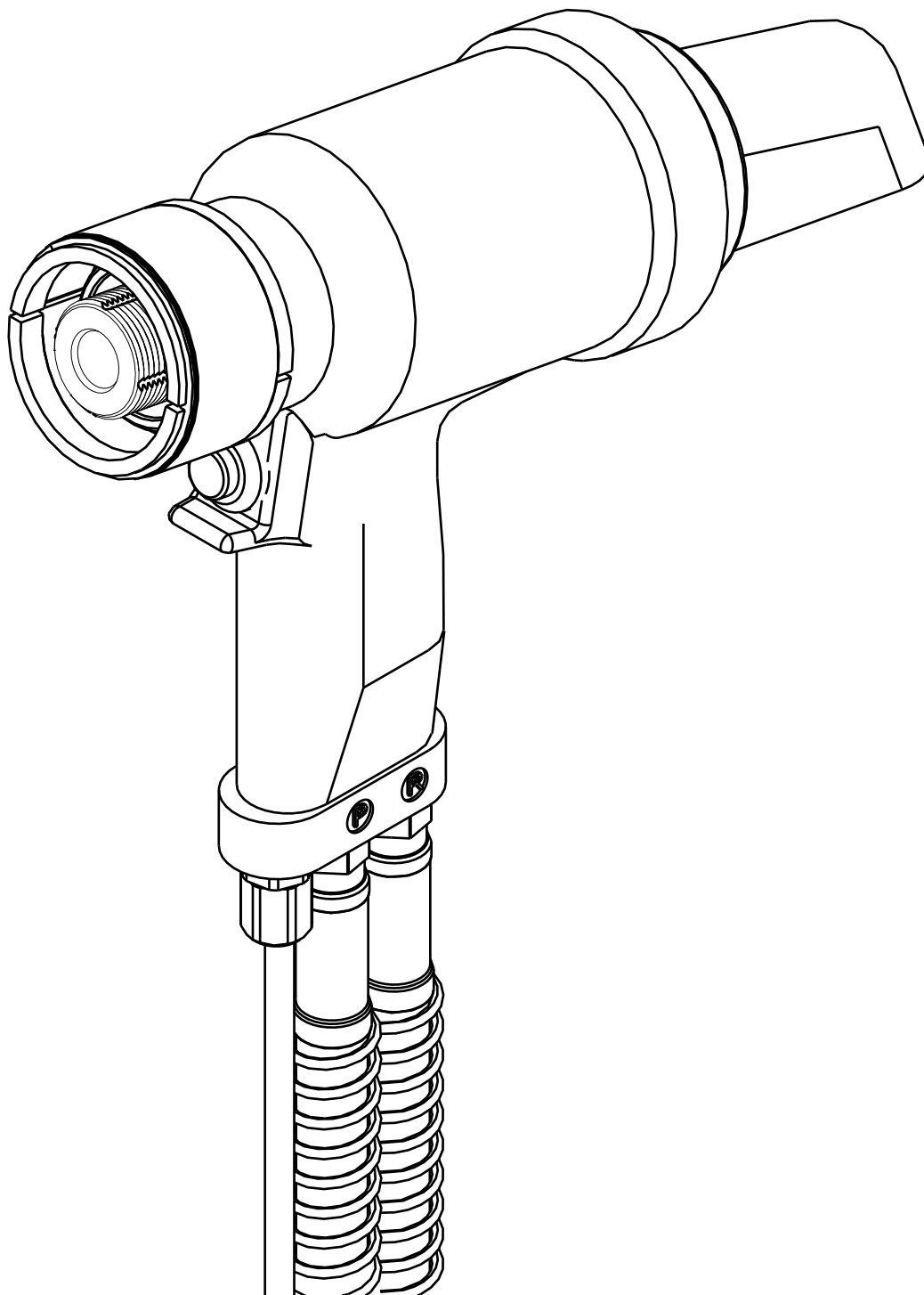


# GB2620PT

## INSTALLATION TOOL



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

# GAGE BILT

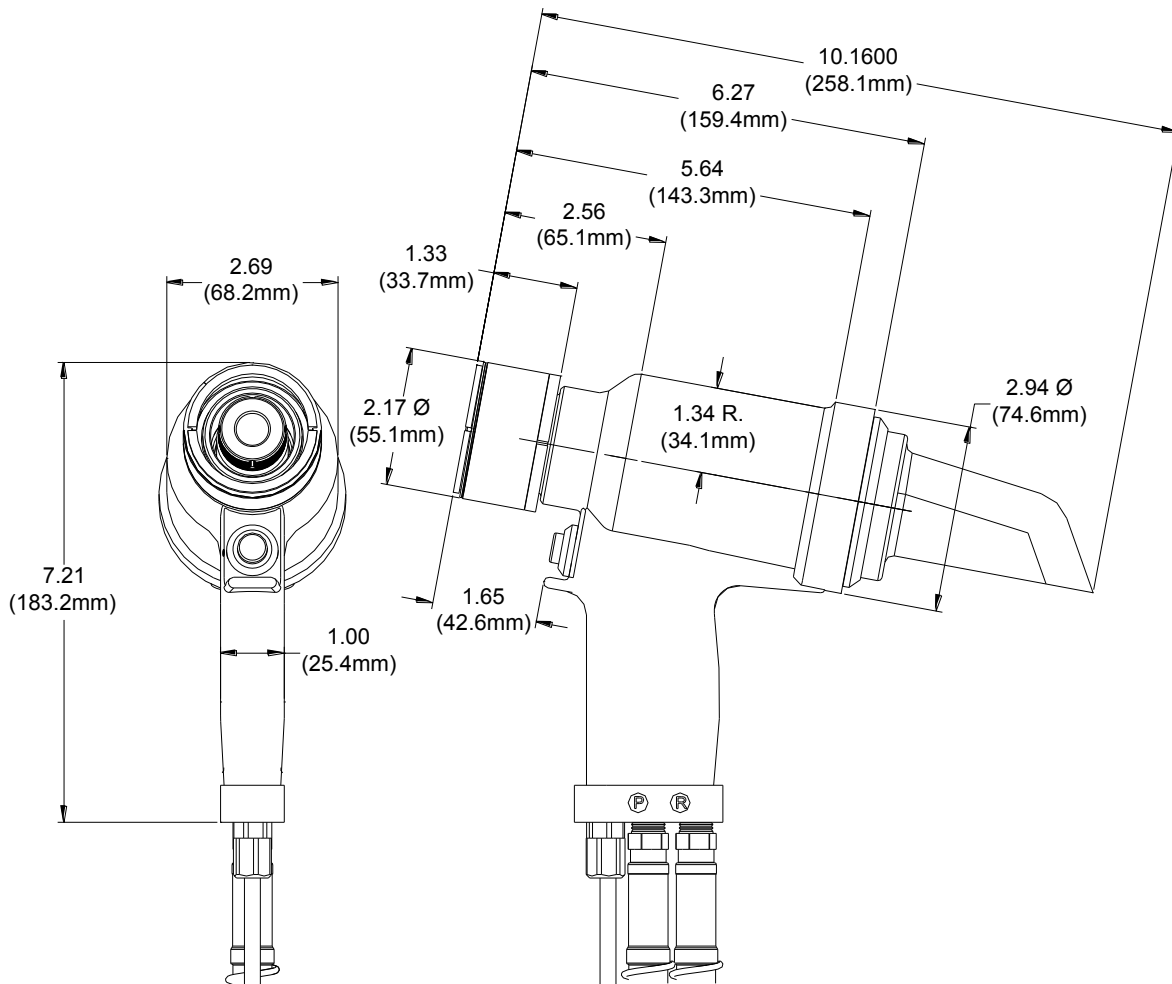
MADE IN U.S.A.

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## SPECIFICATIONS

<b>Weight</b>	- 9 lbs. 14 oz. (4.5 kg)
<b>Hyd. pressure req'd</b>	- 7,400 psi (510.2 bar) PULL 3,200 psi (220.6 bar) RETURN
<b>Hyd. Power Source</b>	- GB940 Powerunit or equivalent
<b>Hydraulic fluid</b>	- Fire resistant hydraulic fluid conforming with OSHA regulation 1926.302.
<b>Setting stroke</b>	- 1.437" (36.5mm)
<b>Rated pull load</b>	- 17,745 lbs. (78.9 kN) @ 6,500 psi (448.2 bar)
<b>Noise level</b>	- 81.5 dB (A)
<b>Vibration</b>	- Tested- No hazards found.

# 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 with collar, pin will eject forcibly when pintail breaks off. Severe personal injury may result.

### **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**

Do not operate if deflector, bottle, catcher bag or vacuum tube is removed or damaged, broken pintails may eject forcibly from rear of tool. Severe personal injury may result.

### **CAUTION**

Keep Nose Assemblies clean and free of chips and debris.

### **WARNING**

Do not use beyond the design intent.

### **WARNING**

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

### **WARNING**

Where prolonged use is foreseen, it is recommended a tool balancer be used. Check suspension device to ensure that it is secure.

### **WARNING**

Do no use tool in explosive atmosphere.

### **WARNING**

#### **Shock:**

It is recommended operator wear a suitable glove during operation where prolonged use is expected.

### **WARNING**

Always disconnect tool from power before performing any maintenance to any tool or nose assembly. Ensure that all connections are proper and there are no visible leaks from tool or hoses before connecting to power.

### **CAUTION**

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

### **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.

### **WARNING**

It is required to use hearing protection. A test was carried out in a simulated work environment where the background level was 73.2 dB (A). In this condition the max level was 81.5 dB (A). Therefore, it is required where prolonged use, hearing protection be used.

### **WARNING**

Risk of crushing exists if nose assembly is not attached.

### **WARNING**

It is recommended tool be operated 50 out of every 60 minutes, where prolonged use is expected.

### **WARNING**

Tool is not to be used as a hammer.

### **CAUTION**

Hydraulic pressure not to exceed 7,400 PSI (510.2 bar) pull 3,200 (220.6 bar) reload

## PRINCIPLE OF OPERATION

When the tool is connected to a powerunit, operation is controlled by the electric actuator (240122) in the handle ass'y (262008). When the electric actuator (240122) is depressed, a directional valve in the powerunit directs fluid to the front side of the piston ass'y (262006) forcing it and the nose assembly collet rearward. This action causes the jaws to clamp onto the fastener pintail and pull the sheets together. The anvil is forced forward, swaging the collar into locking grooves of the fastener. Further force breaks the pintail off, approximately flush with the collar.

When the electric actuator (240122) is released the directional valve reverses fluid flow to the back of the piston ass'y (262006) and pushes the nose assembly off of the swaged fastener. The pintail ejector hydraulically pushes the spent pintail out of the nose assembly.

## HOW TO USE THE GB2620PT

**WARNING:** OPERATOR **MUST** READ AND UNDERSTAND ALL WARNINGS AND CAUTIONS.

**WARNING:** IT IS REQUIRED THAT EYE PROTECTION AND HEARING PROTECTION BE WORN DURING OPERATION.

**WARNING:** DO NOT PULL RIVET IN THE AIR. PERSONAL INJURY FROM FASTENER EJECTING MAY OCCUR.

**CAUTION:** DO NOT USE BEYOND THE DESIGN INTENT.

#1. Set power supply to the recommended pressure, 7,400 psi (510.2bar) for the pull and 3,200 psi (220.6 bar) for the return.

#2. Connect hydraulic hoses and electric cord to power supply.

**WARNING:** ENSURE HYDRAULIC HOSES ARE SECURELY CONNECTED TO AVOID POSSIBLE HOSE WHIPPING.

#3. To ensure piston is in the full forward position, Cycle tool.

#4. Disconnect electric cord from power supply.

#5. Select proper Nose Assembly

#6. Screw collet assembly onto piston ass'y (262006) until top of collet flat lines up with top of tool.

#7. If Collet Lock is not in Piston ass'y (262006) groove, continue to turn 1/4 turn, or less until lock engages groove.

#8. Tighten Set Screw.

#9. Slide Anvil over assembled Collet. Install split ring, sleeve and retaining ring (furnished with tool).

(See proper data sheet for further instructions.)

#10. Re-connect electric cord into power supply.

**Note:** **GBP7624B NOSE ASSEMBLY ATTACHMENT** video located on our website, at : [www.gagebilt.com/videos.htm](http://www.gagebilt.com/videos.htm) may be viewed to review this procedure.

**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.

## DESCRIPTION

**WARNING:** THE BALANCE OF THIS TOOL IS DESIGNED FOR HORIZONTAL USE AND IS NOT SUITED FOR ANY OTHER APPLICATIONS. GAGE BILT WILL BE PLEASED TO ADVISE FOR YOUR SPECIFIC APPLICATION.

The GB2620PT is a hydraulic installation tool capable of installing 1/2" lockbolts. It weighs 9 lbs. 14 oz. (4.5 kg). It has a 1.437" (36.5mm) rivet setting stroke and a rated pull load of 17,745 lbs (78.9kN) @ 6,500 psi. (448.2 bar).

Normal operating pressure is set at 7,400 psi. (510.2 bar) PULL pressure and 3,200 psi. (220.6 bar) RETURN pressure, enabling the tool to pull all the fasteners listed on the selection chart without adjusting pressures. Powerunit may be set to the pressures only needed to pull your specific fastener using pressure setting gauge (942280). The tool comes equipped with 24" hoses and electric cord kit complete with quick disconnects.

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

## MAINTENANCE

**WARNING:** EXCESSIVE CONTACT WITH HYDRAULIC FLUID AND LUBRICANTS SHOULD BE AVOIDED.

**WARNING:** MAINTENANCE PERSONNEL **MUST** READ AND UNDERSTAND ALL WARNINGS AND CAUTIONS.

**WARNING:** DISCONNECT TOOL FROM ITS POWER SOURCE BEFORE PERFORMING MAINTENANCE.

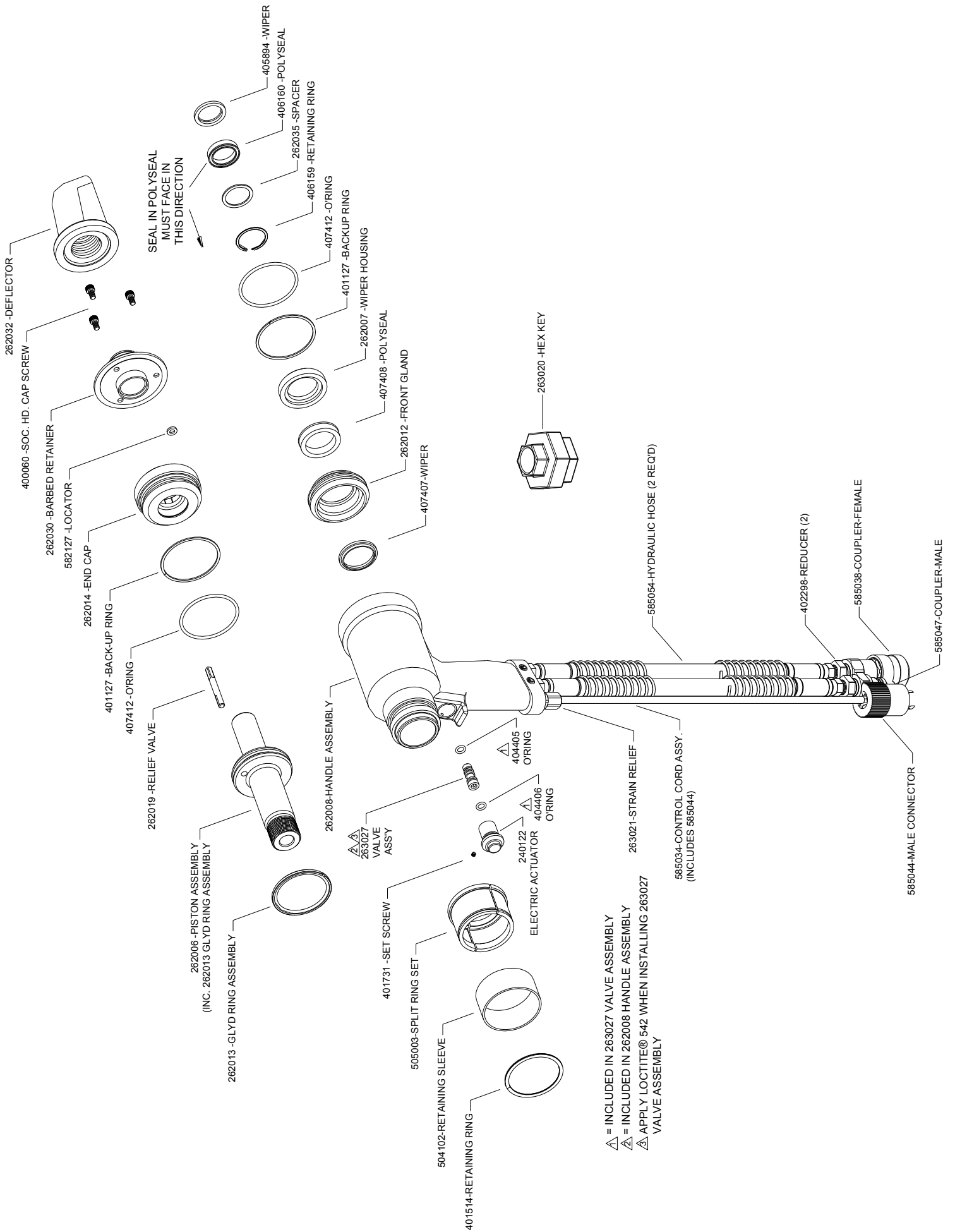
**WARNING:** BE SURE POWERUNIT IS DISCONNECTED BEFORE CLEANING OR WHEN REPLACING WORN OR DAMAGED COMPONENTS. SEVERE PERSONAL INJURY MAY OCCUR IF POWER SOURCE IS NOT DISCONNECTED.

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.

- \*Only use a hydraulic power source equipped with relief valves and pressures set within specified limits.
- \*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 downtime.
- \*Check tool, all hoses and all couplings daily for damage or air/hydraulic leaks. Tighten or replace (if necessary).

## HYDRAULIC THREAD PREPARATION

**IMPORTANT:** Be sure to use thread sealant on all hydraulic fittings, Loctite® 30534 or similar Teflon® infused pipe dope is recommended. **CAUTION:** Teflon tape is an excellent thread sealer, however, if it is not properly applied, pieces of Teflon may enter the hydraulic system and cause malfunction or damage. Use 1 1/2 wraps of tape on each thread. Cut off all loose tape ends. Tighten until fitting feels snug and then go 1/2 to a full turn past that point. **CAUTION:** Over tightening can easily distort the threads.



- △ = INCLUDED IN 263027 VALVE ASSEMBLY
- △ = INCLUDED IN 262008 HANDLE ASSEMBLY
- △ = APPLY LOCTITE® 542 WHEN INSTALLING 263027 VALVE ASSEMBLY

## TROUBLE SHOOTING

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

1. NO OPERATION WHEN ELECTRIC ACTUATOR IS DEPRESSED
  - a.) Check Powerunit power source.
  - b.) Control cord may be loose or damaged.
  - c.) Faulty ELECTRIC ACTUATOR. Replace.
  - d.) Check hydraulic couplings; repair or replace.
2. SLOW OR PARTIAL OPERATION WHEN ELECTRIC ACTUATOR IS DEPRESSED
  - a.) Low hydraulic pressure. Check powerunit, adjust.
  - b.) Glyd Ring Assy. (262013) 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 using a sharp pointed object.
  - 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 and clean before reassembling.

## OVERHAUL

**WARNING: DISCONNECT TOOL FROM ITS POWER SOURCE BEFORE PERFORMING OVERHAUL**

If a tool is performing poorly or leaking badly, a complete overhaul may be necessary. Service Kit GB2620PTKS 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® (Gage Bilt part no. 402723) or other lubricant is recommended during reassembly to prevent tearing or distorting of o'rings.

Disconnect hydraulic hoses (585054) and electrical cord (585034) from powerunit. Remove couplers (585038 & 585047) from hoses (585054) and drain. Remove retaining ring (401514), retaining sleeve (504102), split ring (505003) and nose assembly. Remove deflector (262032), screws (400060), barbed retainer (262030) and locator (582127). Using hex key (263020) remove end cap (262014). Remove relief valve (262019) and push piston ass'y (262006) out rear of tool. Remove front gland (262012), polyseal (407408), wiper housing (262007) and wiper (407407).

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 part list. Relief valve must be installed with four flats towards the rear of the cylinder. Coat hose fitting threads with a non-hardening Teflon thread compound such as Slic-tite® (Gage Bilt part no. 403237). DO NOT USE TEFLON TAPE. Apply hot glue to wire connections to ensure wires DO NOT contact each other or handle ass'y.

# GB2620PT SELECTION CHART

FASTENER	DIA.	NOSE ASSEMBLY
LOCKBOLT HIGH TENSILE PULL TYPE C50L® LD AVDELOK®	1/2"	16-2620PT-41
BOM® AVBOLT®	1/2"	BOM16-2620PT-41
HP8	1/2"	CONTACT GAGE BILT FOR YOUR REQUIREMENTS
MHP 10.9	12mm	CONTACT GAGE BILT FOR YOUR REQUIREMENTS

C50L® AND BOM® ARE REGISTERED TRADEMARKS OF ALCOA INC. AVDELOK® AND AVBOLT® ARE REGISTERED TRADEMARKS OF AVDEL UK LIMITED..

### THE GBP2620PT IS APPROVED TO INSTALL THE ABOVE FASTENERS.

NOTE: THE LAST 2 DIGITS OF THE NOSE ASSEMBLY REPRESENTS THE LENGTH THE NOSE ASSEMBLY EXTENDS FROM THE TOOL. (I.e. -41 = 4.1 inches) REV 7/13

### 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 6 months 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 6 months after the receipt of the material by the customer.

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

TEFLON® IS A REGISTERED TRADEMARK OF E.I. DUPONT DE NEMOURS & CO. LUBRIPLATE® IS A REGISTERED TRADEMARK OF FISKE BROTHERS REFINING CO. SLIC-TITE® IS A REGISTERED TRADEMARK OF LA-CO INDUSTRIES INC. LOCTITE® IS A REGISTERED TRADEMARK OF HENKEL CORPORATION.