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.
CONTENTS

Description ................................................................. 1
Specifications .............................................................. 1
Dimensions ................................................................. 2
General Use and Operating Principles ......................... 3
Specific Steps for Operation and Maintenance ......... 4
MODEL HK150 - S456
MANUAL INSTALLATION KIT

Model HK150 - S456 Installation Kit consists of a manually operated, hydraulically powered installation tool and nose assembly designed to install UNIMATIC® (NAS 1919S and NAS 1921S) and Commercial Single Action (CSMLS) Blind Rivets. This kit is designed to install a few fasteners for emergency repair where compressed air is not available. Maximum grip for all diameters is 08.

A fastener is installed by squeezing pump handles, in full length strokes, until the pintail breaks. A release button on the side of tool allows tool piston and nose assembly to return, ready to install another fastener.

The tool has a rated pull pressure of 3,500 lbs. One-handed operation gives access to tight areas.

Caution: The hydraulic system is sealed; hydraulic fluid cannot be added by the user. If the tool is damaged and/or leaks fluid, IT MUST BE RETURNED TO AN AUTHORIZED DEALER FOR SERVICE.

Driving Anvils and UNITIZED™ Jaws are included to install fastener diameters and materials as shown in the table.

<table>
<thead>
<tr>
<th>Nominal Diameter</th>
<th>Driving Anvils</th>
<th>UNITIZED™ JAWS</th>
<th>MATERIALS</th>
</tr>
</thead>
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<tr>
<td></td>
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</tr>
<tr>
<td>1/8</td>
<td>111455</td>
<td>113220</td>
<td>Alum., Monel, A286</td>
</tr>
<tr>
<td>5/32</td>
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<tr>
<td>3/16</td>
<td>111457</td>
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<td>Aluminum</td>
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General Use and Operating Principles

The tool installs fasteners by a pull and release system. Pumping the handles will actuate tool and install fastener. Tool must also be actuated when changing noses. After installing fastener, or changing nose assembly, tool piston must be returned to the starting position. To do this: (1) Point tool downward. (2) Squeeze handles. (3) Push in releasing button. See NOSE ASSEMBLY INSTALLATION and FASTENER INSTALLATION for detailed instructions.

Nose Assembly Installation
Select correct driving anvil. Unscrew nose from tool. Actuate tool until piston rod is fully extended. There should be a gap of approximately 7/8" between reservoir shield and tool body. (See illustration and NOSE ASSEMBLY DATA SHEET for additional instructions.) Release piston from forward position to rear starting position by simultaneously squeezing the handles and pressing releasing button - see illustration below.

Fastener Installation
Insert pintail of fastener into nose assembly. Position fastener into work piece to be fastened. Hold tool steady and 90 degrees to structure. Pump handles until fastener pintail is broken. (See SPECIFIC STEPS FOR OPERATION AND MAINTENANCE).
Specific Steps for Operation and Maintenance

1. Disassemble and clean nose components periodically. If pintails do not drop out freely, use a pick to clean jaw grooves. 
   **CAUTION:** Do not let jaws soak in solvent as urethane softens. Air dry components immediately.

2. **CAUTION:** DO NOT USE TOOL AS A LEVER if rivet pintail is jammed while regripping. Instead, squeeze HANDLES and press the RELEASING BUTTON while pushing nose against workpiece which allows jaws to get a deeper grip.

3. Before operating tool, be sure that all NOSE PARTS and ADAPTER PARTS have been screwed in HAND-TIGHT.

4. Tool has a 5/8" work travel. A solid stop indicates completion of travel after approximately 12 pumps (one cycle). 
   **CAUTION:** DO NOT FORCE BEYOND THIS POINT to insure long life of tool.

5. Tool should not be used at temperatures below 35 degrees F. unless first brought to room temperature and cycled several times. Normal use of tool after warming should keep it warm enough for proper operation.

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

7. **CAUTION:** DO NOT ROCK TOOL when pumping it as this may cause pintails to prematurely break.

8. Large fasteners can be set one-handed in tight areas by using short pump strokes.
Alcoa Fastening Systems

DATA SHEET

122587

Nose/tool Adapter

TYPE: 99-S456 to HK150

Installation System Division
1 Corporate Drive - Kingston, NY 12401

PRODUCT REVISION: C
REVISED: 3/11/03

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Huck International, Inc.
Installation System Division
1 Corporate Drive - Kingston, NY 12401

TYPE: Nose/tool Adapter
FOR: 99-S456 to HK150
TOOL: HK150

122588 ADAPTER
122589 SPINDLE ASSEMBLY
NOSE ASSEMBLY MAINTENANCE

All parts should be inspected for wear and damage and replaced as necessary. Parts must be clean. Wash in mineral spirits and use a small pick to clean the grooves in the jaws. Part numbers etched on parts must match part numbers shown on other side of this sheet.

1. Use HK150 Installation Tool that has been properly prepared for operation per applicable Instruction Manual.

2. Unscrew Driving Anvil (1), (2) or (3) from Anvil Holder (4), with wrench, when changing fastener size or if driving anvil is worn or damaged.

3. Slide UNITIZED™ Jaws (6) into Collet (5).

4. Screw Drawbolt (7) into assembled collet. Tighten collet onto drawbolt threads with Collet Wrench, P/N 502912 (83659), using bar in drawbolt slot. Tighten collet wrench-tight.

5. Screw Spring Plunger (8) into collet until end of plunger body is slightly below edge of hole.


7. Slide Holder (4) over collet and drawbolt assembly. Screw holder in until it bottoms. Back holder out one-half turn, or less, until holder slot and drawbolt slot are aligned.

8. Install a fastener in test plate of proper thickness with proper size hole. Inspect installed fastener.

NOTES:

1. Disassemble and clean components periodically. Use pick to clean jaw grooves. Wash components in mineral spirits or isopropyl alcohol only. Do not let urethane jaw assemblies soak and do not use solvents that will cause urethane to swell. Dry components immediately after cleaning.

2. Spare parts recommended: UNITIZED jaws, driving anvils and spring plunger.

3. Service items recommended: Brush -3/32 diameter Nylon bristle, part number 105805; Collet Wrench, part number 502912 (83659); Adjustable Wrench, part number 503044.

4. All part numbers shown are available from Huck Manufacturing Company, Installation Equipment Division.

99-S456
HK-150 Riveter
12 Month Warranty

All Huck tools and parts have been carefully tested and checked at the factory and are guaranteed to be free from defects in material and workmanship, subject to the following conditions:

A. The tools manufactured by Huck will be repaired free of charge or replaced at our discretion within 12 months of sale to the first user if, upon examination at our service center, we find a defect in material or workmanship in the hydraulic system.
B. The tool must be returned intact and prepaid to one of our service centers. **Proof of date of sale must accompany any tool returned.** This warranty will be void if repairs have been made or attempted by others, or if the tool has been subject to abuse, neglect, accident or improper application.
C. The foregoing obligation is Huck's sole liability under this or any implied warranty, and no one is authorized to vary its terms or conditions.
D. If you have any problems please contact Customer Service at the factory at 800-278-HUCK (4825)

Before returning tools to the service center, please use the operation and maintenance tips on page 5. If the tool continues to malfunction call the Customer Service Department at Huck for additional assistance. You may also reach us ToolInfo@Huck.com

**Huck Certified Service Centers For the HK-150 Riveter:**

<table>
<thead>
<tr>
<th>Central Fastening Systems Inc</th>
<th>J.O. King Inc</th>
<th>Universal Repair Shop</th>
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<tbody>
<tr>
<td>801 McCann Road</td>
<td>1265 Old Alpharetta Road</td>
<td>1611 Boylston Avenue</td>
</tr>
<tr>
<td>Rogers, AK 72758</td>
<td>Alpharetta, GA 30201</td>
<td>Seattle, WA 98122</td>
</tr>
<tr>
<td>479 936 7577</td>
<td>770 751 1875</td>
<td>206 322 2726</td>
</tr>
<tr>
<td>888 370 1894 (Toll Free)</td>
<td>800 241 2681 (Toll Free)</td>
<td>206 322 2126</td>
</tr>
<tr>
<td>479 636 2119 (Fax)</td>
<td>770 442 0950 (Fax)</td>
<td>206 322 2126 (Fax)</td>
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<table>
<thead>
<tr>
<th>Cooper Aviation Limited</th>
<th>Professional Tool Center</th>
<th>FSI</th>
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<tbody>
<tr>
<td>Station Field Industrial Estate</td>
<td>2236 S.116th Street</td>
<td>1206 East Mac Arthur Street</td>
</tr>
<tr>
<td>Kidlington, Oxford OX54 1JD</td>
<td>West Allis, WI 53227</td>
<td>Sonoma, CA 95476</td>
</tr>
<tr>
<td>United Kingdom</td>
<td>414 321 1234</td>
<td>707 935 1170</td>
</tr>
<tr>
<td>01865 375 111</td>
<td>414 321 2524 (Fax)</td>
<td>800 344 2394 (Toll Free)</td>
</tr>
<tr>
<td></td>
<td></td>
<td>707 935 1828 (Fax)</td>
</tr>
</tbody>
</table>

- **All Huck Service Centers have been factory certified to service the HK-150 Riveter**
- **Only genuine Huck parts are used in the repair of your tools**
- **Most Service Centers can provide 24 hour turnaround of your tool - please specify on your return documentation that an expedited repair is required**
- **Service Centers can handle repairs on other Huck products (AK-175)**
- **Warranty Repairs are performed at only these Huck certified Service Center**