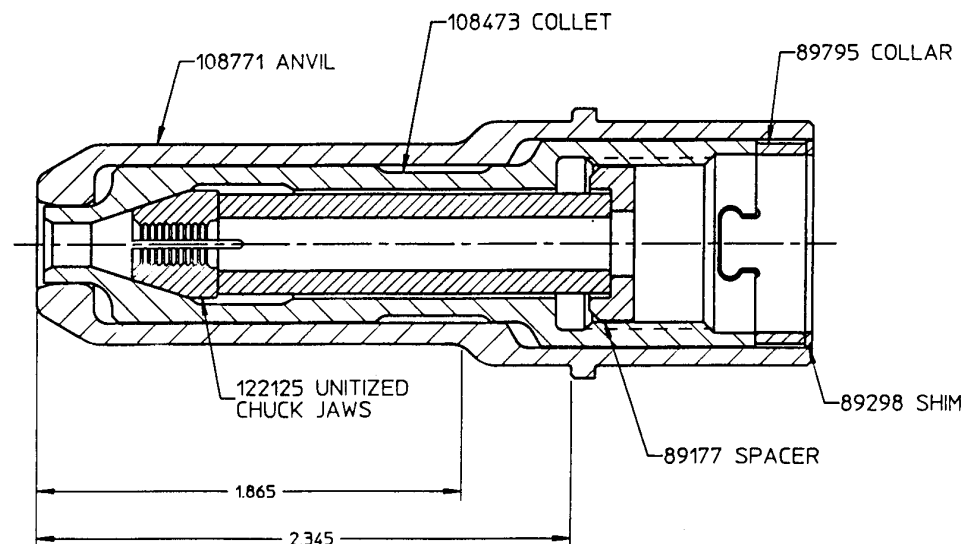
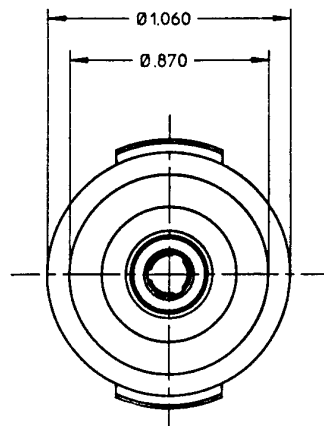


**Huck
Fasteners**

From Cordant Technologies

NOSE ASSEMBLY DATA SHEET



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99-830-1	NOSE ASSEMBLY	Huck International, Inc. Installation System Division 1 Corporate Drive - Kingston, NY 12401	
		TYPE: Non Self-releasing FOR: BOM -08 Blind Fastener TOOL: 353**	
	OTHER	ISSUED:	10-89
		REVISED:	10-91

**225BE 226
 245 246
 2500 247
 2502 4801
 2503 4802
 4803

NOTES:

1 SHIP WITH P/N 114431 PINTAIL TUBE.

Nose Assembly Maintenance

1. Prepare tool per manual. Remove any loose shims from spindle/rod with small pick.

WARNING: Before maintenance or adjustments, **POWERIGO Hydraulic Unit must be disconnected from electrical or air supply; air operated tools must be disconnected from air supply. It not disconnected, severe personal injury and/or damage may result.**

Caution: Damage to 353 tool will result if tool is cycled without a Nose Assembly or the Stop Nut on tool (Stop Nut, P/N 84213, is shipped with each 353).

2. Tools that use hydraulic source:

Connect tools hoses and controls to unit. Reconnect power source. Depress trigger for 30 seconds. Disconnect controls and and **RETURN** hose. **Tool piston must be completely forward.** See **Caution** above.

Tools that use air source: Air supply should have filter - regulator - lubricator unit with regulator set at 90 psi (620 kPa). Disconnect air supply -- see **WARNING** and Caution above -- on 353 tool, install stop nut or nose assembly. Cycle tool a few times and disconnect from air supply with spindle/rod completely **forward**.

3. Disassembly/assembly as applicable:

Remove parts of N/assem. for inspection and maintenance. If applicable, pressed-in anvil is pressed out with drift and arbor press; press new anvil in squarely to prevent cracking. **When using extension, stake to tool's spindle/rod before assembling collet -see Fig. 1; use only one shim.** Use wrench to snug-up extension on spindle. Assemble parts as shown -- apply thin coat SUPER O-LUBE to O-rings and O D of sleeve and VIBRATITE to extension W/O lock collar. Use collet wrench to snug-up collet. **4801:** Tool has holes in adapter-- rod through adapter and spindle/rod prevents piston from turning.

4. Tools with retaining nut and stop:

Slide anvil/holder over collet. Slide stop and retaining nut over holder/anvil -- tighten handtight.

353 Tool: Slide holder/anvil over collet until ear depresses half-moon retainer. Turn holder/anvil until locked by retainer -- remove shim if ears do not enter groove. On rotatable nose assemblies, hold key, 110237, in anvil slot -- as anvil is turned, retainer ears will enter groove .

5. **As applicable:** See **WARNING** -- connect controls and **RETURN** hose on hydraulic tool. Reconnect hydraulic unit or air tool/unit to power source. Install fasteners in test plate of correct thickness with proper size holes -inspect installed fasteners.

6. **Caution: To prevent damage -- after proper adjustment has been made, collet lock collar must be staked.** As applicable, see Fig. 1 and/or Fig. 2. For nose assemblies with sleeve and O-rings, jaw tension on fastener pintail is changed by adding or removing O-ring(s). Use collet wrench to snug-up. Loose lock collars or too many shims (see step 4, 353) may cause holder/anvil damage -- too few shims may cause jaw damage. Reuse lock collars until ineffective.

Notes

1. To extend Jaw life: Disassemble N/A periodically; dean and inspect components -- use a pick to dean Jaw grooves. **Caution:** Wash parts in **mineral spirits or isopropyl alcohol 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, lock collars, press-in anvils, springs, O-rings and shims.

3. Tools/service items -- as required: Brushes
NYLON bristle - 105805 (04, OS & 06), 105806 (08);
collet wrenches - 502914 (9/16), 502920 (13/16);
drifts - 83097 (.434 wide), 79524 (.6S4 wide); staking tool, 84122; adjustable wrench, 503044; Parkers SUPER O-LUBE (for O-rings if used); VIBRATITE, 505125 (on extension W/O lock collar).

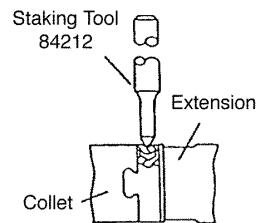


Figure 2

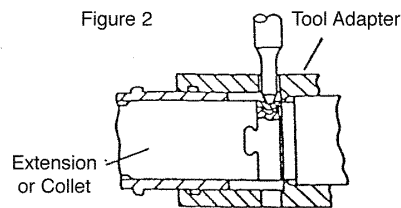


Figure 1

CAUTION: Cycling tool to retract spindle/piston rod when attaching anvil will cause damage to tool and/or nose assembly.

353/225BE/245/246/247/2500/4801
W/lock collar; W/ears