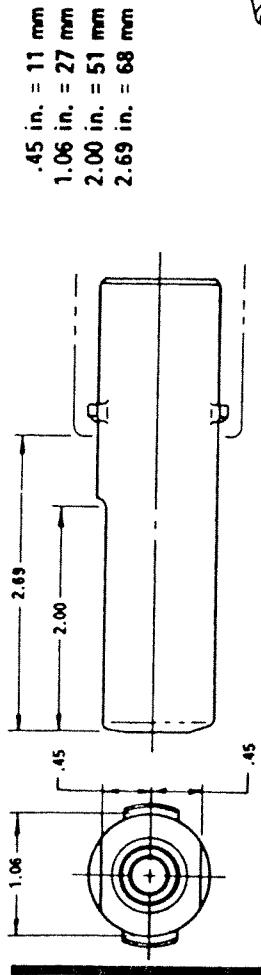
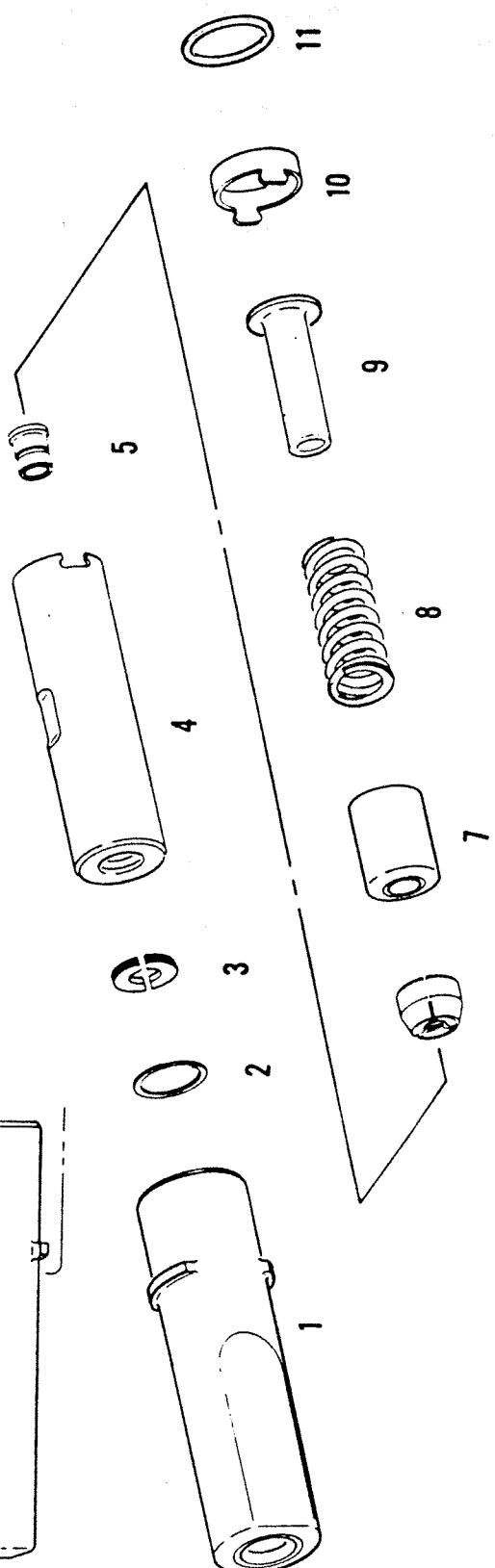
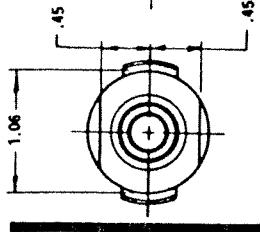
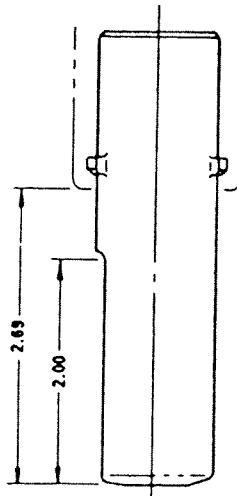




NOSE ASSEMBLY DATA SHEET



.45 in. = 11 mm
1.06 in. = 27 mm
2.00 in. = 51 mm
2.69 in. = 68 mm



•225BE 2500

226 2502

245 2503

246 4801

247 4802

4803

6

REF	PART NO.	REQ	DESCRIPTION
1	102448	1	Anvil - Swaging
2	502816	1	Ret. Ring (SPIROLOX RS-62)
3	102719	1	Flange - Split
4	102449	1	Collet
5	103505	1	Elector
6	102550	1	Jaws marked Z
7	107447	1	Follower
8	109737	1	Spring
9	84454	1	Sleeve
10	89795	1	Lock Collar
11	89298	1	Shim
	103504	1	Collet Assem. (inc. 2 - 11)

REPLACEMENT PARTS			
REF	PART NO.	REQ	DESCRIPTION
1	102448	1	Anvil - Swaging
2	502816	1	Ret. Ring (SPIROLOX RS-62)
3	102719	1	Flange - Split
4	102449	1	Collet
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SEE OTHER SIDE FOR NOTES AND ASSEMBLY INSTRUCTIONS

Huck Manufacturing Company	
Installation Equipment Division	
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® Registered Trademark Of Huck Mfg. Co. Irvine, CA	
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TYPE: Non self-releasing	
FOR: HUCKBOLT® .08 & BL-10	
TOOL: 353*	
ISSUED: 1-80	REVISED:
NOSE ASSEMBLY	
99-667	

Nose Assembly Maintenance

1. Prepare tool per manual. Remove any loose shims from spindle/rod with small pick.

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

Caution: Damage to 353 tool will result if tool is cycled without a Nose Assembly or the Stop Nut on tool (Stop Nut, P/N 84213, is shipped with each 353).

2. Tools that use hydraulic source:

Connect tool's hoses and controls to unit.

Reconnect power source. Depress trigger for 30 seconds. Disconnect controls and RETURN hose. Tool piston must be completely forward. See Caution above.

Tools that use air source: Air supply should have filter - regulator - lubricator unit with regulator set at 90 psi (620 kPa).

Disconnect air supply -- see WARNING and Caution above -- on 353 tool, install stop nut or nose assembly. Cycle tool a few times and disconnect from air supply with spindle/rod completely forward.

3. Disassembly/assembly as applicable:

Remove parts of N/assem. for inspection and maintenance. If applicable; pressed-in anvil is pressed out with drift and arbor press; press new anvil in squarely to prevent cracking.

When using extension, stake to tool's spindle/rod before assembling collet -- see Fig. 1; use only one shim. Use wrench to snug-up extension on spindle. Assemble parts as shown -- apply thin coat SUPER O-LUBE to O-rings and O D of sleeve and VIBRATITE to extension W/O lock collar. Use collet wrench to snug-up collet.

4801: Tool has holes in adapter -- rod through adapter and spindle/rod prevents piston from turning.

4. Tools with retaining nut and stop:

Slide anvil/holder over collet. Slide stop and retaining nut over holder/anvil -- tighten hand-tight.

353 Tool: Slide holder/anvil over collet until ear depresses half-moon retainer. Turn holder/anvil until locked by retainer -- remove shim if ears do not enter groove. On rotatable nose assemblies, hold key, 110237, in anvil slot -- as anvil is turned, retainer ears will enter groove.

5. As applicable: See WARNING -- connect controls and RETURN hose on hydraulic tool. Reconnect hydraulic unit or air tool/unit to power source. Install fasteners in test plate of correct thickness with proper size holes -- inspect installed fasteners.

6. Caution: To prevent damage -- after proper adjustment has been made, collet lock collar must be staked. As applicable, see Fig. 1 and/or Fig. 2. For nose assemblies with sleeve and O-rings, jaw tension on fastener pintail is changed by adding or removing O-ring(s). Use collet wrench to snug-up. Loose lock collars or too many shims (see step 4, 353) may cause holder/anvil damage -- too few shims may cause jaw damage. Reuse lock collars until ineffective.

Notes

1. To extend jaw life: Disassemble N/A periodically; clean and inspect components -- use a pick to clean jaw grooves. **Caution:** Wash parts in mineral spirits or Isopropyl alcohol only -- dry O-rings and urethane jaw assemblies immediately after cleaning as prolonged contact with solvent causes swelling -- dry other parts.

2. Spare parts -- as required: Jaws, lock collars, press-in anvils, springs, O-rings and shims.

3. Tools/service items -- as required: Brushes - NYLON bristle - 105805 (04, 05 & 06), 105806 (08); collet wrenches - 502914 (9/16), 502920 (13/16); drifts - 83097 (.434 wide), 79524 (.684 wide); staking tool, 84122; adjustable wrench, 503044; Parker's SUPER O-LUBE (for O-rings if used); VIBRATITE, 505125 (on extension W/O lock collar).

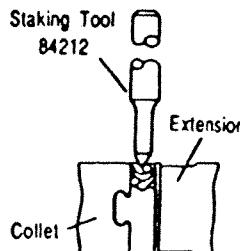


Figure 2

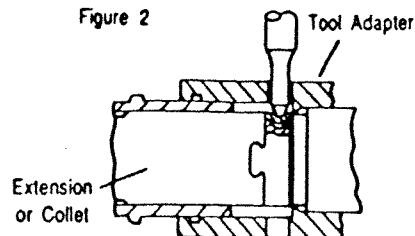


Figure 1

CAUTION: Cycling tool to retract spindle/piston rod when attaching anvil will cause damage to tool and/or nose assembly.