

ARCONIC
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Instruction Manual
B1100 series
Battery-Powered Tool



Follow the instructions contained in this document to ensure safe handling of the battery used with this tool.

November 29, 2017
HK1211

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Makers of Huck®, Marson®, Recoil®
Brand Fasteners, Tools & Accessories



EC Declaration of Conformity

Manufacturer:

Huck International, LLC, Industrial Products Group, 1 Corporate Drive, Kingston, NY, 12401, USA

Description of Machinery:

Model B4600 battery-powered installation tool and specials based on its design (e.g. PR####).

Relevant Provisions Complied With:

Council Directive related to Machine (2006/42/EG)

DIN EN ISO 12100:2010 Safety of machinery - General principles for design - Risk assessment and risk reduction

DIN EN 60745-1-1:2011-01 Hand-held battery-powered motor-operated tools and battery packs - Part 2-1: Particular requirements for drills

Council Directive related to EMC (2004/108/EG)

DIN EN 55014-1:2012 Electromagnetic compatibility - Requirements for household appliances, electric tools and similar apparatus - Part 1: Emission

DIN EN 55014-2:2009 Electromagnetic compatibility - Requirements for household appliances, electric tools and similar apparatus - Part 2: Immunity - Product family standard

Council Directive related to Low Voltage directive (2006/95/EG)

DIN EN 60335-1:2012 Safety of household and similar electrical appliances - Part 1: General requirements

Council Directive related to Battery ordinance (2006/66/EG)

DIN EN 62133:2003 Secondary cells and batteries containing alkaline or other non-acid electrolytes - Safety requirements for portable sealed secondary cells, and for batteries made from them, for use in portable applications

DIN EN ISO 82079-1:2012 Preparation of instructions for use - Structuring, content and presentation - Part 1: General principles and detailed requirements

European Representative:

Rob Pattenden, 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: Robert B. Wilcox

Position: Engineering Manager

Location: Huck International, LLC d/b/a Alcoa Fastening Systems & Rings, Kingston, New York, USA

Date: 01/11/2016 (November 1, 2016)



Declared dual number noise emission values in accordance with ISO 4871

A weighted sound power level, LWA: **84** dB (reference 1 pW) Uncertainty, KWA: 3 dB

A weighted emission sound pressure level at the work station, LpA: **73** dB (reference 20 µPa) Uncertainty, KpA: 3 dB

C-weighted peak emission sound pressure level, LpC, peak: **120** dB (reference 20 µPa) Uncertainty, KpC: 3 dB

Values determined according to noise test code ISO 3744. The sum of a measured noise emission value and its associated uncertainty represents an upper boundary of the range of values which is likely to occur in measurements.

Declared vibration emission values in accordance with EN 12096

Measured Vibrations emission value, a:	<2.5 m/s ²
Uncertainty, K:	1.5 m/s ²
Values measured and determined according to ISO 28662-1, ISO 5349-2, and EN 1033	

Test data to support the above information is on file at:

Arconic Fastening Systems and Rings, Kingston Operations, Kingston, NY, USA.



Safety Instructions

GLOSSARY OF TERMS AND SYMBOLS:



- Product complies with requirements set forth by the relevant European directives.



- Read manual prior to using this equipment.



- Eye protection is required while using this equipment.



- Hearing protection is required while using this equipment.

Notes: are reminders of required procedures.

Bold, Italic type, and underline: emphasize a specific instruction.



WARNINGS: Must be understood to avoid severe personal injury.



CAUTIONS: Show conditions that will damage equipment or structure.

I. GENERAL SAFETY RULES:

1. A half hour long hands-on training session with qualified personnel is recommended before using Huck equipment.
2. Huck equipment must be maintained in a safe working condition at all times. Tools and hoses should be inspected at the beginning of each shift/day for damage or wear. Any repair should be done by a qualified repairman trained on Huck procedures.
3. For multiple hazards, read and understand the safety instructions before installing, operating, repairing, maintaining, changing accessories on, or working near the assembly power tool. Failure to do so can result in serious bodily injury.
4. Only qualified and trained operators should install, adjust or use the assembly power tool.
5. Do not modify this assembly power tool. This can reduce effectiveness of safety measures and increase operator risk.
6. Do not discard safety instructions; give them to the operator.
7. Do not use assembly power tool if it has been damaged.
8. Tools shall be inspected periodically to verify all ratings and markings required, and listed in the manual, are legibly marked on the tool. The employer/operator shall contact the manufacturer to obtain replacement marking labels when necessary. Refer to assembly drawing and parts list for replacement.
9. Tool is only to be used as stated in this manual. Any other use is prohibited.
10. Only genuine Huck parts shall be used for replacements or spares. Use of any other parts can result in tooling damage or personal injury.
11. Never remove any safety guards or pintail deflectors.
12. Check clearance between trigger and work piece to ensure there is no pinch point when tool is activated. Remote triggers are available for hydraulic tooling if pinch point is unavoidable.
13. Do not abuse tool by dropping or using it as a

hammer. Never use hydraulic or air lines as a handle or to bend or pry the tool. Reasonable care of installation tools by operators is an important factor in maintaining tool efficiency, eliminating downtime, and preventing an accident which may cause severe personal injury.

14. Never place hands between assembly power tool and work piece. Keep hands clear from front of tool.

II. PROJECTILE HAZARDS:

1. Disconnect the assembly power tool from energy source when changing inserted tools or accessories.
2. Be aware that failure of the workpiece, accessories, or the inserted tool itself can generate high velocity projectiles.
3. Always wear impact resistant eye protection during tool operation. The grade of protection required should be assessed for each use.
4. For overhead work, wear a safety helmet.
5. Ensure that the workpiece is securely fixed.
6. The risk to others should also be assessed at this time.
7. Be aware of the risk of being exposed to the ejection of cuttings or chips.
8. Be aware that working on brittle material can cause harmful splinters.

III. OPERATING HAZARDS:

1. Use of tool can expose the operator's hands to hazards including: crushing, impacts, cuts, abrasions and heat. Wear suitable gloves to protect hands.
2. Operators and maintenance personnel shall be physically able to handle the bulk, weight and power of the tool.
3. Hold the tool correctly and be ready to counteract normal or sudden movements with both hands available.
4. Maintain a balanced body position and secure footing.
5. Release trigger or stop start device in case of interruption of energy supply.
6. Use only fluids and lubricants recommended by the manufacturer.
7. Avoid direct contact with the inserted tool as it can become hot.
8. Sharp tools shall always be used.
9. Be aware of risk of whipping compressed air hose.
10. Be aware of risk of cutting with tools with large dimensions.

IV. REPETITIVE MOTION HAZARDS:

1. When using assembly power tool, the operator can experience discomfort in the hands, arms, shoulders, neck or other parts of the body.
2. When using tool, the operator should adopt a comfortable posture while maintaining a secure footing and avoid awkward or off balanced postures.

continued



Safety Instructions continued

IV. REPETITIVE MOTION HAZARDS:

1. When using the assembly power tool, the operator can experience discomfort in the hands, arms, shoulders, neck or other parts of the body.
2. When using tool, the operator should adopt a comfortable posture while maintaining a secure footing and avoid awkward or off balanced postures.
3. The operator should change posture during extended tasks to help avoid discomfort and fatigue.
4. If the operator experiences symptoms such as persistent or recurring discomfort, pain, throbbing, aching, tingling, numbness, burning sensations or stiffness, these warnings should not be ignored. The operator should tell the employer and consult a qualified health professional.

V. ACCESSORIES HAZARDS:

1. Disconnect tool from energy supply before changing inserted tool or accessory.
2. Use only sizes and types of accessories and consumables that are recommended. Do not use other types or sizes of accessories or consumables.

VI. WORKPLACE HAZARDS:

1. Be aware of slippery surfaces caused by use of the tool and of trip hazards caused by the air line or hydraulic hose.
2. Proceed with caution while in unfamiliar surroundings; there could be hidden hazards such as electricity or other utility lines.
3. The assembly power tool is not intended for use in potentially explosive environments.
4. Tool is not insulated against contact with electrical power.
5. Ensure there are no electrical cables, gas pipes, etc., which can cause a hazard if damaged by use of the tool.

VII. DUST AND FUME HAZARDS:

1. Dust and fumes generated when using cutting-off and crimping power tools can cause ill health; risk assessment and implementation of appropriate controls for these hazards are essential.
2. Risk assessment should include dust created by the use of the tool and the potential for disturbing existing dust.
3. Operate and maintain the cutting-off or crimping power tool as recommended in the instruction handbook, in order to minimize dust or fume emissions.
4. Direct the exhaust so as to minimize disturbance of dust in a dust-filled environment.
5. Where dust or fumes are created, the priority shall be to control them at the point of emission.
6. All integral features or accessories for the collection, extraction or suppression of airborne dust or fumes should be correctly used and maintained.
7. Use respiratory protection in accordance with employer's instructions and as required by occupational health and safety regulations.

VIII. NOISE HAZARDS:

1. Exposure to high noise levels can cause permanent, disabling hearing loss and other problems such as tinnitus, therefore risk assessment and the implementation of proper controls is essential.
2. Appropriate controls to reduce the risk may include actions such as damping materials to prevent workpiece from 'ringing'.
3. Use hearing protection in accordance with employer's instructions and as required by occupational health and safety regulations.
4. Operate and maintain tool as recommended in the instruction handbook to prevent an unnecessary increase in the noise level.
5. Select, maintain and replace the consumable / inserted tool as recommended to prevent an unnecessary increase in noise.
6. If the power tool has a silencer, always ensure that it is in place and in good working order when the tool is being operated.

IX. VIBRATION HAZARDS:

1. Exposure to vibration can cause disabling damage to the nerves and blood supply to the hands and arms.
2. Wear warm clothing when working in cold conditions and keep hands warm and dry.
3. If numbness, tingling, pain or whitening of the skin in the fingers or hands, stop using the tool, tell your employer and consult a physician.

X. ELECTRIC SHOCKS, INJURIES OR FIRE HAZARDS

1. Do not overload the tool; work within the prescribed work capacity.
2. Never use the tool in humid or wet environment or close to inflammable substances or gases. Risk of explosion!
3. Ensure that the battery is properly secured in the grip.
4. Remove the battery when the tool is not in use and when it is undergoing repair or service.
5. Do not use the tool as a hammer.
6. When not in use, keep tool in a dry, closed room and out of the reach of children.
7. When working with the tool, always wear protective goggles. Personal protection like clothes, gloves, safety helmet, non-slip shoes, ear protection and anti-fall protection are highly recommended.
8. The air inlets for the motor should not be obstructed. Do not place anything in them.
9. When setting tool down, make sure that it cannot fall.
10. Use only genuine spare parts for repair.
11. Repair work must be carried out by skilled workers, or send the tool back to the manufacturer.
12. Do not use the tool outside of riveting holes! The fastener could be ejected from the tool! Never turn the tool towards yourself or towards another person!
13. The mandrel container must be mounted on the tool during operation.



Description

The B1100 tool is designed to install up to -08 Aluminum BobTail fasteners and is compatible with standard "L" version noses.

Specially designed for low-volume production environments, these installation tools are portable, with no hoses or cords. Batteries are easily replaced and/or recharged when they have been depleted of life.

Principle of Operation

The nose assembly is placed over the end of the fastener until the tool's anvil bottoms on the fastener. When the trigger is pressed, the drive unit draws the collet rearward and breaks the pintail of the fastener in tension. After the fastener pintail is broken, the trigger must be released, at which point the drive unit returns the collet forward. The tool is then ready for the next fastener.

Specifications

DRIVE UNIT: Brushless direct current motor

WEIGHT:

3.9 lbs (1.7 kg) without battery or nose piece
4.4 lbs (2.0 kg) with battery

STROKE: .985 in. (2.5 cm)

PULL CAPACITY: 1100 lb

BATTERY AND CHARGER:

18V battery; 100-240V/50-60Hz charger

Battery rated for 2.1 Ah

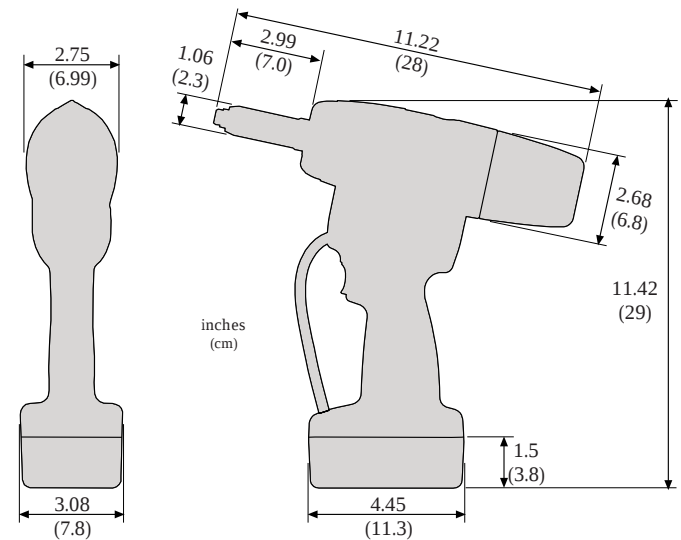
Optimum operating temperature range: 50-122°F (10°-50°C)

Full charging takes approximately 40 minutes. (Charging times may vary according to the remaining capacity and the battery temperature.)

One battery can be charged approximately 1000 times.

One fully charged battery will install approximately 500 fasteners. Number of fastener installations may vary based on the age of the battery and the size and strength of the fastener.

The tool battery has a display showing battery life in percent. Press the button in the display to activate the green LED lights for approx. 5 seconds, and use the table at right to determine capacity.



BATTERY CHARGER FUNCTION LIGHTS

INDICATOR	EXPLANATION
Constant GREEN	Battery is fully charged.
Flashing GREEN	Battery is charging.
Constant RED	Charging temperature error (Battery too hot or too cold)
Flashing RED	Battery is defective, or wrong battery

BATTERY FUNCTION LIGHTS

INDICATOR	EXPLANATION
● ● ● ● ●	Battery is fully charged.
● ● ● ● ○	Battery is at 80% capacity.
● ● ● ○ ○	Battery is at 60% capacity.
● ● ○ ○ ○	Battery is at 40% capacity.
● ○ ○ ○ ○	Battery is at 20% capacity.



Battery and Battery Charger Safety



WARNING: To protect against electric shocks, injuries or fire hazards and RISK OF EXPLOSION, follow all Safety Rules!

BATTERY CHARGER SAFETY RULES

- The charger must be used exclusively to charge the batteries that came with your tool.
- Use only the battery intended for HUCK B4600 battery tool.
- Charge only when environment temperature is between 23-131°F (-5°C to 55°C) Optimum operating temperature range: 50-122°F (10°-50°C)
- Store batteries in a dry place with no danger of frost.
- Plug the battery charger in, and gently insert the battery correctly into the charger. **ONLY** insert batteries that are cooled down. The charging operation starts automatically.
- Do not insert the battery into the charger after each use.
- If battery life becomes significantly shorter despite proper recharging, replace the battery.
- Check the cord, plug and charger regularly and have them repaired by an authorized, skilled specialist electrician when damaged.
- For repairs, use only genuine plugs and cords and genuine spare parts.
- Never use the charger in a humid or wet environment

or close to flammable substance or gases.

- Take the charger out of its packaging before use. Insert the accompanying battery correctly into the charger.
- Never try to charge non-rechargeable batteries.
- Store the charger in a dry, closed room, out of the reach of children.
- Never insert metallic parts into the charging bay - danger of short circuiting.
- If the charger is wall-mounted, make sure that the inserted battery cannot fall out due to external influences (e.g. vibrations).
- Ensure there is adequate supervision for operators of this battery charger who may be impaired, untrained, or unskilled.

BATTERY SAFETY RULES

- Never insert metallic parts into the charging bay - danger of short circuiting.
- Never try to charge a damaged battery.
- Do not insert a dirty or wet battery into the charger.
- Never throw batteries into the waste, into fire, or into water. If old batteries must be replaced, give used batteries to an approved battery recycler. **NEVER THROW DISCARDED BATTERIES INTO THE WASTE, INTO FIRE, OR INTO WATER!**

Maintenance



CAUTION: Always replace all seals, wipers, O-rings, and Back-up rings when the tool is disassembled for any reason.

NOTE: As experience dictates, spare components such as jaws should be kept on hand for repairs. Keep perishable parts (O-rings and seals) on hand for replacement whenever the tool is disassembled.

GOOD SERVICE PRACTICES

Regular maintenance will extend the operating efficiency and service life of this tools. For tools that are used intensively, servicing ahead of schedule is recommended. Tools should be serviced by personnel who are thoroughly familiar with them and how they operate. Service the tool in a clean, well lit area. Give special care to prevent contamination of pneumatic and hydraulic systems. Carefully handle all parts and components. Before reassembly, examine hoses, parts, and components for damage and wear; replace when necessary. Disassemble and assemble tool components in a straight line. Do NOT bend, twist, cock, or apply undue force. Follow the disassembly and assembly procedures in this manual. If HUCK recommended procedures are not followed, the tool could be

damaged. Have available all necessary hand tools (standard and special); a half-inch brass drift and wood block; an arbor press; and a soft-jaw vise. Unsuitable hand tools could cause tool damage.

PREVENTIVE MAINTENANCE

The maintenance of the this blind riveting tool is limited to the nose assembly and the associated wearing parts:

- Remove battery from the tool.
- Unscrew the retaining nut using flat wrench, and remove the anvil. Clean, and check for **and remove** any foreign object debris.
- Unscrew the jaw housing using flat wrenches.
- Take out the jaws and follower, and clean them. Replace the jaws if they are worn.
- Re-assemble in reverse order ensuring that all parts are tightened.

Regular maintenance will extend the service life of your high-quality tools. For tools that are used intensively, servicing ahead of schedule is recommended.



Preparation for Use

**WARNINGS:**

When operating Huck equipment always wear approved eye protection. Severe eye injury may occur if eyes are not protected. The tool moves forcibly while installing fasteners. Be sure there is adequate clearance for the tool and the operator's hands before proceeding. Otherwise, severe personal injury may result.

**CAUTIONS:**

Do not abuse the tool by dropping it, using it as a hammer, or otherwise causing unnecessary wear and tear. Reasonable care of tools by operators is an important factor in maintaining tool efficiency and reducing downtime.

1. Remove Battery.
2. Select correct nose assembly for application.
3. Screw in the nose piece and tighten it.
4. Put the battery back in and activate the switch.

Operating Instructions



WARNING: The tool moves forcibly while installing fasteners. Be sure there is adequate clearance for the tool and the operator's hands before proceeding. Otherwise, severe personal injury may result.

**CAUTIONS:**

Tool must be held perpendicular to the workpiece.

Tool must be centered on the fastener to ensure proper installation.

To prevent structural and tool damage, be sure there is enough clearance for the tool to move during installation process.

1. Place fastener in workpiece, and position tool over fastener.
2. Press the tool trigger to begin fastener installation; then release the trigger when the tool "kicks back", which is an indicator of cycle completion. Remove the tool.
3. If tool is adjusted correctly for swaged condition of the collar, one stroke will install fastener.

The blind riveting tool features optimised operating speed. After inserting the blind rivet, the blind riveting tool can be operated in two different modes:

a. Pressing and holding the switch:

Press and hold the switch to start riveting. The pulling process stops automatically when the rivet reaches the rear end position. The tool automatically assumes the front starting position when the switch is released.

b. Tapping the switch:

Riveting is triggered by briefly tapping and immediately releasing the switch. As soon as the mandrel breaks off, the blind riveting tool stops and automatically re-assumes the front starting position.

Eject the spent mandrel by tilting to the rear into the spent

mandrel container or to the front through the nose piece.

This tool is equipped with **overload protection**. In the event of overload, e.g. by setting fasteners that are outside the working range, operation stops, indicated by the 3 LEDs flashing slowly (1 Hz). Press the switch to make the tool go back to the start position and it will be ready for operation.

The control detects a blockage on return (e.g. dirt, foreign object, etc. in the anvil assembly). The tool stops the return procedure and immediately assumes the rear end position automatically. The fault is indicated by the LEDs flashing rapidly (2 Hz). The battery pack must be removed and the fault eliminated. Then reinsert the battery and briefly press the switch. The tool assumes the front end position and is again ready for use.

This tool is fitted with an **acoustic warning device**, which provides information about the remaining battery time. Beeps sound to tell the user when to change the battery. This ensures that the tool will not switch off during operation:

3 beeps and flashing LED lights for 10 seconds:

The battery needs to be changed soon (about 20% battery charge remaining).

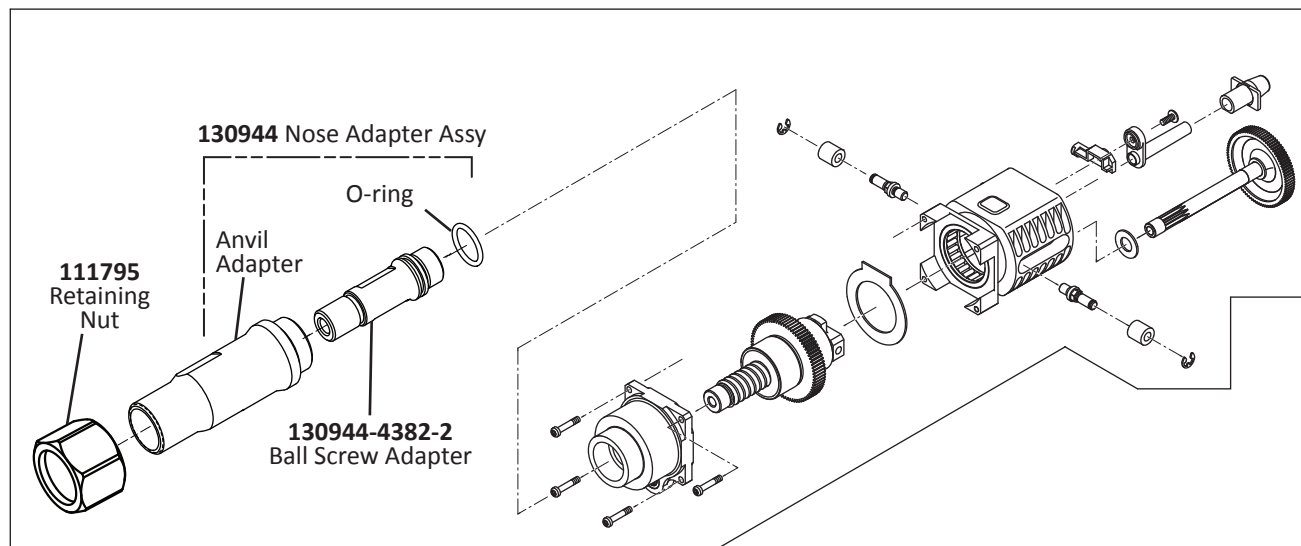
6 beeps and flashing LED lights for 10 seconds after every setting sequence:

Change the battery after a few more riveting sequences in order to guarantee safe riveting sequences (approx. 10% battery remaining).

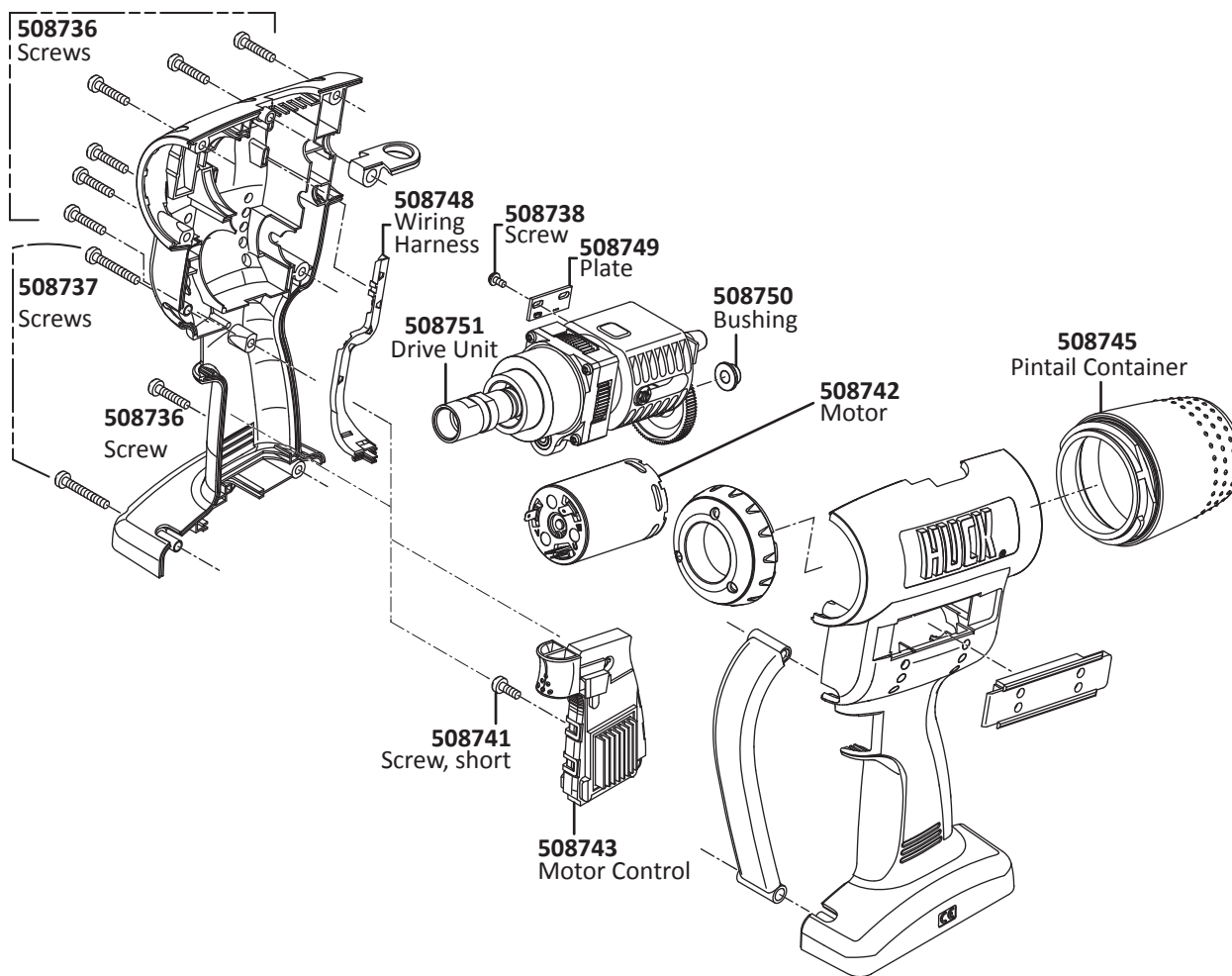
9 beeps and flashing LED lights for 10 seconds:

The next riveting sequence cannot be reliably carried out. The blind riveting tool is switched off. Change the battery.

Components Drawing



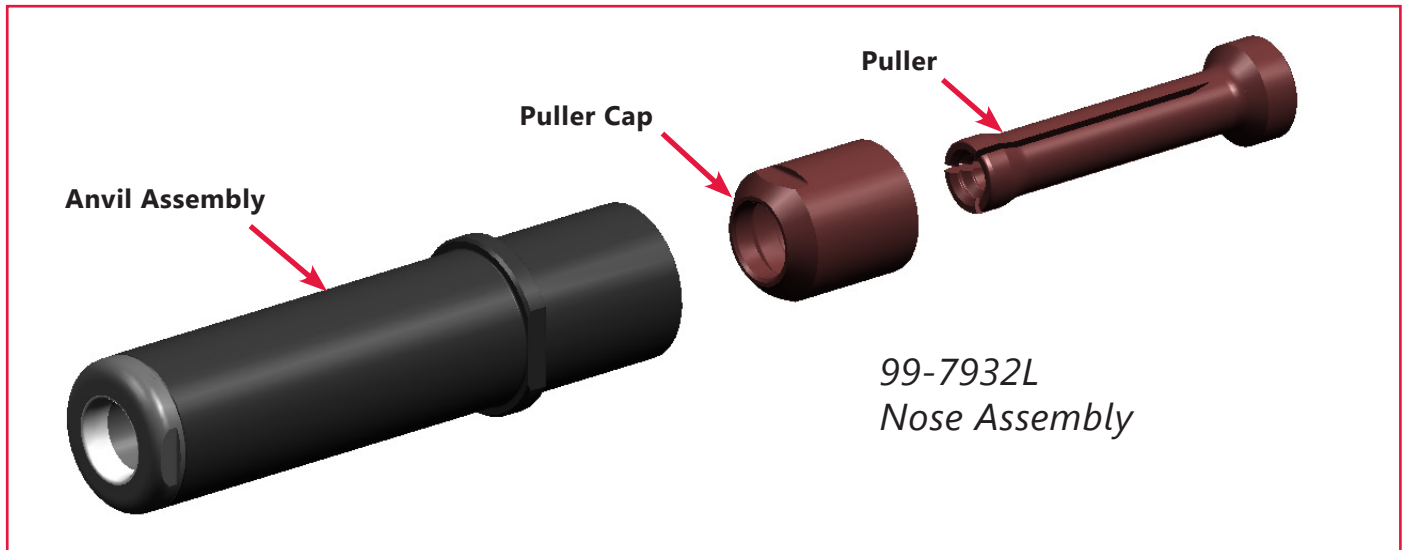
Drive Unit





Attaching a Nose Assembly

1. Unscrew tool retaining nut.
2. Slide puller cap of nose assembly onto puller; then, while holding piston rod flats with a wrench, screw puller and cap onto tool piston until wrench tight.
3. Slide anvil assembly over puller and into tool nose adapter.
4. Thread retaining nut onto nose adapter and wrench tight.





Kits and Accessories

BATTERY (QUICK-CHANGE): 18.0 V: B-18

BATTERY CHARGER: 100 V-240 V~/50-60 Hz: CH-18-120-240

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 Trouble Shooting Chart as an aid for locating and correcting trouble.

- 1. Tool fails to operate when trigger is pressed:**
 - a. Battery is loose or not connected.
 - b. Battery is depleted.
- 2. Pintail stripped and/or swaged collar not ejected from anvil:**
 - a. Check for broken or worn jaws in nose assembly.
 - b. Check for worn anvil.
- 3. Tool overloaded (LED flashes slowly - 1Hz):**
 - a. Check that fastener installation requirements are within the tool's work capacity (see page 9).
- 4. Tool will not return collet to forward position:**
 - a. Check that there is no blockage in the anvil housing (see page 9).



Limited Warranties

Limited Lifetime Warranty on BobTail® Tools:

Huck International, Inc. warrants to the original purchaser that its BobTail® installation tools manufactured after 12/1/2016 shall be free from defects in materials and workmanship for its **useful lifetime**. This warranty does not cover special order / non-standard products, or part failure due to normal wear, tool abuse or misapplication, or user non-compliance with the service requirements and conditions detailed in the product literature.

Two Year Limited Warranty on Installation Tools:

Huck International, Inc. warrants that its installation tools and Powerigs® manufactured after 12/1/2016 shall be free from defects in materials and workmanship for a period of two years from date of purchase by the end user. This warranty does not cover special order / non-standard products, or part failure due to normal wear, tool abuse or misapplication, or user non-compliance with the service requirements and conditions detailed in the product literature.

90 Day Limited Warranty on Nose Assemblies and Accessories:

Huck International, Inc. warrants that its nose assemblies and accessories shall be free from defects in materials and workmanship for a period of 90 days from date of purchase by the end user. This warranty does not cover special clearance noses, or special order / non-standard product, or part failure due to normal wear, abuse or misapplication, or user non-compliance with the service requirements and conditions detailed in the product literature.

Useful lifetime is defined as the period over which the product is expected to last physically, up to the point when replacement is required due to either normal in-service wear, or as part of a complete overhaul. Determination is made on a case-by case basis upon return of parts to Huck International, Inc. for evaluation.

Tooling, Part(s) and Other Items not manufactured by Huck:

HUCK makes no warranty with respect to the tooling, part(s), or other items manufactured by third parties. HUCK expressly disclaims any warranty expressed or implied, as to the condition, design, operation, merchantability, or fitness for use of any tool, part(s), or other items thereof not manufactured by HUCK. HUCK shall not be liable for any loss or damage, directly or indirectly, arising from the use of such tooling, part(s), or other items or breach of warranty or for any claim for incidental or consequential damages.

Huck shall not be liable for any loss or damage resulting from delays or non-fulfillment 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

Outside USA and Canada

Contact your nearest Huck International location (see reverse).

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 Tool Kits and Nose Assemblies. Please contact your Huck Representative or the nearest Huck International location (see reverse) for the ATSC in your area.



ARCONIC

Innovation, engineered.

Arconic Inc. (NYSE: ARNC) creates breakthrough products that shape industries. Working in close partnership with our customers, we solve complex engineering challenges to transform the way we fly, drive, build and power.

Through the ingenuity of our people and cutting-edge advanced manufacturing, we deliver these products at a quality and efficiency that ensures customer success and shareholder value.

Arconic Fastening Systems and Rings world-wide locations:

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FAX: 03-764-5510

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NOTICE: The information contained in this publication is only for general guidance with

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