THE AVIATION POINT · THEAVIATIONPOINT.COM · THE AVIATION POINT · THEAVIATIONPOINT.COM · THE AVIATION POINT · THEAVIATIONPOINT.COM · THE AVIATION POINT · THEAVIATIONPOINT.COM · THE AVIATION POINT · THEAVIATIONPOINT.COM · THE AVIATION POINT · THEAVIATIONPOINT.COM · THE AVIATION POINT

G704B — medium duty CherryMAX riveter, 3,100 lb pull

Cherry's medium duty pneumatic-hydraulic riveter for CherryMAX, on the CherryMAX mounting system.

Specification

Item	Value
Type	Pneumatic-hydraulic riveter, CherryMAX mounting system
Maker	Cherry Aerospace
Air pressure	90 psi (6.2 bar) min., 110 psi (7.6 bar) max.
Stroke	0.510 in (12.95 mm)
Pulling force	3,100 lb (13.79 kN) at 90 psi
Cycle time	Approximately one second

Item	Value
Weight	4.25 lb (1.93 kg)
Noise level	71 dB(A)
Vibration	Less than 2.5 m/s²
Air consumption	0.16 SCF/cycle (4.53 L/cycle) in CA-1001; 3.9 CFM at 20 cycles/min in TM-G704B
National Stock Number	5130-01-393-1584
Military part number	M85188T2

Part numbers

Part no.	Size	Item
G704B	Riveter	Riveter only
G704BCMR	Tool kit	G704B CherryMAX tool kit

Cherry's part numbers for this tool, as the catalog lists them.

Pulling heads

Pulling head	Type	Adapter	Rivet type	Diameters
H701B-456, H747-456	Straight	—	CherryMAX, CherryMAX 'AB', MBC L/C, SST	-4, -5, -6
H753A-456	Right angle	—	CherryMAX, CherryMAX 'AB', SST	-4, -5, -6
H781A-456, H782	Offset	—	CherryMAX, CherryMAX 'AB', SST	-4, -5, -6
H747-3A, -4A, -5A, -6A	Straight	—	CherryLOCK 'A'	-3, -4, -5, -6
H9015-3C, -4C, -5C, -6C	Straight	704A9	MS and nutplate rivets	-3, -4, -5, -6
H746-4MBC, -5MBC, -6MBC	Straight	—	Standard MBC	-4, -5, -6
H704-()NP	Straight	—	Rivetless nutplate	—
H704-()NPC	Straight	—	Rivetless nutplates for composite structures	—

Pulling heads are not furnished with the riveter. H747-456, H753A-456 and H782 can be re-configured to install -6 aluminum fasteners: see their tool sheets.

Riveter grip capability

Fastener type	Grip
CherryMAX	All grips
CherryMAX 'AB'	-05
CherryLOCK 'A'	-05
Standard MBC and MBC L/C	5
SST	All grips
MS and nutplate rivets	-05
MAXIBOLT, both types (U and S)	All grips
Rivetless nutplate	All grips

Largest grip in one stroke. Grip capability may be extended by double stroking. MBC grip as identified by NAS1719, NAS1720 and NAS1721.

G704BCMR tool kit

Part number	Item	Qty
G704B	Medium duty, single action riveter	1
H701B-456	Straight pulling head (-4, -5 and -6 dia.)	1
H781A-456	Offset pulling head (-4, -5 and -6 dia.)	1
H753A-456	Right angle pulling head (-4, -5 and -6 dia.)	1
269C3	CherryMAX / CherryLOCK grip selector gage	1
700A77	Hydraulic air bleeder	1
670A20	Stem catcher bag	1
P-1393	Plastic casing	1

Process manuals, reference card and tool documentation are included.

Notes

- Pulling heads are not furnished with the riveter and must be ordered separately.
- TM-G704B rounds the stroke to 1/2 in. The stroke above is the catalog figure.

SOURCES · Cherry Aerospace, Fastening Systems for Aerospace Tool Catalog CA-1001, p. 4, 6, 20 · Cherry Aerospace, Tool Manual TM-G704B, Rev. C, 06/02/16

SCAN · OPEN THIS DATA SHEET
theaviationpoint.com/parts/tools/g704b/

Reference data. The aircraft manufacturer's documentation (SRM / IPC) takes precedence.