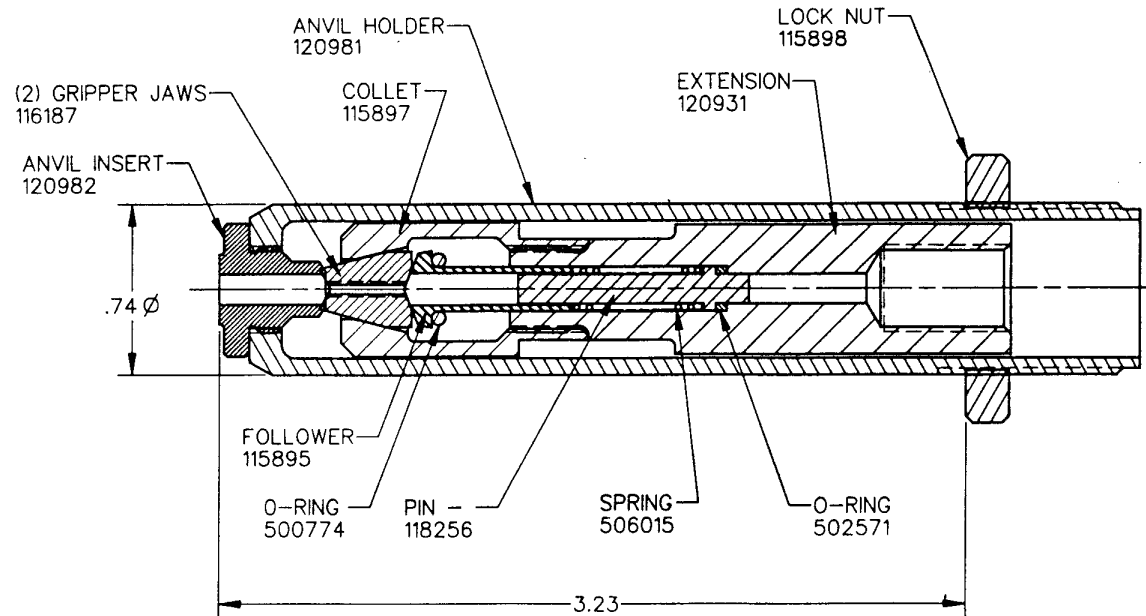




**Huck  
Fasteners**

From Cordant Technologies

# NOSE ASSEMBLY DATA SHEET



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<b>99-1335</b>	<b>Huck International, Inc.</b> Installation System Division 1 Corporate Drive - Kingston, NY 12401	
	<b>NOSE ASSEMBLY</b>	
<b>OTHER</b>	<b>TYPE:</b> B/R, Adjustable, Long <b>FOR:</b> HUCK-CLINCH -04, -05 & -06* <b>TOOL:</b> HK150; 227	
	<b>ISSUED:</b>	6-90
	<b>REVISED:</b>	9-90

***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. **H K 150:** Prepare tool per applicable publication and, then, unscrew nose tube from tool -- counter-clockwise. Unscrew jaw holder from tool's puller shaft -- counter-clockwise. Screw Adapter Shaft, 202971, onto tool's puller shaft until bottomed -- tighten hand-tight. Screw Adapter Nose Tube, 202202, onto tool -- tighten hand-tight.

**227 Tool:** Prepare tool per manual.

### WARNING

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

2. Assemble Collet, Jaws, Follower, Orings, Spring and Pin as shown on front of Data Sheet.

**CAUTION: Jaws must be in phase/step -- jaw damage may result if not in phase/step.**

3. While holding assembled Collet with jaw end tipped down (to keep jaws in phase), thread Extension and Collet together tighten wrench-tight.

4. Install Anvil Insert into Anvil tighten wrench-tight.

5. Thread Locknut onto Anvil as far as possible.

6. Thread Collet onto piston rod of tool use wrench flats to tighten firmly.

**KHK150:** Just snug-up -- do not over-tighten.

**227:** Use wrench flats to tighten firmly.

7. Thread Anvil into wiper housing of tool.

### 8. To check and adjust nose assembly:

See **CAUTION** -- When broken pintail of fastener can be inserted into anvil insert and it can be felt ratcheting across chuck jaws -- but still easily removable -- nose assembly is adjusted correctly. Adjustment is made by turning anvil holder in or out of housing until above condition is met.

**NOTE:** Adjust nose assembly for each size fastener - use correct size broken pintail.

9. Tighten Locknut (25) against tube/tool to maintain adjustment.

**HK150:** Just snug-up -- do not over-tighten lock nut.

**227:** Use wrench flats to tighten firmly.

10. **As Applicable:** Connect tool to power source. Install enough fasteners in a properly drilled test plate of correct thickness to verify functioning of nose assembly.

### Notes:

1. Disassemble and clean components periodically. Use a pick to clean jaw grooves. Wash components in **mineral spirits or isopropyl alcohol** only. Do not let urethane jaw assemblies soak and do not use solvents that will cause urethane to swell. Dry components **immediately** after cleaning.

2. Spare Parts -- as applicable: Driving anvils; jaws; springs.

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