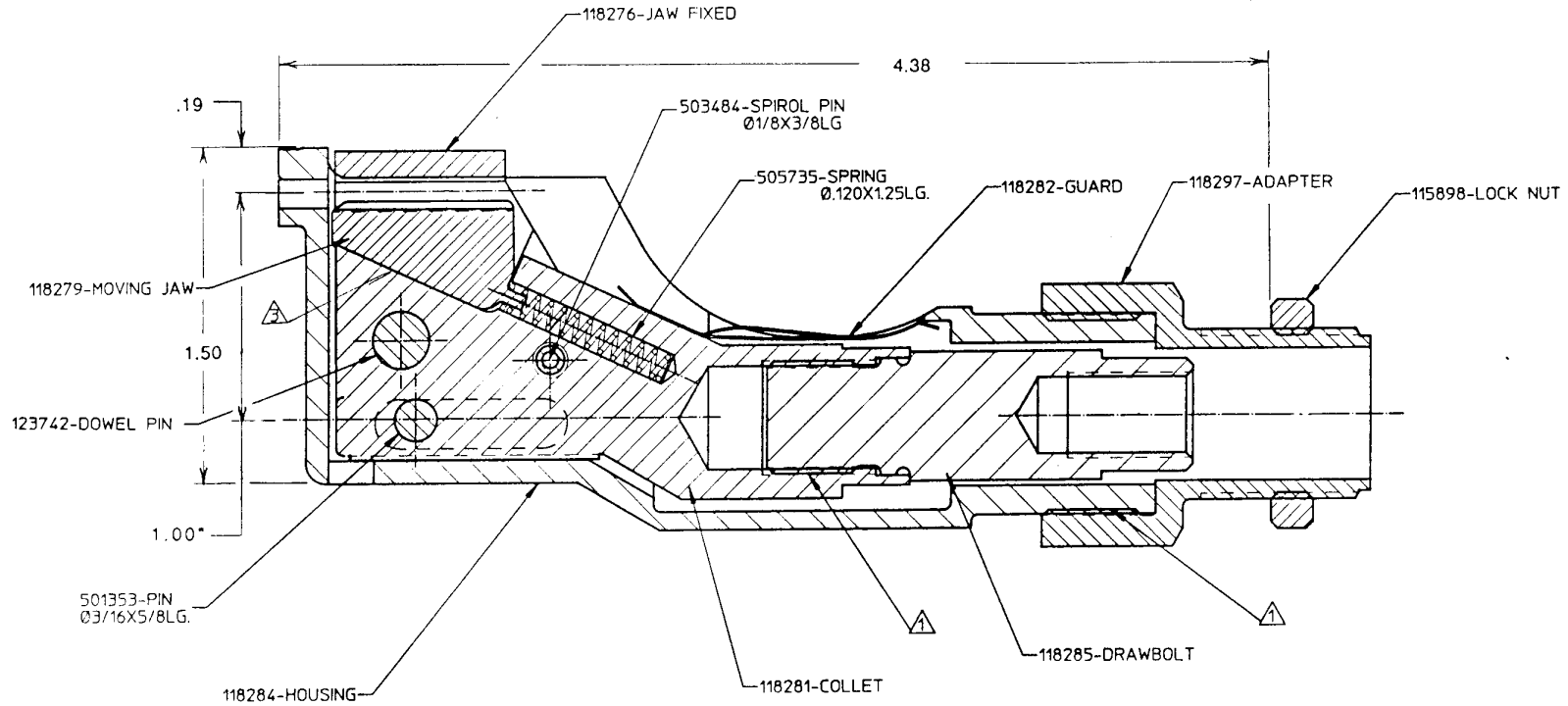




**Huck
Fasteners**

From Cordant Technologies

NOSE ASSEMBLY DATA SHEET



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△ USE P/N 620011 LOCTITE ON THREADS AND TORQUE PARTS TO 40-50 INCH LBS.

△ STONE COLLET RAMP AT ASSEMBLY TO REMOVE BURRS. APPLY NEVER-SEIZE P/N 505565 BETWEEN COLLET AND MOVABLE JAW SURFACES DURING ASSEMBLY

99-1333	Huck International, Inc. Installation System Division 1 Corporate Drive - Kingston, NY 12401	
	TYPE: B/R, Adjustable, Offset FOR: HUCK-CLINCH -04, -05 & -06 TOOL: HK150; 227	
	OTHER	ISSUED: 6-90 REVISED: 9-93

NOTE: FOR ADAPTING NOSE ASSEMBLY TO HK150, Adapter Shaft, 202971, and Adapter Nose Tube, 202202 must be ordered separately.

See other side for notes and assembly instructions.

Nose Assembly Maintenance

1. **HK150:**

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 Tube, 202202, onto tool -- tighten handtight.

227:

Prepare tool per manual.

WARNING As applicable:

Before starting any maintenance or adjustments, the tool must be disconnected from air supply. If not disconnected, severe personal injury and/or damage may result.

2. Assemble Spring/Moving Jaw Assembly and Fixed Jaw on Collet -- install two Pins to retain these parts. Slide assembled collet into Housing and install Dowel Pin through slot.

Caution: To prevent loosening and damage, apply LOCTITE, 242 (620011), to drawbolt and adapter threads as shown.

3. Thread Drawbolt into Collet -- use wrench flats to tighten to 40 - 50 in. lbs.

4. Thread Adapter and Lock Nut together - - turn nut all the way on. Thread assembled adapter and lock nut onto housing -- tighten adapter to 40 - 50 in. lbs. Install Guard in opening of housing -- it snaps in place- - tang engages slot in housing.

5. To check and adjust nose assembly:

Insert broken pintail into jaws until gripped firmly (use size to be installed). Position assembled collet forward until moving jaw is just lightly touching the inside wall of the housing. Hold collet in this position and screw nose assembly onto tool - - drawbolt will stop against shaft/piston rod shoulder, and then, turn lock nut against tube/tool:

HK150:

Just snug-up - - do not overtighten lock nut.

227:

Use wrench flats to tighten lock nut firmly.

Caution: Adjust nose assembly for each size fastener to prevent jaw damage.

10. As applicable:

Connect tool to power source. Install several correct size fasteners in properly drilled test plate of correct thickness to verify functioning of nose assembly.

Notes:

1. *To increase jaw life* : Disassemble and clean components periodically. Use a pick to clean jaw grooves. Wash components in **mineral spirits or isopropyl alcohol** only. Dry components **immediately** after cleaning. Apply lubricant containing graphite on collet where movable jaw slides.

2. *Replacements - - as applicable* : Jaws; springs.

3. *Service items - - as applicable* : Adjustable wrench, 503044; NYLON brush, 105805 (05 & 06); LOCTITE 242 (620011).