



Huck

HUCK FASTENERS INDUSTRIAL DIVISION



The unshakeable world of Huck

Innovation. More than 50 year's ago, the very first Huck fasteners were designed to solve a problem - coping with the extreme stress and vibration of aeroplanes landing on aircraft carriers.

Our product range has evolved and adapted and, today, provides leading-edge solutions in the most demanding applications.

Huck Fasteners are found in very tough engineering situations - in fact, anywhere that fastener failure is not an option.



trucks

trailers

automotive

buses

rail track

rolling stock

containers

heating & ventilation

construction

fencing

racking



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Huck Around The World

Huck Fasteners operates worldwide.

Authorised Huck Fastener distributors are also available in many of the world's industrial centres.

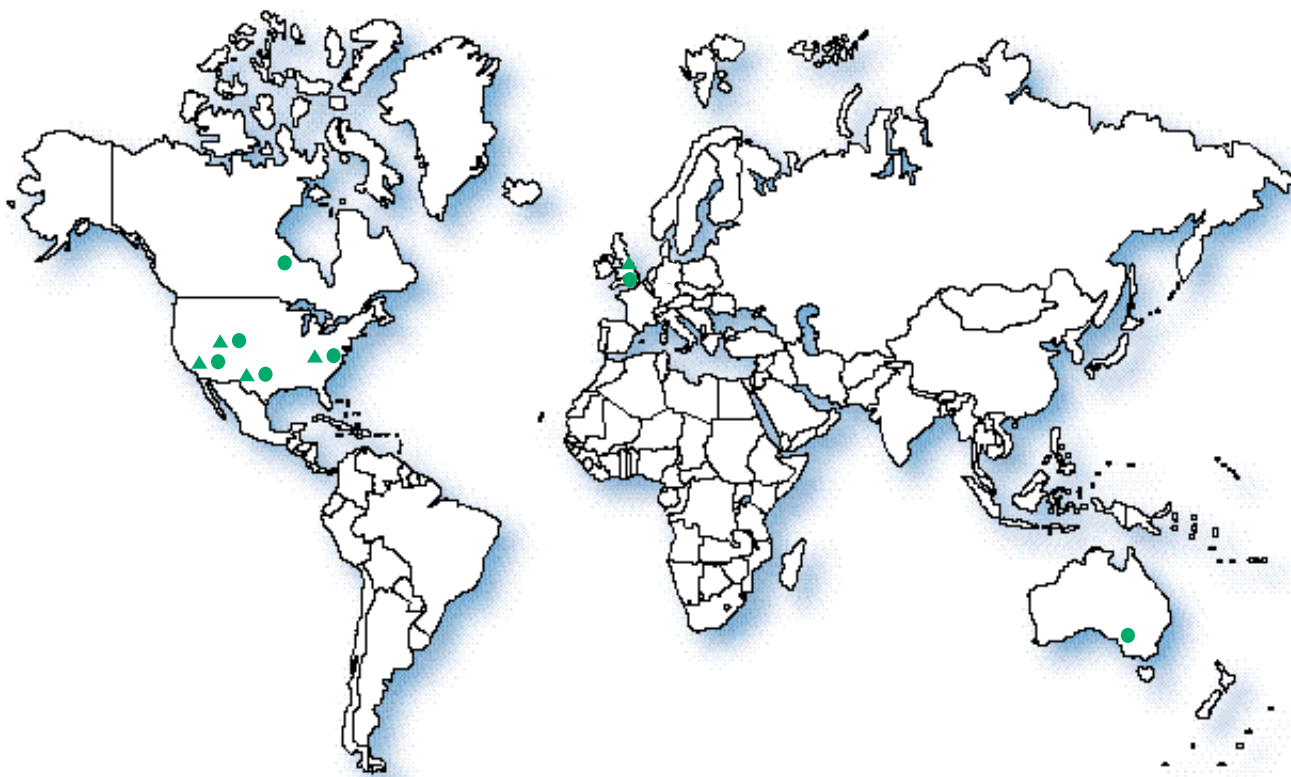
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HUCK COMPANIES EUROPE

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Fax: 01952 290459

▲ Manufacturing
● Service



USA

▲● Huck International, Inc. Aerospace Fasteners Division

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▲● Huck International, Inc. Installation Systems Division

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● Huck International, Inc.

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Fax: 001-905-564-1963

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Rowville, Victoria 3178
Australia
Tel: 0061-39764-5500
Toll Free 008-335-030
Fax: 0061-39764-5510



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		AVAILABLE DIAMETERS																	
		MM	4.8	6.4	7.9	9.5	12	12.7	14	15.9	16	19.1	20	22	22.2	24	25.4	27	28.6
		INCH	3/16	1/4	5/16	3/8	-	1/2	-	5/8	-	3/4	-	-	7/8	-	1	-	1 1/8
		CODE	6	8	10	12	-	16	-	20	-	24	-	-	28	-	32	-	36
LOCKBOLTS	C6L / C120L																		
	MAGNA-GRIP																		
	HUCKTAINER																		
	C50L																		
	MHP																		
	HUCK-FIT																		
	HUCK-SPIN																		
BLIND FASTENERS	MAGNA-LOK																		
	MAGNA-BULB																		
	AUTOBULB																		
	MAGNA-TITE																		
	BOM																		
	FLOORTIGHT																		

 = INCH SERIES

 = METRIC SERIES



Click this button
for contact details

Go to the
next page

Click on installation sequence to view animation

Clicking on the fastener name will take you back to that fastener

Moving the mouse over hyperlinks will cause the cursor to change to a pointing hand or pointing arrow. Clicking on a hyperlink will allow you to go to a related topic.



To magnify areas of the page select the 'zoom tool' situated on the menu bar at the top of the Acrobat Reader window.

Fasteners

Lockbolts

C6L/C120L
Magna-Grip®
Hucktainer®
C50L®
MHP®
Huck-Fit®
Huck-Spin®

Blind Fasteners

Magna-Lok®
Magna-Bulb®
Auto-Bulb®
Magna-Tite®
BOM®
Floortight®

Market Applications

Rail rolling stock
Rail track
Truck & Trailer
Quarrying

Installation Tooling

2025/2025L
LH-224/LH-224B
241E
245
246
255
256
2480/2480L
2503
2580
2600
2620
2624
2628
506
507
Huck-Spin
HPT

Powerigs

HK3413
HK4245
HK432
HP74/HP742
HP116/HP1162
PP275/40

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C6L/C120L® Lockbolt

C6L/C120L® Lockbolt Grade 5.8/8.8

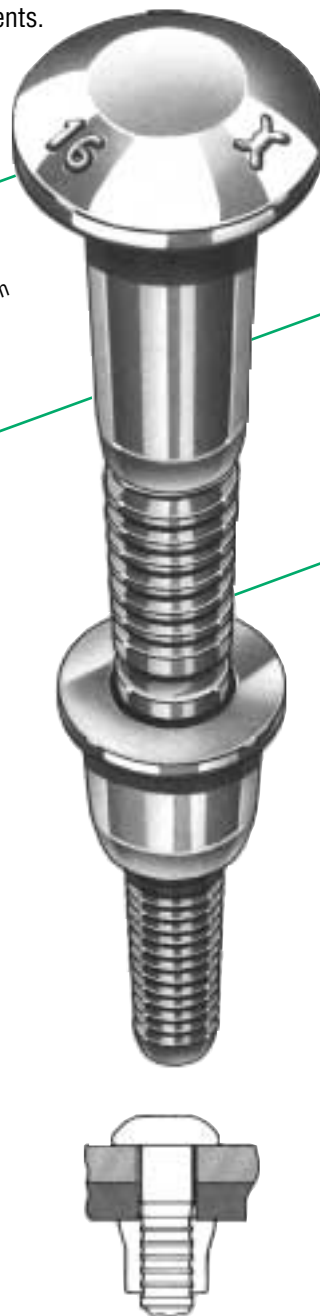
A two piece fastener totally resistant to vibratory loosening, gives high strength and proven performance and reliability. C6L/C120L fasteners are available in diameters 4.8 mm (3/16"), 6.4 mm (1/4"), 7.9 mm (5/16") and 9.5 mm (3/8") with a wide variety of head styles to suit customer requirements. This product is T.I.R. approved.

Vibration Resistant
Provides total resistance to vibratory loosening giving greater reliability in service.

Fast Easy Installation
Fast installed pins and collars result in lower cost assemblies.

Maintenance Free
Vibration resistance, high strength and visual inspection remove the need for expensive re-tightening or replacement.

Versatility
Wide grip range, choice of materials and head style to choose from.



APPLICATIONS

- Buses ■ truck & trailer ■ domestic appliances ■ fencing ■ automotive
- railway rolling stock ■ general sheet metal fabrication
- heating and ventilation ■ agricultural



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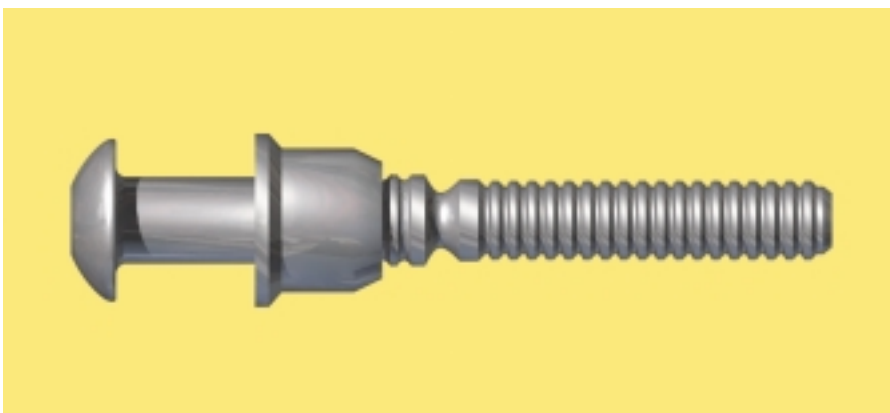
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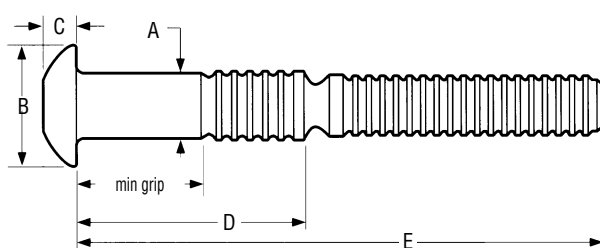
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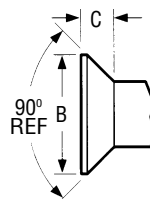
C6L/C120L™ Lockbolt



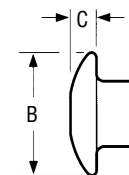
C6LB / C120LB Brazier Head



C6L90 Countersunk Head



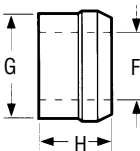
C6LT Truss Head



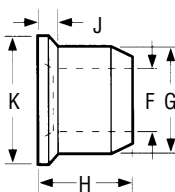
Pin Dimensions

Diameter	Brazier Head (B)			Truss Head (T)		Flush Head (90)	
	A	B	C	B	C	B	C
4.8 mm (3/16")	4.95 - 4.85	10.01 - 9.04	3.18 - 2.87	11.91 - 10.31	2.24 - 1.98	8.99 - 8.33	2.16 - 1.91
6.4 mm (1/4")	6.58 - 6.45	13.34 - 12.07	3.86 - 3.45	15.09 - 13.49	2.92 - 2.62	12.01 - 11.10	2.87 - 2.57
7.9 mm (5/16")	8.18 - 8.05	16.66 - 15.09	5.11 - 4.60	20.24 - 17.86	3.58 - 3.23	14.96 - 13.89	3.58 - 3.23
9.5 mm (3/8")	9.78 - 9.65	19.99 - 18.11	6.30 - 5.66	23.42 - 21.03	4.27 - 3.86	18.01 - 16.66	4.27 - 3.86

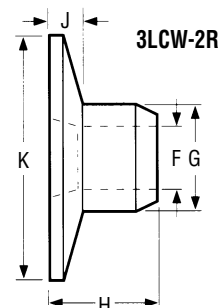
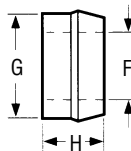
LC/2LC



3LC



8LC



Collar Dimensions

Collar Type	Part Number	Collar Diameter	F Diameter	G Diameter	H Length	J Dimension	K Diameter
Standard	2LC-R, 2LC-F	4.8 mm (3/16")	4.75 - 4.98	7.90 - 7.72	6.30 - 5.54		
	LC-I, 2LC-2CU	6.4 mm (1/4")	6.50 - 6.73	10.39 - 10.21	8.13 - 7.37		
		7.9 mm (5/16")	7.72 - 7.92	12.55 - 12.32	9.65 - 8.89		
		9.5 mm (3/8")	9.53 - 9.78	15.24 - 14.99	11.68 - 10.92		
Flange	3LC-2R, 3LC-F	4.8 mm (3/16")	4.75 - 4.98	7.90 - 7.72	7.11 - 6.35	1.57 - 0.79	9.93 - 9.12
	3LC-I, 3LC-2CU	6.4 mm (1/4")	6.50 - 6.78	10.39 - 10.21	9.63 - 8.86	1.98 - 1.19	13.11 - 12.29
		7.9 mm (5/16")	7.72 - 7.92	12.88 - 12.65	10.82 - 10.01	2.39 - 1.57	16.28 - 15.47
		9.5 mm (3/8")	9.60 - 9.91	15.49 - 15.21	13.51 - 12.75	2.79 - 1.98	19.84 - 18.26
Low Profile	8LC-2R-8LC-F	4.8 mm (3/16")	4.75 - 4.98	7.90 - 7.72	4.11 - 3.35	2.39	
	8LC-I, 8LC-2CU	6.4 mm (1/4")	6.50 - 6.73	10.39 - 10.21	5.13 - 4.37	3.18	
		7.9 mm (5/16")	7.72 - 7.92	12.55 - 12.32	6.48 - 5.72	3.18	
		9.5 mm (3/8")	9.53 - 9.78	15.24 - 14.99	7.70 - 9.47	3.96	
Wide Flange	3LCW-2R6	4.8 mm (3/16")	4.75 - 4.98	7.90 - 7.72	9.30 - 7.65	3.05 - 1.88	19.61 - 16.21
	3LCW-2R8	6.4 mm (1/4")	6.91 - 7.90	10.39 - 10.21	12.19 - 10.41	3.96 - 2.67	25.96 - 21.67

1 When using 3LC or 3LCW-2R collars, add "J" dimension to thickness of material being fastened to determine grip number.

2 When using 8LC collars, subtract "J" dimension from thickness of material being fastened to determine grip number.

3 Use collars and pins together as shown in "Values" tables, or contact Huck.

C6L/C120L® Lockbolt



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C6L/C120L® Lockbolt

Grip¹ Data and Dimensions

Grip No.	Grip Range		4.8mm (3/16") Diameter		6.4mm (1/4") Diameter	
	Min	Max	D $\pm$ 0.8mm 1/32"	E $\pm$ 3.2mm 1/8", -0	D $\pm$ 0.8mm 1/32"	E $\pm$ 3.2mm 1/8", -0
2 ²	1.59	4.76	10.01	34.93	12.32	38.10
3	3.18	6.35	11.61	36.51	13.92	39.69
4	4.76	7.94	13.18	38.10	15.49	41.28
5	6.35	9.53	14.78	39.69	17.09	42.86
6	7.94	11.11	16.36	41.28	18.67	44.45
7	9.53	12.70	17.96	42.86	20.27	46.04
8	11.11	14.29	19.53	44.45	21.84	47.63
9	12.70	15.88	21.13	46.04	23.44	49.21
10	14.29	17.46	22.71	47.63	25.02	50.80
11	15.88	19.05	24.31	49.21	26.62	52.39
12	17.46	20.64	25.88	50.80	28.19	53.98
13	19.05	22.23	27.48	52.39	29.79	55.56
14	20.64	23.81	29.06	53.98	31.37	57.15
15	22.23	25.40	30.66	55.56	32.97	58.74
16	23.81	26.99	32.23	57.15	34.54	60.33
17	25.40	28.58	33.83	58.74	36.14	61.91
18	26.99	30.16	35.41	60.33	37.03	63.50
19	28.58	31.75	37.01	61.91	39.32	65.09
20	30.16	33.34	38.58	63.50	40.89	66.68
21	31.75	34.93	40.18	65.09	42.49	68.26
22	33.34	36.51	41.76	66.68	44.07	69.85
23	34.93	38.10	43.36	68.26	45.67	71.44
24	36.51	39.69	44.93	69.85	47.24	73.03
25	38.10	41.28	46.53	71.44	48.84	74.61
26	39.69	42.86	48.11	73.03	50.42	76.20
27	41.28	44.45	49.71	74.61	52.02	77.79
28	42.86	46.04	51.28	76.20	53.39	79.38
29	44.45	47.63	52.88	77.79	55.19	80.96
30	46.04	49.21	54.46	79.38	56.77	82.55
31	47.63	50.80	56.06	80.96	58.37	84.14
32	49.21	52.39	57.63	82.55	59.94	85.73

¹ "Grip" is actual thickness of material to be fastened - contact Huck for grips not shown.

² C6L90 is not available in grip 2 for 4.8mm (3/16") and 6.4mm (1/4") diameters and grip 4 for 9.5mm (3/8") diameter.

Grip No.	Grip Range		7.9mm (5/16") Diameter		9.5mm (3/8") Diameter	
	Min	Max	D $\pm$ 0.8mm 1/32"	E $\pm$ 3.2mm 1/8", -0	D $\pm$ 0.8mm 1/32"	E $\pm$ 3.2mm 1/8", -0
4 ²	3.18	9.53	19.02	48.42	20.55	53.98
6	6.35	12.70	22.20	51.59	23.72	57.15
8	9.53	15.88	25.37	54.77	26.90	60.33
10	12.70	19.05	28.55	57.94	30.07	63.50
12	15.88	22.23	31.72	61.12	33.25	66.68
14	19.05	25.40	34.90	64.29	36.42	69.85
16	22.23	28.58	38.07	67.47	39.60	73.03
18	25.40	31.75	41.25	70.64	42.77	76.20
20	28.58	34.93	44.42	73.82	45.95	79.38
22	31.75	38.10	47.60	76.99	49.12	82.55
24	34.93	41.28	50.77	80.17	52.30	85.73
26	38.10	44.45	53.95	83.34	55.47	88.90
28	41.28	47.63	57.12	86.52	58.65	92.08
30	44.45	50.80	60.30	89.69	61.82	95.25
32	47.63	53.98	63.48	92.87	65.00	98.43

C6L LOCKBOLT Fastener Values¹ - Grade 5.8

Dia.	Carbon Steel (R) Pins 2LC-R or 3LC-2R Collars			2024 Aluminium (C) Pins 2LC-F or 3LC-F Collars			6061 Aluminium (F) Pins LC-I or 3LC-I Collars			CRES (U) Pins 2LC-2CU or 3LC-2CU Collars		
	Shear	Clamp	Tensile	Shear	Clamp	Tensile	Shear	Clamp	Tensile	Shear	Clamp	Tensile
4.8 mm (3/16")	7670	4560	7340	4670	2450	4450	3450	1560	2360	8900	4560	6470
6.4 mm (1/4")	13570	8030	13340	8340	4230	8010	6120	2760	4340	15790	8030	16680
7.9 mm (5/16")	21020	12500	20460	13010	6670	12680	9450	4290	6890	24580	12500	18900
9.5 mm (3/8")	30360	17880	28910	18680	9790	18680	13570	6140	10680	35360	17880	27130

C120L LOCKBOLT Fastener Values¹ - Grade 8.8

Dia	Carbon Steel (R) Pins 2LC120-R or 3LC120-2R Collars		
	Shear	Clamp	Tensile
4.8 mm (3/16")	10810	5340	9790
6.4 mm (1/4")	19310	10230	16460
7.9 mm (5/16")	29800	18680	26690
9.5 mm (3/8")	42700	26600	41370

¹ Minimum Value, in N, of installed fasteners. Meets requirements of MIL-P-23469 except in 2024 Aluminium (C) - Plated pins may result in reduced tensile values up to 15%.

Hole Preparation Data

Diameter	Clearance Fit Diameter Maximum	Interference Fit Diameter Minimum	Maximum
4.8 mm (3/16")	5.16	4.75	4.85
6.4 mm (1/4")	6.75	6.35	6.45
7.9 mm (5/16")	8.33	7.92	8.05
9.5 mm (3/8")	9.92	9.53	9.65

Materials and Finishes

	Material	Finish
Pin	Carbon Steel (R)	None (Plain Black)
	2024 Aluminium Alloy (C)	Anodize per MIL-A-8625 / chemical surface treatment MIL-C-5541 (Manufacturer's option)
	6061 Aluminium Alloy (F)	None
	Stainless Steel (U)	None
Collar	Low Carbon Steel (R) or (2R)	Zinc plated, Wax Film Lubricated
	5062 Aluminium Alloy - Heat treated (F)	None, Wax Film Lubricated
	6061 Aluminium Alloy (I)	None, Wax Film Lubricated
	Stainless Steel (U)	None, Wax Film Lubricated



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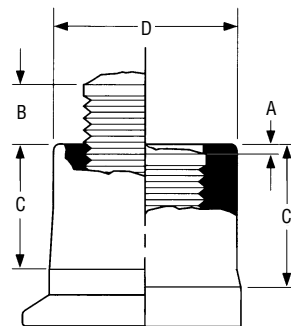
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C6L/C120L® Lockbolt

Inspection Data

A properly installed HUCKBOLT Fastener will possess the dimensional characteristics shown in the chart. Should the dimensions "A" or "B" exceed the indicated values, the fastener is being used out-of-grip. A "C" dimension less than the values specified is an indication of incomplete swage. A "D" dimension exceeding the specified values is an indication of an incorrect or worn anvil on the installation tool.

Because of design margin built into the fastener and peculiar field installation conditions, failure of an installed fastener to meet the specified dimensional criteria is not necessarily an indication of an improperly installed assembly. Conversely, a Huckbolt pin installed in a properly prepared hole with the recommended single cycle driving tool, which swages the lock collar material into the locking grooves of the pin and breaks off the pintail at the breakneck groove, will always possess at least the minimum guaranteed strength characteristics when the dimensional limits specified are met.



Nominal Size	3LC flanged collars		2LC no flange on collar	
	A Max grip	B Min Grip	C Min	D Dia Max
4.8 mm (3/16")	1.98	3.18	4.37	7.01
6.4 mm (1/4")	1.98	3.97	6.35	9.25
7.9 mm (5/16")	1.98	7.14	7.14	11.53
9.5 mm (3/8")	3.18	7.14	8.73	14.02

C120L LOCKBOLT Pins

Follow the form below to construct a part number for ordering C120L pins. Refer to the Grip Data Chart for grip numbers.

C120L (STYLE) - (MATERIAL) (DIAMETER) - (GRIP NUMBER) (FINISH)

Example: **C120LT-R8-4G** is a C120L Huckbolt Pin, Truss Head, Carbon Steel, 1/4" Diameter, Grip 4, Zinc Finish

Style		Material		Diameter		Finish	
Truss Head	T	Carbon Steel	R	4.76 mm (3/16")	6	Zinc Clear Chromate	G
Brazier Head	B			6.35 mm (1/4")	8		
Countersunk Head	90			7.94 mm (5/16")	10		
				9.53 mm (3/8")	12		

C6L LOCKBOLT Pins

Follow the form below to construct a part number for ordering C6L pins. Refer to the Grip Data Chart for grip numbers.

C6L (STYLE) - (MATERIAL) (DIAMETER) - (GRIP NUMBER) (FINISH)

Example: **C6LT-R8-4G** is a C6L Huckbolt Pin, Truss Head, Carbon Steel, 6.4mm Diameter, Grip 4, Zinc Finish.

Style		Material		Diameter		Finish	
Truss Head	T	Carbon Steel	R	4.76 mm (3/16")	6	Zinc Clear Chromate	G
Brazier Head	B	2024 Alum Alloy	C	6.35 mm (1/4")	8		
Countersunk Head	90	6061 Alum Alloy	F	7.94 mm (5/16")	10		
		Stainless Steel	U	9.53 mm (3/8")	12		

C120L LOCKBOLT Collars

Follow the form below to construct a part number for ordering C120L collars.

(TYPE) LC120 - (MATERIAL) (DIAMETER) (FINISH)

Example: **2LC120-R8G** is a Standard C120L Huckbolt Collar, Low Carbon Steel, 6.4mm Diameter, Zinc Finish.

Type		Material		Diameter		Finish	
Standard	2	Low Carbon Steel(standard collar)	R	4.8 mm (3/16")	6	Zinc Clear Chromate	G
Flange	3	Low Carbon Steel(flanged collar)	2R	6.4 mm (1/4")	8		
				7.9 mm (5/16")	10		
				9.5 mm (3/8")	12		

C6L LOCKBOLT Collars

Follow the form below to construct a part number for ordering C6L collars.

(TYPE) LC - (MATERIAL) (DIAMETER) (FINISH)

Example: **2LC-R8G** is a Standard C60L Huckbolt Collar, Low Carbon Steel, 6.4mm Diameter, Zinc Finish.

Type		Material		Diameter		Finish	
Standard	2	Low Carbon Steel(standard collar)	R	4.8 mm (3/16")	6	Zinc Clear Chromate	G
Flange	3	Low Carbon Steel(flanged collar)	2R	6.4 mm (1/4")	8		
		6061 Alum Alloy Heat Treated	F	7.9 mm (5/16")	10		
		6061 Alum Alloy	I	9.5 mm (3/8")	12		
		Stainless Steel	CU				



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Installation Tooling

C6L/120™ Installation Tooling

Huck Installation Tools

Huck installation tools consist of a nose assembly and a tool. The choice of tool and nose assembly is determined by the fastener diameter and application. Tools and nose assemblies are easily changed as installation requirements demand,

Huck offers pneumatic and hydraulic installation tools. Pneumatic tools operate on 6.2-6.9 bar (90-100 psi) air pressure. The lighter weight hydraulic tools operate on hydraulic power supplied by a Huck POWERIG® Hydraulic Unit.

FIG 1

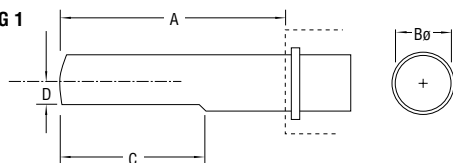
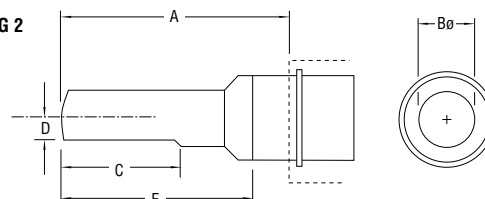


FIG 2



Code	Diameter	Nose Ass.	Fig.	A mm	B mm	C mm	D mm	E mm	Pneumatic Tooling	Hydraulic Tooling
6	4.8 mm (3/16")	99-2558 ³	2	58.3	17.9	43.8	8.0	43.8	245 / 246 / 255 / 256	2503 / 2580
		99-3003 ²	1	48.7	19.1	-	-	-	2025 / 2025V / LH-224	2480
		99-3003L ²	1	48.7	19.1	-	-	-	2025L	2480L
		99-3004 ²	1	150.3	19.1	-	-	-	2025 / 2025V / LH-224	2480
8	6.4 mm (1/4")	99-2564 ³	2	58.1	19.3	43.6	8.6	43.6	245 / 246 / 255 / 256	2503 / 2580
		99-3006 ²	1	50.1	19.1	-	-	-	2025 / 2025V / LH-224	2480
		99-3006L ²	1	50.1	19.1	-	-	-	2025L	2480L
		99-3007 ²	1	152.6	19.1	-	-	-	2025 / 2025V / LH-224	2480
10	7.9 mm (5/16")	99-99-245 ⁵	1	70.7	26.9	53.3	12.2	-	245 / 246 / 255 / 256	2503 / 2580
12	9.5 mm (3/8")	99-100-245 ⁴	1	69.8	26.9	53.3	12.2	-	245 / 246 / 255 / 256	2503 / 2580

Items in **bold** are part of our FOCUS Tooling Range

Note: Other tool and nose assembly combinations may be available for specific applications. Please contact Huck for details.

1 Self releasing, rotatable.

2 Non-self releasing, self ejecting Anvil. Cannot be used to install C120L fasteners or 8LC Collars.

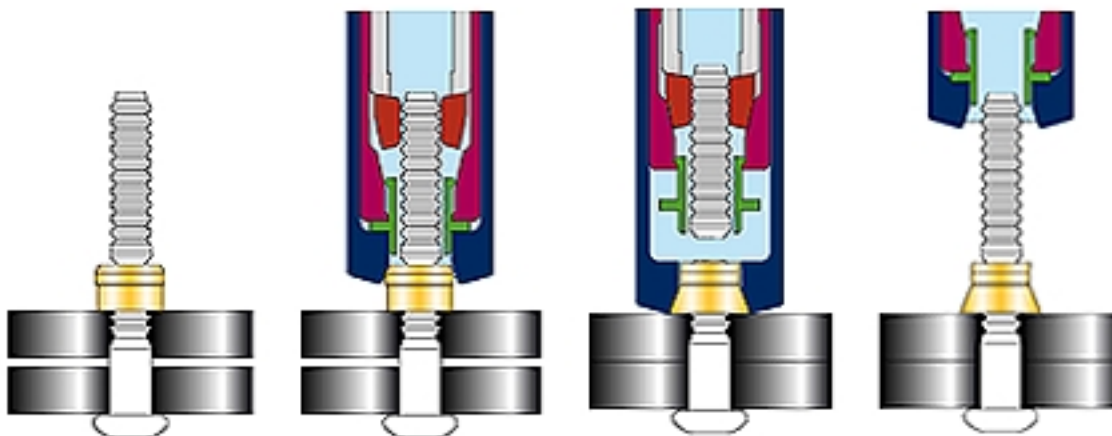
3 Non-self releasing, rotatable.

4 Non-self releasing.

5 Non-self releasing, heavy duty.

6 C6L aluminium and C6L carbon steel pins and collars only.

Installation Sequence



[Click Here to view animation of installation sequence](#)



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Magna-Grip® Lockbolt

Magna-Grip® Lockbolt

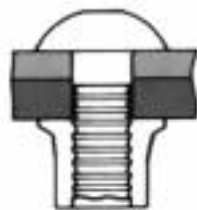
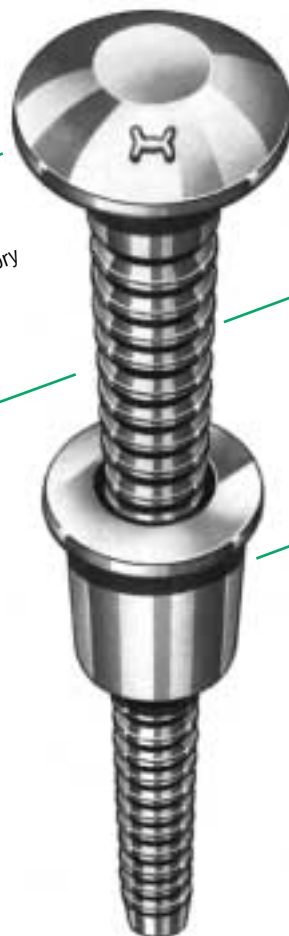
A unique two piece fastener, with a wide grip range and high resistance to vibratory loosening, that breaks flush with the collar every time. Available in diameters from 3/16" (4.8mm) - 3/4" (19.1mm) with a wide variety of head styles and finishes.

Wide Grip and Diameter range Available
High cost savings due to lower inventory part no's and stock levels.

Swaged Collar/Lock Groove Design
Ensures consistent uniform results with vibration resistance.

Fast Easy Installation
Reduces error and rework. Increased productivity without skilled labour.

Visual Inspection
No need to x-ray welds, or check torque. Saves time and cost.



APPLICATIONS

- Sheet Metal Fabrication ■ Trucks and Trailers ■ Buses
- Mining Equipment ■ Railcars and Waggon's ■ Containers
- Heating Ventilation and Air Conditioning ■ Electrical Equipment



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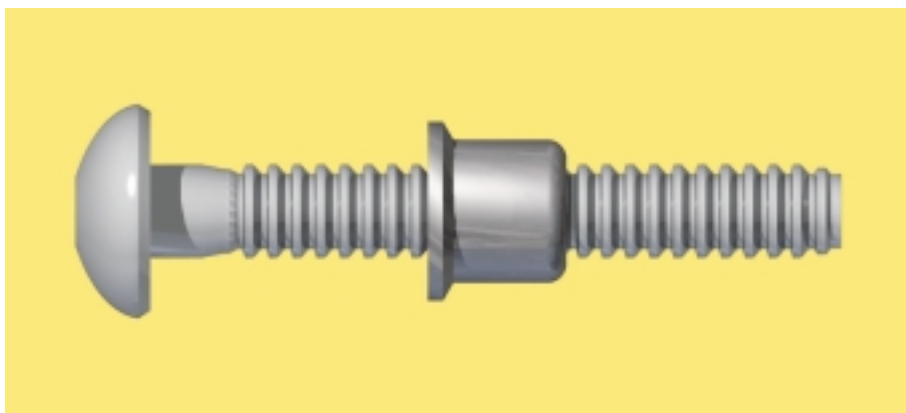
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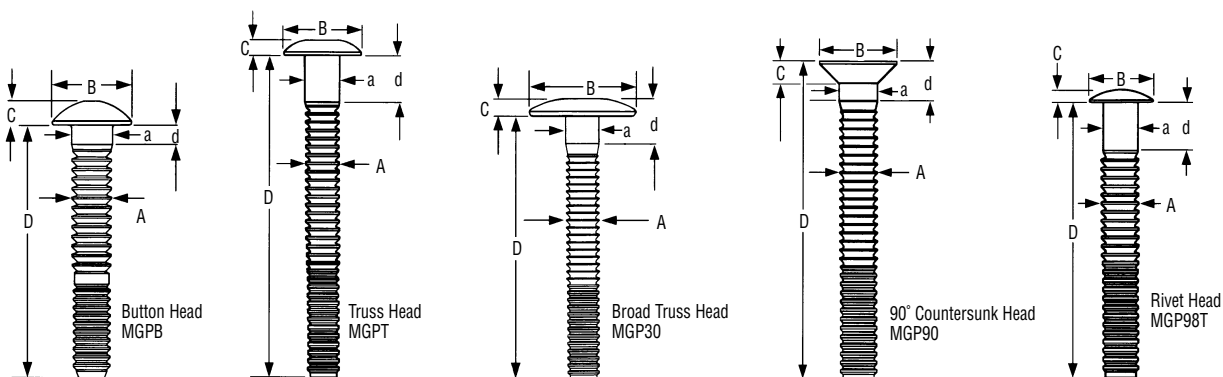
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Magna-Grip® Lockbolt 4.8 - 9.5mm



MAGNA-GRIP® Lockbolt 4.8 mm (3/16"), 6.4 mm (1/4"), 7.9 mm (5/16"), 9.5 mm (3/8") Diameters



Button Head - MGPB

Nom. Dia.	Grip No.	Grip Range Min	Grip Range Max	Max Hole Dia	Fastener Dimension A	B	C	D [*]	a Ref	d Ref	Minimum Installed Values (N)				Tensile Steel		Alum
4.8 mm (3/16")	10	1.57	15.88	5.16	4.65-4.75	9.04-10.01	2.87-3.18	45.42	4.85-4.95	2.62-3.18	4110	2450	7670	3340	6230	4000	
	20	7.92	31.75	5.16	4.65-4.75	9.04-10.01	2.87-3.18	60.20	4.85-4.95	7.72-8.13	4110	2450	7670	3340	6230	4000	
6.4 mm (1/4")	10	1.57	15.88	6.73	6.22-6.32	12.07-13.34	3.45-3.86	49.91	6.35-6.58	2.77-3.58	5340	4230	9790	5340	11340	7210	
	20	7.92	31.75	6.73	6.22-6.32	12.07-13.34	3.45-3.86	65.02	6.35-6.58	7.49-8.36	5340	4230	9790	5340	11340	7210	
7.9 mm (5/16")	12	3.18	19.05	8.33	7.80-7.90	15.09-16.66	4.60-5.11	59.44	6.96-7.19	6.38-Max	9560	7120	13340	9790	17390	11120	
	22	15.88	34.93	8.33	7.80-7.90	15.09-16.66	4.60-5.11	72.14	8.05-8.18	14.20-15.01	9560	7120	13340	9790	17390	11120	
9.5 mm (3/8")	14	3.18	22.23	9.91	9.37-9.53	18.11-19.99	5.66-6.30	73.03	9.65-9.78	4.37-5.18	14230	10680	18680	13340	25020	17790	
	26	20.62	41.28	9.91	9.37-9.53	18.11-19.99	5.66-6.30	88.90	9.65-9.78	20.17-20.98	14230	10680	18680	13340	25020	17790	

Truss Head - MGPT

6.4 mm (1/4")	10	1.57	15.88	6.73	6.22-6.32	13.49-15.09	2.62-2.92	49.91	6.35-6.58	2.77-3.58	5340	4230	9790	5340	11340	7210	
	20	7.92	31.75	6.73	6.22-6.32	13.49-15.09	2.62-2.92	65.02	6.35-6.58	7.49-8.36	5340	4230	9790	5340	11340	7210	
7.9 mm (5/16")	12	3.18	19.05	8.33	7.80-7.90	17.86-20.24	3.23-3.58	59.44	6.96-7.19	6.99-7.11	9560	7120	13340	9790	17390	11120	
	22	15.88	34.93	8.33	7.80-7.90	15.09-16.66	3.23-3.58	72.14	8.05-8.18	13.54-14.40	9560	7120	13340	9790	17390	11120	
9.5 mm (3/8")	14	3.18	22.23	9.91	9.37-9.53	21.03-23.42	3.86-4.27	73.03	9.65-9.78	4.37-5.18	14230	10680	18680	13340	25020	17790	
	26	20.62	41.28	9.91	9.37-9.53	18.11-19.99	3.86-4.27	88.90	9.65-9.78	20.17-20.98	14230	10680	18680	13340	25020	17790	

Broad Truss Head - MGP30

6.4 mm (1/4")	10	3.96	15.88	6.73	6.22-6.32	*	3.51-4.11	49.91	6.35-6.58	2.77-3.58	5340	4230	9790	5340	11340	7210	
	24	15.88	38.10	6.73	6.22-6.32	*	3.51-4.11	71.37	6.35-6.58	13.87-14.68	5340	4230	9790	5340	11340	7210	
9.5 mm (3/8")	24	15.88	38.10	9.91	9.37-9.53	30.18-31.75	4.78-5.38	85.73	9.65-9.78	16.87-17.68	14230	10680	18680	13340	25020	17790	
	32	28.58	50.80	9.91	9.37-9.53	30.18-31.75	4.78-5.38	85.73	9.65-9.78	29.57-30.38	14230	10680	18680	13340	25020	17790	

90° Countersunk Head - MGP90

4.8 mm (3/16")	10	1.57	15.88	5.16	4.65-4.75	8.20-9.12	2.34-2.59	45.42	4.85-4.95	8.94-Max.	4110	2450	7670	3340	6230	4000	
	20	7.92	31.75	5.16	4.65-4.75	8.20-9.12	2.34-2.59	60.20	4.85-4.95	7.49-8.36	4110	2450	7670	3340	6230	4000	
6.4 mm (1/4")	10	1.57	15.88	6.73	6.22-6.32	11.00-12.14	3.02-3.25	49.91	5.51-5.74	9.60-Max.	5340	4230	9790	5340	11340	7210	
	20	7.92	31.75	6.73	6.22-6.32	11.00-12.14	3.02-3.25	65.02	6.35-6.58	7.49-8.36	5340	4230	9790	5340	11340	7210	
7.9 mm (5/16")	12	3.18	19.05	8.33	7.80-7.90	13.77-15.09	3.28-3.61	59.44	6.99-7.11	10.46-Max	9560	7120	13340	9790	17390	11120	
	22	15.88	34.93	8.33	7.80-7.90	13.77-15.09	3.28-3.61	72.14	8.05-8.18	14.20-15.01	9560	7120	13340	9790	17390	11120	
9.5 mm (3/8")	14	6.35	22.23	9.91	9.37-9.53	16.54-18.14	4.52-4.95	73.03	8.56-8.69	11.25-Max	14230	10680	18680	13340	25020	17790	
	26	20.62	41.28	9.91	9.37-9.53	16.54-18.14	4.52-4.95	88.90	9.65-9.78	20.14-21.01	14230	10680	18680	13340	25020	17790	

Rivet Head - MGP98T

4.8 mm (3/16")	10	1.57	15.88	5.16	4.65-4.75	11.43-12.40	2.31-2.67	45.42	4.85-4.95	1.98-2.44	4110	2450	7670	3340	6230	4000	
	20	7.92	31.75	5.16	4.65-4.75	11.43-12.40	2.31-2.67	60.20	4.85-4.95	7.70-8.15	4110	2450	7670	3340	6230	4000	

* Steel 23.8 Aluminium 27.0

Magna-Grip® Lockbolt



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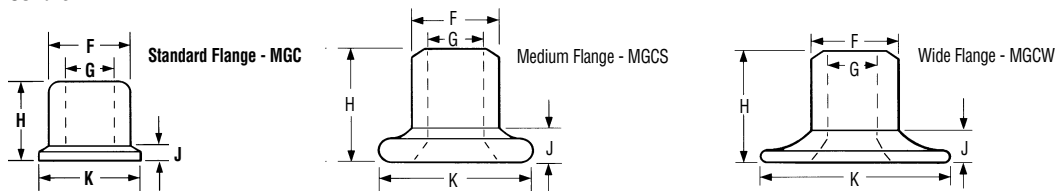
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Magna-Grip® Lockbolt

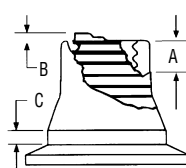
Collars



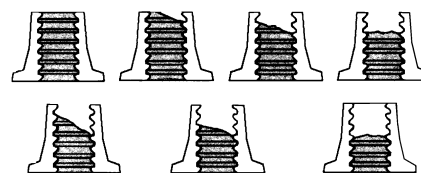
Collar Dimensions

Collar	Diameter	F	G	H	J	K
MGC	4.76 mm (3/16")	7.85-7.92	4.83-4.93	6.86-7.11	1.07-1.27	9.35-9.70
	6.35 mm (1/4")	10.24-10.31	6.40-6.48	9.40-9.65	1.45-1.70	12.45-12.95
	7.94 mm (5/16")	12.78-12.88	7.98-8.08	10.97-11.28	1.80-2.13	15.54-16.18
	9.53 mm (3/8")	15.37-15.47	9.60-9.70	12.70-12.95	2.24-2.49	18.80-19.30
MGCS	4.76 mm (3/16")	7.82-8.00	4.80-4.95	7.37-8.13	2.16-2.79	12.70-13.46
MGCW	4.76 mm (3/16")	7.80-7.98	4.67-5.00	7.82-9.09	1.98-2.97	16.26-19.38
	6.35 mm (1/4")	10.24-10.41	6.40-6.48	10.97-11.73	2.92-3.68	21.72-25.40

Inspection Data



Nom. Dia.	A (max)	B (max)	C (max)
4.8 mm (3/16")	1.6 mm (1/16")	0.8 mm (1/32")	1.27 mm (1/2")
6.4 mm (1/4")	3.2 mm (1/8")	0.8 mm (1/32")	2.54 mm (1")
7.9 mm (5/16")	4.8 mm (3/16")	3.6 mm (9/64")	2.54 mm (1")
9.5 mm (3/8")	6.4 mm (1/4")	4.4 mm (11/64")	2.54 mm (1")



Acceptable Fractures - Substantially flush with end of collar up to maximum of two lock witness marks within collar.
Unacceptable Fractures - Three witness marks within collar.

How to Order

Magna-Grip Pins Follow the form below to construct a part number for ordering Magna-Grip pins. Refer to the grip data chart.

MGP (HEAD STYLE) - (MATERIAL) (DIAMETER) - (GRIP RANGE) (FINISH)

Example: **MGPB-R6-10** is a Magna-Grip Button Head Pin, Carbon Steel, 4.8mm (3/16") Diameter, Grip Range .062"-.625", No Finish.

Pin	Head Style	Material	Diameter	Grip	Finish
Magna-Grip	Button	Carbon Steel	4.8mm (3/16")	6	Zinc Clear Chromate
Pin	Truss	7075-T6 Alum.	6.4mm (1/4")	8	No Plate
	Broad Truss		7.9mm (5/16")	10	
	90° Countersunk		9.5mm (3/8")	12	
	Rivet				

Magna-Grip Collars Follow the form below to construct a part number for ordering collars for Magna-Grip pins.

MG (BASE STYLE) - (MATERIAL) (DIAMETER) (FINISH) (OPTIONS)

Example: **MGC-F12GL** is a Standard Flange, Aluminium, 9.5mm (3/8") Diameter, Zinc Chromate Colourless Finish, Tab-Lok Option.

Pin	Head Style	Material	Diameter	Finish	Options
Magna-Grip	Standard Flange	Carbon Steel	4.8mm (3/16")	Zinc Chrom., Gold	Tab-Lok
Collar	Medium Flange	6061 Alum.	6.4mm (1/4")	Zinc Chrom.,	
	Wide Flange		7.9mm (5/16")	Clear	
	No Flange		9.5mm (3/8")		



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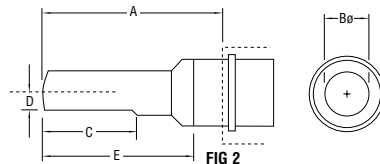
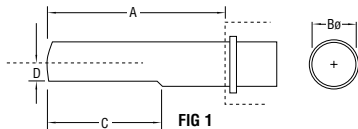
Installation Tooling

Magna-Grip® 4.8, 6.4, 7.9, 9.5mm Installation Tooling

Huck Installation Tools

Huck installation tools consist of a nose assembly and a tool. The choice of tool and nose assembly is determined by the fastener diameter and application. Tools and nose assemblies are easily changed as installation requirements demand.

Huck offers pneumatic and hydraulic installation tools. Pneumatic tools operate on 6.2-6.9 bar (90-100 psi) air pressure. The lighter weight hydraulic tools operate on hydraulic power supplied by a Huck POWERIG®, Hydraulic Unit.

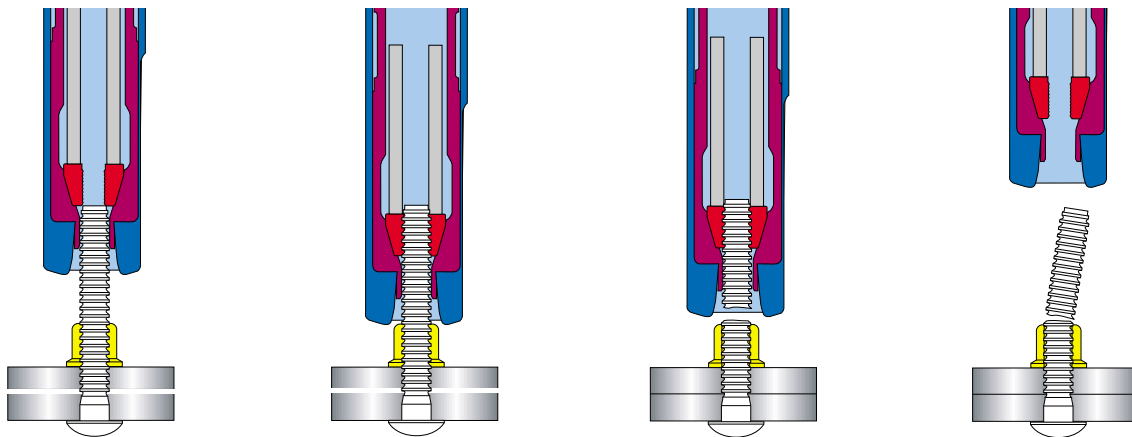


Code	Diameter	Nose Ass.	Fig.	A mm	B mm	C mm	D mm	E mm	Pneumatic Tooling	Hydraulic Tooling
6	4.8 mm (3/16")	99-3200	1	21.6	19.1	-	-	-	2025 / 2025V / LH-224	2480
		99-1456	1	48.7	18.8	-	-	-	2025 / 2025V / LH-224	2480
		99-1456L	1	48.7	18.8	-	-	-	2025L	2480L
		99-3202	1	150.3	19.1	-	-	-	2025 / 2025V / LH-224	2480
		99-3206	2	91.0	19.1	-	-	74.2	245 / 246 / 255 / 256	2503 / 2580
8	6.4 mm (1/4")	99-3203	1	26.7	19.1	-	-	-	2025 / 2025V / LH-224	2480
		99-1458	1	50.1	19.1	-	-	-	2025 / 2025V / LH-224	2480
		99-1458L	1	50.1	19.1	-	-	-	2025L	2480L
		99-3205	1	152.6	19.1	-	-	-	2025 / 2025V / LH-224	2480
		99-3207	2	92.5	18.8	-	-	78.9	245 / 246 / 255 / 256	2503 / 2580
10	7.9 mm (5/16")	99-1439	1	71.1	27.9	50.8	12.5	-	245 / 246 / 255 / 256	2503 / 2580
12	9.5 mm (3/8")	99-1440	1	72.9	27.7	50.8	12.7	-	245 / 256	2503 / 2580

Items in **bold** are part of our FOCUS Tooling Range

Note: Other tool and nose assembly combinations may be available for specific applications. Please contact Huck for details.

Installation Sequence



[Click Here to view animation of installation sequence](#)



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Hucktainer® Lockbolt

Hucktainer® Lockbolt

A fastener specifically designed for the commercial vehicle body building industry where G.R.P. (glass reinforced plastic) boards are used. This fastener covers a wide grip range, is T.I.R. approved, gives improved security to commercial vehicles and has excellent cosmetic appearance qualities.

High Uniform Installed Values

Gives the uniform clamp required every time without dimpling side panels.

Fast And Easy Installation

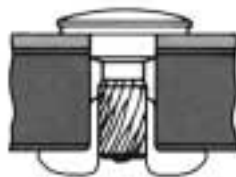
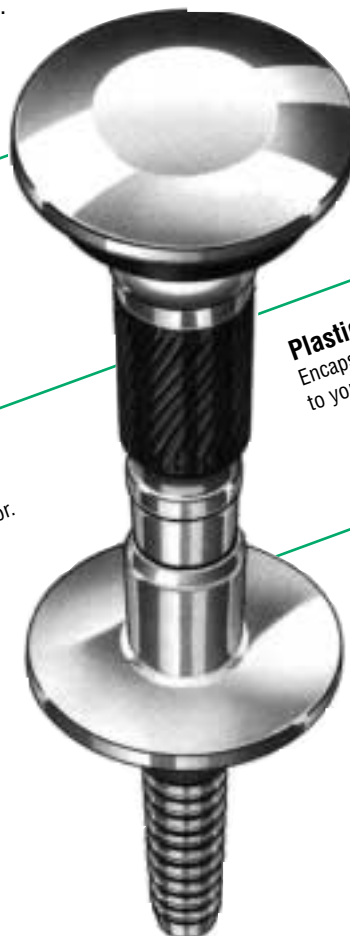
Does not require highly skilled labour, reduces rework and error.

Plastic Coloured Heads (Optional)

Encapsulated heads can be colour co-ordinated to your side panel colouring.

Low Profile Head Design

Does not bulge or protrude, gives good "cosmetic" appearance to vehicles.



APPLICATIONS

- Commercial vehicle body building.
- Suitable for use on rubber swing doors and in the construction of G.R.P. board type products.



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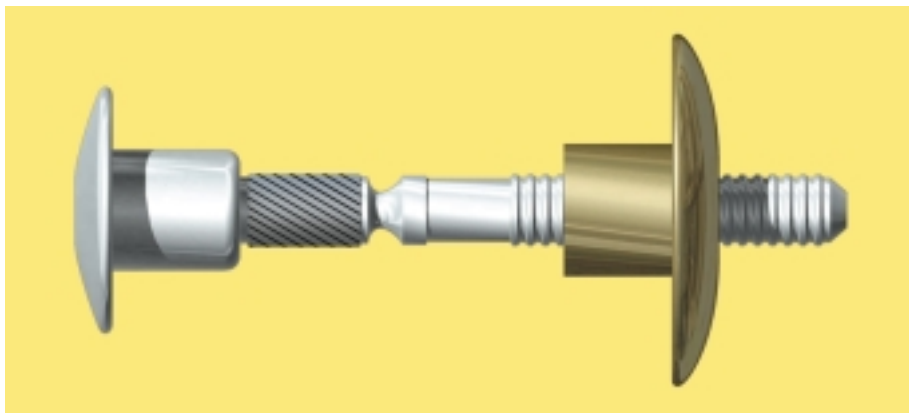
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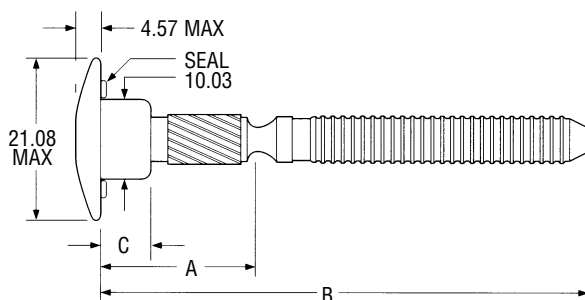
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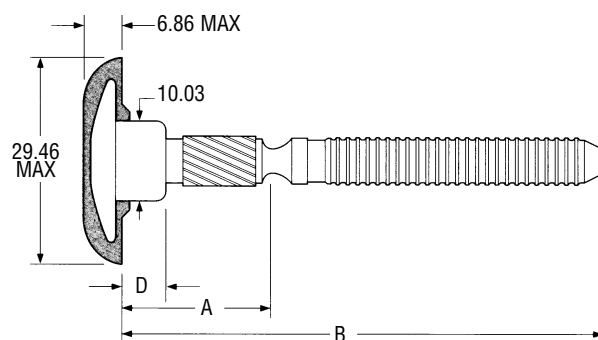
**Hucktainer®
Lockbolt**



Standard low profile head



Plastic encapsulated head



Part No. Standard	Part No. Encapsulated	Grip range* min - max	A +0.0-0.25	B +1.52-0.0	C	D
HLPP-R12-10	HLPE(**)-R12-10	14.27 - 17.48	15.85	56.69	2.54	0.97
HLPP-R12-11	HLPE(**)-R12-11	15.88 - 19.05	17.45	58.29	4.01	2.44
HLPP-R12-12	HLPE(**)-R12-12	17.45 - 20.62	19.02	59.87	5.59	4.01
HLPP-R12-13	HLPE(**)-R12-13	19.05 - 22.23	20.62	61.47	7.16	5.59
HLPP-R12-14	HLPE(**)-R12-14	20.62 - 23.80	22.20	63.04	8.76	7.19
HLPP-R12-15	HLPE(**)-R12-15	22.23 - 25.40	23.80	64.64	10.36	8.79
HLPP-R12-16	HLPE(**)-R12-16	23.80 - 26.97	25.37	66.22	11.94	10.36
HLPP-R12-17	HLPE(**)-R12-17	25.40 - 28.58	26.97	67.82	13.51	11.94
HLPP-R12-18	HLPE(**)-R12-18	26.97 - 30.15	28.55	69.39	15.11	13.54
HLPP-R12-19	HLPE(**)-R12-19	28.58 - 31.75	30.15	70.99	16.71	15.14
HLPP-R12-20	HLPE(**)-R12-20	30.15 - 33.32	31.72	72.57	18.29	16.71
HLPP-R12-21	HLPE(**)-R12-21	31.75 - 34.93	33.32	74.17	19.86	18.29
HLPP-R12-22	HLPE(**)-R12-22	33.32 - 36.50	34.90	75.74	19.86	18.29

*Other grip ranges are available. Please call your Huck representative.

**Add encapsulated colour: W = white, G = grey, Y = yellow. Consult Huck for other colours.

Typical Installed Tensile in Nominal Grip (N)

Diameter	Tensile
10.03	6670 typ

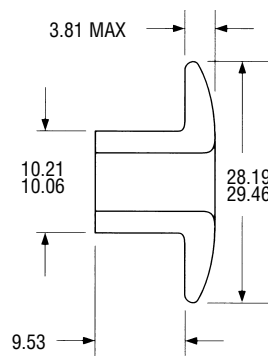
Materials and Finishes

	Material	Finish
Sleeve	Steel	Zinc Plated Gold Chromate
Pin	Steel	Zinc Plated Clear Chromate

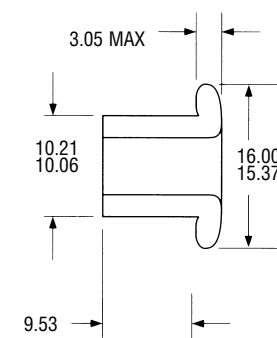
Recommended Hole Size

Diameter	Hole Size
10.03	10.29 - 10.69

Wide bearing sleeve
HLPS-R12

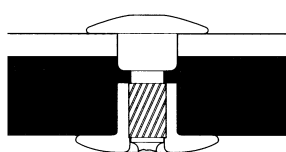


Clearance sleeve¹
HLPSC-R12

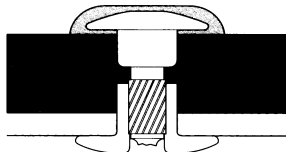


¹ Clearance sleeves are for use against metal structure only.

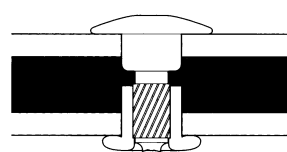
Recommended Installation Configurations



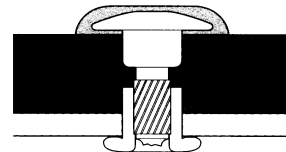
HLPP-R12(-) & HLPS-R12



HLPE(**)-R12(-) & HLPSC-R12



HLPP-R12(-) & HLPSC-R12



HLPE(**)-R12(-) & HLPSC-R12

Aluminium, Steel, Etc.

FRP or other clamp sensitive material

Hucktainer® Lockbolt



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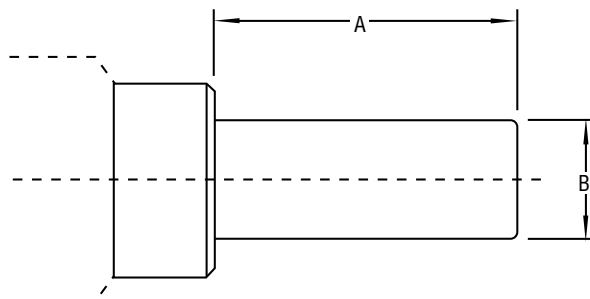
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Hucktainer® Lockbolt Installation Tooling

Huck Installation Tools

Huck installation tools consist of a nose assembly and a tool. The choice of tool and nose assembly is determined by the fastener diameter and application.

Tools and nose assemblies are easily changed as installation requirements demand. Huck offers pneumatic and hydraulic installation tools. Pneumatic tools operate on 6.2-6.9 bar (90-100 psi) air pressure. The lighter weight hydraulic tools operate on hydraulic power supplied by a Huck POWERIG® Hydraulic Unit.

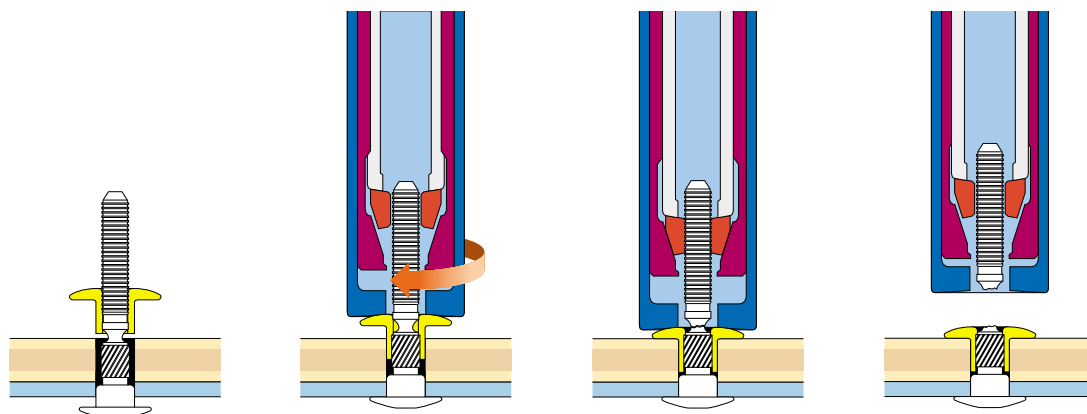


Nose Ass.	A mm	B mm	Pneumatic Tooling	Hydraulic Tooling
99-3464	77.7 (3.1/16")	28.2 (1.11")	2025	2480
99-3464L	77.7 (3.1/16")	28.2 (1.11")	2025L	2480L
99-3438	68.9 (2.23/32")	27.7 (1.3/32")	245 / 246 / 255 / 256	2503 / 2580

Items in **bold** are part of our FOCUS Tooling Range

Note: Other tool and nose assembly combinations may be available for specific applications. Please contact Huck for details.

Installation Sequence



[Click Here to view animation of installation sequence](#)

Installation Tooling



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C50L™ Lockbolt

A heavy duty, 2 piece fastener, totally resistant to vibratory loosening, with high strength and proven performance and reliability. The C50L is a grade 8.8 general purpose fastener available in diameters from 1/2" to 1.1/8" with a wide variety of head styles and finishes to suit customer requirements.

High Strength

Tests show the C50L meets or exceeds grade 8.8 requirements for thread bolts in both shear and tensile strengths.

Fast Easy Installation

Increases productivity, reduces labour costs and rework.

Vibration Resistant

Swaging of collar material into annular grooves provides total resistance to vibratory loosening with high fatigue life.

Visual Inspection

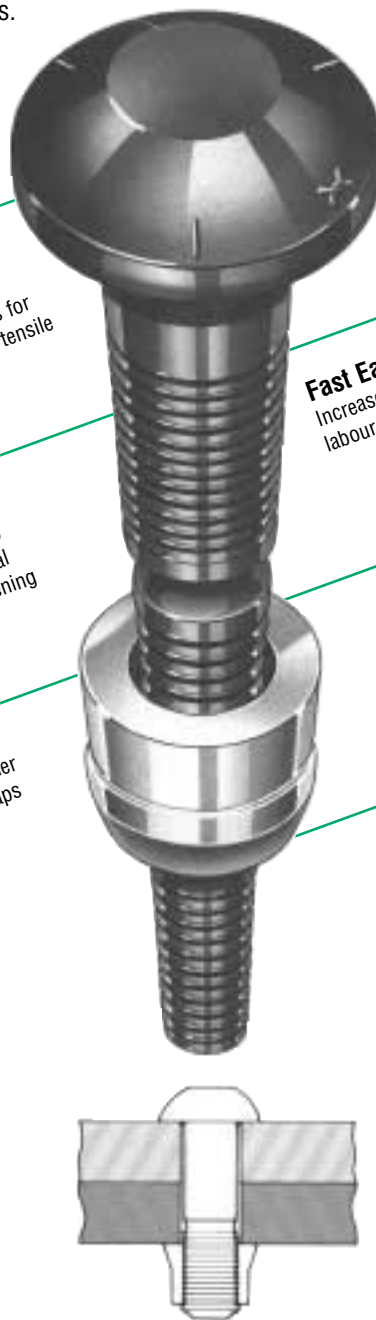
Performance is completely dependant on design not operator. Requires only visual inspection so eliminates costly torque checking ect.

Pre-Tensioning

Initial long length of fastener allows removal of joint gaps prior to final swaging.

Maintenance Free

Vibration resistance, high strength and visual inspection remove the need for expensive re tightening or replacement.



APPLICATIONS

- Construction ■ Mining Equipment ■ Bridge Building ■ Rail Track Assembly
- Quarry Plant and Machinery ■ Railcar and Waggon Construction
- Truck and Trailer Chassis ■ Ball and Rod Mills ■ Etc

C50L™ Lockbolt



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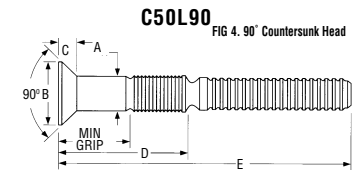
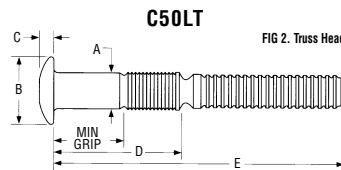
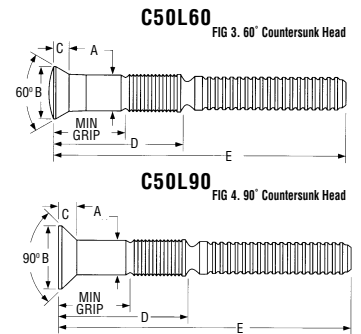
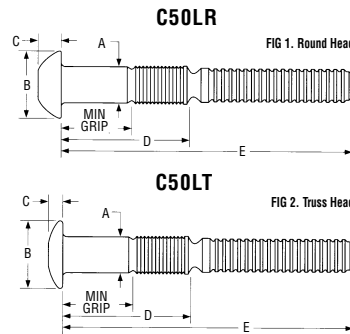
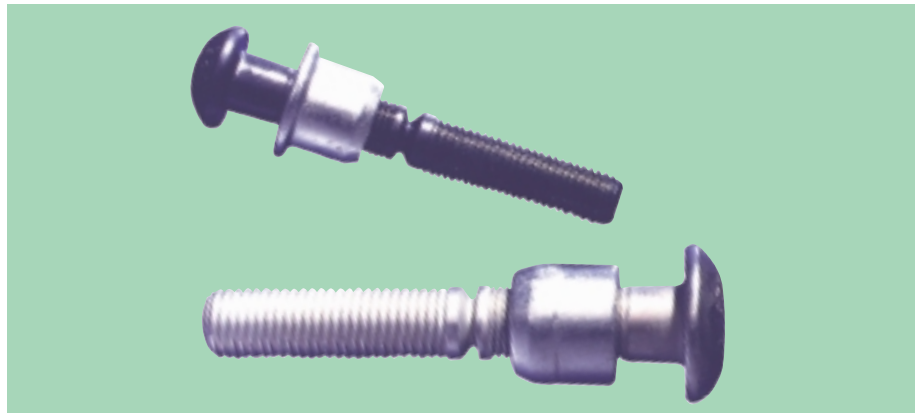
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C50L™ Lockbolt



Fastener Dimensions

	Fig. 1			Fig. 2			Fig. 3			Fig. 4		
Dia.	A	B	C	B	C		B	C		B	C	
12.7 mm (1/2")	13.08 - 12.52	23.42	7.94	23.42	5.95		19.84	5.95		23.02	6.35	
15.9 mm (5/8")	16.31 - 15.67	28.97	9.92	28.97	7.54		24.61	7.14		29.37	7.94	
19.1 mm (3/4")	19.51 - 18.82	34.93	11.91	34.93	9.13		29.37	8.73		34.93	9.53	
22.2 mm (7/8")	22.73 - 22.00	40.48	13.89	40.48	10.32		34.13	10.32		40.48	11.11	
25.4 mm (1")	25.96 - 25.15	46.43	15.48	46.43	11.91		38.89	11.91		46.83	12.70	
28.6 mm (1.1/8")	29.18 - 27.89	52.39	17.46									

Installed Fastener Values¹

Dia.	Carbon Steel Pins LC-2R or 3LC-2R Collars			2024 Aluminum Pins LC-F or 3LC-F Collars			6061 Aluminum Pins LC-1 or 3LC-1 Collars			Stainless Steel Pins LC-2CU or 3LC-2CU Collars		
	Shear	Clamp	Tensile	Shear	Clamp	Tensile	Shear	Clamp	Tensile	Shear	Clamp	Tensile
12.7 mm (1/2")	64050	53600	75840	32470	26240	34920	23580	19570	21800	61830	53600	75840
15.9 mm (5/8")	100080	85410	120550	50710	40920	54710	36920	30690	34120	93410	85410	120550
19.1 mm (3/4")	144120	126330	178370	72950	59160	78730	52930	44260	49110	134780	126330	178370
22.2 mm (7/8")	193050	174590	246650									
25.4 mm (1")	251320	229080	323390									
28.6 mm (1.1/8")	309150	260000	368980									

¹ Minimum values, in N, of installed fasteners. Round head, in carbon steel equivalent to ASTM A325 high strength bolts. Meets requirements of MIL-P-23469.

Grip Data and Dimensions

Grip is the actual thickness of material to be fastened. Grip includes 'C' dimension on 90° countersunk head and 60° watertight fasteners. Grips listed are not necessarily available in every head style. Contact Huck for grips not shown.

Tolerances: Dimension D ± 0.8 , Dimension E ± 4.8 , -1.6

Grip	Grip Range min - max	12.70mm (1/2") Dia.		15.86mm (5/8") Dia.		19.05mm (3/4") Dia.		22.23mm (7/8") Dia.		25.40mm (1") Dia.		28.58mm (1 1/8") Dia.		D	E
		D	E	D	E	D	E	D	E	D	E	D	E		
4	6.35 - 12.70	30.81	80.57	36.40	92.87	38.56	105.57								
8	12.70 - 19.05	37.16	86.92	42.75	99.22	44.91	111.92	48.79	119.06	52.65	136.53				
12	19.05 - 25.40	43.51	93.27	49.10	105.57	51.26	118.27	55.14	125.41	59.00	142.88				
16	25.40 - 31.75	49.86	99.62	55.45	111.92	57.61	124.62	61.49	131.76	65.35	149.23				
20	31.75 - 38.10	56.21	105.97	61.80	118.27	63.96	130.97	67.84	138.11	71.70	155.58				
24	38.10 - 44.45	62.56	112.32	68.15	124.62	70.31	137.32	74.19	144.46	78.05	161.93				
28	44.45 - 50.80	68.91	118.67	74.50	130.97	76.66	143.67	80.54	150.81	84.40	168.28				
32	50.80 - 57.15	75.26	125.02	80.85	137.32	83.01	150.02	86.89	157.16	90.75	174.63				
36	57.15 - 63.50	81.61	131.37	87.20	143.67	89.36	156.37	93.24	163.51	97.10	180.98				
40	63.50 - 69.85	87.96	137.72	93.55	150.02	95.71	162.72	99.59	169.86	103.45	187.33				
44	69.85 - 76.20	94.31	144.07	99.90	156.37	102.06	169.07	105.94	176.21	109.80	193.68				
48	76.20 - 82.55	100.66	150.42	106.25	162.72	108.41	175.42	112.29	182.56	116.15	200.03				
52	82.55 - 88.90	107.01	156.77	112.60	169.07	114.76	181.77	118.64	188.91	122.50	206.38				
56	88.90 - 95.25	113.36	163.12	118.95	175.42	121.11	188.12	124.99	195.26	128.85	212.73	133.35	217.49		
60	95.25 - 101.6	119.71	169.47	125.30	181.77	127.46	194.47	131.34	201.61	135.20	219.08	139.70	223.84		
64	101.60 - 107.95	126.06	175.82	131.65	188.12	133.81	200.82	137.69	207.96	141.55	225.43	146.05	230.19		
68	107.95 - 114.30	132.41	182.17	138.00	194.47	140.16	207.17	144.04	214.31	147.90	231.78	152.40	236.54		
72	114.30 - 120.65	138.76	188.52	144.35	200.82	146.51	213.52	150.39	220.66	154.25	238.13	158.75	242.24		
76	120.65 - 127.00	145.11	194.87	150.70	207.17	152.86	219.87			160.66	244.48	165.10	249.24		
80	127.00 - 133.35	151.46	201.22							166.95	250.83	171.45	255.94		
84	133.35 - 139.70									173.30	257.18	177.80	261.94		
88	139.70 - 146.05									179.65	263.53	184.15	268.29		
92	146.05 - 152.40									186.00	269.88	190.50	274.64		

C50L™ Lockbolt



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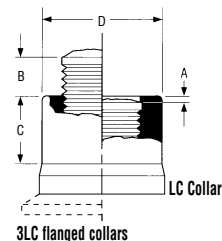
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C50L™ Lockbolt

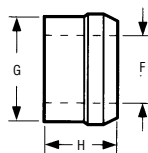
Inspection Data

A properly installed C50L fastener will possess the dimensional characteristics tabulated below. Should the dimensions 'A' or 'B' exceed the indicated values, the fastener is being used out-of-grip. A 'C' dimension less the values specified is an indication of incomplete swage. A 'D' dimension exceeding the tabulated values is an indication of an incorrect or worn anvil on the installation tool. The 'A' dimension can be increased to 3.2 mm (1/8") and still meet all published values, provided there is no requirement to meet ASTM specifications pertaining to locking grooves (threads) in the shear plane.

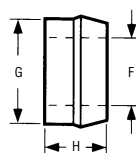


Dia.	Pin Part No.	Collar Type LC	Collar Type 3LC	A max	B max	C min	D max
12.7 mm (1/2")	C50L(-)(-)16	LC-2(-)16G	3LC-2(-)16G	1.59	9.53	10.32	18.62
15.9 mm (5/8")	C50L(-)(-)20	LC-2(-)20G	3LC-2(-)20G	1.59	9.53	15.88	23.27
19.1 mm (3/4")	C50L(-)(-)24	LC-2(-)24G	3LC-2(-)24G	1.59	9.53	16.67	28.19
22.2 mm (7/8")	C50L(-)(-)28	LC-2(-)28G	3LC-2(-)28G	1.59	9.53	19.05	32.56
25.4 mm (1")	C50L(-)(-)32	LC-2(-)32G	3LC-2(-)32G	1.59	9.53	22.23	37.21
28.6 mm (1.1/8")	C50L(-)BR36	LC-2(-)36G		1.59	9.53	23.02	41.81

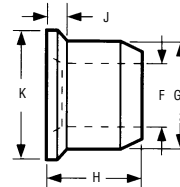
Standard Collar - LC



Low Profile Collar - 8LC



Flanged Collar - 3LC

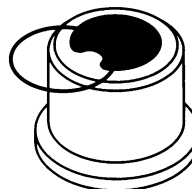


Collar Dimensions

Collar	Diameter	F	G	H	J	K
LC	12.7 mm (1/2")	13.08 - 13.72	20.32 - 19.43	16.38 - 15.49		
	15.9 mm (5/8")	16.51 - 16.89	25.65 - 24.64	22.23 - 21.43		
	19.1 mm (3/4")	19.69 - 20.07	29.97 - 29.59	24.38 - 23.62		
	22.2 mm (7/8")	23.11 - 23.75	34.93 - 34.16	28.72 - 27.51		
	25.4 mm (1")	26.04 - 26.67	40.01 - 38.99	32.39 - 31.24		
	28.6 mm (1.1/8")	29.21 - 29.97	44.96 - 44.20	36.20 - 35.18		
3LC ¹	12.7 mm (1/2")	13.08 - 13.59	20.50 - 20.14	18.95 - 18.19	3.96 - 2.39	26.19 - 24.61
	15.9 mm (5/8")	16.51 - 16.89	25.65 - 24.64	24.36 - 23.60	4.75 - 3.18	32.54 - 30.94
	19.1 mm (3/4")	19.69 - 20.07	30.48 - 29.72	29.13 - 28.37	5.54 - 3.96	38.89 - 37.29
	22.2 mm (7/8")	23.11 - 23.62	34.93 - 34.54	33.78 - 33.02	6.35 - 4.75	41.28 - 39.67
	25.4 mm (1")	26.16 - 26.67	40.01 - 39.37	38.48 - 37.72	7.14 - 5.54	48.41 - 46.81
	28.6 mm (1.1/8")	29.21 - 29.97	44.96 - 44.20	43.18 - 42.42	7.92 - 6.35	54.76 - 53.16
8LC ²	12.7 mm (1/2")	13.08 - 13.59	20.32 - 19.69	12.70 - 11.94	3.56	
	15.9 mm (5/8")	16.51 - 16.89	25.65 - 24.64	17.78 - 17.02	4.57	
	19.1 mm (3/4")	19.69 - 20.07	29.97 - 29.59	18.92 - 18.16	5.46	
	22.2 mm (7/8")	23.11 - 23.62	34.93 - 34.54	21.92 - 21.16	6.35	
	25.4 mm (1")	26.16 - 26.67	40.01 - 39.37	24.89 - 24.13	7.24	

Hole Data ⁴

Dia.	Maximum Hole
12.7 mm (1/2")	14.29
15.9 mm (5/8")	17.46
19.1 mm (3/4")	20.64
22.2 mm (7/8")	23.81
25.4 mm (1")	26.99
28.6 mm (1.1/8")	30.16



TAB-LOK™

The Tab-Lok feature makes sure the collar stays on the pin, before installation, in overhead and down slanted pin placements. To order Tab-Lok collars refer to 'Option' in the 'How to Order' section of this brochure.

1 When using 3LC collars, include J dimension in grip dimension to determine grip number.

2 Optional collar at reduced clamping force and tensile strength. Contact Huck for data. When using 8LC collars, subtract J dimension from grip dimension to determine grip number.

3 H length for 15.88mm (5/8") diameter in F, I or 2CU material is 20.45 - 19.56.

4 Except C50L60, refer to MIL-Spec MIL-P-23469.

How to Order

C50L Pins

Follow the form below to construct a part number for ordering C50L pins. Refer to the Grip Data chart for grip numbers.

C50L (HEAD STYLE) - (MATERIAL) (DIAMETER) - (GRIP NUMBER)

Example: **C50LR-BR16-4** is a C50L Huckbolt fastener, Round Head, Carbon Steel, 12.7mm (1/2") Diameter, Grip 4.

Head Style		Material		Diameter		Grip	
Round	R	Carbon Steel	BR	12.7 mm (1/2")	16	Refer to Grip Data Chart	
Truss	T	2024 Aluminium	C	15.9 mm (5/8")	20		
90° Countersunk	90	6061 Aluminium	F	19.1 mm (3/4")	24		
60° Countersunk	60	Stainless Steel	U	22.2 mm (7/8")	28		
				25.4 mm (1")	32		
				28.6 mm (1.1/8")	36		

Stainless Steel fasteners are available in 12.70mm to 19.05mm diameter and 36 grips only.

C50L Collars

Follow the form below to construct a part number for ordering collars for C50L pins.

(COLLAR STYLE) - (MATERIAL) (DIAMETER) (FINISH) (OPTIONS)

Example: **LC-2R16G** is a Standard Collar, Low Carbon Steel, 12.70mm (1/2") Diameter, Zinc Finish

Collar Style		Material		Diameter		Finishes		Options	
Standard	LC	Low Carbon Steel	2R	12.7 mm (1/2")	16	Zinc Clear Chromate	G	Tab-Lok	L
Flanged	3LC	6061 Aged	F	15.9 mm (5/8")	20				
Low Profile	8LC	6061	I	19.1 mm (3/4")	24				
		Stainless Steel	2CU	22.2 mm (7/8")	28				
				25.4 mm (1")	32				
				28.6 mm (1.1/8")	36				



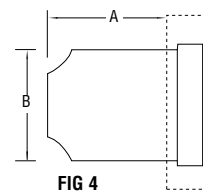
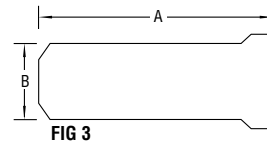
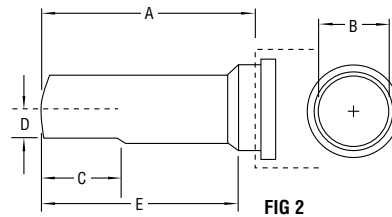
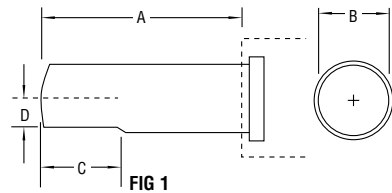
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C50L™ Lockbolt Installation Tooling

Huck Installation Tools

Huck installation tools consist of a nose assembly and a tool. The choice of tool and nose assembly is determined by the fastener diameter and application.

Tools and nose assemblies are easily changed as installation requirements demand. Huck offers hydraulic installation tools which operate on hydraulic power supplied by a Huck POWERIG® Hydraulic Unit.



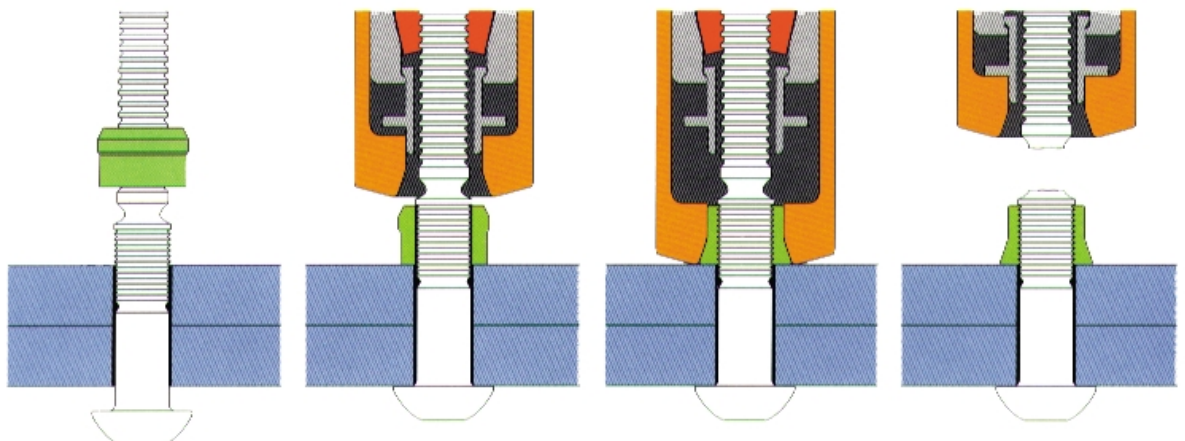
Hydraulic Tooling

Code	Diameter	Nose Ass.	Fig.	A mm	B mm	C mm	D mm	E mm	Hydraulic Tooling
16	12.7 mm (1/2")	99-5002	1	104.6	44.5	58.4	19.7	-	2620-PT
		99-5005	1	193.1	44.5	146.1	19.7	-	2620-PT
		99-6000	3	111.1	42.8	-	-	-	HPT25RH
20	15.9 mm (5/8")	99-5008	2	107.3	52.5	58.4	22.9	98.6	2624 / 2628
		99-5009	1	177.7	55.5	171.5	24.5	-	2624 / 2628
		99-6001	3	147.4	49.5	-	-	-	HPT35RH
24	19.1 mm (3/4")	99-5010	1	120.1	55.5	57.9	24.6	-	2628
		99-5013	1	177.7	55.5	171.5	26.3	-	2628
		99-6002	3	162.8	55.5	-	-	-	HPT57RH
28	22.2 mm (7/8")	99-5014	1	74.1	69.9	54.1	30.4	-	506
		99-5015	1	178.0	69.9	172.5	32.5	-	506
		99-6003	3	183.0	69.9	-	-	-	HPT70
32	25.4 mm (1")	99-5016	1	88.5	82.6	69.9	38.1	-	507
		99-5016FP	4	93.2	82.6	-	-	-	507
		99-5017	1	178.1	82.6	171.6	38.1	-	507
		99-6004	3	204.2	82.6	-	-	-	HPT90
36	28.6 mm (1.1/8")	99-5019	1	94.0	82.6	69.9	38.1	-	507
		99-5019FP	4	94	82.6	-	-	-	507
		99-5020	1	183.7	82.6	170.0	38.1	-	507

Items in **bold** are part of our FOCUS Tooling Range

Note: Other tool and nose assembly combinations may be available for specific applications. Please contact Huck for details.

Installation Sequence



[Click Here to view animation of installation sequence](#)



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MHP® Lockbolt

MHP® Lockbolt

A Grade 10.9 two piece fastener, providing high strength, excellent fatigue life and resistance to vibratory loosening. Manufactured from carbon steel with a wide range of head styles and finishes, available in diameters 12 mm to 27 mm.

Fast, Easy Installation
Reduced installation time,
eliminate errors and rework.
Saves time and costs.

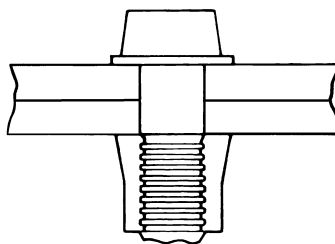
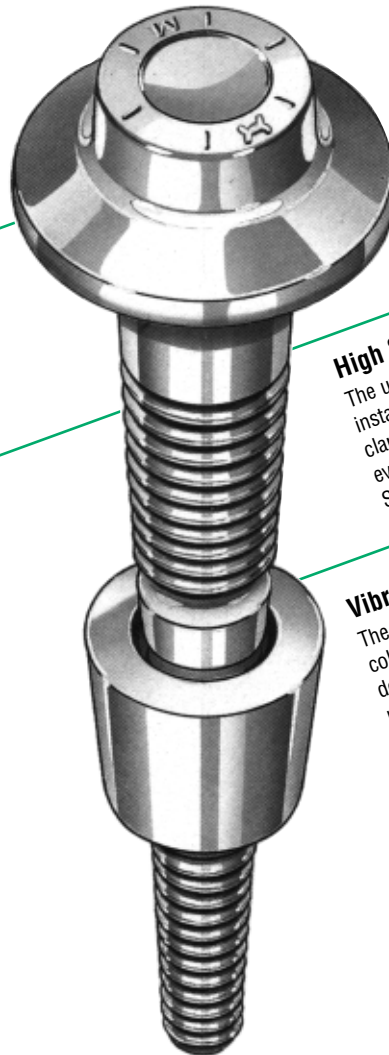
Visual Inspection
No need to X-ray welds or
perform torque checks.
Saves time and costs.

High Strength

The unique tension-tension method of installation causes the fastener to develop its clamp force and tensile strength consistently every time. Clamp force is measured using Skidmore-Wilhelm tester.

Vibration Resistant

The perfect match between the pin and the collar after swage, combined with the developed clamping force, delivers a vibration resistance many times superior to that of ordinary nuts and bolts.

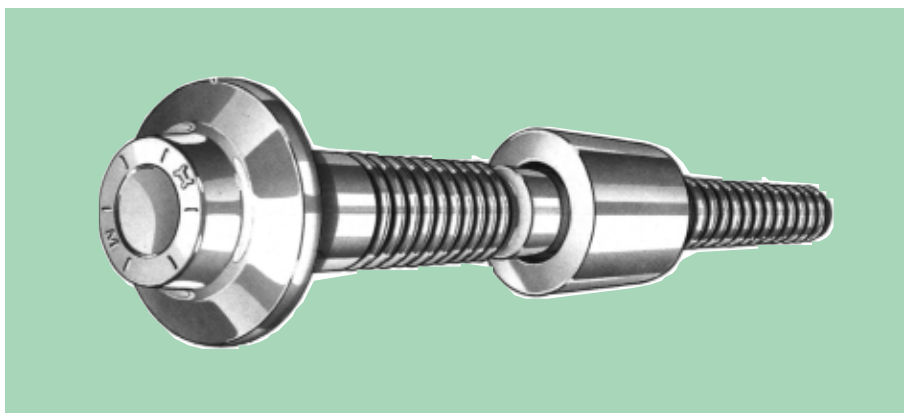


APPLICATIONS

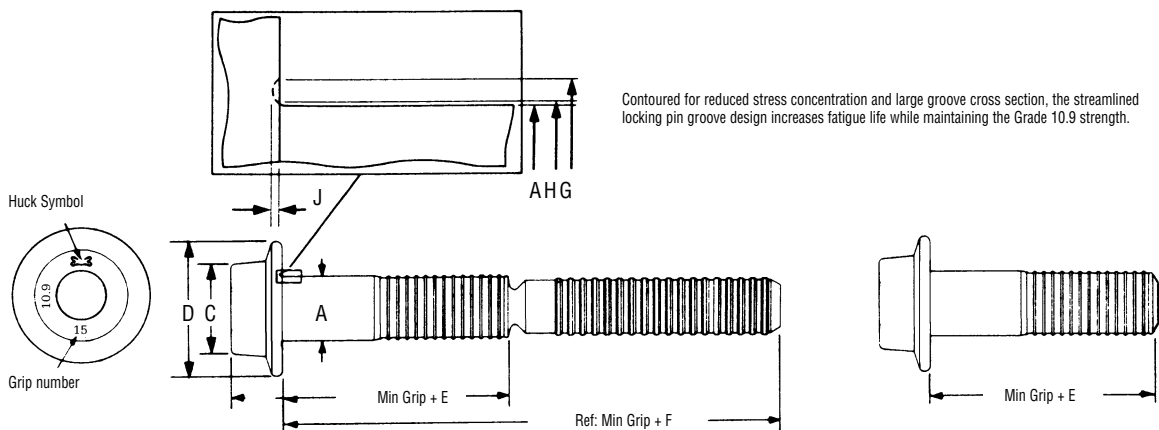
- Bus and Truck
- Chassis
- Heavy Construction
- Mining Equipment
- Railway
- Steelmaking Plant
- Quarry Plant and Machinery



Huck Fasteners
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Pin Dimensions



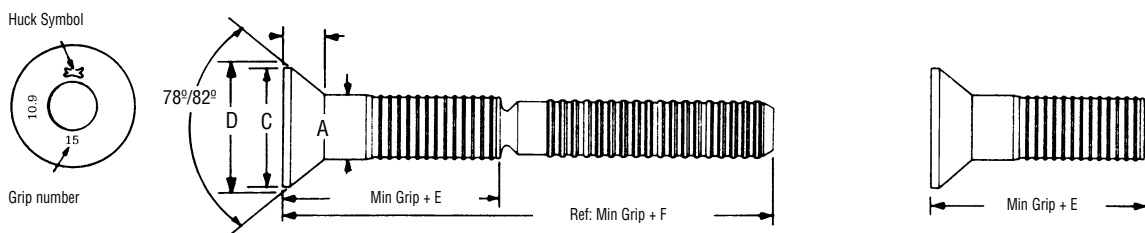
MHP Flange Head Pin (Pull-Type)

MHPFS Flange Head Pin (Stump-Type)

Dia	A	B Max	C Max	D Max	E ±0.5	F Min	G Max	H Max	J Max
12mm	11.73-12.00	9.5	18	25.4	32.6	82.6	15.2	12.8	0.37
14mm	13.73-14.00	11.1	21	29.6	35.2	85.5	17.7	14.8	0.43
16mm	15.73-16.00	12.8	24	33.9	38.6	95.2	20.1	17.1	0.51
18mm	17.73-18.00	14.8	27	39.0	40.9	102.7	23.2	19.4	0.57
20mm	19.67-20.00	16.0	30	42.3	44.3	111.4	25.7	21.6	0.65
22mm	21.67-22.00	17.5	32	46.6	47.7	118.1	27.2	23.8	0.72
24mm	23.67-24.00	18.6	36	50.8	48.9	132.6	29.7	26.2	0.80
27mm	26.67-27.00	20.9	41	57.2	56.2	139.9	33.4	29.4	0.88

Pin Dimensions

80° Countersunk Head (MHP 80) and 80° Flush Head Stump

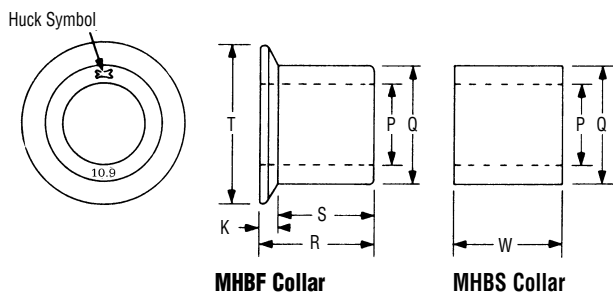


MHP80S (Stump-Type)

MHP80 Countersunk Head Pin (Pull-Type)

Dia	A	B Ref	C Min	D Max	E ±0.5	F Min
12mm	11.73-12.00	6.4	21.2	23.6	32.6	82.6
14mm	13.73-14.00	7.7	24.9	27.7	35.2	85.5
16mm	15.73-16.00	8.8	28.4	31.5	38.6	95.2
18mm	17.73-18.00	9.7	31.6	35.1	40.9	102.7
20mm	19.67-20.00	10.7	34.8	38.7	44.3	111.4
22mm	21.67-22.00	11.8	38.1	42.5	47.7	118.1
24mm	23.67-24.00	12.5	40.8	45.8	48.9	132.6
27mm	26.67-27.00	14.2	46.2	51.6	56.2	139.9

Collar Dimensions



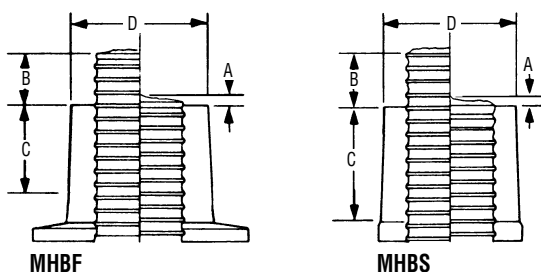
Nominal Fastener Dia.	K Ref.	P ± 0.1	Q ± 0.1	R ± 0.4	S ± 0.4	W $\pm$	T Dia. Max.
12mm	3.0	12.3	19.3	18.5	15.7	15.7	26.0
14mm	3.5	14.3	23.1	21.5	18.1	18.1	30.2
16mm	3.5	16.5	25.6	23.4	20.1	20.3	34.5
18mm	4.5	18.3	29.0	26.1	21.8	21.8	38.7
20mm	5.0	20.3	32.0	28.8	24.0	24.3	42.8
22mm	4.8	22.7	35.5	31.0	26.4	26.4	47.6
24mm	5.6	24.3	38.3	33.9	28.5	28.8	51.4
27mm	6.8	27.3	43.5	39.8	33.2	33.8	57.8

Grip Data

Grip* Number	Grip Range (mm) Min.	Max.*
-10	5	15
-15	10	20
-20	15	25
-25	20	30
-30	25	35
-35	30	40
-40	35	45
-45	40	50
-50	45	55
-55	50	60
-60	55	65
-65	60	70
-70	65	75
-75	70	80
-80	75	85
-85	80	90
-90	85	95
-95	90	100
-100	95	105

*24mm and 27mm fasteners are not manufactured in Grip -10.

Inspection Data



A properly installed HUCK BOLT Fastener will possess the dimensional characteristics tabulated. Should the dimensions "A" or "B" exceed the indicated value, the fastener is being used out-of-grip. A "C" dimension less than the tabulated values is an indication of an incorrect or worn anvil on the installation tool.

Fastener Dia.	A Min	B Max	C Min	D Max
12mm	3.47	14.73	11.60	18.3
14mm	3.12	14.38	15.95	21.9
16mm	4.57	15.83	17.75	24.1
18mm	4.15	15.43	19.25	27.4
20mm	4.87	16.13	21.25	30.3
22mm	6.05	17.31	23.40	33.4
24mm	4.42	15.68	25.30	36.3
27mm	5.82	17.08	29.50	41.3

A properly installed HUCK BOLT fastener will possess the dimensions given here. Visual inspection is sufficient.

Hole Data⁽²⁾

Dia.	Recommended Hole Dia. (mm)
12mm	12.0-13.5
14mm	14.0-15.5
16mm	16.0-17.5
18mm	18.0-19.5
20mm	20.0-22.0
22mm	22.0-24.0
24mm	24.0-26.0
27mm	27.0-30.0

⁽²⁾ For hole diameters smaller than (H), hole may have to be chamfered for proper head seating.

Minimum Fastener Values kN⁽¹⁾

Dia.	Shear	Tensile	Clamp
12mm	70.1	88.2	61.0
14mm	95.9	120.0	83.1
16mm	126.0	163.6	113.4
18mm	160.0	204.5	137.3
20mm	197.0	255.4	176.8
22mm	239.0	315.4	231.3
24mm	285.2	368.2	254.8
27mm	362.1	478.2	329.9

⁽¹⁾ Minimum values, in kilonewtons, of installed fasteners to ISO 898 Grade 10.9 high strength bolts. 1kN = 102 kgf or 225 lbf. Clamp force is measured using Skidmore-Willhelm tester.



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MHP® Lockbolt

How To Order Pin Part Number

Contact your Huck representative for grip numbers not shown, optional materials and optional finishes. MHP Pins and Collars must be shown separately.

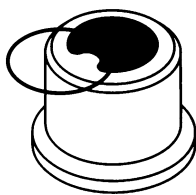
Example 1: **MHPFS-DT12-20G** = Metric; HP; Flanged Head; Stump-Type; Alloy Steel Material; 12mm diameter; 20mm grip, Zinc Chromate finish.

Example 2: **MHP80-DT20-55** = Metric; HP; 80° Flush Head; Pull Type; Alloy Steel Material; 20mm diameter; 55mm grip, Bare finish.

Example 2: 12mm SS 8° Flange Head, Pull-Type, Alloy Steel Material, 12mm Pin Diameter, 12mm Grip, Bare Finish (Blank)										
Metric	Fastener	Head Style	Type	Material	Pin Diameter	Grip	Finish			
Metric	M	High Performance	Flanged Head	F	Allo Steel	DT	12mm	12	See Grip Number	Bare Finish (Blank)
		Fastener	80° Countersunk				14mm	14	Listed in	Zinc Clear Chromate G
			Head	80			16mm	16	Grip Data Chart	
							18mm	18		
							20mm	20		
							22mm	22		
							24mm	24		
							27mm	27		

How to Order Collar Part Number

Metric	Type	Base Style	Material	Collar Diameter	Finish	Option
Metric	M	High Performance	Carbon Steel	12mm	Zinc Gold Chromate	Tab-Lok
		Collar		14mm		
				16mm		
				18mm		
				20mm		
				22mm		
				24mm		
				27mm		



The new optional Tab-Lok™ feature makes sure the MHP's collar stays on the pin, before installation, in overhead and down slanted placements.



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Installation Tooling

MHP® Installation Tooling

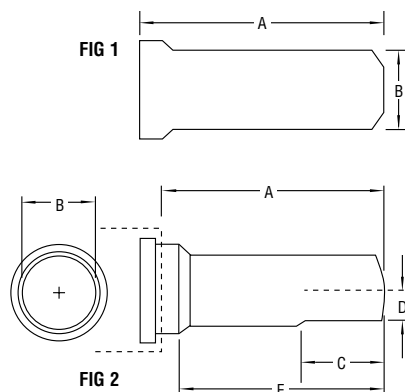
Nose Assemblies, Installation, Tooling, Hose Kits and Power Units

Nose Assemblies - attached to the installation tool, are designed to install a specific diameter MHP fastener.

Installation Tools - hand held and operated by hydraulic pressure, work with the nose assembly to swage the collar onto the pin.

Hose Kits - available in various lengths, connect the installation tools to the POWERIG® Hydraulic units.

POWERIG® Hydraulic Units - powered by petrol, diesel or electricity, provide hydraulic pressure to power the installation.



Hydraulic Tooling

Diameter	Nose Ass.	Fig.	A mm	B mm	C mm	D mm	E mm	Hydraulic Tooling
12 mm	99-6400	1	135.6	42.8	-	-	-	HPT25RH
12 mm	99-5406	2	104.1	44.5	55.4	20.7	-	2620-PT
14 mm	99-6402	1	169.1	49.5	-	-	-	HPT35RH
14 mm	99-5408	2	94.9	44.5	76.2	19.7	83.3	2624 / 2628
16 mm	99-6302	1	172.4	49.5	-	-	-	HPT35RH
16 mm	99-5300	2	100.3	55.5	58.4	24.5	-	2624 / 2628
20 mm	99-6405	1	194.1	55.5	-	-	-	HPT57RH
20 mm	99-5414	2	69.2	69.9	58.4	31.5	-	506
22 mm	99-6305	1	213.2	69.9	-	-	-	HPT70
22 mm	99-5416	2	83.5	82.6	54	36.4	-	507
24 mm	99-6406	1	237.0	82.6	-	-	-	HPT90
24 mm	99-5418	2	88.5	82.6	69.9	38.1	-	507
27 mm	99-6407	1	254.0	95.3	-	-	-	HPT115

Items in **bold** are part of our FOCUS Tooling Range

Note: Other tool and nose assembly combinations may be available for specific applications. Please contact Huck for details.



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Huck-Fit® Lockbolt

Huck-Fit® Lockbolt

Agrade 10.9, two piece fastener, providing high strength and resistance to vibratory loosening. The unique thread form allows pre-tightening fit-up prior to final swaging and, using standard impact wrenches, removal of fastener if required. Available in diameters 12 mm to 27 mm.

High Strength

The unique tension-tension method of installation causes the fastener to develop its clamp force and tensile strength consistently every time.

Visual Inspection

No need for X-ray of welds, or torque checking of bolts. Saves time and costs.

Fast, Easy Installation

Reduces need for skilled labour, reduces rework and errors. Saves time and cost.

Pre-Tightening Fit-Up Feature

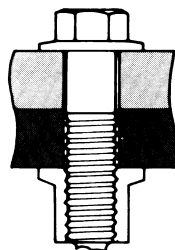
Permits structure alignment prior to final fixing.

Unique Thread Form

Allows initial fit-up, as well as removal using standard impact wrenches.

Vibration Resistant

The perfect match between the pin and the collar after swage, combined with the developed clamping force, delivers a vibration resistance many times superior to that of ordinary nuts and bolts.



APPLICATIONS

- Truck Frames ■ Construction ■ Bridges ■ Mining Equipment
- Off Road Vehicles ■ Steel Making Plant



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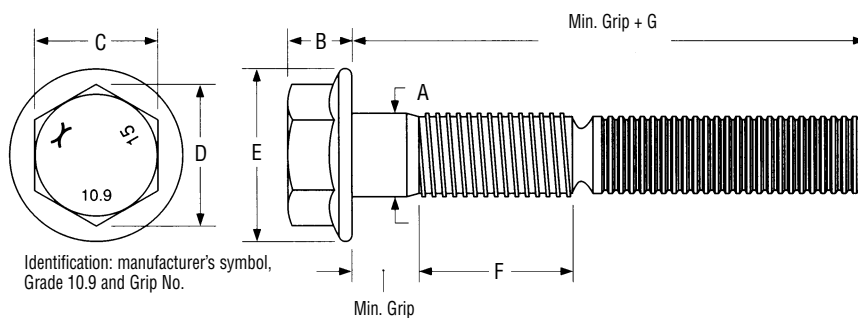
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Huck-Fit® Lockbolt

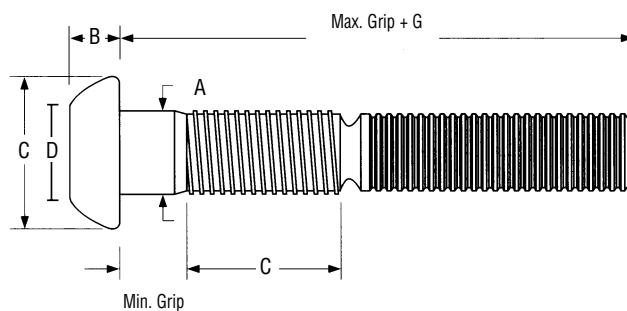


Flanged Hex Head Pin MHFF



Diameter	A	B max	C max	D ref	E max	F±0.5	G max
12mm	11.73-12.00	10.8	15	17.0	24.7	32.6	82.6
14mm	13.73-14.00	12.0	18	20.4	28.5	35.2	85.5
16mm	15.73-16.00	13.7	21	23.9	32.8	38.6	95.2
20mm	19.67-20.00	17.0	27	30.8	40.8	44.3	111.4
22mm	21.67-22.00	18.3	30	34.2	44.1	47.7	118.1
24mm	23.67-24.00	19.5	34	38.7	49.0	48.9	132.6
27mm	26.67-27.00	22.1	36	40.4	53.9	56.2	139.9

Round Head Pin MHFR



Diameter	A	B max	C max	D ref	F±0.5	G max
12mm	11.73-12.00	8.0	22.7	9.2	32.6	82.6
16mm	15.73-16.00	10.7	30.5	13.1	38.6	95.2
20mm	19.67-20.00	13.4	38.3	15.4	44.3	111.4
22mm	21.67-22.00	14.6	41.8	17.3	47.7	118.1
24mm	23.67-24.00	15.5	46.0	20.3	48.9	132.6
27mm	26.67-27.00	17.4	51.4	22.8	56.2	139.9

Huck-Fit® Lockbolt



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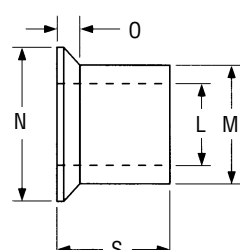
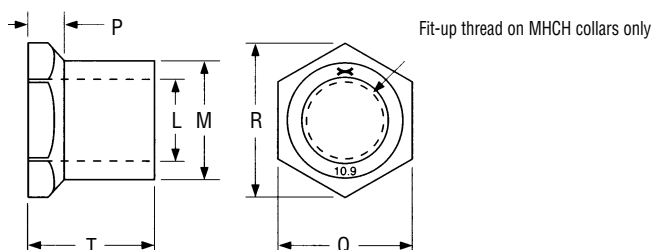
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Huck-Fit® Lockbolt

Collar Dimensions



Hex Flange Collar MHCH/MHBH

Dia.	L±0.1	M±0.1	N max	O ref	P ref	Q max	R ref	S±0.4	T±0.4
12mm	12.3	19.3	26.0	3.0	7.1	22.0	24.9	18.5	22.6
14mm	14.3	23.1	30.2	3.5	7.3	26.0	30.3	21.5	25.2
16mm	16.5	25.6	34.5	3.5	8.7	30.0	33.7	23.4	28.6
20mm	20.3	32.0	42.8	5.0	10.5	36.0	41.0	28.8	34.3
22mm	22.7	35.5	47.6	4.8	11.5	38.0	44.0	31.0	37.7
24mm	24.3	38.3	51.4	5.6	10.6	41.0	47.2	33.9	38.9
27mm	27.3	43.5	57.8	6.8	13.2	46.0	52.2	39.8	46.2

Round Flange Collar MHBFI

Grip Data

Grip Number	Range (mm) min-max
10 ²	5-15
15	10-20
20	15-25
25	20-30
30	25-35
35	30-40
40	35-45
45	40-50
50	45-55
55	50-60
60	55-65
65	60-70
70	65-75
75	70-80
80	75-85
85	80-90
90	85-95
95	90-100
100	95-105

Round flange collars provide additional grip as follows:

Diameter	Add to max grip
12mm	4.0
14mm	4.0
16mm	5.0
20mm	5.5
22mm	6.5
24mm	5.0
27mm	6.5

Minimum Installed Values kN

Diameter	Shear	Tensile	Clamp
12mm	70.1	88.2	61.0
14mm	95.9	120.0	83.1
16mm	126.0	163.6	113.4
20mm	197.0	255.4	176.8
22mm	239.0	315.4	231.3
24mm	285.2	368.2	254.8
27mm	362.1	478.2	329.9

Minimum values, in kilonewtons, of installed fasteners to meet ISO 898 Grade 10.9 high strength bolts. 1kN = 102 kgf or 225 lbf. Approvals from National Institutes of Steel Construction are available on request. Clamp force is measured using Skidmore-Wilhelm tester.

Inspection Data

Should 'A', 'B' or 'E' dimensions exceed the given values, the fastener is out-of grip. A 'C' dimension less than the given value indicates an incomplete swage. A 'D' dimension greater than the given values indicates an incorrect or worn anvil on the installation tool.

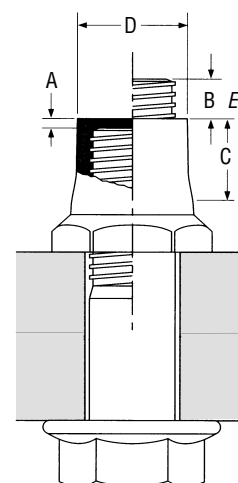
Dia.	A max	B max	C min	D max	E max ²
12mm	0.6	10.6	13.8	18.3	14.7
14mm	0.6	10.6	15.9	21.9	14.4
16mm	0.6	10.6	17.7	24.1	15.8
20mm	0.6	10.6	21.2	30.3	16.1
22mm	0.6	10.6	23.4	33.4	17.3
24mm	0.6	10.6	25.3	36.3	15.7
27mm	0.6	10.6	29.5	41.3	17.1

A properly installed fastener will possess the dimensions given here. Visual inspection is sufficient.
1 Non-standard, available on request 2 Please call for availability 3 E dimension for MHBFI collars only

Hole Data

Diameter	Maximum Hole Diameter
12mm	13.5 (14.0*)
14mm	15.5 (16.0*)
16mm	17.5 (18.0*)
20mm	22.0
22mm	24.0
24mm	26.0
27mm	30.0

*For MHFF pins
For hole diameters smaller than H dimensions (see drawings), the hole may have to be chamfered for proper head seating.



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Huck-Fit® Lockbolt

How to Order Metric Huck-Fit Pins

Follow the form below to construct a part number for ordering Metric Huck-Fit pins. Refer to the Grip Data chart for grip numbers.

MHF (STYLE) (TYPE) - (MATERIAL) DIAMETER) - (GRIP NUMBER) (FINISH)

Example: **MHFF-DT16-20** is a Metric Huck-Fit Pin, Flanged Head, Pull Type, Alloy Steel, 16mm Diameter, Grip 20, Black Standard Finish

Style	Material	Diameter	Grip	Finish
Hex Head	Steel	12mm	Refer to Grip Data Chart	Black Standard
Flanged Head	DT	14mm		Zinc Clear Chromate
Round Head	R	16mm		Zinc Gold Chromate
		20mm		
		22mm		
		24mm		
		27mm		

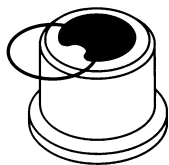
Metric Huck-Fit Collars

Follow the form below to construct a part number for ordering Metric Huck-Fit collars.

MH (STYLE) - (MATERIAL) (DIAMETER) - (FINISH) (OPTIONS)

Example: **MHCH-R16U** is a Metric Huck-Fit Collar, Threaded, Hex Flange, Steel, 16mm Diameter, Zinc Gold Chromate Finish

Style	Material	Diameter	Finish	Options
Thread,	Steel	12mm	Standard	No Tab-Lok
hex flange	CH	14mm	Zinc Gold Chromate	Tab-Lok for
No thread,		16mm		MHBH/BF only
hex flange	BH	20mm		
No thread,		22mm		
round flange	BF	24mm		
		27mm		



TAB-LOK™

The Tab-Lok feature makes sure the collar stays on the pin, before installation, in overhead and down slanted pin placements. To order Tab-Lok collars refer to 'Options' in the 'How to Order' section of this brochure.



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Huck-Fit® Installation Tooling

Standard Tooling

HPT tooling represents the most current technology in Huck tooling. It is designed for production applications, has improved clearance for easier handling and is lighter in weight compared to standard tooling. Where standard tooling is used, the listed nose assemblies in the chart are available.

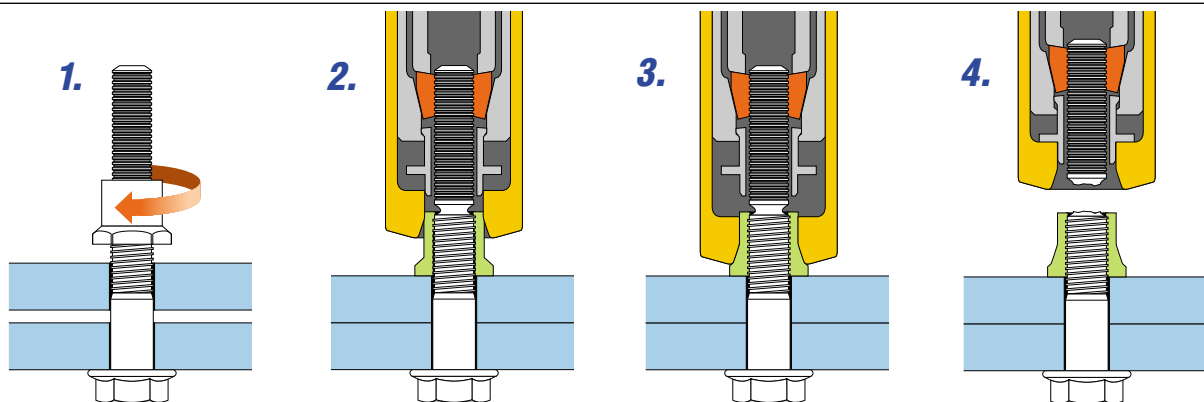
The Huck-Fit HPT Tool System

The Huck-Fit HPT tool system comprises a tool and nose assembly. The tool powers the nose assembly, which provides the installation link between the fastener and the tool. The choice of tool and nose assembly is determined by the fastener diameter and the application.

Installation Tools

The HPT tools are hydraulically powered, hand held units. The weight of this line of tooling is about one half of conventional tools. All tools connect to a POWERIG hydraulic unit designed to provide pressurized hydraulic fluid to the installation tool.

Installation Sequence



- Step 1.** The pin is inserted through a prepared hole. The collar is threaded onto the pin.
- Step 2.** The nose assembly, attached to HUCK's installation tool, is placed over the pintail. The nose assembly pulls on the pintail, drawing the work pieces together.
- Step 3.** Continued pulling on the pintail moves the anvil forward, swaging the collar into the locking grooves. The controlled swaging lengthens the collar to develop clamp.
- Step 4.** When the swaging is completed, the pintail separates from the pin, and the tool ejects the swaged collar out of the anvil, completing the installation.



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Installation Tooling

Huck-Fit® Installation Tooling

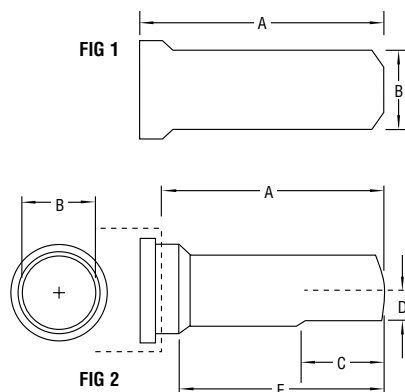
Nose Assemblies, Installation, Tooling, Hose Kits and Power Units

Nose Assemblies - attached to the installation tool, are designed to install a specific diameter MHP fastener.

Installation Tools - hand held and operated by hydraulic pressure, work with the nose assembly to swage the collar onto the pin.

Hose Kits - available in various lengths, connect the installation tools to the POWERIG® Hydraulic units.

POWERIG® Hydraulic Units - powered by petrol, diesel or electricity, provide hydraulic pressure to power the installation.



Hydraulic Tooling

Diameter	Nose Ass.	Fig.	A mm	B mm	C mm	D mm	E mm	Hydraulic Tooling
12 mm	99-6400	1	135.6	42.8	-	-	-	HPT25RH
12 mm	99-5406	2	104.1	44.5	55.4	20.7	-	2620-PT
14 mm	99-6402	1	169.1	49.5	-	-	-	HPT35RH
14 mm	99-5408	2	94.9	44.5	76.2	19.7	83.3	2624 / 2628
16 mm	99-6302	1	172.4	49.5	-	-	-	HPT35RH
16 mm	99-5300	2	100.3	55.5	58.4	24.5	-	2624 / 2628
20 mm	99-6405	1	194.1	55.5	-	-	-	HPT57RH
20 mm	99-5414	2	69.2	69.9	58.4	31.5	-	506
22 mm	99-6305	1	213.2	69.9	-	-	-	HPT70
22 mm	99-5416	2	83.5	82.6	54	36.4	-	507
24 mm	99-6406	1	237.0	82.6	-	-	-	HPT90
24 mm	99-5418	2	88.5	82.6	69.9	38.1	-	507
27 mm	99-6407	1	254.0	95.3	-	-	-	HPT115

Items in **bold** are part of our FOCUS Tooling Range

Note: Other tool and nose assembly combinations may be available for specific applications. Please contact Huck for details.



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Huck-Spin® Lockbolt

Huck-Spin®

A two piece grade 10.9 fastening system providing the high performance of lockbolt technology with the manufacturing flexibility of threaded fasteners. The computer controlled installation tooling removes the chance of human error on over or under tightening whilst providing SPC Quality Control and preventative maintenance data. Available in 12mm, 14 mm, 16mm and 20mm diameters.

Fast Installation
Upto 50% faster than installing nuts and bolts with impact wrenches.

Simple Installation
Tool, not operator, controls installation.
No need for skilled labour.

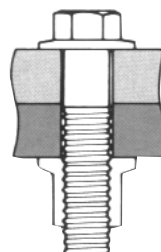
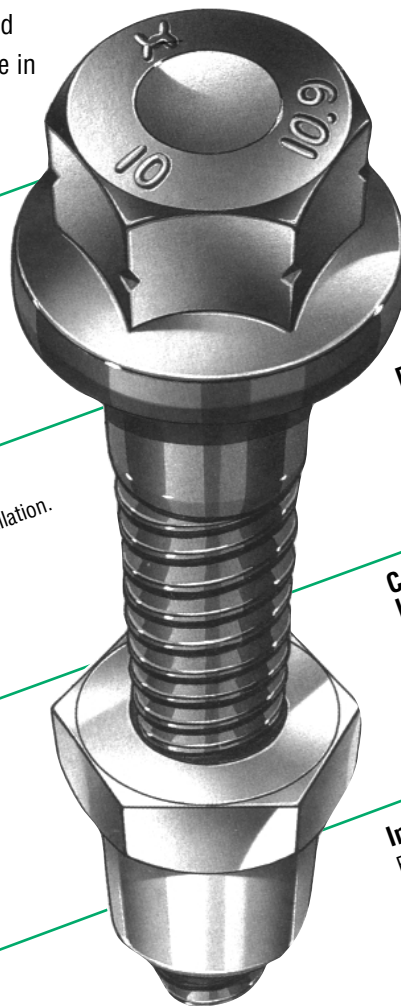
Visual Inspection
No need for X-ray or welding or torque checking of bolts.

Fit-Up Facility
Alignment of components and pre-build capability.

Removability
Simple removal using standard impact wrenches.

Computer Controlled Installation
SP Quality Control and Preventative Maintenance Data.

Improved Working Conditions
Removes danger of injury to operatives by vibration from impact wrenches or high noise levels.



APPLICATIONS

- Truck and Bus Chassis



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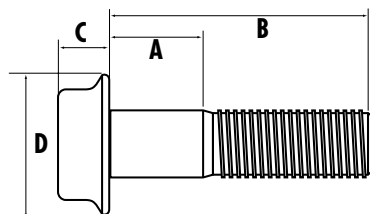
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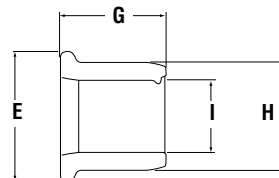
This Grade 10.9 fastening system employs the world's most advanced lockbolt technology to produce a fail-proof joint. Huck-Spin® fastening systems are designed for consistent, reliable installation without the noise and waste associated with pintails. In addition to the round head design, a hex head style is also available which allows the Huck-Spin® to be removed with a standard impact wrench.



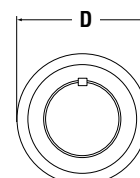
Round Head Metric



Round Flange Pin - MHSPF-DT ("Diameter")-"Grip No."



Round Flange Collar - MHSCF-R ("Diameter")



Fastener Dimensions

12mm Round Head - MHSPF-DT12-"Grip No."

	Grip No.	Grip range(mm)	A	B
C(max) =9.70	10	4-19	4.0	46.04
D(max) =25.50	15	9-24	9.0	51.04
E(max) =26.25	20	14-29	14.0	56.04
G (ref) =18.49	25	19-34	19.0	61.04
H (ref) =19.30	30	24-39	24.0	66.04
I (ref) =12.29	35	29-44	29.0	71.04
	40	34-49	34.0	76.04
	45	39-54	39.0	81.04
	50	44-59	44.0	86.04

Fastener Dimensions

14mm Round Head - MHSPF-DT14-"Grip No."

	Grip No.	Grip range(mm)	A	B
C(max) =11.50	10	4-19	4.0	54.42
D(max) =30.00	15	9-24	9.0	59.42
E(max) =31.00	20	14-29	14.0	64.42
G (ref) =21.40	25	19-34	19.0	69.42
H (ref) =23.15	30	24-39	24.0	74.42
I (ref) =14.45	35	29-44	29.0	79.42
	40	34-49	34.0	84.42
	45	39-54	39.0	89.42
	50	44-59	44.0	94.42
	55	49-64	49.0	99.42
	60	54-69	54.0	104.42
	65	59-74	59.0	109.42
	70	64-79	64.0	114.42
	75	69-84	69.0	119.42

Fastener Dimensions

16mm Round Head - MHSPF-DT16-"Grip No."

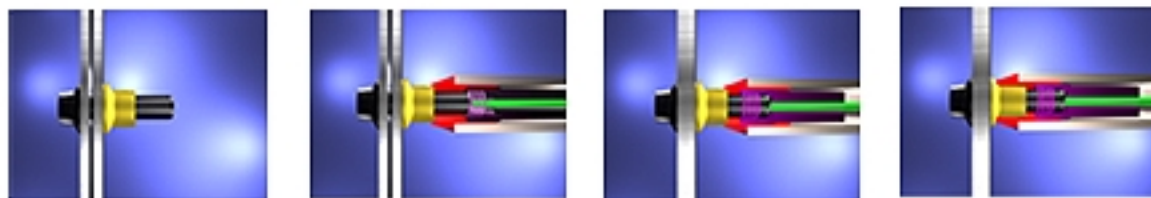
	Grip No.	Grip range(mm)	A	B
C(max) =12.80	10	4-21	4.0	54.41
D(max) =35.00	15	9-26	9.0	59.41
E(max) =34.75	17	10-29	10.0	62.41
G (ref) =23.39	20	14-31	14.0	64.41
H (ref) =25.63	25	19-36	19.0	69.41
I (ref) =16.46	30	24-41	24.0	74.41
	35	29-46	29.0	79.41
	40	34-51	34.0	84.41
	45	39-56	39.0	89.41
	50	44-61	44.0	94.41
	55	49-66	49.0	99.41
	60	54-71	54.0	104.41
	65	59-76	59.0	109.41
	70	64-81	64.0	114.41
	75	69-86	69.0	119.41
	90	84-101	84.0	134.41

Fastener Dimensions

20mm Round Head - MHSPF-DT20-"Grip No."

	Grip No.	Grip range(mm)	A	B
C(max) =16.10	15	9-26	9.0	68.24
D(max) =42.50	20	14-31	14.0	73.24
E(max) =43.05	25	19-36	19.0	78.24
G (ref) =28.80	30	24-41	24.0	83.24
H (ref) =32.10	35	29-46	29.0	88.24
I (ref) =20.45	40	34-51	34.0	93.24
	45	39-56	39.0	98.24
	50	44-61	44.0	103.24
	55	49-66	49.0	108.24
	60	54-71	54.0	113.24
	80	74-91	74.0	133.25

Installation Sequence



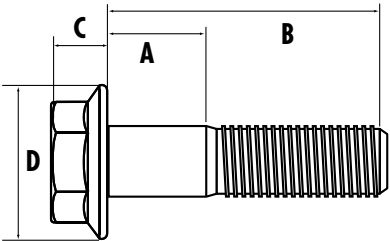
[Click Here to view animation of installation sequence](#)

Huck-Spin® Lockbolt

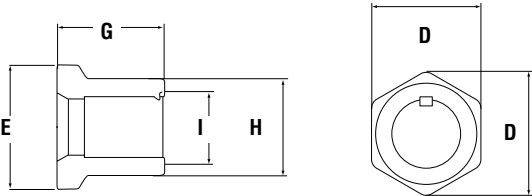


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Hex Head Metric



Hex Head Pin - MHSF-DT ("Diameter")-(“Grip No”)



Hex Flange Collar - MHSR ("Diameter")

Fastener Dimensions				
12mm Hex Head - MHSF-DT12-“Grip No.”				
	Grip No.	Grip range(mm)	A	B
C(max)=12.00	10	4-16	4.0	50.1
D(max)=24.80	15	9-21	9.0	55.1
E (ref) =22.50	17	10-24	10.0	58.1
F (ref) =21.40	20	14-26	14.0	60.1
G (ref) =22.60	25	19-31	19.0	65.1
H (ref) =19.31	30	24-36	24.0	70.1
I (ref) =12.30	35	29-41	29.0	75.1
	40	34-46	34.0	80.1
	45	39-51	39.0	85.1
	50	44-56	44.0	90.1

Fastener Dimensions				
16mm Hex Head - MHSF-DT16-“Grip No.”				
	Grip No.	Grip range(mm)	A	B
C(max)=15.10	10	4-16	4.0	59.54
D(max)=32.80	15	9-21	9.0	64.54
E (ref) =31.87	17	10-24	10.0	67.54
F (ref) =29.31	20	14-26	14.0	69.54
G (ref) =28.60	25	19-31	19.0	74.54
H (ref) =25.65	30	24-36	24.0	79.54
I (ref) =16.45	35	29-41	29.0	84.54
	40	34-46	34.0	89.54
	45	39-51	39.0	94.54
	50	44-56	44.0	99.54
	55	49-61	49.0	104.54
	60	54-66	54.0	109.54
	65	59-71	59.0	114.54
	70	64-76	64.0	119.54
	80	74-86	74.0	129.54

Fastener Dimensions				
14mm Hex Head - MHSF-DT14-“Grip No.”				
	Grip No.	Grip range(mm)	A	B
C(max)=11.92	10	4-16	4.0	54.42
D(max)=28.50	15	9-21	9.0	59.42
E (ref) =29.26	20	14-26	14.0	64.42
F (ref) =26.16	21	15-27	15.0	65.42
G (ref) =25.20	25	19-31	19.0	69.42
H (ref) =23.09	30	24-36	24.0	74.42
I (ref) =14.35	35	29-41	29.0	79.42
	40	34-46	34.0	84.42
	45	39-51	39.0	89.42

Fastener Dimensions				
20mm Hex Head - MHSF-DT20-“Grip No.”				
	Grip No.	Grip range(mm)	A	B
C(max)=17.70	15	9-21	9.0	73.68
D(max)=46.00	20	14-26	14.0	78.68
E (ref) =37.85	25	19-31	19.0	83.68
F (ref) =34.19	30	24-36	24.0	88.68
G (ref) =34.30	35	29-41	29.0	93.68
H (ref) =32.12	40	34-46	34.0	98.68
I (ref) =20.46	45	39-51	39.0	103.68
	50	44-56	44.0	108.68
	55	49-61	49.0	113.68
	60	54-66	54.0	118.68



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Huck-Spin® Lockbolt

Inspection Data

ROUND HEAD Metric (mm)				
Nominal Dia.	A (Max)	B (Max)	C (Min)	D (Max)
DT12	10.32	22.32	14.0	18.3
DT14	12.04	30.22	15.9	21.9
DT16	13.76	25.76	17.7	24.1
DT20	17.20	29.20	21.2	30.3

Inspection Data

HEX HEAD Metric (mm)				
Nominal Dia.	A (Max)	B (Max)	C (Min)	D (Max)
DT12	10.3	22.3	14.0	18.3
DT14	12.1	24.1	15.9	21.9
DT16	13.8	25.8	17.7	24.1
DT20	17.2	29.2	21.2	30.3

Minimum Installed Values kN

Diameter	Shear	Tensile	Clamp
12	70.1	88.2	61.0
14	95.9	120.0	83.1
16	126.0	163.6	113.4
20	197.0	254.0	181.0

Minimum values, in kilonewtons, of installed fasteners to meet ISO 898 Grade 10.9 high strength bolts. 1kN = 102 kgf or 225 lbf. Clamp force is measured using Skidmore-Wilhelm tester.

Hole Preparation Data

Diameter	Maximum Hole Diameter
12	13.5
14	15.5
16	17.5
20	22.0

How to Order

Metric Huck-Spin Pins

Follow the form below to construct a part number for ordering Metric Huck-Spin pins. Refer to the Grip Data chart for grip numbers.

MHS (STYLE) (TYPE) - (MATERIAL) (DIAMETER) - (GRIP NUMBER) (FINISH)

Example: **MHSPF-DT16-20** is a Metric Huck-Spin Pin, Round Head, Alloy Steel, 16mm Diameter, Grip 20, Black Standard Finish

Style		Material		Diameter		Grip		Finish	
Hex Head	F	Steel	DT	12mm	12	Refer to Grip Data Chart		Black Standard	-
Round Head	PF			14mm	14			Zinc Clear Chromate	G
				16mm	16			Zinc Gold Chromate	U
				20mm	20			Dacromet	D

Metric Huck-Spin Collars

Follow the form below to construct a part number for ordering Metric Huck-Spin collars.

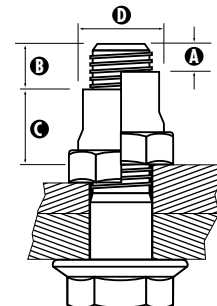
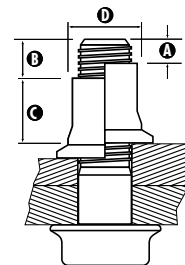
MHS (STYLE) - (MATERIAL) (DIAMETER) - (FINISH) (OPTIONS)

Example: **MHCH-R16U** is a Metric Huck-Fit Collar, Threaded, Hex Flange, Steel, 16mm Diameter, Zinc Gold Chromate Finish

Style		Material		Diameter		Finish	
Thread, hex flange	H	Steel	R	12mm	12	Zinc Clear Chromate	G
Round flange	CF			14mm	14	Zinc Gold Chromate	U
				16mm	16		
				20mm	20		

Installation Tooling

Dia.	Installation Tool	Nose Assembly	Type	Use
12mm	HS37	99-7412-1	Hydraulic	Production
14mm	HS37	99-7414-1	Hydraulic	Production
14mm	HS52	99-7415-1	Hydraulic	Production
16mm	HS52	99-7316-1	Hydraulic	Production
20mm	HS52	99-7418-1	Hydraulic	Production



Huck Fasteners
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Magna-Lok® Blind Fastener

Magna-Lok® Blind Fastener

A blind high strength fastener with the unique "Huck Solid Circle Locking System". High resistance to vibration and loosening available in diameters 3/16" and 1/4" with a range of head styles to suit. This product is T.I.R. approved.

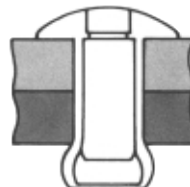
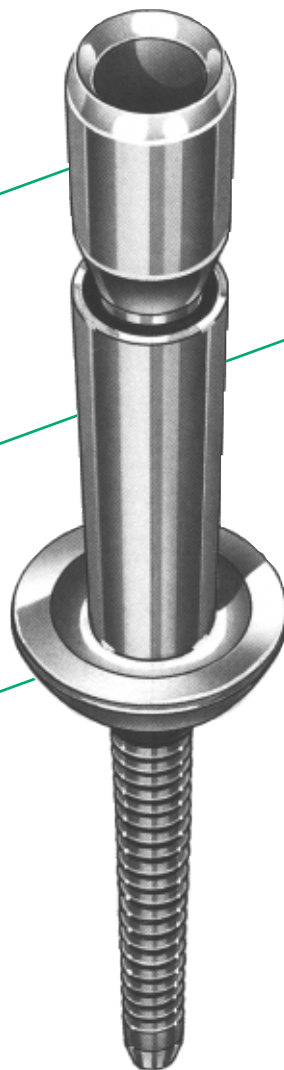
Solid Circle Lock Design
Ensures high strength joint is positively locked against vibration every time.

Fast And Easy To Install
Easily placed from one side of workpiece. Takes 1.1/2 seconds to install, no skilled labour required.

Quick And Easy Inspection
No need for torque gauges or x-ray equipment. A simple visual check is all that is required.

Watertight
No moisture penetration into workpiece. Better life of your product.

Versatility
Choice of materials, wide grip range (1.63 to 15.8mm) and head styles to choose from.



APPLICATIONS

- Commercial vehicle body building ■ buses ■ trains
- automotive ■ sheet metal fabrication ■ containers
- electrical cabinets and anything that needs more than just a rivet



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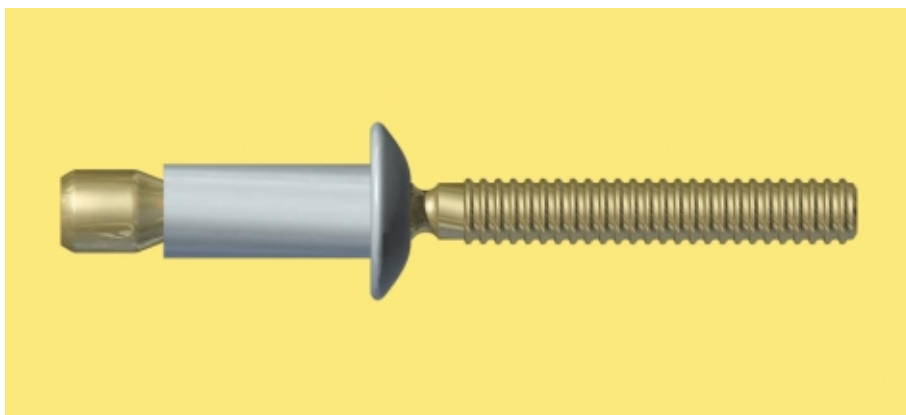
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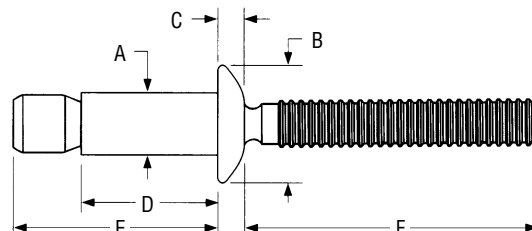
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Magna-Lok® Blind Fastener

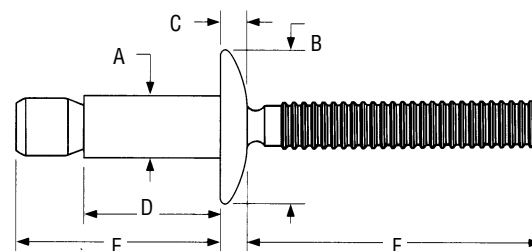


Fastener Specifications and Grip Data



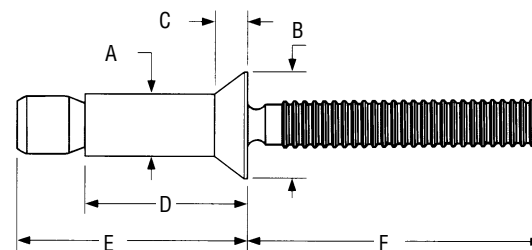
Protruding Head

Dia.	Steel	Aluminium	Stainless	Grip Range	Hole Size	A	B	C	D	E	F
4.8mm (3/16")	MGLP-R6-4	MGLP-B6-4	MGLP-U6-4	1.57 - 6.86	4.85 - 5.11	4.78	9.78	2.16	10.54	17.15	25.40
	MGLP-R6-7	MGLP-B6-7	MGLP-U6-7	5.44 - 11.10	4.85 - 5.11	4.78	9.78	2.16	14.53	20.96	25.40
	MGLP-R6-E	MGLP-B6-E		1.57 - 11.10	4.85 - 5.11	4.78	9.78	2.16	14.53	24.13	25.40
6.4mm (1/4")	MGLP-R8-6	MGLP-B8-6	MGLP-U8-6	2.03 - 9.53	6.63 - 6.91	6.43	13.34	2.97	14.22	24.64	25.40
	MGLP-R8-10	MGLP-B8-10	MGLP-U8-10	8.89 - 15.88	6.63 - 6.91	6.43	13.34	2.97	20.57	30.99	25.40
	MGLP-R8-E	MGLP-B8-E		2.03 - 15.88	6.63 - 6.91	6.43	13.34	2.97	20.57	35.69	25.40
9.5mm (3/8")	MGLP-R12-12	MGLP-B12-12		3.05 - 14.22	9.96 - 10.36	9.80	19.99	4.45	21.34	41.91	39.24



Truss Head

Dia.	Steel	Aluminium	Grip Range	Hole Size	A	B	C	D	E	F
4.8mm (3/16")	MGLT-R6-4	MGLT-B6-4	1.57 - 6.86	4.85 - 5.11	4.75	12.70	2.16	10.54	17.15	25.40
	MGLT-R6-7*	MGLT-B6-7*	5.44 - 11.10	4.85 - 5.11	4.75	12.70	2.16	14.53	20.96	25.40
	MGLT-R6-E	MGLT-B6-E*	1.57 - 11.10	4.85 - 5.11	4.75	12.70	2.16	14.53	24.13	25.40
6.4mm (1/4")	MGLT-R8-6*	MGLT-B8-6*	2.03 - 9.53	6.63 - 6.91	6.43	14.94	2.97	14.22	24.64	25.40
	MGLT-R8-10*	MGLT-B8-10*	8.89 - 15.88	6.63 - 6.91	6.43	14.94	2.97	20.57	30.99	25.40
	MGLT-R8-E*	MGLT-B8-E*	2.03 - 15.88	6.63 - 6.91	6.43	14.94	2.97	20.57	35.69	25.40



100° Countersunk Head

Dia.	Steel	Aluminium	Stainless	Grip Range	Hole Size	A	B	C	D	E	F
4.8mm (3/16")	MGL100-R6-6	MGL100-B6-6	MGL100-U6-6*	3.18 - 8.41	4.85 - 5.11	4.78	8.76	1.78	12.34	19.35	25.40
	MGL100-R6-9	MGL100-B6-9	MGL100-U6-9*	7.75 - 12.70	4.85 - 5.11	4.78	8.76	1.78	16.59	23.60	25.40
6.4mm (1/4")	MGL100-R8-8	MGL100-B8-8	MGL100-U8-8*	4.06 - 12.07	6.63 - 6.91	6.53	10.29	2.01	16.76	26.90	25.40
	MGL100-R8-12	MGL100-B8-12	MGL100-U8-12*	10.54 - 18.42	6.63 - 6.91	6.53	10.29	2.01	23.11	33.25	25.40

*Consult factory for availability. Note: Add a "U" prefix for parts that are compatible with Monobolt, tooling and nose assemblies (eg. UMGLP-R8-6).

Magna-Lok® Blind Fastener



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Magna-Lok® Blind Fastener

Typical Installed Values in Nominal Grip (N)

Material	Diameter	Shear	Tensile	Pin Retention
Steel	4.8 (3/16")	5783	4448	667
	6.4 (1/4")	11121	8229	1334
	9.5 (3/8")	26689	17793	2669
Aluminium	4.8 (3/16")	2669	2224	334
	6.4 (1/4")	5783	3959	445
	9.5 (3/8")	13122	8452	1112
Stainless	4.8 (3/16")	5783	4226	445
	6.4 (1/4")	10453	8006	890

Materials and Finishes

Material	Sleeve	Pin	Sleeve Finish	Pin Finish
Steel	Low	Medium	Zinc Plated	Zinc Plated
	Carbon Steel	Carbon Steel	Clear Chromate	Gold Chromate
Aluminium	5056	7075	Clear Chromate	Gold Chromate
Stainless	302	305/304	Passivated	Dry Lubricated

How to Order

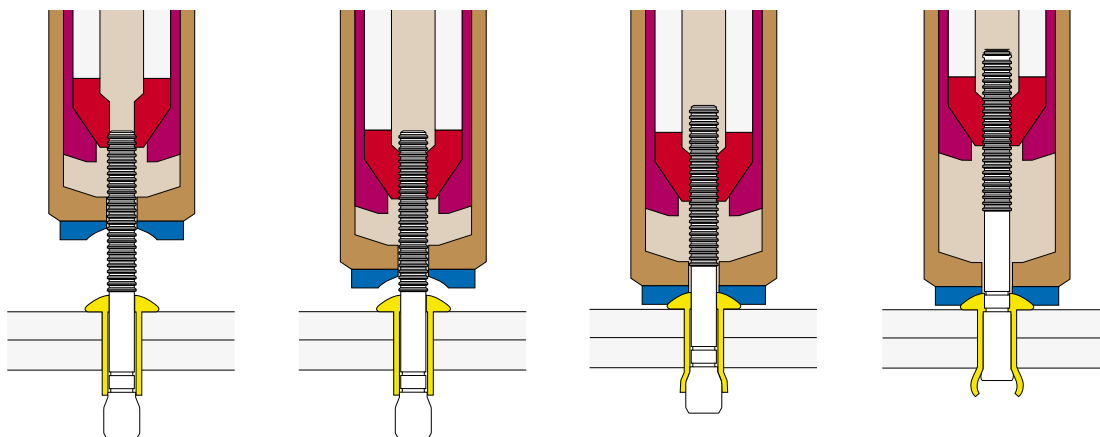
Follow the form below to construct a part number for ordering Magna-Lok blind fasteners. Refer to the Grip Data chart for grip numbers.

MGL (STYLE) - (MATERIAL) (DIAMETER) - (GRIP NUMBER)

Example: **MGLP-R6-4** is a Magna-Lok blind fastener, Protruding Head, Steel, 4.8mm (3/16") Diameter, Grip 4

Style		Material		Diameter	
Protruding Head	P	Steel	R	4.8 (3/16")	6
Truss Head	T	Aluminium	B	6.4 (1/4")	8
100° Countersunk Head	100	Stainless Steel	U	9.5 (3/8")	12

Installation Sequence



[Click Here to view animation of installation sequence](#)



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Magna-Lok® Installation Tooling

Huck Installation Tools

Huck installation tools consist of a nose assembly and a tool. The choice of tool and nose assembly is determined by the fastener diameter and application.

Tools and nose assemblies are easily changed as installation requirements demand. Huck offers pneumatic and hydraulic installation tools.

Pneumatic tools operate on 6.2-6.9 bar (90-100 psi) air pressure.

The lighter weight hydraulic tools operate on hydraulic power supplied by a Huck POWERIG® Hydraulic Unit.

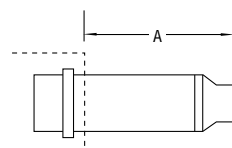


FIG 1

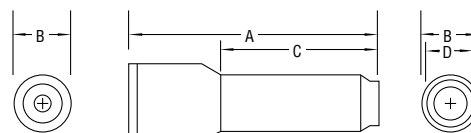


FIG 2

Code	Diameter	Nose Ass.	Fig.	A mm	B mm	C mm	D mm	Pneumatic Tooling	Hydraulic Tooling
6	4.8 mm (3/16")	99-3300	1	49.3	19.1	-	-	2025 / 2025V / LH-224	2480
		99-3303	1	55.9	19.1	-	-	2025 / 2025V / LH-224	2480
		99-3303L	1	55.9	19.1	-	-	2025L	2480L
		99-3304	1	157.5	19.1	-	-	2025 / 2025V / LH-224	2480
		Nose Assembly integral with Tool						241E	-
8	6.4 mm (1/4")	99-3301	1	49.3	19.1	-	-	2025 / 2025V / LH-224	2480
		99-3305	1	50.1	19.1	-	-	2025 / 2025V / LH-224	2480
		99-3305L	1	50.1	19.1	-	-	2025L	2480L
		99-3306	1	157.5	19.1	-	-	2025 / 2025V / LH-224	2480
		Nose Assembly integral with Tool						241E	-
12	9.5 mm (3/8")	99-3318	1	47.6	26.9	-	-	245 / 246 / 255 / 256	2503

Items in **bold** are part of our FOCUS Tooling Range

Note: Other tool and nose assembly combinations may be available for specific applications. Please contact Huck for details.

Installation Tooling



Huck Fasteners
an Alcoa business

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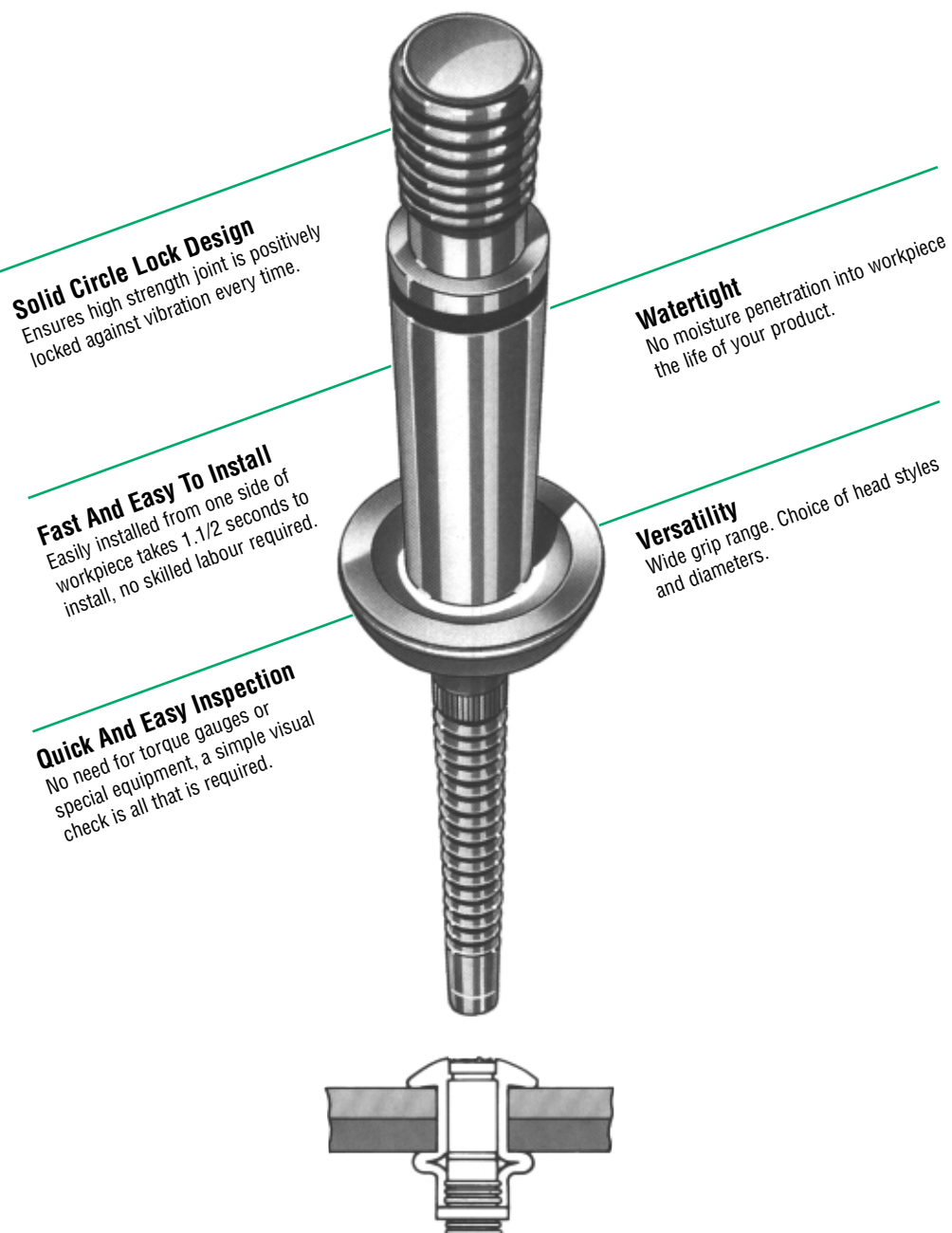
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Magna-Bulb® Blind Fastener

Magna-Bulb® Blind Fastener

A high strength blind fastener that produces a wide blind side footprint specifically designed for fastening thin sheet metal, giving a strong joint with enhanced pull through qualities. Magnabulb also comes with the "Huck Solid Circle Locking System".

This product is T.I.R. approved.



APPLICATIONS

- Commercial vehicle body building ■ buses ■ trains
- general sheet metal fabrication ■ ideally suited for automotive applications



Huck Fasteners
an Alcoa business

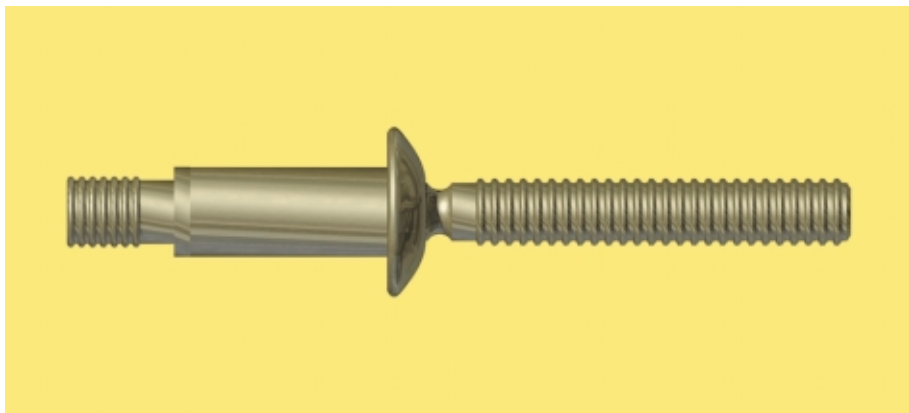
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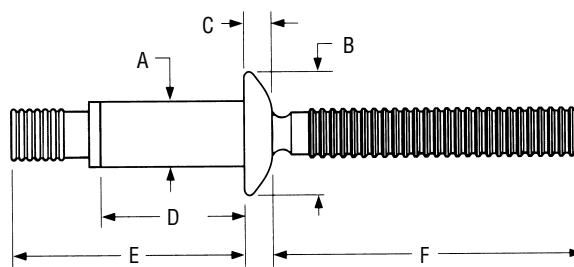
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Magna-Bulb® Blind Fastener



Fastener Specifications



Dia.	Part No.	Grip Range	Hole Size	A nom	B max	C max	D±0.18	E max	F min
4.8 (3/16")	MBP-R6-M1	1.02 - 2.41	4.85 - 5.11	4.75	9.78	2.57	8.89	15.80	25.40
	MBP-R6-M2	1.19 - 2.79	4.85 - 5.11	4.75	9.78	2.57	8.89	15.80	25.40
	MBP-R6-M3	2.21 - 3.81	4.85 - 5.11	4.75	9.78	2.57	9.91	16.79	25.40
	MBP-R6-M4	3.20 - 4.80	4.85 - 5.11	4.75	9.78	2.57	10.90	17.81	25.40
	MBP-R6-M5	4.19 - 5.79	4.85 - 5.11	4.75	9.78	2.57	11.89	18.85	25.40
	MBP-R6-M6	5.21 - 6.81	4.85 - 5.11	4.75	9.78	2.57	12.90	19.86	25.40
	MBP-R6-M7	6.20 - 7.80	4.85 - 5.11	4.75	9.78	2.57	13.89	20.85	25.40
	MBP-R6-M8	7.19 - 8.81	4.85 - 5.11	4.75	9.78	2.57	14.91	21.87	25.40
	MBP-R6-M9	8.20 - 9.80	4.85 - 5.11	4.75	9.78	2.57	15.90	22.86	25.40
	MBP-R6-M10	9.19 - 10.80	4.85 - 5.11	4.75	9.78	2.57	16.89	23.85	25.40
6.4 (1/4")	MBP-R8-M2	1.52 - 3.51	6.63 - 6.91	6.38	13.46	3.18	11.48	20.07	27.94
	MBP-R8-M3	2.79 - 4.80	6.63 - 6.91	6.38	13.46	3.18	12.75	22.61	27.94
	MBP-R8-M4	3.81 - 5.82	6.63 - 6.91	6.38	13.46	3.18	13.77	23.19	27.94
	MBP-R8-M5	4.80 - 6.81	6.63 - 6.91	6.38	13.46	3.18	14.76	23.88	27.94
	MBP-R8-M6	5.82 - 7.82	6.63 - 6.91	6.38	13.46	3.18	15.77	25.40	27.94
	MBP-R8-M7	6.81 - 8.79	6.63 - 6.91	6.38	13.46	3.18	16.76	26.42	27.94
	MBP-R8-M8	7.82 - 9.83	6.63 - 6.91	6.38	13.46	3.18	17.78	27.43	27.94
	MBP-R8-M9	8.79 - 10.80	6.63 - 6.91	6.38	13.46	3.18	18.77	28.45	27.94
	MBP-R8-M10	9.83 - 11.84	6.63 - 6.91	6.38	13.46	3.18	19.79	29.46	27.94
	MBP-R8-M11	10.80 - 12.80	6.63 - 6.91	6.38	13.46	3.18	20.78	30.48	27.94
	MBP-R8-M12	11.84 - 13.84	6.63 - 6.91	6.38	13.46	3.18	21.79	31.50	27.94
	MBP-R8-M13	12.80 - 14.81	6.63 - 6.91	6.38	13.46	3.18	22.78	32.51	27.94
7.9 (5/16")	MBP-R10-3	3.81 - 6.35	8.32 - 8.64	8.03	16.64	3.86		28.32	34.93

Typical Installed Values in Nominal Grip (N)

Diameter	Shear	Tensile	Pin Retention
4.8 mm (3/16")	7560	4890	667
6.4 mm (1/4")	16010	8900	1334
7.9 mm (5/16")	22240	13340	2091

Materials and Finishes

	Material	Finish
Sleeve	Steel	Zinc Plated with Gold Chromate
Pin	Steel	Zinc Plated with Gold Dichromate

How to Order

To order Magna-Bulb fasteners, specify the part number from the Fastener Specifications table above.

Magna-Bulb® Blind Fastener



Huck Fasteners
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Magna-Bulb® Installation Tooling

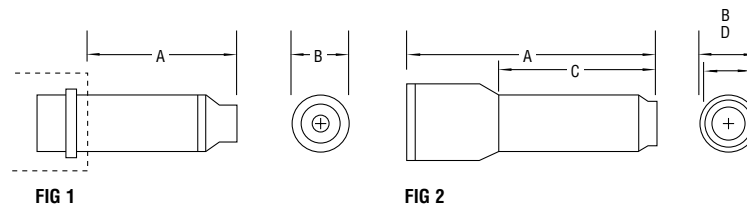
Huck Installation Tools

Huck installation tools consist of a nose assembly and a tool. The choice of tool and nose assembly is determined by the fastener diameter and application.

Tools and nose assemblies are easily changed as installation requirements demand. Huck offers pneumatic and hydraulic installation tools.

Pneumatic tools operate on 6.2-6.9 bar (90-100 psi) air pressure.

The lighter weight hydraulic tools operate on hydraulic power supplied by a Huck POWERIG® Hydraulic Unit.

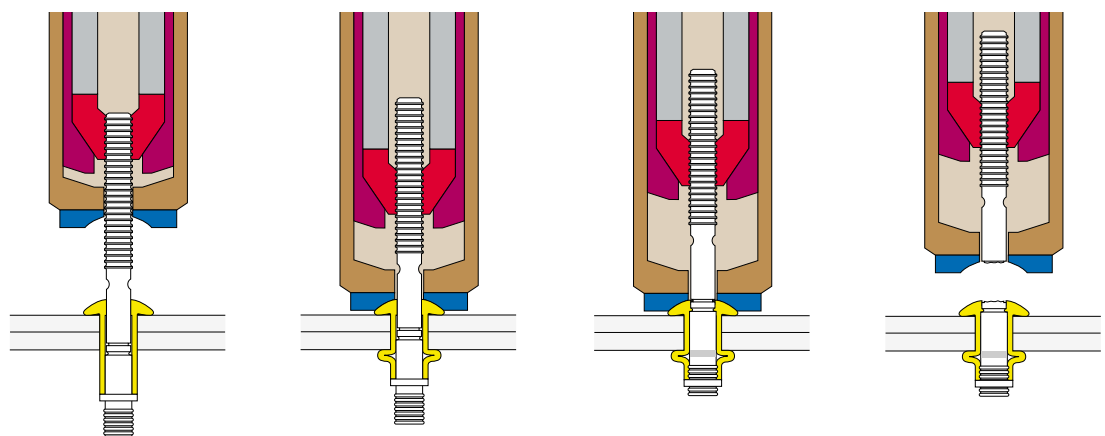


Code	Diameter	Nose Ass.	Fig.	A mm	B mm	C mm	D mm	Pneumatic Tooling	Hydraulic Tooling
6	4.8 mm (3/16")	99-3300	1	49.3	19.1	-	-	2025 / 2025V / LH-224	2480
		99-3303	1	55.9	19.1	-	-	2025 / 2025V / LH-224	2480
		99-3303L	1	55.9	19.1	-	-	2025L	2480L
		99-3304	1	157.5	19.1	-	-	2025 / 2025V / LH-224	2480
8	6.4 mm (1/4")	Nose Assembly integral with Tool						241E	-
		99-3301	1	49.3	19.1	-	-	2025 / 2025V / LH-224	2480
		99-3305	1	50.1	19.1	-	-	2025 / 2025V / LH-224	2480
		99-3305L	1	50.1	19.1	-	-	2025L	2480L
		99-3306	1	157.5	19.1	-	-	2025 / 2025V / LH-224	2480
10	7.9 mm (5/16")	Nose Assembly integral with Tool						241E	-
		99-3307	2	91.7	27.3	56.0	23.9	245 / 246 / 255 / 256	2503

Items in **bold** are part of our FOCUS Tooling Range

Note: Other tool and nose assembly combinations may be available for specific applications. Please contact Huck for details.

Installation Sequence



[Click Here to view animation of installation sequence](#)

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Autobulb® Blind Fastener

Autobulb® Blind Fastener

The Auto-Bulb fastener is designed to fulfil a market need for a high clamp blind fastener, for thin sheet applications. Large diameter head and broad bulb spread diffuses the load over a larger area.

Wider contact area
Wider, more uniform blind-side contact area means higher clamp with increased fatigue life.

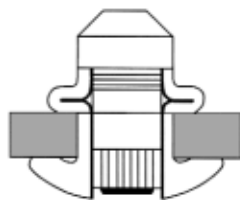
Better blind-side clearance
Suitable for a wide range of applications.

Superior grip overlap
Fewer parts, reduced inventory.

Controlled pin break
Consistent top quality results.

Same pin size
Cuts installation times with common tooling.

Lead-in chamfer
Aids easy installation, & suitable for automatic assembly equipment.



APPLICATIONS

- Automotive ■ Commercial vehicle bodies ■ Trailers
- Buses ■ Trains ■ General sheet metal fabrication



Huck Fasteners
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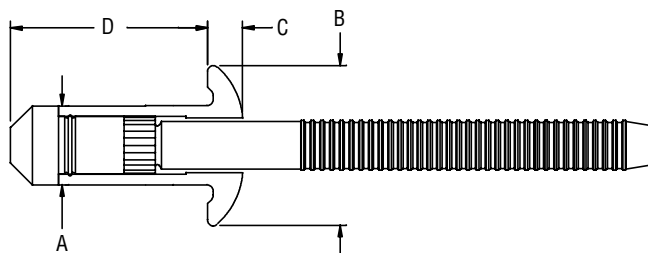
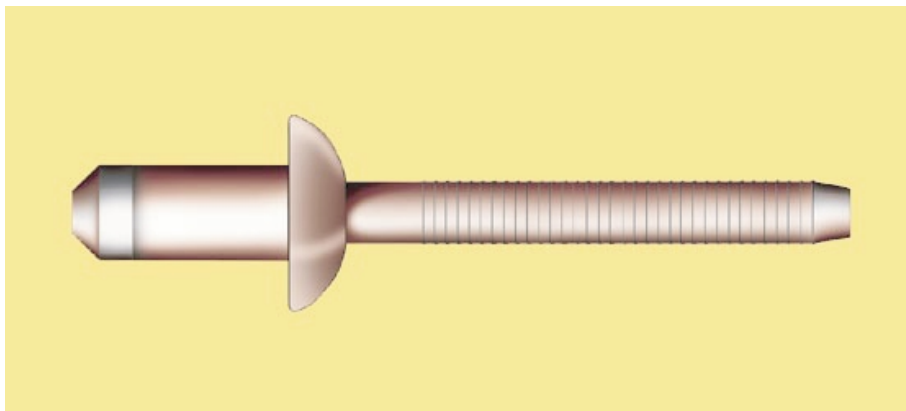
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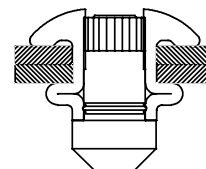
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Auto-Bulb® Blind Fastener

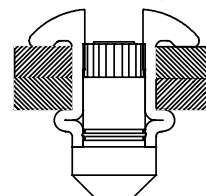
The Auto-Bulb® fastener provides a large diameter head and broad bulb spread that diffuses the load over a larger area, ensuring permanent clamp. This unique fastener also offers a tapered hole-seeking tip, which provides for quick and easy installation.



Min. Grip



Max. Grip



Specifications

Dia. (No.)	Part No.	Grip Range	D max
4.76mm (3/16") (6)	ABP-R6-M2	19.05-2.79mm (0.075"-0.110")	11.96mm (0.471")
Hole Size= 4.85-5.11mm (0.191"-0.201")	ABP-R6-M3	22.12-3.81mm (0.087"-0.150")	12.95mm (0.510")
A nom= 4.83mm (0.190")	ABP-R6-M4	3.20-4.80mm (0.126"-0.189")	13.97mm (0.550")
B max= 9.53mm (0.375")	ABP-R6-M5	4.19-5.79mm (0.165"-0.228")	14.96mm (0.589")
C max= 2.57mm (0.101")	ABP-R6-M6	5.21-6.81mm (0.205"-0.268")	15.98mm (0.629")
	ABP-R6-M7	6.20-7.80mm (0.244"-0.307")	16.97mm (0.668")
	ABP-R6-M8	7.19-8.81mm (0.283"-0.347")	17.98mm (0.708")
	ABP-R6-M9	8.20-9.80mm (0.323"-0.386")	18.97mm (0.747")
	ABP-R6-M10	9.19-10.80mm (0.362"-0.425")	19.99mm (0.787")
	ABP-R6-M11	10.21-11.81mm (0.402"-0.465")	20.98mm (0.826")
	ABP-R6-M12	11.20-12.75mm (0.441"-0.502")	22.00mm (0.866")
	ABP-R6-M13	12.22-13.82mm (0.481"-0.544")	22.99mm (0.905")
	ABP-R6-M14	13.21-14.81mm (0.520"-0.583")	24.00mm (0.945")
	ABP-R6-M15	14.22-15.82mm (0.560"-0.623")	24.99mm (0.984")
	ABP-R6-M16	15.21-16.81mm (0.599"-0.662")	26.01mm (1.024")
	ABP-R6-M17	16.23-17.83mm (0.639"-0.702")	27.00mm (1.063")
	ABP-R6-M18	17.22-18.82mm (0.678"-0.741")	28.02mm (1.103")

Specifications

Dia. (No.)	Part No.	Grip Range	D max
6.35mm (1/4") (8)	ABP-R8-M2	1.52-3.51mm (0.060"-0.138")	15.80mm (0.622")
Hole Size= 6.63-6.91mm (0.261"-0.272")	ABP-R8-M3	2.79-4.80mm (0.110"-0.189")	17.09mm (0.673")
A nom= 6.60mm (0.260")	ABP-R8-M4	3.81-5.82mm (0.150"-0.229")	18.11mm (0.713")
B max= 13.00mm (0.512")	ABP-R8-M5	4.80-6.81mm (0.189"-0.268")	19.10mm (0.752")
C max= 2.84mm (0.112")	ABP-R8-M6	5.82-7.82mm (0.229"-0.308")	20.12mm (0.792")
	ABP-R8-M7	6.81-8.79mm (0.268"-0.346")	21.11mm (0.831")
	ABP-R8-M8	7.82-9.83mm (0.308"-0.387")	22.12mm (0.871")
	ABP-R8-M9	8.79-10.80mm (0.346"-0.425")	23.11mm (0.910")
	ABP-R8-M10	9.83-11.84mm (0.387"-0.466")	24.13mm (0.950")
	ABP-R8-M19	18.82-20.83mm (0.741"-0.820")	33.15mm (1.305")

Auto-Bulb® Blind Fastener



Huck Fasteners
an Alcoa business

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Auto-Bulb® Blind Fastener

Typical Installed Values in Nominal Grip N

Dia.	Shear	Tensile	Pin Retention
4.76mm (3/16")	5340	3780	670
6.35mm (1/4")	11570	7120	1330

Material and Finish

Dia.	Material	Finish
Sleeve	Steel	Zinc Plated Gold Chromate
Pin	Steel	Zinc Plated Gold Dichromate

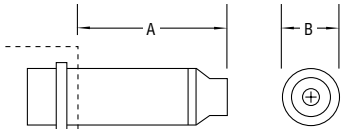


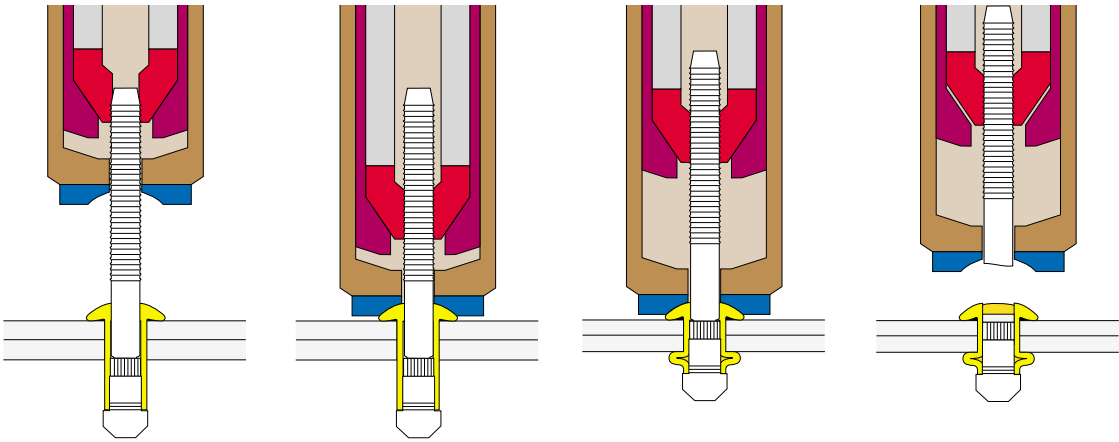
FIG 1

Code	Diameter	Nose Ass.	Fig.	A mm	B mm	C mm	D mm	Pneumatic Tooling	Hydraulic Tooling
6	4.8 mm (3/16")	99-3300	1	49.3	19.1	-	-	2025 / 2025V / LH-224	2480
		99-3303	1	55.9	19.1	-	-	2025 / 2025V / LH-224	2480
		99-3303L	1	55.9	19.1	-	-	2025L	2480L
		99-3304	1	157.5	19.1	-	-	2025 / 2025V / LH-224	2480
		Nose Assembly integral with Tool						241E	-
8	6.4 mm (1/4")	99-3301	1	49.3	19.1	-	-	2025 / 2025V / LH-224	2480
		99-3305	1	50.1	19.1	-	-	2025 / 2025V / LH-224	2480
		99-3305L	1	50.1	19.1	-	-	2025L	2480L
		99-3306	1	157.5	19.1	-	-	2025 / 2025V / LH-224	2480
		Nose Assembly integral with Tool						241E	-

Items in **bold** are part of our FOCUS Tooling Range

Note: Other tool and nose assembly combinations may be available for specific applications. Please contact Huck for details.

Installation Sequence



[Click Here to view animation of installation sequence](#)



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Magna-Tite® Blind Fastener

Magna-Tite® Blind Fastener

A blind high strength fastener with an advanced watertight seal, a large blind side footprint and a wide grip range, providing a strong joint with high resistance to vibration. Available in 4.8mm (3/16") diameter with a range of head styles to suit the application.

Built-in Lock Design
Ensures high strength joint is positively locked against vibration every time.

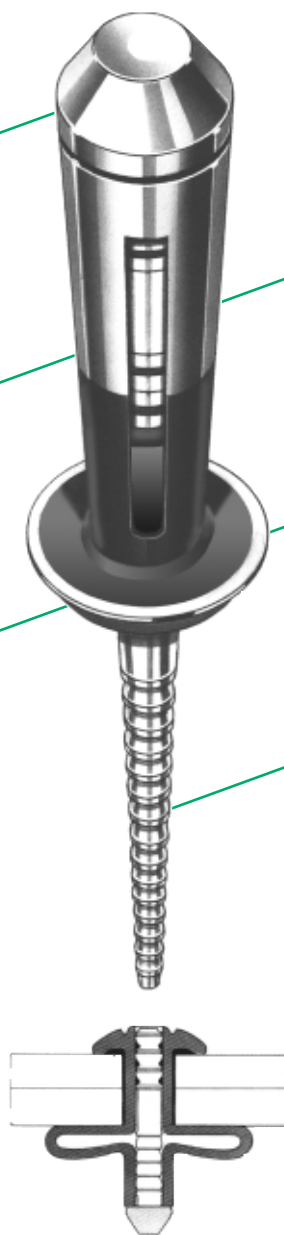
Fast and Easy Installation
Simple installation by unskilled labour increases productivity and reduces time and cost.

Quick and Easy Inspection
A simple visual check is all that is required.

Weathertight
Advanced polymer, applied at the factory, creates an extremely effective seal to keep the fastener watertight. Better life of your product.

Versatility
Wide grip range and choice of head styles.

Quiet Installation
A quiet, less-stressful installation for improved work environment and worker health and safety



APPLICATIONS

- Roofing and cladding
 - Caravans
- Commercial vehicles
- Sheet metal fabrication



Huck Fasteners
an Alcoa business

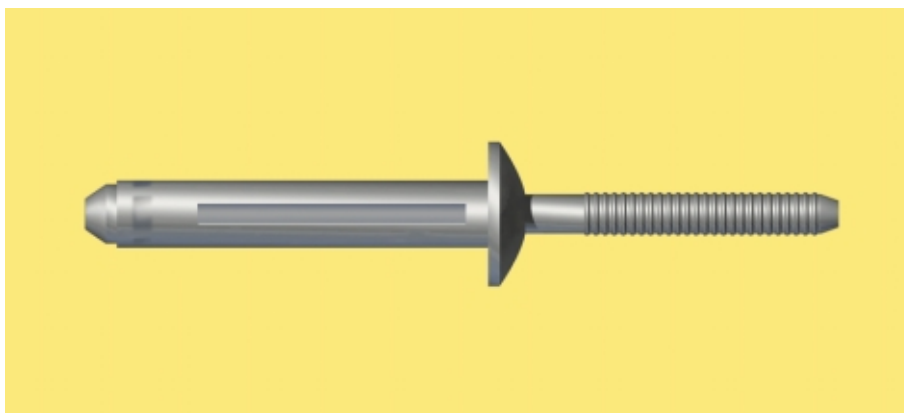
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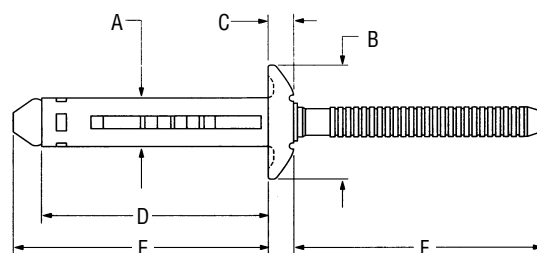
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Magna-Tite® Blind Fastener

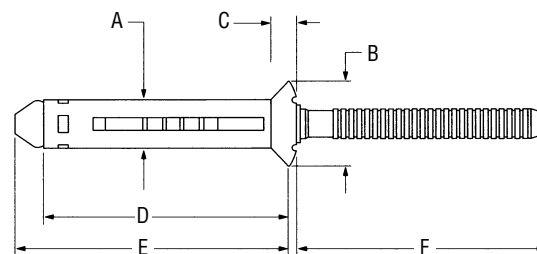


Fastener Specifications



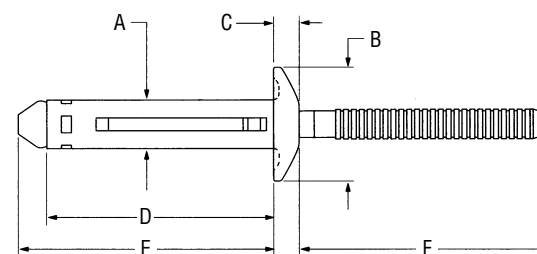
Protruding Head

Dia.	Grip Range	Part No.	Hole Size	A nom	B nom	C nom	D max	E max	F min
4.8	1.27 - 7.92	MTP-B6-5S	5.21 - 5.61	5.05	11.51	2.97	22.61	25.91	23.88
	2.54 - 9.53	MTP-B6-6S	5.21 - 5.61	5.05	11.51	2.97	23.88	27.18	23.88
	6.35 - 12.70	MTP-B6-8S	5.21 - 5.61	5.05	11.51	2.97	27.69	30.99	23.88
	9.53 - 15.88	MTP-B6-10S	5.21 - 5.61	5.05	11.51	2.97	30.86	34.16	23.88
	12.70 - 19.05	MTP-B6-12S	5.21 - 5.61	5.05	11.51	2.97	34.04	37.34	23.88



100% Oval Head

Dia.	Grip Range	Part No.	Hole Size	A nom	B nom	C nom	D max	E max	F min
4.8	1.78 - 7.92	MTV-B6-5S	5.21 - 5.61	5.05	9.02	2.97	23.11	26.42	23.88
	4.06 - 10.41	MTV-B6-7S	5.21 - 5.61	5.05	9.02	2.97	25.65	28.96	23.88
	6.35 - 12.70	MTV-B6-8S	5.21 - 5.61	5.05	9.02	2.97	27.69	30.99	23.88
	9.53 - 15.88	MTV-B6-10S	5.21 - 5.61	5.05	9.02	2.97	30.86	34.16	23.88
	12.70 - 19.05	MTV-B6-12S	5.21 - 5.61	5.05	9.02	2.97	34.04	37.34	23.88



Shavable Head

Dia.	Grip Range	Part No.	Hole Size	A nom	B nom	C nom	D max	E max	F min
4.8	1.27 - 12.70	MTS-B6-8S	5.21 - 5.61	5.05	11.51	2.97	25.65	28.96	23.88
	1.27 - 19.05	MTS-B6-12S	5.21 - 5.61	5.05	11.51	2.97	32.00	35.31	23.88

Magna-Tite® Blind Fastener



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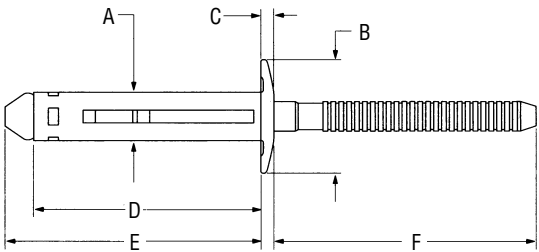
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Magna-Tite® Blind Fastener



Low Profile Head

Dia.	Grip Range	Part No.	Hole Size	A nom	B nom	C nom	D max	E max	F min
4.8	1.27 - 6.35	MTLP-B6-4	5.21 - 5.61	5.05	11.00	1.32	21.34	26.42	23.88
	4.75 - 12.70	MTLP-B6-8	5.21 - 5.61	5.05	11.00	1.32	27.69	28.96	23.88
	9.53 - 19.05	MTLP-B6-12	5.21 - 5.61	5.05	11.00	1.32	32.00	35.31	23.88
	1.27 - 19.05	MTLP-B6-12X	5.21 - 5.61	5.05	11.00	1.32	32.00	35.31	23.88

Typical Installed Values in grip=diameter (N)

Material	Diameter	Shear	Tensile	Pin Retention
Aluminium	4.8	2891	2002	445
Aluminium	4.8 MTLP (above min. grip)	1557	2002	445

How to Order

To order Magna-Bulb fasteners, specify the part number from the Fastener Specifications table above.



Huck Fasteners
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Installation Tooling

Magna-Tite® Installation Tooling

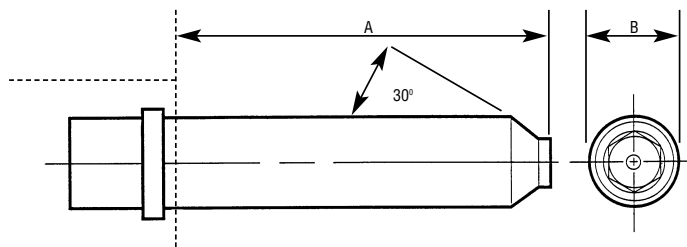
Huck Installation Tools

Huck installation tools consist of a nose assembly and a tool. The choice of tool and nose assembly is determined by the fastener diameter and application.

Tools and nose assemblies are easily changed as installation requirements demand. Huck offers pneumatic and hydraulic installation tools.

Pneumatic tools operate on 6.2-6.9 bar (90-100 psi) air pressure.

The lighter weight hydraulic tools operate on hydraulic power supplied by a Huck POWERIG® Hydraulic Unit.



Code	Diameter	Anvil Insert	Head	Nose Ass.	A mm	B mm	Pneumatic Tooling	Hydraulic Tooling
6	4.8 mm ($\frac{3}{16}$ ")	125180-06 ²	P	-	-	-	2015 ¹	
	-	-	-	99-3310F	56.9	19.0	2025 / 2025Y / LH-224	2480
	-	-	-	99-3310P	57.7	19.0	2025 / 2025Y / LH-224	2480
	-	-	-	99-3311B	159.3	19.0	2025 / 2025Y / LH-224	2480
	-	-	-	99-3311F	158.3	19.0	2025 / 2025Y / LH-224	2480
	-	-	-	99-3311P	159.3	19.0	2025 / 2025Y / LH-224	2480
8	6.4 mm ($\frac{1}{4}$ ")	-	-	99-3312F	57.7	19.0	2025 / 2025Y / LH-224	2480
	-	-	-	99-3312P	57.7	19.0	2025 / 2025Y / LH-224	2480
	-	-	-	99-3313F	158.5	19.0	2025 / 2025Y / LH-224	2480
	-	-	-	99-3313P	159.3	19.0	2025 / 2025Y / LH-224	2480
	-	-	-	-	-	-	-	-

F = Flat/Shavable Head Style

P = Protruding Head Style

Suffixes after Nose Assembly numbers:

F = For installing Flat/Shavable Head, P = For installing Protruding Head

Items in **bold** are part of our FOCUS Tooling Range

Note: Other tool and nose assembly combinations may be available for specific applications. Please contact Huck for details.



Huck Fasteners
an Alcoa business

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BOM® Blind Fastener

BOM® Blind Fastener

A high strength Blind Bolt, ideal for heavy duty joint applications in box and tube sections or where blind side access is restricted. Available in diameters 4.8mm (3/16") to 19.1mm (3/4") with a wide grip range.

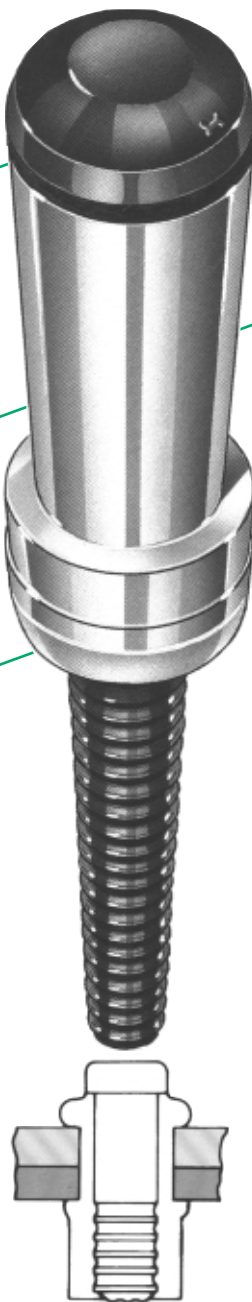
One side Installation
Lower labour costs, reduces access requirement on blind side.

Fast and Easy
Simple installation by unskilled labour increases productivity. Reduces time and cost.

High Strength and Vibration Resistance
Consistent joint integrity and reliability even in high vibration and shock loaded conditions.

Visual Inspection
Eliminate need to x-ray welds or torque check bolts. Saves time and cost.

Quiet Installation
Improved work environment and worker Health and Safety.



APPLICATIONS

- Bridge Construction/Repair ■ Railcar and Waggon
- Heating ventilation and Air Conditioning ■ Truck and Trailer ■ Mining Equipment
- Quarry Plant and Machinery ■ Construction ■ Containers ■ Ship Building



Huck Fasteners
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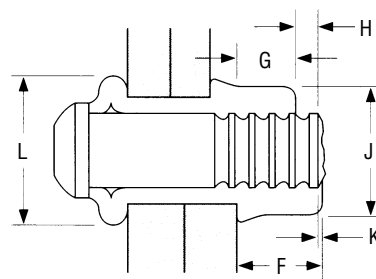
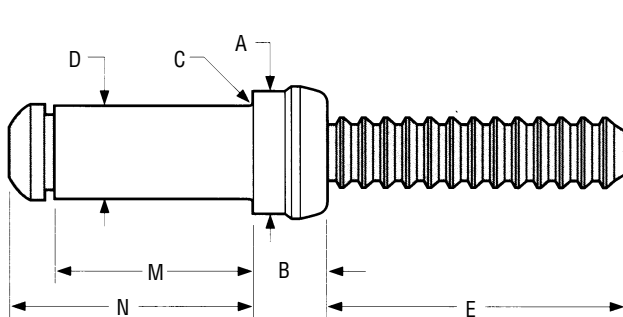
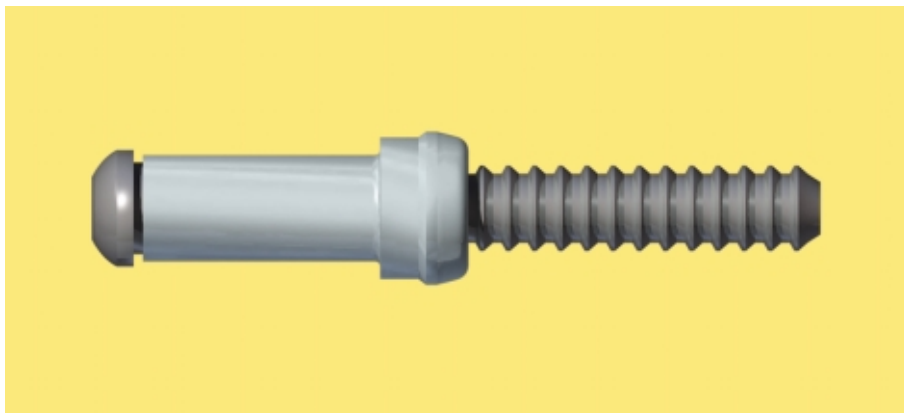
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BOM® Blind Fastener



Fastener Dimensions

Dia.	A	B	C max	D	E	F nom	G min	H max	J max	K max	L nom
4.8 mm (3/16")	7.26 - 7.01	3.86- 4.27	0.38	5.23- 4.98	19.94	4.50	2.78	2.38	6.63	0.79	7.77
6.4 mm (1/4")	9.65 - 9.35	5.21- 5.72	0.51	6.99- 6.65	21.84	5.89	3.97	2.38	8.79	0.79	10.29
7.9 mm (5/16")	12.14- 11.89	6.76- 7.06	0.64	8.79- 8.43	32.64	7.72	4.76	4.37	11.02	1.19	13.13
9.5 mm (3/8")	14.30- 14.05	8.00- 8.31	0.76	10.44- 9.98	31.24	9.07	5.16	4.37	12.95	1.19	15.37
12.7 mm (1/2")	19.15- 18.90	10.54- 11.13	0.89	13.82- 13.44	38.86	12.07	7.54	4.37	17.42	1.59	21.36
15.9 mm (5/8")	23.90- 23.65	12.88- 13.84	1.02	17.40- 16.81	43.43	15.11	10.32	7.94	22.20	1.98	26.37
19.1 mm (3/4")	28.70- 28.32	16.18- 16.61	1.27	20.98- 20.19	54.61	18.34	11.11	7.94	26.09	1.98	32.18

Grip Data and Dimensions

Grip No.	4.8mm (3/16") Dia Range	M ref	N max	6.4mm (1/4") Dia Range	M ref	N max	7.9mm (5/16") Dia Range	M ref	N max	9.5mm (3/8") Dia Range	M ref	N max
2	2.36 - 3.96	9.55	12.70	2.36 - 3.96	11.68	15.75						
3	3.99 - 5.56	11.15	14.27	3.99 - 5.56	13.28	17.32						
4	5.59 - 7.14	12.73	15.88	5.59 - 7.14	14.86	18.92	4.78 - 7.92	17.65	22.23	4.78 - 7.92	19.46	24.61
5	7.16 - 8.74	14.33	17.45	7.16 - 8.74	16.46	20.50						
6	8.76 - 10.31	15.90	19.05	8.76 - 10.31	18.03	22.10	7.95 - 11.10	20.83	25.40	7.95 - 11.10	22.63	27.79
7	10.34 - 11.91	17.50	20.62	10.34 - 11.91	19.63	23.67						
8	11.94 - 13.49	19.08	22.23	11.94 - 13.49	21.21	25.27	11.13 - 14.27	24.00	28.58	11.13 - 14.27	25.81	30.96
9	13.51 - 15.09	20.68	23.80	13.51 - 15.09	22.81	26.85						
10	15.11 - 16.66	22.25	25.40	15.11 - 16.66	24.38	28.45	14.30 - 17.45	27.18	31.75	14.30 - 17.45	28.98	34.14
11	16.69 - 18.26	23.85	26.97	16.69 - 18.26	25.98	30.02						
12	18.29 - 19.84	25.43	28.58	18.29 - 19.84	27.56	31.62	17.48 - 20.62	30.35	34.93	17.48 - 20.62	32.16	37.31
14							20.65 - 23.80	33.53	38.10	20.65 - 23.80	35.33	40.49
16							23.83 - 26.97	36.70	41.28	23.83 - 26.97	38.51	43.66
18										27.00 - 30.15	41.68	46.84
20										30.18 - 33.32	44.86	50.01

Grip No.	12.7mm (1/2") Dia Range	M ref	N max	15.9mm (5/8") Dia Range	M ref	N max	19.1mm (3/4") Dia Range	M ref	N max
4	6.38 - 9.53	25.40	32.16	6.38 - 12.70	30.81	38.89	6.38 - 12.70	35.05	44.45
6	9.55 - 12.70	28.58	35.33						
8	12.73 - 15.88	31.75	38.51	12.73 - 19.05	37.16	45.24	12.73 - 19.05	41.40	50.80
10	15.90 - 19.05	34.93	41.68						
12	19.08 - 22.23	38.10	44.86	19.08 - 25.40	43.51	51.59	19.08 - 25.40	47.75	57.15
14	22.25 - 25.40	41.28	48.03						
16	25.43 - 28.58	44.45	51.21	25.43 - 31.75	49.86	57.94	25.43 - 31.75	54.10	63.50
18	28.60 - 31.75	47.63	54.38						
20	31.78 - 34.93	50.80	57.56	31.78 - 38.10	56.21	64.29			
22	34.95 - 38.10	53.98	60.73						
24	38.10 - 41.28	57.15	63.91						

BOM® Blind Fastener



Huck Fasteners
an Alcoa business

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BOM® Blind Fastener

Minimum Installed Values in Nominal Grip N

Diameter	Shear	Tensile
4.8mm (3/16")	12460	8010
6.4mm (1/4")	22690	14460
7.9mm (5/16")	35810	23130
9.5mm (3/8")	49380	32250
12.7mm (1/2")	89630	57830
15.9mm (5/8")	126,770	91190
19.1mm (3/4")	200610	129440

Note: These are minimum ultimate shear and tensile strengths, in N, of installed fasteners, when tested in a grip equal to, or greater than, one and one half of the fastener diameter.

Hole Preparation Data

Diameter	Hole Diameter
4.8mm (3/16")	5.28 - 5.64
6.4mm (1/4")	7.04 - 7.42
7.9mm (5/16")	8.84 - 9.35
9.5mm (3/8")	10.49 - 11.05
12.7mm (1/2")	13.87 - 14.76
15.9mm (5/8")	17.45 - 18.49
19.1mm (3/4")	21.03 - 22.17

Material, Finish and Lubrication

	Material	Finish	Lubrication
Sleeve	Carbon Steel	Zinc plating per spec. ASTM B633 or ASTM B695 Meets specifications of QQ-Z-325 and MIL-C-81562	Wax Film
Pins	4.8mm - 7.9mm (3/16" - 5/16") Dia. 9.5mm - 19.1mm (3/8" - 3/4") Dia.	Carbon Steel Alloy Steel	None None
			Wax Film Wax Film

How to Order

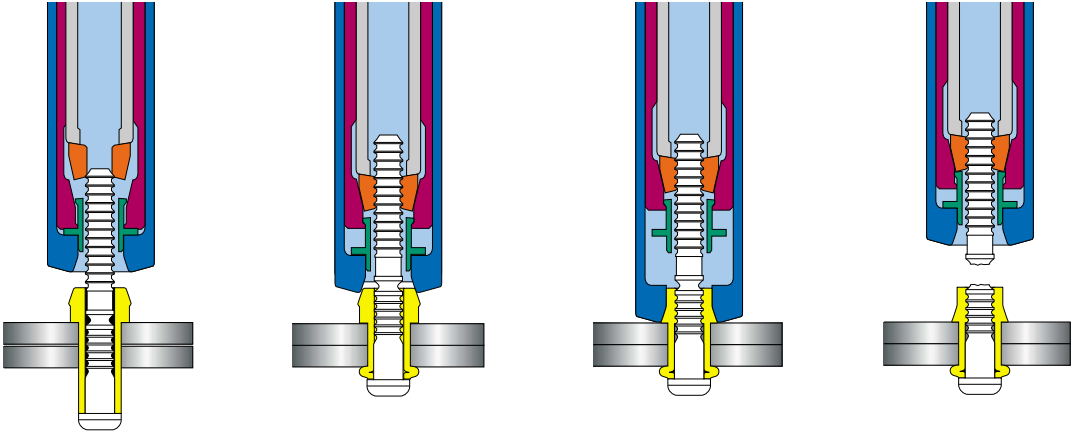
Follow the form below to construct a part number for ordering BOM blind fasteners. Refer to the Grip Data chart for grip numbers.

BOM-R (DIAMETER) - (GRIP NUMBER)

Example: **BOM-R8-6** is a BOM blind fastener, 6.4mm (1/4") Diameter, Grip 6

Diameter	
4.8mm (3/16")	6
6.4mm (1/4")	8
7.9mm (5/16")	10
9.5mm (3/8")	12
12.7mm (1/2")	16
15.9mm (5/8")	20
19.1mm (3/4")	24

Installation Sequence



[Click Here to view animation of installation sequence](#)



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BOM® Installation Tooling

Huck Installation Tools

Huck installation tools consist of a nose assembly and a tool. The choice of tool and nose assembly is determined by the fastener diameter and application.

Tools and nose assemblies are easily changed as installation requirements demand. Huck offers pneumatic and hydraulic installation tools. Pneumatic tools operate on 6.2-6.9 bar (90-100 psi) air pressure. The lighter weight hydraulic tools operate on hydraulic power supplied by a Huck POWERIG®, Hydraulic Unit.

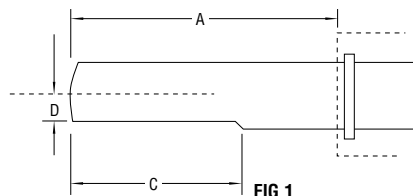


FIG 1

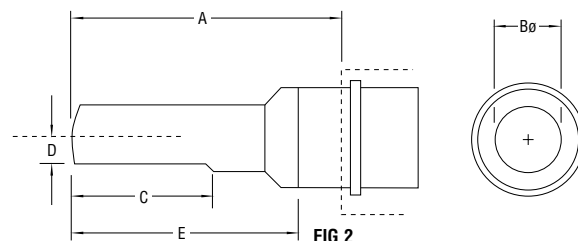


FIG 2

Code	Diameter	Nose Ass.	Fig.	A mm	B mm	C mm	D mm	E mm	Pneumatic Tooling	Hydraulic Tooling
6	4.8 mm (3/16")	99-994	1	45.6	19.1	34.0	8.5	-	-	2480
		99-1053	1	57.1	19.1	34.1	8.4	49.8	245 / 246 / 255 / 256	2503 / 2580
8	6.4 mm (1/4")	99-830-1	2	57.2	22.1	-	-	51.0	245 / 246 / 255 / 256	2503 / 2580
10	7.9 mm (5/16")	99-769	1	69.9	26.9	53.3	12.10	-	-	2503 / 2580
12	9.5 mm (3/8")	99-1272	1	69.7	26.9	52.8	12.7	-	-	2503 / 2580
16	12.7 mm (1/2")	99-5101	1	102.1	44.5	50.8	19.6	-	-	2620-PT
20	15.9 mm (5/8")	99-5102	2	103.6	52.3	50.8	22.4	94.5	-	2624 / 2628
24	19.1 mm (3/4")	99-5103	1	118.4	55.6	50.8	25.4	-	-	2624 / 2628

Items in **bold** are part of our FOCUS Tooling Range

Note: Other tool and nose assembly combinations may be available for specific applications. Please contact Huck for details.



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Floortight® Blind Fastener

Floortight® Blind Fastener

A unique blind fastener designed by Huck for the fastening of commercial vehicle floors. This fastener is fast, easy to use and gives superior fastener performance over conventional flooring fastener systems.

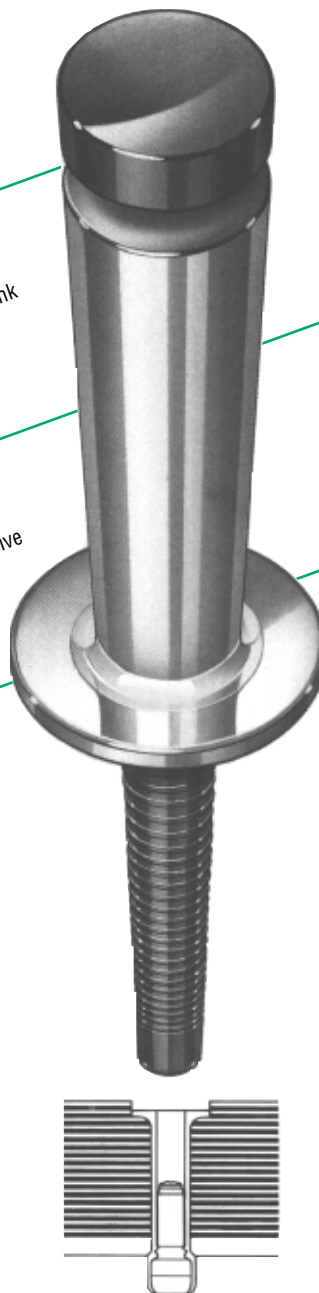
Self Countersinking
No pre-countersinking required. This fastener produces its own countersunk without damage to flooring panels.

One-Man One-Sided Installation
Easily installed, non labour intensive unlike conventional methods.

Superior Performance
High shear, clamp and tensile. No shifting or buckling of floor panels.

Removable
Allows easy access under floor panels.

Watertight
Prevents moisture ingress into floor panels. Gives longer life to floors.



APPLICATIONS

- Commercial vehicle body building and applications where flooring needs to be securely fastened



Huck Fasteners
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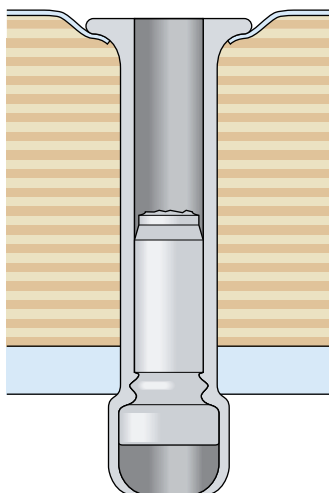
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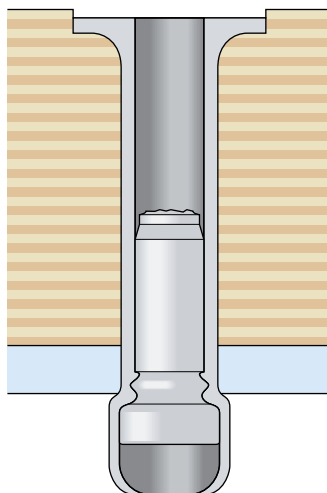
Floortight® Blind Fastener



Installation in plymetal - PMF

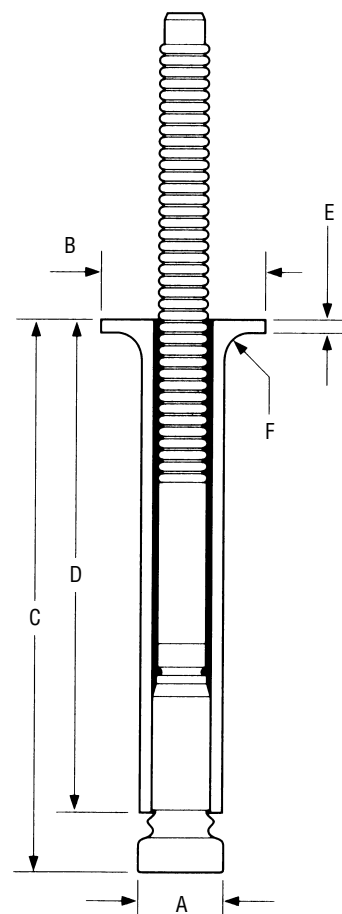


Installation in plywood - PWF



Fastener Dimensions

Part No.	Grip range	A max	B nom	C max	D nom	E nom	F radius
PMF-R10-20	19.05 - 34.93	8.26	14.22	53.98	44.45	1.27	3.18
PMF-R10-26	19.05 - 41.28	8.26	14.22	63.50	53.98	1.27	3.18
PWF-R10-20	19.05 - 34.93	8.26	17.15	53.98	44.45	1.27	3.18
PWF-R10-26	19.05 - 41.28	8.26	17.15	63.50	53.98	1.27	3.18



Typical Installed Values in Nominal Grip* (N)

Shear	Tensile	Pin Retention
15569	13345	890

*With pin in shear plane

Hole Preparation Data

Minimum	Maximum	Recommended
8.33	8.61	8.4 Drill

Material, Finish and Lubrication

	Material	Finish	Lubrication
Sleeve	Steel	Zinc electroplate with gold chromate	Dry film
Pin	Steel	Black	Wax film

Floortight® Blind Fastener



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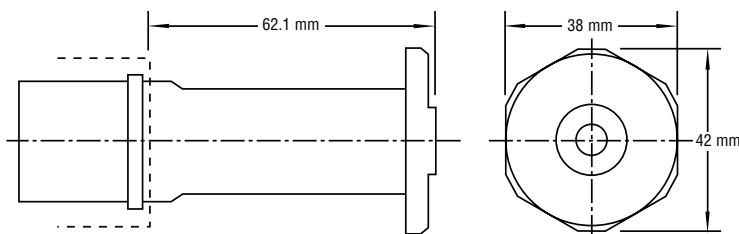
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Floortight® Installation Tooling

Huck Installation Tools

Huck installation tools consist of a nose assembly and a tool. The choice of tool and nose assembly is determined by the fastener diameter and application.

Tools and nose assemblies are easily changed as installation requirements demand. Huck offers pneumatic and hydraulic installation tools. Pneumatic tools operate on 6.2-6.9 bar (90-100 psi) air pressure. The lighter weight hydraulic tools operate on hydraulic power supplied by a Huck POWERIG® Hydraulic Unit.

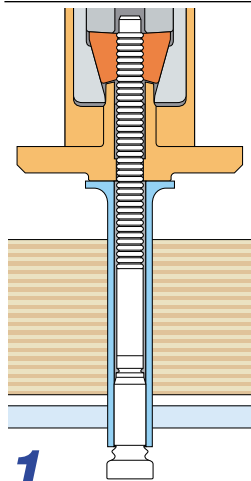


Code	Diameter	Nose Ass.	Pneumatic Tooling	Hydraulic Tooling
10	7.9 mm (5/16")	99-3452	*246 / 256	2503

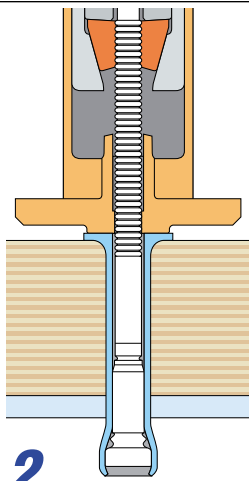
* Recommended for repair use only. Double stroking may be required.

Items in **bold** are part of our FOCUS Tooling Range

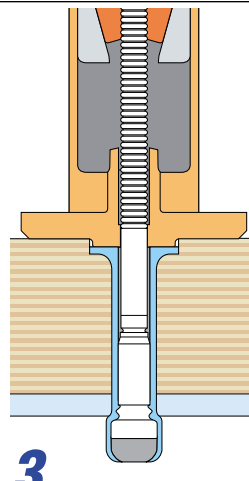
Installation Sequence



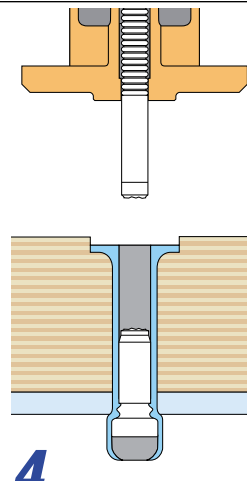
1
Insert fastener in hole. Apply installation tool.



2
The nose assembly (orange), attached to Huck's installation tool, is placed over the pintail (white). When the trigger is pressed, the nose assembly jaws (red) pull on the pintail, drawing the pin through the sleeve, causing the blind side sleeve to expand, partially setting the sleeve in the top sheet and pulling out all the sheet gap.



3
Continued pulling on the pintail forms a mechanical lock between the pin and sleeve end. The anvil on the installation tool then countersinks the fastener head into the top of the material to a preset depth set by the anvil. The anvil's large bearing face then prevents further travel of the sleeve head into the top material.



4
The pin is then separated in tension at the break neck groove. There is no projecting spindle to cut off in a separate operation.

[Click Here to view animation of installation sequence](#)

Installation Tooling



Huck Fasteners
an Alcoa business

Choosing your tooling

Many different types of installation Tooling Systems are available and the most popular combinations of Installation Tools, Nose Assemblies & Powerigs are shown in this CD. Other combinations of tooling components are available for specific applications and we would be pleased to discuss these with you if necessary.

To install any Huck fastener, the basic tooling requirement is:

- Installation Tool, (either Pneumatic or Hydraulic)
- Nose Assembly (to match with the Fastener and Tool)
- Powerig (for use with Hydraulic Tools)
- Additional Hose Set (sometimes required to connect Hydraulic Tools to the Powerigs)

With few exceptions, when using fasteners up to and including 9.5 mm(3/8") diameter, a choice can be made between Pneumatic and Hydraulic Tool systems. Hydraulic Tooling systems should always be used in high production situations since these tools are inherently more robust and have a greater service life than the pneumatic types.

When choosing pneumatic tools, be aware that the lightweight plastic tool, (ie the 241E), will not be as robust or have the same service life as the aluminium types (eg 2025 series).

Physical properties of tools are also an important consideration and these details are shown on each of the individual tool pages. Nose Assembly dimensions are shown in each of the fastener sections.

When choosing a Powerig for use with hydraulic tools, consider the power supply that you have available and that the Powerig operating hydraulic pressures match those of the tool. Also note that the higher the hydraulic output flow from the Powerig, the faster the tool will operate.

Please contact Huck if you need any help in selecting the best tooling system for your application.



2025

Pneudraulic
Installation Tool

Specifications

Weight:

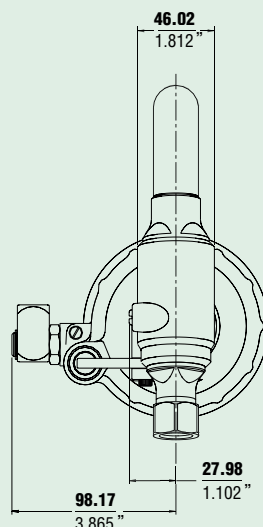
2.63 kg (5.75 lbs.)

Required Air Pressure:

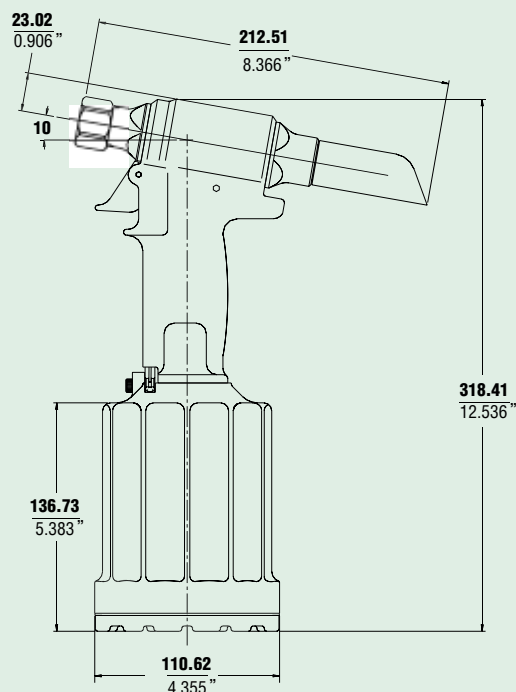
6.21-7.58 bar (90-110 psi)

*Air Consumption:*1.4 CFM (39.64 l/min) based on
30 cycles per minute*Stroke:*

17 mm (0.675 in.)

*Hydraulic Fluid:*Automatic Transmission Fluid
DEXTRON II® or equivalent*Capacity:*23.53 kN @ 6.21 bar
(5290 lbs @ 90 psi)

Top View



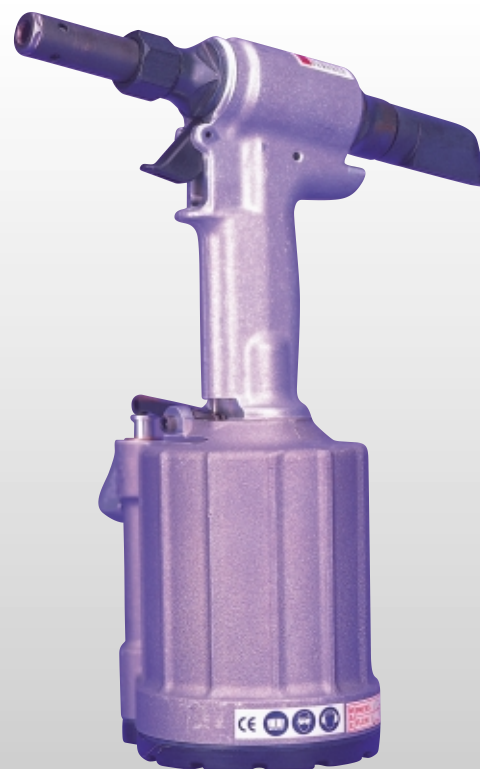
Nose assemblies are to be ordered separately

Compatible Fastener

Type	Diameter	Nose Assembly
MAGNA-LOK	4.8 mm (3/16")	99-3300, 99-3303, 99-3303L , 99-3304
	6.4 mm (1/4")	99-3301, 99-3305, 99-3305L , 99-3306, 99-3478 (H'Duty)
MAGNA-BULB	4.8 mm (3/16")	99-3300, 99-3303, 99-3303L , 99-3304
	6.4 mm (1/4")	99-3301, 99-3305, 99-3305L , 99-3306, 99-3478 (H'Duty)
AUTO-BULB	4.8 mm (3/16")	99-3300, 99-3303, 99-3303L , 99-3304
	6.4 mm (1/4")	99-3301, 99-3305, 99-3305L , 99-3306, 99-3478 (H'Duty)
MAGNA-TITE	4.8 mm (3/16")*	99-3310F, 99-311F
	4.8 mm (3/16")**	99-3310P, 99-3311P
	6.4 mm (1/4")*	99-3312F, 99-3313F
	6.4 mm (1/4")**	99-3312P, 99-3313P
C6L	4.8 mm (3/16")	99-3003, 99-3003L , 99-3004
	6.4 mm (1/4")	99-3006, 99-3006L , 99-3007
MAGNA-GRIP	4.8 mm (3/16")	99-3200, 99-1456, 99-1456L , 99-3202
	6.4 mm (1/4") St.	99-3203, 99-1458, 99-1458L , 99-3205
	6.4 mm (1/4") Al.	99-3212CC
HUCKTAINER	9.5 mm (3/8")	99-3464, 99-3464L

* S & LP Head Styles, ** V & P Head Styles

St. = Steel, Al. = Aluminium

Items in **bold** are part of our FOCUS Tooling Range

The 2025 offers a number of outstanding features, including an ergonomically designed handle, plated piston rods and efficient in-line piston.

An extended piston version (2025L) and vacuum assist pintail collection system version (2025V) are available.

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LH-224

Pneudraulic Installation Tool

Specifications

Weight:

2.8 kg (6.17 lbs.)

Required Air Pressure:

6.21-6.9 bar (90-100 psi)

Stroke:

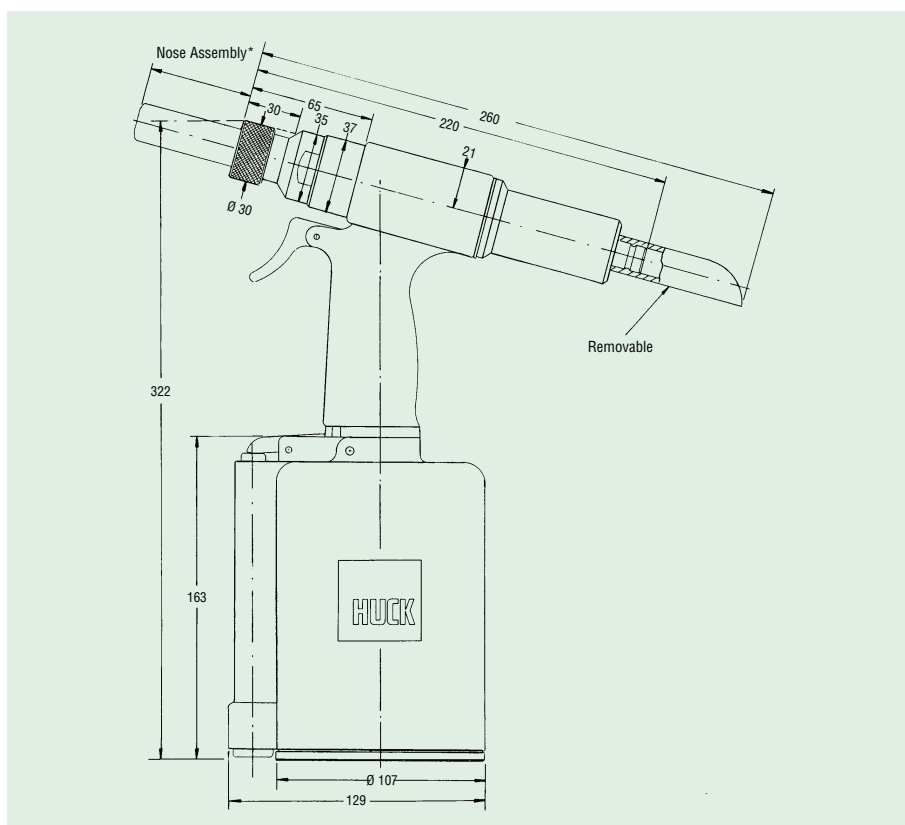
21 mm (0.828 in.)

Hydraulic Fluid:

Automatic Transmission Fluid
DEXTRON II® or equivalent

Capacity:

19 kN @ 6.21 bar
(4271 lbs @ 90 psi)



Nose assemblies are to be ordered separately

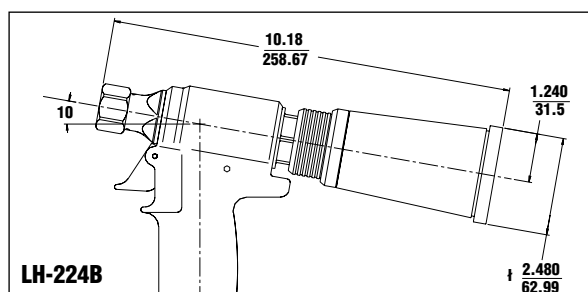
Compatible Fastener

Type	Diameter	Nose Assembly
MAGNA-LOK	4.8 mm (3/16")	99-3300, 99-3303 , 99-3304
	6.4 mm (1/4")	99-3301, 99-3305 , 99-3306
MAGNA-BULB	4.8 mm (3/16")	99-3300, 99-3303 , 99-3304
	6.4 mm (1/4")	99-3301, 99-3305 , 99-3306
AUTO-BULB	4.8 mm (3/16")	99-3300, 99-3303 , 99-3304
	6.4 mm (1/4")	99-3301, 99-3305 , 99-3306
MAGNA-TITE	4.8 mm (3/16")*	99-3310F, 99-3311F
	4.8 mm (3/16")**	99-3310P, 99-3311P
	6.4 mm (1/4")*	99-3312F, 99-3313F
	6.4 mm (1/4")**	99-3312P, 99-3313P
C6L	4.8 mm (3/16")	99-3003 , 99-3004
	6.4 mm (1/4")	99-3006 , 99-3007
MAGNA-GRIP	4.8 mm (3/16")	99-3200, 99-1456 , 99-3202
	6.4 mm (1/4") St.	99-3203, 99-1458 , 99-3205
	6.4 mm (1/4") Al.	99-3212CC

* S & LP Head Styles, ** V & P Head Styles

St. = Steel, Al. = Aluminium

Items in **bold** are part of our FOCUS Tooling Range



LH-224B

The LH-224 offers a number of outstanding features, including an ergonomically designed handle, plated piston rods and efficient in-line piston.

A version fitted with a pintail collector bottle is available (LH-224B).

Powerig



Huck Fasteners
an Alcoa business

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241E

Pneudraulic Powered Installation Tool

Specifications

Weight:

2.5 kg (5.5 lbs.)

Stroke:

23 mm (0.905 in.)

Required Air Pressure:

5.52-6.21 bar (80-90 psi)

Air Consumption per Cycle:

1.61 l/min @ 6 bar

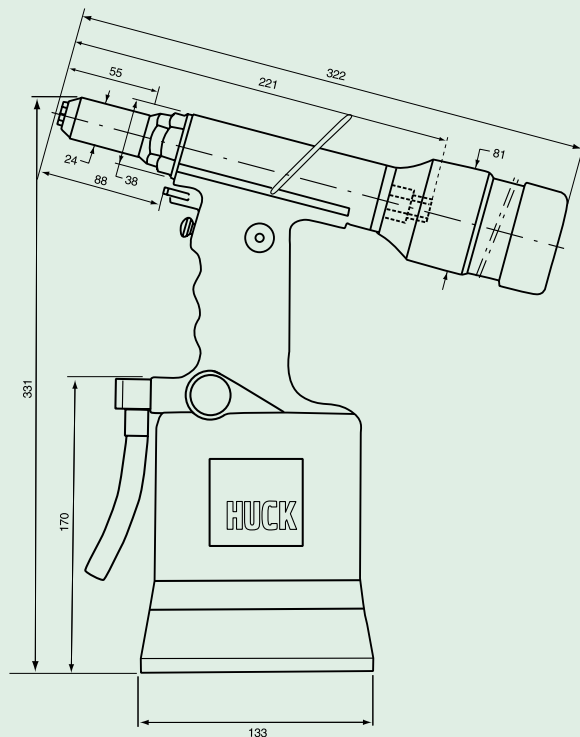
(0.057 ft³ @ 87 psi)

Capacity:

19.6 kN @ 87 bar

(4400 lbs @ 87 psi)

Part of the FOCUS Tooling Range



Nose assemblies are to be ordered separately

Compatible Fastener

Type	Diameter	Nose Assembly
MAGNA-LOK	4.8 mm (3/16")	Integral Nose Assembly and Anvil Inserts supplied with Tool
	6.4 mm (1/4")	
MAGNA-BULB	4.8 mm (3/16")	
	6.4 mm (1/4")	
AUTO-BULB	4.8 mm (3/16")	
	6.4 mm (1/4")	



The 241E is a lightweight plastic tool for the high-speed installation of HUCK's blind fasteners and nail type rivets. It features an integral nose assembly and a pintail collection bottle with a switchable vacuum system.

241E

Powerig



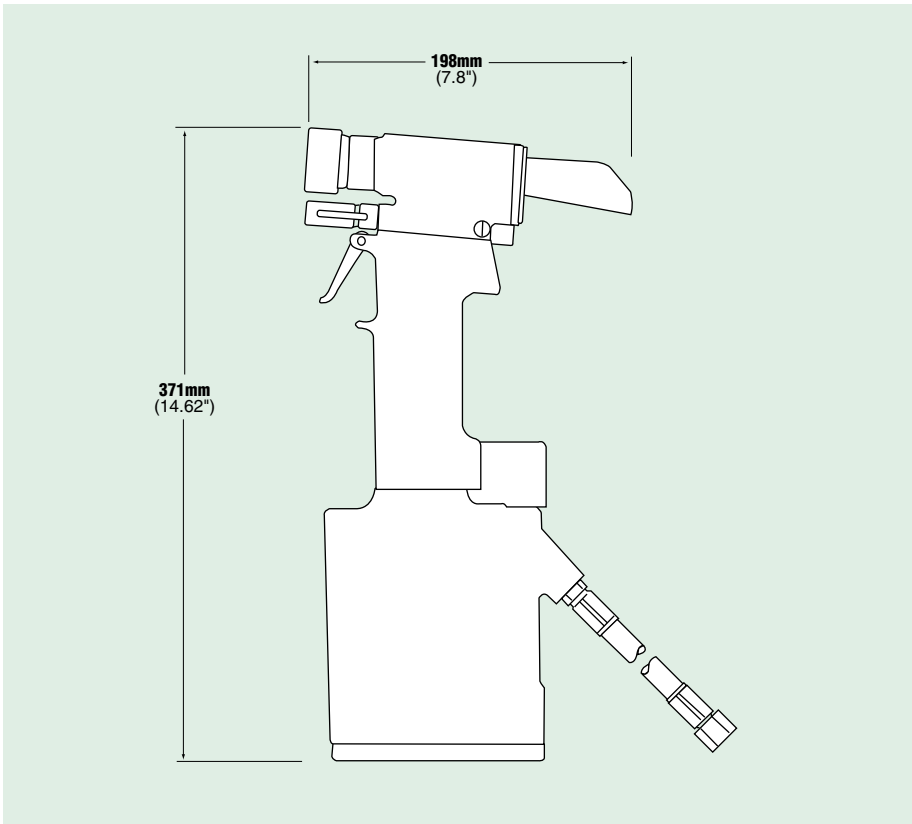
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an Alcoa business

245

Pneudraulic Powered Installation Tool

Specifications

Weight:
4.2 kg (9.3 lbs.)
Required Air Pressure:
6.21-6.9 bar (90-100 psi)
Stroke:
16 mm (0.623 in.)
Air Consumption:
20 CFM (566 l/min) based on 30 cycles per minute
Capacity:
34.47 kN @ 6.21 bar (7750 lbs @ 90 psi)



Nose assemblies are to be ordered separately

Compatible Fastener

Type	Diameter	Nose Assembly
BOM	4.8 mm (3/16")	99-1053
	6.4 mm (1/4")	99-830-1
MAGNA-LOK	9.5 mm (3/8")	99-3318
MAGNA-BULB	7.9 mm (5/16")	99-3307
C6L/C120L	4.8 mm (3/16")	99-2558
	6.4 mm (1/4")	99-2564
	7.9 mm (5/16")	99-99-245
	9.5 mm (3/8")	99-100-245 , 99-100-1D2
MAGNA-GRIP	4.8 mm (3/16")	99-3206
	6.4 mm (1/4")	99-3207
	7.9 mm (5/16")	99-1439
	9.5 mm (3/8")	99-1440
HUCKTAINER	9.5 mm (3/8")	99-3438

Items in **bold** are part of our FOCUS Tooling Range



The 245 is sized for high-speed production applications, up to 20 fastener installations per minute. This tool provides optimum stroke for one-cycle installations, and features an eccentric pull piston for limited clearance applications. Chrome-plated piston rods in the 245 extend the life of the seals.

246

Pneudraulic Installation Tool

Specifications

Weight:

5.8 kg (12.30 lbs.)

Required Air Pressure:

6.21-6.9 bar (90-100 psi)

Stroke:

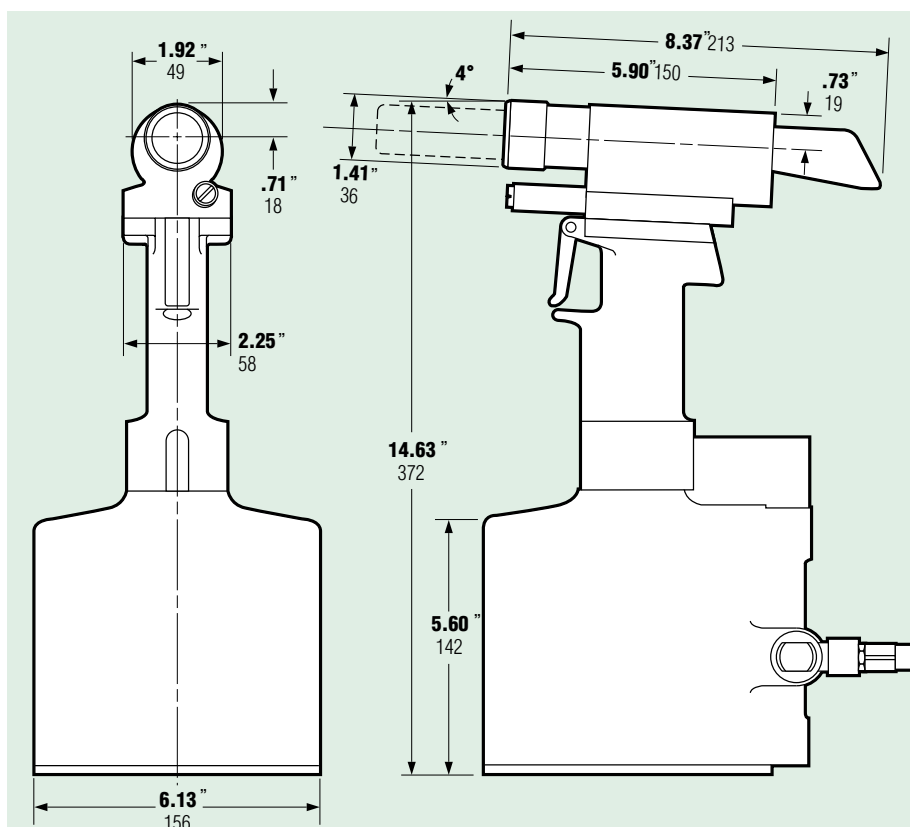
22 mm (0.88 in.)

Air Consumption:

30 CFM (849 l/min) based on
18-20 fastener
installations/minute

Capacity:

44.42 kN @ 621 bar
(9986 lbs @ 90 psi)



Nose assemblies are to be ordered separately

Compatible Fastener

Type	Diameter	Nose Assembly
BOM	4.8 mm (3/16")	99-1053
	6.4 mm (1/4")	99-830-1
MAGNA-LOK	9.5 mm (3/8")	99-3318
MAGNA-BULB	7.9 mm (5/16")	99-3307
C6L/C120L	4.8 mm (3/16")	99-2558
	6.4 mm (1/4")	99-2564
	7.9 mm (5/16")	99-99-245
	9.5 mm (3/8")	99-100-245 , 99-100-1D2
MAGNA-GRIP	4.8 mm (3/16")	99-3206
	6.4 mm (1/4")	99-3207
	7.9 mm (5/16")	99-1439
	9.5 mm (3/8")	99-1440
HUCKTAINER	9.5 mm (3/8")	99-3438
FLOORTIGHT	7.9 mm (5/16")	99-3452

Items in **bold** are part of our FOCUS Tooling Range



The 246 production tool features optimum stroke for one-cycle installation and has an eccentric pull piston for limited clearance applications. The Model 246 has chrome plated piston rods to extend the life of the seals.

255

Pneudraulic Powered
Installation Tool

Specifications

Weight:

3.99 kg (8.8 lbs.)

Required Air Pressure:

6.2-6.9 bar (90-100 psi)

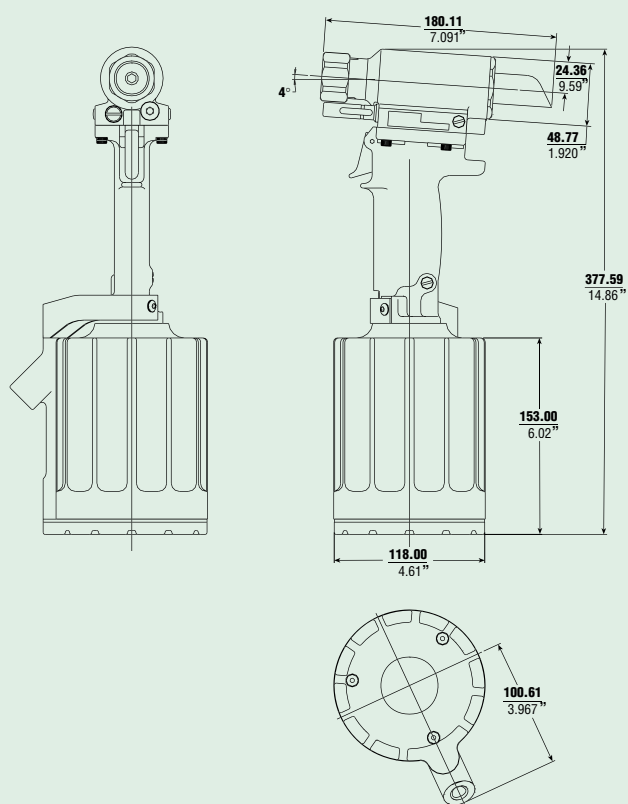
Stroke:

15.88 mm (.625 in.)

*Air Consumption:*20 CFM (561 l/min) based on
30 fastener installations/minute*Capacity:*

34.47 kN @ 6.2 bar

(7750 lbs @ 90 psi)



Nose assemblies are to be ordered separately

Compatible Fastener

Type	Diameter	Nose Assembly
BOM	4.8 mm (3/16")	99-1053
	6.4 mm (1/4")	99-830-1
MAGNA-LOK	9.5 mm (3/8")	99-3318
MAGNA-BULB	7.9 mm (5/16")	99-3307
C6L/C120L	4.8 mm (3/16")	99-2558
	6.4 mm (1/4")	99-2564
	7.9 mm (5/16")	99-99-245
	9.5 mm (3/8")	99-100-245 , 99-100-1D2
MAGNA-GRIP	4.8 mm (3/16")	99-3206
	6.4 mm (1/4")	99-3207
	7.9 mm (5/16")	99-1439
	9.5 mm (3/8") *	99-1440
HUCKTAINER	9.5 mm (3/8")	99-3438

* Aluminium only

Items in **bold** are part of our FOCUS Tooling Range

The 255 is sized for high-speed production applications, up to 20 fastener installations per minute. This tool provides optimum stroke for one-cycle installations, and features an pull piston for improved service life and ease of maintenance. Chrome-plated piston rods in the 255 extend the life of the seals.



256

Pneumatic
Installation Tool

Specifications

Weight:

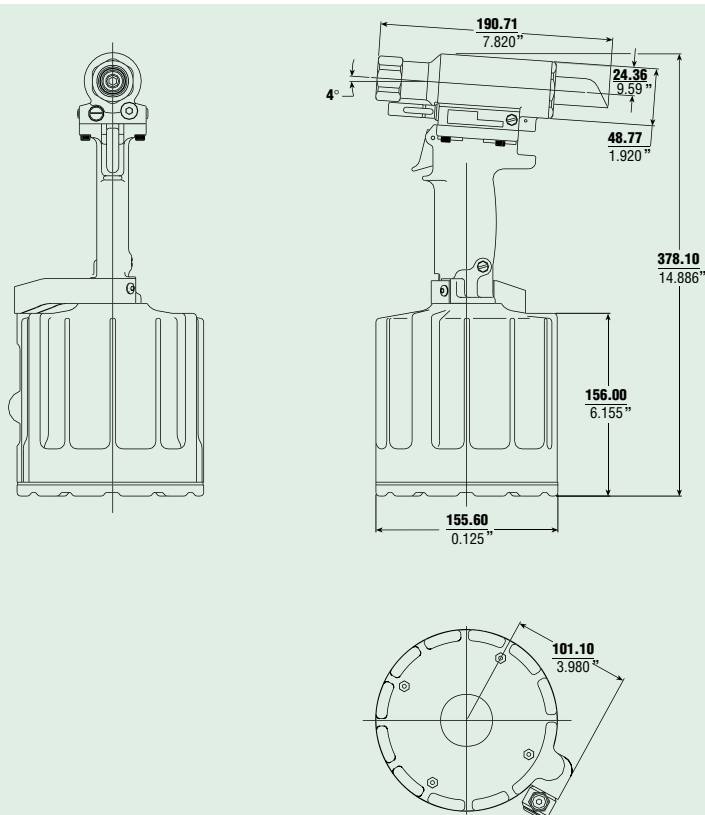
5.03 kg (11.10 lbs.)

Required Air Pressure:

6.2-7.59 bar (90-110 psi)

Stroke:

22.35 mm (0.88 in.)

*Air Consumption:*30 CFM (849 l/min) based on
18-20 fastener
installations/minute*Capacity:*44.42 kN @ 6.2 bar
(9986 lbs @ 90 psi)

Nose assemblies are to be ordered separately

Compatible Fastener

Type	Diameter	Nose Assembly
BOM	4.8 mm (3/16")	99-1053
	6.4 mm (1/4")	99-830-1
MAGNA-LOK	9.5 mm (3/8")	99-3318
MAGNA-BULB	7.9 mm (5/16")	99-3307
C6L/C120L	4.8 mm (3/16")	99-2558
	6.4 mm (1/4")	99-2564
	7.9 mm (5/16")	99-99-245
	9.5 mm (3/8")	99-100-245 , 99-100-1D2
MAGNA-GRIP	4.8 mm (3/16")	99-3206
	6.4 mm (1/4")	99-3207
	7.9 mm (5/16")	99-1439
	9.5 mm (3/8")	99-1440
HUCKTAINER	9.5 mm (3/8")	99-3438

Items in **bold** are part of our FOCUS Tooling Range

The high speed 256 production tool features optimum stroke for one-cycle installation and has an pull piston for improved service life and ease of maintenance. Factory tested for 2,000 cycles, the 256 has chrome plated piston rods to extend the life of the seals.



2480

Hydraulic Installation Tool

Specifications

Weight:

1 kg (2.2 lbs.)

Required Air Pressure:

6.21-6.9 bar (90-100 psi)

Stroke:

20.6 mm (0.85 in.)

Operating Hydraulic Pressures:

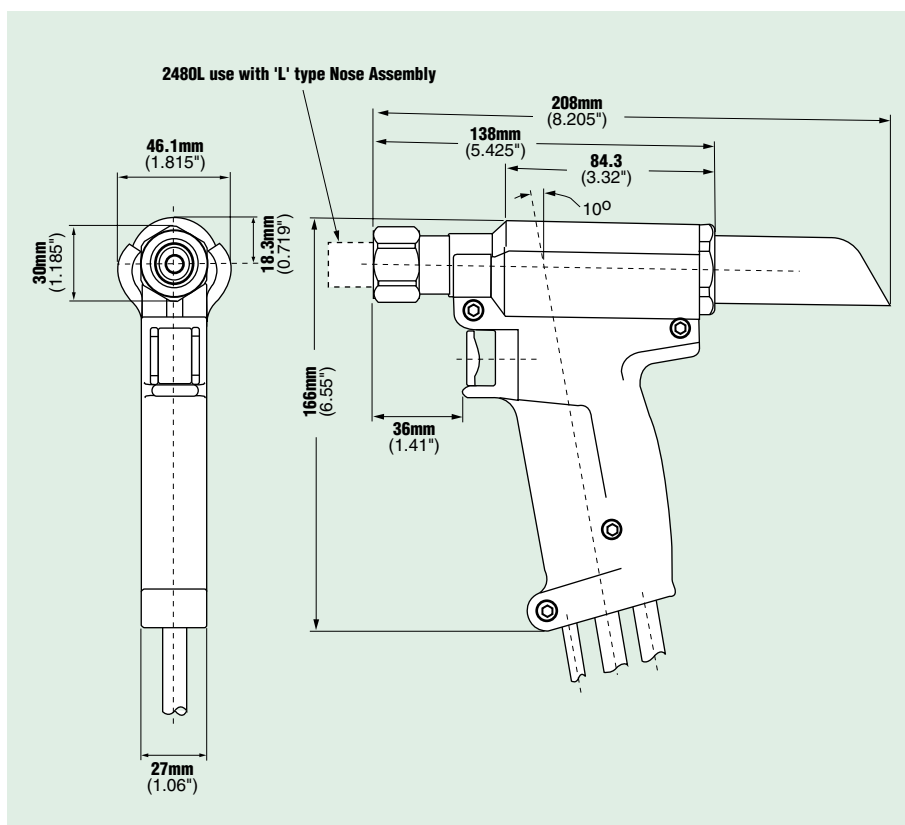
Pull- 579 bar (8400 psi)

Return- 221 bar (3200 psi)

Capacity:

25.4 kN @ 579 bar

(5700 lbs @ 8440 psi)



Compatible Fastener

Type	Diameter	Nose Assembly
BOM	4.8 mm (3/16")	99-994
MAGNA-LOK	4.8 mm (3/16")	99-3300, 99-3303 , 99-3303L , 99-3304
	6.4 mm (1/4")	99-3301, 99-3305 , 99-3305L , 99-3306, 99-3478 (H'Duty)
MAGNA-BULB	4.8 mm (3/16")	99-3300, 99-3303 , 99-3303L , 99-3304
	6.4 mm (1/4")	99-3301, 99-3305 , 99-3305L , 99-3306, 99-3478 (H'Duty)
AUTO-BULB	4.8 mm (3/16")	99-3300, 99-3303 , 99-3303L , 99-3304
	6.4 mm (1/4")	99-3301, 99-3305 , 99-3305L , 99-3306, 99-3478 (H'Duty)
MAGNA-TITE	4.8 mm (3/16")*	99-3310F, 99-311F
	4.8 mm (3/16")**	99-3310P, 99-3311P
	6.4 mm (1/4")*	99-3312F, 99-3313F
	6.4 mm (1/4")**	99-3312P, 99-3313P
C6L	4.8 mm (3/16")	99-3003 , 99-3003L , 99-3004
	6.4 mm (1/4")	99-3006 , 99-3006L , 99-3007
C120L	4.8 mm (3/16")	99-2561, 99-2565
MAGNA-GRIP	4.8 mm (3/16")	99-3200, 99-1456 , 99-1456L , 99-3202
	6.4 mm (1/4") St.	99-3203, 99-1458 , 99-1458L , 99-3205
	6.4 mm (1/4") Al.	99-3212CC
HUCKTAINER	9.5 mm (3/8")	99-3464 , 99-3464L

Nose assemblies are to be ordered separately



The 2480 is a very lightweight tool, which provides for the high-speed installation of a wide range of HUCK Blind and LockBolt fasteners. The tool has only one moving part for increased reliability and minimal maintenance.

An extended piston version is available (2480L) for use with 'L' type nose assemblies.

* S & LP Head Styles, ** V & P Head Styles
St. = Steel, Al. = Aluminium

Items in **bold** are part of our FOCUS Tooling Range



2503

Hydraulic Powered Installation Tool

Specifications

Weight:

2.2 kg (4.85 lbs.)

Stroke:

38 mm (1.3 in.)

Operating Hydraulic Pressures:

Pull- *393 bar (*5700 psi)

Return-152 bar (2,200 psi)

* For 9.5 mm (3/8") MG use 579 bar (8400 psi)

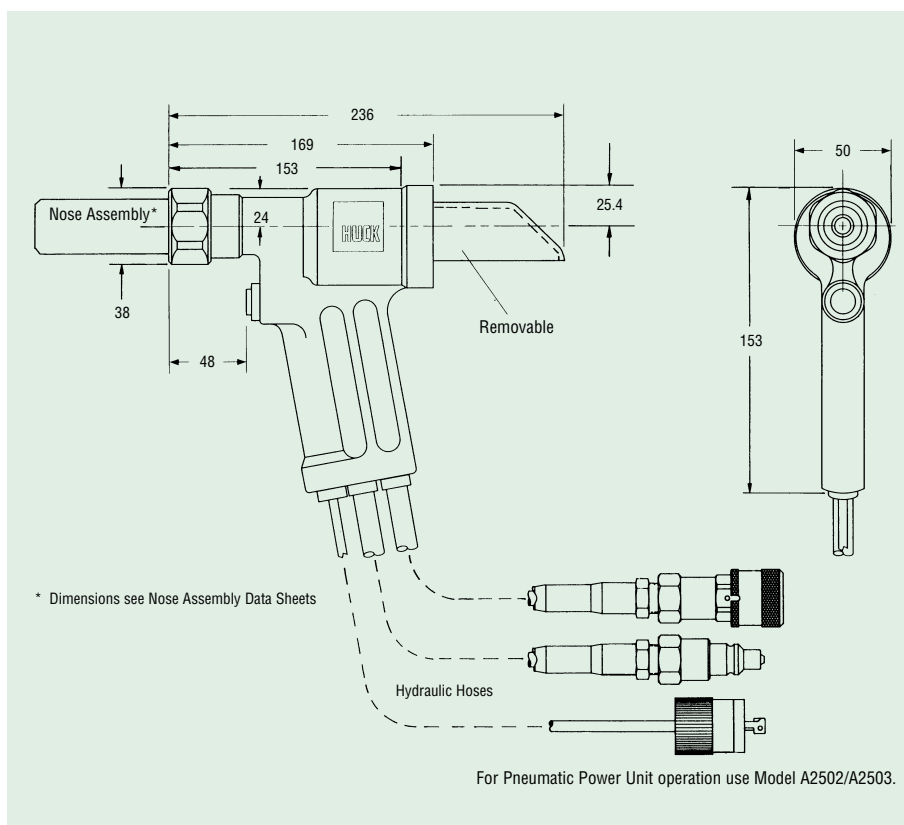
Capacity:

33.13 kN @ 393 bar

(7447 lbs @ 5700 psi)

49 kN @ 579 bar

(11013 lbs @ 8400 psi)

**Nose assemblies are to be ordered separately**

Compatible Fastener

Type	Diameter	Nose Assembly
BOM	4.8 mm (3/16")	99-1053
	6.4 mm (1/4")	99-830-1
	7.9 mm (5/16")	99-769
	9.5 mm (3/8")	99-1272
MAGNA-LOK	9.5 mm (3/8")	99-3318
MAGNA-BULB	7.9 mm (5/16")	99-3307
C6L/C120L	4.8 mm (3/16")	99-2558
	6.4 mm (1/4")	99-2564
	7.9 mm (5/16")	99-99-245
	9.5 mm (3/8")	99-100-245 , 99-100-1D2
MAGNA-GRIP	4.8 mm (3/16")	99-3206
	6.4 mm (1/4")	99-3207
	7.9 mm (5/16")	99-1439
	9.5 mm (3/8")	99-1440
HUCKTAINER	9.5 mm (3/8")	99-3438
FLOORTIGHT	7.9 mm (5/16")	99-3452

Items in **bold** are part of our FOCUS Tooling Range

The 2503 is a lightweight tool for use in a wide range of high-speed production applications. With only one moving part, the tool provides for increased reliability and requires minimal maintenance. An offset piston design allows the 2503 to easily fit in limited clearance applications.



2580**Hydraulic Powered
Installation Tool****Specifications***Weight:*

3 kg (6.58 lbs.)

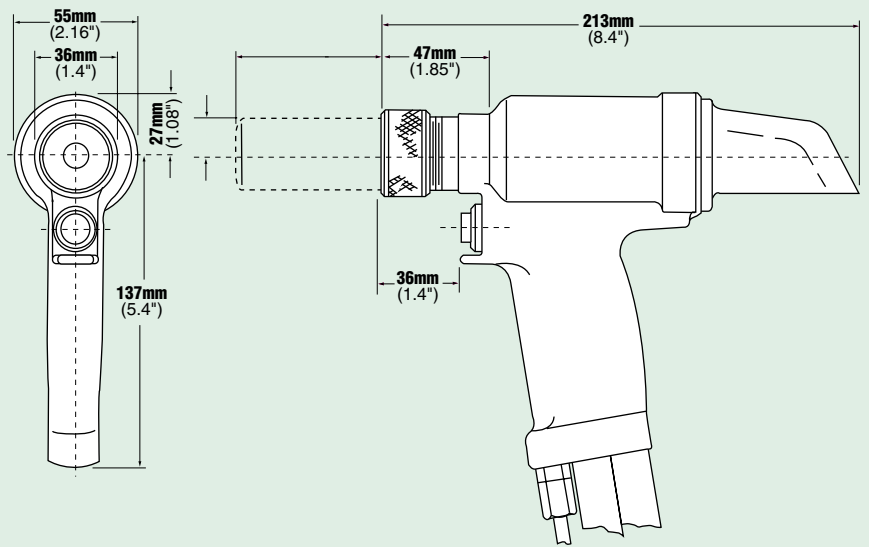
Stroke:

24 mm (0.94 in.)

Operating Hydraulic Pressures:

Pull- *510 bar (*7,400 psi)

Return-221 bar (3,200 psi)

* For fastener diameter 9.5 mm
(3/8") and above*Capacity:*36,65 kN @ 393 bar
(8240 lbs @ 5700 psi)47,6 kN @ 510 bar
(10700 lbs @ 7400 psi)**Part of the FOCUS Tooling
Range****Nose assemblies are to be ordered separately****Compatible Fastener**

Type	Diameter	Nose Assembly
BOM	4.8 mm (3/16")	99-1053
	6.4 mm (1/4")	99-830-1
	7.9 mm (5/16")	99-769
	9.5 mm (3/8")	99-1272
MAGNA-LOK	9.5 mm (3/8")	99-3318
MAGNA-BULB	7.9 mm (5/16")	99-3307
C6L/C120L	4.8 mm (3/16")	99-2558
	6.4 mm (1/4")	99-2564
	7.9 mm (5/16")	99-99-245
	9.5 mm (3/8")	99-100-245 , 99-100-1D2
MAGNA-GRIP	4.8 mm (3/16")	99-3206
	6.4 mm (1/4")	99-3207
	7.9 mm (5/16")	99-1439
	9.5 mm (3/8")	99-1440
HUCKTAINER	9.5 mm (3/8")	99-3438

Items in **bold** are part of our FOCUS Tooling Range**The 2580 is a lightweight tool for use in a wide range of high-speed production applications. With only one moving part, the tool provides for increased reliability and requires minimal maintenance.**

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2600

Powerig

2600

Hydraulic Powered Installation Tool

Specifications

Weight:

3.3 kg (7.3 lbs.)

Stroke:

31 mm (1.22 in.)

Operating Hydraulic Pressures:

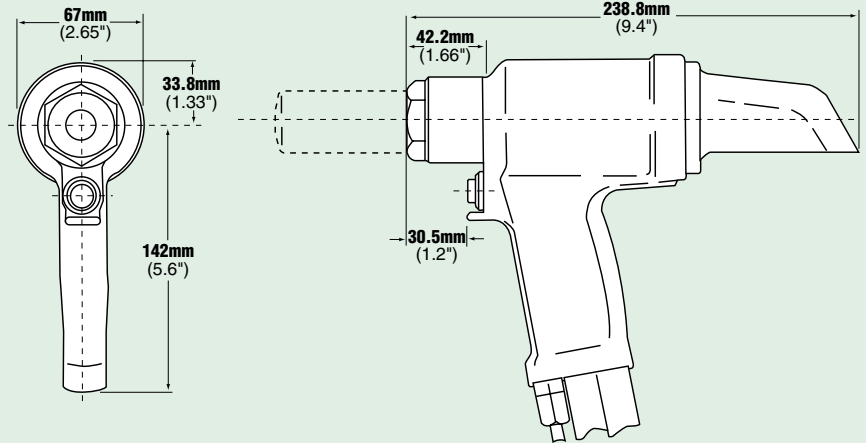
Pull-393 bar (5,700 psi)

Return-193 bar (2,800 psi)

Capacity:

61.56 kN @ 393 bar

(13839 lbs @ 5700 psi)



Nose assemblies are to be ordered separately

Compatible Fastener

Type	Diameter	Nose Assembly
BOM	7.9 mm (5/16")	99-3119
	9.5 mm (3/8")	99-3122
C6L/C120L/C150	9.5 mm (3/8")	99-2663
MAGNA-GRIP	7.9 mm (5/16")	99-3217
	9.5 mm (3/8")	99-3220, 99-3220-2



The Model 2600 is a lightweight and versatile installation tool designed use with a wide range of HUCK blind fasteners and HuckBolt fasteners. The tool's compact size allows it to fit into limited clearance applications, while its light weight provides for outstanding operator productivity.



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2620-PT

Hydraulic Powered Installation Tool

Specifications

Weight:

4.48 kg (9.88 lbs.)

Stroke:

36.50 mm (1.437 in.)

Operating Hydraulic Pressures:

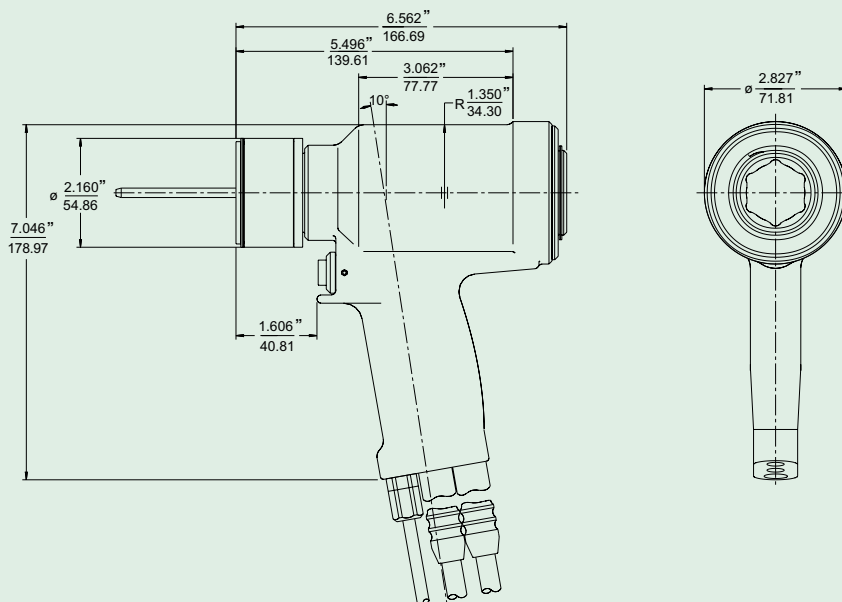
Pull-510 bar (7,400 psi)

Return-221 bar (3,200 psi)

Capacity:

78.93 kN @ 448 bar

(17745 lbs @ 6500 psi)



Nose assemblies are to be ordered separately

Compatible Fastener

Type	Diameter	Nose Assembly
BOM	12.7 mm (1/2")	99-5101
C50L	12.7 mm (1/2")	99-5002 , 99-5005
MHP/HUCKFIT	12 mm	99-5406

Items in **bold** are part of our FOCUS Tooling Range



The 2620-PT is sized for the high-speed installation of HUCK's larger fasteners. The tool features an in-line piston which extends seal life. The 2620-PT has only one moving part, which further minimizes maintenance.

2620-PT

Powerig



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2624

Hydraulic Powered Installation Tool

Specifications

Weight:

6.35 kg (14 lbs.)

Stroke:

42.93 mm (1.69 in.)

Operating Hydraulic Pressures:

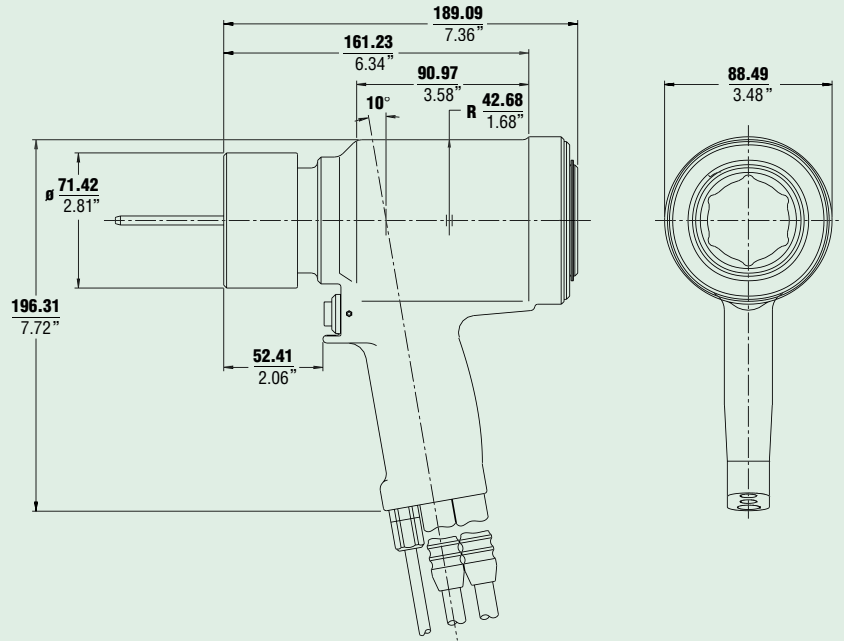
Pull-510 bar (7,400 psi)

Return-221 bar (3,200 psi)

Capacity:

135 kN @ 448 bar

(30356 lbs @ 6500 psi)



Nose assemblies are to be ordered separately

Compatible Fastener

Type	Diameter	Nose Assembly
BOM	15.9 mm (⁵ / ₈ ")	99-5102
C50L	15.9 mm (⁵ / ₈ ")	99-5008 , 99-5009
MHP/HUCKFIT	14 mm	99-5408
MHP/HUCKFIT	16 mm	99-5300

Items in **bold** are part of our FOCUS Tooling Range



The 2624 is sized for the high-speed installation of HUCK's larger fasteners. The tool features an in-line piston which extends seal life. The 2624 has only one moving part, which further minimizes maintenance.

2624

Powerig



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2628

Hydraulic Powered Installation Tool

Specifications

Weight:

8.6 kg (19 lbs.)

Stroke:

46 mm (1.81 in.)

Operating Hydraulic Pressures:

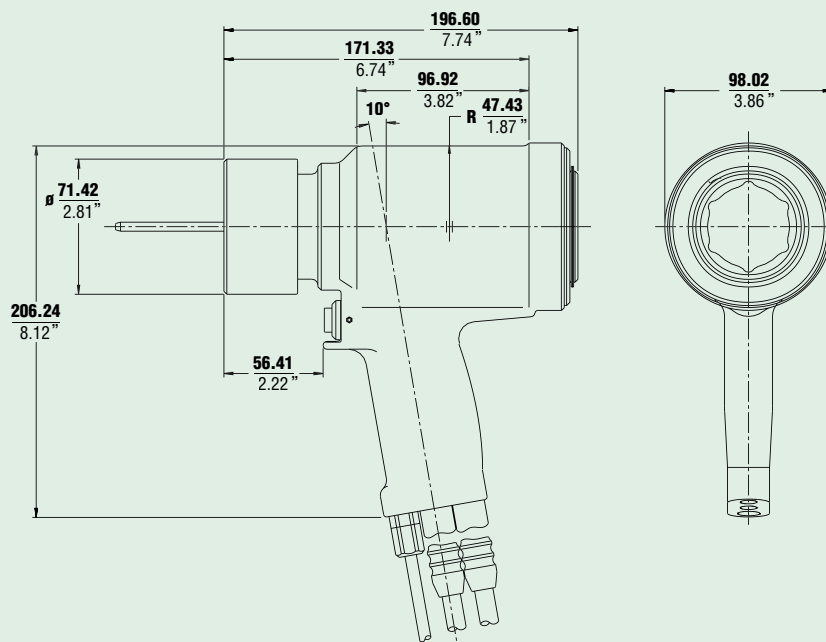
Pull-510.35 bar (7,400 psi)

Return-220.68 bar (3,200 psi)

Capacity:

177.30 kN @ 448.28 bar

(39858 lbs @ 6500 psi)



Nose assemblies are to be ordered separately

Compatible Fastener

Type	Diameter	Nose Assembly
BOM	15.9 mm (⁵ / ₈ "	99-5102
	19.1 mm (³ / ₄ "	99-5103
C50L	15.9 mm (⁵ / ₈ "	99-5008 , 99-5009
	19.1 mm (³ / ₄ "	99-5010 , 99-5013
MHP/HUCKFIT	14 mm	99-5408
MHP/HUCKFIT	16 mm	99-5300

Items in **bold** are part of our FOCUS Tooling Range



The 2628 is sized for the high-speed installation of HUCK's larger fasteners. The tool features an in-line piston which extends seal life. The 2628 has only one moving part, which further minimizes maintenance.

2628

Powerig



Huck Fasteners
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506

Hydraulic Powered Installation Tool

Specifications

Weight:

15 kg (33 lbs.)

Stroke:

50.8mm (2.0 in.)

Operating Hydraulic Pressures:

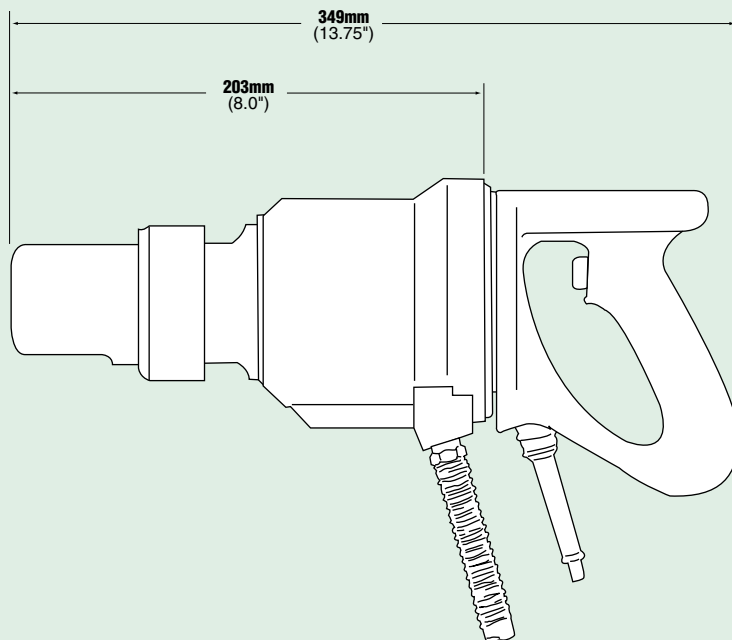
Pull-393 bar (5,400 psi)

Return-165 bar (2,460 psi)

Capacity:

250,88 kN @ 393 bar

(564.00 lbs @ 5,400 psi)



Nose assemblies are to be ordered separately

Compatible Fastener

Type	Diameter	Nose Assembly
C50L	22.2mm (7/8")	99-5014, 99-5015
MHP/HUCKFIT	20mm	99-5414



The PowerDrive 506 is a heavy-duty tool sized for the installation of a number of larger C50L LockBolt fasteners, up to 27.2 mm (7/8") in diameter. This rugged tool provides high-speed installation in a wide range of production applications.

507

Hydraulic Powered Installation Tool

Specifications

Weight:

19.5 kg (43 lbs.)

Stroke:

63.5mm (2.5 in.)

Operating Hydraulic Pressures:

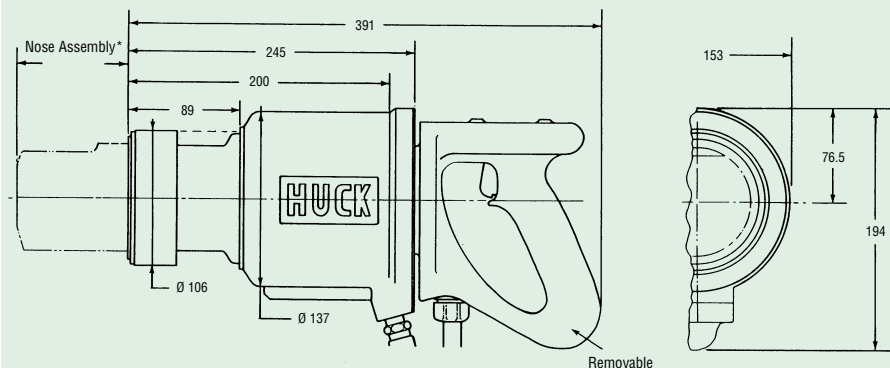
Pull-393 bar (5,400 psi)

Return-165 bar (2,460 psi)

Capacity:

336.73 kN @ 393 bar

(75700 lbs @ 5,400 psi)



Nose assemblies are to be ordered separately

Compatible Fastener

Type	Diameter	Nose Assembly
C50L	25.4mm (1")	99-5016, 99-5016FP, 99-5017
C50L	28.6mm (1 1/8")	99-5019 , 99-5019FP, 99-5020
MHP/HUCKFIT	22mm	99-5416
MHP/HUCKFIT	24mm	99-5418

Items in **bold** are part of our FOCUS Tooling Range



The 507 is a heavy-duty tool sized for the installation of a number of larger LockBolt fasteners. This rugged tool provides high-speed installation in a wide range of production applications.

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HS Huck-Spin™ Tool

Powerig

Huck-Spin™ Hydraulic Production Tool

Specifications

Weight:

HS37: 13.6 kg (30 lbs.)

HS52: 18.1 kg (40 lbs.)

Operating Hydraulic Pressures:

Pull-(HS37) 577 bar (8369 psi)

Return-(HS52) 555 bar (8042 psi)

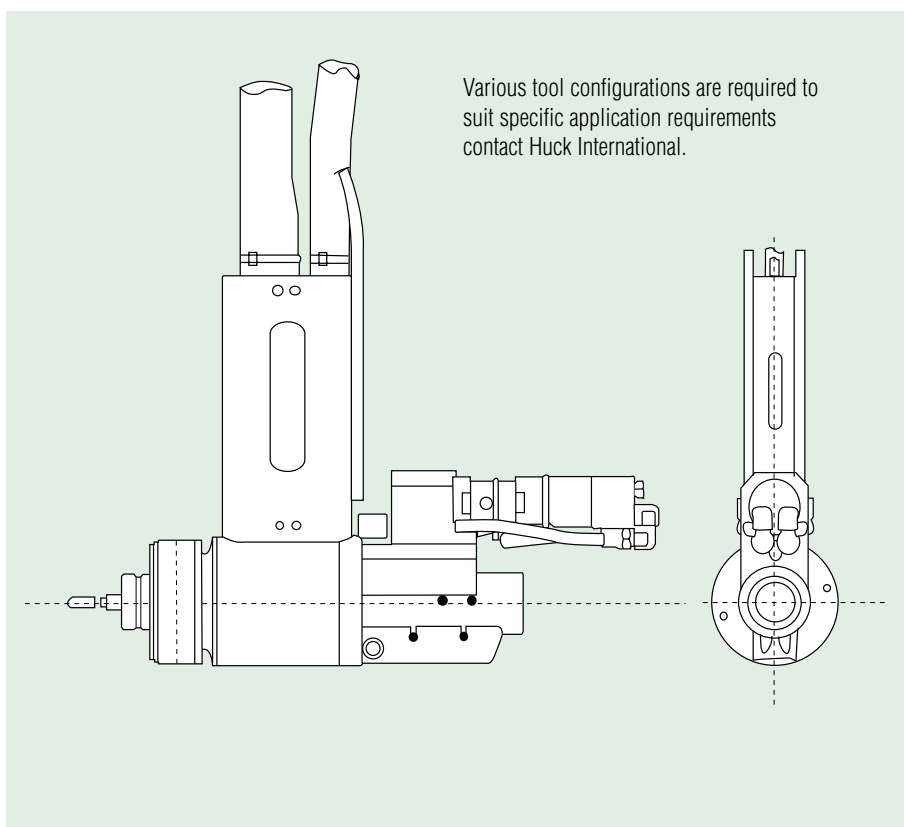
Capacity:

HS37: 164.6 kN @ 577 bar

(37000 lbs @ 8369 psi)

HS52: 231.3 kN @ 555 bar

(52000 lbs @ 8042 psi)



Various tool configurations are required to suit specific application requirements contact Huck International.

Nose assemblies are to be ordered separately

Compatible Fastener

Type	Diameter	Nose Assembly	Tool
HUCKSPIN (Metric)	12 mm	99-7412, 99-7412-1	HS37
	14 mm	99-7414, 99-7414-1, 99-7416,	HS52
	16 mm	99-7415, 99-7415-1	
	20 mm	99-7418, 99-7418-1, 99-7419, 99-7419-1	
HUCKSPIN (Inches)	1/2" (12.7 mm)	99-7312, 99-7312-1	HS37
		99-7309, 99-7309-1, 99-7313, 99-7313-1	HS52
	5/8" (15.9 mm)	99-7315, 99-7315-1, 99-7316, 99-7316-1	
	3/4" (19.1 mm)	99-7314, 99-7314-1	



These high volume production Installation Tools are designed to be used with the Huck-Spin™ Manifold Controller (125725) which suspend the tool and automatically controls it's functions. Various tool configurations are available with different handle, air motor and trigger positions and options, (please refer to specific data sheets). Manipulator mounted tools are also available which enable angular movement of the tool into any position, (contact our Systems Specialists for further details).

Hydraulic power for the tool is provided by Huck Powerigs.



Huck Fasteners
an Alcoa business

HPT**Pneudraulic
Installation Tool****Specifications***Operating Hydraulic Pressures:*

Pull-579 bar (8,400 psi)

Return-448 bar (6,500 psi)

Capacities @:

579 bar (8400 psi)

HPT25RH 25,000 lbs (111.2 kN)

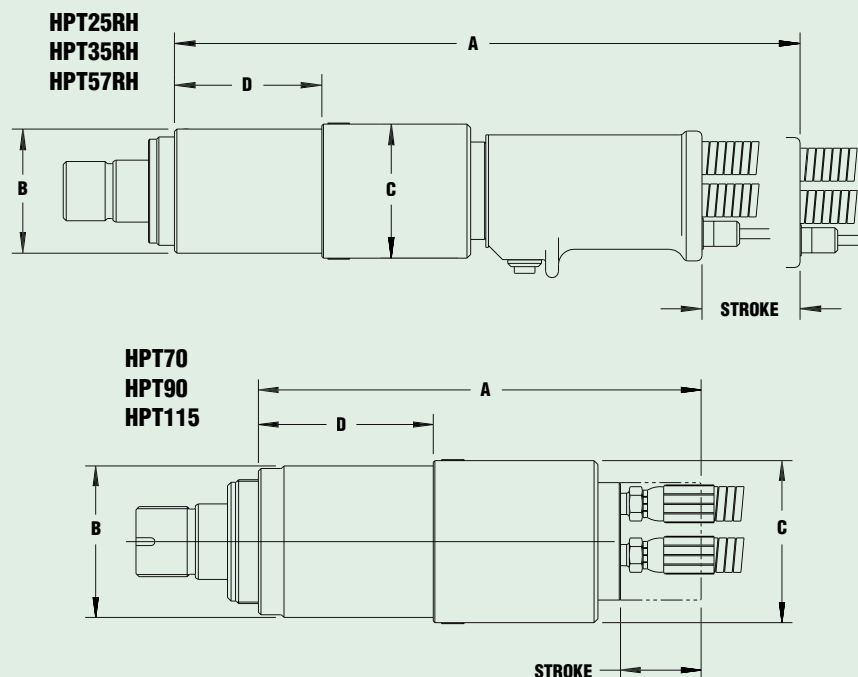
HPT35RH 35,000 lbs (155.7 kN)

HPT57RH 57,000 lbs (253.6 kN)

HPT70 70,000 lbs (311.5 kN)

HPT90 90,000 lbs (400.5 kN)

HPT115 115,000 lbs (511.5 kN)

**Nose assemblies are to be ordered separately****Specifications Continued**

Tool	Weight	Stroke	A	B	C	D
HPT25RH	2.73 kg	2.73	225.55	73.66	57.15	70.87mm
	6.00 lbs	1.25"	8.88"	2.90"	2.25"	2.79"
HPT35RH	4.09 kg	38.10	208.03	60.45	66.55	82.55mm
	9.00 lbs	1.50"	8.19"	2.38"	2.62"	3.25"
HPT57RH	5.45 kg	44.45	236.22	76.20	82.30	90.68mm
	12.00 lbs	1.75"	9.30"	3.00"	3.24"	3.57"
HPT70	8.91 kg	31.75	260.10	88.90	95.25	102.87mm
	19.60 lbs	1.25"	10.24"	3.50"	3.75"	4.05"
HPT90	11.27 kg	38.10	273.05	100.08	106.43	105.92mm
	24.80 lbs	1.50"	10.75"	3.94"	4.19"	4.17"
HPT115	14.45 kg	44.45	285.75	111.25	117.60	112.27mm
	31.80 lbs	1.75"	11.25"	4.38"	4.63"	4.42"

Compatible Fastener

Type	Diameter	Nose Assembly	Tool
MHP/HUCKFIT	12 mm	99-6400	HPT25RH
	14 mm	99-6402	HPT35RH
	16 mm	99-6302	
	20 mm	99-6405	HPT57RH
	22 mm	99-6305	HPT70
	24 mm	99-6406	HPT90
C50L	27 mm	99-6407	HPT115
	12.7 mm (1/2")	99-6000	HPT25RH
	15.9 mm (5/8")	99-6001	HPT35RH
	19.1 mm (3/4")	99-6002	HPT57RH
	22.2 mm (7/8")	99-6003	HPT70
	25.4 mm (1")	99-6004	HPT90



The compact in-line design of the HPT Tools is configured specifically for limited clearance applications. The unique hydraulic piston arrangement allows for a small diameter cylinder which gives a small centre to edge distance along the complete length of the tool.

POWERIG® Hydraulic Power Systems

HUCK offers POWERIG® hydraulic power units for both in-plant and on-site use. Available in a choice of gasoline or electric power, there is a POWERIG® available to deliver a hydraulic flow rate ranging from 70 cu. inches to 2 gallons per minute.

POWERIG® HK3413

(CE Certified)

Specifications

Weight (Including Hydraulic Oil):	48.5 kg (107 lbs.)
Length:	580 mm (22.83 in.)
Height:	430 mm (16.93 in.)
Width:	295 mm (11.6 in.)
Power Supply Options:	Single Phase 50 Hz 230 or 110 VAC $\pm 10\%$
Motor:	1.5 kW
Number of Tool Outlets:	1
Flow Rate from each Tool Outlet:	1.15 l/min. (230 VAC version) 1.65 l/min. (110 VAC version)
Hydraulic Pull Pressure (Max):	600 bar (8700 psi)
Hydraulic Return Pressure (Max):	413 bar (6000 psi)

The HK3413 Powerig provides lightweight portable hydraulic Power for all Huck Installation Tools. The strong tubular frame makes for easy manual handling and provides protection for main components when used in rugged conditions. It also features a built in pressure gauge and large oil filter for the hydraulic system. The Powerig automatically starts when the Installation Tool Trigger is activated and stops when the Installation Tool cycle is complete.



POWERIG® HK4245

(CE Certified)

Specifications

Weight (Including Hydraulic Oil):	75 kg (165 lbs.)
Length:	650 mm (25.59 in.)
Height:	610 mm (24 in.)
Width:	555 mm (21.85 in.)
Power Supply Options:	Three Phase 50 Hz 3 x 230 $\pm 10\%$, 3 x 400 VAC $\pm 10\%$, 3 x 500 VAC $\pm 10\%$
Motor:	2.2 kW
Number of Tool Outlets:	1
Flow Rate from each Tool Outlet:	2.45 l/min. (nominal)
Hydraulic Pull Pressure (Max):	700 bar (10153 psi)
Hydraulic Return Pressure (Max):	350 bar (5075 psi)

The HK4245 Powerig provides hydraulic power for all Huck Installation Tools. Its rugged construction makes it particularly suitable for construction site work and it features include a built in pressure gauge and large oil filter. In addition, an electrical switching system enables easy changing between two adjustable Pull Pressures; particularly useful when two stage swaging of lockbolt collars is required.



POWERIG® HK432

(CE Certified)

Specifications

Weight (Including Hydraulic Oil):	62 kg (137 lbs.)
Length:	540 mm (21.26 in.)
Height:	510 mm (20.07 in.)
Width:	470 mm (18.5 in.)
Power Supply Options:	Three Phase 50 Hz 3 x 230 $\pm 10\%$, 3 x 400 VAC $\pm 10\%$, 3 x 500 VAC $\pm 10\%$
Motor:	2.2 kW
Number of Tool Outlets:	1
Flow Rate from each Tool Outlet:	3.2 l/min. (nominal)
Hydraulic Pull Pressure (Max):	550 bar (7977 psi)
Hydraulic Return Pressure (Max):	400 bar (4351 psi)

The very popular HK432 Powerig is suitable for use with most Huck Installation Tools. It's built in wheels and detachable handle together with compact size, make this unit easy to move between work stations. It also features a built in temperature switch to prevent the unit being used when the hydraulic oil level is too low. The Powerig automatically starts when the Installation Tool Trigger is activated and stops when the Installation Tool cycle is complete.



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POWERIG® HP74, HP742, HP116, HP1162, PP275/40
Hydraulic Power Systems

POWERIG® Hydraulic Power Systems

HUCK offers POWERIG® hydraulic power units for both in-plant and on-site use. Available in a choice of gasoline or electric power, there is a POWERIG® available to deliver a hydraulic flow rate ranging from 70 cu. inches to 2 gallons per minute.

POWERIG® HP74 & HP742

(CE Certified)

Specifications	HP74	HP742
Weight (Including Hydraulic Oil):	314 kg (692 lbs.)	324 kg (714 lbs.)
Length:	1168 mm (46 in.)	1168 mm (46 in.)
Height:	902 mm (35.5 in.)	902 mm (35.5 in.)
Width:	508 mm (20 in.)	508 mm (20 in.)
Power Supply Options:	Three Phase 50 Hz 3 x 400 VAC ±10%, 3 x 500 VAC ±10%	
Motor:	9.2 kW	9.2 kW
Number of Tool Outlets:	1	2
Flow Rate from each Tool Outlet:	7.4 l/min. (nominal)	3.7 l/min. (nominal)
Hydraulic Pull Pressure (Max):	550 bar (7977 psi)	550 bar (7977 psi)
Hydraulic Return Pressure (Max):	400 bar (4351 psi)	400 bar (4351 psi)

These heavy duty HP Powerigs are suitable for use with most Huck Installation Tools. They are designed for use in a production environment and the powerful Motor/Pump unit ensures the high-speed operation of Installation tools; the HP742 unit allowing simultaneous operation of both tool outlets. The pump unit is submersed in the large oil reservoir ensuring that noise is kept to a minimum. For use in elevated environmental temperatures, (eg. Factory roof areas), an oil cooling radiator can be fitted together with a Reservoir Oil Level Switch.



POWERIG® HP116 & HP1162

(CE Certified)

Specifications	HP116	HP1162
Weight (Including Hydraulic Oil):	337 kg (743 lbs.)	351 kg (774 lbs.)
Length:	1168 mm (46 in.)	1168 mm (46 in.)
Height:	902 mm (35.5 in.)	902 mm (35.5 in.)
Width:	508 mm (20 in.)	508 mm (20 in.)
Power Supply Options:	Three Phase 50 Hz 3 x 400 VAC ±10%, 3 x 500 VAC ±10%	
Motor:	9.2 kW	9.2 kW
Number of Tool Outlets:	1	2
Flow Rate from each Tool Outlet:	11.6 l/min. (nominal)	5.8 l/min. (nominal)
Hydraulic Pull Pressure (Max):	450 bar (6527 psi)	450 bar (6527 psi)
Hydraulic Return Pressure (Max):	400 bar (4351 psi)	400 bar (4351 psi)

These heavy duty HP Powerigs are suitable for use with most Huck Installation Tools. The powerful high output Motor/Pump unit ensures that Installation Tools are operated at their optimum speed. They are designed for use in a production environment and the HP1162 unit allows simultaneous operation of both tool outlets. The pump unit is submersed in the large oil reservoir ensuring that noise is kept to a minimum. For use in elevated environmental temperatures, (eg. Factory roof areas), an oil cooling radiator can be fitted together with a Reservoir Oil Level Switch.



POWERIG® PP275/40

(CE Certified)

Specifications	
Weight (Including Hydraulic Oil):	15.5 kg (34.1 lbs.)
Length:	419 mm (16.5 in.)
Height:	381 mm (15 in.)
Width:	241 mm (9.5 in.)
Motor:	2 HP Tecumseh 2 stroke petrol
Number of Tool Outlets:	1
Flow Rate Tool Outlet:	2 stage 275cc/40cc per min.
Hydraulic Pull Pressure (Max):	393 bar (5700 psi)
Hydraulic Return Pressure (Max):	165 bar (2400 psi)

Designed for the unique requirements of the railway industry, this unit is of specifically lightweight construction and can easily be carried to remote working sites. The Motor/Pump output is configured for use with all the Huck 500 series Installation tools. It is rugged, reliable and simple to operate, with a manual hydraulic directional valve to control the function of the Installation Tools.



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Freedom

Liberate your design with Huck fasteners



Magna-Lok • Roof supports



C6L • Hinges, door locks
Magna-Grip • Handles
C50L • Bogies



BOM • Body shell
C6L • Door and window frames



Huck-Fit • Sub-frame
Huck-Spin • Body shell



Magna-Lok • Luggage shelf
Magna-Bulb • Internal accessories



One-piece self-locking, tubing blind fastener. Wide grip range. High shear and tensile strength, vibration resistant. Ideal for thin or low-strength materials—plastic, aluminium, fibreglass.

Air conditioning, luggage shelves, sound system brackets



One-piece self-locking blind fastener with circle-seal lock for high vibratory situations. Wide grip range for reduced inventory. Available in aluminium, steel and stainless steel. High shear and tensile strength, good sealing properties

Air conditioning, roof, side panels, front and rear panels, door & window frames, luggage shelves, sound system brackets



Structural high strength blind steel fastener. Excellent pull-together properties, high clamping force. Roof, chassis, side panels, cabs, door & window frames



Superior performance over conventional flooring fasteners. Blind installation. High shear, clamp and tensile strength. Watertight

Floors



High strength blind fastener with advanced polymer watertight seal. Wide grip range for reduced inventory. Large blind-side footprint for strong, vibration resistant joint.

Roof, side panels



Extensive grip range, consistent, high clamp force. Good vibration resistance. Air conditioning, accessories, chassis, side panels, coupling mechanisms, front & rear panels, cab, door & window frames, handles



High tensile strength and vibration resistance. Available in aluminium, steel and stainless steel. Air conditioning, accessories, chassis, side panels, coupling mechanisms, front & rear panels, cabs, door & window frames, handles



Heavy duty lockbolt in larger diameters, 12.7 - 28.6mm. Grade 8.8 general purpose fastener, is completely resistant to vibration. Visual inspection confirms joint integrity. Bogies, accessories, coupling mechanisms, axle guards, ladders, handles



Helical thread facilitates pre-alignment fit-up. High resistance to vibratory loosening—but can be removed with conventional wrench. High clamping force, suits Grade 10.9, tough service applications. Bogies, batteries, accessories, chassis, coupling mechanisms, cabs, sidewall to chassis, sidewall to roof



Combines lock-bolt performance with the manufacturing flexibility of conventional threaded fasteners. Computer controlled tooling ensures consistently accurate installation, provides SPC quality control, preventative maintenance data. High clamping force, suits Grade 10.9, tough service applications. Bogies, batteries, accessories, chassis, coupling mechanisms, cabs, sidewalls to chassis, sidewalls to roof

Click on a fastener to see larger view



Huck Fasteners
an Alcoa business

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SAFETY

Huck in rail applications

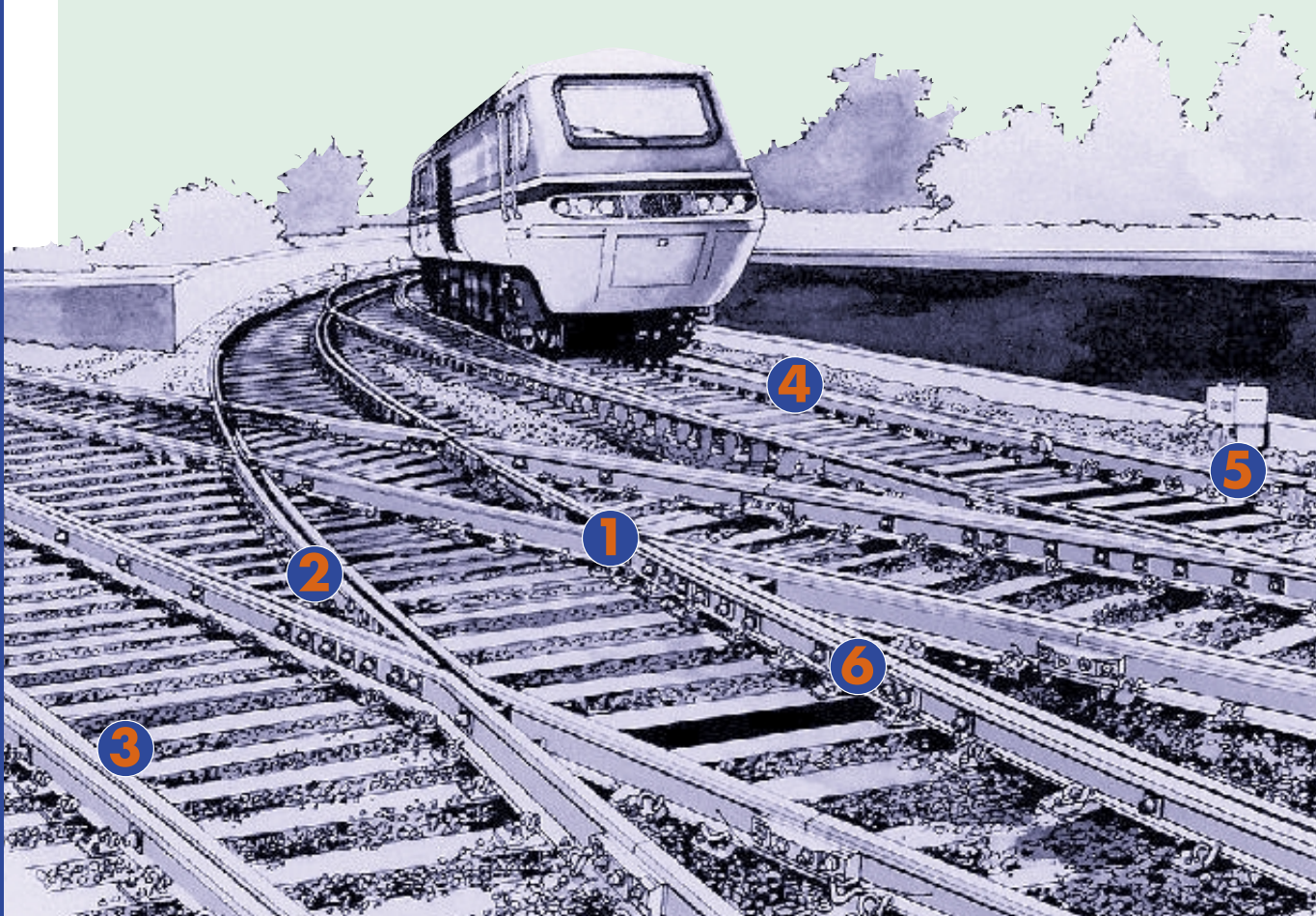
Fast & simple installation - means reduced time per point end

Increased joint integrity - 100% life extension of fastenings

Extreme vibration resistance reduces failures by
0.75 per urban point (0.5 rural)

Built up crossing life extended by 3 years

Adds up to fewer train delays and lower installed costs



Click a number for more details



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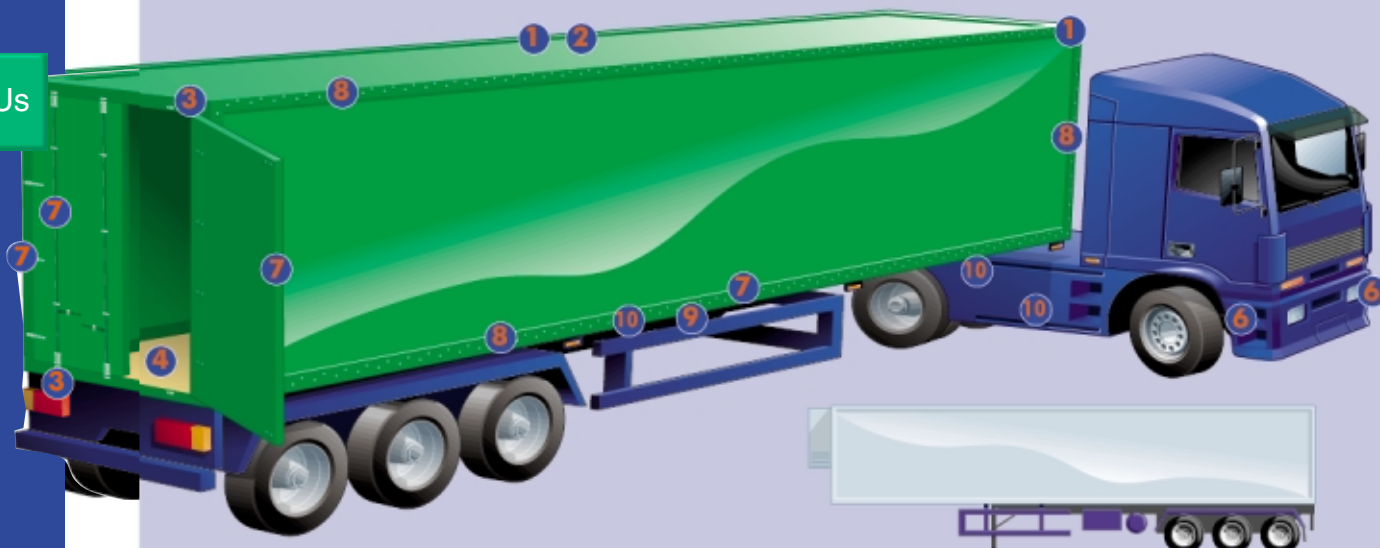
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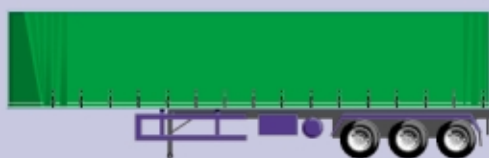
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Freedom

Liberate your design with Huck fasteners



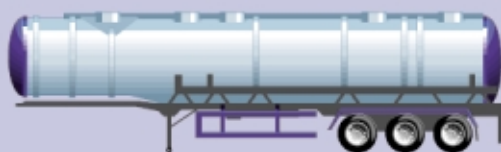
Magna-Tite • Load locking system
Magna-Lok • Exterior frame



BOM • Internal corner sections
Magna-Lok • Roof supports
Magna-Grip • curtain straps and buckles



Hucktainer • GRP board to frame
CL6 • Locking system to rear door
CL6 • Frame to chassis cross-members
Magna-Grip • Frame to chassis cross-members



Huck-Fit • Chassis
Huck-Spin • Chassis



Magna-Lok • Sound adsorbing pads
Magna-Bulb • Exterior side panelling



Magna-Bulb®
One-piece self-locking, bulbing blind fastener. Wide grip range. High shear and tensile strength, vibration resistant. Ideal for thin or low-strength materials—plastic, aluminum, fiberglass.

Trailer corner sections, aluminum floors and panels, roof-to-roof bows. Repairs out-of-round holes



Magna-Lok®
One-piece self-locking blind fastener with circle-seal lock for high vibratory situations. Wide grip range for reduced inventory. Available in aluminum, steel and stainless steel. High shear and tensile strength, good sealing properties

Trailer roof applications, curtain rails, and refrigerated trailer exterior frames



BOM®
Structural high strength blind steel fastener. Excellent pull-together properties, high clamping force.

Trailer heavy-duty joints, corner sections, door locking brackets, mounting brackets



Floortight®
Superior performance over conventional flooring fasteners. Blind installation. High shear, clamp and tensile strength. Watertight. Trailer floors



Magna-Tite®
High strength blind fastener with advanced polymer watertight seal. Wide grip range for reduced inventory. Large blind-side footprint for strong, vibration resistant joint.

Trailer roofs. Load-locking systems on refrigerated trailers



Magna-Grip®
Extensive grip range, consistent, high clamp force. Good vibration resistance.

Trailer curtain straps and buckles, frame-to-chassis on lightweight vehicles. Truck cab assemblies



CL6®
High tensile strength and vibration resistance. Available in aluminum, steel and stainless steel.

Trailer door furnishings, roof supports to frame, plus rear door locking systems and frame-to-chassis cross-members.

Truck bumper attachments, radiator mountings



Hucktainer®
Two-piece fastener specifically for joining GRP board to frame. Does not crush or damage. Wide grip range. Low profile, gives neat tamper-proof finish. Seal prevents moisture ingress.

Trailer sides



Huck-Fit®
Helical thread facilitates pre-alignment fit-up. High resistance to vibratory loosening—but can be removed with conventional wrench. High clamping force, suits Grade 10.9, tough service applications.

Trailer chassis. Truck cross-members, frame assembly, fifth wheel, suspensions



Huck-Spin®
Combines lock-bolt performance with the manufacturing flexibility of conventional threaded fasteners. Computer controlled tooling ensures consistently accurate installation, provides SPC quality control, preventative maintenance data. High clamping force, suits Grade 10.9, tough service applications.

Trailer chassis. Truck cross-members, frame assembly, fifth wheel, suspensions

Click on a fastener to see larger view



Huck Fasteners
an Alcoa business

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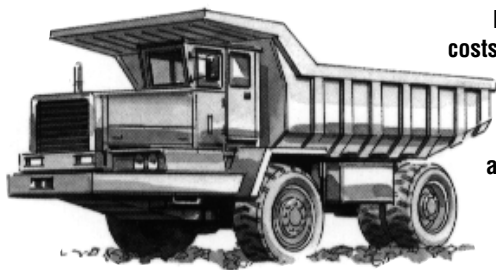
Quarrying Industry

Lockbolt® Fastening Systems



HIGH
PERFORMANCE
FASTENING
FOR THE

QUARRYING INDUSTRY



Designed to reduce costs and improve profitability through increased performance, a Huck system is the tough solution to most fastening problems.



**Huck
Fasteners**

From Cordant Technologies



Huck Fasteners
an Alcoa business

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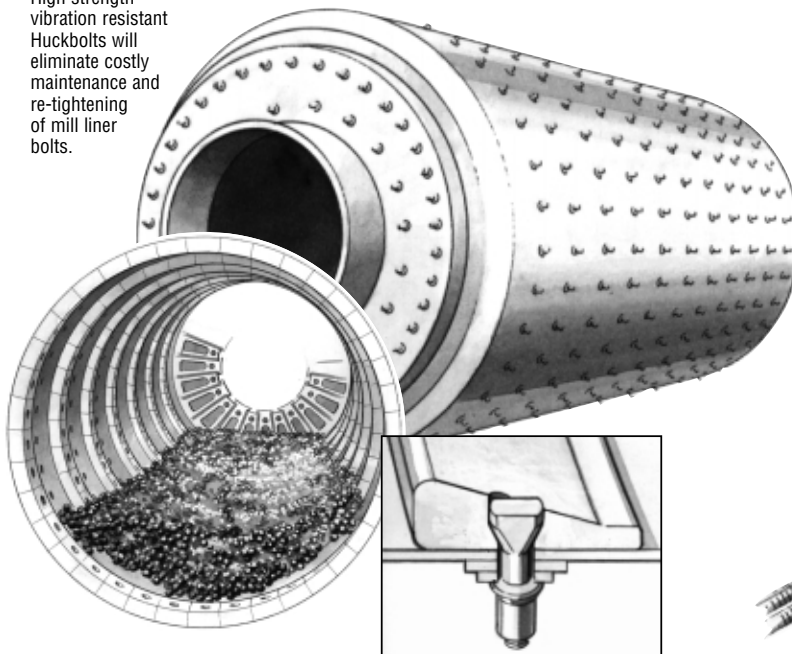
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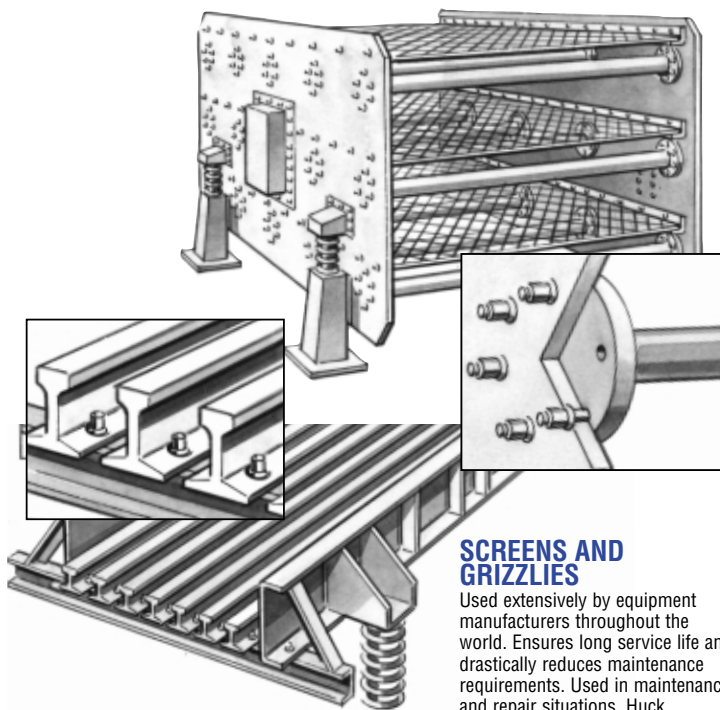
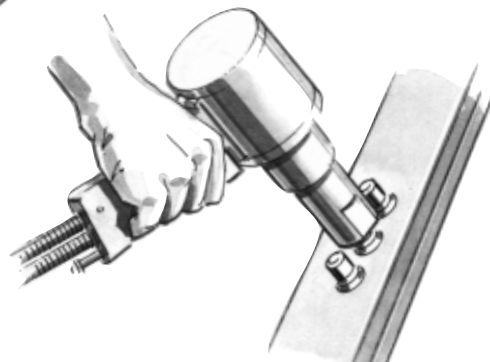
BALL AND ROD MILLS

High strength vibration resistant Huckbolts will eliminate costly maintenance and re-tightening of mill liner bolts.



Lockbolt® Fastening Systems

PROVEN, DEPENDABLE FASTENING FOR TOUGH QUARRYING APPLICATIONS



SCREENS AND GRIZZLIES

Used extensively by equipment manufacturers throughout the world. Ensures long service life and drastically reduces maintenance requirements. Used in maintenance and repair situations, Huck Fasteners will guard against premature failure and eliminate the need for costly re-work.



MHP®

High strength and consistent reliability, typically providing 10-20% higher clamp force and tensile strength than other 10.9 grade fasteners. Guaranteed performance and product quality. A metric fastener.



C50L

Total resistance to vibratory loosening, with high strength and proven performance. 8.8 grade general purpose imperial fastener.

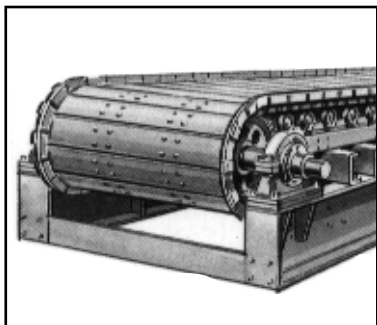


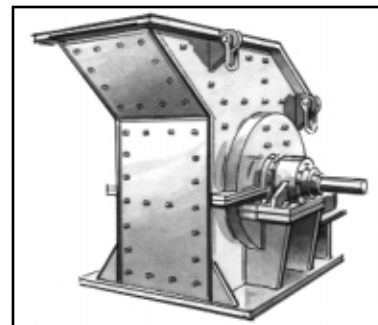
PLATE FEEDERS

The use of C50L bolts and studs ensures secure plate fixing, improving service life and reducing maintenance costs.



TRUCK BODY LINERS

The reliable and cost effective fixing of liner plates to body will drastically reduce change-out time from days to hours whilst eliminating the need for expensive welding.



CRUSHERS

Cost effective retention of liner and breaker plates reduces downtime and maintenance costs.



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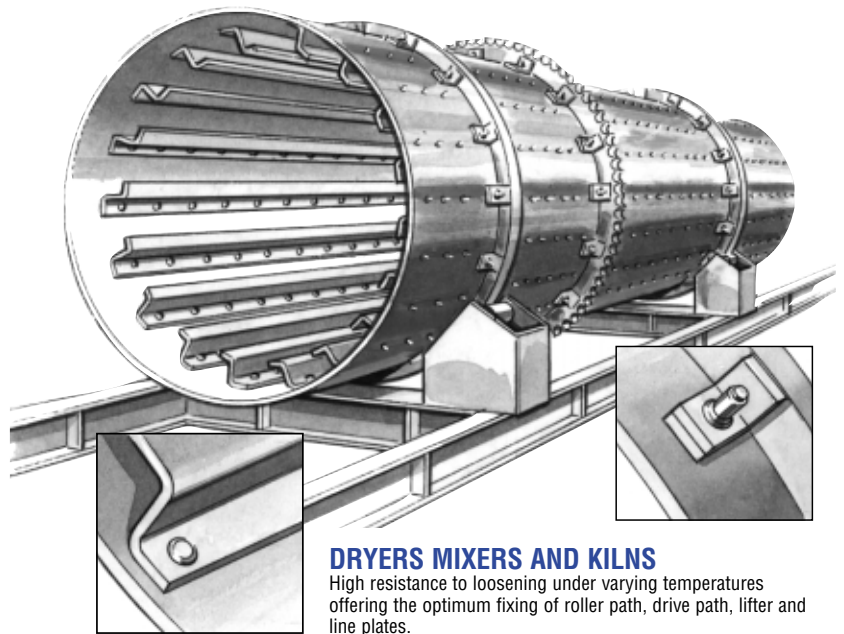
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Quarrying Industry

All Huck fastening systems provide high strength joints that have unequalled resistance to vibratory loosening, temperature variations and shock loading, when compared to equivalent threaded fasteners.

Used extensively on quarrying plant and equipment in Australia, North America and South Africa to reduce maintenance, downtime and repair costs, thereby increasing plant efficiency and operating profit.



DRYERS MIXERS AND KILNS

High resistance to loosening under varying temperatures offering the optimum fixing of roller path, drive path, lifter and line plates.



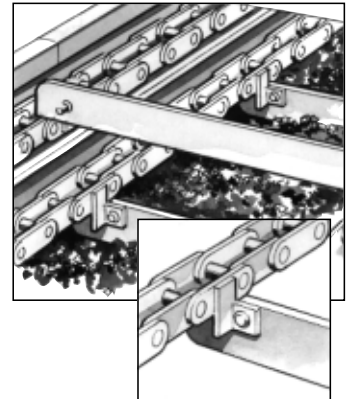
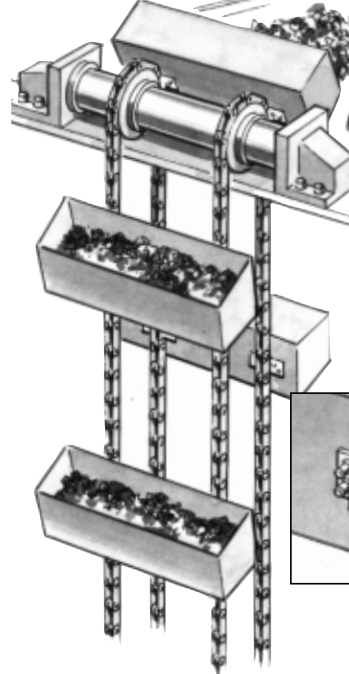
HUCKFIT®

10.9 metric fastener with a unique thread form enabling removal using standard high torque wrenches. High strength, combined with vibration resistance give guaranteed performance and product quality.



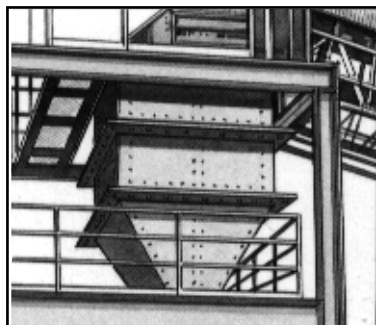
BOM®

High in shear and tensile strength, this vibration resistant blind fastener is ideal for structures and one sided applications.



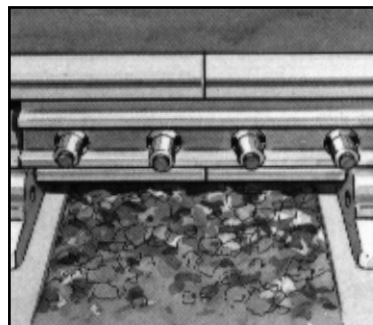
DRAG SLATS AND ELEVATORS

Secure fixings of buckets and slats to chains ensuring longer life and reduced maintenance. Unaffected by heat variations.



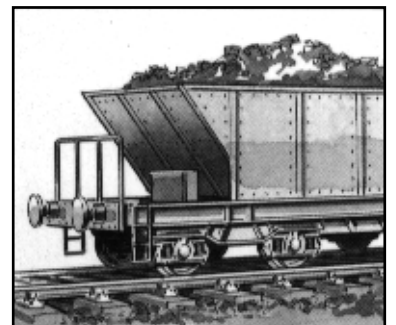
CHUTE LINER PLATES

Safe, secure fixing of liner plates will prevent downtime stoppages and damage caused by loose plates.



RAIL TRACK

Worldwide acceptance by all major rail operators used to ensure safe, secure fastenings of crossings, points, joints etc.



ORE WAGGONS

Proven reliable fixing of chassis and body components and liners.



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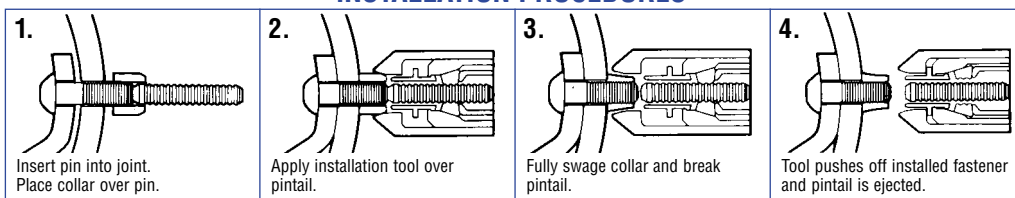
Lockbolt® Fastening Systems

SAFE, SECURE FASTENING – EVERY TIME!

Huck International Ltd is part of a worldwide organisation with a reputation for innovative design, quality products and the highest standards of customer care and support.

Industry specialists, with an understanding of the pressures and problems of the quarrying environment, are able to provide optimum solutions to the majority of fastener problems and offer continual on-site support and advice.

INSTALLATION PROCEDURES



INSTALLATION EQUIPMENT

Hand-held tooling is driven by a hydraulic power pack for convenience and portability.

Simple to use for fast installation and eliminating the need for torquing or x-ray examination – a visual inspection is sufficient.

A complete support service is provided by our systems specialists who will provide training for operators and on-site assistance to ensure optimum usage and maximum results.



Quarrying Industry



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