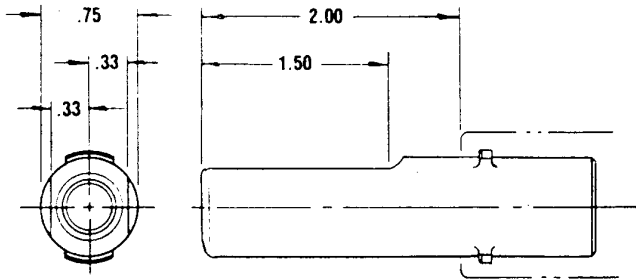




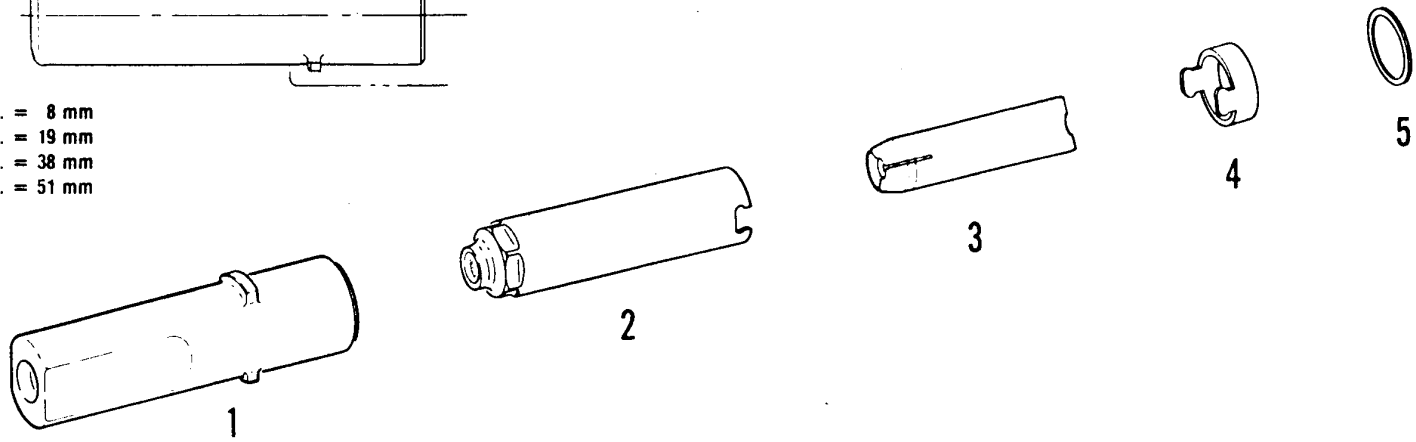
**Huck
Fasteners**

From Cordant Technologies

NOSE ASSEMBLY DATA SHEET



.33 in. = 8 mm
 .75 in. = 19 mm
 1.50 in. = 38 mm
 2.00 in. = 51 mm



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99-999	NOSE ASSEMBLY	Huck International, Inc. Installation System Division 1 Corporate Drive - Kingston, NY 12401	
		TYPE: Non Self-releasing; Self-ejecting FOR: HUCKBOLT -06; DR-08 TOOL: 212; 230; 352; 2400	
OTHER		ISSUED:	12-74
		REVISED:	10-82

REPLACEMENT PARTS			
REF	PART NO.	REQ	DESCRIPTION
1	109941	1	Anvil - Swaging
2	116224	1	Collet
3	116233	1	UNITIZED™ Jaws marked G
4	89794	1	Lock Collar
5	89140	1	Shim
	116234	1	Collet Assembly (incl. 2 - 5)
U.S. Patent No. 4,347,728			

SEE OTHER SIDE FOR NOTES AND ASSEMBLY INSTRUCTIONS

Nose Assembly Maintenance

1. Prepare tool per manual -- remove any shims from spindle/rod with small pick. Select pintail tube below to prevent small diameter pintails from jamming in pull piston or spindle.

Fastener	200/212/230/352/2400
-04 (1/8)	100534-1
-05 (5/32)	100534-1
-06 (3/16)	None req'd.

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

2. Tools that use hydraulic source :

Connect tool's hoses and controls to unit. Reconnect power source. Depress trigger for 30 seconds. Disconnect controls and RETURN hose. Tool piston must be completely forward.

Tools that use air source :

Air supply should have filter - regulator - lubricator unit with regulator set at 90 psi (620 kPa). See **WARNING** - - cycle tool a few times and disconnect with spindle/rod completely forward.

3. Disassembly/assembly as applicable:

Disassemble for inspection and maintenance.

Collet: extension : Stake extension to spindle/rod before attaching collet to extension - use only one shim. See 6. - - do not stake collet until jaw tension is correct - - see Fig. 1. SHIM AND LOCK COLLAR ARE NOT USED ON 200 TOOL SPINDLE - - spacer, 100536, is used instead - - see Fig. 3. SUPER O-LUBE on O-rings and follower. Apply VIBRA-TITE to extension W/O lock collar - - thread on collet/extension - - use 9/16 collet wrench, wrench flats, 5/32, 3/16, 1/4 and/or 5/16 hex key and tighten wrench-tight.

200 Tool : Hold spanner wrench, 111239, in slots at rear while snugging-up collet or extension.

210/212/230/2400 Tools : Hold 1/4 hex key (230) or 5/16 hex key (212/2400) in hex at rear while snugging-up collet or extension.

Anvil: Anvil is pressed out with drift and arbor press - - press new anvil in squarely to prevent cracking. Thread correct anvil insert into anvil holder. Assemble anvil retainer to anvil.

4. Tools with retaining nut and stop as applicable:

Slide holder/anvil over collet; stop and retaining nut over anvil/holder - - tighten hand-tight.

352 Tool : Slide holder/anvil over collet until ear depresses half-moon retainer. Turn holder until locked - - if ears do not enter groove, remove shim. On rotatable nose assemblies with retainer, 120738, hold key, 110237, in anvil slot - - 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.

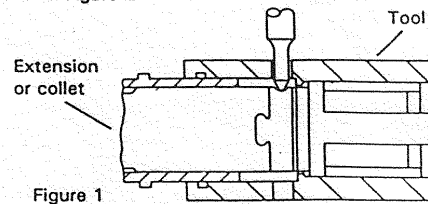
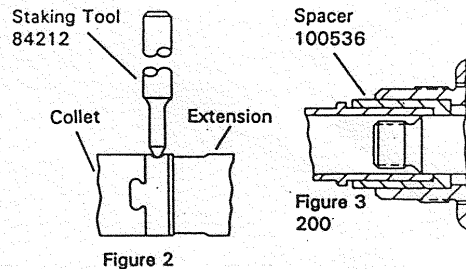
6. **Caution: To prevent damage, after proper adjustment has been made, collet lock collar must be staked.** As applicable, see Fig. 1 and/or Fig. 2. For nose assemblies with sleeve and O-rings, jaw tension on fastener pintail is changed by adding or removing O-ring(s). Use collet wrench to snug-up. Loose lock collars or too many shims (see step 4, **352 Tool**) may cause holder/anvil damage - - at least one shim per lock collar prevents potential jaw damage. Reuse lock collars until worn out.

Notes:

1. **To extend law 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 required : Jaws, lock collars, shims, press-in anvils, anvil inserts, springs, O-rings, retaining rings and anvil retainers.

3. Tools/service items - - as required: Brushes - NYLON bristle - 105805 (04, 05 & 06), 105806 (08); 9/16 collet wrench, 502914; drift, 83097 (.434 wide); staking tool, 84122; 5/32 hex key, 502450; 3/16 hex key, 502914; 1/4 hex key, 502445; 5/16 hex key, 502446; adjustable wrench, 503044; spanner wrench, 111239 (200); Parker SUPER O-LUBE, 505476 (for O-rings); VIBRA-TITE 505125.



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

352/200/212/230/2400
W/lock collars; W/ears