SAFETY

This instruction manual must be read with particular attention to the following safety guide lines, 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 your 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. 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.

12. Never place hands between nose assembly and work piece.
**PRINCIPLE OF OPERATION AND TOOL SPECIFICATIONS**

*READ INSTRUCTIONS THOROUGHLY PRIOR TO OPERATING THE RIVETER. THIS RIVETER IS DESIGNED FOR INTERMITTENT DUTY AND MAINTENANCE WORK ONLY.*

**HK-150 Manual Hydraulic Riveter**

The HK-150 is a hydraulic tool designed to set from 1/8 inch up to and including 1/4 inch diameter steel, stainless steel, aluminum and plastic rivets by changing only the nose piece. The HK-150 has a rated pull pressure of over 3,500 lbs and one handed operation gives access to tight areas.

The hydraulic system is sealed, oil need not be added. If the HK-150 should become damaged and leaks oil from the tool, it should be returned to an authorized service center. *(Authorized Service centers may be found in the Authorized Tools Centers section.)*

**Table:**

<table>
<thead>
<tr>
<th>Model</th>
<th>Stroke</th>
<th>Rivet Diameter</th>
<th>Rivet Materials</th>
<th>Pull Pressure</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>HK-150</td>
<td>5/8&quot;</td>
<td>1/8&quot;-1/4&quot;</td>
<td>Stainless Steel, Aluminum, Plastic</td>
<td>3,500 lbs</td>
<td>28 oz</td>
</tr>
</tbody>
</table>

**Diagram:**

- Tool Body
- Full Extension
- Pump Handle
- Releasing Button
- 201050 Jaw Holder
- 201061 Nose Tube
- Nose Piece See Pg. 5
- Jaws (3 PC)-202329 (2 PC)-202122
- Jaws Pusher
- Puller Shaft
- 202124 Return Spring
- 202312 Reservoir Shield

**ACCESSORIES**

* NUTSETTER KITS:
  - 205400 (NUTSETTER KIT)
  - 205401 (METRIC NUTSETTER KIT)
  - 205403 (RIVNUT NUTSETTER KIT)
  * NOSE EXTENSION KIT: 205490

** See Optional Accessories Section for more accessories.
**Operating Instructions**

The HK-150 hydraulic riveter installs fasteners by a pull and release system. Pumping the handles (see fig. 2 on the next page) will actuate the tool. The tool must be actuated when installing fasteners or changing nose pieces. After installing the fastener or changing the nose piece, the tool must be returned to its original position. This releases the pintail if a fastener was installed. To do this point the tool downward, squeeze HANDLES and push in RELEASING BUTTON (see fig. 3). The pintail should drop out. (See sections on NOSE PIECE INSTALLATION and FASTENER INSTALLATION for detailed instructions.)

![Diagram of Pintail and Body]

**Nose Piece Installation:**

**SELECT THE PROPER NOSE PIECE FOR THE CORRECT INSTALLATION OF FASTENER AND FUNCTION OF TOOL.**

**To change the Nose Piece**

1. Remove the NOSE PIECE in the tool by unscrewing it in a counterclockwise direction.
2. Actuate tool until it is fully extended. (There should be gap of approximately 7/8" in between the RESERVOIR SHIELD and the TOOL BODY. (see fig. 1))
3. Hand tighten the NOSE PIECE into the NOSE TUBE and release the tool by squeezing the HANDLES and pressing the RELEASING BUTTON at the same time.

**Fastener Installation:**

**Install correct nose piece on tool (see NOSE PIECE installation section).**

1. Insert pintail of rivet in to the NOSE PIECE.
2. Position the RIVET BODY in to WORK PIECE to be fastened.
3. Hold the tool steady against the work piece and pump HANDLES until rivet is set and pintail is broken* See fig. 2 on the next page.

---

**Note:**

**Before operating tool, make sure that all NOSE PARTS have been screwed in HAND TIGHT.**

**Frequently check that nose components do not vibrate loose during operation.**

---

*The HK-150 has a 5/8 inch work travel and will set most rivets in one cycle (approx. 12 pumps). If the tool reaches the end of its travel before the rivet breaks, DO NOT continue pumping the HANDLES on the tool. Release the tool by squeezing the HANDLES and pressing the RELEASING BUTTON, regrip the rivet, pump the HANDLES and finish the installation.*
Rivet Pintail Removal:

Once Rivet is installed pintail must be removed

1. Point tool downward
2. Squeeze the HANDLES while pressing the RELEASING BUTTON

It is necessary to REMOVE PINTAIL BEFORE ATTEMPTING TO INSTALL ANOTHER RIVET
Three/Two Piece Jaw Installation and

1. The jaws are installed at the factory and should only need to be removed for periodic inspection and cleaning. To remove the jaws unscrew the NOSE TUBE from the tool in a counterclockwise direction.

2. **TWO PIECE JAW SYSTEM**
   Remove the JAW HOLDER by unscrewing it in a counterclockwise direction. Drop JAWS out from SPRING side. Push JAW PUSHER through PULLER SHAFT while squeezing the RELEASING TRIGGER (See Figure 3 above).

3. **TWO PIECE JAW SYSTEM**
   To replace JAWS, hold JAW HOLDER large end down and at a slight angle. Place jaws in one at a time. Add a small amount of jaw lubricant to jaws and jaw holder prior to assembly.

2. **THREE PIECE JAW SYSTEM**
   Remove the JAW HOLDER by unscrewing it in a counterclockwise direction. Drop JAWS out from SPRING side. Actuate tool by squeezing the ACTUATING TRIGGER (see fig 3 above) until the jaw pusher is fully extended. Stop as soon as the JAW PUSHER is in the extended position.

3. **THREE PIECE JAW SYSTEM**
   To replace JAWS, hold JAW HOLDER large end down and at a slight angle. Hold finger over small opening and place jaws in one at a time. Add a small amount of jaw lubricant to jaws and jaw holder prior to assembly.
4. When jaws are in place, insert jaw holder into spring, being sure to keep large end of jaw holder pointing downward.

5. **TWO JAW SYSTEM**
Hold tool with the PULLER SHAFT pointing down and screw the jaw holder on to the PULLER SHAFT. HAND TIGHTEN ONLY.

5. **THREE JAW SYSTEM**
Hold tool with the PULLER SHAFT pointing down and the JAW PUSHER fully extended. Screw the jaw holder on to the PULLER SHAFT. HAND TIGHTEN ONLY.

6. Replace the NOSE TUBE and NOSE PIECE, HAND TIGHTEN ONLY. The tool is now ready to use.
**Steps for Proper Tool Maintenance and Operation**

1. Disassemble and clean NOSE components periodically or if the pintails do not drop out freely. Use a pick to clean the jaw grooves. Wash components in mineral spirits or isopropyl alcohol. Apply a small amount of lubricant to the JAWS and inside of JAW HOLDER prior to assembly.

2. To ease NOSE TUBE and NOSE PIECE installation, extend tool by pumping HANDLES.

3. **Do not use tool as a lever** if rivet pintail is jammed while regripping. Instead, squeeze HANDLES and press the RELEASING BUTTON while pushing tool nose against work piece for the jaws to get a deeper grip.

4. If rivet pintail is stuck in tool after breaking, lightly tap nose against a hard surface while squeezing HANDLES and pressing the RELEASING BUTTON with tool pointing downward. Pintail should then fall out.

5. Before operating tool, make sure that all NOSE PARTS have been screwed in HAND TIGHT.

6. The tool has a 5/8” work travel, the completion of which is indicated by a solid stop after approximately 12 pumps (one cycle). **Do not force beyond this point** to insure long life of tool.

7. The HK-150 should not be used at temperatures below 35°F unless it is first brought to room temperature and cycled several times. Normal use of the tool after warming should keep it warm enough for proper operation.

8. If tool will not reverse, remove NOSE TUBE and inspect for any foreign matter that might have caused jamming between JAW HOLDER and inside of NOSE TUBE.

9. Frequently check that nose components do not vibrate loose during operation.

10. **Do not rock tool** when pumping it. This may cause rivets to prematurely break.

11. Large fasteners can be set one handed in tight areas by using short pump strokes.

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### Nose Pieces

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
<th>Part No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>202156</td>
<td>1/8” for Trim Molcing Pop Rivets</td>
<td>202155</td>
<td>1/4” Auto Split &quot;T&quot; Rivets</td>
</tr>
<tr>
<td>Ø.093</td>
<td></td>
<td>Ø.160</td>
<td></td>
</tr>
<tr>
<td>202159</td>
<td>'3/32&quot; &amp; 1/8&quot; Pop Rivets</td>
<td>202157</td>
<td>1/4” Pop &amp; Plastic Rivets</td>
</tr>
<tr>
<td>Ø.098</td>
<td></td>
<td>Ø.160</td>
<td></td>
</tr>
<tr>
<td>202190</td>
<td>1/8” Stand Off Pop Rivets</td>
<td>202169</td>
<td>1/4” Monobolts</td>
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<tr>
<td>Ø.093</td>
<td></td>
<td>Ø.160</td>
<td></td>
</tr>
<tr>
<td>202158</td>
<td>5/32” &amp; 3/16” Pop &amp; Plastic Rivets</td>
<td>202193</td>
<td>Spec. GM Glass Stop Travel, Pop Rivets</td>
</tr>
<tr>
<td>Ø.130</td>
<td></td>
<td>Ø.160</td>
<td></td>
</tr>
<tr>
<td>202168</td>
<td>3/16” Monobolts</td>
<td>202142</td>
<td>1/4” Magna Lok</td>
</tr>
<tr>
<td>Ø.125</td>
<td></td>
<td>Ø.172</td>
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</tbody>
</table>
# Troubleshooting

<table>
<thead>
<tr>
<th>Problem</th>
<th>Solution</th>
</tr>
</thead>
</table>
| 1.) Rivet pintail is stuck in tool          | **First Step:** Lightly tap nose against a hard surface while after breaking squeezing HANDLES and pressing down the RELEASING BUTTON with tool pointing downward Pintail should then fall out, see fig. 4. *(If that does not work try Second Step.)*  
**Second Step:** *(Use this only if first step does not work)* Remove NOSE TUBE and JAW HOLDER (for help see figure 5) take out pintail and reassemble. |
| 2.) Tool will not reverse                    | Push on the handles until you feel a slight give, then press the RELEASING BUTTON and continue pushing on the handles, the tool should then reverse. If this does not work Remove NOSE TUBE and inspect for any foreign matter that may have cause the jamming between JAW HOLDER and the inside of NOSE TUBE. |
| 3.) Fastener does not pull rivet            | The JAW HOLDER is loose. Remove the NOSE TUBE and tighten the JAW HOLDER by turning it counter clockwise (see (See Three Piece Jaw Installation and Removal)). |
| 4.) The rivet does not fit into the tool    | The rivet is to large, or the wrong NOSE PIECE is on the tool. To find the correct NOSE PIECE (see chart on page 11). If you do not have the needed NOSE PIECE, See next page for how to order the correct one. |
| 5.) Premature breaking                       | See solution for problem 4. Also verify the grip of the fastener and make sure you are not rocking the tool during installation. |
| 6.) Jamming of tool                          | See solution for problem 4. Also verify that you have the proper jaw engagement and that all parts are hand tight and that the jaws are cleaned and properly assembled in jaw pusher (See Three Piece Jaw Installation and Removal) |
| 7.) Rivet not installed properly            | See solution for problem 4. Also verify jaw grip and that the appropriate fastener is being used. |
| 8.) Jaws breaking                            | See solution for problem 4. Check to see all parts are properly assembled and hand tight. |
| 9.) Damaged jaw pusher                       | See solution for problem 4. Check to see if all parts are properly assembled. |
OPTIONAL ACCESSORIES

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>202156</td>
<td>Nose Piece - 1/8” for Trim Molding Pop Rivets</td>
</tr>
<tr>
<td>202159</td>
<td>Nose Piece - 3/32” &amp; 1/8” Pop Rivets</td>
</tr>
<tr>
<td>202190</td>
<td>Nose Piece - 1/8” Stand Off Pop Rivets</td>
</tr>
<tr>
<td>202158</td>
<td>Nose Piece - 5/32” &amp; 3/16” Pop and Plastic Rivets</td>
</tr>
<tr>
<td>202168</td>
<td>Nose Piece - 3/16” Monobolts</td>
</tr>
<tr>
<td>202155</td>
<td>Nose Piece - 1/4” Auto Split “T” Rivets</td>
</tr>
<tr>
<td>202157</td>
<td>Nose Piece - 1/4” Pop and Plastic Rivets</td>
</tr>
<tr>
<td>202169</td>
<td>Nose Piece - 1/4” Monobolts</td>
</tr>
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<td>202193</td>
<td>Nose Piece - Spec. GM Glass Stop Travel, Pop Rivets</td>
</tr>
<tr>
<td>202142</td>
<td>Nose Piece - 1/4” Magna Lok</td>
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<tr>
<td>205490</td>
<td>Nose Extension Kit</td>
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<td>Metric Nut Setter Kit</td>
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<td>205403</td>
<td>Rivnut Nut Setter Kit</td>
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<tr>
<td>126016</td>
<td>Rivet Stem Removal Tool “Punch Assembly”</td>
</tr>
<tr>
<td>202122</td>
<td>Two Piece Jaws</td>
</tr>
<tr>
<td>202929</td>
<td>Three Piece Jaws</td>
</tr>
</tbody>
</table>

To order an item please call 1-800-278-4825 for aid in finding nearest dealer.
CONVERTING A RIVETER TO A NUTSETTER

The HK-150 can be converted from a riveter to a nutsetter by changing several of the nose components. No tools required as parts require hand tightening only.

1. COMPLETELY RETRACT THE TOOL BY SQUEEZING HANDLES AND PRESSING THE RELEASING BUTTON. (FIGURE 3)

2. REMOVE NOSE PIECE FROM NOSE TUBE. REMOVE NOSE TUBE, JAWS AND JAW HOLDER.

The parts that were removed should be stored for future use as a riveter. The tool is ready to start adding NUTSETTER accessories as follows:

The HK-150 NUTSETTER sets 3mm through 3/8-24 threaded aluminum inserts and up to 1/4-20 steel inserts. Size changes are accomplished by changing the PULL-UP STUD and ANVIL. No tools required.

Installing threaded Inserts:
1. Make sure proper PULL-UP STUD and are ANVIL in place.
2. Thread the insert on the PULL-UP STUD until all threads on the insert are engaged.
3. Position the INSERT into workpiece with the appropriate size hole and pump the HANDLES until the INSERT is set.

(You will feel the tool come to a definite stop when the insert is properly set. STOP PUMPING HANDLES)

Releasing the Tool: (After INSERT has been set in the workpiece)
1. PRESS THE RELEASING BUTTON WHILE SQUEEZING HANDLES.
2. Rotate the TURN NUT in a counter clockwise direction until the PULL-UP STUD is released from the THREADED INSERT.