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G85D-S — split lockbolt riveter, 7,000 lb pull

The split version of the G87D: the heavy power unit stays on the floor and the head goes into the structure.

Specification

Item	Value
Type	Split pneumatic-hydraulic riveter
Maker	Cherry Aerospace
Air pressure	90 psi (6.2 bar) min., 110 psi (7.6 bar) max. at tool
Stroke	0.720 in (18.29 mm)
Pulling force	7,000 lb (31.14 kN) at 90 psi

Item	Value
Weight	Total 19.3 lb (8.75 kg); head only 4.3 lb (1.95 kg)
Noise level	76.7 dB(A)
Vibration	Less than 2.5 m/s²
Air consumption	0.27 SCF/cycle (7.65 L/cycle)
Mounting system	Large bayonet, common to the G87D (compatible with the Huck 353 model)

Part numbers

Part no.	Size	Item
G85D-S	Riveter	Split riveter

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

Lockbolt pulling head selection chart

Dia.	Length from tool face	Straight, short pintail	Straight, swivel	Straight, swivel self-releasing	Chisel, swivel self-releasing	Offset
-4	2"	H513-04-20*	—	—	—	H563-4B*
-4	3-1/2"	H513-04-35*	—	—	—	H563SP-4B*
-5	2"	—	H513S-05-20*	H513SR-05-20*	H513SRC-05-20*	H563-5B*
-5	3-1/2"	H513-05-35*	H513S-05-35	H513SR-05-35	H513SRC-05-35*	H563SP-5B
-6	2"	H513-06-20*	H513S-06-20*	H513SR-06-20*	H513SRC-06-20*	H563-6B*
-6	2-3/8"	—	H513S-06-24	H513SR-06-24	—	H562-6B
-6	3-1/2"	—	H513S-06-35*	H513SR-06-35*	H513SRC-06-35*	H563SP-6B*
-6	4-13/16"	—	H513S-06-48	H513SR-06-48	—	—
-6	6"	H513-06-60*	—	—	—	—
-8	2-3/8"	—	H513S-08-24	H513SR-08-24	—	H562-8B
-8	3-1/2"	H513-08-35*	H513-08-35*	—	—	—
-8	4-13/16"	—	H513S-08-48	H513SR-08-48	H513SRC-08-48	—
-10	2-11/16"	—	H513S-10-27	H513SR-10-27	—	—
-10	4-3/16"	—	H513S-10-42	H513SR-10-42	—	—
-12	2-11/16"	—	H513S-12-27	H513SR-12-27	—	—
-12	4-3/16"	—	H513S-12-42	H513SR-12-42	—	—

* These parts require the 552 adapter on the G87D, G85D or Huck 353, and fit directly on the G83A or Huck 352. Parts with no asterisk fit directly on the G87D, G85D and Huck 353. After H513: S = swivel, R = self releasing, C = chisel nose. H513-05-35: -05 is the -5 diameter, -35 means the head extends 3.5 in beyond the gun line. After H563: SP = short pintail.

Notes

- Pulling heads are not furnished with the riveter and must be ordered separately.
- The power unit may be placed on the floor, away from the structure, for access in constricted areas.

SOURCES · Cherry Aerospace, Fastening Systems for Aerospace Tool Catalog CA-1001, p. 11 · Cherry Aerospace, Tool Manual TM-G85D-S, Rev. G, 4/30/15

SCAN · OPEN THIS DATA SHEET
theaviationpoint.com/parts/tools/g85d-s/

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