back-up rings (38), (10) on shift spool (37). Make sure O-rings are toward the center of the spool and the back-up rings are toward the ends. Use assembly tool (750-043) to insert sub-assembly shift spool into the housing. Make sure that the spool is generously lubed and fully inserted to the end of the cavity.

Place poppet (40) into shift spool (37) supporting with small screw driver while placing O-ring (41) and back-up ring (42) on poppet (40) from the left hand side of the tool. Carefully screw the release knob (44) without spring (43) to push and seat seal onto the poppet (40). Place spring (43) adding a small drop of #242 Lock-tite or equivalent on the threaded end of the poppet (40). Screw the release knob (44) onto poppet (40).

Allow the Lock-tite to cure for 2 hours before use. **There is no need to rotate the knob after assembly.** To return or retract the piston to original position, push in the knob.

Drop ball (53) and spring (52) in cartridge cover and secure with screw (51) with O-ring (3) on it. Place spring (46) on shift pin.

With needle nose pliers, place the shift pin (45) in recess of the spool (37). Place spring (46) on shift pin. Apply lube to spacer (47) and place it in cartridge cover (48). Screw the cartridge cover assembly (48) into the housing.

Place seals (21) and (20) on the drawbar (17) and insert O-ring (16) with back-up ring (15) into the drawbar (17). Plunger (8) with drawbar insert (14) can be used to facilitate this. Place

drawbar insert (14) in the drawbar (17). Torque (approximately 25 ft. -lb.) this assembly into the housing. Tighten with a 3/8" wrench.

NOTE: This is a left hand thread (turn counterclockwise to install).

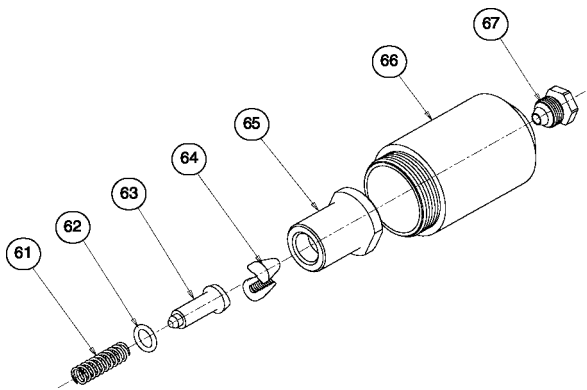
Using a 7/8" deep socket wrench and spacer (750-052), torque the nut (30) (approximately 10 ft. -lb.) Care should be exercised not to cross thread and not to damage seals.

Place seals (25, 24) on the piston (19) and insert the seals (22, 23) into the piston (19). O-rings should be placed away from the wrench flats end of the piston. From the Tool Kit, select tool assembly (750-046) and place on end of the drawbar. Slide the piston over the protected area until it bottoms out. Place spring base (28) over drawbar (17) place nut (18) and tighten.

Install #10-32 by 1.50" long screw (not provided) into the hole of screw (31). Place plunger insertion sleeve (750-44) into rear of housing. Slide lubricated plunger assembly (8) with plunger spring (60) screw (13) check valve spring (12) check ball (11) and seals (9, 10) installed, through the sleeve and push the plunger down with 3/8" diameter rod. While holding the plunger down in place, lift plunger insertion sleeve to allow inserting of flat stock .060 x .250 x 2.0" long beyond the #10-32 screw to hold the plunger in place. At this time, remove the plunger insertion sleeve (750-044).

Insert the lever (6) align and insert pin (5), squeeze lever (6) and remove flat stock. Release lever and remove #10-32 screw. Install screw (31) to retain pin (5). Install shell (28) with screw (29).

CherryMAX® Pulling Head Assembly Instructions



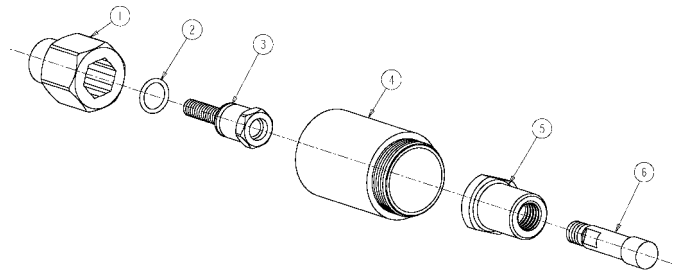
Place the jaw follower spring (61) into the front end to the drawbar. Place the O-ring (62) over the jaw follower (63). Insert the jaw follower subassembly into the front end of the drawbar.

Lube jaws (64) and place in collet (65). Place spring (27) over collet (65). Assemble collet on drawbar. Use assembly tool (750-045) from Tool Kit to facilitate installation. **NOTE: Collet must always be fully threaded on drawbar.** Screw nosepiece (67) on outer sleeve (66) and thread into piston (19).

TIP: When reattaching the H750A-456 pulling head to the G750A, it is necessary to align the jaws.

To align the jaws, first pump the handle several times. Second, place the rivet stem into the H750A-456 pulling head. Last, fully retract the piston while the rivet stem is in the H750A-456 pulling head.

Rivnut Adapter Assembly Instructions



Place the rivnut spindle 6 inside the collet 5 and screw as a sub-assembly on the drawbar (17). Screw sleeve 4 on the piston (19). Screw the pull-up stud 3 on the rivnut spindle 5 and tighten by holding the spindle 5. Use wrenches to tighten. Install O-ring (2 on the pull-up stud (2) and install on the anvil nut 1 on the pull-up stud 2. Changing from one size to another, it will only be necessary to change the anvil nut 3 and the pull-up stud 2.

Filling/Bleeding Instructions

Remove screw (4) and attach Air Bleeder 745A45 with adapter 750-040 through the same hole.

Remove screw (33) and force fluid into the tool while actuating the lever (6) and tilting the tool in different directions allowing the air to escape through the hole of screw (33). When bubbles no longer exit, replace screw (33) with O-ring (32) and continue forcing fluid into the tool while actuating the lever (6) until piston is fully extended.

Place thumb over hole in vent plug (35) to create a seal and detach air bleeder and replaced screw (4) with O-ring (3).

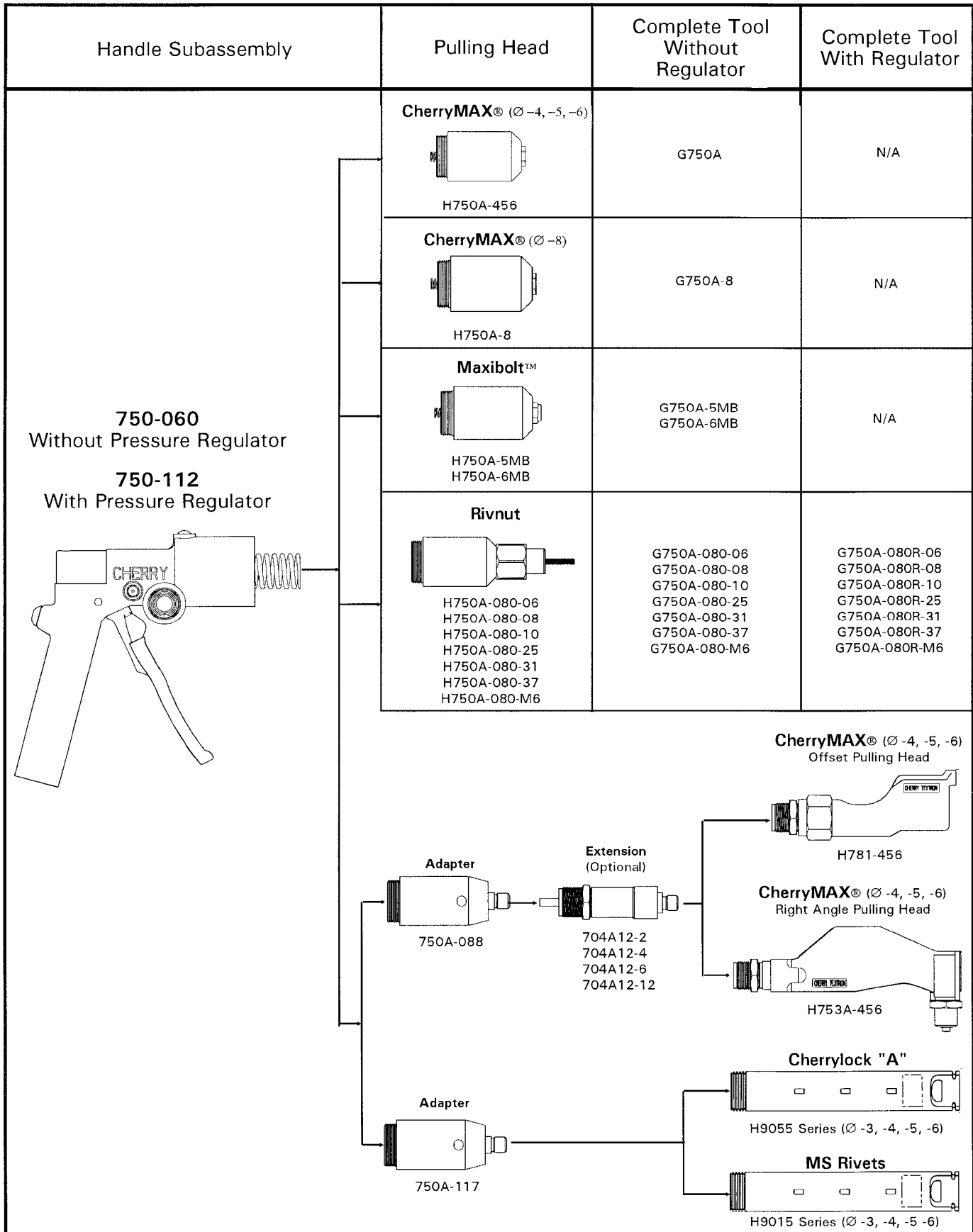
Push release knob (44) to force fluid from main cylinder to the reservoir. Normally the piston will not retract all the way because the tool was filled with excess fluid.

Carefully loosen screw (33) to release excess fluid.

CAUTION: Cover screw (33) as fluid is under pressure and will spray.

When piston is fully retracted, tighten screw (33) and check tool performance. The tool should take from 10 to 12 pumps from lever (6) to travel the full stroke. If necessary, repeat bleeding procedure.

NOTE: Set screws (2) (3 screws) are factory set and should not be removed



G750A TOOL KITS

G750AKT TOOL KIT

QTY.	PART NO.	DESCRIPTION
1	745A45	CHERRY AIR BLEEDER
1	750-040	ADAPTER FOR AIR BLEEDER
1	750-043	ASSEMBLY SLEEVE FOR SHIFT SPOOL
1	750-044	SLEEVE, PLUNGER INSERTION
1	750-045	COLLET CAP
1	750-046	SLEEVE, PISTON ASSEMBLY
1	P-1349	SOCKET WRENCH
1	750-052	WRENCH SPACER

G750AKTR RIVNUT TOOL KIT

QTY.	PART NO. & DESCRIPTION
1	G750A-080R-06 RIVNUT TOOL
1	H750A-456 CHERRYMAX PULLING HEAD
1	750-086-08 ANVIL NUT
1	750-086-10 ANVIL NUT
1	750-086-25 ANVIL NUT
1	750-086-31 ANVIL NUT
1	750-086-37 ANVIL NUT
1	750-086-M6 ANVIL NUT
1	750-087-08 PULL-UP STUD
1	750-087-10 PULL-UP STUD
1	750-087-25 PULL-UP STUD
1	750-087-31 PULL-UP STUD
1	750-087-37 PULL-UP STUD
1	750-087-M6 PULL-UP STUD
1	P-1350 PACKING BOX
1	435-80 G750 NAMEPLATE
1	TLC865 CHERRYMAX POCKET CARD
1	TMAN-G750A-G750A MANUAL
1	269C3 SELECTOR FOR CHERRYMAX GAUGE

G750AKS SERVICE KIT

QTY.	PART NO.	DESCRIPTION
1	750A-033	BLADDER
3	P-383	O-RING
1	P-1313	SPRING
2	P-112	O-RING
2	P-650	BACK-UP RING
1	P-1344	O-RING
1	P-1345	BACK-UP RING
1	P-299	O-RING
1	P-869	BACK-UP RING
1	P-1315	SPRING
1	P-313	O-RING
1	P-1347	BACK-UP RING
1	P-1331	O-RING
1	P-832	O-RING
1	P-706	O-RING
1	P-925	O-RING
1	P-945	O-RING
1	P-621	O-RING
1	P-1007	O-RING
1	P-1346	BACK-UP RING
1	P-1294	O-RING
1	P-1328	SPRING, RELEASE KNOB
1	P-1365	SPRING, BYPASS
1	P-1321	SPRING, VALVE CHECK
1	P-1324	O-RING
1	P-1324	O-RING
1	P-1320	SPRING, SHIFT PRESSURE
1	P-231	O-RING
1	P-919	BACK-UP RING
1	P-1381	SPRING
1	P-1383	SPRING



G750ACMR HAND RIVETER

NSN 5120-01-432-6190

The Cherry G750ACMR hydraulic riveter tool kit includes the G750A with an H750A-456 pulling head, an adapter assembly, a right angle pulling head, an offset pulling head and a sturdy plastic carrying case.

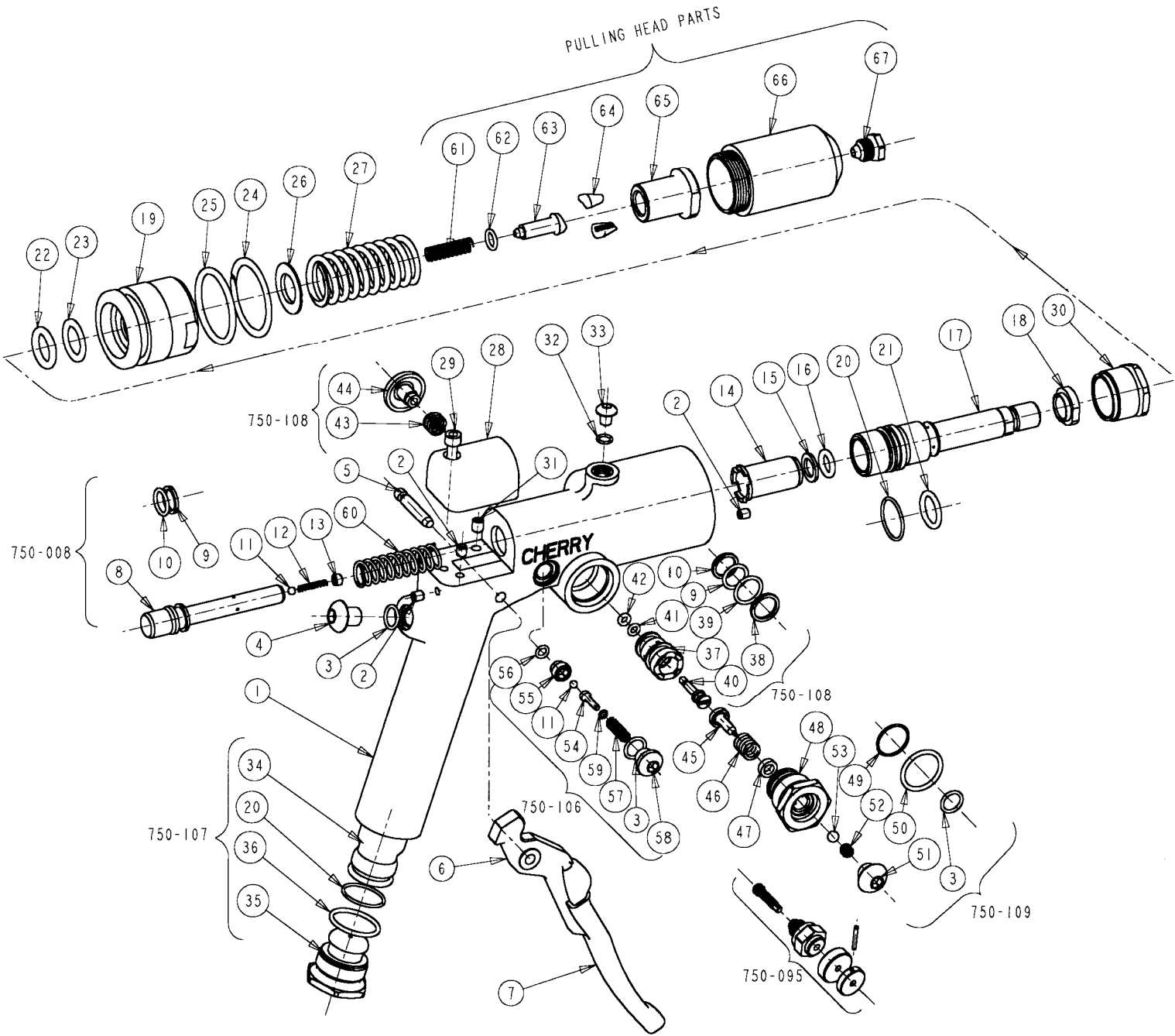
ITEM NO.	QTY.	PART NO.	DESCRIPTION
1	1	G750A	HAND RIVETER (INCLUDES HEAD)
2	1	H781-456	OFFSET PULLING HEAD
3	1	H753A-456	RIGHT ANGLE PULLING HEAD
4	1	750A-088	ADAPTER ASSEMBLY
5	1	TLIT H781-456	H781-456 TOOL SET
6	1	TLIT H753A-456	H753A-456 TOOL SET

G750A PARTS LIST

ITEM NO. / DESCRIPTION		QTY
750-060 HANDLE SUBASSEMBLY		
1	750-061 MACHINED HOUSING	1
2	P-510 SET SCREW	3
3	P-383 O-RING	3
4	P-1322 CAP SCREW	1
5	750-031 PIN	1
6	750-012 LEVEL	1
7	P-1342 VINYL GRIP	1
750-008 PLUNGER SUBASSEMBLY		
8	750-029 PLUNGER	1
9	P-112 O-RING	2
10	P-650 BACK-UP RING	1
11	P-164 BALL	1
12	P-1332 SPRING	1
13	P-1333 HOLLOW LOCK	1
14	750-013 DRAWBAR INSERT	1
15	P-1346 BACK-UP RING	1
16	P-1007 O-RING	1
17	750-049 DRAWBAR	1
18	750-111 NUT, LOCK	1
19	750-015 PISTON	1
20	P-621 O-RING	1
21	P-945 O-RING	1
22	P-1344 O-RING	1
23	P-1345 BACK-UP RING	1
24	P-869 BACK-UP RING	1
25	P-299 O-RING	1
26	750-020 SPRING BASE	1
27	P-1315 SPRING, PISTON RETURN	1
28	750-028 SHELL	1
29	P-153 SOCKET HD. CAP SCREW	1
30	750-030 NUT	1
31	P-99 SET SCREW	1
32	P-1294 O-RING	1
33	P-573 CAP SCREW	1
750-107 BLADDER SUB-ASSEMBLY		
34	750-033 BLADDER	1
20	P-621 O-RING	1
35	750-091 VENT PLUG	1
36	P-1331 O-RING	1

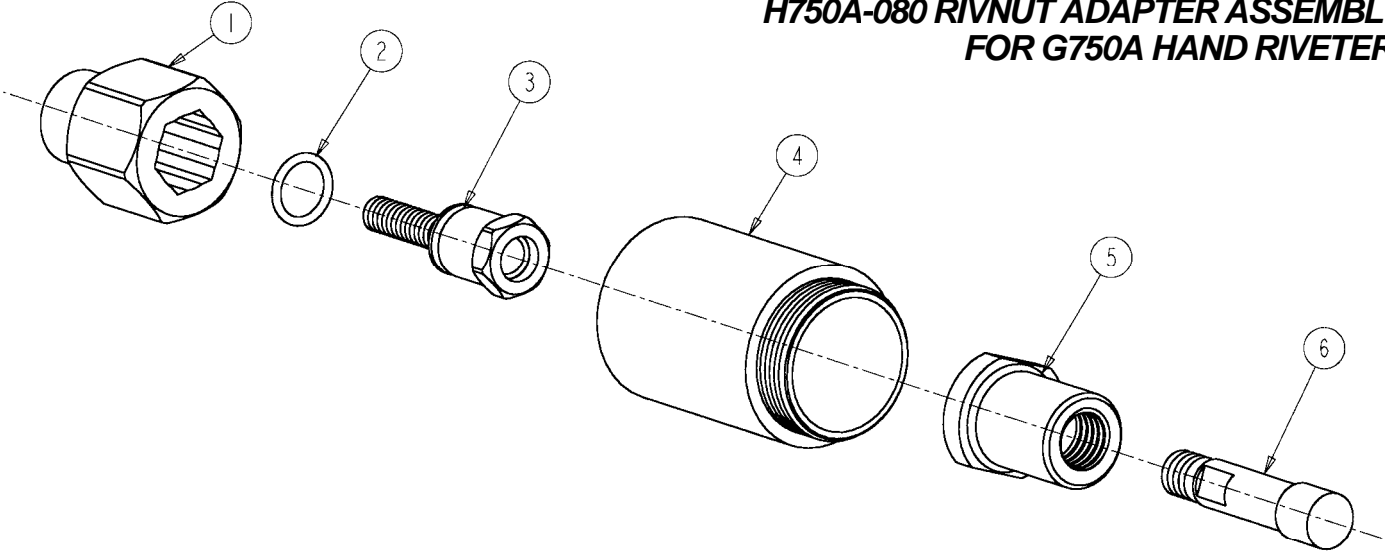
ITEM NO. / DESCRIPTION		QTY
750-060 HANDLE SUBASSEMBLY		
750 -108 VALVE, RETURN SUBASSEMBLY		
37	750-022 SHIFT SPOOL	1
38	P-919 BACK-UP RING	1
39	P-231 O-RING	1
40	750-023 POPPET	1
41	P-313 O-RING	1
42	P-1347 BACK-UP RING	1
9	P-112 O-RING	1
10	P-650 BACK-UP RING	1
43	P-1328 SPRING	1
44	750-024 RELEASE KNOB	1
45	750-025 SHIFT PIN	1
46	P-1320 SHIFT PRESSURE SPRING	1
47	750-036 SHIFT SPACER	1
750-109 VALVE, CHECK SUB-ASSEMBLY		
48	750-026 CARTRIDGE COVER	1
49	P-1324 O-RING	1
50	P-1334 O-RING	1
3	P-383 O-RING	1
51	750-027 SCREW	1
52	P-1321 VALVE CHECK SPRING	1
53	P-117 BALL	1
750-106 PRESSURE RELIEF VALVE		
54	750-065 BALL GUIDE	1
11	P-164 BALL	1
55	750-059 CHECK INSERT	1
56	P-925 O-RING	1
57	P-1383 SPRING	1
58	750-064 SAFETY CHECK SCREW	1
3	P-383 O-RING	1
59	P-1384 WASHER	1
60	P-1313 SPRING	1
750-071 PULLING HEAD CHERRYMAX OTHER ATTACHMENTS AVAILABLE		
61	P-1381 SPRING	1
62	P-832 O-RING	1
63	750-067 JAW FOLLOWER	1
64	701B18 JAWS, SET OF 2	1
65	750-066 COLLET	1
66	750-062 SLEEVE	1
67	750-019 NOSE PIECE	1

G750A EXPLODED VIEW

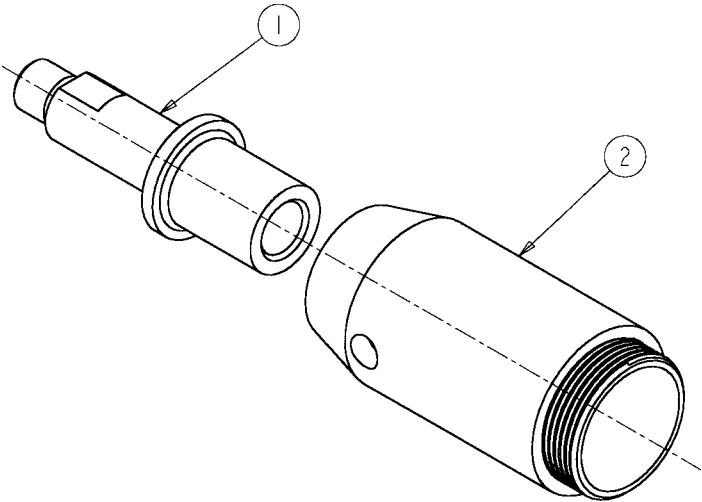


ADAPTERS & PULLING HEADS

H750A-080 RIVNUT ADAPTER ASSEMBLY FOR G750A HAND RIVETER



750A-088 ADAPTER

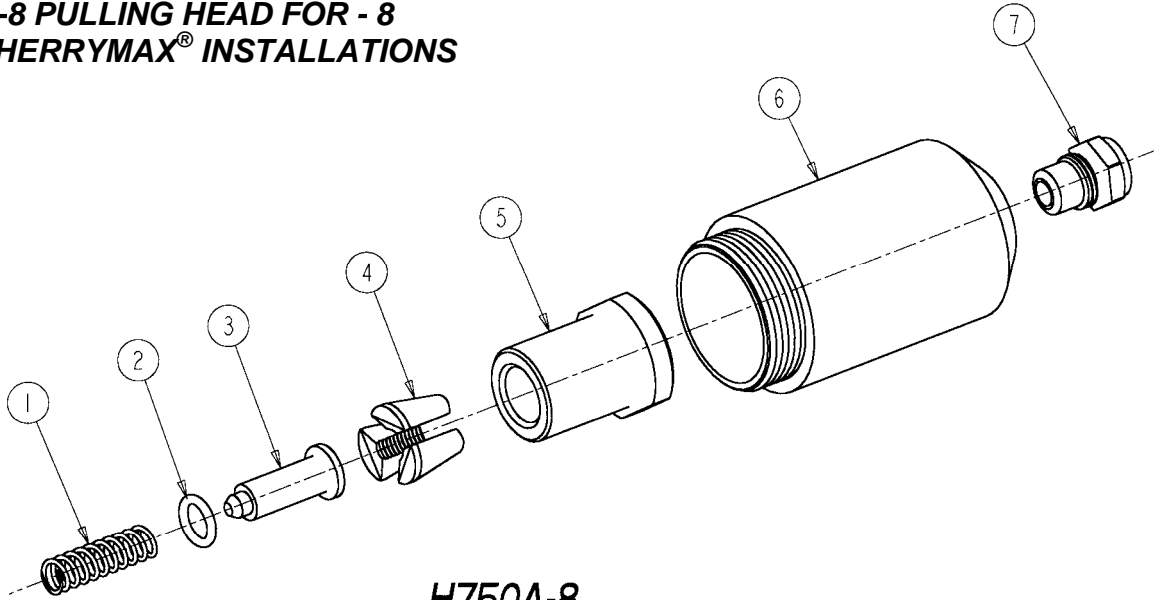


Note:
 This adapter is mounted on the G750A before attaching the H753A-456 Right Angle Pulling Head or the H781-456 Offset Pulling Head.

750A-088

ITEM NO.	REQ.	PART NO.	DESCRIPTION
2	1	750-090	SLEEVE, ADAPTER
1	1	750-089	ADAPTER, DRAWBAR

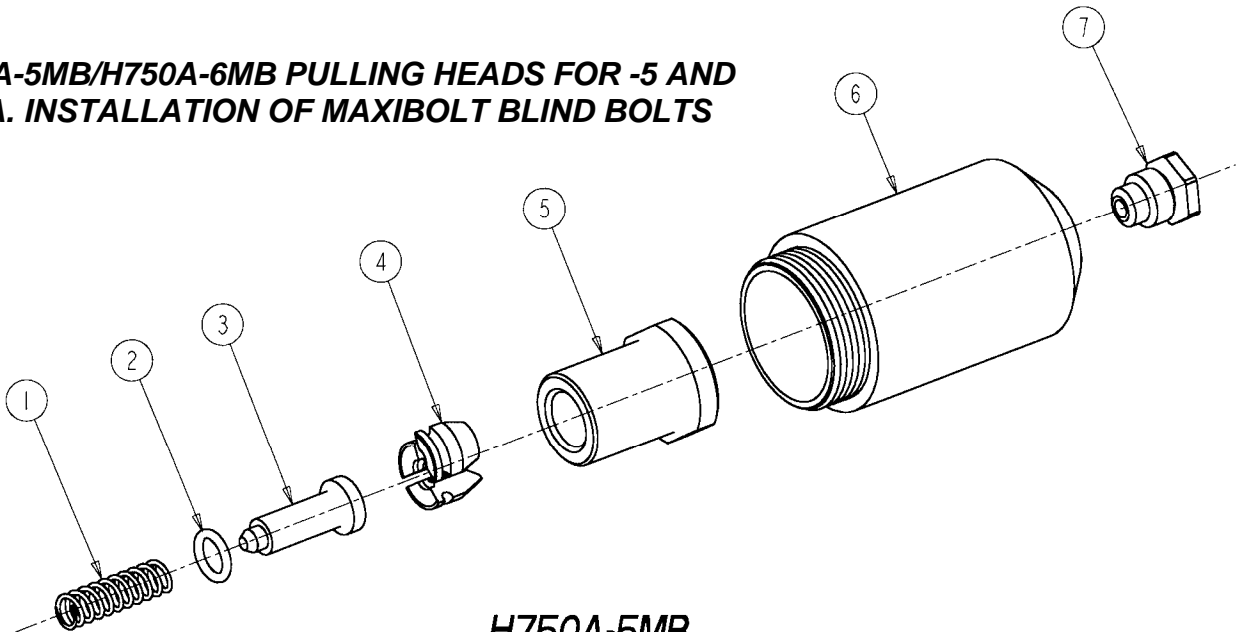
**H750A-8 PULLING HEAD FOR - 8
DIA. CHERRYMAX® INSTALLATIONS**



H750A-8

ITEM NO.	REQ.	PART NO.	DESCRIPTION
7	1	743A7-8Z	NOSEPIECE
6	1	750-062	SLEEVE
5	1	750-055	COLLET, 3 JAWS
4	1	743B54	JAW, SET OF 3
3	1	750-056	FOLLOWER, JAW
4	1	P-832	O-RING
1	1	P-1381	SPRING

**H750A-5MB/H750A-6MB PULLING HEADS FOR -5 AND
-6 DIA. INSTALLATION OF MAXIBOLT BLIND BOLTS**



**H750A-5MB
H750A-6MB**

H750A-6MB	744C76	750-076
H750A-5MB	744C75	750-075
MODEL NUMBER	JAWS SET	NOSEPIECE

ITEM NO.	REQ.	PART NO.	DESCRIPTION
7	1	SEE TABLE	NOSEPIECE, MAXIBOLT
6	1	750-062	SLEEVE
5	1	750-068	COLLET, MAXIBOLT
4	1	SEE TABLE	JAW, SET OF 3
3	1	750-069	FOLLOWER, JAW
2	1	P-832	O-RING (.379, .239, .070)
1	1	P-1381	SPRING (.240, .029, 1.50)



G750A WITH RIVNUT ADAPTER

The G750A with Rivnut adapter permits installation of threaded inserts.



H753A-456 RIGHT ANGLE PULLING HEAD

The right angle nose assembly permits installation of -4, -5, -6 CherryMAX® rivets in many applications that are inaccessible to a straight head.

NSN 5130-01-393-2926



H782-() OFFSET PULLING HEAD

The offset nose assembly permits installation of different sizes of:

Pull through rivets, Bulb Type Blind Fasteners, Self Plugging Rivets, Blind Bolts, Single Action Wiredraw in limited access areas. See tool sheet for details.



H781-456 OFFSET PULLING HEAD

The offset nose assembly permits installation of -4, -5, -6 CherryMAX® rivets in limited access areas.

NSN 5130-01-393-2925

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.

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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.

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