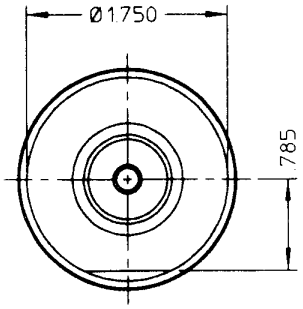
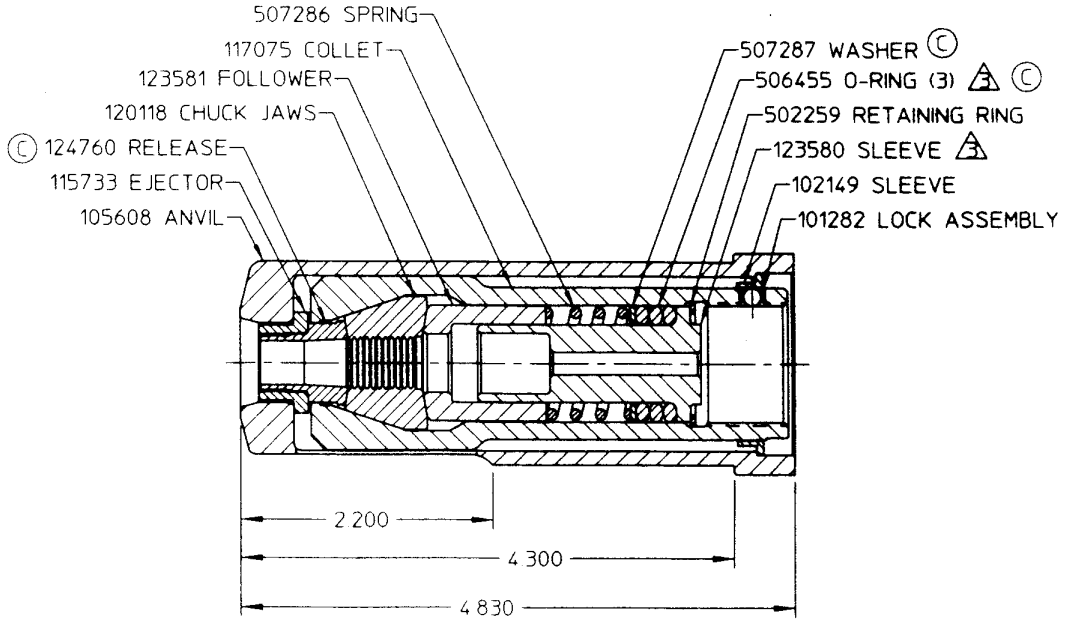
Huck Fasteners
From Cordant Technologies

NOSE ASSEMBLY DATA SHEET





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1 COLLET AND LOCK ASSEMBLY 124228 CONSISTS OF COLLET 117075, NOT AVAILABLE SEPARATELY. LOCK ASSEMBLY 101282. RELEASE 124760 AND EJECTOR 115733.

2 RELEASE AND EJECTOR KIT 124227 COSISTS OF RELEASE 124760 AND EJECTOR 115733

3 ASSEMBLE SLEEVE AND O-RINGS PER HUCK SPEC. 42-491

4 SHIP WITH CAUTION TAG 590152

© 5 RELEASE AND EJECTOR ASSEMBLY TOOL 124751 OPTIONALLY AVAILABLE

99-5100

NOSE ASSEMBLY

OTHER

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

TYPE: Self-releasing
FOR: BOM Blind Fastener -16
TOOL: 504

ISSUED: 12-89
REVISED: 9-97 C

Nose Assembly Maintenance

1. Prepare tool per manual.
WARNING: Before maintenance or adjustments, POWERIG Hydraulic Unit must be disconnected from electrical or air supply. If not disconnected, severe personal injury and/or damage may result. Disconnect POWERIG Hydraulic Unit's power source. Connect tool's hoses and controls to unit. Reconnect power source. Depress trigger for 30 seconds -- piston stops completely forward. Disconnect controls and **RETURN** hose - - **tool piston must remain completely forward.**

2. **Disassembly/assembly as applies:**
Remove parts of nose assembly for inspection and maintenance.
Anvil: Remove retaining ring and split ring/sleeve from anvil/tool. Where used, pressed-in anvil is pressed out with drift and arbor press -- press new anvil in squarely to prevent cracking.
Collet: To remove defective release/ejector assembly, cut at a point between flange of ejector and end of collet put LOCTITE on new release/ejector threads. Check to be sure brass locking ball (and set screw where used) is not missing or worn press new lock assembly squarely into collet. Spread thin film of SUPER O-LUBE on O-rings and O D of sleeve. Push HUCKBOLT pin into collet. With jaws engaged evenly on pin, turn collet over and slide other parts in -- turn collet up and press up on release -- pin will drop out. Check to see that retaining ring inside collet is below thread. Push with thumb on ring to insure movement up and down. **If not**, reassemble collet.
CAUTION: On collet adjustment - - be sure tool piston stays completely forward.
Slowly screw collet onto piston watch small flat section until top of flat just disappears under edge of the tool's adapter. Put thumb pressure on brass ball and turn collet slowly until ball drops in groove - - **do not turn collet anymore.** If jaws will not release broken pintail, readjust top of flat to adapter's edge.

CAUTION: Check position of collet flat at regular intervals to prevent nose assembly and/or tool damage.

Additional precautions: On nose assemblies manufactured after 9-1-90 (for 1/2, 5/8 and 3/4 fasteners): The special lockscrew -- see spare parts -- opposite the ball lock is tightened into groove after ball lock is seated in a groove. Lockscrews are coated with VIBRATITE to prevent loosening. For best results reapply VIBRATITE whenever collet is adjusted on, or installed onto, tool-carefully follow directions on container.
If there's a collet lock sleeve, slide it down over brass ball and, if applicable, over the lockscrew. Slide anvil over collet - - **do not turn.** Place hand on top of anvil and push up and down should be a springy movement.
Attaching anvil: Place split rings over anvil and adapter of tool push anvil into tool to assist in seating split rings. Slide sleeve or retainer over split rings and, depending on nose design, install retaining ring on either anvil or split rings

3. **Checking nose assembly:** See **WARNING - -** connect controls and **RETURN** hose. Reconnect hydraulic unit to power source. Install fasteners in test plate of correct thickness with proper size holes check pintail ejection and installed fasteners.

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

2. Spare parts as applicable: Collet locks; collet lock pins; jaws; O-rings; springs; retaining rings; driving anvils; release and ejector kits; lockscrews, 121343 (1/2 collet); lockscrews, 121342 (5/8 and 3/4 collet).

3. Tool/service items as applicable:
Adjustable wrench, 503044; TRUARC pliers (0100), 502857; TRUARC pliers (0600) 502867;
LOCTITE (609), 503657 (for release/ejector);
VIBRA-TITE, 505125 (if applicable, for collet set screw and collet extension); Parker SUPER O-LUBE, 505476 (for Orings); hex keys 5/16-502446, 3/8-502651; 1/2-505898; 5/8-504249; 3/4-506175
hex keys for set screws 5/64-502444 (for 121343); 3/32-502293 (for 121342).

N/A's for 500 series tools