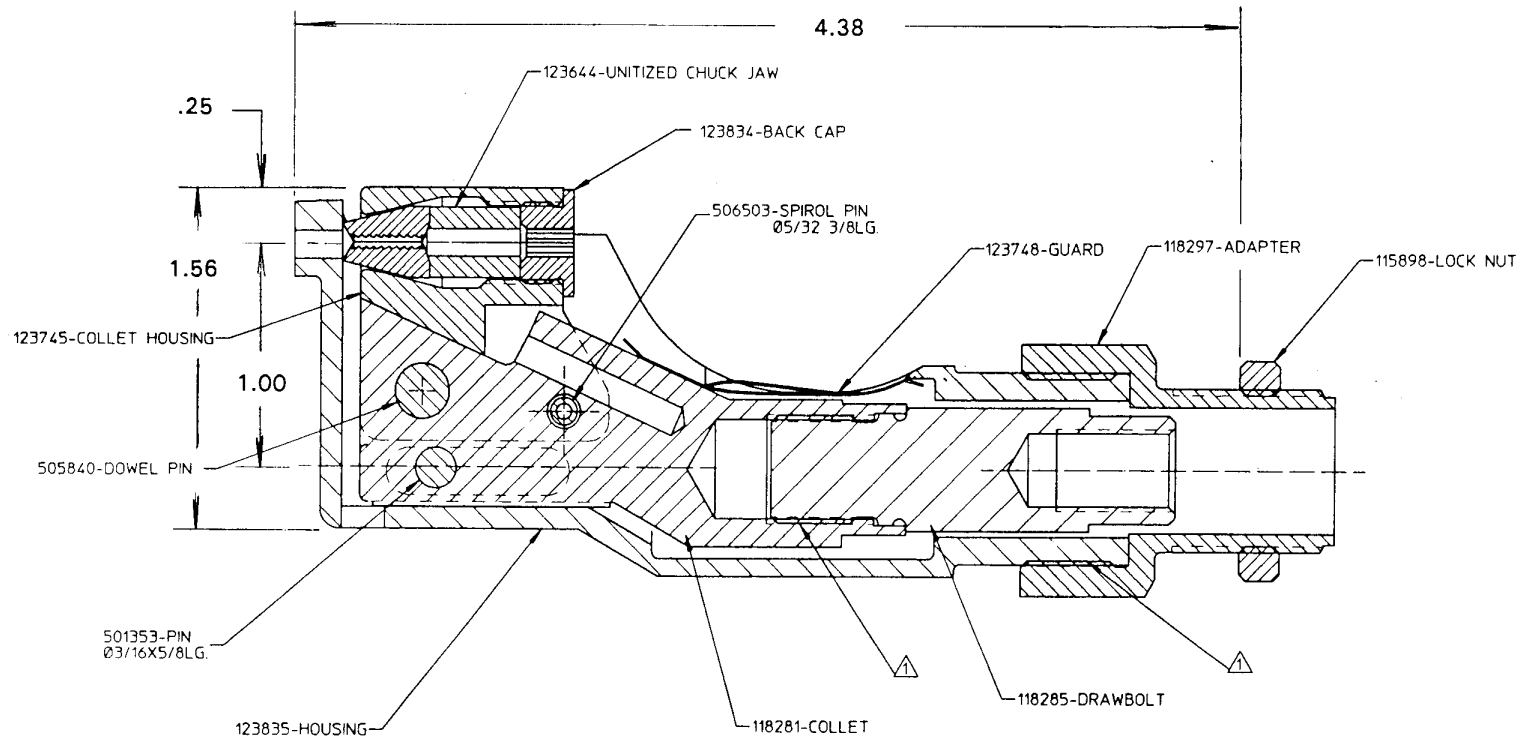




**Huck
Fasteners**

From Cordant Technologies

NOSE ASSEMBLY DATA SHEET



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99-1336	Huck International, Inc. Installation System Division 1 Corporate Drive - Kingston, NY 12401	
	NOSE ASSEMBLY	TYPE: B/R, Adjustable, Offset FOR: HUCK-CLINCH -04, -05 & -06 TOOL: HK150; 227
	OTHER	ISSUED: 11-93 REVISED:

.S. Patent No. 4,347,728

NOTE: FOR ADAPTING NOSE ASSEMBLY TO HK150,
 Adapter Shaft, 202971, and Adapter Nose Tube, 202202
 must be ordered separately.

⚠ USE P/N 620011 LOCTITE ON THREADS AND TORQUE PARTS
 TO 40-50 INCH LBS

Nose Assembly Maintenance

1. **HK150:** Prepare tool per manual, and then, unscrew nose tube from tool -- counterclockwise. Unscrew jaw holder from tool's puller shaft -- counterclockwise. Screw Adapter Shaft, 202971, onto tool's puller shaft until bottomed -- tighten handtight. Screw Adapter Tube, 202202, onto tool -- tighten handtight.
227: Prepare tool per tool's manual.

WARNING As applicable:
Before starting any maintenance or adjustments, the tool must be disconnected from air supply. If not disconnected, severe personal injury and/or damage may result.

2. Assemble UNITIZED jaws into collet housing -- tighten with 1/8 hex key. Install two pins to hold assembled collet housing/jaws secure in collet. Slide assembled collet into housing and install dowel pin through slot.

Caution: To prevent loosening and damage, apply LOCTITE, 242 (620011), to drawbolt and adapter threads.

3. Thread drawbolt into collet -- use wrench flats to tighten to 40 - 50 in. lbs.

4. Thread adapter and lock nut together -- turn nut all the way on. Thread assembled adapter and lock nut onto housing -- tighten adapter to 40 - 50 in. lbs. Install guard in opening of housing -- it snaps in place -- tang engages slot in housing.

5. Move collet assembly to full rear position within housing. Screw collet assembly onto tool piston rod by rotating entire nose assembly 2 - 3 turns. Push housing assembly against tool adapter, and then, screw housing 4 - 5 turns into adapter. Tighten lock-nut against face of adapter to retain nose assembly position. To reduce pin insertion load of O6 fasteners, unscrew back-cap one full turn -- leave back-cap unscrewed until O4 or O5 fasteners are used.
HK150: Just snugup -- do not overtighten lock nut.
227: Use wrench flats to tighten lock nut firmly.

6. **As applicable:** Connect tool to power source. Install several correct size fasteners in properly drilled test plate of correct thickness to verify functioning of nose assembly.

Notes:

1. Disassemble and clean components periodically. Use a pick to clean jaw grooves. Wash components in **mineral spirits or isopropyl alcohol** only. Dry components immediately after cleaning.

2. *Replacements -- as applicable: Jaws.*

3. *Service items -- as applicable: Adjustable wrench, 503044; 1/8 hex key, 502294; NYLON brush, 105805 (O5 & O6); LOCTITE 242 (Huck P/N, 620011).*