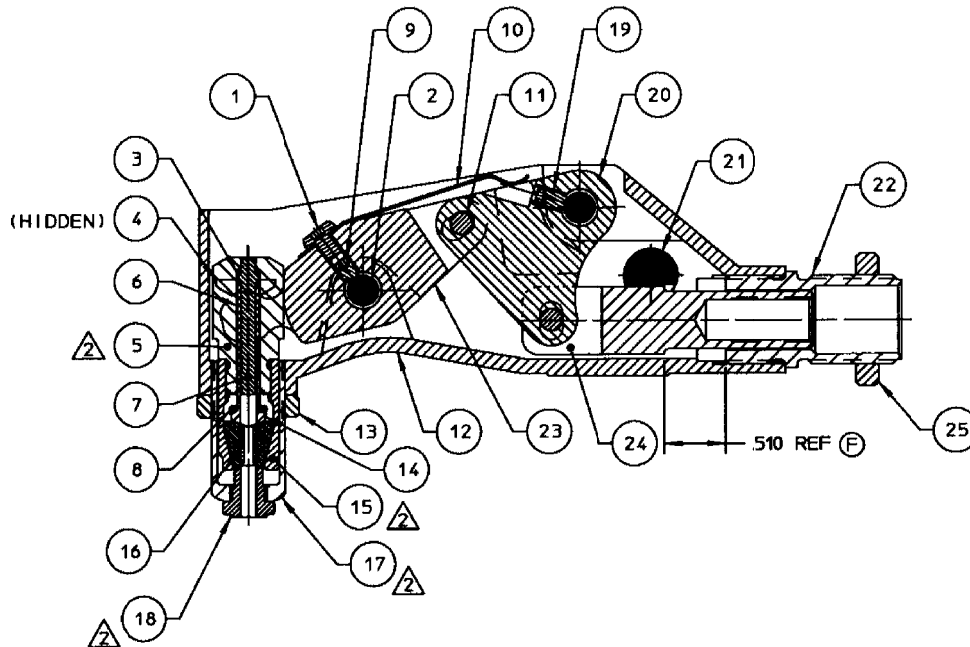




Huck Fasteners
an Alcoa business

DATA SHEET



600058	2	HC3213-06-04 HUCK CLINCH	27
600057	2	HC3213-04-03 HUCK CLINCH	26
115898	1	LOCKNUT	A 25
118273	1	DRAWBOLT	B 24
118272	1	ROCKER MACHINED	A 23
126682	1	ADAPTER	A 22
118269	1	PIN, RETAINING	A 21
118268	1	BELLCRANK MACHINED	A 20
501864	1	SSCR SOC HDG #08-32 X .25 26	19
118266	1	ANVIL INSERT HUCKCLINCH	B 18
118265	1	ANVIL HOLDER	A 17
116187	1	JAWS, GRIPPER	N 16
118263	1	COLLET	B 15
115895	1	FOLLOWER	A 14
118261	1	LOCKNUT	A 13
118260	1	HOUSING MACHINED	A 12
118258	2	LINKAGE PIN	A 11
118257	1	GUARD	A 10
501863	1	SSCR SOC HDG #08-32 X .19 26	9
500774	1	O-RING AS568-008 C366Y D70 80	8
118256	1	PIN, EJECTOR	A 7
506015	1	SPRING-LEE #LC-020B-12	76 6
118255	1	DRAWBOLT	B 5
118254	2	BEARING	A 4
502571	1	O-RING AS568-003 C366Y D70 80	3
118253	2	PIN, PIVOT	A 2
505737	1	SCR BUT #08-32 X .19 ZP	14 1
PART NO	QTY	DESCRIPTION	ITEM

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99-1334	Huck International, Inc. Installation System Division 1 Corporate Drive - Kingston, NY 12401	
	TYPE: B/R, Adjustable, Right-angle FOR: HUCK-CLINCH -04, -05 & -06* TOOL: 2013; HK155M	
	OTHER	PRODUCT REVISION: F REVISED: 7/24/02

NOTES:

- NOSE ASSEMBLY TO CONFORM TO HUCK SPEC 42-484 USING THE FOLLOWING FASTENERS: 1/8, 5/32, 3/16 HUCK-CLINCH.
- TORQUE COLLET #118263 TO DRAWBAR #118255 TO 30-40 IN-LBS AND TORQUE ANVIL INSERT #118266 TO ANVIL HOLDER #118265 TO 10-20 IN-LBS.

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 any maintenance or nose assembly adjustments, tool must always be disconnected from air supply. If not disconnected, severe personal injury and/or damage may result.

2. Assemble Drawbolt (24) to Bellcrank (20) and Rocker (23) use 2 Pins (11). Slide Retaining Pin (21) into Housing (12). Drop Drawbolt / Bellcrank Assembly into housing and guide past retaining pin. Use one Pivot Pin (2) to hold Bellcrank (20) in Housing (12).

3. Turn housing so open side faces down and rocker drops out of housing. Turn housing back over while holding end of rocker drop Drawbar (5) into slots in rocker. Where rear of rocker contacts drawbar, insert two brass Bearings (4).

4. Push rocker and drawbar back into housing use Pivot Pin (2) to hold rocker in housing. Install both Set Screws (9) to retain pivot pins and, then, fasten Guard (10) to rocker with Button Head Screw (1) -- use 5/64 and 3/32 hex keys.

5. Assemble components in collet and drawbar as shown. Thread assembled collet onto drawbar while guiding Follower (14) onto Ejector Pin (7) -- torque collet and drawbar to 3040 in. lbs. Thread Anvil Insert (18) into Holder (17) -- torque to 10-20 in. lbs.

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

6. Check Chuck Jaws (16) to be sure they are in phase/step. First, thread Drawbolt (24) onto adapter shaft/rod of tool -- about 1 1/2 turns. Next, thread Adapter (22) into tube/tool until Collet Drawbar (5) just begins to move back -- this position allows for full stroke of tool.

7. To check and adjust nose assembly:

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.

8. 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.

9. Connect tool to power source. Install several fasteners in 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:* Anvil insert; jaws; springs.

3. *Service items as applicable:* Adjustable Wrench, 503044; 5/64 hex key, 502444; 3/32 hex key, 502293; NYLON brush (-05 & -06), 105805.