

**Alcoa
Fastening
Systems**



NOSE ASSEMBLY INSTALLATION AND MAINTENANCE GUIDE

Makers of Huck®, Marson®, Recoil®
Brand Fasteners, Tools & Accessories

11-23-2011
HK1100



EC Declaration of Conformity

Manufacturer:

Alcoa Fastening Systems, Industrial Products Group, 1 Corporate Drive, Kingston, NY, 12401, USA

Description of Machinery:

Model numbers **99-1700, 1800, & 3700 series** Offset Nose Assemblies

Relevant provisions complied with:

Council Directive related to Machinery (2006/42/EC)

British Standard related to hand held, non-electric power tools (EN 792-1)

European Representative:

Rob Pattenden, Huck International, Ltd. Unit C Stafford Park 7, Telford Shropshire TF3 3BQ, England, United Kingdom

Authorized Signature/Date:

I, the undersigned, do hereby declare that the equipment specified above conforms to the above Directive(s) and Standard(s).

Signature:



Full Name:

Larry M. Krieg

Position:

Engineering Manager
Installation Systems Division

Place:

Kingston, New York, USA

Date:

November, 2011

HUCK Offset Nose Assemblies alone will not exceed the maximum allowable sound and vibration levels. For more accurate sound and vibration levels, please refer to the Instruction Manual of the HUCK tool on which the Offset Nose Assembly is to be installed.

Test data to support the above information is on file at Alcoa Fastening Systems, Industrial Products Group, Kingston Operations, Kingston, NY, USA.

SAFETY

This instruction manual must be read, with particular attention to the following safety guidelines, by any person servicing or operating this tool.

1. Glossary



— Product complies with requirements set forth by the relevant European directives.



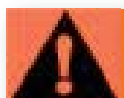
— Read manual prior to using this equipment.



— Eye protection is required while using this equipment.



— Hearing protection is required while using this equipment.



WARNINGS: Must be understood to avoid severe personal injury.



CAUTIONS: show conditions that will damage equipment and or structure.

Notes: are reminders of required procedures.

Bold, Italic type and underlining: emphasizes a specific instruction.

2. A half hour long hands-on training session with qualified personnel is recommended before using Huck equipment.
3. Huck equipment must be maintained in a safe working condition at all times. Tools and hoses should be inspected at the beginning of each shift/day for damage or wear. Any repair should be done by a qualified repairman trained on Huck procedures.
4. Repairman and Operator must read manual prior to using equipment. Warning and Caution stickers/labels supplied with equipment must be understood before connecting equipment to any primary power supply. As applicable, each of the sections in this manual have specific safety and other information.
5. Read MSDS Specifications before servicing the tool. MSDS Specifications are available from the product manufacturer or your Huck representative.
6. When repairing or operating Huck installation equipment, always wear approved eye protection. Where applicable, refer to ANSI Z87.1 - 2003
7. Disconnect primary power source before performing maintenance on Huck equipment or changing Nose Assembly.
8. Tools and hoses should be inspected for leaks at the beginning of each shift/day. If any equipment shows signs of damage, wear, or leakage, do not connect it to the primary power supply.
9. Mounting hardware should be checked at the beginning of each shift/day.
10. Make sure proper power source is used at all times.
11. Release tool trigger if power supply is interrupted.
12. Tools are not to be used in an explosive environment unless specifically designed to do so.
13. Never remove any safety guards or pintail deflectors.
14. Where applicable, ensure deflector or pintail collector is installed and operating prior to use.
15. Never install a fastener in free air. Personal injury from fastener ejecting may occur.
16. Where applicable, always clear spent pintail out of nose assembly before installing the next fastener.
17. There is possibility of forcible ejection of pintails or spent mandrels from front of tool.
18. If there is a pinch point between trigger and work piece, use remote trigger when possible.
19. Unsuitable postures may not allow counteracting of normal expected movement of tool.
20. Do not abuse tool by dropping or using it as a hammer. Never use hydraulic or air lines as a handle or to bend or pry the tool. Reasonable care of installation tools by operators is an important factor in maintaining tool efficiency, eliminating downtime, and in preventing an accident which may cause severe personal injury.
21. Never place hands between nose assembly and work piece. Keep hands clear from front of tool. Never place hands near moving parts.
22. There is a risk of crushing if tool is cycled without Nose Assembly installed.
23. Tools with ejector rods should never be cycled with out nose assembly installed.
24. When two piece lock bolts are being used always make sure the collar orientation is correct. See fastener data sheet of correct positioning.
25. Tool is only to be used as stated in this manual. Any other use is prohibited.
26. There is a risk of whipping compressed air hose if tool is pneumatic or pneumatic.
27. Release the trigger in case of failure of air supply or hydraulic supply.
28. Use only fluids or lubricants recommended.
29. Disposal instruction: Disassemble and recycle steel, aluminum and plastic parts, and drain and dispose of hydraulic fluid in accordance with local lawful and safe practices.
30. If tool is fixed to a suspension device, ensure that the device is secure prior to operating the tool.



NOSE ASSEMBLY INSTRUCTIONS



WARNING: Before performing 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.

1. **PREPARE TOOL PER MANUAL:** Disconnect Powerig's power source. Connect tool's hoses and controls to Powerig. Reconnect power source. Press trigger for 30 seconds; piston stops when completely forward. Disconnect controls and RETURN pressure hose. **Tool piston must remain completely forward.**

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 an arbor press. Press new insert in squarely to prevent cracking.

Collet and Drawbar:

Assemble Collet as shown in the Nose Assembly drawing supplied with the Nose Assembly. Slide Drawbar into Collet. Push crosspin through Collet and Drawbar. With Loctite® on threads, lock Collet to Drawbar with tightly installed socket head screw.

3. **ATTACHING TO TOOL:**

3.1 CROSS PIN STYLE:

While holding front of Collet against back of Anvil, screw assembly onto tool (*Figure 1*), ensuring that all guarding is installed on the Nose Assembly (*Figure 2*).

3.2 FRONT BEARING STYLE:

While holding front of Collet against back of Anvil, screw Anvil onto tool (*Figure 3*). Screw the Drawbar into the tool (*Figure 4*).

If necessary, place Shim p/n 128290 between the Collet and tool Piston (*Figures 5 & 7*). Make sure that all guarding is installed on the Nose Assembly (*Figure 6*).

4. **CHECKING NOSE ASSEMBLY:**

See WARNING. Connect controls and RETURN pressure hose. Reconnect Powerig to power source. Install fasteners in test plate of correct thickness with proper size holes, and inspect fasteners.

NOTE: To extend jaw life, disassemble Nose Assembly periodically and clean and inspect components, using 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.

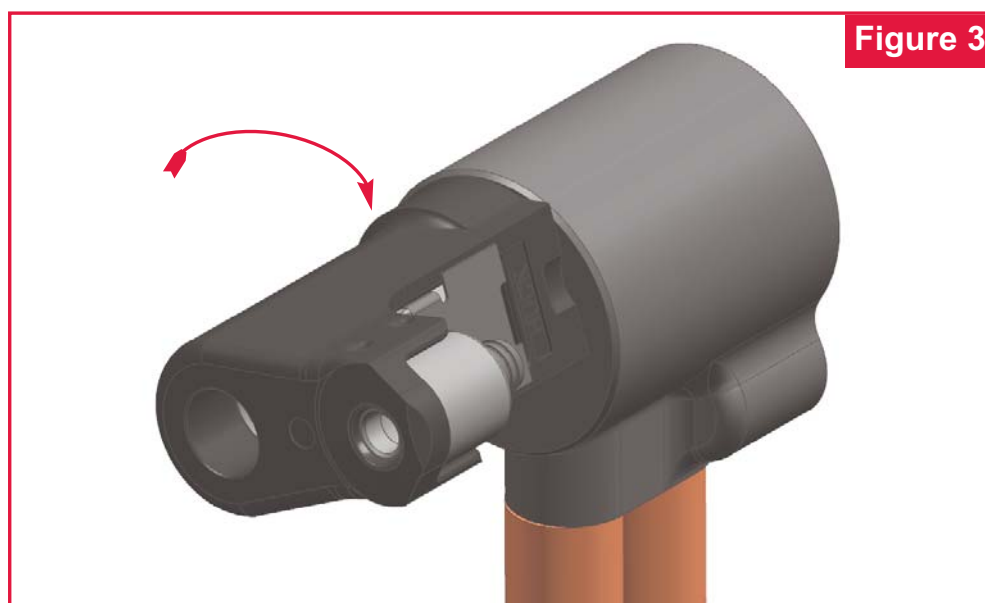
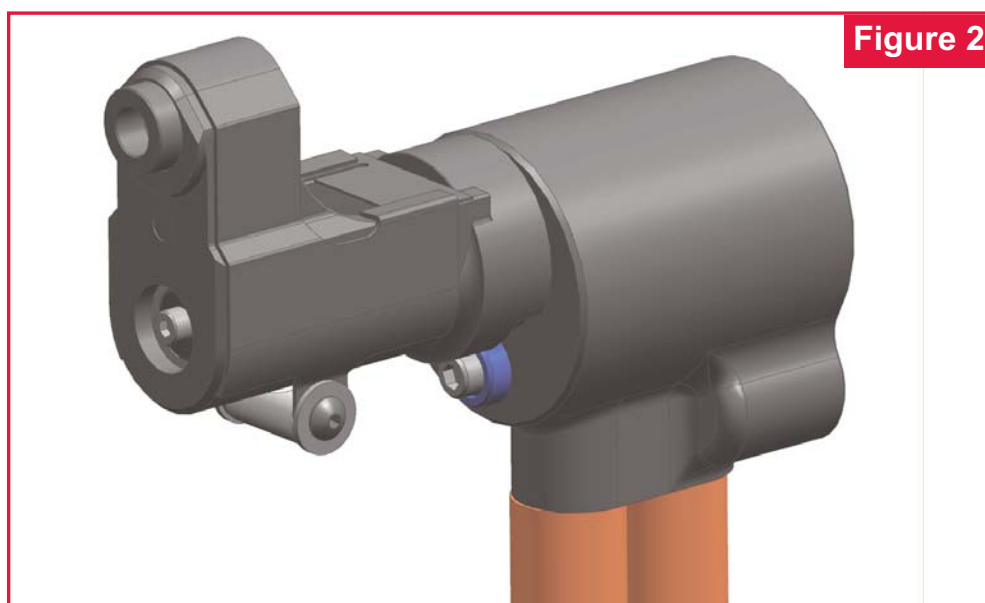
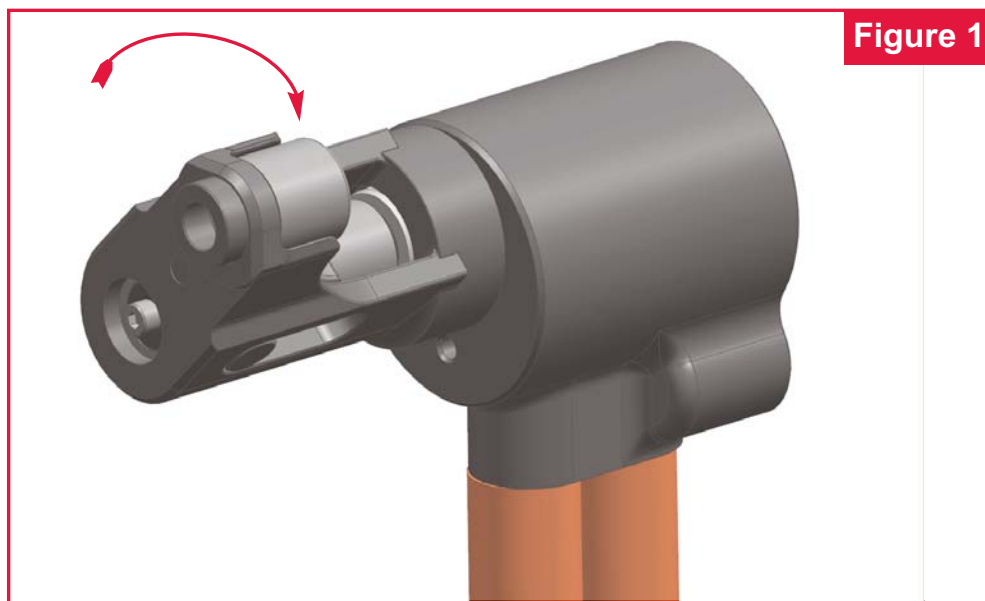


Figure 4

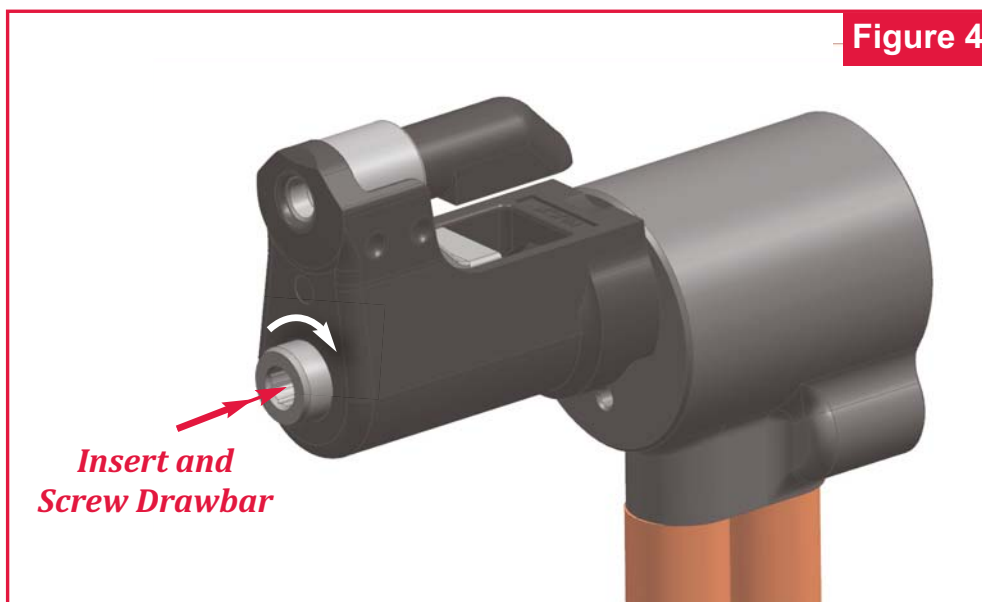


Figure 5

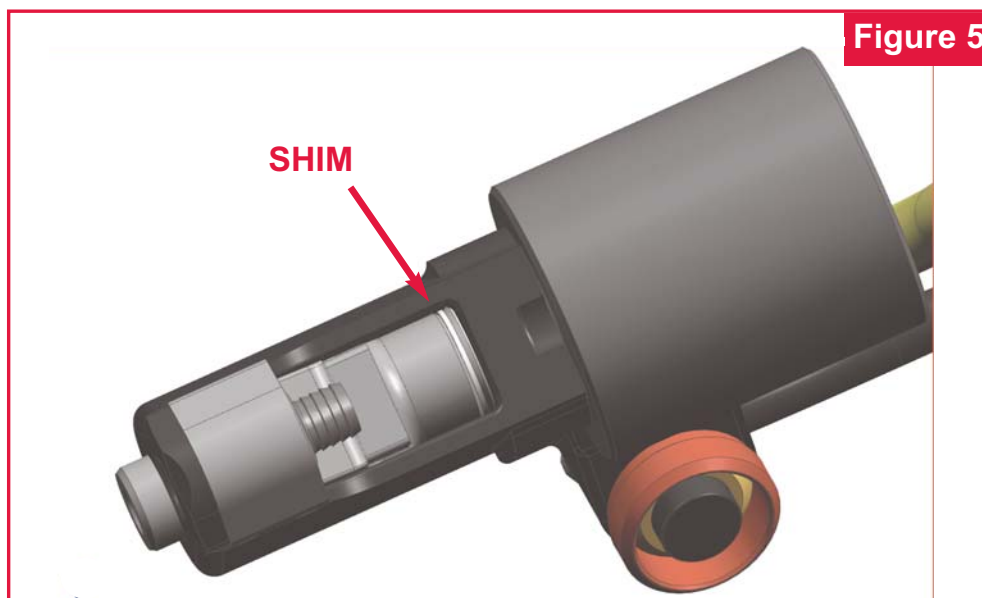


Figure 6

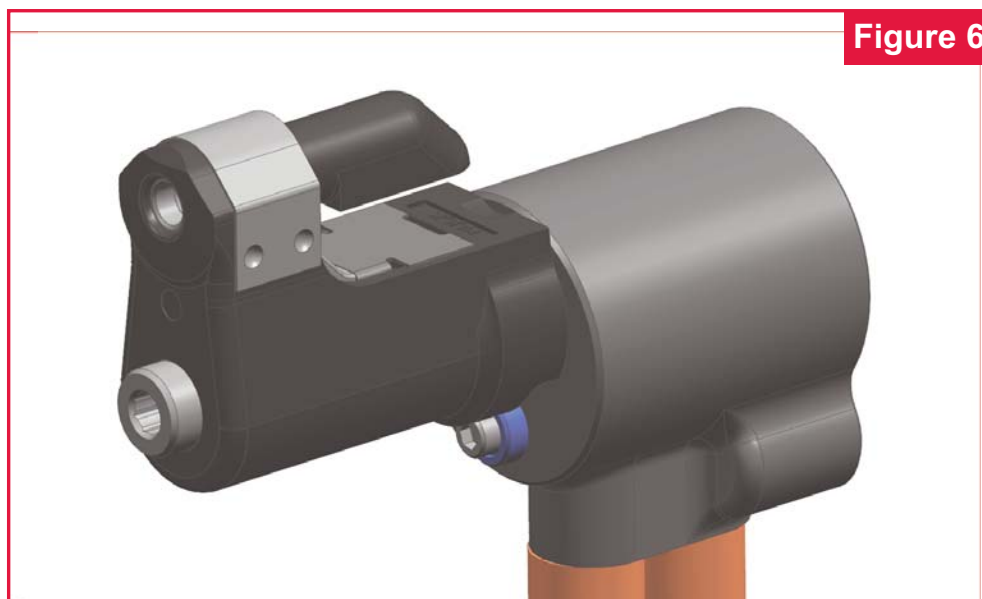
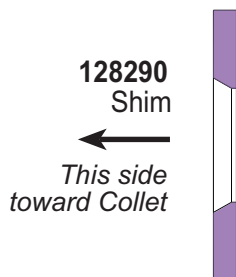
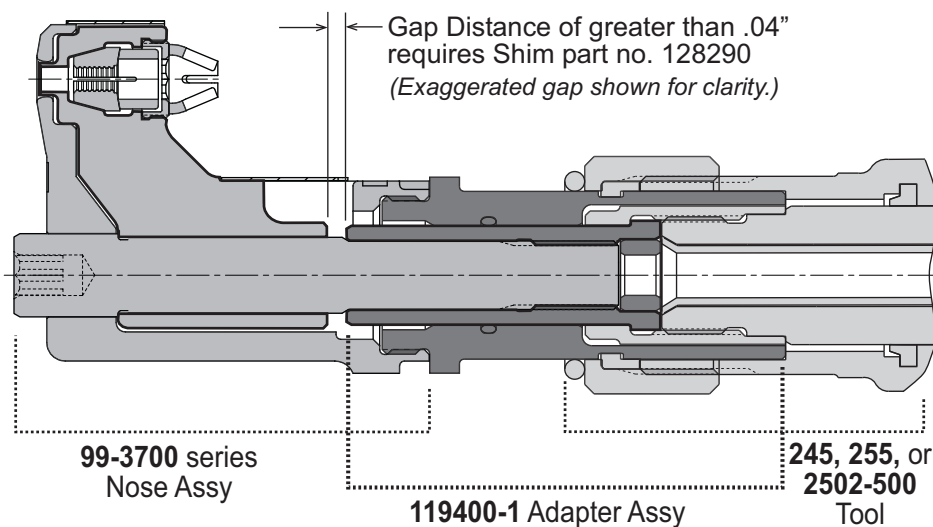


Figure 7

USE OF SHIM WITH 99-3700 SERIES NOSES

Shim part number 128290 is available for 99-3700 series Nose Assemblies when used with 206-375 and 206-500 tools, or when used in combination with Adapter 119400-1 and 245, 255, or 2502-500 Tool which may yield a gap of .04 inches or greater between the back of the Collet and the front of the Drawbar Adapter.

The figure below shows this combination and where to measure the gap. Using this Shim with this Nose-Adapter-Tool combination ensures that ejection will occur properly.



Please Note:

The inner chamfer of the shim MUST face the rear of the Collet.



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Alcoa Fastening Systems (AFS) maintains company offices throughout the United States and Canada, with subsidiary offices in many other countries. Authorized AFS distributors are also

located in many of the world's Industrial and Aerospace centers, where they provide a ready source of AFS fasteners, installation tools, tool parts, and application assistance.

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