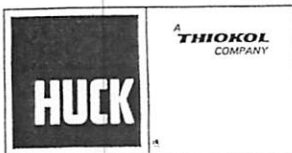
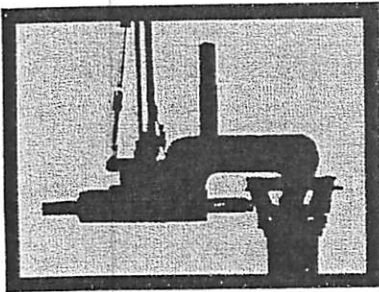
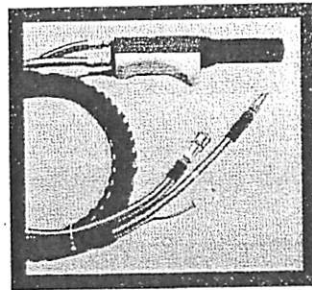
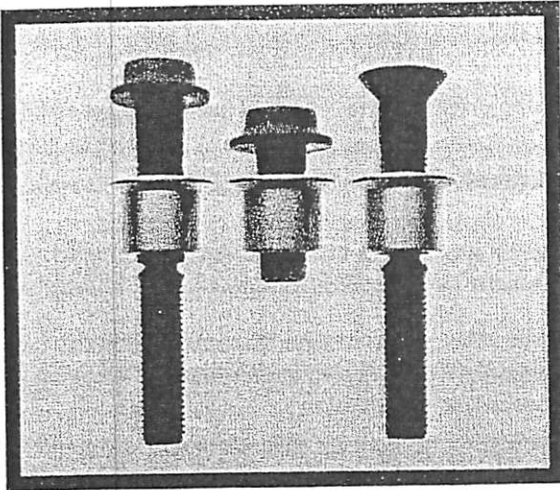




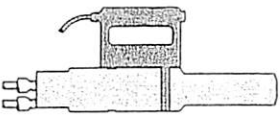
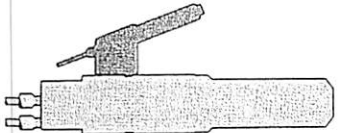
THE HUCK HP8 HUCKBOLT®

FASTENING SYSTEM



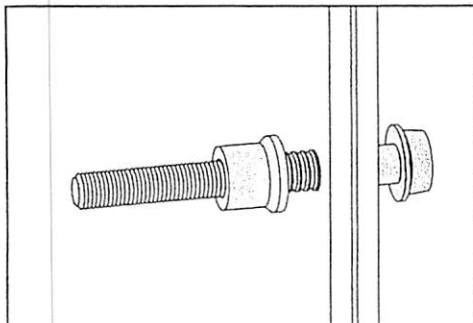
The Lockbolt Fastening System
for all Grade 8 Applications.

HPT Handle Selection Chart

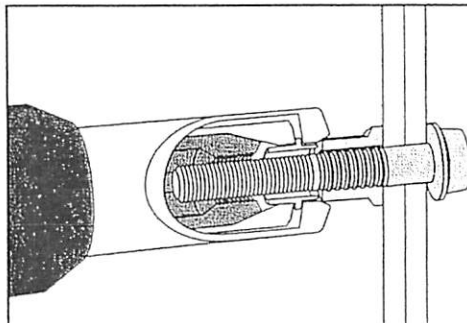
Handle Description	Installation Tools
Cylinder Handle 	HPT 25, 35, 57
Pistol Grip Handle 	HPT 25, 35, 57
"D" Handle 	HPT 57, 70, 90
Angle Handle 	All HPT Tools

Optional handle designs, shown at left, are available upon request. Specify the tool model and the handle description when ordering an easy to assemble handle kit.

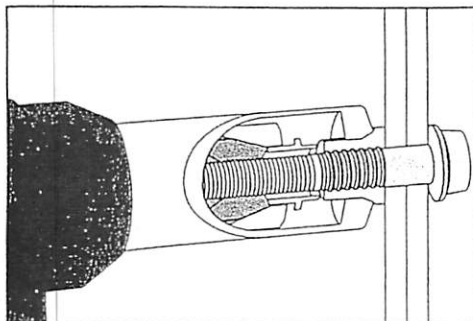
Installation Sequence



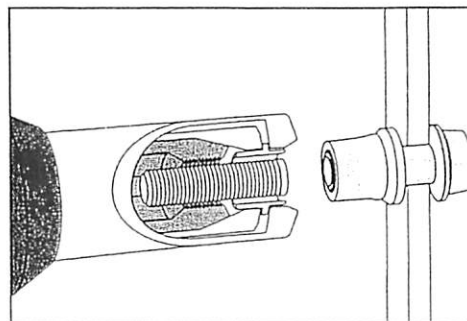
Step 1. Pin is inserted thru prepared hole. Collar is placed over pintail.



Step 2. Nose assembly is placed over pintail. Nose assembly/installation tool pulls on pin and starts drawing sheets together.

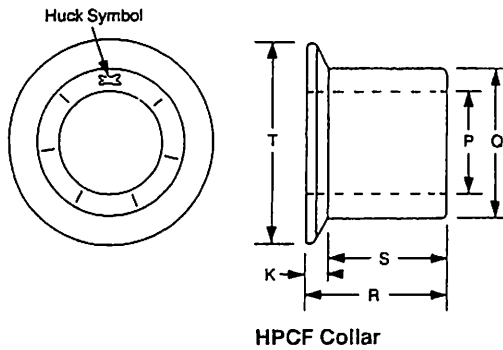


Step 3. Continued pulling on pintail swages collar into locking grooves. Controlled volume swaging lengthens collar and develops clamp.



Step 4. As pull increases, pintail breaks—anvil pushes off swaged collar.

Collar Dimensions

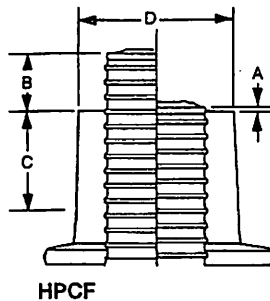


Nominal Fastener Dia	Dash No.	K Ref.	P ±.003	Q ±.003	R ±.015	S ±.015	T Dia. Max.
1/2	-16	.125	.522	.812	.750	.630	1.085
5/8	-20	.137	.648	1.009	.922	.790	1.358
3/4	-24	.187	.783	1.213	1.107	.925	1.600

Grip Data

Grip Number	Grip Range	
	Min.	Max.
- 08	.25	.75
- 12	.50	1.00
- 16	.75	1.25
- 20	1.00	1.50
- 28	1.50	2.00
- 36	2.00	2.50
- 44	2.50	3.00
- 52	3.00	3.50
- 60	3.50	4.00
- 68	4.00	4.50
- 76	4.50	5.00
- 84	5.00	5.50
- 92	5.50	6.00
-100	6.00	6.50
-108	6.50	7.00

Inspection Data



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

Nominal Dia.	Dash No.	A Max	B Max	C Min	D Max
1/2	-16	.10	.65	.56	.760
5/8	-20	.12	.67	.73	.945
3/4	-24	.12	.67	.86	1.132

A properly installed HUCKBOLT Fastener will possess the dimensions given here. Visual inspection is sufficient.

Hole Data⁽¹⁾

Nom. Dia.	Dash No.	Recommended Hole Dia.
1/2	-16	.500-.562
5/8	-20	.625-.687
3/4	-24	.750-.812

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

Minimum Fastener Values for Grade 8 (A490) Fasteners, (pounds)

Dia.	Shear	Tensile	Clamp
-16 (1/2")	17,350	21,300	16,000
-20 (5/8")	27,450	33,900	25,500
-24 (3/4")	39,850	50,100	37,600

HP8 fasteners typically provide 10-20% higher tensile values.

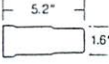
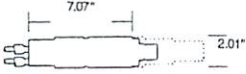

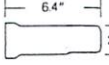


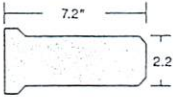
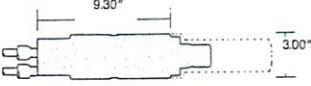

Nose Assemblies, Installation Tooling, Hose Kits and Power Units

Nose Assemblies—attached to the installation tool, are designed to install a specific diameter HP8 fastener.

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

Hose Kits—available in various lengths, connect the installation tools to the POWERIG Hydraulic units.⁽¹⁾

POWERIG Hydraulic Units—powered by gasoline or electricity, provide hydraulic pressure to power the installation tools.

Fastener Diameter	Nose Assembly	Installation Tool	Hydraulic Units ⁽²⁾
1/2"	99-1388 	HPT25 	Model 913 <ul style="list-style-type: none"> • Gasoline Powered • Weight 175 Lbs. • Length—24" • Width—21" • Height—27" 
5/8"	99-1389 	HPT35 	Model 940 <ul style="list-style-type: none"> • Electrically powered • Weight 75 Lbs. • Length—12.5" • Width—10.5" • Height—18" 
3/4"	99-1390 	HPT57 	Model 918 <ul style="list-style-type: none"> • Electrically powered • Weight 708 Lbs. • Length—44" • Width—25" • Height—30" 

⁽¹⁾**Hose Kits**—Each Hose Kit includes hydraulic hoses, control card, couplers, and electrical connectors. Hose kits available for any of the above hydraulic units; 12 ft. P/N 110838, 26 Ft. P/N 110839, 52 Ft. P/N 110841

⁽²⁾Models 913 and 918 are new versions of the Models 912 and 917. They are specifically designed to power HPT installation tools. Kits are available to modify Models 912 or 917 units to power HPT tooling. Contact the Huck Installation Equipment Division for details.

Standard Huck Tooling

HPT tooling is a new advancement in Huck tooling. It is designed for production applications, has improved clearance for easier handling and is lighter in weight compared to Huck standard tooling. Where standard tooling is utilized, the listed nose assemblies in the chart below are available. For dimensional data, refer to the applicable data sheet

Dia.	Nose Assembly	Tool #	Hydraulic Units
1/2"	99-1484	557	Choice of 912, 940, or 917
5/8"	99-1481	585	
3/4"	99-1489	506	

Collar Cutting Equipment

When collar and fastener removal is necessary, Huck recommends the use of the applicable collar cutting tool as listed below. Contact the Huck Installation Equipment Division for detailed information.

Dia.	Collar Removal Tool
1/2"	516
5/8"	520
3/4"	524