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

**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:
Leq = SEL + 10 log (n/28,800)
where n = number of fasteners in eight hours.

**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:
Equivalent Vibration Level, Aeq (m/s²) = (n/480) x 0.90
where n = number of fasteners in eight hours, and 0.90 (m/s²) = Aeq for 60 seconds

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).
S A F E T Y

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.
CONTENTS

Safety ................................................................................................................................. 3
Description/Specifications .................................................................................. 5 & 6
Principle of Operation .......................................................................................... 7
Preparation for Use ................................................................................................. 8
Operating Instructions ......................................................................................... 9
Maintenance ............................................................................................................... 10
  Good Service Practices ..................................................................................... 10
  Preventive Maintenance .................................................................................. 11
  Troubleshooting ............................................................................................... 12 & 13
Suspension Bracket ............................................................................................. 14
Notes for Tool .......................................................................................................... 14
Specifications for Standard Components ....................................................... 14
Service Parts Kit ..................................................................................................... 14
Cylinder Assembly with Part Numbers ............................................................. 15
Disassembly .............................................................................................................. 16
Gland Assemblies ................................................................................................... 17
Assembly ..................................................................................................................... 18
Assembly Drawings .................................................................................................. 19-21
Tool Product Updates ............................................................................................. 22 & 23
DESCRIPTION

Model 586* and 586NS* Hydraulic Installation Tools install various Huck Blind Fasteners and HUCKBOLT® Fasteners. This in-line design has proven to be effective for the heavier fasteners.

These electrically triggered tools are used with Huck Models 913H, 918, 940 and 956 POWERIG® Hydraulic Units, or equivalent. Except for Nose Assembly, each Tool is complete with hydraulic hoses, couplings and electric control cord ready to be attached to POWERIG Hydraulic Unit’s hoses and control cord.

Tool consists of a cylinder and piston assembly with an unloading valve to relieve hydraulic pressure at both ends of piston’s stroke. After each fastener installation cycle, pintail ejector pushes broken-off pintail out of Nose Assembly. Split ring and sleeve are included for attaching Nose Assembly to Tool.

The modification that identifies a 586NS is the special male electrical cord and connector assembly, 506019, (modified to meet customer requests). To adapt new connector to your present hose and cord kit, see procedure on figure 7.

SPECIFICATIONS

Weight 21.5 lbs. - - - - 9.8 kg
Stroke 2", min. - - - - 50.8 mm

Hydraulic power source Huck POWERIG Hydraulic Unit

PULL pressure 5400-5700 psi - - 37200-39300 kPa
RETURN pressure 2200-2400 psi - - 15200-16500 kPa

Hydraulic fluid Automatic transmission fluid, DEXRON III, or equivalent.

For dimensions of basic Tool, see Figure 1 - Outline Drawing.
Length and weight do not include Nose Assemblies.

* Patent Pending Model 586 & 586N
Fig. 1

Outline Drawing
**PRINCIPLE OF OPERATION**

See Figure 2

Switch in handle controls PULL and RETURN strokes of Tool. As switch is pressed, hydraulic pressure is directed to PULL side of piston. Piston, with nose assembly collet, moves rearward; jaws grip pintail and anvil starts to swage collar.

When fastener installation is completed, switch is released. Hydraulic pressure is directed to RETURN side of piston and it moves forward — nose assembly’s anvil is pushed off installed fastener. Jaw release opens jaws and ejector rod ejects broken pintail. Tool/nose assembly is ready for next installation cycle.

Flats on both ends of unloading valve relieve pressure at end of both PULL and RETURN strokes. Flats provide passages for fluid to pass through the piston — pressurized fluid is “unloaded/dumped” — fluid circulates back to reservoir in POWERIG® Hydraulic Unit.
PREPARATION FOR USE

CAUTION
Do not let disconnected hoses and couplers contact a dirty floor. Dirt/debris in hydraulic fluid causes valve failure in the Tool and in the POWERIG® Hydraulic Unit.

Note: Where a part number (P/N) is given, Huck sells that part.

Rub SLIC-TITE TEFLON thread compound or equivalent, on pipe threads to prevent leaks and for ease of assembly — CAUTION: Do not use TEFLON tape on pipe threads — particles of shredded tape cause failure of hydraulic unit valve. (SLIC-TITE — in stick form, P/N 503237; manufactured by Markal Co.)

1. Use Huck POWERIG Hydraulic Unit, or equivalent, that has been prepared for operation per INSTRUCTION MANUAL. Check both PULL and RETURN pressures, and if required, adjust to pressures given in SPECIFICATIONS of this manual. See both hydraulic unit’s and T-124833’s instruction manuals before and during checking procedure.

2. First, turn hydraulic unit to OFF, and then, disconnect power supply from hydraulic unit. Connect Tool’s hoses to hydraulic unit.

3. Connect Tool’s control switch electrical cord to hydraulic unit.

4. Connect hydraulic unit to power supply. Turn hydraulic unit to ON. Hold Tool trigger depressed for 30 seconds; depress trigger a few times to cycle tool and to circulate hydraulic fluid. Observe action of Tool and check for leaks. Turn hydraulic unit to OFF.

5. Select nose assembly from SELECTION CHART for fastener to be installed. Disconnect Tool’s control switch electrical cord from hydraulic unit; disconnect hydraulic unit from power supply. Attach nose assembly to Tool as given by instructions on NOSE ASSEMBLY DATA SHEET.

6. Reconnect hydraulic unit to power supply; reconnect Tool’s switch control cord to unit. Check operation of nose assembly — see Tool’s SPECIFICATIONS and Gauge Instruction Manual. Failure to verify pressures may result in severe personal injury.

Be sure to connect Tool’s hydraulic hoses to POWERIG Hydraulic Unit before connecting Tool’s switch control cord to unit. If not connected in this order, severe personal injury may occur when tool accidentally cycles.

WARNINGS
Huck recommends that only Huck POWERIG® Hydraulic Units be used as a 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 TO PERSONNEL

Correct PULL and RETURN pressures are required for operator’s safety and for Installation Tool’s function. Gauge Set-Up, T-124833, is available for checking pressures - - see Tool’s SPECIFICATIONS and Gauge Instruction Manual. Failure to verify pressures may result in severe personal injury.

Be sure to connect Tool’s hydraulic hoses to POWERIG Hydraulic Unit before connecting Tool’s control switch cord to unit. If not connected in this order, severe personal injury may occur when tool accidentally cycles.
OPERATING INSTRUCTIONS

For safe operation please read completely

**WARNINGS**

Do not pull on a pin without placing fastener/collar in a workpiece, and also, collar chamfer **MUST** be out toward tool - these conditions cause pin to eject with velocity and force when the pintail breaks off or teeth/grooves strip. This may cause severe personal injury.

To avoid severe personal injury, be sure of adequate clearance for operator’s hands before proceeding with fastener installation.

**CAUTION**

Remove excess gap from between the sheets - - this permits enough pintail to emerge from collar for ALL jaw teeth to engage with pintail - - if ALL teeth do not engage properly, jaws will be stripped/damaged.

To avoid structural and tool damage, be sure enough clearance is allowed for nose assembly at full stroke. Do not abuse tool by dropping it, using it as a hammer or otherwise causing unnecessary wear and tear. Reasonable care of installation tools by operators is an important factor in maintaining tool efficiency and reducing downtime.

**HUCKBOLT® Fastener Installation:**

Place pin in workpiece and place collar over pin - - see WARNING. (If Collar has only one tapered end, that end **MUST** be out toward tool - - not next to sheet.) Hold pin and push nose assembly onto pin protruding through collar until nose anvil touches collar. Depress trigger - - hold trigger depressed until collar is swaged and pintail breaks. Release trigger and tool will go into return stroke -- tool/nose are ready for next installation cycle.

**Blind Fastener Installation:**

**WARNING**

Do not pull on a pin without placing fastener in a workpiece - - fastener will eject from front with velocity and force when pintail breaks off or teeth/grooves strip - - this may cause severe personal injury.

Remove excess gap from between the sheets to permit correct fastener installation. Fastener may be placed in workpiece or in end of nose assembly - - see WARNING. In either case, tool/nose must be held against work and at right angles to it. Depress trigger - - hold trigger depressed until fastener is installed and pintail breaks. Release trigger and tool will go into its return stroke. The tool/nose are ready for next fastener installation cycle.

**CAUTION**

BOM blind fasteners jam in nose assembly if pulled when not in workpiece.

**Please note**

Failure to understand WARNINGS may cause severe personal injury.

Failure to understand CAUTIONS may cause damage to structure and Tool.

For additional safety information, see near front of manual.
MAINTENANCE

CAUTION
Keep dirt and other harmful material out of hydraulic system — this includes Tool, hoses, couplers and POWERIG® Hydraulic Unit. Parts must be kept away from unclean work surfaces. Dirt in hydraulic fluid causes valve failure in Tool and in POWERIG Hydraulic Unit.

Good Service Practices

The efficiency and life of your Installation Tool depends upon proper maintenance and good service practices. Using our manual will help give you a clear understanding of your tool and basic maintenance procedures — please read entire page before proceeding with maintenance/repair.

Use proper hand tools in a clean well-lighted area for maintenance/repair — always be careful to keep dirt/debris out of pneumatic and hydraulic systems. Only standard hand tools are required in most cases; where a special tool is required, the description and part number are given.

While clamping Installation Tool and/or parts in a vise, and when parts require force, use suitable soft materials to cushion impact — for example, using a half-inch brass drift, wood block and/or vise with soft jaws greatly diminishes the possibility of a damaged Tool. Remove components in a straight line without bending, cocking or undue force — reassemble Tool with the same care.

Note: Individual parts must be handled carefully and examined for damage or wear — replace parts where required. Always replace O-rings and back-up rings when the tool is disassembled for any reason — see SERVICE PARTS KIT. Consult manual’s TROUBLESHOOTING CHART if malfunction occurs — then see appropriate section of DISASSEMBLY ASSEMBLY and SECTIONAL VIEW W/TOOL P/N’s.

Note: Where a part number (P/N) is given, Huck sells that part.

Standard Sealants, Lubricants, and SERVICE PARTS KIT

Rub SLIC-TITE TEFLON thread compound or equivalent, on pipe threads to prevent leaks and for ease of assembly— CAUTION: Do not use TEFLON tape on pipe threads — particles of shredded tape cause Tool and hydraulic unit valve failure/malfunction. (SLIC-TITE — in stick form, P/N 503237.)

Smear LUBRIPLATE 130AA, or equivalent lubricant, on O-rings and mating surfaces — this prevents nicking/pinching O-rings on any rough/tight spot and increases ease of assembly. (LUBRIPLATE 130AA — in tube P/N 502723.)

SERVICE PARTS KIT contains perishable parts for your specific Tool — see NOTES FOR TOOL For convenience and as experience indicates, keep extra Kits (O-rings; back-up rings; other standard items) and Tool parts on hand. As an alternative, you can obtain O-rings and back-up rings from any regular retailer of these items — ask for: O-ring size (AS 568-number); material and durometer. For additional information/specifications on O-rings and back-up rings, see NOTES AND SPECIFICATIONS FOR STANDARD PARTS.
MAINTENANCE (CONT.)

PREVENTIVE MAINTENANCE

System Inspection

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

1. Inspect Tool and nose assembly for external damage.

2. Verify that hose fittings, couplings and electrical connections are secure.

3. Inspect hydraulic hoses for signs of damage or deterioration. Do not carry Tool suspended from hoses coupled together. Replace hoses as required.

4. Observe/monitor Tool, hoses, and POWERIG Hydraulic Unit during operation to detect abnormal heating, leaks or vibration.

POWERIG Hydraulic Unit Maintenance

Maintenance and repair instructions are in applicable POWERIG Hydraulic Unit Instruction Manual.

Tool and Nose Assembly Maintenance and Precautions

Whenever disassembled, and also at regular intervals (depending on severity and length of use), replace all O-rings and back-up rings — Spare Parts Kits should be kept on hand. Inspect cylinder bore, piston and rod, and unloading valve for scored surfaces, excessive wear or damage — replace parts as necessary.

Clean nose assembly often — dip in mineral spirits, or similar solvent, to clean jaws and wash away metal chips and debris. At regular intervals, indicated by experience, disassemble nose assembly and use a sharp pointed “pick” to remove imbedded particles from the pull grooves of the jaws — see appropriate NOSE ASSEMBLY DATA SHEET.
# Troubleshooting

Always check the simplest possible cause of a malfunction first. For example, a loose or disconnected trigger line. Then proceed logically, eliminating each possible cause until the defective part is located.

Where possible, substitute known good parts for suspected defective parts. Use TROUBLESHOOTING CHART as an aid for locating and correcting trouble.

<table>
<thead>
<tr>
<th>Symptom</th>
<th>Probable cause</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Tool fails to operate when trigger is depressed.</td>
<td>a. Inoperative POWERIG® Hydraulic Unit. See applicable instruction manual. b. Loose air or electric connections. c. Damaged trigger assembly d. Loose or faulty hydraulic hose couplings e. Unloading valve not installed in Tool.</td>
</tr>
<tr>
<td>2. Tool operates in reverse.</td>
<td>a. Reversed hydraulic hose connections between hydraulic unit and Tool.</td>
</tr>
<tr>
<td>3. Tool leaks hydraulic fluid.</td>
<td>a. Defective Tool O-rings or loose hose connections at Tool.</td>
</tr>
<tr>
<td>4. Hydraulic couplers leak fluid.</td>
<td>a. Damaged or worn O-rings in coupler body — see Coupler, 110440.</td>
</tr>
<tr>
<td>5. Hydraulic fluid overheats.</td>
<td>a. Hydraulic unit not operating properly. b. Unloading valve installed incorrectly. c. POWERIG Hydraulic Unit running in reverse (918; 918-5) — see unit’s manual.</td>
</tr>
</tbody>
</table>
### Troubleshooting (cont.)

<table>
<thead>
<tr>
<th>Symptom</th>
<th>Probable cause</th>
</tr>
</thead>
<tbody>
<tr>
<td>7. Pull grooves on fastener pintail stripped during PULL stroke.</td>
<td>a. Operator not sliding anvil completely onto fastener pintail.</td>
</tr>
<tr>
<td></td>
<td>b. Incorrect fastener grip.</td>
</tr>
<tr>
<td></td>
<td>c. Worn or damaged jaw segments.</td>
</tr>
<tr>
<td></td>
<td>d. Metal particles in pull grooves of jaw segments.</td>
</tr>
<tr>
<td></td>
<td>e. Excessive sheet gap.</td>
</tr>
<tr>
<td></td>
<td>b. Scored anvil.</td>
</tr>
<tr>
<td></td>
<td>b. RETURN pressure too low.</td>
</tr>
<tr>
<td></td>
<td>c. Not enough collar lubricant.</td>
</tr>
<tr>
<td></td>
<td>d. Nose assembly not installed per NOSE ASSEMBLY DATA SHEET.</td>
</tr>
<tr>
<td></td>
<td>b. Pull grooves on fastener stripped — see Trouble 7.</td>
</tr>
<tr>
<td></td>
<td>c. PULL pressure too low.</td>
</tr>
<tr>
<td></td>
<td>d. Worn unloading valve.</td>
</tr>
<tr>
<td>11. Nose assembly will not release broken pintail.</td>
<td>a. Nose assembly not installed per NOSE ASSEMBLY DATA SHEET.</td>
</tr>
<tr>
<td></td>
<td>b. Bent/broken pintail ejector rod.</td>
</tr>
</tbody>
</table>
NOTES FOR TOOL

1. Hex wrench, 122048
2. Wrench, 124434
3. 3/16 hex key, 502296
4. Al/s hex key, 502294
5. 1/16 hex key, 502443
6. 5/64 hex key, 502444

NOTES AND SPECIFICATIONS FOR STANDARD PARTS

1. All part numbers shown are available from Huck. The 500000 series numbers are standard parts which can generally be purchased locally.

2. Part No. 586KIT is the SERVICE PARTS KIT for 586 and 586NS Tools.

3. The Aerospace Standard designation for O-rings is “AS568-" The last 3 digits after the dash give size— i.e. in AS568-111, 111 is the size. (AS568- was previously ARP568-) QUAD ring size is the last 3 digits (equivalent to O-ring size).

4. Back-up rings are WS. Shambam & Co. series S-11248-, single turn TEFLON (MS-28774). or equivalent — size is the last 3 digits (equivalent to O-ring size).

5. Materials for O-rings and QUAD ring are shown below (equivalent may be used):

   Optional Accessory
   Suspension Bracket, PR1734-586, 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.

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### SERVICE PARTS KIT

<table>
<thead>
<tr>
<th>FIG</th>
<th>P/N</th>
<th>DESCRIPTION</th>
<th>QTY/ASSEM.</th>
</tr>
</thead>
<tbody>
<tr>
<td>5</td>
<td>500779</td>
<td>O-ring, AS568-013,</td>
<td>2</td>
</tr>
<tr>
<td>5</td>
<td>500780</td>
<td>O-ring, AS568-014,</td>
<td>1</td>
</tr>
<tr>
<td>5</td>
<td>500812</td>
<td>O-ring, AS568-115,</td>
<td>2</td>
</tr>
<tr>
<td>4</td>
<td>500867</td>
<td>O-ring, AS568-235, SAE SB715 BE1 E3 F2 or F1; 70D</td>
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<tr>
<td>3</td>
<td>504438</td>
<td>O-ring, AS568-111, (VITON-Parker Co. V747-75, 75 Duro.)</td>
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<tr>
<td>5</td>
<td>504552</td>
<td>O-ring, AS568-013, (Nat. O-ring Co. V25, 95 Duro.)</td>
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<tr>
<td>4</td>
<td>504626</td>
<td>O-ring, AS568-220, (Nat. O-ring Co. V25, 95 Duro.)</td>
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</tr>
<tr>
<td>4</td>
<td>503881</td>
<td>O-ring, AS568-337, (Disogrin Ind. IDSA 9250, 90 Duro.)</td>
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</tr>
<tr>
<td>4</td>
<td>506001</td>
<td>wiper, (Microdot Inc. 959-15)</td>
<td>1</td>
</tr>
<tr>
<td>5</td>
<td>506831</td>
<td>POLYSEAL, (Microdot Inc. .187-01.375SQB)</td>
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<tr>
<td>5</td>
<td>122742</td>
<td>ejector rod wiper</td>
<td>1</td>
</tr>
<tr>
<td>5</td>
<td>501411</td>
<td>QUAD ring, MR-Q4008. (VITON - Minn. Rubber Co.)</td>
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<tr>
<td>5</td>
<td>501080</td>
<td>back-up ring, S-11248-008</td>
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<tr>
<td>3</td>
<td>501102</td>
<td>back-up ring, S-11248-111</td>
<td>1</td>
</tr>
<tr>
<td>5</td>
<td>501103</td>
<td>back-up ring, S-11248-112</td>
<td>2</td>
</tr>
<tr>
<td>5</td>
<td>501106</td>
<td>back-up ring, S-11248-115</td>
<td>2</td>
</tr>
<tr>
<td>4</td>
<td>501147</td>
<td>back-up ring, S-11248-220</td>
<td>1</td>
</tr>
<tr>
<td>4</td>
<td>501162</td>
<td>back-up ring, S-11248-235</td>
<td>2</td>
</tr>
<tr>
<td>4</td>
<td>503752</td>
<td>back-up ring, S-11248-337</td>
<td>1</td>
</tr>
<tr>
<td>4</td>
<td>506002</td>
<td>retaining ring, (SPIROLOX RSN-262)</td>
<td>1</td>
</tr>
<tr>
<td>4</td>
<td>500047</td>
<td>soc. hd. screw, 6-32 x 1/4</td>
<td>1</td>
</tr>
</tbody>
</table>
CAUTION
Install POLYSEAL, 506831, cup toward rear of tool.

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.

Figure 4 - Cylinder Assembly with Part Numbers
(See Notes For Tool for disassembly tools and SERVICE PARTS KIT)
DISASSEMBLY

See Figures 4, 5, 6 and Notes for Tool.

For part identification see Figures given above. The following procedures are for complete disassembly of Tool. Remove ONLY those parts necessary - check and replace damaged or worn components. **Replace O-rings and back-up rings.**

⚠️ **WARNING**

Be sure to disconnect Tool’s control trigger system from POWER-ERG Hydraulic Unit before disconnecting Tool’s hydraulic hoses from unit. If not disconnected in this order before any maintenance or cleaning is done, severe personal injury may occur.

For part identification see Figures given above.

1. First, disconnect Tool’s electric trigger control cord from hydraulic unit - then, uncouple Hydraulic Hoses.

   Note: Disassemble control switch only when necessary to rewire or replace - — see appropriate paragraph.

2. Cut Cable Ties from hoses, being careful not to cut into hoses.

3. Remove both Couplers (nipple & body) from hoses - - drain hoses into container - - push rearward on Piston until fluid is drained.

4. Unscrew both hoses from Tool’s Handle.

5. Remove Retaining Ring and Cover Plate from End Cap.

6. Use Wrench, 124434, and unscrew End Cap.

7. Pull Dump Valve out of Piston.

8. Unscrew both Socket Head Cap Screws from Trigger Guard - - use hex key. Pull guard away.

9. Remove Retaining Ring from Nose Adapter.

10. Push rearward on piston and adapter until both are out of Cylinder -- pull piston out of adapter.

   Note: Ejector Gland can be removed to inspect and/or replace components without completely disassembling Tool.


10. Use a small diameter, dull-pointed rod to remove seals and back-up rings from all parts.

11. Unscrew six Socket Head Cap Screws from Handle — use hex key. Carefully lift Cylinder away from handle.

12. Pull both Gland Assemblies out
586 Series Tooling

Fig. 5

500779 O-RING
120652 EJECTOR WASHER

501411 QUAD RING
501080 BACK-UP RING
122742 EJECTOR ROD WIPER

△ NOTE ORIENTATION OF LARGE CHAMFER ON DETAIL 120652 (WASHER).

120653
GLAND ASSEMBLY

122047 GLAND

121187
GLAND ASSEMBLY

501106 B/U RING
501103 B/U RING
500812 O-RING
500809 O-RING

121175 GLAND

Figure 5 - Gland Assemblies with Part Numbers
(See Notes For Tool for disassembly tools and SERVICE PARTS KIT)
Assembly

Clean tool parts with mineral spirits, or equivalent, (see Tool and Nose Assembly Maintenance and Precautions) — inspect for wear or damage — replace as required. Always replace all seals on/in disassembled components. Use O-rings and back-up rings supplied in SERVICE PARTS KIT, also see page 6 for alternative sources. Smear LUBRIPLATE 130AA, or equivalent, on O-rings, back-up rings and mating components for ease of assembly. Assemble Tool taking care not to damage either O-rings or Back-up rings.

Caution

Use SLIC-TITE on pipe threads — do not use TEFILON tape.

1. Place both Gland Assemblies in Cylinder.

2. Carefully push Handle onto Gland assemblies. Screw two Socket Head Cap Screws into opposite sides of handle — tighten with hex key. Install remaining screws. Tighten all screws evenly to 18-22 foot pounds.

3. Install Ejector Gland Assembly and Pintail Ejector into Piston as follows to prevent damage to loose O-ring:
   a. Place O-ring in groove of threads, Back-up ring; QUAD ring in I.D. and O-Ring on O.D. of Gland.
   b. Hold Ejector Washer against back of gland to contain O-ring.
   c. Slide pintail ejector through washer and assembled gland — start ejector from washer side.
   d. With ejector end holding washer and gland together, slide assembly into piston rod — by hand, screw gland in for two or more threads — tighten gland with special hex wrench, 122048.
   e. Slide Ejector Rod Wiper over ejector and push into gland.
   f. Tighten ejector gland with spanner wrench, 122048.

4. Push Adapter into Cylinder - - install Retaining Ring into groove.

5. Align hole in piston with pocket in adapter - - push piston into cylinder. Rotate piston or adapter until holes are aligned. Push Dump Valve through piston - - valve goes farther than piston thickness when bottomed - - four (4) flats are to rear of Tool.

6. Using Wrench, 124434, thread End Cap completely into cylinder. Back end cap out until until nearest cap slot aligns with cylinder groove. Push Locator into recess - - if locator does not seat flush with cylinder, remove end cap and reposition dump valve’s indexing pin into adapter pocket.

7. Slide Cover Plate over End Cap. Install Retaining Ring.

8. Push electrical cord through Strain Relief and attach wires to Switch — use hex key.

9. Screw both Hoses into handle - - see Caution. Screw Coupler Nipple onto hose in port P and Coupler Body in port R.

10. Install new cable ties - - see Warning in Disassembly.
    a. Connect Hydraulic Hoses to POWERIG Hydraulic Unit.
    b. Connect Control Cord Plug to hydraulic unit.

11. Important — see Preparation for Use for WARNINGS, CAUTIONS, procedure for Tool set-up and checking installed fasteners. See Operating Instructions for safe fastener installing procedure — after checking performance, return Tool to service.
Figure 6 - Handle Assembly, 123407
(See Notes For Tool for disassembly tools and SERVICE PARTS KIT)

Handle assembly, 123407, may be purchased as a single part number or individual parts may be purchased separately.
NOTE: This kit, supplied with 586 Tool, gives the option of modifying your Tool to suit certain safety/power requirements. The new female cord and connector assembly, 506018, must replace the cord on your present hose and cord kit--attach male connector, 110686, to new cord. Install cable ties as required. To obtain Tool with kit installed, specify 586NS.

Figure 7 - Optional Control Cord Assembly Kit, 121248
(to modify 586 to 586NS, see NOTE)
586 Series Tooling

Please note:
Assembly includes latest instruction component part numbers.
To obtain online sub-assembly when purchasing a main component, please include related parts, for example, piston. O-ring: backup ring.

Rev. 7-95
Huck International, Inc. has determined the hydraulic cylinder on all model 585 and 586 installation tools should be replaced after approximately 160,000 installations or three (3) years of continuous use, whichever occurs first. Fatigue can occur at the rear of the cylinder in the thread relief area depending on the severity of the application and the usage factor.

When the cylinder is used beyond its normal life in severe duty, the End Cap and Retaining Ring can separate from the hydraulic cylinder allowing hydraulic fluid to escape under pressure. This event could possibly result in a serious injury or a spray of hydraulic fluid. To prevent this occurrence and assure operator safety, the hydraulic cylinder is to be replaced prior to reaching the possible fatigue condition.

Huck International, Inc. is offering replacement cylinders at attractive rates to facilitate this process. Contact your Huck Customer Service Representative at (800) 278-4825 for price and availability information.
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

Rev. 8-3-95
385
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's sole liability and Buyer's exclusive remedy for any breach of warranty shall be limited, at Huck's option, to replacement or repair, at FOB Huck's plant, of Huck manufactured tooling, other items, nonstandard or custom products found to be defective in specifications, workmanship and materials not otherwise the direct or indirect cause of Buyer supplied molds, material, tooling or fixtures. Buyer shall give Huck written notice of claims for defects within the ninety (90) day warranty period for tooling, other items, nonstandard or custom products described above and Huck shall inspect products for which such claim is made.

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Huck shall not be liable for any loss or damage resulting from delays or nonfulfillment of orders owing to strikes, fires, accidents, transportation companies or for any reason or reasons beyond the control of the Huck or its suppliers.

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

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