**EU Declaration of Conformity**

**Manufacturer:**
Huck International Inc., Installation Systems Division, 85 Grand Street, Kingston, NY, 12401, USA

**Description of Machinery:**
Model number 585 series of fastener installation tools
Model number 586 series of fastener installation tools

**Relevant provisions complied with:**

**European Representative:**
Rob Pattendon, Huck International, Ltd. Unit C Stafford Park 7, Telford Shropshire TF3 3BQ, England, United Kingdom

**Authorized Signature/date:**
I, the undersigned, do hereby declare that the equipment specified above conforms to the above Directive(s) and Standard(s).

Signature: [Signature]
Full Name: Renno Budziak
Position: Vice President of Engineering, Installation Systems Division
Place: Kingston, New York, USA
Date: November, 1996

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**Huck Model 585,586 (family) Sound Level**

SEL --- 96 dB (A)
peak value = 129 dB (C)

For an eight hour work day, installing 700 typical Huck fasteners will result in an equivalent noise level (Leq) of 79.86 dB (A).

To calculate equivalent noise level for other quantities of fasteners in an eight hour period, use the formula:

\[ \text{Leq} = \text{SEL} + 10 \log \left( \frac{n}{28,800} \right) \]

where \( n \) = number of fasteners in eight hours.

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**Huck Model 585,586 (family) Vibration Level**

For an eight hour work day, installing 700 typical Huck fasteners will result in an equivalent weighted RMS vibration level (Aeq) of 1.31m/s².

To calculate the equivalent vibration level for other quantities of fasteners in an eight hour period, use the formula:

\[ \text{Equivalent Vibration Level, Aeq (m/s}^2) = \left( \frac{n}{480} \right) \times 0.90 \]

where \( n \) = number of fasteners in eight hours, and \( 0.90 \text{ (m/s}^2) = \text{Aeq for 60 seconds} \)

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Test data to support the above information is on file at Huck International, Inc., Kingston, NY. USA. Vibration measurements are frequency weighted in accordance with ISO 8041(1990).
**SAFETY**

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

1. Safety Glossary
   - Product complies with requirements set forth by the relevant European directives.
   - Read manual prior to using equipment.
   - Eye protection required while using this equipment.
   - Hearing protection required while using this equipment.

| **WARNINGS** - Must be understood to avoid severe personal injury. |
| **CAUTIONS** - show conditions that will damage equipment and or structure. |
| **Notes** - are reminders of required procedures. |
| **Bold, Italic type and underlining** - emphasizes a specific instruction. |

2. Huck equipment must be maintained in a safe working condition at all times and inspected on a regular basis for damage or wear. Any repair should be done by a qualified repairman trained on Huck procedures.

3. Repairman and Operator must read manual prior to using equipment and understand any Warning and Caution stickers/labels supplied with equipment before connecting equipment to any primary power supply. As applicable, each of the sections in this manual have specific safety and other information.

4. See MSDS Specifications before servicing the tool. MSDS Specifications are available from you Huck representative or on-line at www.huck.com. Click on Installation Systems Division.

5. When repairing or operating Huck installation equipment, always wear approved eye protection. Where applicable, refer to ANSI Z87.1 - 1989

6. Disconnect primary power source before doing maintenance on Huck equipment.

7. If any equipment shows signs of damage, wear, or leakage, do not connect it to the primary power supply.

8. Make sure proper power source is used at all times.

9. Never remove any safety guards or pintail deflector.

10. Never install a fastener in free air. Personal injury from fastener ejecting may occur.

11. When using an offset nose always clear spent pintail out of nose assembly before installing the next fastener.

12. If there is a pinch point between trigger and work piece use remote trigger. (Remote triggers are available for all tooling).

13. Do not abuse tool by dropping or using it as a hammer. Never use hydraulic or air lines as a handle. Reasonable care of installation tools by operators is an important factor in maintaining tool efficiency, eliminating downtime, and in preventing an accident which may cause severe personal injury.

14. Never place hands between nose assembly and work piece.

15. Tools with ejector rods should never be cycled with out nose assembly installed.

16. When two piece lock bolts are being used always make sure the collar orientation is correct. See fastener data sheet of correct positioning.
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NOTE
Please read manual completely. Pages not numbered
give additional information required for maintaining tools
with modified parts and new part numbers.

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DESCRIPTION

GENERAL

Huck Model 585 Hydraulic Installation Tool (H.I.T.) is designed to install a variety of HUCKBOLT® Fasteners and Huck Blind Fasteners. The tool is designed to operate on 5400-5700 psi (37250-39300 kPa) PULL and 2200-2400 psi (15200-16500 kPa) RETURN pressures as supplied by Huck Hydraulic POWERIG® Models 906, 908, 910, 911, 914, 917 and 940, or equivalent.

The Model 585 must be equipped with a NOSE ASSEMBLY designed for the installation of a specific fastener. See nose assemblies listed under 585 or 505 in SELECTION CHART, Form 461, for specific fasteners.

Each tool is basically a cylinder and piston assembly. An unloading valve, designed to relieve the hydraulic pressure at both ends of the stroke, is positioned by the piston. A pintail ejector is provided to eject the broken pintail from the nose assembly. The end of the piston rod is threaded, and a nose adapter, split ring and sleeve are included for attaching nose assemblies to tool.

Except for nose assembly, each tool is complete with handle, hoses, couplers and control cord ready to be attached to the POWERIG hoses and control cord.

Figure 1 is a sectional view, Figure 2 is clearance dimensional view, and Figure 3 is an exploded view of the 585 H.I.T.

Table 1 - SPECIFICATIONS

<table>
<thead>
<tr>
<th>Specification</th>
<th>Measurement</th>
</tr>
</thead>
<tbody>
<tr>
<td>Length (overall)</td>
<td>6.98 in.</td>
</tr>
<tr>
<td>Width (maximum)</td>
<td>4.25 in.</td>
</tr>
<tr>
<td>Height (including handle)</td>
<td>10.85 in.</td>
</tr>
<tr>
<td>Weight</td>
<td>19 lbs</td>
</tr>
<tr>
<td>Stroke</td>
<td>1.60 in.</td>
</tr>
<tr>
<td>Fasteners Installed</td>
<td>See SELECTION CHART, Form 461</td>
</tr>
<tr>
<td>Power Source</td>
<td>Huck Hydraulic POWERIGS®</td>
</tr>
<tr>
<td>PULL Pressure</td>
<td>5400-570 psi</td>
</tr>
<tr>
<td>RETURN Pressure</td>
<td>2200-2400 psi</td>
</tr>
</tbody>
</table>

(1) Lengths and weights do not include nose assemblies.
Early Version Model 585

Later Version Model 585 2/91
PRINCIPLE OF OPERATION

Refer to Figure 1

When tool hoses and control cord are connected to POWERIG hoses and control cord, PULL and RETURN strokes of tool are controlled by a switch in the handle. When the switch is depressed, a solenoid operated valve in the POWERIG directs pressured hydraulic fluid through the PULL hose to the front side of piston, and allows fluid on the RETURN side to flow back to tank. The piston and nose assembly collet moves rearward causing follower O-rings and/or spring to impart a forward motion to the follower. If tool and nose assembly is in position on a fastener pin and collar, this forward motion causes the jaws to clamp onto pintail of fastener and installation cycle commences. Clamping pressure is applied to the sheets. The anvil is forced forward, swaging the collar into locking grooves of the fastener. When the anvil hits the sheet, continued pull causes the pintail to break off. When the piston reaches the end of its PULL stroke, it uncovers flats on the rear end of the unloading valve. These flats were designed to provide a passage for hydraulic fluid from PULL side to RETURN side of piston, “unloading” or “dumping” the pressurized fluid back to tank. When the switch is released, the solenoid is de-energized and the valve directs pressurized fluid to rear side of the piston and allows fluid on PULL side to flow back to tank. This causes piston and collet to move forward and pushes nose assembly and tool off the swaged (installed) fastener. Nose assembly jaw release contacts jaws, causing them to open and release the broken-off pintail. The ejector rod hydraulically ejects the pintail out the front of the nose assembly. When the piston reaches the end of its RETURN stroke, pressure is built up causing the POWERIG idler valve (except on Models 910, 911 and 940 to go to idling pressure). Idling pressure keeps the tool piston and nose assembly collet, jaws, etc. in the forward position ready for the next installation cycle.

A flat on the front end of the unloading valve was designed to provide a passage for hydraulic fluid from RETURN side of piston to PULL side of piston and back to tank.

WARNING

HUCK RECOMMENDS THAT ONLY HUCK HYDRAULIC POWERIGS BE USED AS THE POWER SOURCE FOR HUCK INSTALLATION EQUIPMENT. HYDRAULIC POWER UNITS THAT DELIVER HIGH PRESSURE FOR BOTH “PULL” AND “RETURN” AND ARE NOT EQUIPPED WITH RELIEF VALVES ARE SPECIFICALLY NOT RECOMMENDED AND MAY BE DANGEROUS.
585 Series Tooling

585 Clearance Dimensions

Fig. 2
CAUTION
KEEP DIRT AND OTHER FOREIGN MATTER OUT OF THE HYDRAULIC SYSTEMS OF THE TOOLS, HOSES, COUPLERS AND POWERIG. DO NOT LET HOSE FITTINGS AND COUPLERS CONTACT A DIRTY FLOOR OR UNCLEAN WORKING SURFACE. FOREIGN MATTER IN HYDRAULIC FLUID WILL CAUSE THE TOOL AND POWERIG VALVES TO MALFUNCTION.

POWER SOURCE CONNECTIONS

Coat hose fitting threads with a non-hardening Teflon thread compound such as Slic-tite. (Slic-tite is manufactured by the Markal Co., and is available from Huck in stick form as part number 503237.) DO NOT use Teflon tape on hose fitting threads.

1. Screw PULL pressure hose, with coupler nipple into port “F”. Screw RETURN pressure hose, with coupler body, into port “R”.

2. Use a Huck POWERIG, or equivalent, that has been prepared for operation per applicable Instruction Manual. Check both PULL and RETURN pressures, and adjust as necessary.

3. Turn POWERIG to “OFF” and couple tool hoses to POWERIG hoses. Be sure that the hoses run from tool port “P” to POWERIG port “PULL PRESSURE” and from tool port “R” to POWERIG port “RETURN PRESSURE.”

4. Connect switch cord to POWERIG cord.

5. Turn POWERIG to “ON”. Depress and release switch a few times to circulate hydraulic fluid. Observe action of tool. Check for fluid leaks.

6. Attach the proper Nose Assembly to the tool per instructions on the Nose Assembly.
OPERATING INSTRUCTIONS

WARNING
REASONABLE CARE OF INSTALLATION TOOLS BY OPERATORS IS AN IMPORTANT FACTOR IN MAINTAINING TOOL EFFICIENCY AND IN REDUCING REPAIR DOWNTIME. DO NOT ABUSE THE TOOL BY DROPPING IT, USING IT AS A HAMMER OR OTHERWISE. CAUSING UNNECESSARY WEAR AND TEAR. BE SURE THERE IS ADEQUATE CLEARANCE FOR THE TOOL AND OPERATOR’S HANDS BEFORE PROCEEDING. DO NOT CONNECT TOOL HOSES TO EACH OTHER AND USE AS A HANDLE FOR CARRYING.

To install a HUCKBOLT Fastener:

1. Check work and remove excessive gap. (Gap is the space between sheets. Gap is excessive if not enough pintail sticks through the collar for the nose assembly jaws to grab onto).

2. Put HUCKBOLT pin into hole.

3. Slide HUCKBOLT collar over pin. (The beveled end of the collar must be towards the nose assembly and tool.)

4. Push nose assembly onto the pin until the nose assembly anvil stops against the collar. Tool and nose assembly must be held at right angles (90°) to the work.

5. Depress tool switch to start installation cycle.

6. When forward motion of nose assembly anvil stops and pintail breaks off, release switch. Tool will go into its return stroke, push off the installed fastener and eject the pintail.

7. The tool and nose assembly is ready for the next installation cycle.

WARNING
DO NOT PULL ON PIN WITHOUT A COLLAR. IF A PIN IS PULLED WITHOUT COLLAR, THE PIN WILL EJECT FORCIBLY WHEN THE PINTAIL BREAKS OFF.
MAINTENANCE

PREVENTIVE MAINTENANCE

NOTE
Refer to the applicable section for assembly or disassembly. For supplementary Information refer to Troubleshooting Chart and Parts List.

System Inspection

Operating efficiency of the installation tool is directly related to performance of the complete system, including the tool with nose assembly, hydraulic hoses, switch and control cord, and POWERIG. Therefore, an effective preventive maintenance program includes scheduled inspections of the system to detect and correct minor troubles.

1. Inspect tool and nose for external damage.
2. Verify that hydraulic hose fittings and couplings and electrical connections are secure.
3. Inspect hydraulic hoses for signs of damage or aging. Do not carry tool suspended from hoses coupled together. Replace hoses if damaged.
4. Inspect tool, hose, and POWERIG during operation to detect abnormal heating, leaks, or vibration.

POWERIG Maintenance

Maintenance instructions and repair procedures are in the applicable POWERIG Instruction Manual.

Tool Maintenance

At regular intervals, depending upon use, replace all O-rings and back-up rings in the tool. Spare Parts Kits should be kept on hand. Inspect cylinder bore, piston and piston rod, and unloading valve for scored surfaces, excessive wear or damage, and replace as necessary.

Nose Assembly Maintenance

Frequent cleaning of the nose assembly is recommended. Dip nose assembly in mineral spirits, or other suitable solvent, to clean jaws and wash away metal chips and dirt. If more thorough cleaning or maintenance is necessary, disassemble the nose assembly. Use a sharp pointed “pick” to remove imbedded particles from the pull grooves of the jaws. Reassemble per instructions on the applicable Nose Assembly Data Sheet.
**TROUBLESHOOTING**

Always check out the simplest possible cause of a malfunction first. For example, a switch turned off or a power cord not connected. Then proceed logically, eliminating each possible cause until the defective circuit or pan is located. Where possible, substitute known good parts for suspected bad parts. Use a Troubleshooting Chart as an aid in locating and correcting it.

### Table 2- TROUBLESHOOTING CHART

<table>
<thead>
<tr>
<th>TROUBLE</th>
<th>PROBABLE CAUSE</th>
<th>CORRECTIVE ACTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>A. Tool fails to operate.</td>
<td>Inoperative POWERIG.</td>
<td>Check power source to POWERIG. See applicable POWERIG instruction manual.</td>
</tr>
<tr>
<td></td>
<td>Loose or disconnected control cord.</td>
<td>Check and tighten securely.</td>
</tr>
<tr>
<td></td>
<td>Defective switch assembly.</td>
<td>Replace switch assembly.</td>
</tr>
<tr>
<td></td>
<td>Loose or faulty hydraulic hose couplings.</td>
<td>Check and tighten securely or replace faulty couplings.</td>
</tr>
<tr>
<td>B. Tool operates in reverse; stops in back position.</td>
<td>Reversed hydraulic hose connections between POWERIG and Tool.</td>
<td>Check and correct hose connections.</td>
</tr>
<tr>
<td>C. Tool leaks hydraulic oil.</td>
<td>Depending on where leak occurs, defective or worn O-rings, loose hydraulic hose connection at Tool.</td>
<td>Check and replace O-rings and back-up rings, or tighten hydraulic hose.</td>
</tr>
<tr>
<td>D. Hydraulic oil overheats.</td>
<td>POWERIG not operating properly. Pump motor rotation reversed.</td>
<td>See applicable POWERIG instruction manual.</td>
</tr>
<tr>
<td></td>
<td>Restriction in hydraulic line.</td>
<td>Check and tighten couplings and replace if necessary.</td>
</tr>
</tbody>
</table>
## Troubleshooting (Cont.)

<table>
<thead>
<tr>
<th>Trouble</th>
<th>Probable Cause</th>
<th>Corrective Action</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>E.</strong> Tool operates erratically and fails to install fastener properly.</td>
<td>Low or erratic hydraulic pressure supply.</td>
<td>See POWERIG Instruction manual.</td>
</tr>
<tr>
<td></td>
<td>Defective or excessively worn piston O-ring in Tool.</td>
<td>Replace O-ring and back-up rings.</td>
</tr>
<tr>
<td></td>
<td>Excessive wear or scoring of sliding surfaces of Tool parts.</td>
<td>Check and replace defective parts.</td>
</tr>
<tr>
<td><strong>F.</strong> Pull grooves on fastener pintail stripped during pull stroke.</td>
<td>Operator not sliding nose completely onto fastener pintail.</td>
<td>Instruct operator in proper installation methods.</td>
</tr>
<tr>
<td></td>
<td>Incorrect fastener length.</td>
<td>Use correct length fastener.</td>
</tr>
<tr>
<td></td>
<td>Worn or damaged jaw segments.</td>
<td>Check and replace jaw set.</td>
</tr>
<tr>
<td></td>
<td>Metal chips accumulated in pull grooves of jaw segments.</td>
<td>Clean jaw segments.</td>
</tr>
<tr>
<td></td>
<td>Excessive sheet gap.</td>
<td>Eliminate excessive gap.</td>
</tr>
<tr>
<td><strong>G.</strong> Collar of HUCKBOLT Fastener not completely swaged.</td>
<td>Improper Tool operation.</td>
<td>See Trouble E.</td>
</tr>
<tr>
<td></td>
<td>Scored anvil in nose.</td>
<td>Check and replace anvil.</td>
</tr>
</tbody>
</table>
### TROUBLESHOOTING (CONT.)

<table>
<thead>
<tr>
<th>TROUBLE</th>
<th>PROBABLE CAUSE</th>
<th>CORRECTIVE ACTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>H. Tool “hangs-up” on swaged collar of HUCK-BOLT Fastener.</td>
<td>Improper Tool operation.</td>
<td>See Trouble E.</td>
</tr>
<tr>
<td>I. Pintail of fastener fails to break.</td>
<td>Pull grooves on fastener stripped.</td>
<td>See troubles E and F.</td>
</tr>
<tr>
<td>J. Jaw segments do not maintain proper position in collet.</td>
<td>Improper operation of jaw follower.</td>
<td>Check spring and Install correct number of follower O-rings. Clean before reassembling.</td>
</tr>
<tr>
<td>K. Hydraulic couplers leak oil.</td>
<td>Defective or worn O-ring in coupler body.</td>
<td>See Figure 5 for removing and replacing O-ring and back-up ring.</td>
</tr>
<tr>
<td>L. Pintail falls to eject from nose assembly.</td>
<td>Bent or broken pintail ejector.</td>
<td>Replace pintail ejector.</td>
</tr>
</tbody>
</table>
**DISASSEMBLY AND ASSEMBLY**

**GENERAL**

During disassembly and assembly, take the following precautions to avoid damaging tool or components:

(a) Always work on a clean surface.

(b) Use relatively soft materials, such as brass, aluminum or wood, to protect tool when applying pressure.

(c) Apply a continuous strong pressure, rather than sharp blows, to disassemble or assemble a component. An arbor press provides steady pressure to press a component in or out.

(d) Never continue to force a component if it “hangs up” due to misalignment. Reverse the procedure to correct misalignment and start over.

(e) Smear Lubriplate™ 13OAA, or equivalent, on O-rings and mating surfaces to aid assembly and prevent damage to O-rings. (Lubriplate is manufactured by Fiske Brothers Refining Co. and is available in most localities. A handy tube of Lubriplate 13OAA is available from Huck as part number 502723).

(f) Coat hose fitting threads with a nonhardening Teflon thread compound such as Slic-tite.™ (Slic-tite is manufactured by the Markal Co., and is available from [luck in stick form as part number 503237.]) DO NOT use Teflon tape on hose fitting threads.

**DISASSEMBLY AND ASSEMBLY TOOLS**

Standard hand tools such as wrenches, drifts, copper or lead hammers, screwdrivers, socket screw hexagon keys, long forceps (tweezers), etc. which can be purchased at most local supply firms are required. If possible, an arbor press and vise with soft jaws should be available. Standard tools available from Huck are shown in Table 3. Wrench, 122048, is available for Ejector Gland. Wrench, 124434, is available for End Cap.

**SPARE PARTS AND SPARE PARTS KITS**

The quantity of spare parts that should be kept on hand varies with the application and number of tools in service. However, spare parts kits containing perishable parts such as O-rings, back-up rings, etc., should be kept on hand at all times. Parts included in Spare Parts Kit 585KIT are indicated by asterisks (*) Table 4 — PARTS LIST.

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
<th>Used on</th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>502294</td>
<td>Hex key, 1/8 across flats</td>
<td>3-11</td>
<td>504128</td>
<td></td>
</tr>
<tr>
<td>502295</td>
<td>Hex key, 5/32 across flats</td>
<td>3-21 3-32</td>
<td>501218502489</td>
<td></td>
</tr>
</tbody>
</table>
DISASSEMBLY

For component identification, refer to Figure 3, EXPLODED VIEW and Table 4, PARTS LIST. Numbers in parenthesis ( ) are reference numbers shown in Figure 3.

The following procedure is for complete disassembly. Disassemble only components necessary to check damaged O-ring, C-ring, back-up ring, or other components.

8. Pull piston out of adapter, and remove Unloading Valve (22) from piston.

NOTE
The ejector gland can be removed to inspect and/or replace components without completely disassembling tool.

9. Remove Ejector Gland Assembly (12 thru 18) and Pintail Ejector (19) from piston. Use Special Wrench, P/N 122048, to unscrew gland.

10. Use a small diameter, dull-pointed rod to remove O-rings, C-ring and back-up rings from all components.

11. Remove Socket Head Cap Screw (21) from Handle Assembly (20).

12. Remove two Button Head Cap Screws (11) from one-half of handle and cylinder.

13. Separate handle halves, and lift out assembly Switch (10), Control Cord Assembly (34) including Connector Assembly (35), and Strain Relief Grommet (33).

14. Remove remaining button head cap screws and handle half. Remove both Hydraulic Hoses (36) from cylinder.

15. Loosen two screws at rear of switch to remove switch from electrical cord. Remove two #6-32 socket set screws to disassemble switch for cleaning. Pull strain relief grommet from cord.

16. Disassemble electrical connector to replace Connector, or to rewire.
**ASSEMBLY**

**Before assembling tool:**

(a) Clean components in mineral spirits, or other solvent compatible with O-ring seals.

(h) Clean out O-ring grooves

(c) Inspect components for scoring, excessive wear or damage.

(d) Replace O-rings, C-ring, and back-up rings. Be sure that relative positions of the O-rings, C-ring and back-up rings are as shown in Figures 1, 3, 4 and 5. Specifications for O-rings, back-up rings, and other standard components are given in Table 4, and NOTES, so that they may be purchased locally.

(e) Smear Lubriplate 130AA on O-rings, C-ring and mating surfaces to prevent damage to O-rings and C-ring and to aid assembly.

1. Assemble electrical Control Cord (34) to plug of electrical Connector (35).

2. Push cord thru Strain Relief Grommet (33), and attach to Switch (10).

3. Screw both Hoses (36) into Cylinder (4).

4. Loosely attach handle half by turning two Button Head Cap Screws (11) into cylinder.

5. Place assembled switch, electrical cord, strain relief grommet and electrical connector into handle recesses. Loosely attach other handle half. Partially turn Socket Head Cap Screw (21) into handle halves. Evenly tighten five cap screws to 50 in. lbs. torque if plated, and 70 in. lbs. if un plated, while holding assembled components in position.

6. Assemble ejector gland assembly and pintail ejector to the piston as follows:

   a. Insert Pintail Ejector (19) into Piston (23).

   b. Drop in Ejector Washer (18).

   c. Drop in O-ring (15).

   d. Screw in Gland (12) with O-ring (13) in groove in threads, back-up ring (16) and C-ring (17) in I.D., and back-up ring (14) on O.D.

   e. Tighten Ejector Gland (12) with Wrench, P/N 122048.

7. Push Adapter Assembly (5) including O-ring and back-up ring into cylinder.

8. Install Retaining Ring (3) into groove in adapter.

9. Push assembled Piston (23) O-rings and back-up ring into assembled cylinder and adapter.

10. Slide Unloading Valve (22) into hole thru piston. BE SURE UNLOADING VALVE IS ASSEMBLED WITH FOUR FLATS TO THE REAR AS SHOWN.

11. Tighten End Cap, then, back off until Locator can be placed in closest matching grooves. Use Wrench, 124434.
ASSEMBLY (CONT.)

12. After End Cap is locked in place, install Cover Plate and Retaining Ring.

13. Screw Coupler Nipple (37) onto hose in port P and Coupler Body (38) onto hose in port R.

14. Connect tool hoses to POWERIG hoses and cycle tool a few times. Observe action of tool and check for leaks.

15. Attach nose assembly to tool following applicable Nose Assembly Data Sheet. Use Split Ring Set (2) and Retaining Sleeve (1) furnished with tool.

NOTES

1. All part numbers shown are available from Huck for replacements.

2. Part numbers in the 500000 series are standard parts which generally can be purchased locally.

3. Asterisks (*) indicate parts in Spare Parts Kit, Part Number 585KIT

4. O-ring sizes are specified as AS 568 dash numbers. (AS 568 is an AEROSPACE SIZE STANDARD FOR O-RINGS and formerly was known as ARP.)

5. Material for O-rings:

   a. Ref. numbers 7 and 25 are VITON, (Parker Seal Co. compound V709-90 or equivalent) 90 durometer.

   b. Ref. nos. 9.13, 15 and 21 are VITON, (Parker Seal Co. compound V747-75 or equivalent) 75 durometer.

6. Back-up rings are W. S. Shamban & Co. series S-11248. single turn TEFLON (MS-26774) or equivalent. The dash numbers correspond to the O-ring AS 568 dash numbers.
PLEASE NOTE:

Assembly includes latest single component part numbers.

To obtain entire sub-assembly when purchasing a main component, please include related parts, for example, piston; O-ring; back-up ring.

NOTES:

△ USE TEFLOK STICK SEALANT OR EQUIVALENT ON PIPE THREADS.

2 SERVICE KIT P/N 585KIT AVAILABLE FOR SERVICE PARTS.

3 SHIP WITH EJECTOR GLAND HEX KEY P/N 122048 AND END CAP HEX KEY 124434.
### Table 4 - PARTS LIST

**NOTE:** Except where notes show otherwise, illustration and parts list (Fig. 3 & 3a) apply to latest 585. Illustration and P/L without □ □ □ and star (Fig. 3 & 3a) are for tools prior to 4-19-95.

<table>
<thead>
<tr>
<th>REF. NO.</th>
<th>PART NO.</th>
<th>NO. REQ.</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
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<td>Split Ring Group (Includes 1 &amp; 2)</td>
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<td>7*</td>
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<td>O-ring—AS 568-220</td>
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<tr>
<td>8*</td>
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<td>10</td>
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<td>Switch</td>
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<td>4</td>
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<td>Ejector Gland Assem. (incl. 13 thru 18)</td>
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<td>13*</td>
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<td>1</td>
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<td>15*</td>
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<td>16*</td>
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<td>Back-up Ring—S-11248-08</td>
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<td>1</td>
<td>C-ring</td>
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<td>18</td>
<td>100236</td>
<td>1</td>
<td>Washer - Ejector</td>
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<tr>
<td>19</td>
<td>122705</td>
<td>1</td>
<td>Ejector - Pintail</td>
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<td>Screw - Soc. Hd. Cap—#10-24 X 7/8</td>
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<td>22</td>
<td>111966</td>
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<td>Valve - Unloading</td>
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<td>112004</td>
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<td>25*</td>
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<td>O-ring—AS 568-337</td>
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<td>25</td>
<td>111233</td>
<td>1</td>
<td>Cylinder Cap (includes 27 &amp; 28)</td>
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<td>29</td>
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<td>31*</td>
<td>500181</td>
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<td>Lock Washer</td>
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<td>32*</td>
<td>502489</td>
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<td>Screw - But. Hd. Cap—1/4-20 X 3/8</td>
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<td>33</td>
<td>104619</td>
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<td>Grommet - Strain Relief</td>
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<td>110940</td>
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<td>Tool Hose Group (incl. 36 thru 38)</td>
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<td>36</td>
<td>110842</td>
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<td>Hose Hydraulic</td>
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<td>110440</td>
<td>1</td>
<td>Hyd. Coupling Assm. (incl. 37 &amp; 38)</td>
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<td>37</td>
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<td>1</td>
<td>Nipple (Male)</td>
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<tr>
<td>38</td>
<td>- - -</td>
<td>1</td>
<td>Body (Female)</td>
</tr>
</tbody>
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For latest parts, see Fig. 3

***SEE PRODUCT UPDATE IN REAR OF MANUAL***

(See Assembly Notes)
### 585 Series Tooling

<table>
<thead>
<tr>
<th>PART NUMBER</th>
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<th>ASSEMBLY</th>
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<tbody>
<tr>
<td>122242</td>
<td>EJECTOR ROD WIPER</td>
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<td>500047</td>
<td>SCR SOC CAP #06-32 X .25 ZP3</td>
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<td>500779</td>
<td>O-RING AS568-013 C366Y D70</td>
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<td>BACK-UP RING S-11248-08</td>
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<td>501102</td>
<td>BACK-UP RING S-11248-111</td>
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<td>501411</td>
<td>QUAD RING t1R—Q4009</td>
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<td>O-RING AS568-337 C9250 D90</td>
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<td>506001</td>
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<td>8-585</td>
<td>REF DRAWING 585 HYD TOOL</td>
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**Optional Accessory**

Suspension Bracket, PR1734-585, is available. When used with a balance spring suspension system, much of the tool’s weight is supported. Operator fatigue is alleviated for longer periods.
PLEASE NOTE:
Assembly includes latest single component part numbers.
To obtain entire sub-assembly when purchasing a main component, please include related parts, for example, piston; O-ring; back-up ring.

NOTES:
△ USE TEFLOX STICK SEALANT OR EQUIVALENT ON PIPE THREADS
2 SERVICE KIT P/N 585KIT AVAILABLE FOR SERVICE PARTS.
3 SHIP WITH EJECTOR GLAND HEX KEY P/N 122048 AND END CAP HEX KEY 124434.
**IMPORTANT NOTICE**

**Effective October 1, 1989**

Reference - Hydraulic Installation Tool Models 504, 505, 585, UK585-2 and FE5901

The following parts have been obsoleted and superceded to Part Number 120653 Ejector Gland Assembly.

This change has been made to reduce the leakage of hydraulic fluid from the ejector gland area of the tools.

<table>
<thead>
<tr>
<th>Part number</th>
<th>Description</th>
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<tbody>
<tr>
<td>104638</td>
<td>Ejector Gland Assembly</td>
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<tr>
<td>100238</td>
<td>Gland Ejector</td>
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<tr>
<td>100236</td>
<td>Washer - Ejector</td>
</tr>
<tr>
<td>505040</td>
<td>Seal</td>
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When customers order any of the above parts they will receive Part Number 120653. The following service kits and Sub assemblies are also affected, they will now contain the new gland assembly (P/N 120653)

<table>
<thead>
<tr>
<th>Part Number</th>
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<tbody>
<tr>
<td>106639</td>
<td>Service Kit Model 504</td>
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<td>106640</td>
<td>Service Kit Model 505</td>
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<tr>
<td>110403</td>
<td>Service Kit Model 585</td>
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<td>113735</td>
<td>Service Kit Model FE5901</td>
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<td>106625</td>
<td>Piston Assembly - 504</td>
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<td>106630</td>
<td>Piston Assembly - 505</td>
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<td>111292</td>
<td>Piston Assembly - 585</td>
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<tr>
<td>113351</td>
<td>Piston Assembly - FE5901</td>
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See Reverse side for additional information
NOTES:

1. ORIENTATION OF LARGE CHAMFER ON DETAIL WASHER P/N 120652.

2. SHIP WITH HEX KEY P/N 122048.

3. SEAL KIT P/N 120653 KIT AVAILABLE FOR THIS TOOL.
PRODUCT IMPROVEMENT

Models 585 and 586
Improved End Cap Assemblies

End Cap Assemblies, 124433 (585) and 124431 (586) replace the existing assemblies. The new design’s cover plate reduces, or eliminates, the possibility of damaging the cylinder’s threads by impact - - cover plate also retains the locator disk. With wrench, 124434, cap is easily removed.

To order, please contact:

Huck International, Inc.
Installation Systems Division
800-431-3091

PATENT PENDING
SERVICE NOTES:
**LIMITED WARRANTIES**

**Tooling Warranty:** Huck warrants that tooling and other items (excluding fasteners, and hereinafter referred as "other items") manufactured by Huck shall be free from defects in workmanship and materials for a period of ninety (90) days from the date of original purchase.

**Warranty on "non standard or custom manufactured products":** With regard to non-standard products or custom manufactured products to customer's specifications, Huck warrants for a period of ninety (90) days from the date of purchase that such products shall meet Buyer's specifications, be free of defects in workmanship and materials. Such warranty shall not be effective with respect to non-standard or custom products manufactured using buyer-supplied molds, material, tooling and fixtures that are not in good condition or repair and suitable for their intended purpose.

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**Huck Installation Equipment**

Huck International, Inc. reserves the right to make changes in specifications and design and to discontinue models without notice.

Huck Installation Equipment should be serviced by trained service technicians only.

Always give the Serial Number of the equipment when corresponding or ordering service parts.

Complete repair facilities are maintained by Huck International, Inc. Please contact one of the offices listed below.

**Eastern**
One Corporate Drive Kingston, New York 12401-0250
Telephone (845) 331-7300 FAX (845) 334-7333

**Canada**
6150 Kennedy Road Unit 10, Mississauga, Ontario, L5T2J4, Canada.
Telephone (905) 564-4825 FAX (905) 564-1963

**Outside USA and Canada**
Contact your nearest Huck International Office, see back cover.

In addition to the above repair facilities, there are Authorized Tool Service Centers (ATSC's) located throughout the United States. These service centers offer repair services, spare parts, Service Parts Kits, Service Tools Kits and Nose Assemblies. Please contact your Huck Representative or the nearest Huck office listed on the back cover for the ATSC in your area.
A Global Organization

Alcoa Fastening Systems (AFS) maintains company offices throughout the United States and Canada, with subsidiary offices in many other countries. Authorized AFS distributors are also located in many of the world’s industrial and Aerospace centers, where they provide a ready source of AFS fasteners, installation tools, tool parts, and application assistance.

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Tucson, AZ 85714
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520-747-9898
FAX: 520-748-2142

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Carson Operations
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Carson, CA 90749
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310-830-8200
FAX: 310-830-1436

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FAX: 845-334-7333
www.hucktools.com

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FAX: 310-830-1436

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8001 Imperial Drive
Waco, TX 76714-8117
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254-776-2000
FAX: 254-751-5259

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Rowville, Victoria
Australia 3178
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FAX: 0952-290459

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TELEX: 1173530 LUKSME


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