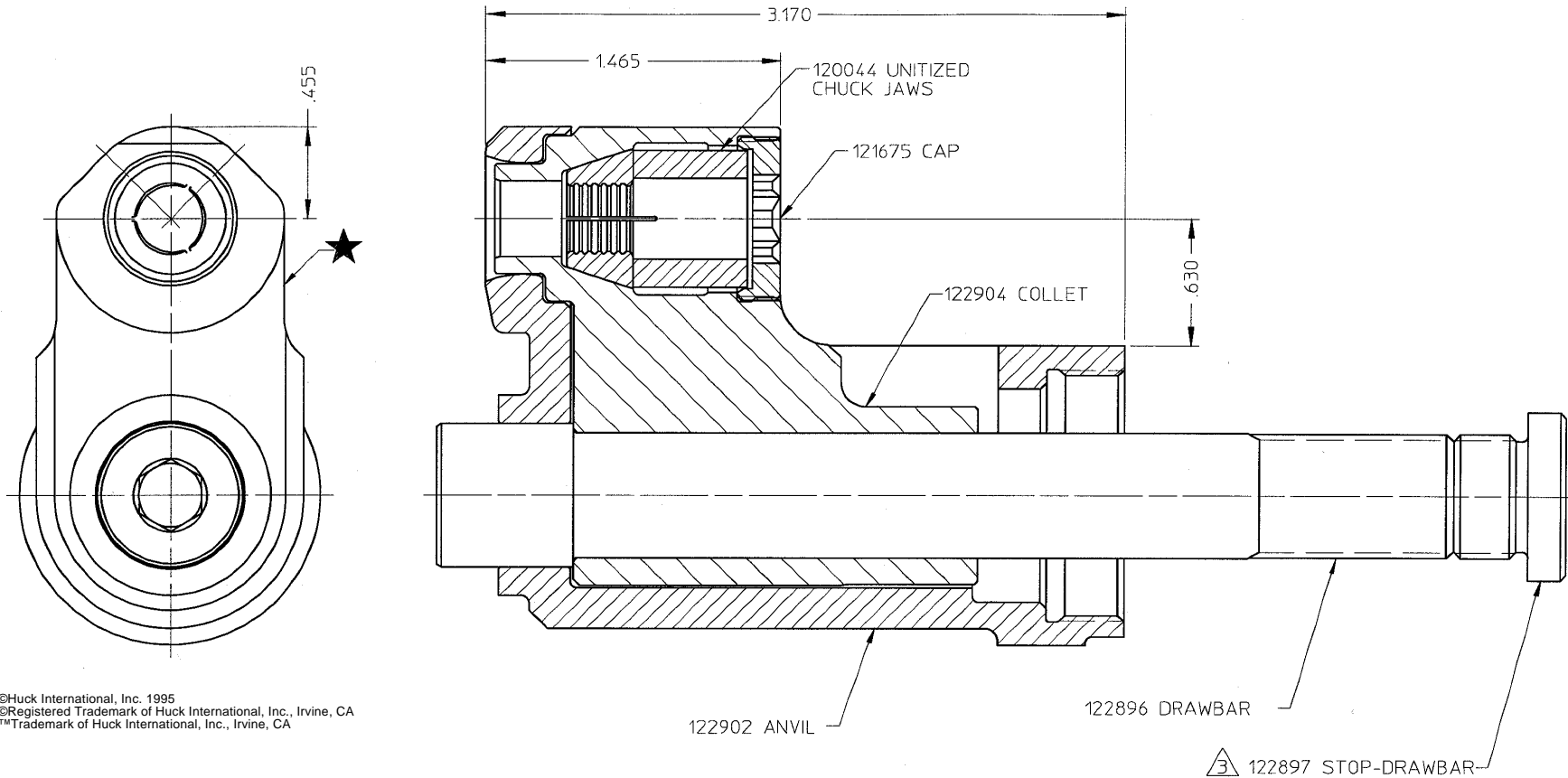




**Huck
Fasteners**

From Cordant Technologies

NOSE ASSEMBLY DATA SHEET



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99-1756	Huck International, Inc. Installation System Division 1 Corporate Drive - Kingston, NY 12401	
	TYPE: Offset, Non Self-releasing FOR: HUCKBOLT, GP -12, Straddle TOOL: 208-625	
	OTHER	ISSUED: 2-93 REVISED: 12-98

NOTES:

- 1 MAXIMUM RECOMMENDED STROKE: .625
- 2 OPTIONAL DEFLECTOR KIT P/N 121680 AVAILABLE FOR THIS NOSE ASSEMBLY CONSISTING OF:
 DEFLECTOR P/N 121677
 RETAINING NUT P/N 121679
- 3 INSTALL IN REAR OF 208-625 TOOL AND TORQUE TO 25-30 FT/LBS.

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.**

CAUTION: In severe conditions, VIBRA-TITE can be used on all threads to prevent loosening and damage. Carefully follow container's directions.

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/stop:

Assemble collet as shown - - use 3/8 hex key on cap - - tighten wrench-tight. Using 5/16 hex key, tighten drawbar stop into back of tool. Screw anvil/collet onto tool. Slide drawbar through anvil/collet and tighten against drawbar stop.

3. **Attaching to tool:**

While holding front of collet against back of anvil, screw assembly onto tool.

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; 1/4 hex key, 502445; 5/16 hex key, 502446; 3/8 hex key, 502651; LOC-TITE, 503657; VIBRA-TITE, 502125; TRUARC (0100) pliers, 502857; NYLON brushes: 105805 (05 & 06), 105806 (08), 107070 (10 & 12)