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H681 — straight pulling head for CherryLOCK 2000 Series

Pulling Head for the 2000 Series CherryLOCK Rivets (Double Action).

Specification

Item	Value
Type	Straight pulling head
Maker	Cherry Aerospace
Tool sheet	TS-H681, Rev. C, 5/14/15

Part numbers

3/32 in (-3) 1 part number

Part no.
H681-3C

1/8 in (-4) 4 part numbers

Part no.
H681-4C
H681-4S
H681-4F
H681B166-4

5/32 in (-5) 4 part numbers

Part no.
H681-5C
H681-5S
H681-5F
H681B166-5

3/16 in (-6) 4 part numbers

Part no.
H681-6C
H681-6S
H681-6F
H681B166-6

1/4 in (-8) 2 part numbers

Part no.
H681-8C
H681-8S

What it installs as supplied

Fastener	Diameter	Note
CherryLOCK 2000 Series (double action) rivets, countersunk (C) heads also install universal and countersunk head rivets	3/32", 1/8", 5/32", 3/16", 1/4"	separate pulling head required for each diameter

Riveters

Riveter	Adapter	Note
G700	—	Cherry Double Action Riveters (Ex: G700, G784, G689); heads fit directly
G784	—	
G689	—	

Pulling head numbers and dimensions

Rivet	Dia.	Pulling head	Dimensions
CherryLOCK 3/32"	3/32	H681-3C Countersunk Head (MS 20426)	A 0.163, B 0.332
CherryLOCK 1/8"	1/8	H681-4C Countersunk Head (MS 20426)	A 0.208, B 0.341
CherryLOCK 1/8"	1/8	H681-4F Countersunk Head (156 deg)	A 0.43, B 0.358
CherryLOCK 1/8"	1/8	H681-4S Countersunk Head (NAS 1097)	A 0.174, B 0.341
CherryLOCK 1/8"	1/8	H681B166-4 Uni-Sink Head	A 0.25, B 0.359
CherryLOCK 5/32"	5/32	H681-5C Countersunk Head (MS 20426)	A 0.269, B 0.352
CherryLOCK 5/32"	5/32	H681-5F Countersunk Head (156 deg)	A 0.535, B 0.338
CherryLOCK 5/32"	5/32	H681-5S Countersunk Head (NAS 1097)	A 0.225, B 0.352
CherryLOCK 5/32"	5/32	H681B166-5 Uni-Sink Head	A 0.313, B 0.377
CherryLOCK 3/16"	3/16	H681-6C Countersunk Head (MS 20426)	A 0.335, B 0.386
CherryLOCK 3/16"	3/16	H681-6F Countersunk Head (156 deg)	A 0.625, B 0.367
CherryLOCK 3/16"	3/16	H681-6S Countersunk Head (NAS 1097)	A 0.281, B 0.386
CherryLOCK 3/16"	3/16	H681B166-6 Uni-Sink Head	A 0.375, B 0.419
CherryLOCK 1/4"	1/4	H681-8C Countersunk Head (MS20426)	A 0.458, B 0.398
CherryLOCK 1/4"	1/4	H681-8S Countersunk Head (NAS 1097)	A 0.374, B 0.398

Parts list

Item	Part number	Description	Qty
1	-3: 681C6-3C; -4: 681C6-4C; -5: 681C6-5C; -6: 681C6-6C; -8: 681C6-8C	Outer Sleeve, C'sunk Head (MS20426)	1
1	-4: 681C6-4F; -5: 681C6-5F; -6: 681C6-6F	Outer Sleeve, C'sunk Head (158 deg)	1
1	-4: 681C6-4S; -5: 681C6-5S; -6: 681C6-6S; -8: 681C6-8S	Outer Sleeve, C'sunk Head (NAS 1097)	1
1	-4: 681C86-4; -5: 681C86-5; -6: 681C86-6	Outer Sleeve, Uni-Sink Head	1
2	680A25 (all)	Retainer	1
3	-3: 681B5-3; -4: 681B5-4; -5: 681B5-5; -6: 681B5-6; -8: 681B5-8	Anvil	1
4	681A4 (all)	Tube	1
5	680A152 (all)	Collet Assembly	1
6	680A152-3 (all)	Collet Lock (included in the Collet Assy.)	1
7	-3: 615A48; -4: 615A41; -5: 615A37; -6: 615A37; -8: 615A37	Stem Stop	1
8	-3: 615B40-3; -4: 615B40-4; -5: 615B40-5; -6: 615B40-6; -8: 615B40-8	Jaw (pair)	1
9	-3: 680A30-1; -4: 680A30-1; -5: 680A30-2; -6: 680A30-2; -8: 680A30-2	Pusher	1
10	P-575 (all)	Pin	1
11	-3: 680A16-3; -4: 680A16-1; -5: 680A16-2; -6: 680A16-2; -8: 680A16-2	Ejector Pin	1
12	-3: P555; -4: P555; -5: 680A56; -6: 680A56; -8: 680A56	Spring	1
13	680A29 (all)	Stop	1
14	680A26 (all)	Spring	1

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

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Notes

- Parts 8-14 (marked *) can be ordered separately or as Pusher Assembly P/N: 680A13-3 (-3), 680A13-4 (-4), 680A13-5 (-5), 680A13-6 (-6), 680A13-8 (-8).
- NSN standard straight pulling heads: H681B166-4 5130-01-089-8039; H681B166-5 5130-01-089-2721; H681-3C 5130-01-154-6997; H681-4C 5130-00-083-6625; H681-5C 5130-00-083-6627; H681-6C 5130-01-021-7451; H681-8C 5130-00-083-6634.
- Keep pulling head clean especially riveting end (adhesives, chips, sealants cause slipping). Stem stop (7) must be reassembled with arrow pointing forward. To replace ejector pin (11) or spring (12) remove pin (10) and stop (13). Anvil (3) flushness critical: if anvil protrudes .004" or more out of outer sleeve (1), sleeve is worn/damaged and must be replaced.

SOURCES · Cherry Aerospace, Tool Sheet TS-H681, Rev. C, 5/14/15

SCAN · OPEN THIS DATA SHEET
theaviationpoint.com/parts/tools/h681/

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