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H642 — offset pulling head for CherryLOCK rivet 1/8" universal head

H642 Pulling Heads (offset) for CherryLOCK rivets, 15 Series and 40 Series.

Specification

Item	Value
Type	Offset pulling head
Maker	Cherry Aerospace
Tool sheet	TS-H642, 02/05/07

Part numbers

1/8 in (-4) 4 part numbers

Part no.
H642-4U15
H642-4C15
H642-4U40
H642-4C40

5/32 in (-5) 4 part numbers

Part no.
H642-5U15
H642-5C15
H642-5U40
H642-5C40

3/16 in (-6) 4 part numbers

Part no.
H642-6U15
H642-6C15
H642-6U40
H642-6C40

1/4 in (-8) 2 part numbers

Part no.
H642-8U40
H642-8C40

What it installs as supplied

Fastener	Diameter	Note
CherryLOCK rivet 1/8" universal head	1/8	pulling head H642-4U15 / H642-4U40
CherryLOCK rivet 1/8" countersunk head	1/8	pulling head H642-4C15 / H642-4C40
CherryLOCK rivet 5/32" universal head	5/32	pulling head H642-5U15 / H642-5U40
CherryLOCK rivet 5/32" countersunk head	5/32	pulling head H642-5C15 / H642-5C40
CherryLOCK rivet 3/16" universal head	3/16	pulling head H642-6U15 / H642-6U40
CherryLOCK rivet 3/16" countersunk head	3/16	pulling head H642-6C15 / H642-6C40
CherryLOCK rivet 1/4" universal head	1/4	pulling head H642-8U40 (40 series only)
CherryLOCK rivet 1/4" countersunk head	1/4	pulling head H642-8C40 (40 series only)

Riveters

Riveter	Adapter	Note
G-11	—	15 series heads fit directly
G-15	—	15 series heads fit directly
G-36	—	15 series heads fit directly
G-684 / G-784 Hydro-shift	680B46 (15 series; adapter parts 30-33)	special adjusting instructions
G-40	—	40 series heads fit directly
G-55	—	40 series
G-86	—	40 series

Parts list

Item	Part number	Description	Qty
1	—	Cover	1
2	P-56	Cap Screw, 10-32 X 1 1/2	1
3	P-402	Set Screw, 10-32 X 7/8"	1
4	—	Shift Slide	1
5	—	Drawbolt	1
6	642A33-5	Stop Block (1/8 and 5/32 in heads)	1
6	642A33-8	Stop Block (3/16 and 1/4 in heads)	1
7	P-90	Cap Screw, 10-32 X 3/8"	1
8	642A23	Stem Stop	1
9	642B13-4	Jaws (pair), includes P-383 (1/8 in heads)	1
9	642B13-5	Jaws (pair), includes P-383 (5/32 in heads)	1
9	642B13-6	Jaws (pair), includes P-383 (3/16 in heads)	1
9	642B13-8	Jaws (pair), includes P-383 (1/4 in heads)	1
14	620A44	Seat (3/16 and 1/4 in heads)	2
15	642A14-4	Spacer (1/8 in heads)	1
15	642A14-5	Spacer (5/32 in heads)	1
15	642A14-6	Spacer (3/16 in heads)	1
15	642A14-8	Spacer (1/4 in heads)	1
16	642A16	Jaw Spring	1
17	642A18	Washer	1
18	P-405	Retaining Ring, Truarc 5000-51	1
19	642B58-4	Rivet Seat (1/8 in heads)	1
19	642B58-5	Rivet Seat (5/32 in heads)	1
19	642B58-6	Rivet Seat (3/16 in heads)	1
19	642B58-8	Rivet Seat (1/4 in heads)	1
20	P-924	Set Screw, 6-32 x 5/16	1
21	642B53	Rocker Arm	1
22	642A60-4	Anvil (1/8 in heads)	1
23	P-404	Retaining Ring	2
24	642A32	Trunion Pin	1
25	642A41	Guard	1
26	P-714	Button Head Screw, 6-32	5
27	P-42	Shakeproof Washer, #6	5
28	642B55-4	Sleeve Assembly (1/8 in heads)	1
28	642B55-5	Sleeve Assembly (5/32 in heads)	1
28	642B55-6	Sleeve Assembly (3/16 in heads)	1
28	642B55-8	Sleeve Assembly (1/4 in heads)	1
29	—	Jam Nut (1/8 and 5/32 in heads)	1
29	642A64	Jam Nut (3/16 and 1/4 in heads)	1
30	642A63-1	Drawbolt Adapter (15 Series adapter)	1

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

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Item	Part number	Description	Qty
10	P-383	O-Ring	1
11	642A15	Stem Ejector	1
12	P-518	Ejector Spring	1
13	642A17	Follower	1
14	620A44	Seat (1/8 and 5/32 in heads)	1

Item	Part number	Description	Qty
22	642A60-5	Anvil (5/32 in heads)	1
22	642A60-6	Anvil (3/16 in heads)	1
22	642A60-8	Anvil (1/4 in heads)	1

Item	Part number	Description	Qty
31	560A20	Spring (15 Series adapter)	1
32	642A63-2	Sleeve Adapter (15 Series adapter)	1
33	G6JN	Jam Nut (15 Series adapter)	1
34	642A62-1	Drawbolt Adapter (40 Series adapter)	1
35	642A62-2	Sleeve Adapter (40 Series adapter)	1

Cherry's sheet misprints several numbers on this list, differently from one head to the next. Where a clean number is printed it is given here; items 1, 4 and 5 and the 1/8 and 5/32 in jam nut have none, so they are left blank: ask Cherry before ordering.

Notes

- Offset pulling heads for installing CHERRYLOCK rivets up to 1/2" grip length in limited access areas.
- Separate pulling head needed for each rivet head style and each shank diameter (universal or countersunk). Not to be used on Bulbed CherryLOCK rivets larger than 5/32" diameter.
- 15 series (suffix 15) heads: fit G-11, G-15 and G-36 directly; G-684/G-784 Hydro-shift with 680B46 adapter (and special adjusting instructions).
- 40 series heads (suffix 40) fit directly on Cherry Riveters G-40, G-55 and G-86; 1/4" (-8U40/-8C40) only in 40 series.
- Cherry marks this sheet as currently under change: ask Cherry for its status.
- Heads 15 and 40 installed on riveter: 15 series secured with jam nut, 40 series with set screw.
- Keep head clean around the riveting end (adhesives, chips, sealants clog jaw serrations); rivet seat and lock ring anvil must be kept clean. Apply high pressure grease (Lubriplate 130A/130AA) to top/bottom of drawbolt (5) and bottom of rocker arm (21). Factory-adjusted for A-Group (shorter lengths); adjust with colour-coded gages 628-4 (1/8 green), 628-5 (5/32 red), 628-6 (3/16 blue), 628-8 (1/4 plain).

SOURCES · Cherry Aerospace, Tool Sheet TS-H642, 02/05/07

SCAN · OPEN THIS DATA SHEET
theaviationpoint.com/parts/tools/h642/

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