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G784 — medium duty double action riveter, 2,600 lb pull

Cherry's medium duty double action riveter for CherryLOCK wiredraw rivets.

Specification

Item	Value
Type	Double action pneumatic-hydraulic riveter
Maker	Cherry Aerospace
Air pressure	90 psi (6.2 bar) min., 110 psi (7.6 bar) max.
Stroke	0.875 in (22.23 mm)
Pulling force	2,600 lb (11.57 kN) at 90 psi
Weight	8 lb (3.63 kg)

Item	Value
Noise level	69.7 dB(A)
Vibration	Less than 2.5 m/s²
Air consumption	0.27 SCF/cycle (7.65 L/cycle)
National Stock Number	5130-00-935-4681
Mounting system	Custom, compatible only with double action pulling heads (H681); other front or side eject pulling heads with adapters

Part numbers

Part no.	Size	Item
G784	Riveter	Riveter only
G784-CLRA	Tool kit	CherryLOCK wiredraw tool kit with H681-4C, -5C, -6C heads
G784-CLRB	Tool kit	CherryLOCK wiredraw tool kit without heads

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

Standard wiredraw CherryLOCK rivets (NAS1398 and NAS1399)

Dia.	Tool	Al, Monel univ. (CR2163, CR2263, CR2563)	Al, Monel flush (CR2162, CR2262, CR2562)	Stainless univ. (CR2643, CR2653, CR2663)	Stainless flush (CR2642, CR2652, CR2662)	Tool	Al, Monel NAS1097 flush (CR2164, CR2564)	Stainless NAS1097 flush (CR2644, CR2664)
-3	H681-3C	—	—	All grips	All grips	—	—	—
-4	H681-4C	All grips	All grips	All grips	All grips	H681-4S	All grips	All grips
-5	H681-5C	up to -08	up to -09	up to -08	up to -09	H681-5S	up to -09	up to -09
-6	H681-6C	up to -08	up to -09	up to -08	up to -09	H681-6S	up to -09	—
-8	H681-8C	up to -08	up to -09	—	—	H681-8S	up to -09	—

Bulb type CherryLOCK rivets (NAS1738 and NAS1399)

Dia.	Tool	Univ. (CR2249, CR2539, CR2839)	Flush (CR2238, CR2248, CR2538, CR2838)	Tool	156° flush (CR2540, CR2840)	Tool	Unisink (CR2235, CR2245, CR2545, CR2845)
-4	H681-4C	All grips	All grips	H681-4F	All grips	H681B166-4	All grips
-5	H681-5C	All grips	All grips	H681-5F	All grips	H681B166-5	All grips
-6	H681-6C	All grips	All grips	H681-6F	All grips	H681B166-6	All grips

Other pulling heads

Pulling head	Type	Adapter	Rivet type	Rivet dia.	Max. grip
H9055-3, -4, -5, -6	Straight	680B46	CherryLOCK 'A'	-3, -4, -5, -6	-3: All. -4, -5, -6: 8, 9*
H9015-3C, -4C, -5C, -6C	Straight	680B46	MS	-3, -4, -5, -6	All
H9040-4C, -5C, -6C	Straight	680B57	MS	-4, -5, -6	All
H680B200A	Straight	—	CherryMAX	-4, -5, -6	All
H781A-456	Offset	680B205	CherryMAX	-4, -5, -6	All
H753A-456	Right angle	680B205	CherryMAX	-4, -5, -6	All

* 8 grip for protruding head, 9 grip for countersunk head.

Notes

- Pulling heads are not furnished with the riveter and must be ordered separately.

SOURCES · Cherry Aerospace, Fastening Systems for Aerospace Tool Catalog CA-1001, p. 13, 21 · Cherry Aerospace, Tool Manual TM-G784, Rev. E, 08-Aug-19

SCAN · OPEN THIS DATA SHEET
theaviationpoint.com/parts/tools/g784/

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