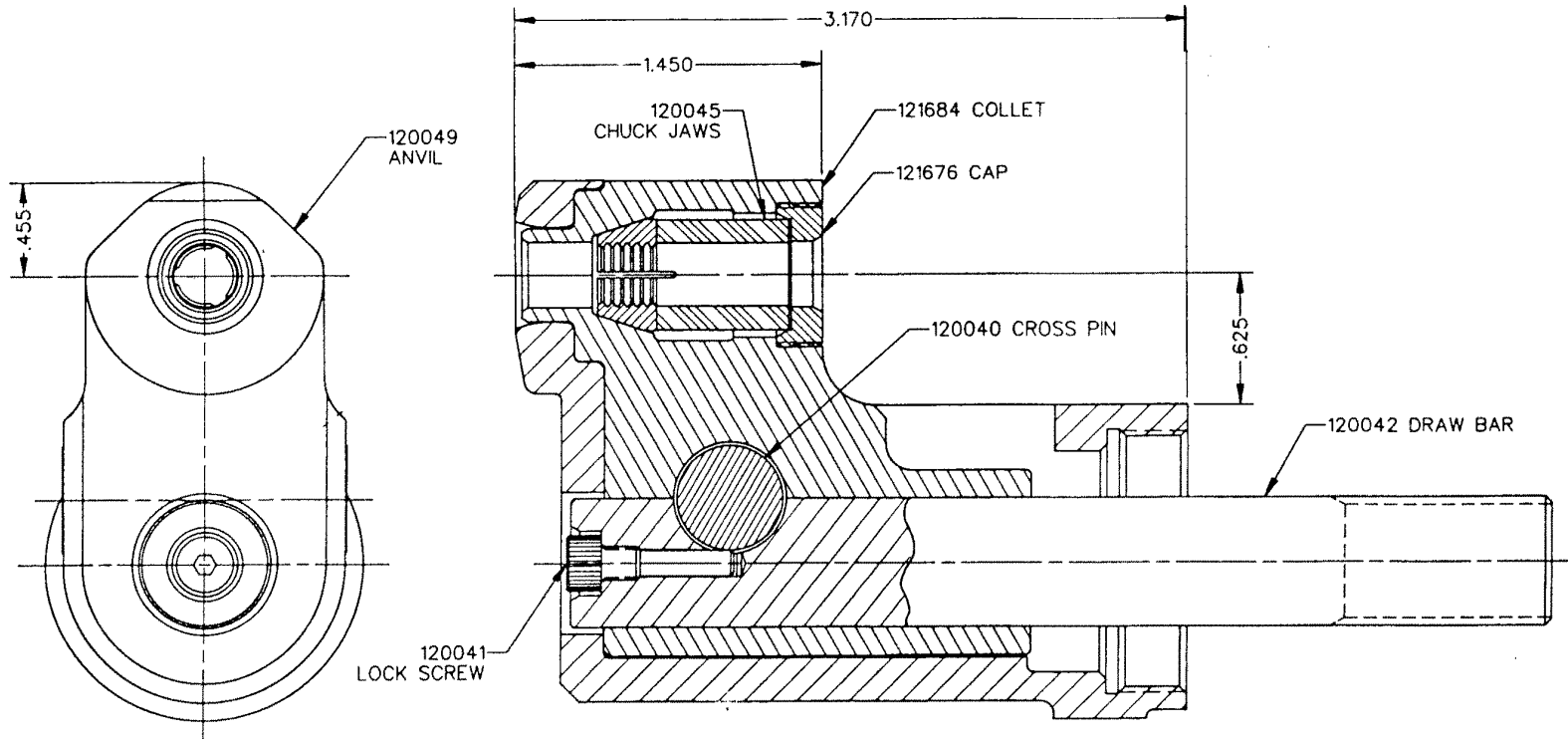


**Huck
Fasteners**

From Cordant Technologies

NOSE ASSEMBLY DATA SHEET



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99-1720	Huck International, Inc. Installation System Division 1 Corporate Drive - Kingston, NY 12401	
	TYPE: Offset, Non Self-releasing FOR: HUCKBOLT GP -10 TOOL: 208-625	
	OTHER	ISSUED: 10-89 REVISED: 5-91

U.S. Patent No. 4,796,455

NOTES:

- 1 MAXIMUM RECOMMENDED STROKE: .750
- 2 OPTIONAL DEFLECTOR KIT P/N 121681 AVAILABLE FOR THIS NOSE ASSEMBLY CONSISTS OF:
 DEFLECTOR P/N 121677
 RETAINING NUT P/N 121678

Nose Assembly Maintenance

1. Prepare tool per manual.

WARNING

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

Disconnect POWERIG Hydraulic Unit's power source. Connect tool's hoses and controls to unit. Reconnect power source. Depress trigger for 30 seconds piston stops completely forward. Disconnect controls and **RETURN** hose **tool piston must be remain completely forward.**

2. **Disassembly/assembly as applies:** Remove parts of nose assembly for inspection and maintenance.

Anvil:

Pressed in anvil insert is pressed out with drift and arbor press press new insert in squarely to prevent cracking.

Collet/drawbar:

Assemble collet as shown. Use 7/32, 1/4, 5/16 or 3/8 hex key (tighten wrench-tight) or 0100 TRUARC pliers. Slide drawbar into collet. Push crosspin through collet and drawbar. With LOCKTITE on threads, lock collet to drawbar with tightly installed socket head screw as applicable, use either 3/32 or 9/64 hex key.

3. Attaching to tool:

While holding front of collet against back of anvil, screw assembly onto/into tool. When assembly stops turning, collet should still be against back of anvil.

4. Checking nose assembly:

See **WARNING** connect controls and **RETURN** hose. Reconnect hydraulic unit to power source. Install fasteners in test plate of correct thickness with proper size holes inspect installed fasteners.

Notes

1. To extend 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; urethane jaw assemblies **immediately** after cleaning as prolonged contact with solvent causes swelling dry other parts.

2. Replacements as applicable: Anvil inserts; jaws; springs; retaining rings.

3. Service items as required: 3/32 hex key, 502293; 9/64 hex key, 502655; 7/32 hex key, 502297; 1/4 hex key, 502445; 5/16 hex key, 502446; 3/8 hex key, 502651; LOCTITE, 503657; VIBRA-TITE, 502125; TRUARC (0100) pliers, 502857; NYLON brushes: 105805 (05 & 06), 105806 (08), 107070 (10 & 12)