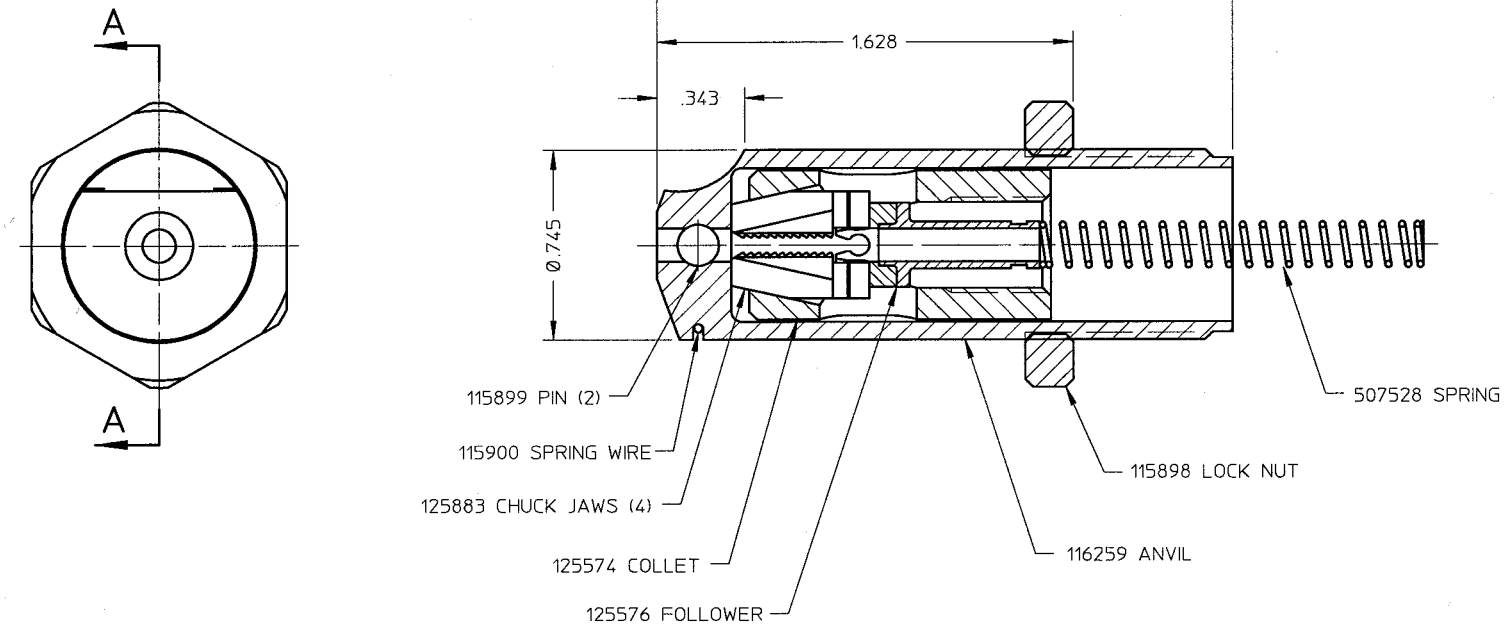
Huck Fasteners
From Cordant Technologies

NOSE ASSEMBLY DATA SHEET



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99-3442

NOSE ASSEMBLY

Huck International, Inc.
Installation System Division
1 Corporate Drive - Kingston, NY 12401

TYPE: Non-Self-releasing
FOR: HUCK-CLINCH -04, -05, -06
TOOL: 2012, 2013, HK150, 227, G704B

OTHER Replaces 99-1479
Will install HuckMAX, M7885 & -06 MGL

ISSUED: 10/12/199
REVISED: 9-99

Nose Assembly Maintenance

1. **HK150 Tool**:
Prepare tool per manual, and then, unscrew nose tube from tool counterclockwise. Unscrew jaw holder from tool's puller shaft - - counterclockwise. Screw adapter shaft, 202971, onto tool's puller shaft until bottomed tighten handtight. Screw adapter nose tube, 202202, onto tool tighten - - handtight.
227 Tool:
Prepare tool per applicable manual.

WARNING - - as applicable:
Before maintenance or adjustments, tool must be disconnected from air supply. If not disconnected, severe personal injury may result.

2. **Tools using air source:**
Air supply should have filter regulator lubricator unit with regulator set at 90 psi (620 kPa) see Caution: Cycle tool a few times and disconnect with spindle/rod ***completely forward.***

Caution: In severe conditions, VIBRATITE can be used on collet and/or extension threads to prevent loosening or damage. Carefully follow container's directions.

3. **Disassembly/assembly *as applicable* :**
Remove parts of nose assembly for inspection and maintenance.

Collet/extension:
Assemble parts as shown. Keep collet tipped down (to keep jaws in phase/step) and screw assembled collet onto extension/tool using 9/16 collet wrench, adjustable wrench and/or 1/4 hex key as follows:
HK150:
Just snugup - - do not overtighten.
227:
Use wrench flats to tighten firmly.

Caution: Jaws must be in phase/step look into front of collet jaw damage may result if front of jaws are not in even alignment.

Anvil:
Thread correct driving anvil into anvil holder - - thread lock nut onto anvil as far forward as possible. When changing anvil insert to another size, nose assembly must be readjusted - - see step 4. Before threading holder into housing of tool, see Caution above thread holder into housing of tool.

4. **To check and adjust nose assembly**:
See **Caution** in step 3. When broken pintail of fastener is inserted into driving anvil and it can be felt sliding across the jaws - - but still easily removal nose assembly is adjusted correctly. Adustment is made by turning anvil in or out of the housing until above condition is met.

Note: Adjust nose assembly for each size fastener - - use correct size broken pintail.

To maintain adjustment, tighten lock nut against housing as follows:
HK150:
Just snugup do not overtighten.
227:
Use wrench flats to tighten firmly.

5. **As applicable:** See **WARNING - -** connect air tool to air supply. Install enough fasteners in test plate of correct thickness with proper size holes to verify functioning of nose assembly.

Notes
1. ***To extend jaw life*** : Disassemble nose assembly periodically; use a pick to clean jaw grooves.
Caution : Wash parts in **mineral spirits or isopropyl alcoho**l only. Dry O-rings and urethane jaw assemblies **immediately** after cleaning as prolonged contact with solvent causes swelling - - dry other parts.

2. *Spare parts - - as required :* Jaws, ratchet pins; driving anvils and springs.

3. *Tool/service items - - as required :* NYLON bristle brushes 105805 (04, 05 & 06), 105806 (08); 1/4 hex key, 502445; adjustable wrench, 503044; 9/16 collet wrench, 502914; VIBRATITE, 505125.