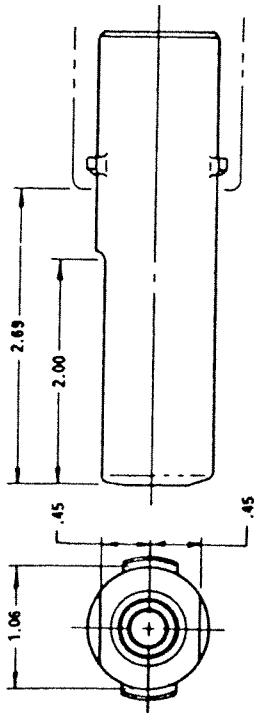
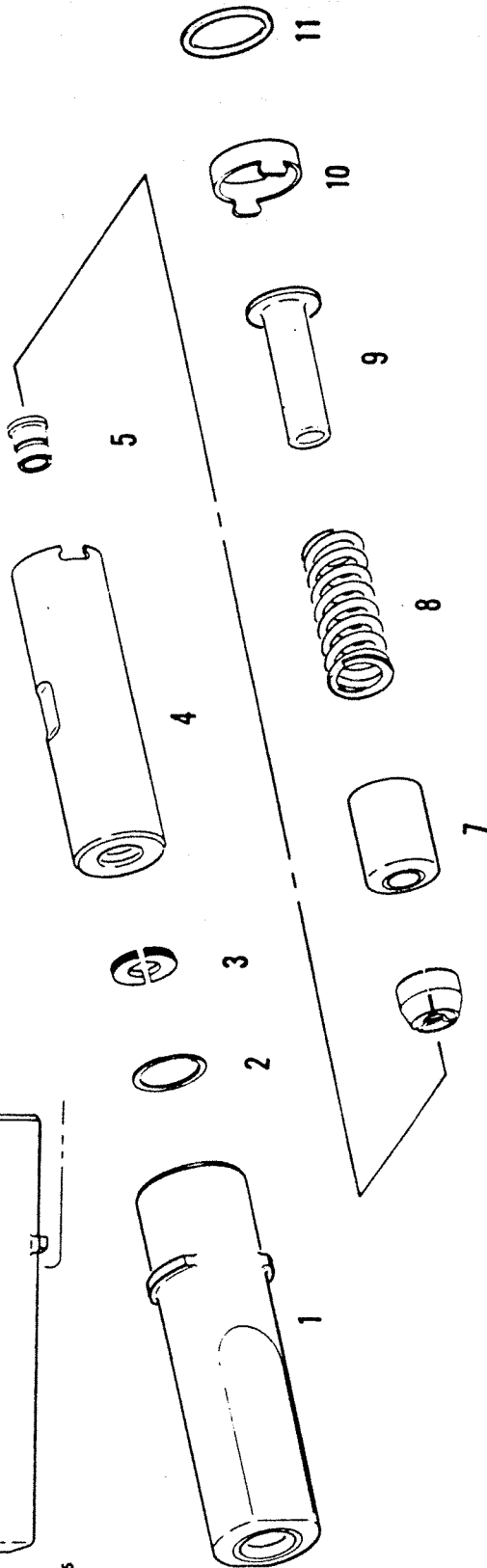


# NOSE ASSEMBLY DATA SHEET



.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

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<b>Huck Manufacturing Company</b> Installation Equipment Division 85 Grand Street • Kingston, NY 12401	
TYPE: Non self-releasing FOR: HUCKBOLT® -08 & BL-10 TOOL: 353**	
ISSUED: 1-80	REVISED:
NOSE ASSEMBLY	
99-667	

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

SEE OTHER SIDE FOR NOTES AND ASSEMBLY INSTRUCTIONS

## 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).

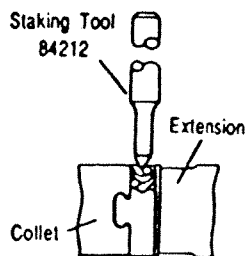


Figure 2

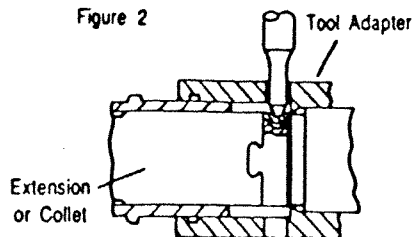


Figure 1

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