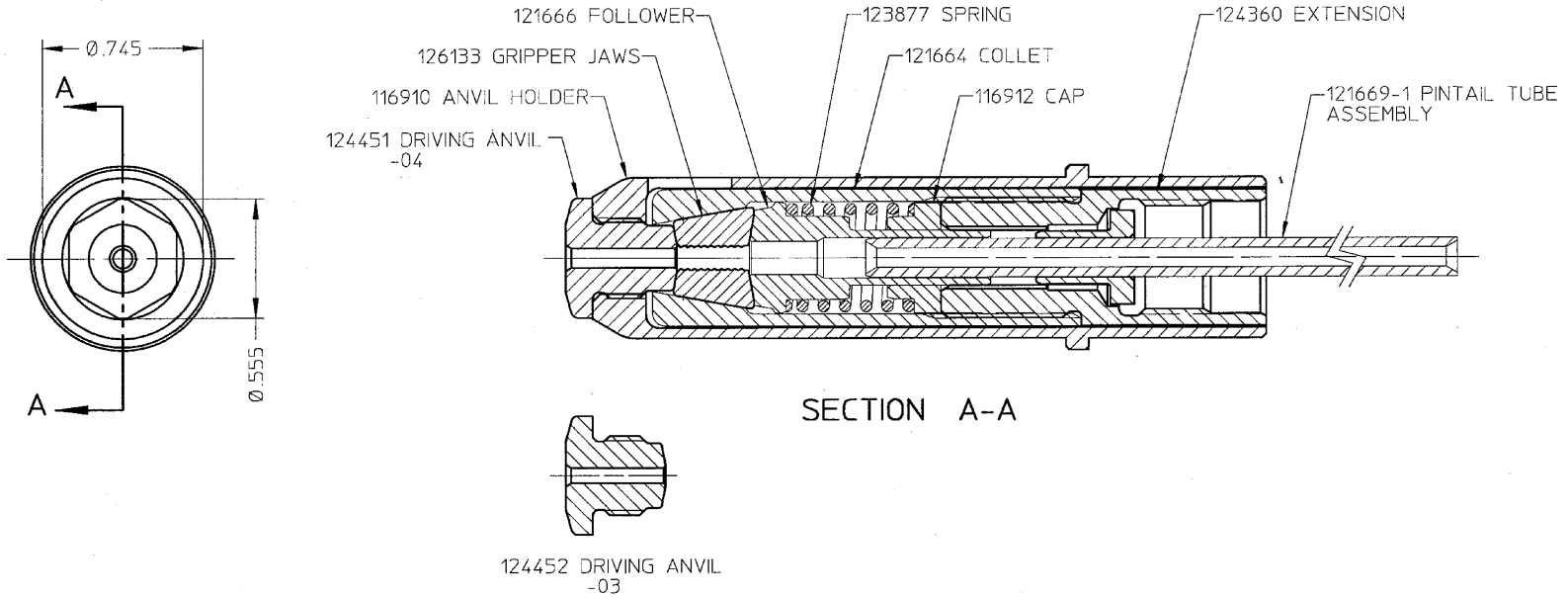




**Huck Fasteners**  
an Alcoa business

# DATA SHEET



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**NOTES:**

1 SHIP DRIVING ANVIL 124452 IN SEPARATE BAG.

<b>99-3422-34</b>	<b>Huck International, Inc.</b> Installation System Division 1 Corporate Drive - Kingston, NY 12401	
	<b>TYPE:</b> Nail Type Blind Rivet <b>FOR:</b> -03; -04; convertible; std. lgth. <b>TOOL:</b> 202; 212; 230; 2400	
	<b>OTHER</b>	<b>PRODUCT REVISION:</b> C <b>REVISED:</b> 12/06/00

# **NOSE ASSEMBLY MAINTENANCE**

## **200, 202, 202L, 212, 230, 2400, 2480, 2480L,**

### **2025L: Without Lock Collars; With Ears**

1. Prepare tool per manual. Remove any shims from spindle/rod with small pick. Select pintail tube to prevent small diameter pintails from jamming in the pull piston or spindle.



**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 may result.

2. **Tools using hydraulic source:**  
Connect tool's hoses and controls to POWERIG hydraulic unit. Reconnect power source. Depress trigger for 30 seconds. Disconnect controls and RETURN hose. **Tool piston must be completely forward.**

#### **Tools using air source:**

Air supply should have filter regulator lubricator unit with regulator set at 90psi (620 kPa). **See WARNING.** Cycle tool a few times and disconnect. **Spindle rod must be completely forward.**

**CAUTION:** In severe conditions, VIBRATITE can be used on collet and/or extension threads to prevent loosening or damage. Carefully follow container's directions.

3. **Disassembly/assembly as applicable:**  
Disassemble for inspection and maintenance. **Collet/Extension:** Assemble parts as shown. Spread thin film of SUPER OLUBE on o-rings and O.D. of Follower. Tighten assembled collet onto extension using 9/16 collet wrench, wrench flats, 1/4 and/or 5/16 hex key. Tighten assembled collet onto extension to 28-32 ft. lbs. **See CAUTION.** **202/212/230/2400/2480 tools:** Hold 3/16 hex key (202), 1/4 hex key (230), or 5/16 hex key (212/2400/2480) in hex at rear while tightening collet/extension to torque listed above. **Anvil:** Thread anvil insert into anvil holder and torque 20-23 ft. lbs. for MG &

MGL noses with anvil inserts. Others should be snugged up securely. When changing insert, holder needs not be removed. Pressed-in anvil is pressed out with drift and arbor press. Press new anvil in squarely to prevent cracking. Snug up anvil spindle and/or install other parts as shown.

4. **Attaching to tool as applicable:** Slide holder/anvil over collet, and stop and retaining nut over anvil holder. Tighten adapter to 28-32 ft. lbs. Install anvil holder and retaining sleeve. Tighten 3 screws to 3-5 ft. lbs.
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. Inspect installed fasteners.

#### **Notes:**

1. **To extend jaw life:** Disassemble nose assembly periodically. Clean and inspect components. Use a pick to clean chuck jaw grooves.  
**CAUTION:** Wash parts in mineral spirits or isopropyl alcohol only.  
Dry o-rings. Urethane chuck jaw assemblies immediately after cleaning as prolonged contact with solvent causes swelling. Dry other parts.
2. **Spare parts as required:** Chuck jaws, o-rings, anvil inserts, springs, screws, bearings.
3. **Tool/Service items as required:** Brushes, NYLON bristle 105805 (04, -05, -06), 105806 (-08); 9/16 collet wrench 502914; drift 83097 (.434 wide); 3/16 hex key 502296; 1/4 hex key 502445; 5/16 hex key 502446; adjustable wrench 503044; spanner wrench 111239 (200); VIBRATITE 505125; Parker SUPER OLUBE 505476 (for o-rings).

NADS back no. **NA006**