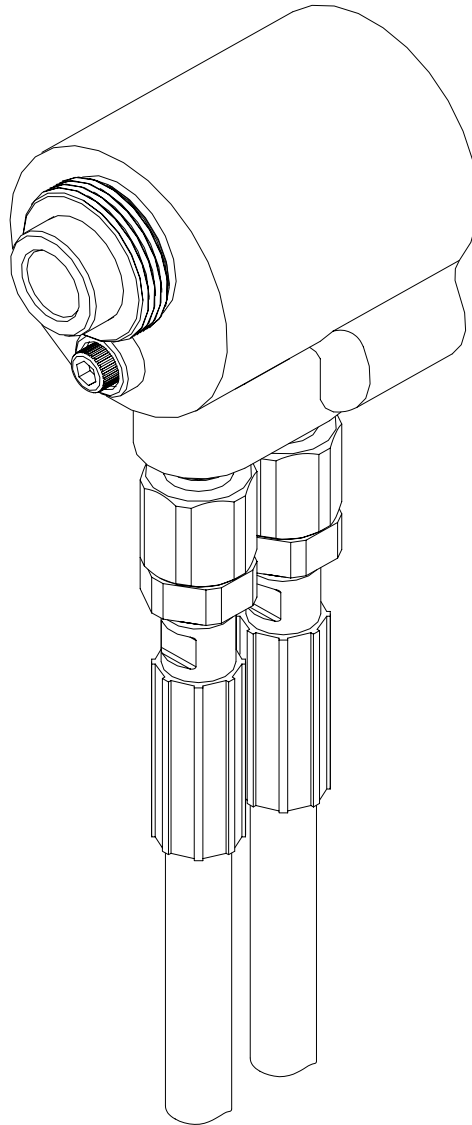


GBP204

GBP204A

HYDRAULIC INSTALLATION TOOL



GAGE BILT TOOLS ARE AVAILABLE WORLDWIDE
E-MAIL US FOR A DISTRIBUTOR NEAR YOU.

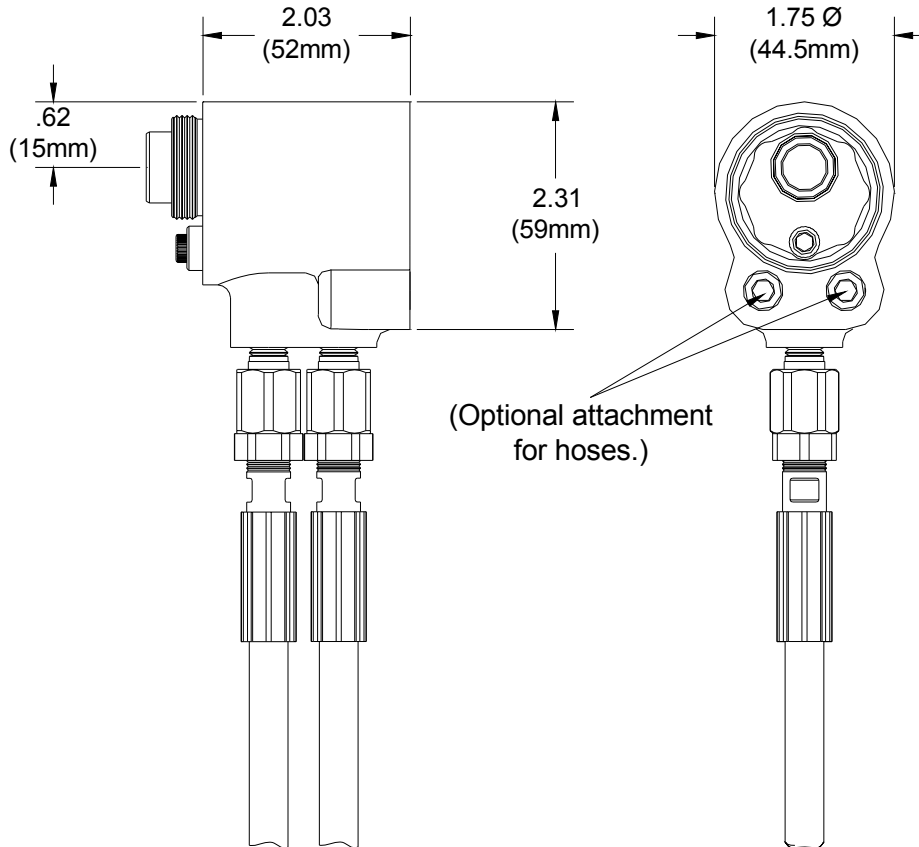
GAGE BILT
MADE IN U.S.A.

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SPECIFICATIONS

Weight	- 3 lbs.
Hyd. Pressure Req'd.	- 5600 PULL 2400 psi RETURN
Hyd. Power Source	- GBP940 or GBP910A Powerunit or equivalent.
Hydraulic Fluid	- Fire resistant hydraulic fluid conforming with OSHA regulation 1926.302.
Setting Stroke	- .500"
Rated Pull Load	- 5800 lbs.



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

Always disconnect tool from powerunit 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

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

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.

WARNING

Hydraulic power units that deliver high pressure for the "PULL" and "RETURN" and are not equipped with relief valves are specifically not recommended and may be dangerous.

DESCRIPTION

Covered under Patent No. 5,371,933

The GBP204 and the GBP204A are hydraulic installation tools designed specifically for the efficient installation of a wide range of blind rivets and lockbolt fasteners thru 1/4" diameter. It weighs just over 3 lbs. and can be operated in any position with one hand. It has a .500 rivet setting stroke and a rated pull load of 5800 lbs.

The GBP204 installation tool operates on hydraulic pressure developed by the GBP940 Powerunit set at 5600 psi maximum PULL pressure and 2400 psi maximum RETURN pressure. The tool comes equipped with 12 feet of hydraulic hoses and couplings, actuator and cord. The GBP204A installation tool operates on hydraulic pressure developed by the GBP910A Powerunit set at 5600 psi maximum PULL pressure and 2400 psi maximum RETURN pressure. The tool comes equipped with 12 feet of hydraulic hoses, swivels and couplings, air trigger and tube.

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

OPERATION

When the tool is connected to a powerunit, operation is controlled by a trigger or actuator attached to the hydraulic hoses. The GBP204A incorporates an air trigger to send a signal; the GBP204 an electric switch. When the button is depressed, a directional valve in the powerunit directs fluid to the front side of the piston forcing it and the nose assembly collet rearward. This action causes the jaws to clamp on the fastener pintail and pull the material together. The anvil is forced over the collar, swaging it into locking grooves of the fastener. Further force breaks the pintail off, approximately flush with the collar.

When the piston nears the end of its stroke it exposes flats on the back of the unloading valve. These flats "dump" fluid back to the powerunit tank. When the button is released the directional valve reverses fluid flow to the back of the piston and pushes the nose assembly off of the swaged fastener. The spent pintail is forced out the back of the nose assembly with the insertion of the next fastener.

MAINTENANCE

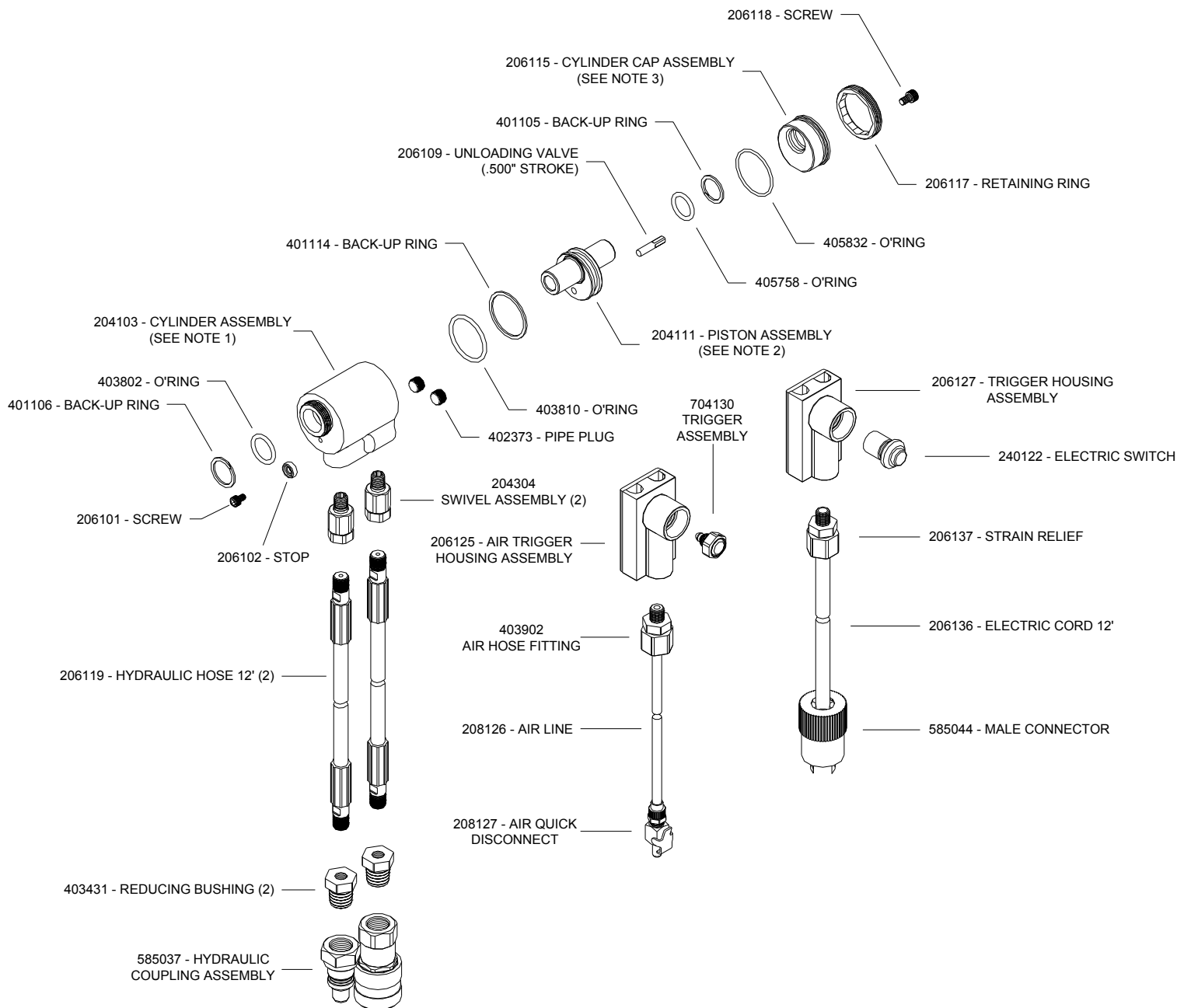
The performance of any tool depends upon the practice of good maintenance. Following these minimal requirements for service and care will extend the life of your tool.

- *Only use a hydraulic power source equipped with relief valves and pressures set within specified limits. Consult Powerunit Manual for procedure to set Pull and Return pressures.
- *Keep hydraulic system free of dirt. Avoid letting couplers contact a dirty floor.
- *Do not use as a hammer to force fasteners into holes or otherwise abuse tool.
- *Proper care by operators is necessary in maintaining full productivity and reducing down time.

WARNING

Be sure Powerunit is disconnected before cleaning, or when replacing worn or damaged components. Severe personal injury may occur if power source is not disconnected.

GBP204/GBP204A PARTS LIST



NOTES

1. 204103 includes: 401106, 403802 & 402373 (2)
2. 204111 includes: 403810 & 401114
3. 206115 includes: 405758, 401105 & 405832
4. 206120 complete Air Trigger Assembly includes: 206125, 704130, 403902, 208126 & 208127
5. 206131 complete Actuator Assembly includes: 206127, 240122, 206137, 206136 & 585044
6. To reduce stroke to .375" order part number 206110 unloading valve & 206112 stroke limiter.

TROUBLE SHOOTING

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

1. NO OPERATION WHEN TRIGGER IS DEPRESSED

- a.) Check powerunit power source.
- b.) Control cord may be loose or damaged.
- c.) Faulty trigger. Replace.
- d.) Check hydraulic couplings; tighten, repair or replace.

2. SLOW OR PARTIAL OPERATION WHEN TRIGGER IS DEPRESSED

- a.) Low hydraulic pressure. Check powerunit, adjust.
- b.) Cylinder Piston O’ring (403810) could be worn or damaged. Replace.
- c.) Excessive wear or scoring on moving parts. Check and replace faulty parts.

3. TOOL OPERATES IN REVERSE

- a.) Tool stops in back position. Hydraulic hoses are reversed. Correct.

4. HYDRAULIC OIL OVERHEATS

- a.) Powerunit motor rotation reversed. Electrical connections reversed. See powerunit instruction manual.
- b.) Restrictions in either hydraulic lines, hoses or couplings. Check and tighten, clean or replace.

5. OIL LEAKAGE

- a.) Hydraulic oil leaks from connections. Tighten threaded connections. Do not use Teflon® tape.
- b.) Oil leaks from tool. Determine source of leak and replace worn or defective o’rings and back-up rings.

6. PINTAIL GROOVES STRIPPED DURING PULL STROKE

- a.) Nose Assembly must be pushed onto fastener fully.
- b.) Chips may have collected in chuck jaws. Disassemble nose assembly, clean jaws in mineral spirits or use a sharp pointed object to remove chips. Relube surfaces jaws ride on.
- c.) Chuck jaws may be worn or damaged. Replace.
- d.) Pintail too short for jaws to properly grip. Select proper grip length fastener.
- e.) Excessive gap between sheets. Reduce gap before attempting to install fastener.

7. NOSE ASSEMBLY WON'T ACCEPT FASTENER PINTAIL

- a.) Spent fastener stem may be jammed in pulling head. Disassemble and check for worn or broken parts in nose assembly. Replace defective parts, clean and relube jaws before reassembling.

OVERHAUL

If a tool is performing poorly or leaking badly, a complete overhaul may be necessary. Service Kit 206100 contains a complete set of o’rings, back-up rings and screws.

Perform overhaul in a clean, well lit area using care not to scratch or nick any smooth surface that comes in contact with an o’ring. Use of Lubriplate® (GBP part no. 402723) or other lubricant is recommended during reassembly to prevent tearing or distorting of o’rings.

Disconnect hydraulic hoses and electrical cord or air line from powerunit. Remove couplers (585037) from hoses and drain. Push piston (204111) back into cylinder (204103) to empty all fluid from tool. Push piston back to the front of cylinder.

Unscrew socket head cap screw (206118) from retaining ring (206117) using a spanner wrench to remove retaining ring. Push piston back until cylinder cap (206115) falls out of cylinder. Push piston (204111) out the rear of the cylinder. Remove loading valve (206109) from the piston. Using a small blunt object, remove o’rings and back-up rings from components.

Clean parts in mineral spirits or other o’ring compatible solvent being sure to clean o’ring grooves. Inspect components for scoring, excessive wear or damage.

Reassembly sequence is opposite of disassembly. Be sure relative positions of o’rings and back-up rings are as shown in exploded view and parts list. Relief valve must be installed with flats towards the rear and must enter notch in the rear of adapter. Coat hose fitting threads with a non-hardening teflon thread compound such as Slic-tite® (GBP part no. 403237).

DO NOT USE TEFLON TAPE.

GBP204 SELECTION CHART

FASTENER	DIA.	STANDARD	STRADDLE NOSE 1	LONG
NAS and GP® SHEAR/TENSION LOCKBOLTS BACB30TY BACB30UA BACB30TZ BACB30UB BACB30DY BACB30GX BACB30DX BACB30GP BACB30GO BACB30GY BACB30GW	5/32" 3/16" 1/4"	NAST05-204C-25OS NASS05-204C-25OS NAS06-204C-25OS NAS08-204C-25OS	NAST05-204C-30OS NASS05-204C-30OS NAS06-204C-30OS NAS08-204C-30OS	NAST05-204C-34OS NASS05-204C-34OS NAS06-204C-34OS NAS08-204C-34OS
MGP®	4mm 5mm	MGP4-204C-25OS MGP5-204C-25OS	MGP4-204C-30OS MGP5-204C-30OS	MGP4-204C-34OS MGP5-204C-34OS
LGP® LOCKBOLT LGPL2SC-V BACB30VM LGPL18SC-V BACB30XT LGPL4SC-V ABS0548 LGPL2SP-V BACB30VN LGPL4SP-V ASNA2392 LGPL8SC-V BACB30WD LGPL9SC-V BACB30WB LGPL9SP-V BACB30VY	5/32" 3/16" 1/4"	LGP05-204C-25OS LGP06-204C-25OS LGP08-204C-25OS	LGP05-204C-30OS LGP06-204C-30OS LGP08-204C-30OS	LGP05-204C-34OS LGP06-204C-34OS LGP08-204C-34OS
MLGP®	4mm 5mm 3/8"	MLGP4-204C-25OS MLGP5-204C-25OS MLGP6-204C-25OS	MLGP4-204C-30OS MLGP5-204C-30OS	MLGP4-204C-34OS MLGP5-204C-34OS MLGP6-204C-34OS
BLIND RIVET (SINGLE ACTION) WITH OR W/O DRIVE WASHER NAS1900 S & U SERIES	1/8" 5/32" 3/16" 1/4"	SMLS04-204D-27OS SMLS05-204D-27OS SMLS06-204D-27OS SMLS08-204D-27OS		SMLS04-204D-37OS SMLS05-204D-37OS SMLS06-204D-37OS SMLS08-204D-37OS
BLIND BOLT (SINGLE ACTION) WITH OR W/O DRIVE WASHER MS90353S & U / MS90354S & U MS21140S & U / MS21141S & U CR7000 SERIES, BACB30YY, YU, & YT	5/32" 3/16" 1/4"	SB05-204D-27OS SB06-204D-27OS SB08-204D-27OS		SB05-204D-37OS SB06-204D-37OS SB08-204D-37OS
BACR15FR/FP, BACR15GF/GK, NAS1900 S & U SERIES BLIND RIVET WITH DRIVE WASHER NAS9301-9312	1/4"	08MAX-204D-27OS		08MAX-204D-37OS
"A" CODE NAS1398A & NAS1399A	1/8" 5/32" 3/16" 1/4"	4A-204D-27OS 5A-204D-27OS 6A-204D-27OS SMLS08-204D-27OS		4A-204D-37OS 5A-204D-37OS 6A-204D-37OS SMLS08-204D-37OS
ASP® ASP 2, ASP PF, ASP 4 FF, ASP 2 F, ASP 2 LC	13/64" 17/64" 21/64"	ASP06-204D-27OS ASP08-204D-27OS ASP10-204D-27OS		ASP06-204D-37OS ASP08-204D-37OS ASP10-204D-37OS
NAS1719, NAS1720, NAS1721 & MBC®	1/8" 5/32" 3/16"	MBC04-204D-27OS MBC05-204D-27OS MBC06-204D-27OS		MBC04-204D-37OS MBC05-204D-37OS MBC06-204D-37OS
GROUND STUD, BACS53B	13/64" 17/64"	GS8-204D-32OS GS10-204D-32OS		GS8-204D-42OS GS10-204D-42OS

HUCK®, GP®, MGP®, LGP®, MLGP®, AND ASP® ARE REGISTERED TRADEMARKS OF ALCOA INC. MBC® IS A REGISTERED TRADEMARK OF CHERRY AREOSPACE.

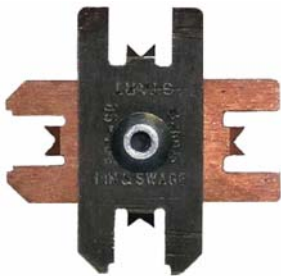
THE GBP204 TOOL IS APPROVED TO INSTALL THE ABOVE FASTENERS.

1) -30 STRADDLE NOSES ARE DESIGNED TO REACH OVER THE COLLAR.

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

10/11

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 ALSO SUPPLIES PIN & COLLAR SWAGE INSPECTION GAGES TO CERTIFY CORRECT SWAGE INSTALLATION.



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.

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