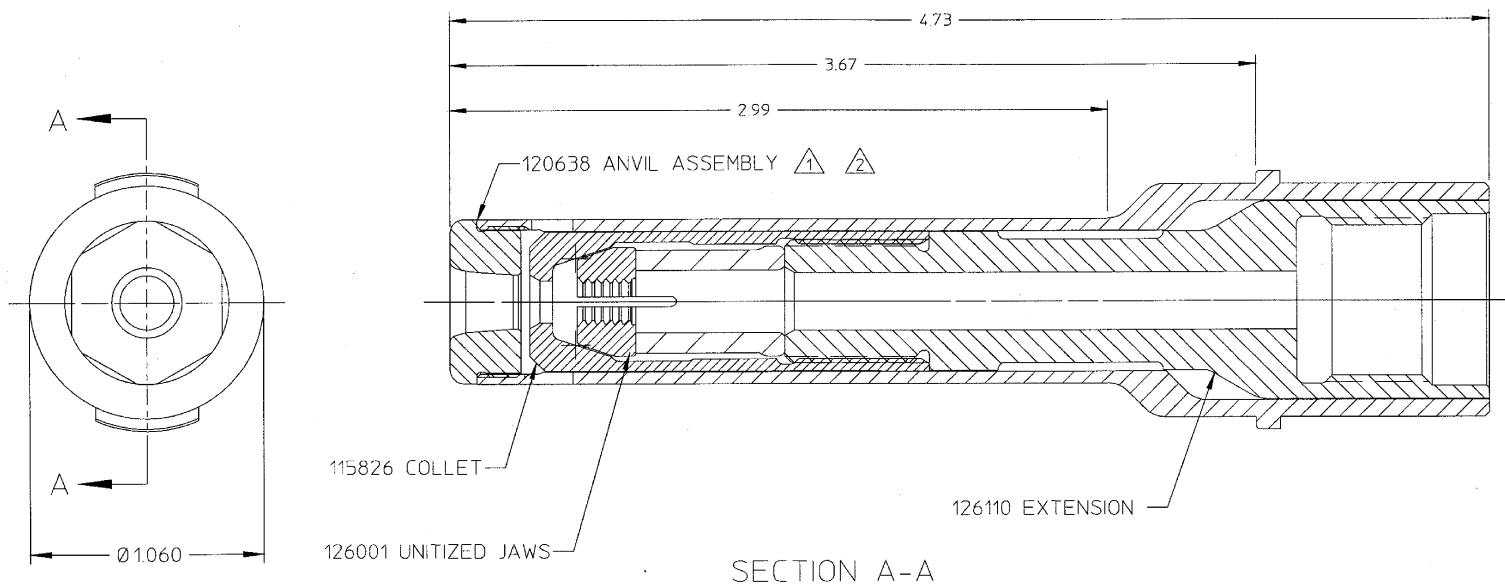




Huck Fasteners
an Alcoa business

DATA SHEET



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99-3206	NOSE ASSEMBLY	Huck International, Inc. Installation System Division 1 Corporate Drive - Kingston, NY 12401	
		TYPE: Non-self-releasing; Self-ejecting FOR: HUCKBOLT MAGNA-GRIP -06 TOOL: 353**	
	OTHER	PRODUCT REVISION: 7-91 REVISED: 05/26/00	

NOTES:

- 1 ANVIL ASSY 120638 CONSISTS OF:
(1) 120717 ANVIL HOLDER AND
(1) 120624 ANVIL INSERT
BOTH ARE AVAILABLE INDIVIDUALLY.
- 2 ANVIL INSERT WRENCH 125400 IS
OPTIONALLY AVAILABLE.

Nose Assembly Maintenance

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

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.**

Caution: Damage to 353 tool will result if tool is cycled without a nose assembly or the Stop Nut on tool (Stop Nut, 84213, is shipped with each 353).

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 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.

Caution: In severe conditions (and where lock collars are not used) VIBRA-TITE can be used on collet and/or extension threads to prevent loosening and damage. Carefully follow container's directions.

3. **Disassembly/assembly as applicable :** Remove parts of nose assembly for inspection/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. Use wrench to snugup extension on spindle. Assemble parts as shown - - apply thin coat SUPER OLUBE to Orings and O D of sleeve; VIBRA-TITE to extension W/O lock collar. Use collet wrench to snugup collet.

2580: To prevent piston from turning, hold 3/8 hex key in rear of tool.

Anvil; anvil holder: Pressed in anvil is pressed out with drift and arbor press; press new anvil in squarely to prevent cracking. Install anvil insert with 1/2 hex key. Assemble anvil retainer to anvil.

4. Tools with retaining nut and stop

as applicable:

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

353 Tool: Slide anvil over collet until ear depresses halfmoon retainer. Turn anvil until locked by retainer - - remove shim if ears do not enter groove. On rotatable nose assemblies with retainer, 106798, hold key, 110237, in anvil slot

- - as anvil is turned, retainer ears 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 Orings, jaw tension on fastener pintail is changed by adding or removing Oring(s). Use collet wrench to snugup. Loose lock collars or too many shims (see step 4, 353) 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 increase 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 Orings 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, shims, pressin anvils, screw-in anvils, springs, Orings and rotatable retainers.

3. *Tools/service items - - as required :* Brushes NYLON bristle - 105805 (04, 05 & 06), 105806 (08); collet wrenches - 502914 (9/16), 502920 (13/16); drifts - 83097 (.434 wide), 79524 (.684 wide); staking tool, 84122; 1/16 hex key, 502443; 3/8 hex key, 502650; 1/2 hex key, 505899; adjustable wrench, 503044; Parker's SUPER OLUBE (for Orings if used); VIBRA-TITE, 505125 (on extension W/O lock collar).

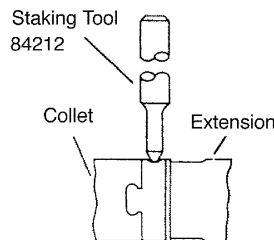


Figure 2

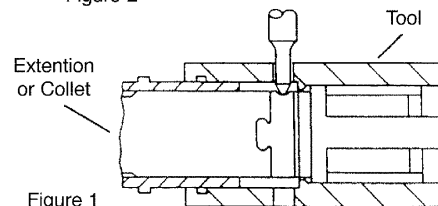


Figure 1

353/245/246/247/2502/2580
W/lock collar; ears optional