

HUCK Fastening Systems

truck cabs

trailers

recreational vehicles

automotive

buses

cargo containers

construction

heating

air conditioning

signs and displays

electrical

aircraft

manufacturing

awnings

metal furniture

appliances

boats and ships

storage racks



For more than a century, the goal of HUCK Fasteners has been to provide customers with problem-solving and cost-efficient fastening solutions. HUCK meets this goal by offering complete fastening systems. The company's products include blind rivets, blind bolts and lockbolts, as well as a full line of pneudraulic and hydraulic tooling and installation equipment.

To assist its customers in their assembly of quality products, HUCK Fasteners emphasizes stringent quality control standards in the manufacture of these industrial fastening systems. HUCK facilities have been recognized as compliant with various quality standards, including ISO 9001 and QS 9000. The company has also been awarded the highest ratings by major automotive and industrial customers.

HUCK fastening systems are backed up by the company's state-of-the-art Technical Research, Development and Testing Center, with further support provided by a worldwide network of sales/distribution offices.



**Huck
Fasteners**

From Cordant Technologies

FOR THE LONG HAUL™

Welcome to the HUCK International's interactive catalog. In order to better navigate this program, take a look at the pages below. If you have any questions while you're browsing our catalog click on the "?" button at the bottom of each page, it will take you back to this "Help" page.

Clicking this button will take you back to the previously viewed page

Takes you to the introduction of product group

Click this button for tooling options for this fastener

Takes you to the Table of Contents page

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Clicking on the tool model number will take you to detailed information about that tool

Clicking on the nose assembly number will take you to a detailed drawing

Click on installation sequence to view animation

Contact HUCK

Clicking on the fastener name will take you back to that fastener

Clicking on the nose assembly number will take you to a detailed drawing

Clicking on the fastener name will take you back to that fastener

Clicking on the tool model number will take you to detailed information about that tool

Moving the mouse over hyperlinks will cause the cursor to change to a pointing hand or pointing arrow. Click on a hyperlink will allow you to go to a related topic.

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SURE SET RIVETS

SureSet™ rivets feature extended grip ranges to meet a variety of fastening applications, allowing for reductions in part numbers. The Grip-Rite™ and Auto-Clamp™ fasteners provide a permanent, vibration-resistant clamp. These fasteners are widely used in automotive, HVAC, light construction and electronic cabinetry.

Grip-Rite™

Blind rivet featuring a wide grip range

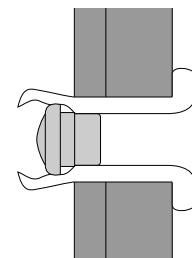
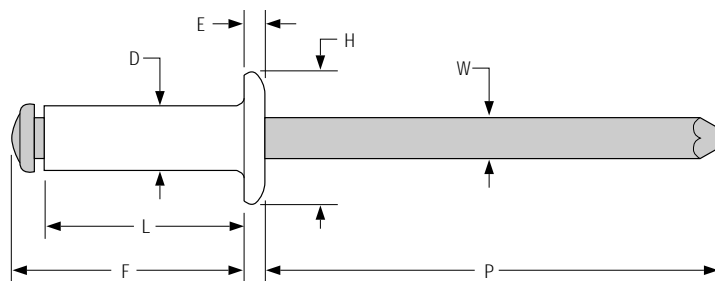
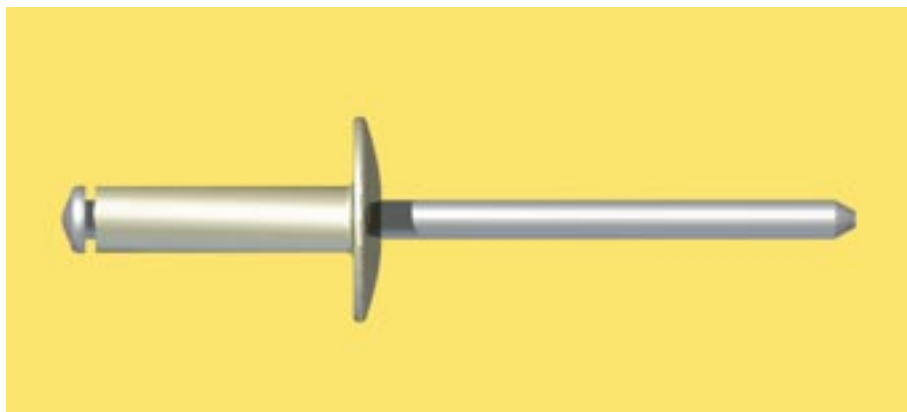
Auto-Clamp™

Two-piece rivet, with a wide grip range and low-profile head

Grip-Rite SureSet™ Rivet

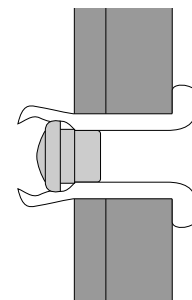
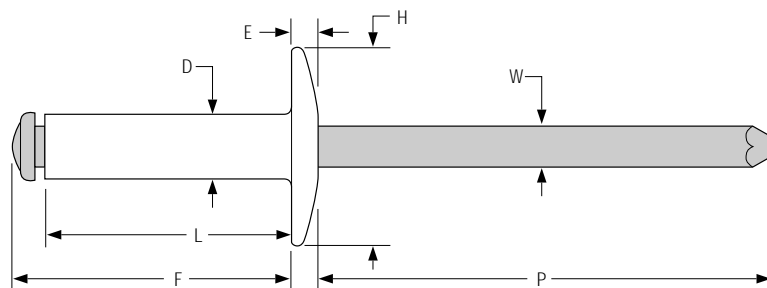
Precision two-piece, all-metal fastener ideally suited for use in blind (one side access only) and non-blind applications.

Can be used with just about any combination of materials. Available in 3/32"-1/4" diameters and in domed, large flange and 120° flush head styles.



Dimensional Data—Domed Head

| Dia. | (No.) | Hole Size | Drill | D nom | H nom | E ref | W nom | P min |
|------|-------|-----------|-------|-------|-------|-------|-------|-------|
| 3/32 | (3) | .097-.100 | #41 | .094 | .188 | .032 | .057 | 1.00 |
| 1/8 | (4) | .129-.133 | #30 | .125 | .250 | .040 | .076 | 1.00 |
| 5/32 | (5) | .160-.164 | #20 | .156 | .312 | .050 | .095 | 1.00 |
| 3/16 | (6) | .192-.196 | #11 | .187 | .375 | .060 | .114 | 1.00 |
| 1/4 | (8) | .257-.261 | F | .250 | .500 | .080 | .151 | 1.00 |



Dimensional Data—Large Flange

| Dia. | (No.) | Hole Size | Drill | D nom | H nom | E ref | W nom | P min |
|------|-------|-----------|-------|-------|-------|-------|-------|-------|
| 1/8 | (4) | .129-.133 | #30 | .125 | .375 | .065 | .076 | 1.00 |
| 5/32 | (5) | .160-.164 | #20 | .156 | .468 | .075 | .095 | 1.00 |
| 3/16 | (6) | .192-.196 | #11 | .187 | .625 | .092 | .114 | 1.00 |
| 1/4 | (8) | .257-.261 | F | .250 | .750 | .107 | .151 | 1.00 |

Grip Data

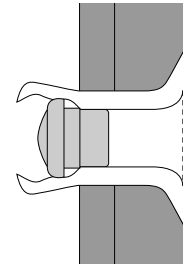
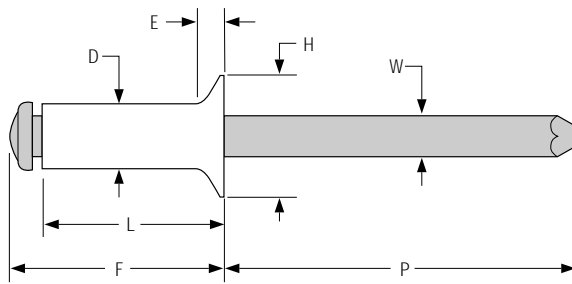
| Dia. | Grip No. | Range | L max | F max | |
|-------------|-------------|-----------|-----------|-------|------|
| 3/32 | 2 | .020-.125 | .250 | .350 | |
| | 4 | .126-.250 | .375 | .475 | |
| | 6 | .251-.375 | .500 | .600 | |
| 1/8 | 1 | .020-.062 | .212 | .332 | |
| | 2 | .063-.125 | .275 | .395 | |
| | 3 | .126-.187 | .337 | .457 | |
| | 4 | .188-.250 | .400 | .520 | |
| | 5 | .251-.312 | .462 | .582 | |
| | 6 | .313-.375 | .525 | .645 | |
| | 8 | .376-.500 | .650 | .770 | |
| | 10 | .501-.625 | .775 | .895 | |
| | 5/32 | 2 | .020-.125 | .300 | .440 |
| | | 3 | .126-.187 | .362 | .502 |
| 4 | | .188-.250 | .425 | .565 | |
| 6 | | .251-.375 | .550 | .690 | |
| 8 | | .376-.500 | .675 | .815 | |
| 10 | | .501-.625 | .800 | .940 | |

| Dia. | Grip No. | Range | L max | F max |
|-------------|----------|-------------|-------|-------|
| 3/16 | 2 | .020-.125 | .325 | .485 |
| | 3 | .126-.187 | .387 | .547 |
| | 4 | .188-.250 | .450 | .610 |
| | 6 | .251-.375 | .575 | .735 |
| | 8 | .376-.500 | .700 | .860 |
| | 10 | .501-.625 | .825 | .985 |
| | 12 | .626-.750 | .950 | 1.110 |
| | 14 | .751-.875 | 1.075 | 1.235 |
| | 16 | .876-1.000 | 1.200 | 1.360 |
| 1/4 | 18 | 1.001-1.125 | 1.325 | 1.485 |
| | 2 | .020-.125 | .375 | .555 |
| | 4 | .126-.250 | .500 | .680 |
| | 6 | .251-.375 | .625 | .805 |
| | 8 | .376-.500 | .750 | .930 |
| | 10 | .501-.625 | .875 | 1.055 |
| | 12 | .626-.750 | 1.000 | 1.180 |
| | 14 | .751-.875 | 1.125 | 1.305 |
| | 16 | .876-1.000 | 1.250 | 1.430 |
| | 18 | 1.001-1.125 | 1.375 | 1.555 |
| | 20 | 1.126-1.250 | 1.500 | 1.680 |

Installed Values in Nominal Grip (lbs.)—Domed Head, Large Flange, and 120° Flush Head

| Body Material: | | C Steel Plated | Aluminum | Aluminum | Stainless Steel | Stainless Steel |
|-------------------|---------|----------------|--------------|----------|-----------------|-----------------|
| Mandrel Material: | | Carbon Steel | Carbon Steel | Aluminum | Stainless Steel | Carbon Steel |
| 3/32 | Shear | 150 | 110 | 80 | 230 | 230 |
| | Tensile | 210 | 170 | 115 | 320 | 320 |
| 1/8 | Shear | 285 | 200 | 150 | 500 | 500 |
| | Tensile | 420 | 300 | 230 | 650 | 650 |
| 5/32 | Shear | 420 | 320 | 220 | 800 | 800 |
| | Tensile | 565 | 450 | 340 | 900 | 900 |
| 3/16 | Shear | 600 | 435 | 310 | 995 | 995 |
| | Tensile | 850 | 725 | 485 | 1350 | 1350 |
| 1/4 | Shear | 1200 | 850 | 580 | 1700 | 1700 |
| | Tensile | 1475 | 1150 | 770 | 2200 | 2200 |





Dimensional Data—120° Flush Head Style

| Dia. | (No.) | Hole Size | Drill | D nom | H nom | E ref | W nom | P min |
|------|-------|-----------|-------|-------|-------|-------|-------|-------|
| 1/8 | (4) | .129-.133 | #30 | .125 | .220 | .045 | .076 | 1.00 |
| 5/32 | (5) | .160-.164 | #20 | .156 | .281 | .058 | .095 | 1.00 |
| 3/16 | (6) | .192-.196 | #11 | .187 | .348 | .073 | .114 | 1.00 |

Grip Data—120° Flush Head Style

| Dia. | Grip No. | Range | L max | F max |
|------|----------|-----------|-------|-------|
| 1/8 | 2 | .092-.125 | .275 | .395 |
| | 3 | .126-.187 | .337 | .457 |
| | 4 | .188-.250 | .400 | .520 |
| | 5 | .251-.312 | .462 | .582 |
| | 6 | .313-.375 | .525 | .645 |
| | 8 | .376-.500 | .650 | .720 |
| 5/32 | 3 | .120-.187 | .362 | .502 |
| | 4 | .188-.250 | .425 | .565 |
| | 6 | .251-.375 | .550 | .690 |
| | 8 | .376-.500 | .675 | .815 |
| 3/16 | 3 | .151-.187 | .387 | .547 |
| | 4 | .188-.250 | .450 | .610 |
| | 6 | .251-.375 | .575 | .735 |
| | 8 | .376-.500 | .700 | .860 |
| | 10 | .501-.625 | .825 | .985 |

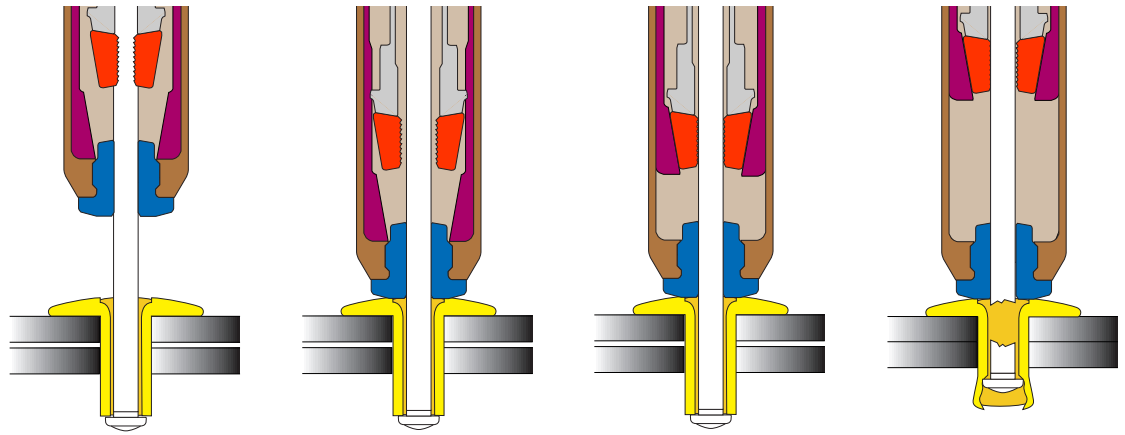
Diameter Numbers

| Number | Diameter (inches) |
|--------|-------------------|
| 3 | 3/32 |
| 4 | 1/8 |
| 5 | 5/32 |
| 6 | 3/16 |

Installation Tooling

| Dia. | Installation Tool | Nose Assembly | Type | Use | |
|-------------|-------------------|--|--|----------------|--------------------------|
| 3/32 | 2015 | 125151 | (Insert) | Pneudraulic | Production |
| | 202 | 99-3422-34 | 99-3422-3456 99-3423-3456 | Pneudraulic | Production |
| | 229 | 99-3422-34 | 99-3422-3456 99-3423-3456 | Pneudraulic | Prod. or Maint. & Repair |
| | 2480 | 99-3422-34 | 99-3422-3456 99-3423-3456 | Hydraulic | Production |
| | HK150-I | 202159 | | Hand Hydraulic | Maintenance & Repair |
| | AK180-I | 202159 | | Pneudraulic | Maintenance & Repair |
| 1/8 | 2015 | 125152 | (Insert) | Pneudraulic | Production |
| | 202 | 99-3422-34 | 99-3422-3456 99-3423-3456 | Pneudraulic | Production |
| | 229 | 99-3422-34 | 99-3422-3456 99-3423-3456 | Pneudraulic | Prod. or Maint. & Repair |
| | 2480 | 99-3422-34 | 99-3422-3456 99-3423-3456 | Hydraulic | Production |
| | HK150-I | 202159 | | Hand Hydraulic | Maintenance & Repair |
| | AK180-I | 202159 | | Pneudraulic | Maintenance & Repair |
| 5/32 | 2015 | 125153 | (Insert) | Pneudraulic | Production |
| | 202 | 99-3422-56 99-3423-56 | 99-3422-3456 99-3423-3456 | Pneudraulic | Production |
| | 229 | 99-3422-56 99-3423-56 | 99-3422-3456 99-3423-3456 | Pneudraulic | Prod. or Maint. & Repair |
| | 2480 | 99-3422-56 99-3423-56 | 99-3422-3456 99-3423-3456 | Hydraulic | Production |
| | HK150-I | 202158 | | Hand Hydraulic | Maintenance & Repair |
| | AK180-I | 202158 | | Pneudraulic | Maintenance & Repair |
| 3/16 | 2015 | 125154 | (Insert, included with tool) | Pneudraulic | Production |
| | 202 | 99-3422-56 99-3423-56 99-3445-68 | 99-3422-3456 99-3423-3456 99-3446-68 | Pneudraulic | Production |
| | 229 | 99-3422-56 99-3423-56 99-3445-68 | 99-3422-3456 99-3423-3456 99-3446-68 | Pneudraulic | Prod. or Maint. & Repair |
| | 2480 | 99-3422-56 99-3423-56 99-3445-68 | 99-3422-3456 99-3423-3456 99-3446-68 | Hydraulic | Production |
| | HK150-I | 202158 | | Hand Hydraulic | Maintenance & Repair |
| | AK180-I | 202158 | | Pneudraulic | Maintenance & Repair |
| 1/4 | 202 | 99-3445-68 | 99-3446-68 | Pneudraulic | Production |
| | 229 | 99-3445-68 | 99-3446-68 | Pneudraulic | Prod. or Maint. & Repair |
| | 2480 | 99-3445-68 | 99-3446-68 | Hydraulic | Production |
| | HK150-I | 202157 | | Hand Hydraulic | Maintenance & Repair |
| | AK180-I | 202157 | | Pneudraulic | Maintenance & Repair |

Installation Sequence



[Click Here to view animation of installation sequence](#)

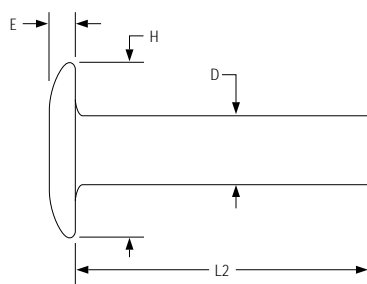
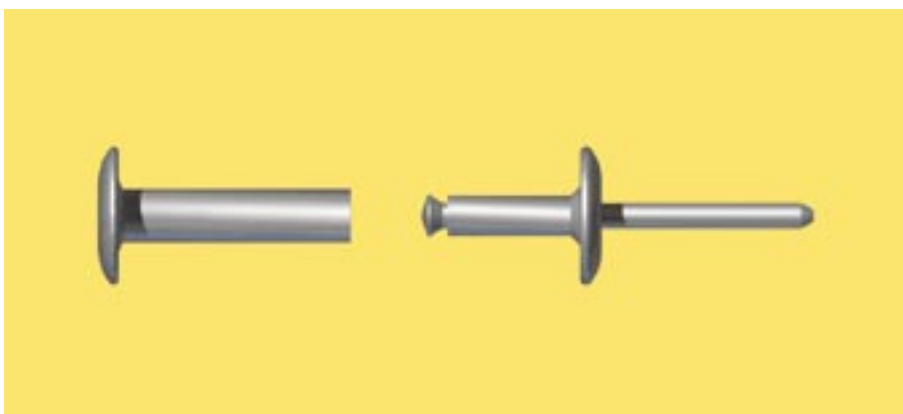
Part Number Identification

S B S 6 2 L

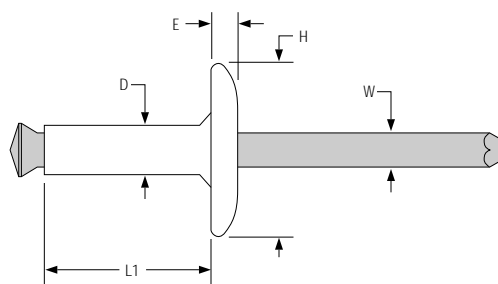
- Large flange head
- Grip Range (See Grip Data Chart)
- Diameter: in 1/32" increments
- Mandrel Material:
S = steel,
A = aluminum,
F = stainless steel
- Head Style:
B = domed head,
C = 120° flush head
- Rivet Body Material:
S = steel, A = aluminum,
F = stainless steel, C = copper

Auto-Clamp™ SureSet™ Rivet

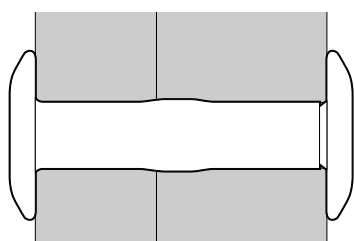
A multiple-piece fastening system for extended grip applications. Material grip thickness may vary as much as 4". Clamps tight without crushing or marring. Can be set with either hand or pneumatic tools. Low profile heads on both ends provide high degree of tamper resistance, yet authorized personnel may drill out and replace quickly.



Tubular Component



Blind Rivet



Recommended Hole Size

| Diameter | Hole Diameter |
|----------|---------------|
| 3/16 | .250 |
| 1/4 | .312 |

Dimensional Data

| Dia. | (No.) | Blind Rivet | | | | Tubular Component | | |
|------|-------|-----------------------|---------------------|--------------------|---------------------|---------------------|--------------------|---------------------|
| | | Mandrel Diameter W | Rivet Diameter D | Head Diameter H | Head Thickness E | Rivet Diameter D | Head Diameter H | Head Thickness E |
| 3/16 | (6) | .076 | .125 | .375 | .065 | .188 | .375 | .057 |
| 1/4 | (8) | .114 | .187 | .625 | .092 | .250 | .625 | .095 |

Installation Tooling

| Dia. | Installation Tool | Nose Assembly | Type | Use | |
|------|-------------------|-------------------------------------|-------------|-------------|--------------------------|
| 3/16 | 2015 | 125154 (Insert, included with tool) | Pneudraulic | Production | |
| | 202 | 99-3422-3456 | 99-3422-56 | Pneudraulic | Production |
| | | 99-3423-3456 | 99-3423-56 | | |
| | | 99-3445-68 | 99-3446-68 | | |
| 229 | 2480 | 99-3422-3456 | 99-3422-56 | Pneudraulic | Prod. or Maint. & Repair |
| | | 99-3423-3456 | 99-3423-56 | | |
| | | 99-3445-68 | 99-3446-68 | | |
| | | 99-3422-3456 | 99-3422-56 | | |
| 1/4 | 202 | 99-3423-3456 | 99-3423-56 | Hydraulic | Production |
| | | 99-3445-68 | 99-3446-68 | | |
| | | 99-3422-3456 | 99-3422-56 | | |
| 229 | 2480 | 99-3423-3456 | 99-3423-56 | Pneudraulic | Prod. or Maint. & Repair |
| | | 99-3445-68 | 99-3446-68 | | |
| | | 99-3422-3456 | 99-3422-56 | | |
| 2480 | 2480 | 99-3445-68 | 99-3446-68 | Hydraulic | Production |
| | | 99-3423-3456 | 99-3423-56 | | |
| | | 99-3422-3456 | 99-3422-56 | | |

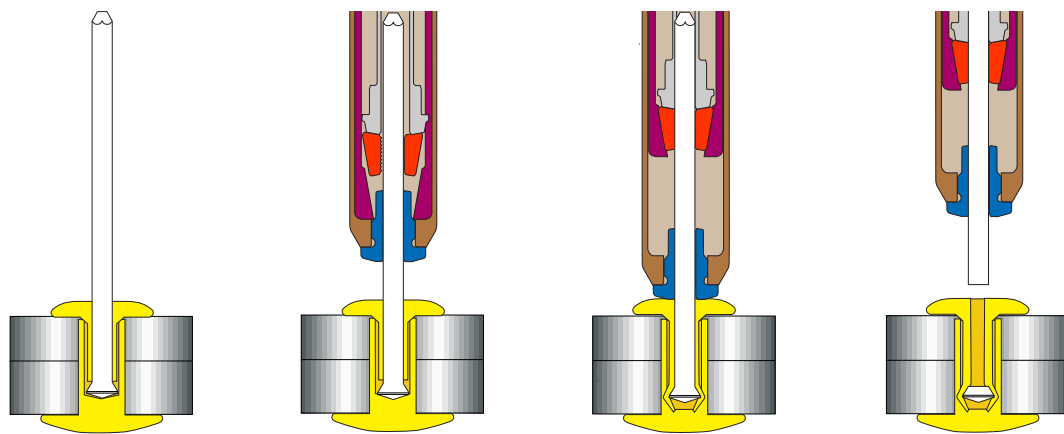
Grip Data

| Diameter | Grip Range | L1 max | L2 max | Body: Aluminum | Body: Steel | Body: Aluminum |
|-------------|-------------|--------|----------|---------------------|---------------------|---------------------|
| | | | | Mandrel: Aluminum | Mandrel: Steel | Mandrel: Steel |
| | | | | Tubular Comp: Alum. | Tubular Comp: Steel | Tubular Comp: Alum. |
| 3/16 | .625-.750 | .525 | .585 | STA612AC | STS612AC | STAS612AC |
| | .688-.875 | .525 | .647 | STA614AC | STS614AC | STAS614AC |
| | .875-1.063 | .525 | .825 | STA617AC | STS617AC | STAS617AC |
| | 1.063-1.250 | .525 | 1.012 | STA620AC | STS620AC | STAS620AC |
| | 1.250-1.438 | .525 | 1.200 | STA623AC | STS623AC | STAS623AC |
| | 1.438-1.625 | .525 | 1.387 | STA626AC | STS626AC | STAS626AC |
| | 1.625-1.813 | .525 | 1.575 | STA629AC | STS629AC | STAS629AC |
| | 1.813-2.000 | .525 | 1.762 | STA632AC | STS632AC | STAS632AC |
| | 2.000-2.188 | .525 | 1.950 | STA635AC | STS635AC | STAS635AC |
| 2.188-2.625 | .525 | 2.137 | STA638AC | STS638AC | STAS638AC | |
| 1/4 | .625-.750 | .454 | .580 | STA812AC | STS812AC | STAS812AC |
| | .750-.875 | .608 | .695 | STA814AC | STS814AC | STAS814AC |
| | .875-1.125 | .608 | .820 | STA818AC | STS818AC | STAS818AC |
| | 1.125-1.375 | .608 | 1.070 | STA822AC | STS822AC | STAS822AC |
| | 1.375-1.625 | .608 | 1.320 | STA826AC | STS826AC | STAS826AC |
| | 1.625-1.875 | .608 | 1.570 | STA830AC | STS830AC | STAS830AC |
| | 1.875-2.125 | .608 | 1.820 | STA834AC | STS834AC | STAS834AC |
| | 2.125-2.375 | .608 | 2.070 | STA838AC | STS838AC | STAS838AC |
| | 2.375-2.625 | .608 | 2.320 | STA842AC | STS842AC | STAS842AC |
| | 2.625-2.875 | .608 | 2.570 | STA846AC | STS846AC | STAS846AC |
| | 2.875-3.125 | .608 | 2.820 | STA850AC | STS850AC | STAS850AC |
| | 3.125-3.375 | .608 | 3.070 | STA854AC | STS854AC | STAS854AC |
| | 3.375-3.625 | .608 | 3.320 | STA858AC | STS858AC | STAS858AC |
| | 3.625-3.875 | .608 | 3.570 | STA862AC | STS862AC | STAS862AC |

Installed Values in Nominal Grip (lbs.)

| | | Rivet/Mandrel/Tubular Component: | | |
|-------------|----------------|----------------------------------|-------------------|-----------------|
| | | Alum/Alum/Alum | Steel/Steel/Steel | Alum/Steel/Alum |
| 3/16 | Tensile | 100 | 200 | 300 |
| 1/4 | Tensile | 250 | 350 | 450 |

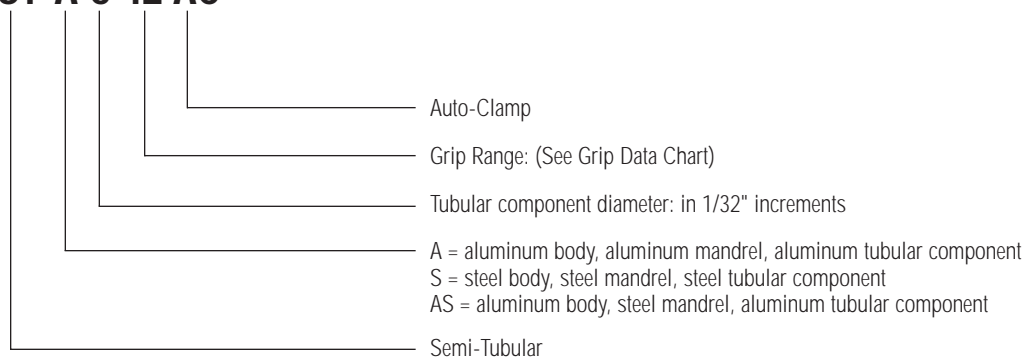
Installation Sequence



[Click Here to view animation of installation sequence](#)

Part Number Identification

ST A 6 12 AC



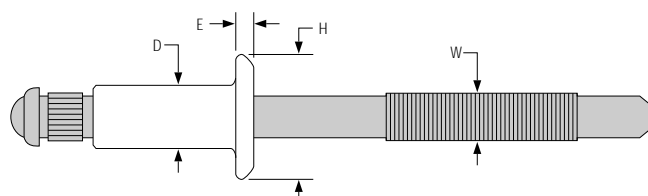
LOCK RIVETS

HUCK LockRivets™ include three medium-duty fasteners for use in a wide range of production or maintenance and repair applications. These blind fasteners offer exceptional clamp in a number of materials including plywood, aluminum, steel, fiberglass and plastic. LockRivets are commonly used in automotive and truck cab applications, as well as the assembly of such items as recreational vehicles and outdoor furniture.

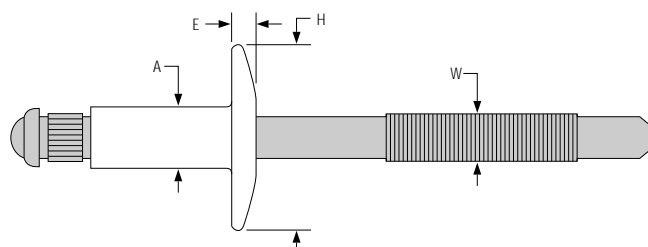
- StrongHold™** Blind rivet, used for a variety of higher strength applications
- Peel™** Blind rivet, with a split sleeve and hardened mandrel for extra strength
- A-Lock™** Blind rivet, peels from the blind side into the core of the clamped material
- Magna-Tite™** Blind rivet, with a slotted sleeve and an applied sealant for watertight applications

StrongHold™ LockRivet™

Designed for structural applications where highly durable physical properties are required. Special design combines weather-tight sealing capability and high shear values with excellent vibration resistance.



Regular Flange StrongHold



Large Flange StrongHold

Dimensional Data

| Dia. | (No.) | Nom Diameter | | Countersunk Head | | Regular Flange Head | | Large Flange Head | |
|------|-------|--------------|------|------------------|------|---------------------|------|-------------------|------|
| | | W | D | H | E | H | E | H | E |
| 1/8 | (4) | .076 | .125 | .220 | .031 | .250 | .040 | .375 | .065 |
| 5/32 | (5) | .095 | .156 | .281 | .040 | .312 | .050 | .468 | .075 |
| 3/16 | (6) | .114 | .187 | .348 | .050 | .365 | .060 | .625 | .092 |
| 1/4 | (8) | .151 | .250 | N/A | N/A | .500 | .080 | .750 | .107 |

Note: 1/8" and 5/32" diameters are special order—non stock standard parts.

Recommended Hole Size

| Diameter | Hole Diameter | Drill Size |
|----------|---------------|------------|
| 1/8 | .129-.133 | #30 |
| 5/32 | .160-.164 | #20 |
| 3/16 | .192-.196 | #11 |
| 1/4 | .257-.261 | F |

Grip Data—StrongHold

| Part Number | Grip Range |
|-------------|------------|
| SBS42MG | .063-.125 |
| SBS42LMG | .063-.125 |
| SBS43MG | .126-.187 |
| SBS54MG | .188-.250 |
| SBS54MG | .188-.250 |
| SBS62MG | .020-.125 |
| SBS64MG | .188-.250 |
| SBS66MG | .251-.375 |
| SBS68MG | .376-.500 |
| SBS84MG | .126-.250 |
| SBS84LMG | .126-.250 |
| SBS86MG | .251-.375 |
| SBS86LMG | .251-.375 |

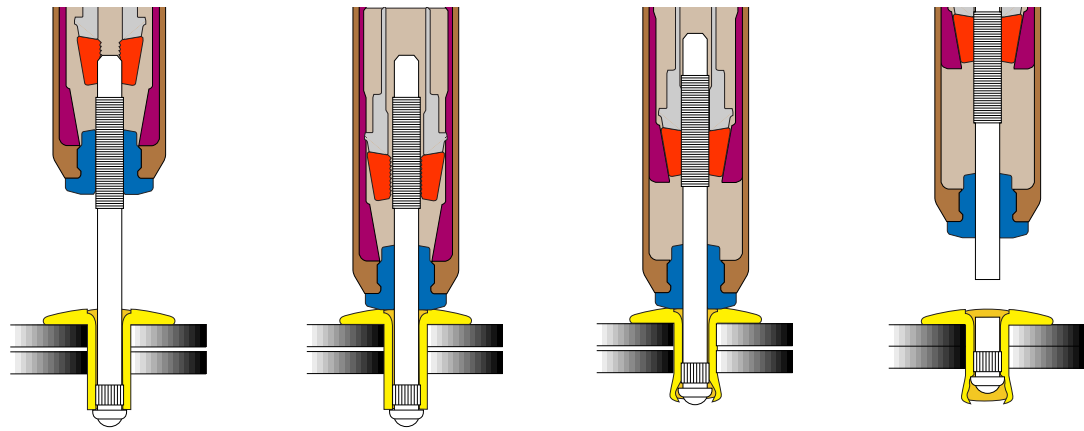
Installed Values in Nominal Grip (lbs.)

| | | Body Material/Mandrel Material: | | | | |
|-------------|----------------|---------------------------------|------------|-------------|----------|-------|
| | | Alum/Alum | Alum/Steel | Steel/Steel | SS/Steel | SS/SS |
| 1/8 | Shear | 220 | 340 | 450 | 550 | 550 |
| | Tensile | 180 | 275 | 350 | 530 | 530 |
| 5/32 | Shear | 340 | 520 | 525 | 850 | 850 |
| | Tensile | 300 | 425 | 500 | 820 | 820 |
| 3/16 | Shear | 480 | 650 | 900 | 1325 | 1325 |
| | Tensile | 400 | 600 | 700 | 1200 | 1200 |
| 1/4 | Shear | 900 | 1200 | 1750 | 2250 | 2250 |
| | Tensile | 650 | 1000 | 1400 | 2100 | 2100 |

Installation Tooling

| Dia. | Installation Tool | Nose Assembly | | Type | Use |
|-------------|-------------------|--|--|-------------|--------------------------|
| 1/8 | 2015 | 125152 (Insert) | | Pneudraulic | Production |
| | 202 | 99-3422-34 | 99-3422-3456 99-3423-3456 | Pneudraulic | Production |
| | 229 | 99-3422-34 | 99-3422-3456 99-3423-3456 | Pneudraulic | Prod. or Maint. & Repair |
| | 2480 | 99-3422-34 | 99-3422-3456 99-3423-3456 | Hydraulic | Production |
| 5/32 | 2015 | 125153 (Insert) | | Pneudraulic | Production |
| | 202 | 99-3422-3456 99-3423-3456 | 99-3422-56 33-3423-56 | Pneudraulic | Production |
| | 229 | 99-3422-3456 99-3423-3456 | 99-3422-56 99-3423-56 | Pneudraulic | Prod. or Maint. & Repair |
| | 2480 | 99-3422-3456 99-3423-3456 | 99-3422-56 99-3423-56 | Hydraulic | Production |
| 3/16 | 2015 | 125154 (Insert, included with tool) | | Pneudraulic | Production |
| | 202 | 99-3422-3456 99-3423-3456 99-3445-68 | 99-3422-56 99-3423-56 99-3446-68 | Pneudraulic | Production |
| | 229 | 99-3422-3456 99-3423-3456 99-3445-68 | 99-3422-56 99-3423-56 99-3446-68 | Pneudraulic | Prod. or Maint. & Repair |
| | 2480 | 99-3422-3456 99-3423-3456 99-3445-68 | 99-3422-56 99-3423-56 99-3446-68 | Hydraulic | Production |
| 1/4 | 202 | 99-3445-68 | 99-3446-68 | Pneudraulic | Production |
| | 229 | 99-3445-68 | 99-3446-68 | Pneudraulic | Prod. or Maint. & Repair |
| | 2480 | 99-3445-68 | 99-3446-68 | Hydraulic | Production |

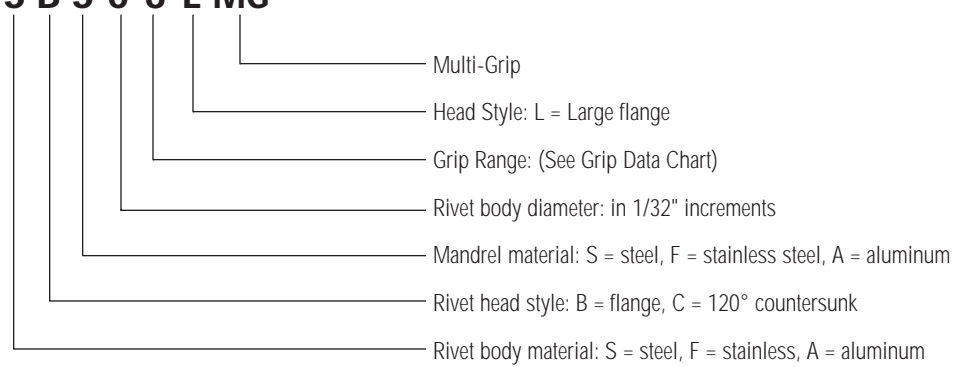
Installation Sequence



[Click Here to view animation of installation sequence](#)

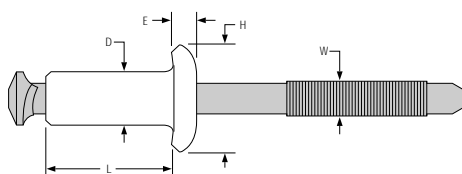
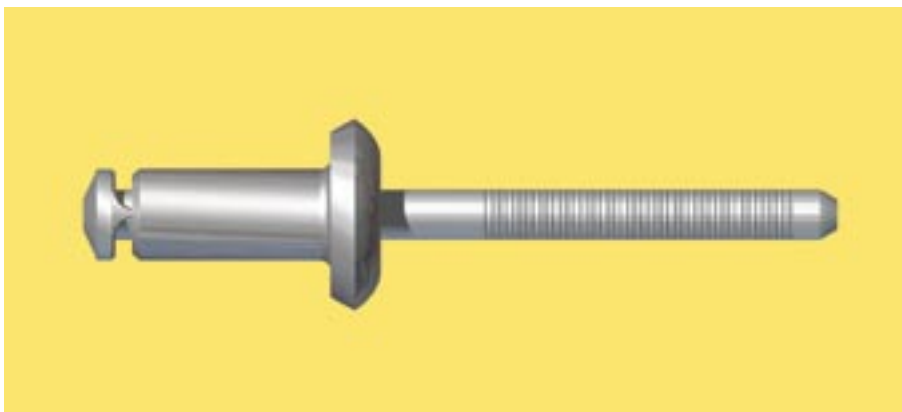
Part Number Identification

S B S 6 8 L MG

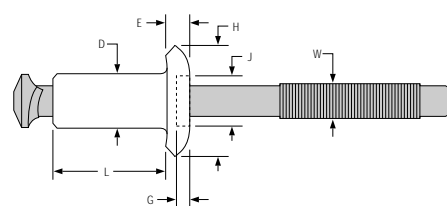


Peel™ LockRivet™

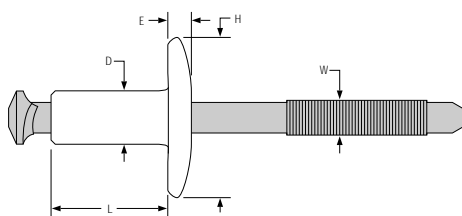
This proven LockRivet™ features a "Secondary Grip Ring" for added mandrel retention. 3/16" and 1/4" diameter heavy-duty rivets are designed for maximum clamp-up strength with exceptional vibration-free characteristics. This self-plugging fastener yields extremely high shear and tensile values from its unique, hardened, locked-in-place mandrel and specially designed aluminum body.



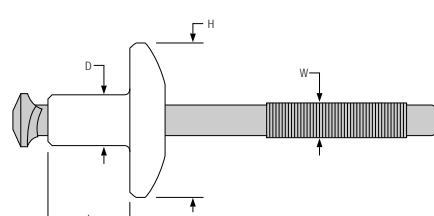
Standard Flange Head



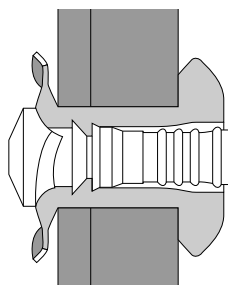
Multi-Grip Head



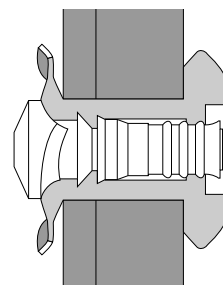
Large Flange Head



Large Flange Multi-Grip Head



Peel Lock Rivet



Multi-Grip Peel Lock Rivet

Dimensional Data—Peel LockRivet

| Dia. (No.) | Hole Size | W | D | Reg. Flange Dome Head H | Large Flange Dome Head H | E | G | J |
|------------|-----------|------|------|----------------------------|-----------------------------|------|------|------|
| 3/16 (6) | .192-.196 | .116 | .188 | .390 | .562 | .093 | .030 | .200 |
| 1/4 (8) | .257-.261 | .151 | .249 | .510 | .750 | .116 | .057 | .250 |

Dimensional Data—Multi-Grip Peel LockRivet

| Dia. (No.) | Hole Size | W | D | Regular Flange Diameter H | Medium Flange Diameter H | Large Flange Diameter H |
|------------|-----------|------|------|---------------------------------|--------------------------------|-------------------------------|
| 3/16 (6) | .192-.196 | .116 | .188 | .375 | .470 | .625 |
| 1/4 (8) | .257-.261 | .151 | .250 | .500 | .625 | .750 |

Grip Data—Peel LockRivets

| Part Number | Overall Grip Range | Nominal Shank Length L |
|-------------|--------------------|------------------------|
| TABS6075L | .046-.075 | .381 |
| TABS6109 | .079-.109 | .405 |
| TABS6203 | .047-.203 | .464 |
| TABS6075L | .047-.203 | .464 |
| TABS6500 | .398-.567 | .840 |
| TABS8140 | .030-.140 | .490 |
| TABS814L | .090-.142 | .490 |
| TABS814LR | .090-.142 | .490 |
| TABS814R | .090-.125 | .490 |
| TABS8177R | .082-.180 | .490 |
| TABS8187Y | .141-.187 | .552 |
| TABS8250R | .188-.250 | .615 |
| TABS825L | .188-.250 | .615 |
| TABS8620 | .480-.620 | .937 |
| TABS8715 | .520-.715 | .940 |

Typical Installed Values—Peel LockRivets

| Diameter | Min. Shear | Min. Tensile | Mandrel Pushout |
|-------------|------------|--------------|-----------------|
| 3/16 | 1100 | 800 | 150 |
| 1/4 | 2000 | 1300 | 200 |

Grip Data—Universal Multi-Grip SGR Peel Rivets

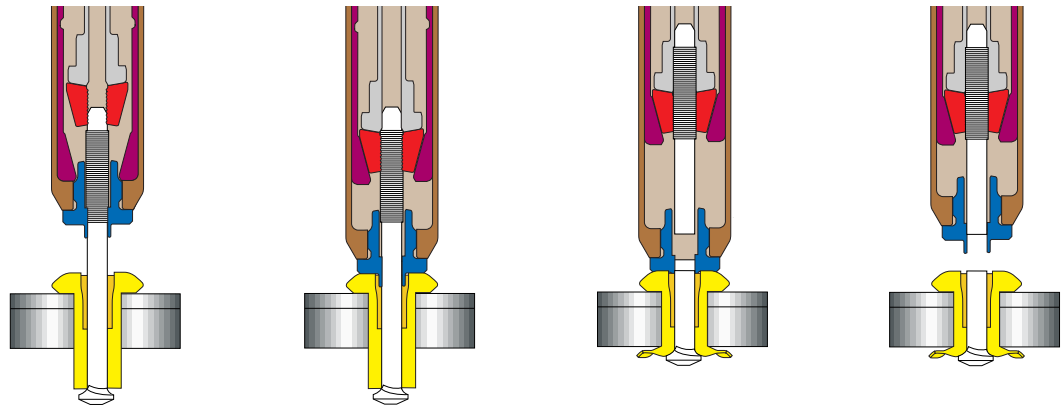
| Part Number | Overall Grip Range | Flush Break Grip Range | Nominal Shank Length L |
|-------------|--------------------|------------------------|------------------------|
| TABS625MSG | .020-.250 | .100-.250 | .455 |
| TABS66MSG | .250-.575 | .400-.575 | .834 |
| TABS82SG | .020-.217 | .100-.217 | .490 |
| TABS82MSG | .020-.217 | .100-.217 | .490 |
| TABS84MSG | .201-.400 | .256-.400 | .689 |
| TABS865 | .401-.650 | .500-.650 | .937 |

Installation Tooling

| Diameter | Installation Tool | Nose Assembly | Type | Use |
|-------------|-------------------|-----------------|----------------|--------------------------|
| 3/16 | 2015 | 125283 (Insert) | Pneudraulic | Production |
| | 202 | 99-3460 99-3461 | Pneudraulic | Production |
| | 229 | 99-3460 99-3461 | Pneudraulic | Prod. or Maint. & Repair |
| | 2480 | 99-3460 99-3461 | Hydraulic | Production |
| 1/4 | 2015 | 125284 (Insert) | Pneudraulic | Prod. or Maint. & Repair |
| | 202 | 99-3462 99-3463 | Pneudraulic | Production |
| | 229 | 99-3462 99-3463 | Pneudraulic | Prod. or Maint. & Repair |
| | 2480 | 99-3462 99-3463 | Hydraulic | Production |
| | HK150-I | 202155 | Hand Hydraulic | Maintenance & Repair |
| | AK180-I | 202155 | Pneudraulic | Maintenance & Repair |

Replacement anvil inserts: 3/16 use 124153 ; 1/4 use 124155

Installation Sequence



[Click Here to view animation of installation sequence](#)

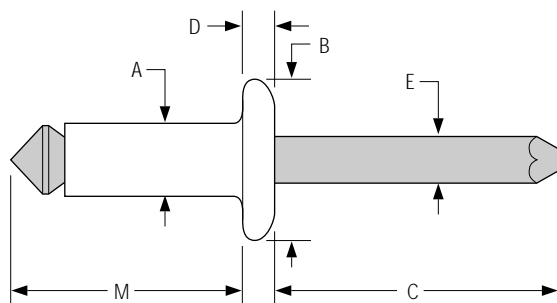
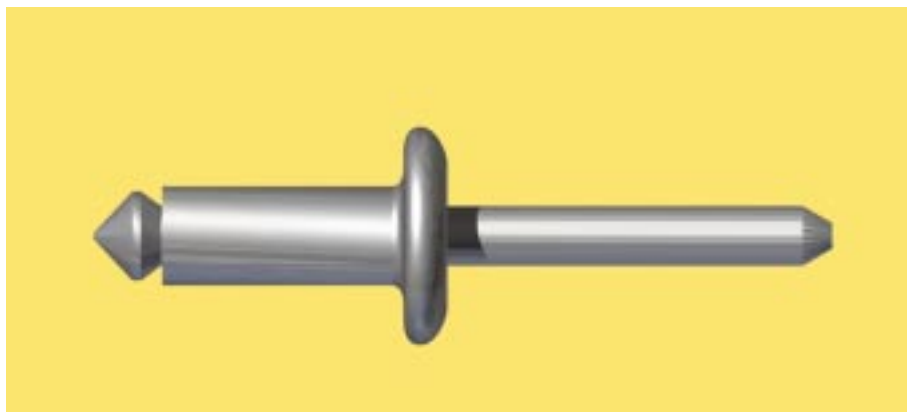
Part Number Identification

T A B S 8 14 L R ()



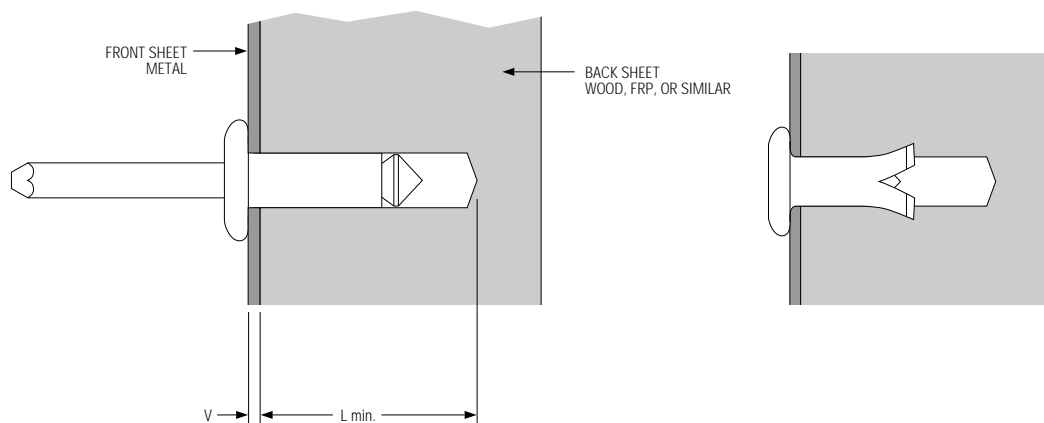
A-Lock™ LockRivet™

Provides robust fastening of metal to wood, FRP, plastics and fiberglass without through holes. A-Lock™ rivets peel from the blind side when set and lock themselves into the application. Once locked in place, these rivets offer superior pull-out strength and vibration resistance.



Dimensional Data

| Dia. | (No.) | A | B | C min | D | E nom | M |
|------|-------|-------------|-----------|-------|-----------|-------|---------|
| 3/16 | (6) | .1780-.1865 | .387-.401 | 1.34 | .074-.081 | .110 | .52-.57 |



Hole Preparation and Grip Data

| Dia. | (No.) | Recommended Hole Size | V min-max | L min at V min | L min at V max |
|------|-------|-----------------------|-----------|----------------|----------------|
| 3/16 | (6) | .1875-.1925 | .010-.120 | .48 | .37 |

NOTE: Other sizes available upon request.

Typical Installed Values

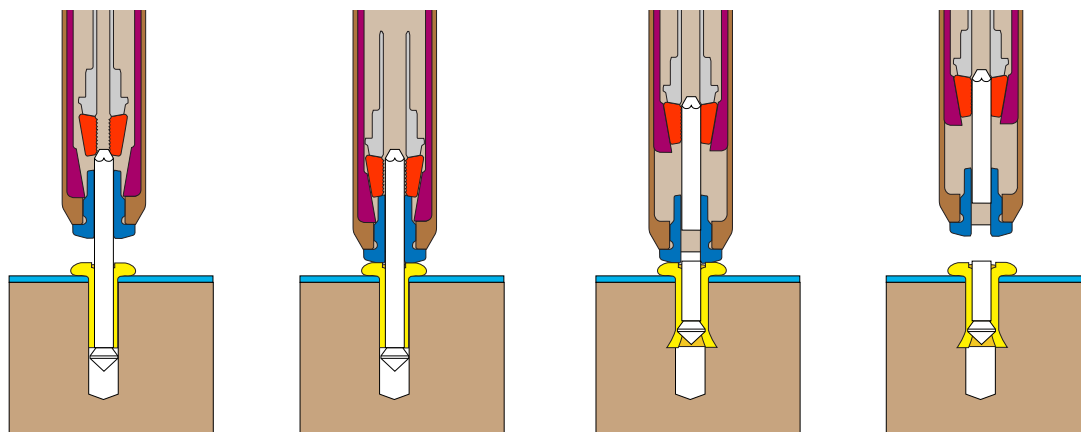
| Diameter | Material | Pull-Out Strength (pounds) |
|----------|--|----------------------------|
| 3/16 | Body: low carbon steel, zinc plated Mandrel: low carbon steel | 220 |

Installation Tooling

| Diameter | Installation Tool | Nose Assembly | Type | Use | |
|------------|-------------------|-----------------|----------------|----------------------|--------------------------|
| 3/16 | 2015 | 125154 (Insert) | Pneudraulic | Production | |
| | 202 | 99-3422-3456 | 99-3422-56 | Pneudraulic | Production |
| | | 99-3423-3456 | 99-3423-56 | | |
| 99-3445-68 | 99-3446-68 | | | | |
| 229 | 229 | 99-3422-3456 | 99-3422-56 | Pneudraulic | Prod. or Maint. & Repair |
| | | 99-3423-3456 | 99-3423-56 | | |
| | | 99-3445-68 | 99-3446-68 | | |
| 2480 | 2480 | 99-3422-3456 | 99-3422-56 | Hydraulic | Production |
| | | 99-3423-3456 | 99-3423-56 | | |
| | | 99-3445-68 | 99-3446-68 | | |
| HK150-I | HK150-I | 202158 | Hand Hydraulic | Maintenance & Repair | |
| AK180-I | AK180-I | 202158 | Pneudraulic | Maintenance & Repair | |



Installation Sequence



[Click Here to view animation of installation sequence](#)

Part Number Identification

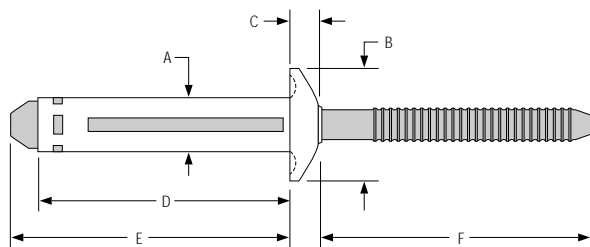
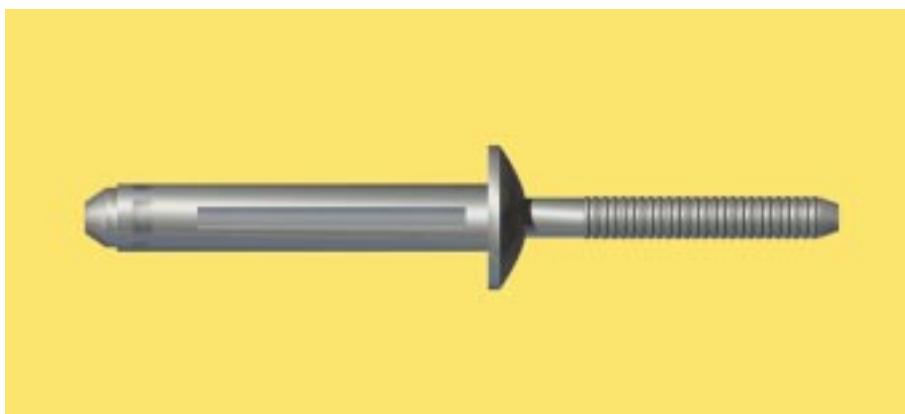
T SB S 6 120



Add suffix "LT" for soft core material applications.

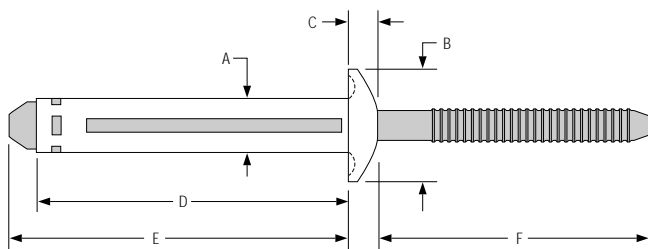
Magna-Tite™ LockRivet™

An applied watertight sealant makes this rivet especially suitable for oversize holes and repair applications. A large blind-side footprint also makes the fastener ideal for installation in thin or low-strength materials such as aluminum, fiberglass and plastic.



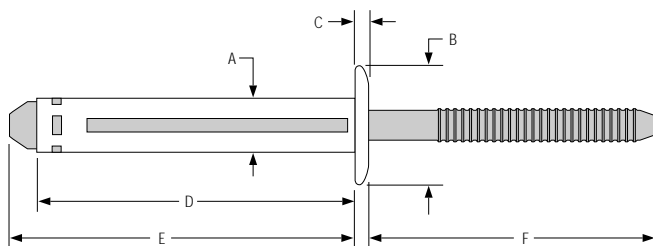
Specifications—Protruding Head Hole Size nom=.205-.221 A=.199 B=.453 C=.117 F min=.940

| Dia. (No.) | Part No. | Grip Range | D max | E max |
|------------|------------|-------------|-------|-------|
| 3/16 (6) | MTP-B6-5S | .050 - .312 | .890 | 1.020 |
| | MTP-B6-6S | .100 - .375 | .940 | 1.070 |
| | MTP-B6-8S | .250 - .500 | 1.090 | 1.220 |
| | MTP-B6-10S | .375 - .625 | 1.215 | 1.345 |
| | MTP-B6-12S | .500 - .750 | 1.340 | 1.470 |



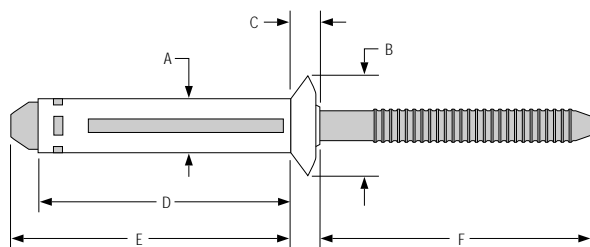
Specifications—Shavable Head Hole Size nom=.205-.221 A=.199 B=.453 C=.117 F min=.940

| Dia. (No.) | Part No. | Grip Range | D max | E max |
|------------|------------|-------------|-------|-------|
| 3/16 (6) | MTS-B6-8S | .050 - .500 | 1.010 | 1.140 |
| | MTS-B6-12S | .050 - .750 | 1.260 | 1.390 |



Specifications—Low Profile (non-structural) Hole Size nom=.205-.221 A=.199 B=.453 C=.052

| Dia. (No.) | Part No. | Grip Range | D max | E max | F min |
|------------|-------------|-------------|-------|-------|-------|
| 3/16 (6) | MTLP-B6-4 | .050 - .250 | .840 | 1.040 | 1.189 |
| | MTLP-B6-8 | .187 - .500 | 1.090 | 1.140 | .939 |
| | MTLP-B6-12 | .375 - .750 | 1.260 | 1.390 | 1.143 |
| | MTLP-B6-12X | .050 - .750 | 1.260 | 1.390 | 1.143 |


Specifications—100° Countersunk Oval Head Hole Size nom=.205-.221 A=.199 B=.355 C=.117 F min=.940

| Dia. | Part No. | Grip Range | D max | E max |
|------|------------|-------------|-------|-------|
| 3/16 | MTV-B6-5S | .070 - .312 | .910 | 1.040 |
| | MTV-B6-7S | .160 - .410 | 1.010 | 1.140 |
| | MTV-B6-8S | .250 - .500 | 1.090 | 1.220 |
| | MTV-B6-10S | .375 - .625 | 1.215 | 1.345 |
| | MTV-B6-12S | .500 - .750 | 1.340 | 1.470 |

Installed Values in Nominal Grip (lbs.)

| | | Head Styles: | | | |
|------|---------------|--------------|----------|-------------|------|
| | | Protruding | Shavable | Low Profile | Oval |
| 3/16 | Shear | 630 | 630 | 630* | 630 |
| | Tensile | 450 | 450 | 450 | 450 |
| | Pin Retention | 90 | 90 | 90 | 90 |

In Minimum Grip. 350 lb. Shear Strength Over Minimum Grip.

Material

| | |
|--------|----------|
| Sleeve | Aluminum |
| Pin | Aluminum |

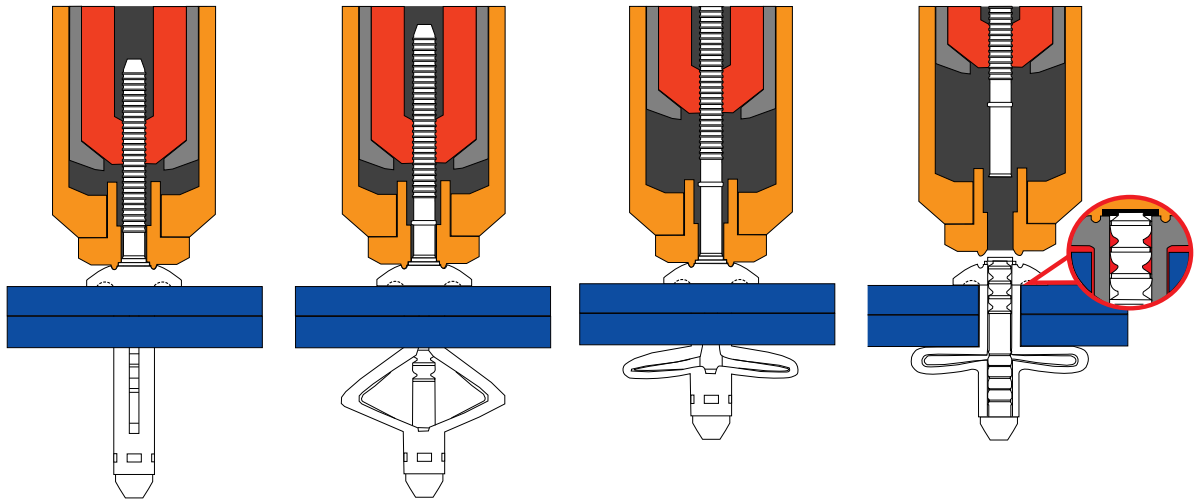
Installation Tooling

| Dia. | Installation Tool | Nose Assembly | Type | Use | |
|------|-------------------|-----------------|-------------|--------------------------|------------|
| 3/16 | 2015 | 125280 (Insert) | Pneudraulic | Prod. or Maint. & Repair | |
| | 202 | 99-3310F/P | Pneudraulic | Production | |
| | 2480 | 99-3310F/P | Hydraulic | Production | |
| 1/4 | 2015 | 125280 (Insert) | Pneudraulic | Prod. or Maint. & Repair | |
| | 202 | 99-3311F/P | 99-3312F/P | Pneudraulic | Production |
| | 2480 | 99-3311F/P | 99-3312F/P | Hydraulic | Production |

F--For use with Low Profile and Shavable Head styles. Replacement insert #123021

P--For use with Protruding and Oval Head styles. Replacement insert #124185

Installation Sequence

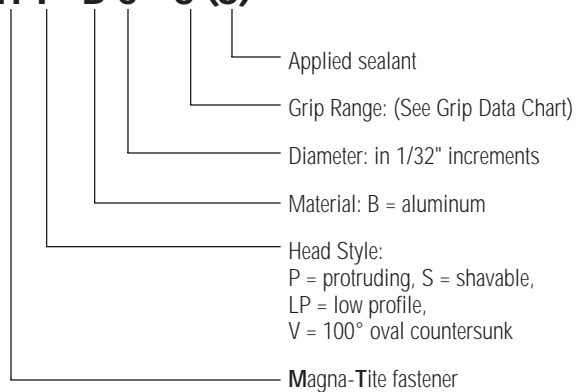


[Click Here to view animation of installation sequence](#)

**(Solid rivet-look parts may be shaved after pintail is clipped)*

Part Number Identification

MT P - B 6 - 8 (S)



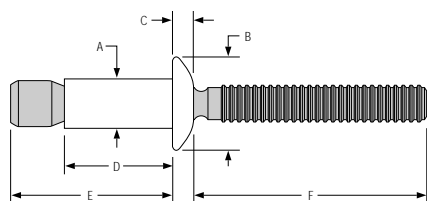
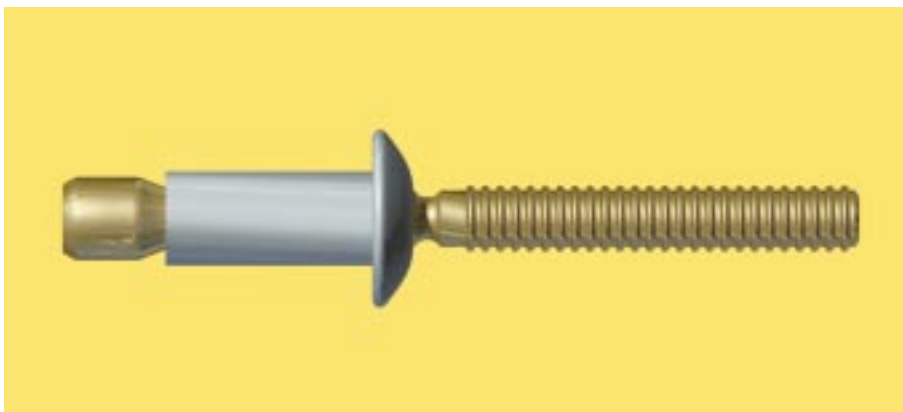


Three blind fasteners comprise the LockRite™ line: the Magna-Lok®, the Magna-Bulb®, the Auto-Bulb™ and the BOM®. These fasteners are ideal for a wide range of uses, including automotive, heavy truck and trailer, shopping carts and a wide range of assembly applications.

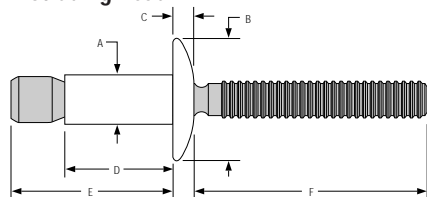
- Magna-Lok®** Blind rivet, featuring an internal lock and superior hole fill characteristics
- Magna-Bulb®** Blind rivet, forms a bulbed footprint on the blind side for a broader grip surface
- Auto-Bulb™** Blind rivet with a hole-seeking tip, which provides for easy installation
- BOM®** High strength blind bolt, 3/16" - 3/4" diameter, for severe duty applications

Magna-Lok[®] LockRite[™]

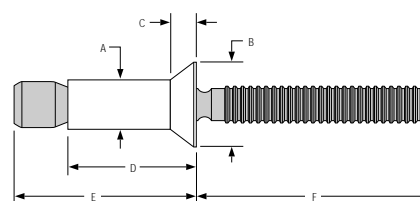
Strong, consistent and reliable. Employing a unique solid-circle lock, the Magna-Lok[®] fastener creates an internal lock during installation that virtually eliminates pin pushout.



Protruding Head



Truss Head



100° Countersunk Head

Dimensional Data—Protruding Head

| Dia. (No.) | Steel | Aluminum | Stainless | Grip Range | Hole Size | A | B | C | D | E | F |
|------------|-------------|-------------|------------|-------------|-------------|------|------|------|------|-------|-------|
| 3/16 (6) | MGLP-R6-4* | MGLP-B6-4* | MGLP-U6-4 | .062 - .270 | .191 - .201 | .188 | .385 | .085 | .415 | .675 | 1.00 |
| | MGLP-R6-7* | MGLP-B6-7* | MGLP-U6-7 | .214 - .437 | .191 - .201 | .188 | .385 | .085 | .572 | .825 | 1.00 |
| | MGLP-R6-E* | MGLP-B6-E* | | .062 - .437 | .191 - .201 | .188 | .385 | .085 | .572 | .950 | 1.00 |
| 1/4 (8) | MGLP-R8-6* | MGLP-B8-6* | MGLP-U8-6 | .080 - .375 | .261 - .272 | .253 | .525 | .117 | .560 | .970 | 1.00 |
| | MGLP-R8-10* | MGLP-B8-10* | MGLP-U8-10 | .350 - .625 | .261 - .272 | .253 | .525 | .117 | .810 | 1.220 | 1.00 |
| | MGLP-R8-E* | MGLP-B8-E* | | .080 - .625 | .261 - .272 | .253 | .525 | .117 | .810 | 1.405 | 1.00 |
| 3/8 (12) | MGLP-R12-12 | MGLP-B12-12 | | .120 - .560 | .392 - .408 | .386 | .787 | .175 | .840 | 1.650 | 1.545 |

Dimensional Data—Truss Head

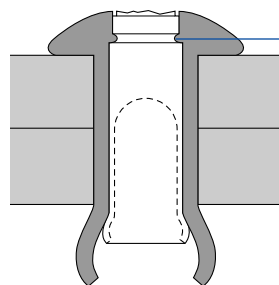
| Dia. (No.) | Steel | Aluminum | Stainless | Grip Range | Hole Size | A | B | C | D | E | F |
|------------|------------|------------|-----------|-------------|-------------|------|------|------|------|-------|------|
| 3/16 (6) | MGLT-R6-4 | MGLT-B6-4 | | .062 - .270 | .191 - .201 | .187 | .500 | .085 | .415 | .675 | 1.00 |
| | MGLT-R6-7 | MGLT-B6-7 | | .214 - .437 | .191 - .201 | .187 | .500 | .085 | .572 | .825 | 1.00 |
| | MGLT-R6-E | MGLT-B6-E | | .062 - .437 | .191 - .201 | .187 | .500 | .085 | .572 | .950 | 1.00 |
| 1/4 (8) | MGLT-R8-6 | MGLT-B8-6 | | .080 - .375 | .261 - .272 | .253 | .588 | .117 | .560 | .970 | 1.00 |
| | MGLT-R8-10 | MGLT-B8-10 | | .350 - .625 | .261 - .272 | .253 | .588 | .117 | .810 | 1.220 | 1.00 |
| | MGLT-R8-E | MGLT-B8-E | | .080 - .625 | .261 - .272 | .253 | .588 | .117 | .810 | 1.405 | 1.00 |

Dimensional Data—100° Countersunk Head

| Dia. (No.) | Steel | Aluminum | Stainless | Grip Range | Hole Size | A | B | C | D | E | F |
|------------|--------------|--------------|--------------|-------------|-------------|------|------|------|------|-------|------|
| 3/16 (6) | MGL100-R6-6 | MGL100-B6-6 | MGL100-U6-6 | .125 - .331 | .191 - .201 | .188 | .345 | .070 | .486 | .762 | 1.00 |
| | MGL100-R6-9 | MGL100-B6-9 | MGL100-U6-9 | .305 - .500 | .191 - .201 | .188 | .345 | .070 | .653 | .929 | 1.00 |
| | MGL100-R6-E | MGL100-B6-E | | .125 - .331 | .191 - .201 | .188 | .345 | .070 | .653 | .929 | 1.00 |
| 1/4 (8) | MGL100-R8-8 | MGL100-B8-8 | MGL100-U8-8 | .160 - .475 | .261 - .272 | .257 | .405 | .079 | .660 | 1.059 | 1.00 |
| | MGL100-R8-12 | MGL100-B8-12 | MGL100-U8-12 | .415 - .725 | .261 - .272 | .257 | .405 | .079 | .910 | 1.309 | 1.00 |
| | MGL100-R8-E | MGL100-B8-E | | .160 - .475 | .261 - .272 | .257 | .405 | .079 | .660 | 1.059 | 1.00 |

Typical Installed Values in Nominal Grip (lbs.)

| | | Aluminum | Steel | Stainless Steel |
|------|---------------|----------|-------|-----------------|
| 3/16 | Shear | 600 | 1300 | 1300 |
| | Tensile | 500 | 1200 | 950 |
| | Pin Retention | 50 | 150 | 100 |
| 1/4 | Shear | 1300 | 2500 | 2350 |
| | Tensile | 890 | 2200 | 1800 |
| | Pin Retention | 100 | 300 | 200 |
| 3/8 | Shear | 2950 | 5600 | NA |
| | Tensile | 1900 | 4000 | NA |
| | Pin Retention | 250 | 650 | NA |



Unique solid-circle lock ensures maximum strength and resistance to vibration. It is designed to eliminate pin pushout. It forms a mechanical lock, permanently locking the pin and sleeve together.

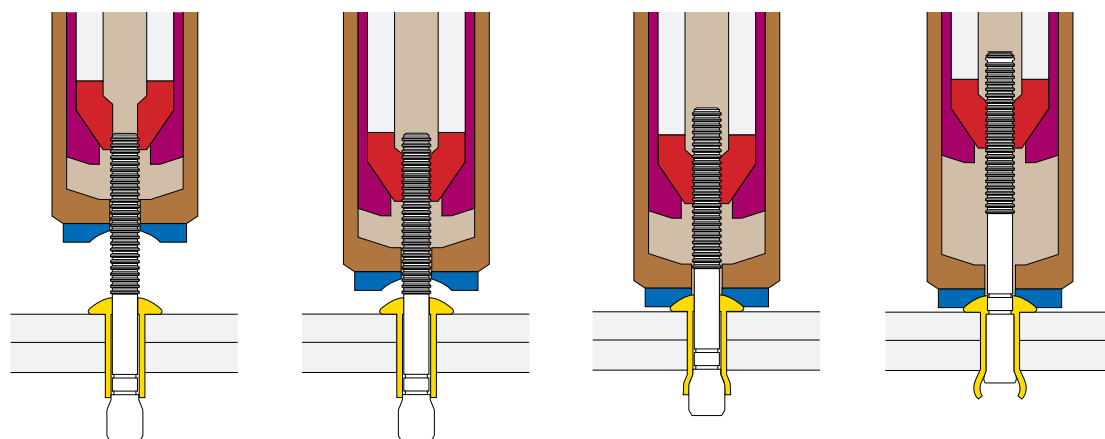
Material and Finish

| Material | Sleeve | Pin | Sleeve Finish | Pin Finish |
|-----------|------------------|---------------------|----------------------------|---------------------------|
| Steel | Low Carbon Steel | Medium Carbon Steel | Zinc Plated Clear Chromate | Zinc Plated Gold Chromate |
| Aluminum | 5056 | 7075 | Clear Chromate | Gold Chromate |
| Stainless | 302 | 305/304 | Passivated | Dry Lubricated |

Installation Tooling

| Dia. | Installation Tool | Nose Assembly | | Type | Use | |
|------|-------------------|-------------------------------------|------------|-------------|--------------------------|------------|
| 3/16 | 229 | 99-3300 | 99-3316-68 | Pneudraulic | Maintenance | |
| | 230 | 99-3300 | 99-3316-68 | Pneudraulic | Maintenance & Repair | |
| | 2025 | 99-3300 | | Pneudraulic | Maintenance & Repair | |
| | 202 | 99-3303 | 99-3316-68 | Pneudraulic | Prod. or Maint. & Repair | |
| | 2015 | 125154 (Insert, included with tool) | | Pneudraulic | Prod. or Maint. & Repair | |
| | 212 | 99-3300 | 99-3303 | 99-3316-68 | Pneudraulic | Production |
| | AK180-I | 120982 | | Pneudraulic | Maintenance & Repair | |
| | 2480 | 99-3300 | 99-3303 | 99-3316-68 | Hydraulic | Production |
| 1/4 | 229 | 99-3301 | 99-3316-68 | Pneudraulic | Maintenance | |
| | 230 | 99-3301 | 99-3316-68 | Pneudraulic | Maintenance & Repair | |
| | 2025 | 99-3301 | | Pneudraulic | Maintenance & Repair | |
| | 202 | 99-3301 | 99-3316-68 | Pneudraulic | Prod. or Maint. & Repair | |
| | 212 | 99-3301 | 99-3305 | 99-3316-68 | Pneudraulic | Production |
| | AK180-I | 202142 | | Pneudraulic | Maintenance & Repair | |
| | 2480 | 99-3301 | 99-3305 | 99-3316-68 | Hydraulic | Production |
| | 246 | 99-3318 | | Pneudraulic | Production | |
| 3/8 | 2580 | 99-3318 | | Hydraulic | Production | |

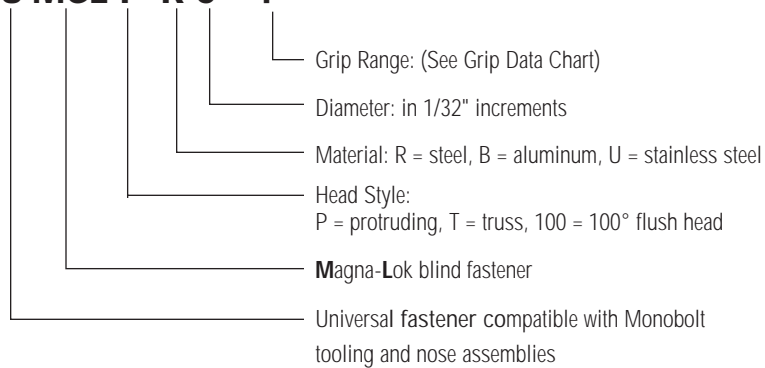
Installation Sequence



[Click Here to view animation of installation sequence](#)

Part Number Identification

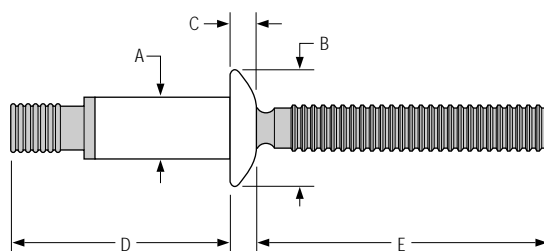
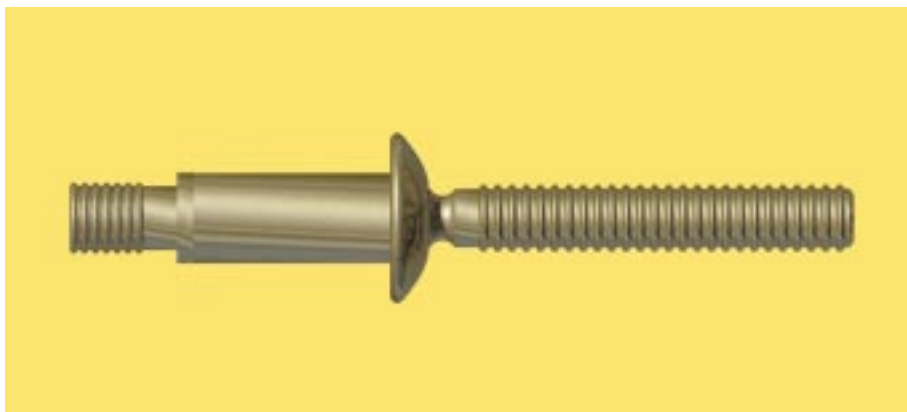
U MGL P-R 6 - 4



NOTE: Contact your HUCK representative for head styles, grips, and configurations not shown.

Magna-Bulb® LockRite™

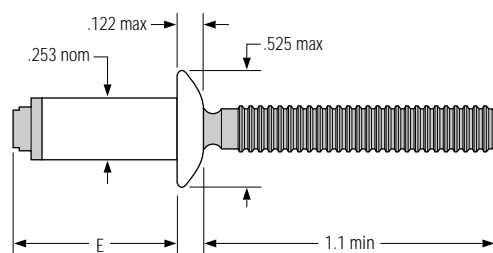
High strength with a broader bearing surface. The Magna-Bulb® fastener creates a broader bearing surface that helps spread the load over more area for a stronger, longer lasting connection.



Specifications

| Dia. (No.) | Part No. | Grip Range | D max |
|------------------|----------------|-------------|-------------|
| 3/16 (6) | MBP-R6-M2 | .075 - .110 | .592 |
| | MBP-R6-M3 | .087 - .150 | .672 |
| | MBP-R6-M4 | .126 - .189 | .695 |
| | MBP-R6-M5 | .165 - .228 | .734 |
| | MBP-R6-M6 | .205 - .268 | .774 |
| | MBP-R6-M7 | .244 - .307 | .813 |
| | MBP-R6-M8 | .283 - .347 | .853 |
| | MBP-R6-M9 | .323 - .386 | .892 |
| | MBP-R6-M10 | .362 - .425 | .931 |
| | 1/4 (8) | MBP-R8-M2 | .060 - .138 |
| MBP-R8-M3 | | .110 - .189 | .861 |
| MBP-R8-M4 | | .150 - .229 | .940 |
| MBP-R8-M5 | | .189 - .268 | .912 |
| MBP-R8-M6 | | .229 - .308 | .942 |
| MBP-R8-M7 | | .268 - .346 | .981 |
| MBP-R8-M8 | | .308 - .387 | 1.021 |
| MBP-R8-M9 | | .346 - .425 | 1.060 |
| MBP-R8-M10 | | .387 - .466 | 1.100 |
| MBP-R8-M11 | | .425 - .504 | 1.139 |
| MBP-R8-M12 | | .466 - .545 | 1.179 |
| MBP-R8-M13 | | .504 - .583 | 1.218 |
| 5/16 (10) | | MBP-R10-3 | .150 - .250 |
| | MBP-R10-4 | .200 - .300 | 1.165 |
| | MBP-R10-5 | .250 - .350 | 1.215 |
| | MBP-R10-6 | .300 - .400 | 1.265 |
| | MBP-R10-7 | .350 - .450 | 1.315 |
| | MBP-R10-8 | .400 - .500 | 1.365 |
| | MBP-R10-9 | .450 - .550 | 1.415 |
| | MBP-R10-10 | .500 - .600 | 1.465 |

Specifications—Clearance



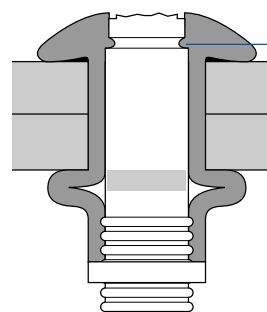
| Dia. | Part No. | Grip Range | E max |
|------|-------------|------------|-------|
| 1/4 | MBCP-R8-M2 | .060-.138 | .580 |
| | MBCP-R8-M3 | .110-.189 | .627 |
| | MBCP-R8-M5 | .189-.268 | .706 |
| | MBCP-R8-M7 | .268-.346 | .785 |
| | MBCP-R8-M8 | .308-.387 | .825 |
| | MBCP-R8-M9 | .346-.425 | .864 |
| | MBCP-R8-M11 | .425-.504 | .943 |
| | MBCP-R8-M13 | .504-.583 | 1.022 |

Typical Installed Values in Nominal Grip (lbs.)

| Dia. | Shear | Tensile | Pin Retention |
|-----------------|-------|---------|---------------|
| 3/16 | 1700 | 1050 | 150 |
| 1/4 | 3500 | 1900 | 300 |
| 1/4 (clearance) | 3000 | 1600 | 300 |
| 5/16 | 5000 | 2960 | 450 |

Material and Finish

| | Material | Finish |
|--------|----------|---------------------------|
| Sleeve | Steel | Zinc Plated Gold Chromate |
| Pin | Steel | Zinc Plated Gold Chromate |



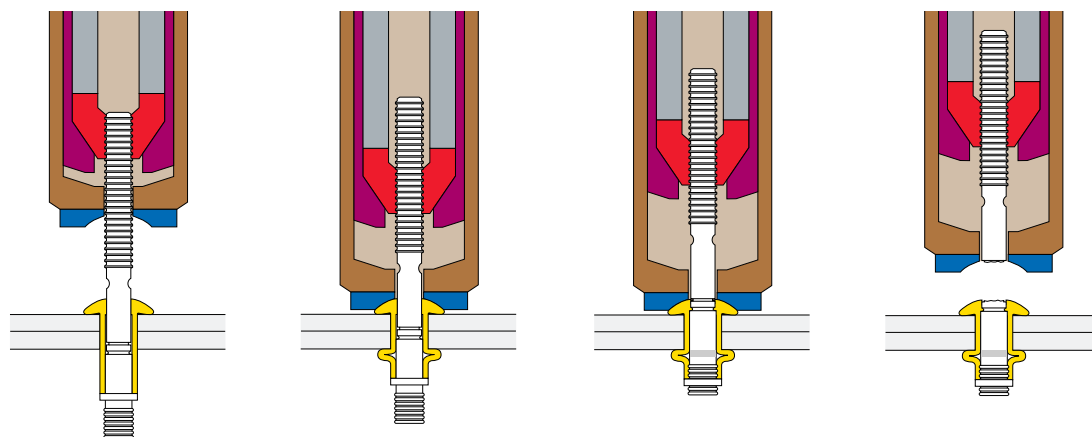
Unique solid-circle lock ensures maximum strength and resistance to vibration. It is designed to eliminate pin pushout.

Installation Tooling

| Dia. | Installation Tool | Nose Assembly | Type | Use |
|------|-------------------|-------------------------------------|-------------|--------------------------|
| 3/16 | 229 | 99-3300 | Pneudraulic | Production |
| | 230 | 99-3300 | Pneudraulic | Maintenance & Repair |
| | 2025 | 99-3300 | Pneudraulic | Maintenance & Repair |
| | 2015 | 125154 (Insert, included with tool) | Pneudraulic | Prod. or Maint. & Repair |
| | 202 | 99-3303 | Pneudraulic | Production |
| | 212 | 99-3300 99-3303 | Pneudraulic | Production |
| | 2480 | 99-3300 99-3303 | Hydraulic | Production |
| 1/4 | 229 | 99-3301 | Pneudraulic | Production |
| | 230 | 99-3301 | Pneudraulic | Maintenance & Repair |
| | 2025 | 99-3301 | Pneudraulic | Maintenance & Repair |
| | 202 | 99-3301 | Pneudraulic | Prod. or Maint. & Repair |
| | 212 | 99-3301 99-3305 | Pneudraulic | Production |
| | 2480 | 99-3301 99-3305 | Hydraulic | Production |
| 5/16 | 246 | 99-3307 | Pneudraulic | Production |
| | 2580 | 99-3307 | Hydraulic | Production |



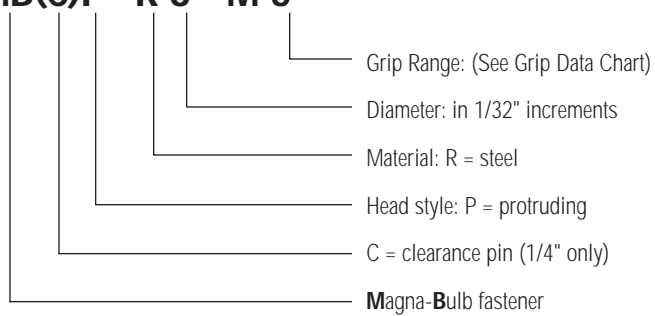
Installation Sequence



[Click Here to view animation of installation sequence](#)

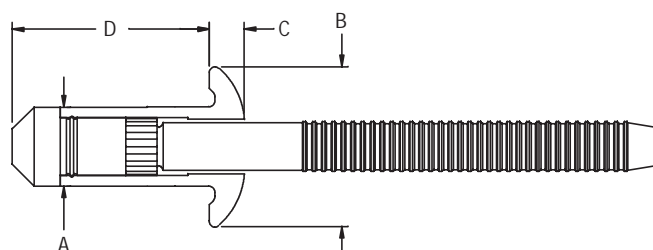
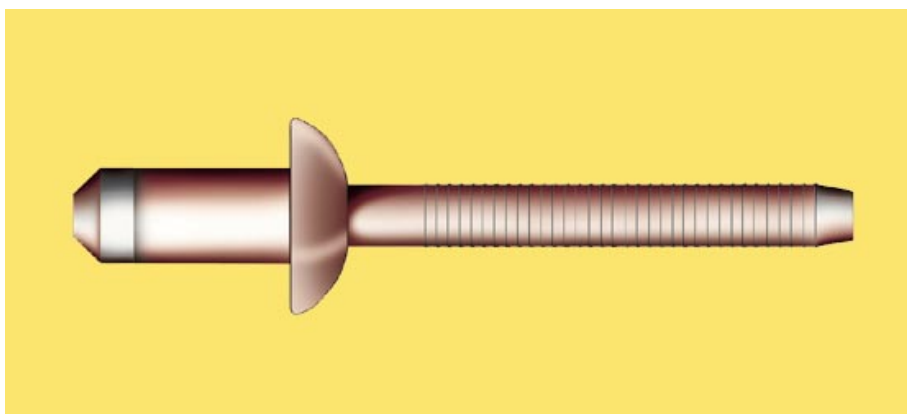
Part Number Identification

MB(C)P - R 8 - M 5

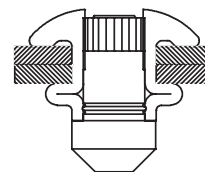


Auto-Bulb™ LockRtie™

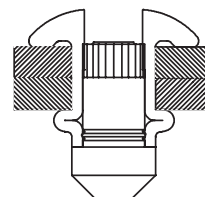
The Auto-Bulb™ fastener provides a large diameter head and broad bulb spread that diffuses the load over a larger area, ensuring permanent clamp. This unique fastener also offers a tapered hole-seeking tip, which provides for quick and easy installation.



Min. Grip



Max. Grip



Specifications

| Dia. (No.) | Part No. | Grip Range | D max |
|----------------------------|------------|-------------|-------|
| 3/16 (6) | ABP-R6-M2 | .075 - .110 | .471 |
| Hole Size=.191-.201 | ABP-R6-M3 | .087 - .150 | .510 |
| A nom=.190 | ABP-R6-M4 | .126 - .189 | .550 |
| B max=.375 | ABP-R6-M5 | .165 - .228 | .589 |
| C max=.101 | ABP-R6-M6 | .205 - .268 | .629 |
| | ABP-R6-M7 | .244 - .307 | .668 |
| | ABP-R6-M8 | .283 - .347 | .708 |
| | ABP-R6-M9 | .323 - .386 | .747 |
| | ABP-R6-M10 | .362 - .425 | .787 |
| | ABP-R6-M11 | .402 - .465 | .826 |
| | ABP-R6-M12 | .441 - .502 | .866 |
| | ABP-R6-M13 | .481 - .544 | .905 |
| | ABP-R6-M14 | .520 - .583 | .945 |
| | ABP-R6-M15 | .560 - .623 | .984 |
| | ABP-R6-M16 | .599 - .662 | 1.024 |
| | ABP-R6-M17 | .639 - .702 | 1.063 |
| | ABP-R6-M18 | .678 - .741 | 1.103 |

Specifications

| Dia. (No.) | Part No. | Grip Range | D max |
|----------------------------|------------|-------------|-------|
| 1/4 (8) | ABP-R8-M2 | .060 - .138 | .622 |
| Hole Size=.261-.272 | ABP-R8-M3 | .110 - .189 | .673 |
| A nom=.260 | ABP-R8-M4 | .150 - .229 | .713 |
| B max=.512 | ABP-R8-M5 | .189 - .268 | .752 |
| C max=.112 | ABP-R8-M6 | .229 - .308 | .792 |
| | ABP-R8-M7 | .268 - .346 | .831 |
| | ABP-R8-M8 | .308 - .387 | .871 |
| | ABP-R8-M9 | .346 - .425 | .910 |
| | ABP-R8-M10 | .387 - .466 | .950 |
| | ABP-R8-M19 | .741 - .820 | 1.305 |

Typical Installed Values in Nominal Grip (lbs.)

| Dia. | Shear | Tensile | Pin Retention |
|------|-------|---------|---------------|
| 3/16 | 1200 | 850 | 150 |
| 1/4 | 2600 | 1600 | 300 |

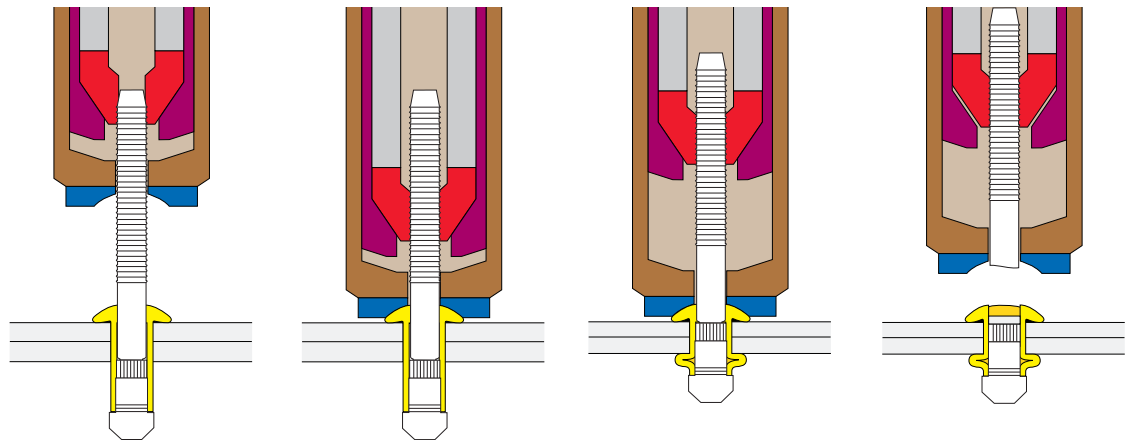
Material and Finish

| | Material | Finish |
|--------|----------|-----------------------------|
| Sleeve | Steel | Zinc Plated Gold Chromate |
| Pin | Steel | Zinc Plated Gold Dichromate |

Installation Tooling

| Dia. | Installation Tool | Nose Assembly | Type | Use |
|------|-------------------|-------------------------------------|-------------|--------------------------|
| 3/16 | 2015 | 125154 (Insert, included with tool) | Pneudraulic | Prod. or Maint. & Repair |
| | 202 | 99-3303 | Pneudraulic | Production |
| | 230 | 99-3305 | Pneudraulic | Maintenance & Repair |
| | 2025 | 99-3305 | Pneudraulic | Maintenance & Repair |
| 1/4 | 202 | 99-3303 | Pneudraulic | Production |
| | 230 | 99-3305 | Pneudraulic | Maintenance & Repair |
| | 2025 | 99-3305 | Pneudraulic | Maintenance & Repair |

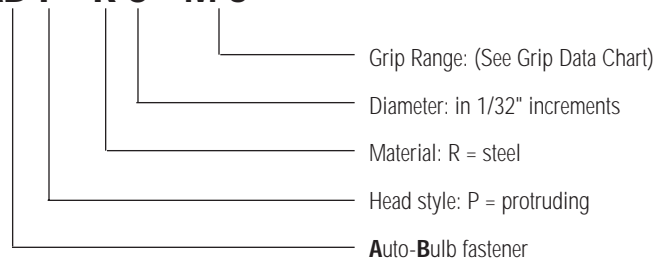
Installation Sequence



[Click Here to view animation of installation sequence](#)

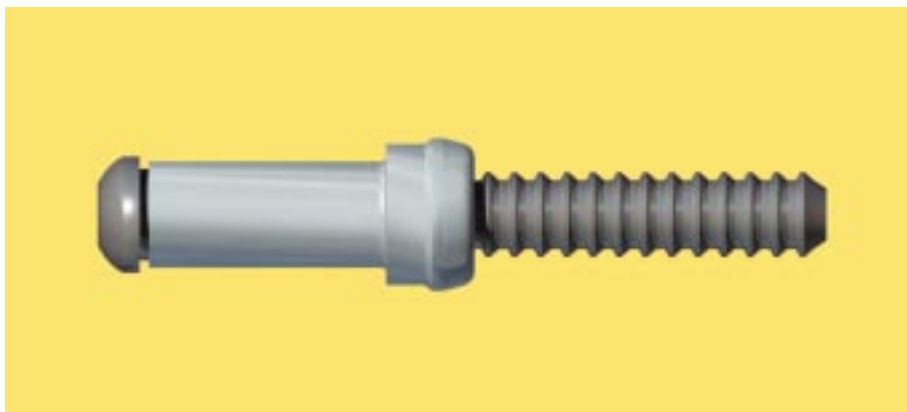
Part Number Identification

AB P - R 8 - M 5

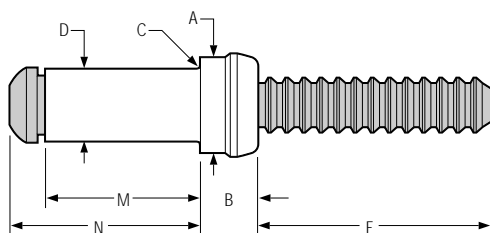


BOM[®] LockRite[™]

High-strength industrial blind bolt. Meets ASTM A307 strength requirements. Use in situations where a two-piece fastener would commonly be used. BOM[®] fastener install from just one side by a single worker—saving time and reducing cost.

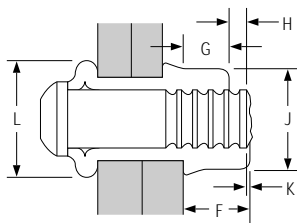


Dimensional Data



| Dia. (No.) | A | B | C max | D | E |
|------------------|--------------|------------|-------|------------|-------|
| 3/16 (6) | .286 -.276 | .152 -.168 | .015 | .206 -.196 | .785 |
| 1/4 (8) | .380 -.368 | .205 -.225 | .020 | .275 -.262 | .860 |
| 5/16 (10) | .478 -.468 | .266 -.278 | .025 | .346 -.332 | 1.285 |
| 3/8 (12) | .563 -.553 | .315 -.327 | .030 | .411 -.393 | 1.230 |
| 1/2 (16) | .755 -.745 | .415 -.438 | .035 | .544 -.529 | 1.530 |
| 5/8 (20) | .941 -.931 | .507 -.545 | .040 | .685 -.662 | 1.710 |
| 3/4 (24) | 1.130 -1.120 | .637 -.654 | .050 | .816 -.795 | 2.150 |

Installed Dimensions



| Dia. | F nom | G min | H max | J max | K max | L nom |
|-------------|-------|-------|-------|-------|-------|-------|
| 3/16 | .177 | 7/64 | 3/32 | .261 | 1/32 | .306 |
| 1/4 | .232 | 5/32 | 3/32 | .346 | 1/32 | .405 |
| 5/16 | .304 | 3/16 | 11/64 | .434 | 3/64 | .517 |
| 3/8 | .357 | 13/64 | 11/64 | .510 | 3/64 | .605 |
| 1/2 | .475 | 19/64 | 11/64 | .686 | 1/16 | .841 |
| 5/8 | .595 | 13/32 | 5/16 | .874 | 5/64 | 1.038 |
| 3/4 | .722 | 7/16 | 5/16 | 1.027 | 5/64 | 1.267 |

Grip Data

6 (3/16) Dia. Hole Size=.208-.222 (7/32)

| Grip No. | Range | M ref | N max | 8 (1/4) Dia. Hole Size=.277-.292 (9/32) | Grip No. | Range | M ref | N max |
|----------|------------|-------|-------|---|------------|-------|-------|-------|
| 2 | .093 -.156 | .376 | .500 | 2 | .093 -.156 | .460 | .620 | |
| 3 | .157 -.219 | .439 | .562 | 3 | .157 -.219 | .523 | .682 | |
| 4 | .220 -.281 | .501 | .625 | 4 | .220 -.281 | .585 | .745 | |
| 5 | .282 -.344 | .564 | .687 | 5 | .282 -.344 | .648 | .807 | |
| 6 | .345 -.406 | .626 | .750 | 6 | .345 -.406 | .710 | .870 | |
| 7 | .407 -.469 | .689 | .812 | 7 | .407 -.469 | .773 | .932 | |
| 8 | .470 -.531 | .751 | .875 | 8 | .470 -.531 | .835 | .995 | |
| 9 | .532 -.594 | .814 | .937 | 9 | .532 -.594 | .898 | 1.057 | |
| 10 | .595 -.656 | .876 | 1.000 | 10 | .595 -.656 | .960 | 1.120 | |
| 11 | .657 -.719 | .939 | 1.062 | 11 | .657 -.719 | 1.023 | 1.182 | |
| 12 | .720 -.781 | 1.001 | 1.125 | 12 | .720 -.781 | 1.085 | 1.245 | |

Grip Data

| 10 (5/16) Dia. Hole Size=.348-.368 | | | | 12 (3/8) Dia. Hole Size=.413-.435 | | | |
|---|--------------|--------------|--------------|--|--------------|--------------|--------------|
| Grip No. | Range | M ref | N max | Grip No. | Range | M ref | N max |
| 4 | .188 -.312 | .695 | .875 | 4 | .188 -.312 | .766 | .969 |
| 6 | .313 -.437 | .820 | 1.000 | 6 | .313 -.437 | .891 | 1.094 |
| 8 | .438 -.562 | .945 | 1.125 | 8 | .438 -.562 | 1.016 | 1.219 |
| 10 | .563 -.687 | 1.070 | 1.250 | 10 | .563 -.687 | 1.141 | 1.344 |
| 12 | .688 -.812 | 1.195 | 1.375 | 12 | .688 -.812 | 1.266 | 1.469 |
| 14 | .813 -.937 | 1.320 | 1.500 | 14 | .813 -.937 | 1.391 | 1.594 |
| 16 | .938 -1.062 | 1.445 | 1.625 | 16 | .938 -1.062 | 1.516 | 1.719 |
| 18 | | | | 18 | 1.063 -1.187 | 1.641 | 1.844 |
| 20 | | | | 20 | 1.188 -1.312 | 1.766 | 1.969 |

Grip Data

| 16 (1/2) Dia. Hole Size=.546-.581 (9/16) | | | | 20 (5/8) Dia. Hole Size=.687-.728 (11/16) | | | |
|---|--------------|--------------|--------------|--|--------------|--------------|--------------|
| Grip No. | Range | M ref | N max | Grip No. | Range | M ref | N max |
| 4 | .251 -.375 | 1.000 | 1.266 | 4 | .251 -.500 | 1.213 | 1.531 |
| 6 | .376 -.500 | 1.125 | 1.391 | | | | |
| 8 | .501 -.625 | 1.250 | 1.516 | 8 | .501 -.750 | 1.463 | 1.781 |
| 10 | .626 -.750 | 1.375 | 1.641 | | | | |
| 12 | .751 -.875 | 1.500 | 1.766 | 12 | .751 -1.000 | 1.713 | 2.031 |
| 14 | .876 -1.000 | 1.625 | 1.891 | | | | |
| 16 | 1.001 -1.125 | 1.750 | 2.016 | 16 | 1.001 -1.250 | 1.963 | 2.281 |
| 18 | 1.126 -1.250 | 1.875 | 2.141 | | | | |
| 20 | 1.251 -1.375 | 2.000 | 2.266 | 20 | 1.251 -1.500 | 2.213 | 2.531 |
| 22 | 1.376 -1.500 | 2.125 | 2.391 | | | | |
| 24 | 1.501 -1.625 | 2.250 | 2.516 | | | | |

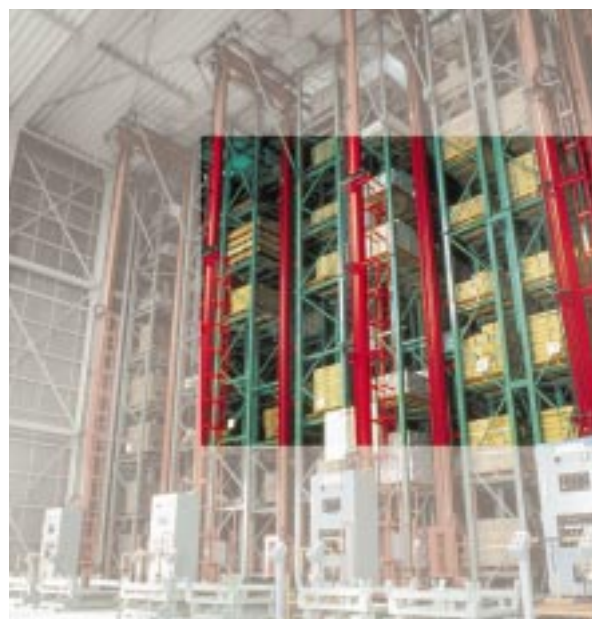
Grip Data

| 24 (3/4) Dia. Hole Size=.828-.873 (13/16) | | | |
|--|--------------|--------------|--------------|
| Grip No. | Range | M ref | N max |
| 4 | .251 -.500 | 1.380 | 1.750 |
| 8 | .501 -.750 | 1.630 | 2.000 |
| 12 | .751 -1.000 | 1.880 | 2.250 |
| 16 | 1.001 -1.250 | 2.130 | 2.500 |

Installed Values in Nominal Grip (lbs.)

| Diameter | Shear | Tensile |
|-----------------|--------------|----------------|
| 3/16 | 2800 | 1800 |
| 1/4 | 5100 | 3250 |
| 5/16 | 8050 | 5200 |
| 3/8 | 11100 | 7250 |
| 1/2 | 20150 | 13000 |
| 5/8 | 31900 | 20500 |
| 3/4 | 45100 | 29100 |

Note: These are minimum ultimate shear and tensile strengths, in pounds, of installed fastener, when tested in a grip equal to or greater than one and one half the fastener diameter.



Material, Finish and Lubrication

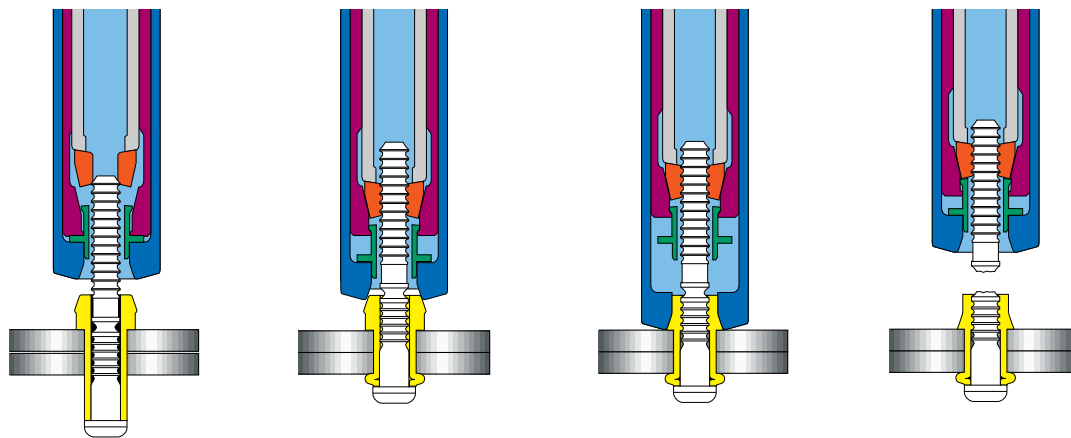
| | | Material | Finish | Lubrication |
|---------------|----------------|--------------|---|-------------|
| Sleeve | | Carbon Steel | Zinc plating per specification ASTM B695 or ASTM B633 | Wax Film |
| | | | Meets specifications of QQ-Z-325 and MIL-C-81562 | |
| Pin | 3/16-5/16 Dia. | Carbon Steel | None | Wax Film |
| | 3/8-3/4 Dia. | Alloy Steel | None | Wax Film |

Installation Tooling

| Dia. | Installation Tool | Nose Assembly | Type | Use |
|-------------|-------------------|----------------------|-------------|----------------------|
| 3/16 | 230 | 99-994 | Pneudraulic | Maintenance & Repair |
| | 2025 | 99-994 | Pneudraulic | Maintenance & Repair |
| | 212 | 99-994 | Pneudraulic | Production |
| | 245 | 99-1053 (heavy duty) | Pneudraulic | Production |
| | 246 | 99-1053 (heavy duty) | Pneudraulic | Production |
| | 2480 | 99-994 | Hydraulic | Production |
| | 2580 | 99-1053 (heavy duty) | Hydraulic | Production |
| 1/4 | 245 | 99-830-1 | Pneudraulic | Production |
| | 246 | 99-830-1 | Pneudraulic | Production |
| | 2580 | 99-830-1 | Hydraulic | Production |
| 5/16 | 246 | 99-769 | Pneudraulic | Production |
| | 2580 | 99-769 | Hydraulic | Production |
| | 2600 | 99-3119 | Hydraulic | Production |
| 3/8 | 2600 | 99-3122 | Hydraulic | Production |
| 1/2 | FE5901 | 99-5100 | Hydraulic | Production |
| | 5901 | 99-5100 | Hydraulic | Production |
| 5/8 | 585 | 99-5102 | Hydraulic | Production |
| | 586 | 99-5102 | Hydraulic | Production |
| 3/4 | 586 | 99-5103 | Hydraulic | Production |



Installation Sequence



[Click Here to view animation of installation sequence](#)

Part Number Identification

BOM- R 8 - 6

Grip Range: (See Grip Data Chart)

Diameter: in 1/32" increments

Material: R = steel pin, steel sleeve

Blind **O**versize **M**echanical fastener

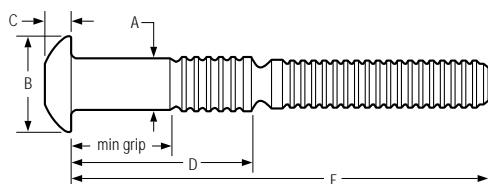
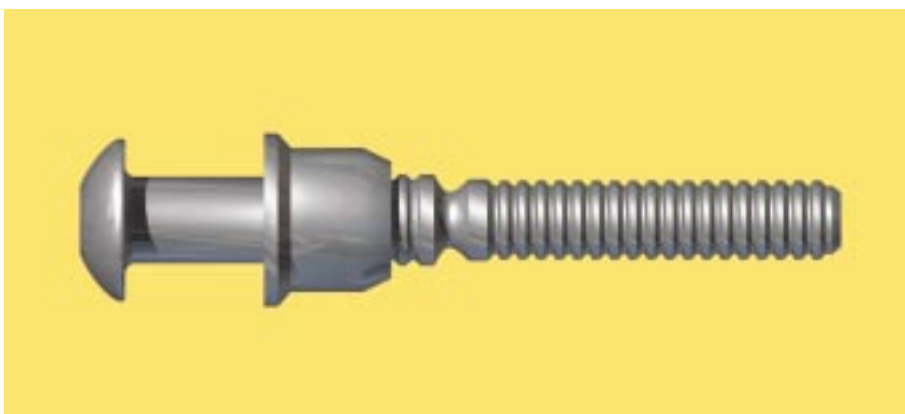
LOCK BOLTS

The LockBolt™ category includes the C6L® and Magna-Grip® two-piece fasteners, each consisting of a pin and collar. During installation, the collar is swaged on to the bolt, resulting in a permanent installation. Both the C6L® and Magna-Grip® fasteners are commonly used in the manufacturing of truck trailers, shipping containers and vehicles of all types.

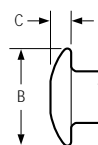
- C6L®** Two-piece, structural lockbolt, providing high clamp in a variety of applications
- Magna-Grip®** Two-piece, structural lockbolt, accommodates a wide grip range

C6L® LockBolt™

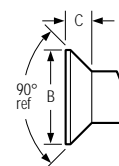
Vibration-resistant C6L® fasteners install with consistency and control. They resist loosening due to vibration and provide a high uniform clamp force. This is an excellent fastener for a wide range of structural applications.



Brazier Head—C6LB



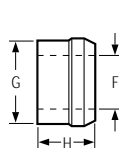
Truss Head—C6LT



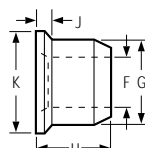
Flush Head—C6L90

Pin Dimensions

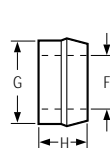
| Dia. (No.) | Maximum Hole Size | A | Brazier Head (B) | | Truss Head (T) | | Flush Head (90) | |
|------------------|-------------------|-------------|------------------|-------------|----------------|-------------|-----------------|-------------|
| | | | B | C | B | C | B | C |
| 3/16 (6) | .203 | .195 - .191 | .394 - .356 | .125 - .113 | .469 - .406 | .088 - .078 | .354 - .328 | .085 - .075 |
| 1/4 (8) | .266 | .259 - .254 | .525 - .475 | .152 - .136 | .594 - .531 | .115 - .103 | .473 - .437 | .113 - .101 |
| 5/16 (10) | .328 | .322 - .317 | .656 - .594 | .201 - .181 | .797 - .703 | .141 - .127 | .589 - .547 | .141 - .127 |
| 3/8 (12) | .391 | .385 - .380 | .787 - .713 | .248 - .223 | .922 - .828 | .168 - .152 | .709 - .656 | .168 - .152 |



LC/2LC



3LC



8LC

Collar Dimensions

| Collar Type | Part Number | Collar Diameter | F Diameter | G Diameter | H Length | J Dimension | K Diameter |
|-------------|----------------------------------|-----------------|-------------|-------------|-------------|-------------|-------------|
| Standard | 2LC-R, 2LC-F, LC-I, 2LC-2CU | 3/16 | .187 - .196 | .311 - .304 | .220 - .260 | | |
| | | 1/4 | .256 - .265 | .409 - .402 | .320 - .290 | | |
| | | 5/16 | .304 - .312 | .494 - .485 | .380 - .350 | | |
| | | 3/8 | .375 - .385 | .600 - .590 | .460 - .430 | | |
| Flange | 3LC-2R, 3LC-F, 3LC-I, 3LC-2CU | 3/16 | .187 - .196 | .311 - .304 | .280 - .250 | .062 - .031 | .391 - .359 |
| | | 1/4 | .256 - .267 | .409 - .402 | .379 - .349 | .078 - .047 | .516 - .484 |
| | | 5/16 | .304 - .312 | .507 - .498 | .426 - .394 | .094 - .062 | .641 - .609 |
| | | 3/8 | .378 - .390 | .610 - .599 | .532 - .502 | .125 - .062 | .781 - .719 |
| Low Profile | 8LC-2R, 8LC-F, 8LC-I, 8LC-2CU | 3/16 | .187 - .196 | .311 - .304 | .162 - .132 | .094 | |
| | | 1/4 | .256 - .265 | .409 - .402 | .202 - .172 | .125 | |
| | | 5/16 | .304 - .312 | .494 - .485 | .255 - .225 | .125 | |
| | | 3/8 | .375 - .385 | .600 - .590 | .295 - .310 | .156 | |

Note: When using 3LC collars, add "J" dimension to thickness of material being fastened to determine grip number.

Note: When using 8LC collars, subtract "J" dimension from thickness of material being fastened to determine grip number.

Note: Use collars and pins together as shown in "Values" tables, or contact HUCK.

Grip Data 3/16 and 1/4 diameter

| Grip No. | Grip Min | Range Max | 6 (3/16) Dia | | 8 (1/4) Dia | |
|----------|----------|-----------|--------------|----------|--------------|----------|
| | | | D \pm 1/32 | E+1/8,-0 | D \pm 1/32 | E+1/8,-0 |
| 2 | .063 | .188 | .394 | 1.404 | .485 | 1.520 |
| 3 | .125 | .250 | .457 | 1.466 | .548 | 1.583 |
| 4 | .188 | .313 | .519 | 1.529 | .610 | 1.645 |
| 5 | .250 | .375 | .582 | 1.591 | .673 | 1.708 |
| 6 | .313 | .438 | .644 | 1.654 | .735 | 1.770 |
| 7 | .375 | .500 | .707 | 1.716 | .798 | 1.833 |
| 8 | .438 | .563 | .769 | 1.779 | .860 | 1.895 |
| 9 | .500 | .625 | .832 | 1.841 | .923 | 1.958 |
| 10 | .563 | .688 | .894 | 1.904 | .985 | 2.020 |
| 11 | .625 | .750 | .957 | 1.966 | 1.048 | 2.083 |
| 12 | .688 | .813 | 1.019 | 2.029 | 1.110 | 2.145 |
| 13 | .750 | .875 | 1.082 | 2.091 | 1.173 | 2.208 |
| 14 | .813 | .938 | 1.144 | 2.154 | 1.235 | 2.270 |
| 15 | .875 | 1.000 | 1.207 | 2.216 | 1.298 | 2.333 |
| 16 | .938 | 1.063 | 1.269 | 2.279 | 1.360 | 2.395 |
| 17 | 1.000 | 1.125 | 1.332 | 2.341 | 1.423 | 2.458 |
| 18 | 1.063 | 1.188 | 1.394 | 2.404 | 1.485 | 2.520 |
| 19 | 1.125 | 1.250 | 1.457 | 2.466 | 1.548 | 2.583 |
| 20 | 1.188 | 1.313 | 1.519 | 2.529 | 1.610 | 2.645 |

Note: "Grip" is actual thickness of material to be fastened—contact HUCK for grips not shown.

Note: C6L90 is not available in grip 2 for 3/16 and 1/4 diameters and grip 4 for 3/8 diameter.

Grip Data 5/16 and 3/8 diameter

| Grip No. | Grip Min | Range Max | 10 (5/16) Dia | | 12 (3/8) Dia | |
|----------|----------|-----------|---------------|----------|--------------|----------|
| | | | D \pm 1/32 | E+1/8,-0 | D \pm 1/32 | E+1/8,-0 |
| 4 | .125 | .375 | .749 | 1.910 | .809 | 2.121 |
| 6 | .250 | .500 | .874 | 2.035 | .934 | 2.246 |
| 8 | .375 | .625 | .999 | 2.160 | 1.059 | 2.371 |
| 10 | .500 | .750 | 1.124 | 2.285 | 1.184 | 2.496 |
| 12 | .625 | .875 | 1.249 | 2.410 | 1.309 | 2.621 |
| 14 | .750 | 1.000 | 1.374 | 2.535 | 1.434 | 2.746 |
| 16 | .875 | 1.125 | 1.499 | 2.660 | 1.559 | 2.871 |
| 18 | 1.000 | 1.250 | 1.624 | 2.785 | 1.684 | 2.996 |
| 20 | 1.125 | 1.375 | 1.749 | 2.910 | 1.809 | 3.121 |

Installed Values ¹ in Nominal Grip (lbs.)

| | Pin: Collar: | 6061 Aluminum (F) | 2024 Aluminum (C) | Carbon Steel | CRES (U) |
|-------------|-----------------|-------------------|-------------------|----------------|--------------------|
| | | LC-I or 3LC-I | 2LC-F or 3LC-F | 2LC-R or 3LC-R | 2LC-2CU or 3LC-2CU |
| 3/16 | Shear | 775 | 1050 | 1725 | 2000 |
| | Tensile | 530 | 1000 | 1650 | 1455 |
| | Clamp | 350 | 550 | 1025 | 1025 |
| 1/4 | Shear | 1375 | 1875 | 3050 | 3550 |
| | Tensile | 975 | 1800 | 3000 | 3750 |
| | Clamp | 620 | 950 | 1805 | 1805 |
| 5/16 | Shear | 2125 | 2925 | 4725 | 5525 |
| | Tensile | 1550 | 2850 | 4600 | 4250 |
| | Clamp | 965 | 1500 | 2810 | 2810 |
| 3/8 | Shear | 3050 | 4200 | 6825 | 7950 |
| | Tensile | 2400 | 4200 | 6500 | 6100 |
| | Clamp | 1380 | 2200 | 4020 | 4020 |

¹ Minimum installed values (pounds) in nominal grip



Material and Finish

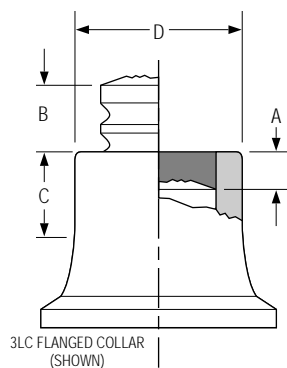
| | Material | Finish |
|--------|--------------------------------------|---|
| Pin | Carbon Steel (R) | Carbon Steel—none (plain black) |
| | 2024 Aluminum Alloy (C) | 2024 Aluminum Alloy—Anodize per MIL-A-8625 or chemical surface treatment per MIL-C-5541 (Manufacturer's option) |
| | 6061 Aluminum Alloy (F) | 6061 Aluminum Alloy—None |
| | CRES Steel (U) | CRES Steel—None |
| Collar | Low Carbon Steel (R) or (2R) | Carbon Steel—Zinc plated, Wax Film Lubricated |
| | 6061 Aluminum Alloy—Heat treated (F) | Aluminum Alloy—None, Wax Film Lubricated |
| | 6061 Aluminum Alloy (I) | CRES Steel—None, Wax Film Lubricated |
| | CRES Steel (CU) | Wax Film Lubricated |

Inspection Data

A properly installed HUCKBOLT Fastener will possess the dimensional characteristics shown in the chart. Should the dimensions "A" or "B" exceed the indicated values, the fastener is being used out-of-grip. A "C" dimension less than the values specified is an indication of incomplete swage. A "D" dimension exceeding the specified values is an indication of an incorrect or worn anvil on the installation tool.

Because of design margin built into the fastener and peculiar field installation conditions, fail-

ure of an installed fastener to meet the specified dimensional criteria is not necessarily an indication of an improperly installed assembly. Conversely, a HUCKBOLT pin installed in a properly prepared hole with the recommended single cycle driving tool, which swages the lock collar material into the locking grooves of the pin and breaks off the pintail at the breakneck groove, will always possess at least the minimum guaranteed strength characteristics when the dimensional limits specified are met.

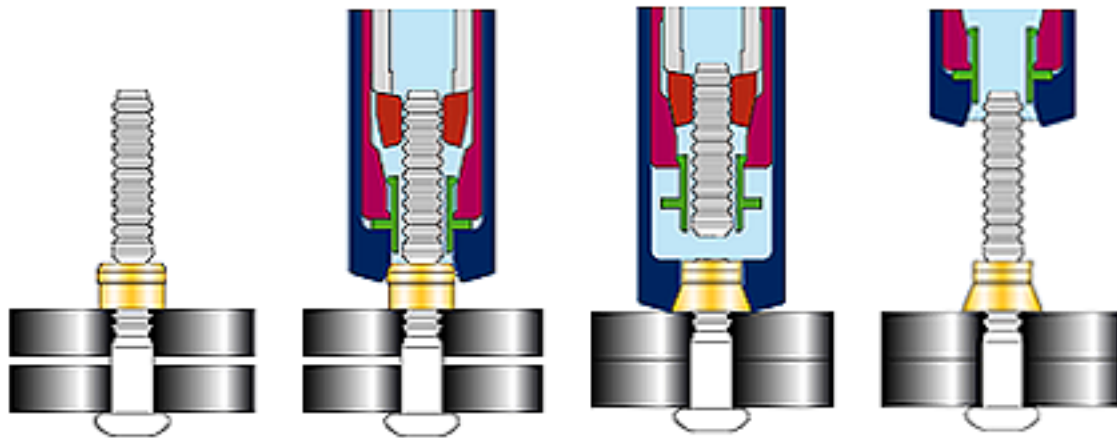


| Nominal Size | A Max Grip | B Min Grip | C Min | D Dia Max |
|--------------|---------------|---------------|----------|--------------|
| 3/16 | .078 | .125 | .172 | .276 |
| 1/4 | .078 | .156 | .250 | .364 |
| 5/16 | .141 | .219 | .281 | .454 |
| 3/8 | .125 | .281 | .344 | .522 |

Installation Tooling

| Dia. | Installation Tool | Nose Assembly | Type | Use |
|------|-------------------|---------------|-------------|----------------------|
| 3/16 | 230 | 99-999 | Pneudraulic | Maintenance & Repair |
| | 2025 | 99-999 | Pneudraulic | Maintenance & Repair |
| | 212 | 99-999 | Pneudraulic | Production |
| | 2480 | 99-999 | Hydraulic | Production |
| 1/4 | 230 | 99-1000 | Pneudraulic | Maintenance & Repair |
| | 2025 | 99-1000 | Pneudraulic | Maintenance & Repair |
| | 212 | 99-1000 | Pneudraulic | Production |
| | 2480 | 99-1000 | Hydraulic | Production |
| 5/16 | 246 | 99-99-245 | Pneudraulic | Production |
| | 2580 | 99-99-245 | Hydraulic | Production |
| 3/8 | 246 | 99-100-245 | Pneudraulic | Production |
| | 2580 | 99-100-245 | Hydraulic | Production |

Installation Sequence



[Click Here to view animation of installation sequence](#)

Part Number Identification

C6L LockBolt Pins

C6L B - R 8 - 4 G

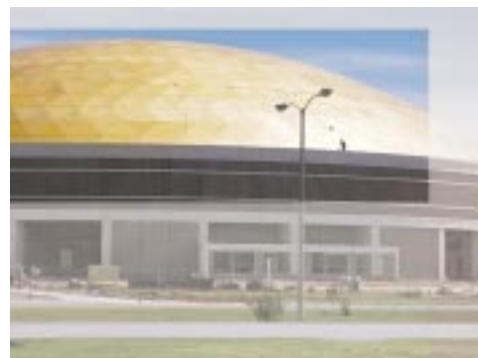
- Finish: G = zinc
- Grip Range: (See Grip Data Chart)
- Diameter: in 1/32" increments
- Material: R = carbon steel, C = 2024 alum. alloy, F = 6061 alum. alloy, U = CRES steel
- Style: T = truss head, B = brazier head, 90 = flush head

C6L LockBolt Collars

2 LC - R 8 G

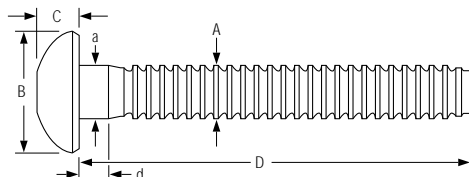
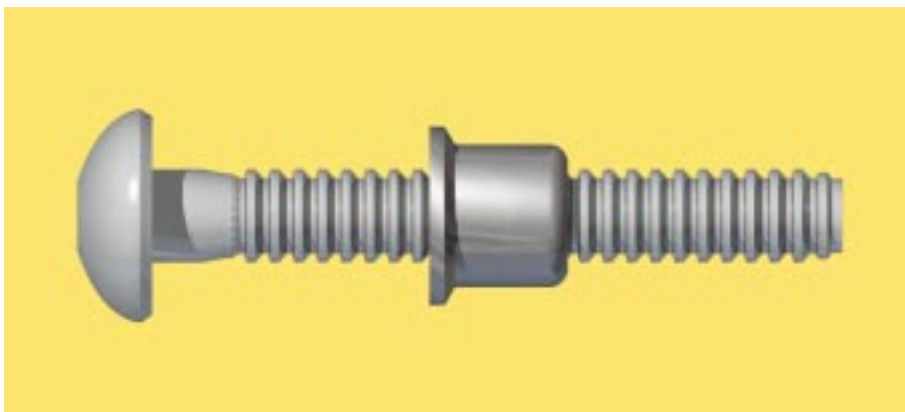
- Finish: G = zinc
- Diameter: in 1/32" increments
- R = carbon steel, F = 6061 alum. alloy heat treated, I = 6061 alum. alloy, CU = CRES steel
- Lock Collar
- Type: 2 = standard, 3 = flange

*Note: C120L (Grade 5) available at special request.
Contact your HUCK representative for stainless steel capped and special finishes not published.*



Magna-Grip® LockBolt™

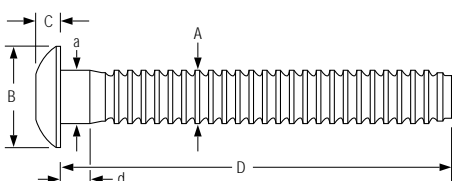
Grade 2 fastener that resists loosening. Widely known as the most reliable wide grip fastening system there is—the HUCK Magna-Grip® fastener also provides vibration resistance and high uniform installed values.



Button Head MGPB

Dimensional Data – Button Head

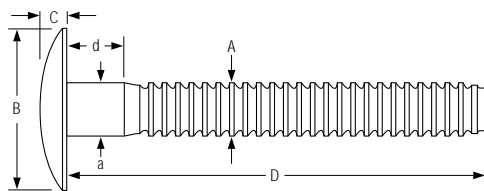
| Dia. (No.) | Grip Number | Grip Range | Hole Size max | A | B | C | D <small>+ .025 - .000</small> | a ref | d ref |
|---------------|----------------|--------------|------------------|-----------|-----------|-----------|--------------------------------|-----------|-----------|
| 3/16 | 10 | .062 - .625 | .203 | .183-.187 | .356-.394 | .113-.125 | 1.788 | .191-.195 | .103-.125 |
| | (6) 20 | .312 - 1.250 | .203 | .183-.187 | .356-.394 | .113-.125 | 2.730 | .191-.195 | .304-.320 |
| 1/4 | 10 | .062 - .625 | .265 | .245-.249 | .475-.525 | .136-.152 | 1.965 | .250-.259 | .109-.141 |
| | (8) 20 | .312 - 1.250 | .265 | .245-.249 | .475-.525 | .136-.152 | 2.560 | .250-.259 | .295-.329 |
| 5/16 | 12 | .125 - .750 | .328 | .307-.311 | .594-.656 | .181-.201 | 2.340 | .274-.283 | .251-Max. |
| | (10) 22 | .625 - 1.375 | .328 | .307-.311 | .594-.656 | .181-.201 | 2.840 | .317-.322 | .533-.567 |
| 3/8 | 14 | .125 - .875 | .390 | .369-.375 | .713-.787 | .223-.248 | 2.875 | .380-.385 | .172-.204 |
| | (12) 26 | .812 - 1.625 | .390 | .369-.375 | .713-.787 | .223-.248 | 3.500 | .380-.385 | .794-.826 |



Truss Head MGPT

Dimensional Data – Truss Head

| Dia. (No.) | Grip Number | Grip Range | Hole Size max | A | B | C | D <small>+ .025 - .000</small> | a ref | d ref |
|---------------|----------------|--------------|------------------|-----------|-----------|-----------|--------------------------------|-----------|-----------|
| 1/4 | 10 | .062 - .625 | .265 | .245-.249 | .531-.594 | .103-.115 | 1.965 | .250-.259 | .109-.141 |
| | (8) 20 | .312 - 1.250 | .265 | .245-.249 | .531-.594 | .103-.115 | 2.560 | .250-.259 | .295-.329 |
| 5/16 | 12 | .125 - .750 | .328 | .307-.311 | .703-.797 | .127-.141 | 2.340 | .274-.283 | .251-Max. |
| | (10) 22 | .625 - 1.375 | .328 | .307-.311 | .703-.797 | .127-.141 | 2.840 | .317-.322 | .533-.567 |
| 3/8 | 14 | .125 - .875 | .390 | .369-.375 | .828-.922 | .152-.168 | 2.875 | .380-.385 | .172-.204 |
| | (12) 26 | .812 - 1.625 | .390 | .369-.375 | .828-.922 | .190-.200 | 3.500 | .380-.385 | .794-.826 |

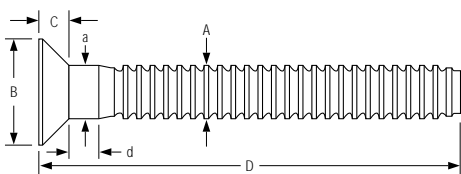


Broad Truss Head MGP30

Dimensional Data – Broad Truss Head

| Dia. (No.) | Grip Number | Grip Range | Hole Size max | A | B | C | D $+0.025 - .000$ | a ref | d ref |
|------------|-------------|--------------|---------------|-----------|-------------|-----------|-------------------|-----------|-------------|
| 1/4 | 10 | .062 - .625 | .265 | .245-.249 | ** | .138-.162 | 1.965 | .250-.259 | .109-.141 |
| | (8) | .625 - 1.50 | .265 | .245-.249 | ** | .138-.162 | 2.810 | .250-.259 | .546-.578 |
| 3/8 | 24 | .625 - 1.50 | .390 | .369-.375 | 1.188-1.250 | .188-.212 | 3.375 | .380-.385 | .664-.696 |
| | (12) | 1.125 - 2.00 | .390 | .369-.375 | 1.188-1.250 | .188-.212 | 3.875 | .380-.385 | 1.164-1.196 |

** Steel .937 Aluminum 1.063

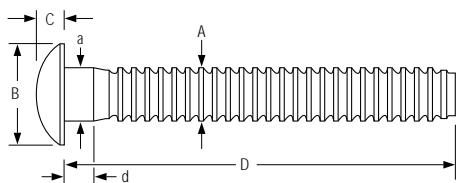


90° Flush Head MGP90

Dimensional Data – 90° Flush Head

| Dia. (No.) | Grip Number | Grip Range | Hole Size max | A | B | C | D $+0.025 - .000$ | a ref | d ref |
|------------|-------------|--------------|---------------|-----------|-----------|-----------|-------------------|-----------|-----------|
| 3/16 | 10 | .062 - .625 | .203 | .183-.187 | .323-.359 | .092-.102 | 1.788 | .191-.195 | .109-.141 |
| | (6) | .312 - 1.250 | .203 | .183-.187 | .323-.359 | .076-.087 | 2.370 | .191-.195 | .295-.329 |
| 1/4 | 10 | .062 - .625 | .265 | .245-.249 | .433-.478 | .119-.128 | 1.965 | .217-.226 | .141-.181 |
| | (8) | .312 - 1.250 | .265 | .245-.249 | .433-.478 | .102-.115 | 2.560 | .250-.259 | .295-.329 |
| 5/16 | 12 | .125 - .750 | .328 | .307-.311 | .542-.594 | .149-.162 | 2.340 | .275-.280 | .166-.206 |
| | (10) | .625 - 1.375 | .328 | .307-.311 | .542-.594 | .129-.142 | 2.840 | .317-.322 | .559-.591 |
| 3/8 | 14 | .250 - .875 | .390 | .369-.375 | .651-.714 | .178-.195 | 2.875 | .337-.342 | .229-.269 |
| | (12) | .812 - 1.625 | .390 | .369-.375 | .651-.714 | .153-.170 | 3.500 | .380-.385 | .793-.827 |

1 "d" dimension is not applicable to short grip parts



Rivet Head MGP98T

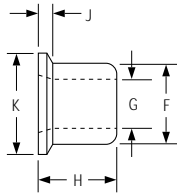
Dimensional Data – Rivet Head

| Dia. (No.) | Grip Number | Grip Range | Hole Size max | A | B | C | D $+0.025 - .000$ | a ref | d ref |
|------------|-------------|--------------|---------------|-----------|-----------|----------|-------------------|-----------|-----------|
| 3/16 | 10 | .062 - .625 | .203 | .183-.187 | .450-.488 | .91-.105 | 1.801 | .189-.196 | .078-.096 |
| | (6) | .312 - 1.250 | .203 | .183-.187 | .450-.488 | .91-.105 | 2.383 | .189-.196 | .303-.321 |

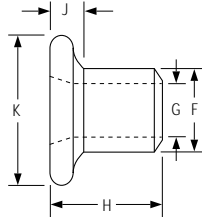
Installed Values in Nominal Grip (lbs.)

| | | Aluminum | Steel |
|------|---------|----------|-------|
| 3/16 | Shear | 750 | 1725 |
| | Tensile | 900 | 1400 |
| | Clamp | 550 | 925 |
| 1/4 | Shear | 1200 | 2200 |
| | Tensile | 1620 | 2550 |
| | Clamp | 950 | 1200 |

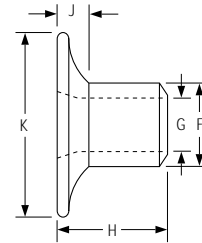
| | | Aluminum | Steel |
|------|---------|----------|-------|
| 5/16 | Shear | 2200 | 3000 |
| | Tensile | 2500 | 3910 |
| | Clamp | 1600 | 2150 |
| 3/8 | Shear | 3000 | 4200 |
| | Tensile | 4000 | 5625 |
| | Clamp | 2400 | 3200 |



Standard Flange MGC



Medium Flange MGCS



Wide Flange MGCW

Collar Dimensions

| Collar | Diameter | F | G | H | J | K |
|--------|----------|-----------|-----------|-----------|-----------|-----------|
| MGC | 3/16 | .307-.313 | .189-.195 | .265-.285 | .040-.052 | .365-.385 |
| | 1/4 | .399-.405 | .250-.260 | .360-.390 | .055-.070 | .480-.520 |
| | 5/16 | .501-.509 | .312-.320 | .430-.446 | .069-.086 | .605-.645 |
| | 3/8 | .603-.611 | .376-.384 | .490-.520 | .086-.100 | .730-.770 |
| MGCS | 3/16 | .308-.315 | .189-.195 | .290-.320 | .085-.115 | .495-.535 |
| MGCW | 3/16 | .307-.314 | .189-.195 | .290-.320 | .090-.115 | .640-.754 |
| | 1/4 | .399-.405 | .250-.260 | .432-.462 | .115-.145 | .855-1.00 |

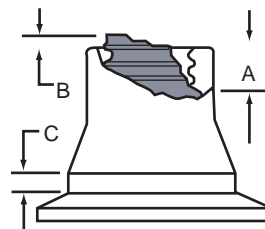
Installation Tooling

| Dia. | Installation Tool | Nose Assembly | Type | Use |
|-------------|-------------------|---------------|-------------|----------------------|
| 3/16 | 230 | 99-3201 | Pneudraulic | Maintenance & Repair |
| | 2025 | 99-3201 | Pneudraulic | Maintenance & Repair |
| | 212 | 99-3201 | Pneudraulic | Production |
| | 245 | 99-3206 | Pneudraulic | Production |
| | 246 | 99-3206 | Pneudraulic | Production |
| | 2480 | 99-3201 | Hydraulic | Production |
| | 2580 | 99-3206 | Hydraulic | Production |
| 1/4 | 230 | 99-3204 | Pneudraulic | Maintenance & Repair |
| | 2025 | 99-3204 | Pneudraulic | Maintenance & Repair |
| | 212 | 99-3204 | Pneudraulic | Production |
| | 245 | 99-3207 | Pneudraulic | Production |
| | 246 | 99-3207 | Pneudraulic | Production |
| | 2480 | 99-3204 | Hydraulic | Production |
| | 2580 | 99-3207 | Hydraulic | Production |
| 5/16 | 245 | 99-1439 | Pneudraulic | Production |
| | 246 | 99-1439 | Pneudraulic | Production |
| | 2580 | 99-1439 | Hydraulic | Production |
| | 2600 | 99-3217 | Pneudraulic | Production |
| 3/8 | 245* | 99-1440 | Pneudraulic | Production |
| | 246 | 99-1440 | Pneudraulic | Production |
| | 2580 | 99-1440 | Hydraulic | Production |
| | 2600 | 99-3220 | Hydraulic | Production |
| | FE5901 | 99-1492 | Hydraulic | Production |
| | 5901 | H99-1492 | Hydraulic | Production |

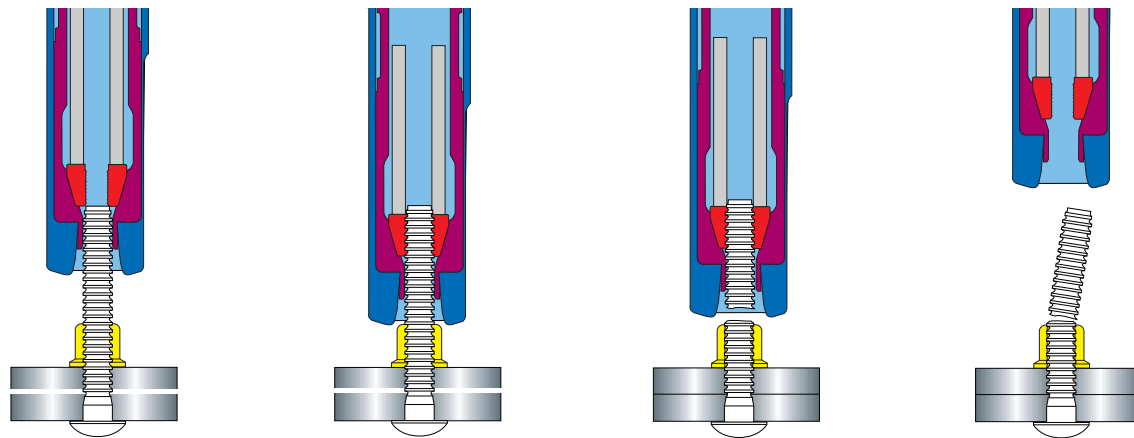
* Note: Aluminum Only

Inspection Data

| Dia. | A max | B max | C max |
|-------------|-------|-------|-------|
| 3/16 | 1/16 | 1/32 | .050 |
| 1/4 | 1/8 | 3/32 | .100 |
| 5/16 | 3/16 | 9/64 | .100 |
| 3/8 | 1/4 | 11/64 | .100 |



Installation Sequence

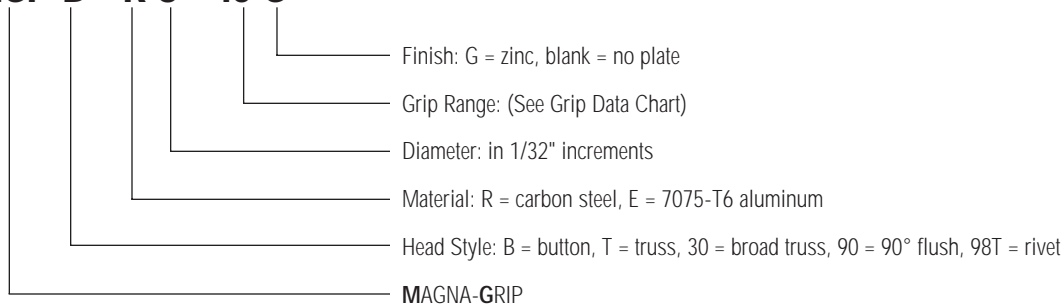


[Click Here to view animation of installation sequence](#)

Part Number Identification

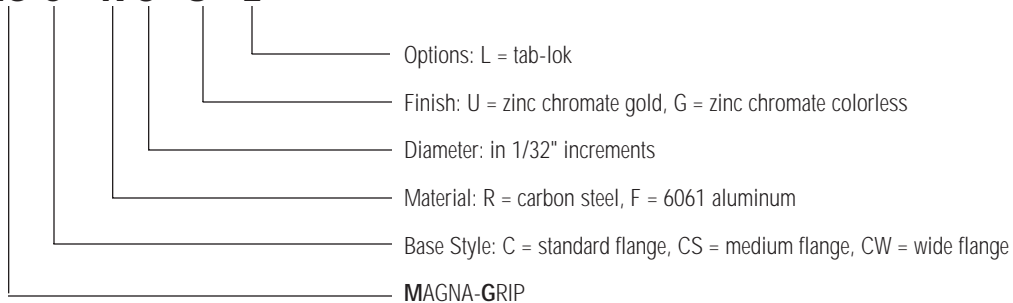
Magna-Grip Pins

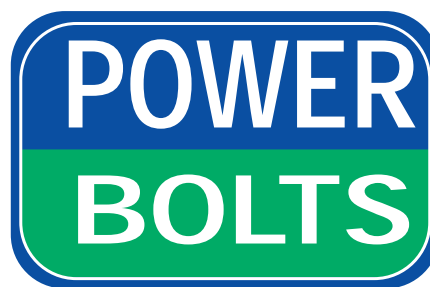
MGP B - R 8 - 10 G



Magna-Grip Collars

MG C - R 8 U L



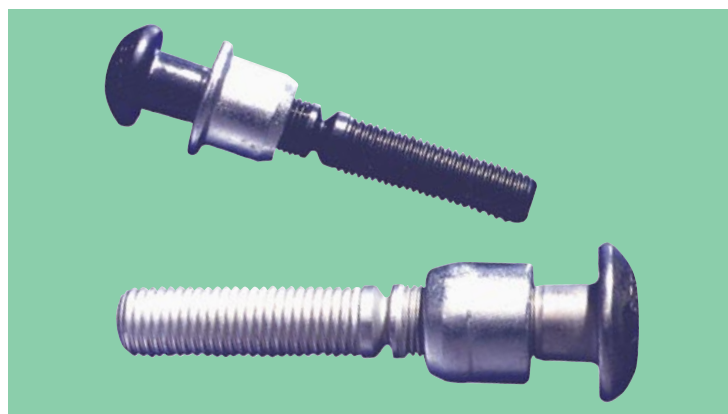


HUCK PowerBolts™, the company's largest diameter, two-piece fasteners, set the industry standard for strength and durability in high-vibration applications. Consisting of a pin and collar, these fasteners are installed by swaging the collar on the pin. Often used in truck and railcar manufacturing, these fasteners are also designed for the assembly of railroad crossings, mining equipment, cranes and ships, as well as in bridge and building construction.

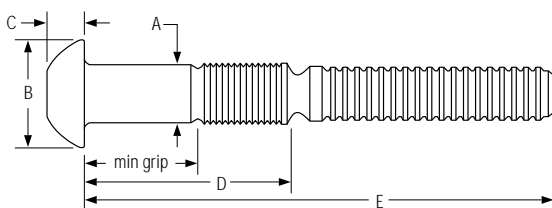
- C50L®** Two-piece lockbolt, widely used in railcar and locomotive applications
- HP8®** Two-piece Grade 8 lockbolt, for truck frame and other applications
- Huck-Fit®** Two-piece Grade 8 lockbolt, with a fit-up threaded collar for positioning prior to installation

C50L® PowerBolt™

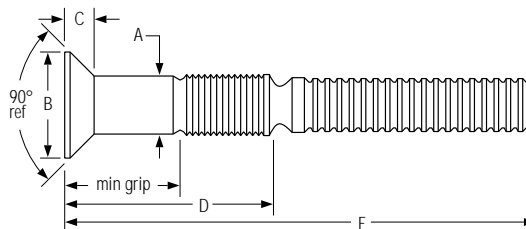
The rugged C50L® PowerBolt™ fastener is an alternative to Grade 5 bolts. Available in diameters ranging from 1/2" to 1-3/8", a variety of materials and head styles, the C50L® is ideal for applications where consistent, uniform clamp force is required.



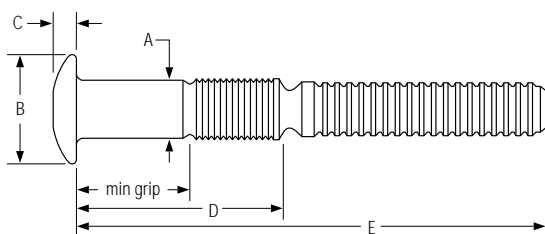
Round Head – C50LR



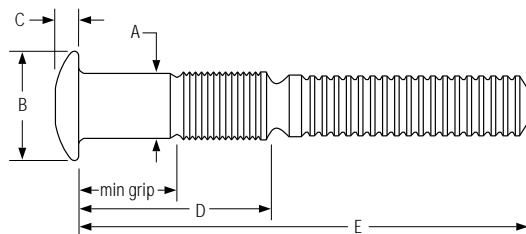
90° Flush Head – C50L90



Truss Head – C50LT



Large Truss Head – C50L30



Fastener Dimensions

| Dia. | A | Round Head | | Truss Head C50LT | | Truss Head C50L30 | | 90° Flush Head | |
|------------|---------------|------------|-------|------------------|-------|-------------------|-------|----------------|------|
| | | B | C | B | C | B | C | B | C |
| 1/2 (16) | .515 - .493 | 59/64 | 5/16 | 59/64 | 15/64 | 1 3/32 | 17/64 | 29/32 | 1/4 |
| 5/8 (20) | .642 - .617 | 1 9/64 | 25/64 | 1 9/64 | 19/64 | 1 3/8 | 21/64 | 1 5/32 | 5/16 |
| 3/4 (24) | .768 - .741 | 1 3/8 | 15/32 | 1 3/8 | 23/64 | | | 1 3/8 | 3/8 |
| 7/8 (28) | .895 - .866 | 1 19/32 | 35/64 | 1 19/32 | 13/32 | | | 1 19/32 | 7/16 |
| 1 (32) | 1.022 - .990 | 1 53/64 | 39/64 | 1 53/64 | 15/32 | | | 1 27/32 | 1/2 |
| 1 1/8 (36) | 1.149 - 1.098 | 2 1/16 | 11/16 | | | | | | |

1 3/8 -- See RamBolt for specifications.

Installed Fastener Values¹

| Dia. | Carbon Steel Pins LC-2R or 3LC-2R Collars | | | 2024 Aluminum Pins LC-F or 3LC-F Collars | | | 6061 Aluminum Pins LC-1 or 3LC-1 Collars | | | CRES Pins LC-2CU or 3LC-2CU Collars | | |
|-------|--|-------|---------|---|-------|---------|---|-------|---------|--|-------|---------|
| | Shear | Clamp | Tensile | Shear | Clamp | Tensile | Shear | Clamp | Tensile | Shear | Clamp | Tensile |
| 1/2 | 14400 | 12050 | 17050 | 7300 | 5900 | 7850 | 5300 | 4400 | 4900 | 13900 | 12050 | 17050 |
| 5/8 | 22500 | 19200 | 27100 | 11400 | 9200 | 12300 | 8300 | 6900 | 7670 | 21000 | 19200 | 27100 |
| 3/4 | 32400 | 28400 | 40100 | 16400 | 13300 | 17700 | 11900 | 9950 | 11040 | 30300 | 28400 | 40100 |
| 7/8 | 43400 | 39250 | 55450 | | | | | | | | | |
| 1 | 56500 | 51500 | 72700 | | | | | | | | | |
| 1 1/8 | 69500 | 58450 | 82950 | | | | | | | | | |

1 3/8 -- See RamBolt for specifications.

¹ Minimum values, in pounds, of installed fasteners. Round head, in carbon steel equivalent to ASTM A325 high strength bolts. Meets requirements of MIL-P-23469.

Grip Data and Dimensions

Grip is the actual thickness of material to be fastened. Grip includes 'C' dimension on 90° flush head and 60° watertight fasteners. Grips listed are not necessarily available in every head style. Contact HUCK for grips not shown.

Tolerances: Dimension D ± 1/32, Dimension E + 3/16, -1/16

| Grip No. | Grip Range min - max | 1/2" Diameter (-16) | | 5/8" Diameter (-20) | | 3/4" Diameter (-24) | | 7/8" Diameter (-28) | | 1" Diameter (-32) | | 1 1/8" Diameter (-36) | |
|----------|----------------------|---------------------|---------|---------------------|---------|---------------------|---------|---------------------|---------|-------------------|--------|-----------------------|----------|
| | | D | E | D | E | D | E | D | E | D | E | D | E |
| 4 | 1/4 - 1/2 | 1.213 | 3 11/64 | 1.433 | 3 21/32 | 1.518 | 4 5/32 | | | | | | |
| 8 | 1-2 - 3/4 | 1.463 | 3 27/64 | 1.683 | 3 29/32 | 1.768 | 4 13/32 | 1.921 | 4 11/16 | 2.073 | 5 3/8 | | |
| 12 | 3/4 - 1 | 1.713 | 3 43/64 | 1.933 | 4 5/32 | 2.018 | 4 21/32 | 2.171 | 4 15/16 | 2.323 | 5 5/8 | | |
| 16 | 1 - 1 1/4 | 1.963 | 3 59/64 | 2.183 | 4 13/32 | 2.268 | 4 29/32 | 2.421 | 5 3/16 | 2.573 | 5 7/8 | | |
| 20 | 1 1/4 - 1 1/2 | 2.213 | 4 11/64 | 2.433 | 4 21/32 | 2.518 | 5 5/32 | 2.671 | 5 7/16 | 2.823 | 6 1/8 | | |
| 24 | 1 1/2 - 1 3/4 | 2.463 | 4 27/64 | 2.683 | 4 29/32 | 2.768 | 5 13/32 | 2.921 | 5 11/16 | 3.073 | 6 3/8 | | |
| 28 | 1 3/4 - 2 | 2.713 | 4 43/64 | 2.933 | 5 5/32 | 3.018 | 5 21/32 | 3.171 | 5 15/16 | 3.323 | 6 5/8 | | |
| 32 | 2 - 2 1/4 | 2.963 | 4 59/64 | 3.183 | 5 13/32 | 3.268 | 5 29/32 | 3.421 | 6 3/16 | 3.573 | 6 7/8 | | |
| 36 | 2 1/4 - 2 1/2 | 3.213 | 5 11/64 | 3.433 | 5 21/32 | 3.518 | 6 5/32 | 3.671 | 6 7/16 | 3.823 | 7 1/8 | | |
| 40 | 2 1/2 - 2 3/4 | 3.463 | 5 27/64 | 3.683 | 5 29/32 | 3.768 | 6 13/32 | 3.921 | 6 11/16 | 4.073 | 7 3/8 | | |
| 44 | 2 3/4 - 3 | 3.713 | 5 43/64 | 3.933 | 6 5/32 | 4.018 | 6 21/32 | 4.171 | 6 15/16 | 4.323 | 7 5/8 | | |
| 48 | 3 - 3 1/4 | 3.963 | 5 59/64 | 4.183 | 6 13/32 | 4.268 | 6 29/32 | 4.421 | 7 3/16 | 4.573 | 7 7/8 | | |
| 52 | 3 1/4 - 3 1/2 | 4.213 | 6 11/64 | 4.433 | 6 21/32 | 4.518 | 7 5/32 | 4.671 | 7 7/16 | 4.823 | 8 1/8 | | |
| 56 | 3 1/2 - 3 3/4 | 4.463 | 6 27/64 | 4.683 | 6 29/32 | 4.768 | 7 13/32 | 4.921 | 7 11/16 | 5.073 | 8 3/8 | 5.250 | 8 9/16 |
| 60 | 3 3/4 - 4 | 4.713 | 6 43/64 | 4.933 | 7 5/32 | 5.018 | 7 21/32 | 5.171 | 7 15/16 | 5.323 | 8 5/8 | 5.500 | 8 13/16 |
| 64 | 4 - 4 1/4 | 4.963 | 6 59/64 | 5.183 | 7 13/32 | 5.268 | 7 29/32 | 5.421 | 8 3/16 | 5.573 | 8 7/8 | 5.750 | 9 1/16 |
| 68 | 4 1/4 - 4 1/2 | 5.213 | 7 11/64 | 5.433 | 7 21/32 | 5.518 | 8 5/32 | 5.671 | 8 7/16 | 5.823 | 9 1/8 | 6.000 | 9 5/16 |
| 72 | 4 1/2 - 4 3/4 | 5.463 | 7 27/64 | 5.683 | 7 29/32 | 5.768 | 8 13/32 | 5.921 | 8 11/16 | 6.073 | 9 3/8 | 6.250 | 9 9/16 |
| 76 | 4 3/4 - 5 | 5.713 | 7 43/64 | 5.933 | 8 5/32 | 6.018 | 8 21/32 | | | 6.323 | 9 5/8 | 6.500 | 9 13/16 |
| 80 | 5 - 5 1/4 | 5.963 | 7 59/64 | | | | | | | 6.573 | 9 7/8 | 6.750 | 10 1/16 |
| 84 | 5 1/4 - 5 1/2 | | | | | | | | | 6.823 | 10 1/8 | 7.000 | 10 5/16 |
| 88 | 5 1/2 - 5 3/4 | | | | | | | | | 7.073 | 10 3/8 | 7.250 | 10 9/16 |
| 92 | 5 3/4 - 6 | | | | | | | | | 7.323 | 10 5/8 | 7.500 | 10 13/16 |

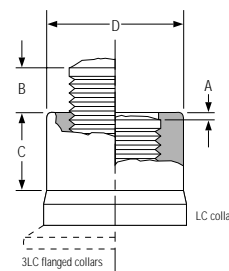
* 1 3/8 -- See RamBolt for specifications.

Inspection Data

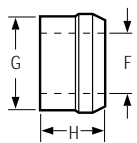
A properly installed C50L fastener will possess the dimensional characteristics tabulated below. Should the dimensions 'A' or 'B' exceed the indicated values, the fastener is being used out-of-grip. A 'C' dimension less than the values specified is an indication of incomplete swage. A 'D' dimension exceeding the tabulated values is an indication of an incorrect or worn anvil on the installation tool. The 'A' dimension can be increased to 1/8 and still meet all published values, provided there is no requirement to meet ASTM specifications pertaining to locking grooves (threads) in the shear plane.

| Dia. | Pin Part No. | Collar Type LC* | Collar Type 3LC* | A max | B max | C min | D max |
|-------|--------------|-----------------|------------------|-------|-------|-------|-------|
| 1/2 | C50L(-)(-)16 | LC-2R16G | 3LC-2R16G | 1/16 | 3/8 | 13/32 | .733 |
| 5/8 | C50L(-)(-)20 | LC-2R20G | 3LC-2R20G | 1/16 | 3/8 | 5/8 | .916 |
| 3/4 | C50L(-)(-)24 | LC-2R24G | 3LC-2R24G | 1/16 | 3/8 | 21/32 | 1.110 |
| 7/8 | C50L(-)(-)28 | LC-2R28G | 3LC-2R28G | 1/16 | 3/8 | 3/4 | 1.282 |
| 1 | C50L(-)(-)32 | LC-2R32G | 3LC-2R32G | 1/16 | 3/8 | 7/8 | 1.465 |
| 1 1/8 | C50LR-BR36 | LC-2R36G | | 1/16 | 3/8 | 29/32 | 1.646 |

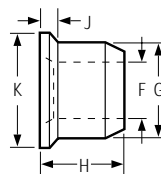
* Manufacturer's Option: 'G' or 'GA', unless specified



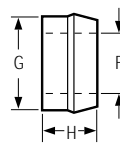
Standard Collar – LC



Flanged Collar – 3LC



Low Profile Collar – 8LC



Collar Dimensions

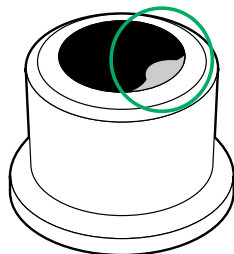
| Collar | Diameter | F | G | H | J | K |
|------------------|----------|---------------|---------------|--------------------------|-------------|---------------|
| LC | 1/2 | .515 - .540 | .800 - .765 | .645 - .610 | | |
| | 5/8 | .650 - .665 | 1.010 - .970 | .875 - .845 ³ | | |
| | 3/4 | .775 - .790 | 1.180 - 1.165 | .960 - .930 | | |
| | 7/8 | .910 - .935 | 1.375 - 1.345 | 1.113 - 1.083 | | |
| | 1 | 1.025 - 1.050 | 1.575 - 1.535 | 1.275 - 1.230 | | |
| | 1 1/8 | 1.150 - 1.180 | 1.770 - 1.740 | 1.425 - 1.385 | | |
| 3LC ¹ | 1/2 | .515 - .535 | .807 - .793 | .746 - .716 | .156 - .094 | 1.031 - .969 |
| | 5/8 | .650 - .665 | 1.010 - .970 | .959 - .929 | .187 - .125 | 1.281 - 1.218 |
| | 3/4 | .775 - .790 | 1.200 - 1.170 | 1.147 - 1.117 | .218 - .156 | 1.531 - 1.468 |
| | 7/8 | .910 - .930 | 1.375 - 1.360 | 1.330 - 1.300 | .250 - .187 | 1.625 - 1.562 |
| | 1 | 1.030 - 1.050 | 1.575 - 1.550 | 1.515 - 1.485 | .281 - .218 | 1.906 - 1.843 |
| | 1 1/8 | 1.150 - 1.180 | 1.770 - 1.740 | 1.700 - 1.670 | .312 - .250 | 2.156 - 2.093 |
| 8LC ² | 1/2 | .515 - .535 | .800 - .775 | .500 - .470 | | |
| | 5/8 | .650 - .665 | 1.010 - .970 | .700 - .670 | | |
| | 3/4 | .775 - .790 | 1.180 - 1.165 | .745 - .715 | | |
| | 7/8 | .910 - .930 | 1.375 - 1.360 | .863 - .833 | | |
| | 1 | 1.030 - 1.050 | 1.575 - 1.550 | .980 - .950 | | |

Installation Tooling

| Dia. | Installation Tool | Nose Assembly | Type | Use |
|-------|-------------------|---------------|-----------|------------|
| 1/2 | FE5901 | 99-5000 | Hydraulic | Production |
| | 5901 | 99-5002 | Hydraulic | Production |
| 5/8 | 585 | 99-5008 | Hydraulic | Production |
| | 586 | 99-5008 | Hydraulic | Production |
| 3/4 | 585 | 99-5010 | Hydraulic | Production |
| | 586 | 99-5010 | Hydraulic | Production |
| 7/8 | 506 | 99-5014 | Hydraulic | Production |
| 1 | 507 | 99-5016 | Hydraulic | Production |
| 1 1/8 | 507 | 99-5019 | Hydraulic | Production |
| 1 3/8 | 12142 | Integral | Hydraulic | Production |

Hole Data⁴

| Dia. | Maximum Hole |
|-------|--------------|
| 1/2 | 9/16 |
| 5/8 | 11/16 |
| 3/4 | 13/16 |
| 7/8 | 15/16 |
| 1 | 1 1/16 |
| 1 1/8 | 1 3/16 |



TAB-LOK™

The Tab-Lok feature makes sure the collar stays on the pin, before installation, in overhead and down slanted pin placements. To order Tab-Lok collars refer to 'Options' in the 'How to Order' section of this brochure.

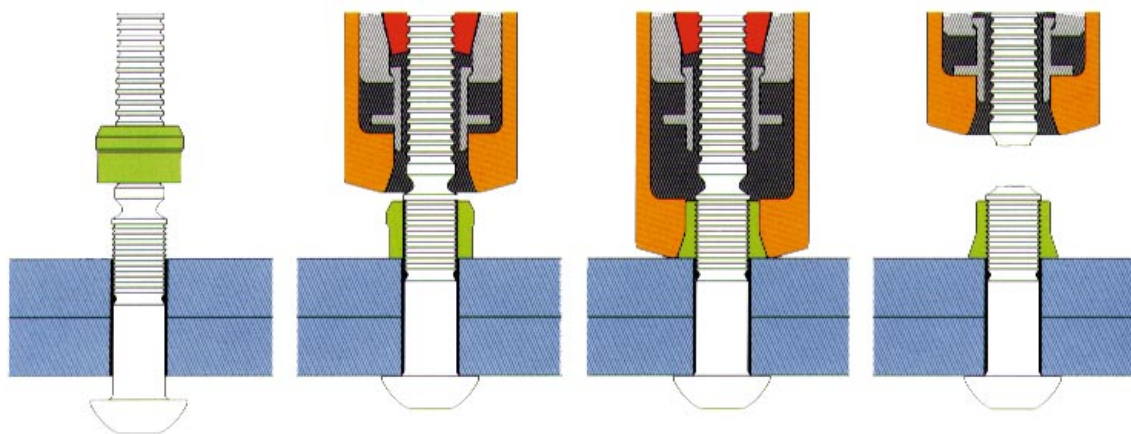
¹ When using 3LC collars, include J dimension in grip dimension to determine grip number.

² Optional collar at reduced clamping force and tensile strength. Contact HUCK for data. When using 8LC collars, subtract J dimension from grip dimension to determine grip number.

³ H length for 20(5/8) diameter in F, I or 2CU material is .805 - .770.

⁴ Except C50L60, refer to Mil-Spec MIL-P-23469.

Installation Sequence



[Click Here to view animation of installation sequence](#)

Part Number Identification

C50L Pins

Follow the form below to construct a part number for ordering C50L pins. Refer to the Grip Data chart for grip numbers.

C50L (HEAD STYLE) - (MATERIAL) (DIAMETER) - (GRIP NUMBER)

Example: **C50LR-BR16-4** is a C50L HUCKBOLT fastener, Round Head, Carbon Steel, 1/2" Diameter, Grip 4

| Head Style | Material | Diameter | Grip |
|------------|-----------------------------|---------------|------------------------------------|
| Round | R Carbon Steel | BR 1/2 | 16 Refer to Grip Data Chart |
| Truss | T 2024 Aluminum | C 5/8 | 20 |
| 90° Flush | 90 6061 Aluminum | F 3/4 | 24 |
| 60° Flush | 60 CRES ¹ | U 7/8 | 28 |
| | | | 1 32 |
| | | | 1 1/8 36 |

¹ CRES fasteners are available in 16 through 24 diameters and through 36 grips only.

C50L Collars

Follow the form below to construct a part number for ordering collars for C50L pins.

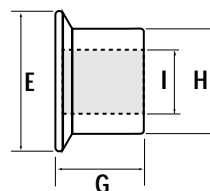
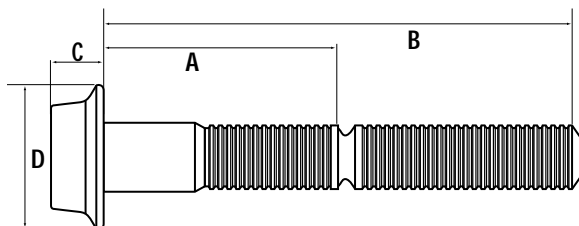
(COLLAR STYLE) - (MATERIAL) (DIAMETER) (FINISH) (OPTIONS)

Example: **LC-2R16G** is a Standard Collar, Low Carbon Steel, 1/2" Diameter, Zinc Finish

| Collar Style | Material | Diameter | Finishes | Options |
|--------------|----------------------------|------------------|----------------|------------------|
| Standard | LC Low Carbon Steel | 1/2 | 16 Zinc | G Tab-Lok |
| Flanged | 3LC Zinc Plated | 2R 5/8 | 20 | L |
| Low Profile | 8LC 6061 Aluminum | 3/4 | 24 | |
| | Aged | F 7/8 | 28 | |
| | 6061 Aluminum | I 1 | 32 | |
| | Stainless Steel | 2CU 1 1/8 | 36 | |

HP8® PowerBolt™

HUCK's original Grade 8 fastening system, the HP8® PowerBolt®, provides an easy-to-use system that delivers a permanent, vibration resistant clamp. These fasteners, available in diameters ranging from 1/2" to 3/4", offer fast, tamper-resistant installation, with only a visual inspection required.



Fastener Dimensions

1/2" Round Head (DT16)

| | Grip No. | A | B |
|--------|-----------|-------|-------|
| C=.307 | 8 | 1.625 | 3.550 |
| D=1.07 | 12 | 1.875 | 3.800 |
| G=.75 | 16 | 2.125 | 4.050 |
| H=.812 | 20 | 2.375 | 4.300 |
| I=.519 | 28 | 2.875 | 4.80 |
| | 36 | 3.375 | 5.300 |
| | 44 | 3.875 | 5.800 |
| | 52 | 4.375 | 6.300 |
| | 60 | 4.875 | 6.800 |

5/8" Round Head (DT20)

| | Grip No. | A | B |
|---------|-----------|-------|-------|
| C=.498 | 8 | 1.820 | 4.038 |
| D=1.330 | 12 | 2.070 | 4.288 |
| G=.922 | 16 | 2.320 | 4.538 |
| H=1.009 | 20 | 2.570 | 4.788 |
| I=.645 | 28 | 3.070 | 5.288 |
| | 36 | 3.570 | 5.788 |
| | 44 | 4.070 | 6.288 |
| | 52 | 4.570 | 6.788 |
| | 60 | 5.070 | 7.288 |
| | 88 | 6.820 | 9.038 |

3/4" Round Head (DT24)

| | Grip No. | A | B |
|---------|-----------|-------|-------|
| C=.60 | 8 | 2.000 | 4.640 |
| D=1.59 | 12 | 2.250 | 4.890 |
| G=1.107 | 16 | 2.500 | 5.140 |
| H=1.213 | 20 | 2.750 | 5.390 |
| I=.780 | 28 | 3.250 | 5.890 |
| | 32 | 3.500 | 6.140 |
| | 36 | 3.750 | 6.390 |
| | 44 | 4.250 | 6.890 |
| | 52 | 4.750 | 7.390 |
| | 60 | 5.250 | 7.890 |

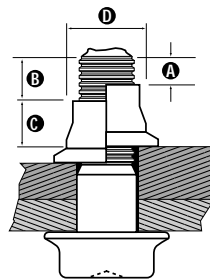
Grip Data

| Grip Number | Range min-max |
|-------------|---------------|
| 8 | .250-.750 |
| 12 | .500-1.00 |
| 16 | .750-1.25 |
| 20 | 1.00-1.50 |
| 28 | 1.50-2.00 |
| 32 | 1.75-2.25 |
| 36 | 2.00-2.50 |
| 44 | 2.50-3.00 |
| 52 | 3.00-3.50 |
| 60 | 3.50-4.00 |
| 88 | 5.25-5.75 |

Inspection Data

ROUND HEAD INCH SERIES (")

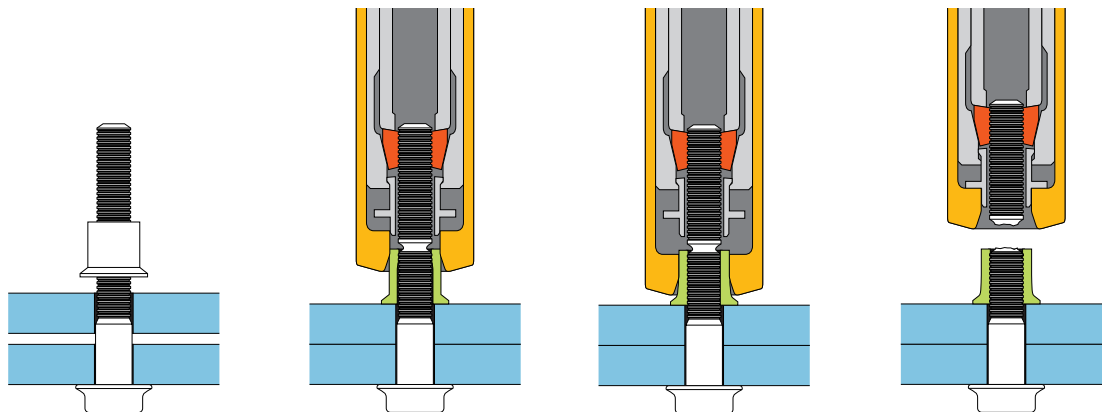
| DIAMETER | A (Min) | B (Max) | C (Min) | D (Max) |
|----------|---------|---------|---------|---------|
| DT16 | .10 | .65 | .56 | .760 |
| DT20 | .12 | .67 | .73 | .945 |
| DT24 | .12 | .67 | .86 | 1.132 |



Installation Tooling

| Dia. | Installation Tool | Nose Assembly | Type | Use |
|------|-------------------|---------------|-----------|------------|
| 1/2 | FE5901 | 99-5300 | Hydraulic | Production |
| | 5901 | 99-5300 | Hydraulic | Production |
| 5/8 | 585 | 99-5301 | Hydraulic | Production |
| | 586 | 99-5301 | Hydraulic | Production |
| 3/4 | 585 | 99-5303 | Hydraulic | Production |
| | 586 | 99-5303 | Hydraulic | Production |

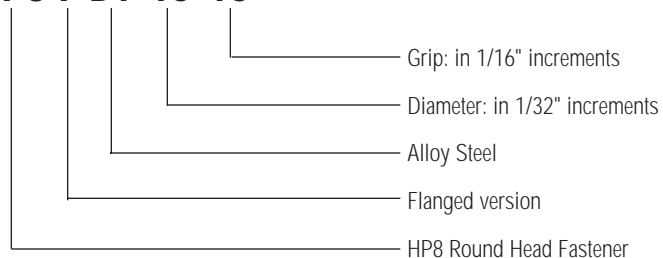
Installation Sequence



[Click Here to view animation of installation sequence](#)

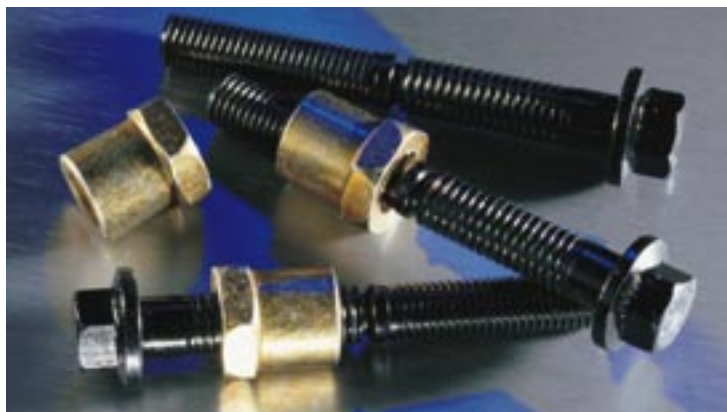
Part Number Identification

HP8 F DT 16 16

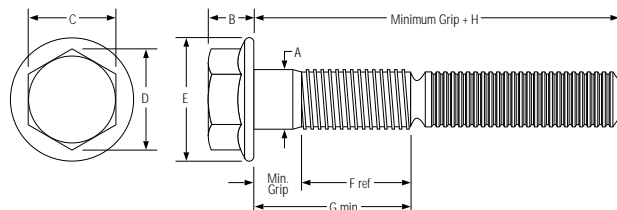


Metric Huck-Fit® PowerBolt™

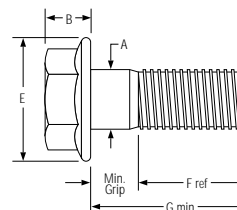
For use in OEM and aftermarket applications that require a metric fastener, the Metric Huck-Fit® PowerBolt™ fastening system includes a pin and collar with fit-up thread. This feature allows the Metric Huck-Fit® to be accurately positioned prior to fastening. The Metric Huck-Fit® fasteners are also removable, using an impact wrench.



Flanged Hex Head Pin MHFF

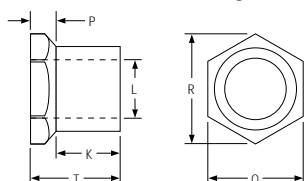


Flanged Hex Head Stump Type Pin MHFFS



| Diameter | A | B max | C max | D ref | E max | F ref | G min | H min |
|----------|---------------|-------|-------|-------|-------|-------|-------|-------|
| 12mm | 11,73 – 12,00 | 11,9 | 15 | 16,3 | 24,7 | 32,6 | 38,2 | 82,6 |
| 16mm | 15,73 – 16,00 | 15,1 | 21 | 22,9 | 32,8 | 40,1 | 44,5 | 95,2 |
| 20mm | 19,67 – 20,00 | 17,7 | 30 | 32,7 | 43,0 | 45,4 | 55,5 | 111,4 |

Collar Dimensions Hex Flange Collar MHCH / MHBH



| Diameter | Dia No | K ± 0,4 | L ± 0,1 | P ref | Q max | R ref | T ± 0,4 |
|----------|--------|---------|---------|-------|-------|-------|---------|
| 12mm | 12 | 15,6 | 12,3 | 7,1 | 21,6 | 23,1 | 22,6 |
| 16mm | 16 | 20,1 | 16,5 | 8,9 | 29,6 | 31,9 | 28,6 |
| 20mm | 20 | 24,0 | 20,3 | 10,7 | 34,3 | 37,9 | 34,3 |

Grip Data

| Grip Number | Range (mm) min-max |
|-------------|-----------------------|
| 10 | 5 - 15 |
| 15 | 10 - 20 |
| 20 | 15 - 25 |
| 25 | 20 - 30 |
| 30 | 25 - 35 |
| 35 | 30 - 40 |
| 40 | 35 - 45 |
| 45 | 40 - 50 |
| 50 | 45 - 55 |
| 55 | 50 - 60 |
| 60 | 55 - 65 |
| 65 | 60 - 70 |
| 70 | 65 - 75 |
| 75 | 70 - 80 |
| 80 | 75 - 85 |
| 85 | 80 - 90 |
| 90 | 85 - 95 |

Hole Data

| Diameter | Maximum Hole Diameter |
|----------|-----------------------|
| 12mm | 13,5 |
| 16mm | 17,5 |
| 20mm | 22,0 |

Minimum Installed Values kN

| Diameter | Shear | Tensile | Clamp |
|----------|-------|---------|-------|
| 12mm | 70 | 92 | 65 |
| 16mm | 126 | 163 | 116 |
| 20mm | 197 | 254 | 181 |

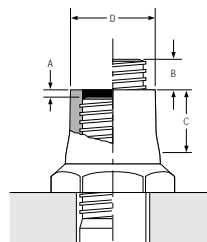
Minimum values, in kilonewtons, of installed fasteners ISO 898 Grade 10.9 high strength bolts. 1kN = 102 kgf or 225 lbf.

Inspection Data

Should 'A' or 'B' dimensions exceed the given values, the fastener is out-of-grip. A 'C' dimension less than the given value indicates an incomplete swage. A 'D' dimension greater than the given values indicates an incorrect or worn anvil on the installation tool.

| Dia | A max | B max | C min | D max |
|------|-------|-------|-------|-------|
| 12mm | .60 | 10.6 | 14.0 | 18.3 |
| 16mm | .60 | 10.6 | 17.7 | 24.1 |
| 20mm | .60 | 10.6 | 21.2 | 30.3 |

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



Installation Tooling

| Dia. | Installation Tool | Nose Assembly | Type | Use |
|------|-------------------|-----------------|-----------|------------|
| 12mm | 5901 | 99-5404 99-5406 | Hydraulic | Production |
| 16mm | 586 | 99-5300 | Hydraulic | Production |
| 20mm | 507 | 99-5414 | Hydraulic | Production |

Part Number Identification

Metric Huck-Fit Pins

Follow the form below to construct a part number for ordering Metric Huck-Fit pins. Refer to the Grip Data chart for grip numbers.

MHF (STYLE)(TYPE) - (MATERIAL) (DIAMETER) - (GRIP NUMBER)(FINISH)

Example: **MHFF-DT16-20** is a Metric Huck-Fit Pin, Flanged Head, Pull Type, Alloy Steel, 16mm Diameter, Grip 20, Black Standard Finish

| Style | Type | Material | Diameter | Finish |
|-----------------------|----------------|-------------|----------------|------------------|
| Hex Head - | Pull - | Alloy Steel | 12mm 12 | Black Standard - |
| Flanged Head F | Stump S | | 16mm 16 | Zinc G |
| | | | 20mm 20 | |

Metric Huck-Fit Collars

Follow the form below to construct a part number for ordering Metric Huck-Fit collars.

MH (STYLE) - (MATERIAL) (DIAMETER) (FINISH) (OPTIONS)

Example: **MHCH-R16U** is a Metric Huck-Fit Collar, Threaded, Hex Flange, Steel, 16mm Diameter, Zinc Gold Chromate

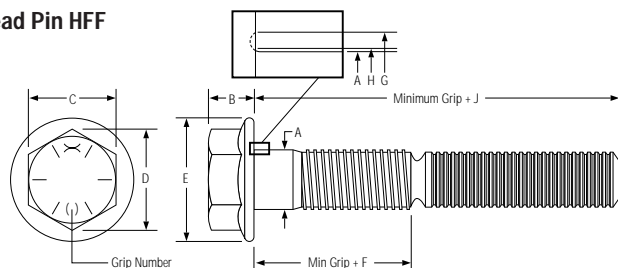
| Style | Material | Diameter | Finishes | Options |
|---|----------------|----------------|-----------------------------|-----------------------------------|
| Thread, hex flange CH | Steel R | 12mm 12 | Zinc Gold Chromate U | Tab-Lok for MHBH collars L |
| No thread, hex flange BH | | 16mm 16 | Primer R | |
| No thread, Round flange, tamper resistant BF | | 20mm 20 | | |

Huck-Fit® PowerBolt™

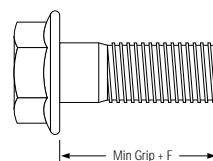
Designed for both OEM and aftermarket applications, the Huck-Fit® PowerBolt™ fastening system includes a pin and collar with fit-up thread. This feature allows the Huck-Fit® to be accurately positioned prior to fastening. Huck-Fit® fasteners are also removable, using an impact wrench.



Flanged Hex Head Pin HFF

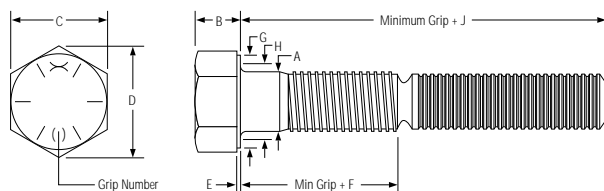


Flanged Hex Head HFFS

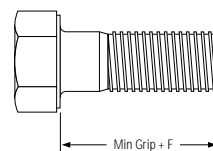


| Diameter | Dia No | A | B max | C max | D min | E max | F ± .020 | G max | H max | J min |
|----------|--------|-------------|-------|-------|-------|-------|----------|-------|-------|-------|
| 1/2 | 16 | .485 - .500 | .498 | .750 | .842 | 1.070 | 1.375 | .627 | .538 | 3.335 |
| 5/8 | 20 | .610 - .625 | .611 | .937 | 1.058 | 1.330 | 1.570 | .791 | .673 | 3.788 |
| 3/4 | 24 | .735 - .750 | .711 | 1.125 | 1.264 | 1.585 | 1.750 | .940 | .808 | 4.390 |

Hex Head Pin HF

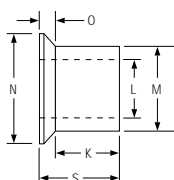


Hex Head HFS

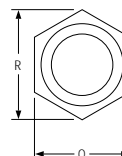
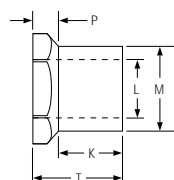


| Diameter | Dia No | A | B max | C max | D min | E max | F ± .01 | G max | H max | J min |
|----------|--------|-------------|-------|-------|-------|-------|---------|-------|-------|-------|
| 1/2 | 16 | .485 - .500 | .323 | .875 | .986 | .015 | 1.375 | .825 | .538 | 3.335 |
| 5/8 | 20 | .610 - .625 | .403 | 1.062 | 1.202 | .015 | 1.570 | 1.002 | .673 | 3.788 |
| 3/4 | 24 | .735 - .750 | .483 | 1.250 | 1.408 | .015 | 1.750 | 1.176 | .808 | 4.390 |

Collar Dimensions Round Flange



Hex Flange



| Diameter | Dia No | K ± .015 | L ± .003 | M ± .003 | N max | O ref | P ref | Q ± .005 | R ref | S ± .015 | T ± .015 |
|----------|--------|----------|----------|----------|-------|-------|-------|----------|-------|----------|----------|
| 1/2 | 16 | .630 | .522 | .812 | 1.085 | .125 | .250 | .914 | 1.061 | .750 | .875 |
| 5/8 | 20 | .790 | .648 | 1.009 | 1.358 | .137 | .285 | 1.098 | 1.274 | .922 | 1.070 |
| 3/4 | 24 | .925 | .783 | 1.213 | 1.600 | .187 | .330 | 1.280 | 1.484 | 1.107 | 1.250 |

Grip Data

| Grip Number | Range | |
|-------------|-------|------|
| | min | max |
| 4 | .25 | .50 |
| 8 | .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 |

Hole Data

| Diameter | Recommended Hole Diameter |
|----------|---------------------------|
| 1/2 | .500 - .562 |
| 5/8 | .625 - .687 |
| 3/4 | .750 - .812 |

For hole diameters smaller than H dimension (see drawings) the hole may have to be chamfered for proper head seating.

Minimum Installed Values for Grade 8 (A490)

| Diameter | Shear | Tensile | Clamp |
|----------|-------|---------|-------|
| 1/2 | 17350 | 21300 | 16000 |
| 5/8 | 27450 | 33900 | 25500 |
| 3/4 | 39850 | 50100 | 37600 |

Minimum values, in pounds, of installed fasteners

Installation Tooling

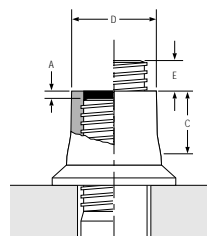
| Dia. | Installation Tool | Nose Assembly | Type | Use |
|------|-------------------|---------------|-----------|------------|
| 1/2 | 5901 | 99-5404 | Hydraulic | Production |
| 5/8 | 507 | 99-5414 | Hydraulic | Production |
| 3/4 | 585 | 99-5303 | Hydraulic | Production |
| | 586 | 99-5303 | Hydraulic | Production |

Inspection Data

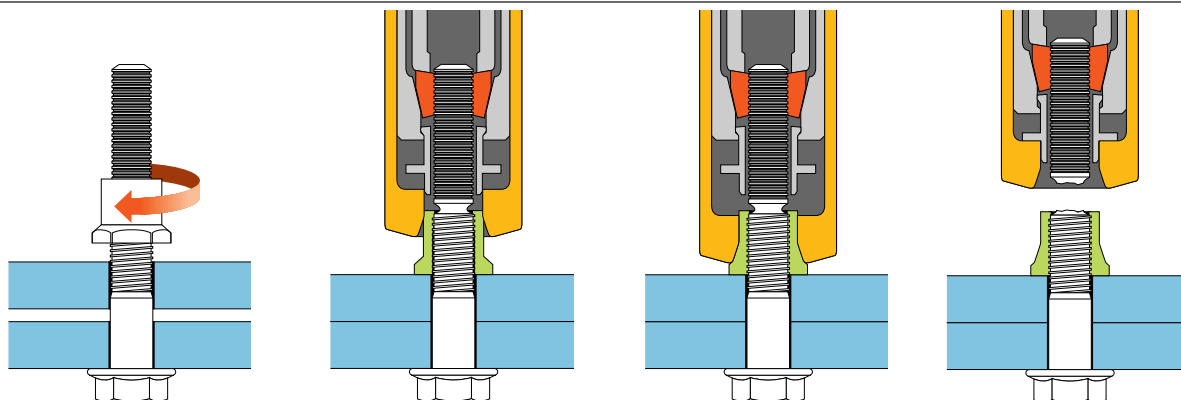
Should 'A' or 'B' or 'E' dimensions exceed the given values, the fastener is out-of-grip. A 'C' dimension less than the given value indicates an incomplete swage. A 'D' dimension greater than the given values indicates an incorrect or worn anvil on the installation tool.

| Dia | A max | B max | C min | D max | E max |
|-----|-------|-------|-------|-------|-------|
| 1/2 | .03 | .53 | .56 | .760 | .65 |
| 5/8 | .03 | .53 | .73 | .945 | .67 |
| 3/4 | .03 | .53 | .86 | 1.132 | .67 |

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



Installation Sequence



[Click Here to view animation of installation sequence](#)

Part Number Identification

Huck-Fit Pins

Follow the form below to construct a part number for ordering Huck-Fit pins. Refer to the Grip Data chart for grip numbers.

HF (STYLE)(TYPE) - (MATERIAL) (DIAMETER) - (GRIP NUMBER)(FINISH)

Example: **HFF-DT16-20** is a Huck-Fit Pin, Flanged Head, Pull Type, Alloy Steel, 1/2" Diameter, Grip 20, Black Standard Finish

| Style | Type | Material | Diameter | Finish | | | |
|--------------|---------|---------------|----------|--------|----|--------------------|---|
| Hex Head | - Pull | - Alloy Steel | DT | 1/2 | 16 | Bare Finish | - |
| Flanged Head | F Stump | S | | 5/8 | 20 | Zinc | G |
| | | | | 3/4 | 24 | Zinc/Gold Chromate | U |

Huck-Fit Collars

Follow the form below to construct a part number for ordering Huck-Fit collars.

H (STYLE) - (MATERIAL) (DIAMETER) (FINISH) (OPTIONS)

Example: **HCH-R16U** is a Huck-Fit Collar, Threaded, Hex Flange, Steel, 1/2" Diameter, Zinc Gold Chromate Finish

| Style | Material | Diameter | Finishes | Options | | | | | |
|---|----------|----------|----------|---------|----|--------------------|---|------------------------|---|
| Thread, hex flange | CH | Steel | R | 1/2 | 16 | Zinc Gold Chromate | U | Tab-Lok for HB collars | L |
| No thread, hex flange | BH | | | 5/8 | 20 | | | | |
| No thread, Round flange, tamper resistant | BF | | | 3/4 | 24 | | | | |

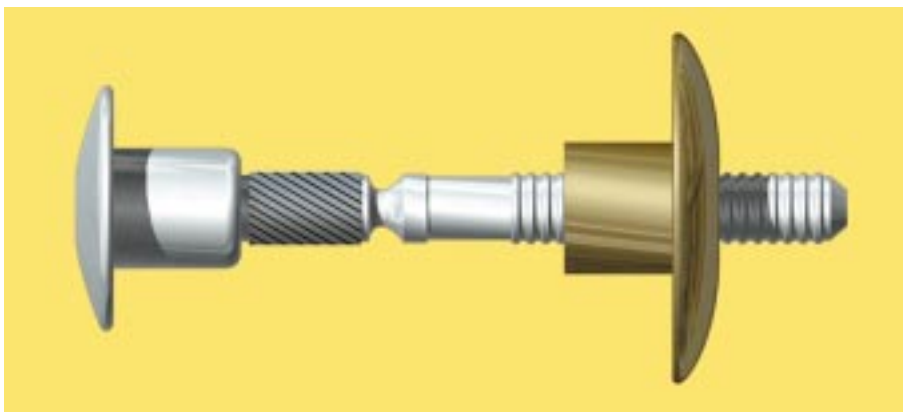
HUCK *Specialty* FASTENERS

Huck's line of specialty fasteners are designed to meet a specific use, offering features that make them uniquely suited to their intended applications.

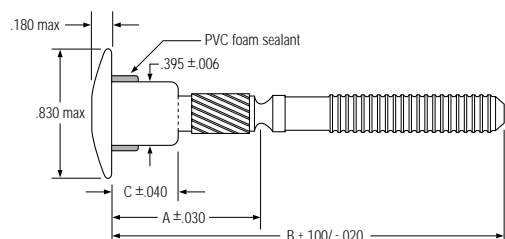
- Hucktainer[®]** Two-piece locking fastener for fiberglass reinforced plywood FRP applications
- FloorTight[®]** Blind fastener for plywood or plymetal flooring applications
- RamBolt[™]** Two-piece, retighten-able lockbolt, for track crossings and frogs
- Ultra-Twist[™]** Metric, multiple-piece blind bolt, for joining tubular steel sections

Hucktainer® Specialty Fastener

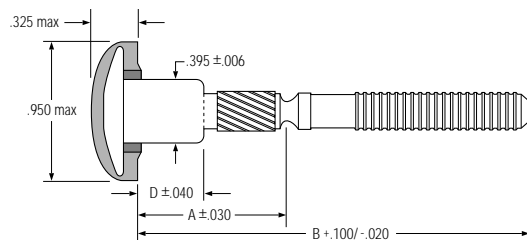
The Hucktainer® fastener is designed to meet the special needs of FRP fabrication. These fasteners install with a consistent pressure that reduces the potential for crushing or crazing FRP panels.



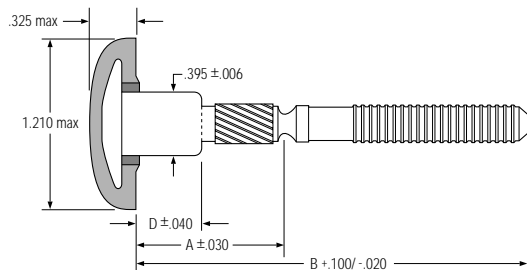
Specifications—Standard Grip



Standard low profile head HLPP-R12-()



Medium bearing encapsulate head HLPM(*)-R12-()

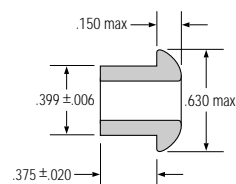


Wide bearing encapsulate head HLPE(*)-R12-()

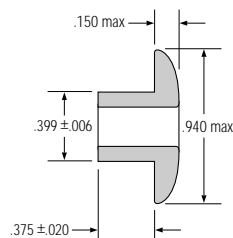
NOTE: Only wide bearing pin HLPE () and/or wide bearing sleeve HLPS should be used directly against FRP.
Consult factory for stock status—minimums may apply.
Contact your HUCK representative for head styles, grips, and configurations not shown.

| Grip Number | Grip Range | | Hole Size | A | B | C | D |
|-------------|------------|-------|-----------|-------|-------|------|------|
| | min | max | | | | | |
| -9 | .500 | .625 | .405-.421 | .562 | 2.170 | ** | .015 |
| -10 | .562 | .687 | .405-.421 | .624 | 2.232 | .090 | .015 |
| -11 | .625 | .750 | .405-.421 | .687 | 2.295 | .090 | .015 |
| -12 | .687 | .812 | .405-.421 | .749 | 2.357 | .220 | .145 |
| -13 | .750 | .875 | .405-.421 | .812 | 2.420 | .220 | .145 |
| -14 | .812 | .937 | .405-.421 | .874 | 2.482 | .345 | .270 |
| -15 | .875 | 1.000 | .405-.421 | .937 | 2.545 | .345 | .270 |
| -16 | .937 | 1.062 | .405-.421 | .999 | 2.607 | .470 | .395 |
| -17 | 1.000 | 1.125 | .405-.421 | 1.062 | 2.670 | .532 | .457 |
| -18 | 1.062 | 1.187 | .405-.421 | 1.124 | 2.732 | .595 | .520 |
| -19 | 1.125 | 1.250 | .405-.421 | 1.187 | 2.795 | .658 | .583 |
| -20 | 1.187 | 1.312 | .405-.421 | 1.249 | 2.857 | .720 | .645 |
| -21 | 1.250 | 1.375 | .405-.421 | 1.312 | 2.920 | .782 | .707 |
| -22 | 1.312 | 1.437 | .405-.421 | 1.374 | 2.982 | .782 | .707 |
| -23 | 1.375 | 1.500 | .405-.421 | 1.437 | 3.045 | .782 | .707 |
| -24 | 1.437 | 1.562 | .405-.421 | 1.499 | 3.107 | .782 | .707 |
| -25 | 1.500 | 1.625 | .405-.421 | 1.562 | 3.170 | .782 | .707 |
| -26 | 1.562 | 1.687 | .405-.421 | 1.625 | 2.232 | .782 | .707 |
| -27 | 1.625 | 1.750 | .405-.421 | 1.687 | 3.295 | .782 | .707 |
| -28 | 1.687 | 1.812 | .405-.421 | 1.750 | 3.357 | .782 | .707 |
| -29 | 1.750 | 1.875 | .405-.421 | 1.812 | 3.420 | .782 | .707 |
| -30 | 1.812 | 1.937 | .405-.421 | 1.875 | 3.482 | .782 | NA |

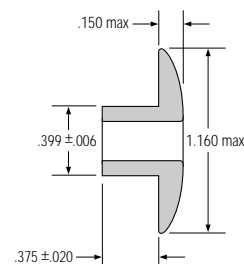
Clearance sleeve HLPSC-R12



Medium bearing sleeve HLPMS-R12



Clearance sleeve HLPSS-R12



* Add encapsulated color: W = white, G = gray, RY = Ryder yellow, HY = Hertz yellow. Consult HUCK for other colors.

** Available only in encapsulated configuration.

Installed Values in Nominal Grip (lbs.)

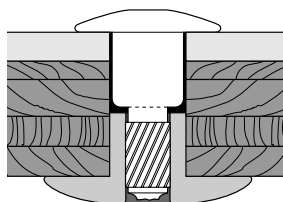
| | | | |
|---------|-------------|-----------------------|-----------------------|
| Tensile | 800 lbs min | 1200 lbs typ max grip | 1800 lbs typ min grip |
| Clamp | 700 lbs typ | | |

Material and Finish—Standard Grip

| | Material | Finish |
|--------|----------|----------------------------|
| Sleeve | Steel | Zinc Plated Gold Chromate |
| Pin | Steel | Zinc Plated Clear Chromate |

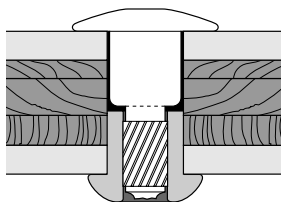
Installation Tooling

| Installation Tool | Nose Assembly | Type | Use |
|-------------------|---------------|-------------|----------------------|
| 230 | 99-3465 | Pneudraulic | Maintenance & Repair |
| 2025 | 99-3465 | Pneudraulic | Maintenance & Repair |
| 212 | 99-3464 | Pneudraulic | Production |
| 246 | 99-3438 | Pneudraulic | Production |
| 2480 | 99-3464 | Hydraulic | Production |
| 2580 | 99-3438 | Hydraulic | Production |

Recommended Installation Configurations

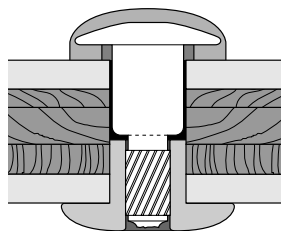
HLPP-R12(-)

HLPS-R12



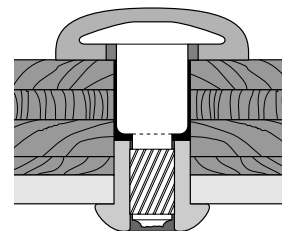
HLPP-R12(-)

HLPSC-R12





HLP M(-)R12(-)

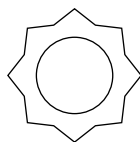
HLP S M-R12



HLP E(-)R12(-)

HLP S C-R12

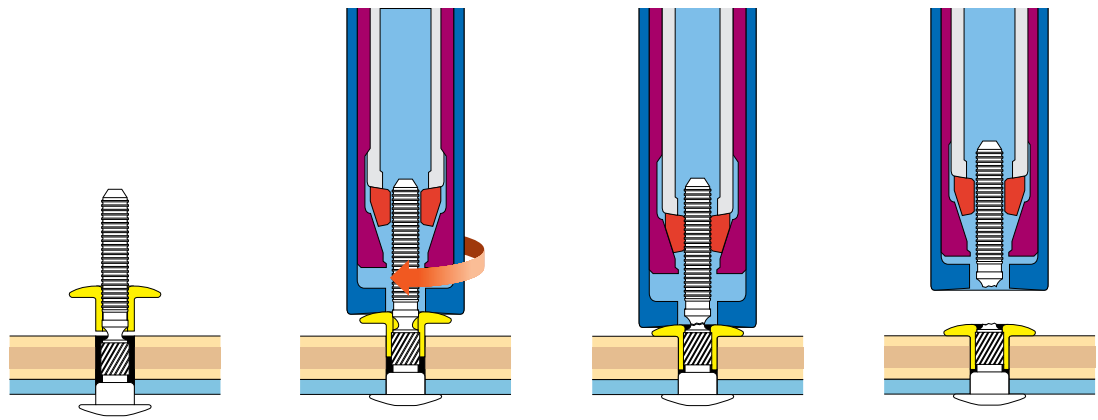
 FRP or other clamp sensitive material
 Aluminum, Steel, etc.

**Pin-Lock**

The Pin-Lock is an option that can be ordered by adding "PL" suffix to the pin part number. The Pin-Lock is a nylon "star" that retains the pin in the hole prior to installation.



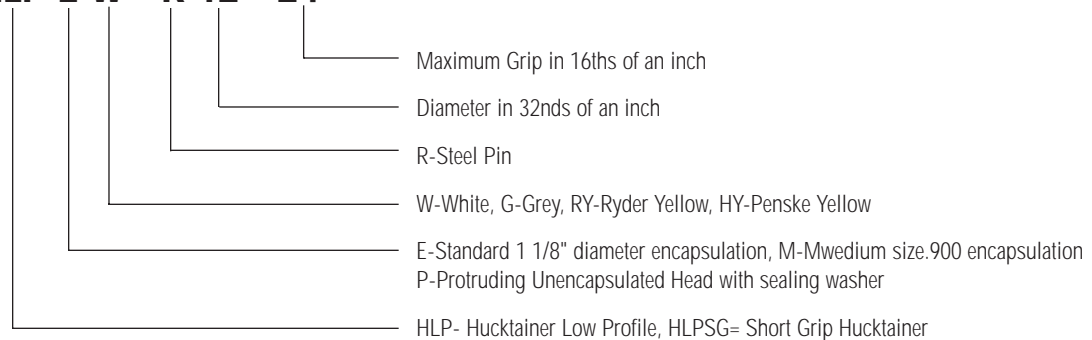
Installation Sequence



[Click Here to view animation of installation sequence](#)

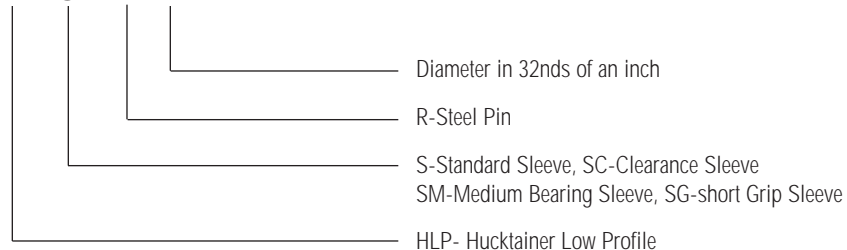
Part Number Identification - Pin

HLP E W - R 12 - 24



Part Number Identification - Sleeve

HLP S - R 12

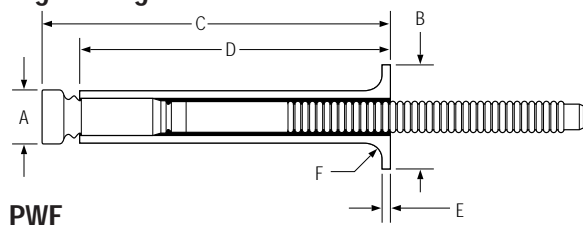


FloorTight® Specialty Fastener

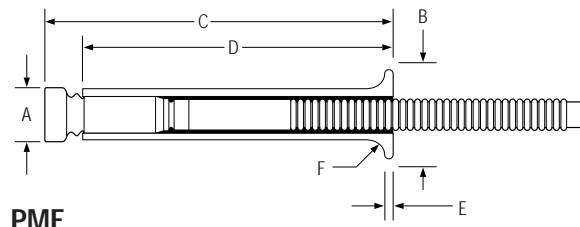
Designed for large vehicle flooring installations, FloorTight® fasteners eliminate the counterboring process in plywood and dimpling in plymetal. Because FloorTight® fasteners are locked on the blind side, they are also ideal for other plywood or plymetal applications.



Engineering Standards



PWF

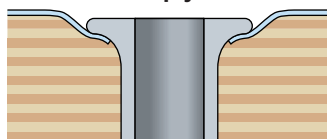


PMF

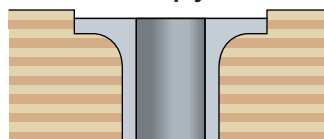
Fastener Dimensions

| Part No. | Grip range | A max | B nom | C max | D nom | E nom | F radius | Clamp |
|---------------|--------------|-------|-------|-------|-------|-------|----------|--------------------------|
| PMF-R10-20 | .750 - 1.375 | .325 | .560 | 2.125 | 1.750 | .050 | .125 | Standard |
| PMF-R10-26 | .750 - 1.625 | .325 | .560 | 2.500 | 2.125 | .050 | .125 | Standard |
| PWF-R10-20 | .750 - 1.375 | .325 | .675 | 2.125 | 1.750 | .050 | .125 | Standard |
| PWF-R10-26 | .750 - 1.625 | .325 | .675 | 2.500 | 2.125 | .050 | .125 | Standard |
| PWFMC-R10-20 | .750 - 1.375 | .325 | .675 | 2.125 | 1.750 | .050 | .125 | Medium |
| PWFWLC-R10-20 | .750 - 1.375 | .325 | .850 | 2.125 | 1.750 | .050 | .125 | Low Clamp Wide Flange |

Installation in plymetal – PMF



Installation in plywood – PWF



Typical Installed Values in Nominal Grip*

| Shear | Tensile | Pin Retention |
|-------|---------|---------------|
| 4300 | 3000 | 500 |

*With pin in shear plane

Hole Preparation Data

| Minimum | Maximum | Recommended |
|---------|---------|----------------|
| .328 | .339 | .332 (Q drill) |

Material, Finish and Lubrication

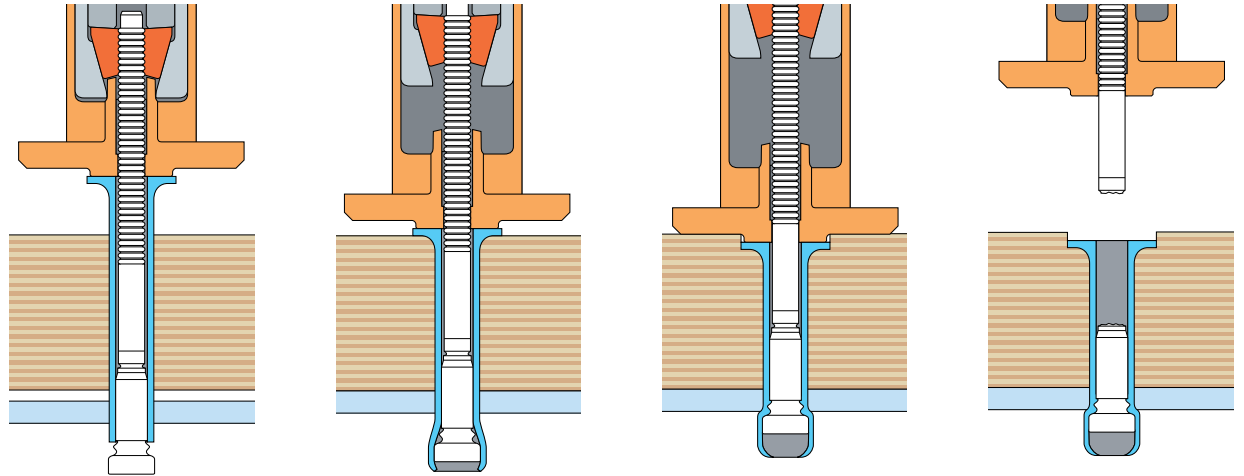
| | Material | Finish | Lubrication |
|--------|----------|--------------------------------------|-------------|
| Sleeve | Steel | Zinc electroplate with gold chromate | Dry film |
| Pin | Steel | Black | Wax film |

NOTE: Stringer material must withstand force of fastener installation without pulling through (approx. 1/8" thick). Testing is performed in AB Grade - 7 ply - plywood. Fastener performance may vary depending on grade of plywood.

Installation Tooling

| Installation Tool | Nose Assembly | Type | Use |
|-------------------|---------------|-------------|--------------------------|
| 245 | 99-3452 | Pneudraulic | Production |
| 246 | 99-3452 | Pneudraulic | Production |
| 2580 | 99-3452 | Hydraulic | Prod. or Maint. & Repair |

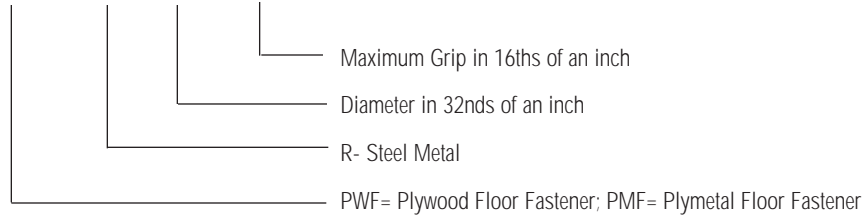
Installation Sequence



[Click Here to view animation of installation sequence](#)

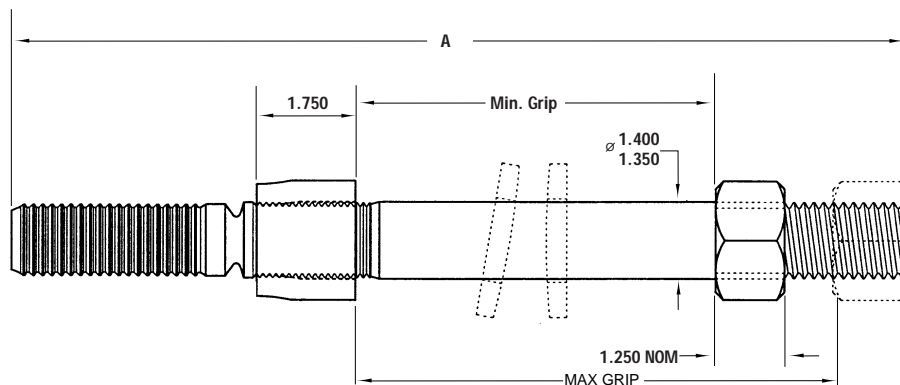
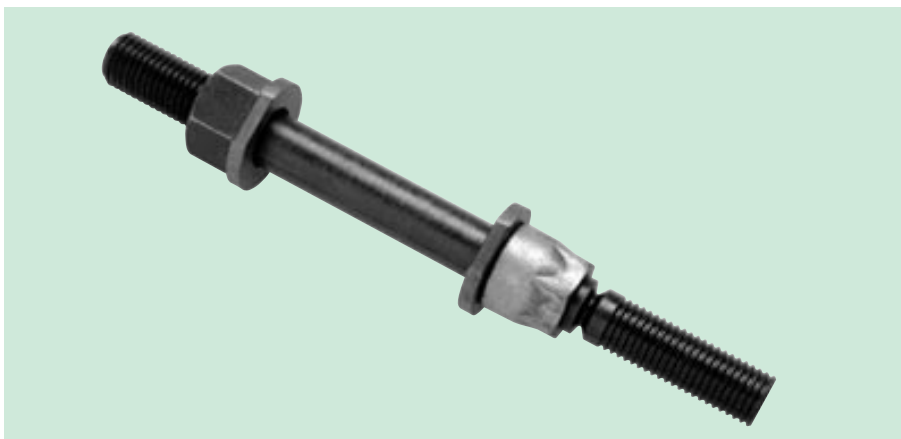
Part Number Identification

PWF - R - 10 - 20



RamBolt™ Track Crossing and Frog Fastener

Combining the best characteristics of conventional nuts and bolts with the permanent clamp of a HuckBolt®, the RamBolt™ sets the standard for joining rail crossings and frogs. The unique RamBolt™ is initially installed with a torque wrench, allowing it to be retightened during wear-in. After the joint has seated, a HuckBolt® collar is fully swaged on the RamBolt™, delivering a permanent, retained clamp of 85,000 lbs.



Grip Data

| Dia. | A | Grip Range |
|-------|--------|-------------|
| 1 3/8 | 17 1/8 | 6.50-8.50 |
| | 19 1/8 | 8.50-10.50 |
| | 21 1/8 | 10.50-12.50 |
| | 23 1/8 | 12.50-14.50 |
| | 25 1/8 | 14.50-16.50 |
| | 27 1/8 | 16.50-18.50 |
| | 29 1/8 | 18.50-20.50 |
| | 31 1/8 | 20.50-22.50 |
| | 33 1/8 | 22.50-24.50 |
| | 35 1/8 | 24.50-26.50 |

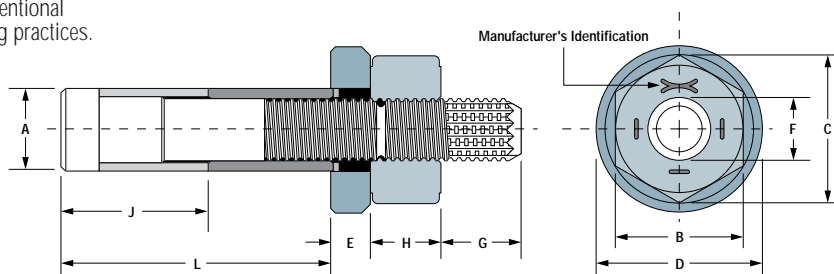
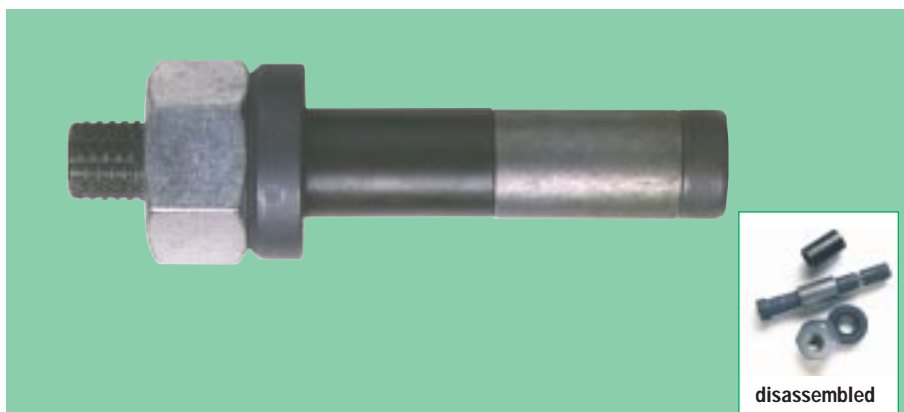
Installation Tooling

| Dia. | Installation Tool | Nose Assembly | Type |
|-------|-------------------|---------------|-----------|
| 1 3/8 | 12142 | Integral | Hydraulic |



Ultra-Twist™ Specialty Fastener

Precision multi-piece Ultra-Twist™ metric fasteners are the first structural blind bolts for joining tubular steel sections, whether column-to-beam or column-to-column. This advanced fastening system allows for simple, consistent installation throughout its entire 5 mm grip range. The Ultra-Twist™ meets stringent strength requirements and is easy to install, making it an attractive alternative for conventional welding and bolting practices.



Fastener Dimensions (millimeters)

| Ultra-Twist | A Body Diameter | | B Width Across Flats | | | C Width Across Corners | | D Washer Outside Dia. | |
|-------------|--------------------|------|-------------------------|------|------|---------------------------|------|--------------------------|------|
| | max | min | basic | max | min | max | min | max | min |
| 20 | 20.8 | 20.4 | 32.0 | 32.0 | 30.8 | 37.0 | 36.2 | 37.9 | 37.5 |
| 24 | 24.7 | 24.3 | 41.0 | 41.0 | 40.2 | 47.3 | 46.5 | 47.6 | 47.0 |
| 27 | 28.7 | 28.3 | 46.0 | 46.0 | 45.1 | 53.1 | 52.3 | 50.9 | 50.3 |

| Ultra-Twist | E Washer Thickness | | F Drive Spline Dia. reference | G Drive Spline Height reference | H Nut Height | | J Length reference |
|-------------|-----------------------|------|-------------------------------------|---------------------------------------|-----------------|------|--------------------------|
| | max | min | | | max | min | |
| 20 | 13.5 | 13.2 | 13.5 | 18.0 | 19.8 | 19.5 | 48.0 |
| 24 | 13.8 | 13.4 | 15.0 | 18.0 | 21.8 | 21.4 | 55.0 |
| 27 | 14.2 | 13.7 | 18.0 | 18.0 | 25.9 | 25.5 | 60.0 |

Grip Data

| Grip Dash Number | Grip Range (millimeters) | L Length ± 1 mm | | |
|---------------------|-----------------------------|-----------------|-------|-------|
| | | 20 mm | 24 mm | 27 mm |
| -20 | 15.0 - 20.0 | 62.9 | 69.1 | N/A |
| -25 | 20.0 - 25.0 | 67.9 | 74.1 | N/A |
| -30 | 25.0 - 30.0 | 72.9 | 79.1 | 82.9 |
| -35 | 30.0 - 35.0 | 77.9 | 84.1 | 87.9 |
| -40 | 35.0 - 40.0 | 82.9 | 89.1 | 92.9 |
| -45 | 40.0 - 45.0 | 87.9 | 94.1 | 97.9 |
| -50 | 45.0 - 50.0 | 92.9 | 99.1 | 102.9 |
| -55 | 50.0 - 55.0 | 97.9 | 104.1 | 107.9 |
| -60 | 55.0 - 60.0 | 102.9 | 109.1 | 112.9 |
| -65 | 60.0 - 65.0 | 107.9 | 114.1 | 117.9 |
| -70 | 65.0 - 70.0 | 112.9 | 119.1 | 122.9 |
| -75 | 70.0 - 75.0 | 117.9 | 124.1 | 127.9 |

Material, and Finish

| | Core Pin | Nut | Bearing Washer | Shear Washer | Grip Sleeve | Bulb Sleeve |
|----------|-------------|---------------------------|----------------|--------------|-------------|--------------|
| Material | Alloy Steel | Alloy Steel | Alloy Steel | Alloy Steel | Alloy Steel | Carbon Steel |
| Finish | * | Electro-Zinc ASTM B633 | * | None | None | None |

* Components are selectively lubed as needed for function, do not modify.

Mechanical Properties

| Ultra-Twist Size | Bolt Stress Area* mm ² | Minimum Clamp, kgf | Tensile Strength min, kgf | Shear Strength min, kgf |
|------------------|-----------------------------------|--------------------|---------------------------|-------------------------|
| 20 | 169.0 | 13100 | 19200 | 20800 |
| 24 | 235.0 | 17500 | 25700 | 29800 |
| 27 | 321.0 | 24600 | 36200 | 40300 |

* Based on 98% of thread pitch diameter

Installation Hole Sizes

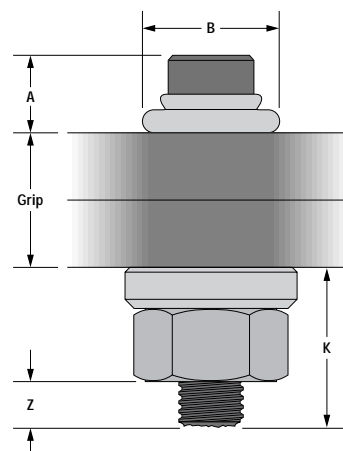
| Ultra-Twist Size | Recommended Drill Size (mm) | Hole Diameter (mm)* | |
|------------------|-----------------------------|---------------------|------|
| | | min | max |
| 24 | 21.5 | 20.9 | 21.6 |
| 28 | 26.0 | 24.8 | 26.1 |
| 32 | 30.0 | 28.8 | 30.1 |

* In drilling holes, care must be taken so that the back side is free of large burrs

Installed Fastener Dimensions

Ultra-Twist blind bolt is a "flagging" fastener meaning that upon completion of the installation, pin protrusion "Z" must be within designated limits listed in the table below. Generally, any protrusion outside of these limits is a sign of wrong grip thickness for the fastener. Installed bulb dimensions are also listed in order to establish backside joint clearances.

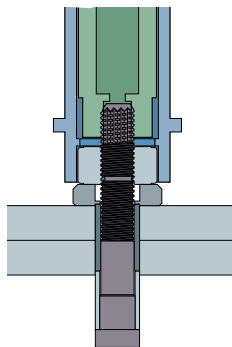
| Ultra-Twist | A ± .06 | B ± .03 | Z | K max |
|-------------|---------|---------|-------------|-------|
| 24 | .62 | 1.22 | .443 - .693 | 2.00 |
| 28 | .79 | 1.44 | .497 - .747 | 2.35 |
| 32 | .94 | 1.55 | .600 - .850 | 2.57 |



Installation Tooling (Electric)

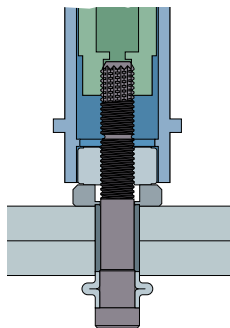
| Installation Tool | Ultra-Twist Sizes |
|-------------------|-------------------|
| S60EZ | 20mm |
| S90EZ | 24mm |
| S170EZ | 27mm |

Installation Sequence



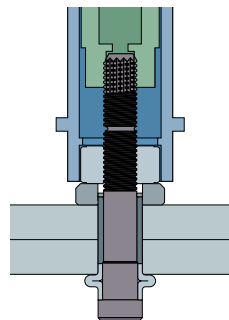
1

The ULTRA-TWIST blind bolt is installed from one side of the structure by a single operator. The installation tool is the standard electric shear wrench tooling used for installation of Twist-Off Control (T-C) type fasteners. The fastener is inserted and the tool engaged.



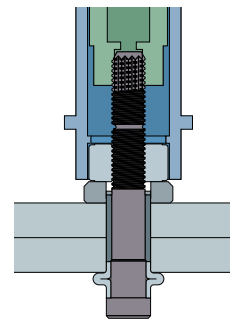
2

The backside bulb is fully formed in the air to a uniform diameter regardless of grip.



3

As the installation load increases, a special internal washer shears allowing the backside bulb to come into contact with the work surface and for all clamp load to go into the work structure.



4

Continued torquing of the unit develops the required clamp and the torque pintail shears off, completing the installation. Using a standard S60EZ shear wrench, installation time for a 20mm fastener is approximately 30 seconds.

Part Number Identification

Ultra-Twist

MUTF () - ()

*Metric
Ultra-Twist
Fastener*

*Diameter:
20 mm
24 mm
27 mm*

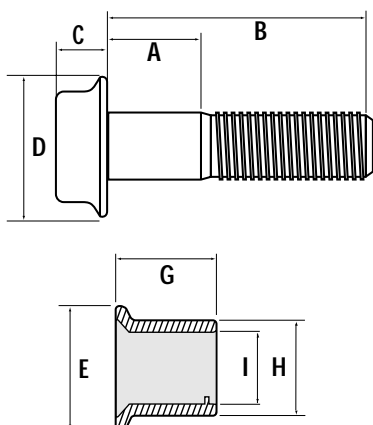
*Grip No.
Refer to
Grip Data
Chart*

HuckSpin®

This Grade 8 fastening system employs the world's most advanced lockbolt technology to produce a fail-proof joint. Huck-Spin® fastening systems are designed for consistent, reliable installation without the noise and waste associated with pintails. In addition to the round head design, a hex head style is also available which allows the Huck-Spin® to be removed with a standard impact wrench.



Round Head Inches



Fastener Dimensions

1/2" Round Head (DT16)

| | Grip No. | A | B |
|--------|----------|-------|-------|
| C=.397 | 4 | .250 | 1.715 |
| D=1.07 | 6 | .250 | 1.840 |
| E=.75 | 8 | .250 | 1.965 |
| G=.750 | 10 | .375 | 2.090 |
| H=.812 | 12 | .500 | 2.215 |
| I=.519 | 16 | .750 | 2.465 |
| | 20 | 1.000 | 2.715 |
| | 24 | 1.250 | 2.965 |
| | 28 | 1.500 | 3.215 |
| | 32 | 1.750 | 3.465 |
| | 36 | 2.000 | 3.715 |
| | 40 | 2.250 | 3.965 |
| | 44 | 2.500 | 4.215 |
| | 48 | 2.750 | 4.465 |
| | 52 | 3.000 | 4.715 |

5/8" Round Head (DT20)

| | Grip No. | A | B |
|---------|----------|-------|-------|
| C=.498 | 4 | .250 | 2.005 |
| D=1.33 | 6 | .250 | 2.130 |
| E=.94 | 8 | .250 | 2.255 |
| G=.972 | 10 | .375 | 2.380 |
| H=1.009 | 12 | .500 | 2.505 |
| I=.645 | 14 | .625 | 2.630 |
| | 16 | .750 | 2.755 |
| | 18 | .875 | 2.880 |
| | 20 | 1.000 | 3.005 |
| | 22 | 1.125 | 3.130 |
| | 24 | 1.250 | 3.255 |
| | 26 | 1.375 | 3.380 |
| | 28 | 1.500 | 3.505 |
| | 32 | 1.750 | 3.755 |
| | 36 | 2.000 | 4.005 |
| | 40 | 2.250 | 4.255 |
| | 44 | 2.500 | 4.505 |
| | 48 | 2.750 | 4.755 |
| | 52 | 3.000 | 5.000 |

3/4" Round Head (DT24)

| | Grip No. | A | B |
|---------|----------|-------|-------|
| C=.60 | 4 | .250 | 2.290 |
| D=1.59 | 6 | .250 | 2.415 |
| E=1.12 | 8 | .250 | 2.540 |
| G=1.107 | 12 | .500 | 2.790 |
| H=1.213 | 16 | .750 | 3.040 |
| I=.780 | 20 | 1.000 | 3.290 |
| | 24 | 1.250 | 3.540 |
| | 28 | 1.500 | 3.790 |
| | 32 | 1.750 | 4.040 |
| | 36 | 2.000 | 4.290 |
| | 40 | 2.250 | 4.540 |
| | 44 | 2.500 | 4.790 |
| | 48 | 2.750 | 5.040 |
| | 52 | 3.000 | 5.290 |

Grip Data

| Grip Number | Range (mm) min-max | Grip Number | Range (mm) min-max |
|-------------|--------------------|-------------|--------------------|
| 4 | .125 - .500 | 24 | 1.250 - 1.750 |
| 6 | .125 - .625 | 26 | 1.375 - 1.875 |
| 8 | .250 - 1.00 | 28 | 1.500 - 2.000 |
| 10 | .375 - .875 | 32 | 1.750 - 2.250 |
| 12 | .500 - 1.00 | 36 | 2.000 - 2.500 |
| 14 | .625 - 1.125 | 40 | 2.250 - 2.750 |
| 16 | .750 - 1.25 | 44 | 2.500 - 3.000 |
| 18 | .875 - 1.375 | 48 | 2.750 - 3.250 |
| 20 | 1.000 - 1.500 | 52 | 3.000 - 3.500 |
| 22 | 1.125 - 1.625 | 60 | 3.500 - 4.000 |

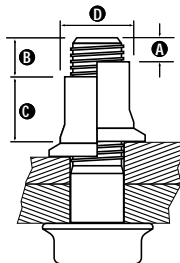
Installation Tooling

| Dia. | Installation Tool | Nose Assembly | Type | Use |
|------|-------------------|---------------|-----------|------------|
| 1/2 | HS52 | 99-7313-1 | Hydraulic | Production |
| 5/8 | HS52 | 99-7315-1 | Hydraulic | Production |
| 3/4 | HS52 | 99-7314-1 | Hydraulic | Production |

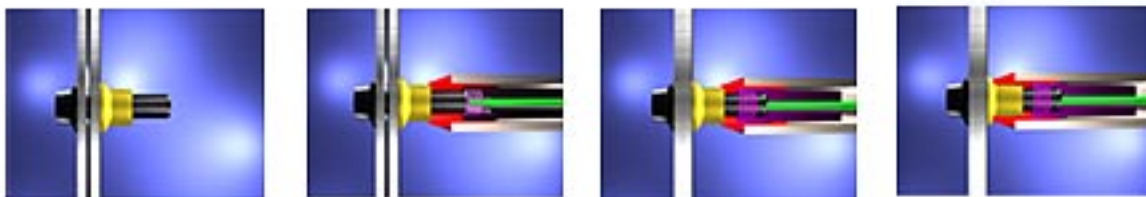
Inspection Data

ROUND HEAD INCH SERIES (")

| DIAMETER | A (Max) | B (Max) | C (Min) | D (Max) |
|----------|---------|---------|---------|---------|
| DT16 | .43 | .93 | .56 | .76 |
| DT20 | .54 | 1.04 | .73 | .945 |
| DT24 | .64 | 1.14 | .86 | 1.132 |



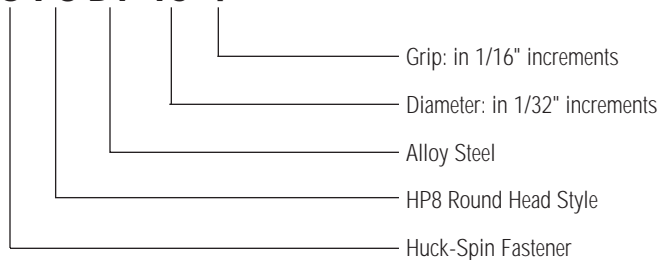
Installation Sequence



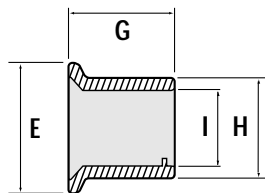
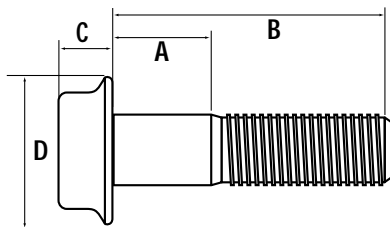
[Click Here to view animation of installation sequence](#)

Part Number Identification

HS P8 DT 16 4



Round Head Metric

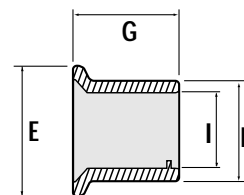
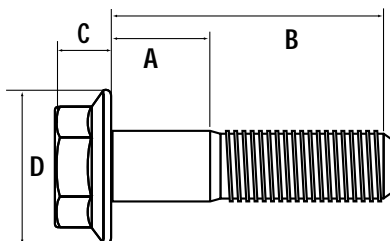


Fastener Dimensions

16mm Round Head (DT16)

| | Grip No. | A | B |
|---------|----------|------|--------|
| C=12.80 | 10 | 4.0 | 54.41 |
| D=24.10 | 15 | 9.0 | 59.41 |
| E=34.80 | 20 | 14.0 | 64.41 |
| G=23.40 | 25 | 19.0 | 69.41 |
| H=25.60 | 30 | 24.0 | 74.41 |
| I=16.46 | 35 | 29.0 | 79.41 |
| | 40 | 34.0 | 84.41 |
| | 45 | 39.0 | 89.41 |
| | 50 | 44.0 | 94.41 |
| | 55 | 49.0 | 99.41 |
| | 60 | 54.0 | 104.41 |
| | 65 | 59.0 | 109.41 |
| | 70 | 64.0 | 114.41 |

Hex Head Metric



16mm Hex Head (DT16)

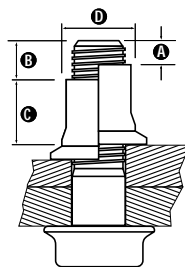
| | Grip No. | A | B |
|---------|----------|------|--------|
| C=15.10 | 10 | 4.0 | 59.54 |
| D=32.80 | 15 | 9.0 | 64.54 |
| E=21.00 | 17 | 10 | 67.54 |
| G=28.98 | 20 | 14.0 | 69.54 |
| H=26.00 | 25 | 19.0 | 74.54 |
| I=16.10 | 30 | 24.0 | 79.54 |
| | 35 | 29.0 | 84.54 |
| | 40 | 34.0 | 89.54 |
| | 45 | 39.0 | 94.54 |
| | 50 | 44.0 | 99.54 |
| | 55 | 49.0 | 104.54 |
| | 60 | 54.0 | 109.54 |
| | 65 | 59.0 | 114.54 |
| | 70 | 64.0 | 119.54 |

20mm Hex Head (DT20)

| | Grip No. | A | B |
|---------|----------|------|--------|
| C=17.70 | 15 | 9.0 | 73.68 |
| D=46.00 | 20 | 14.0 | 78.68 |
| E=30.00 | 25 | 19.0 | 83.68 |
| G=33.92 | 30 | 24.0 | 88.68 |
| H=32.00 | 35 | 29.0 | 93.68 |
| I=20.34 | 40 | 34.0 | 98.68 |
| | 45 | 39.0 | 103.68 |
| | 50 | 44.0 | 108.68 |
| | 55 | 49.0 | 113.68 |
| | 60 | 54.0 | 118.68 |

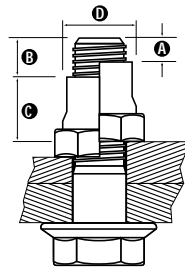
Inspection Data-ROUND HEAD METRIC (MM)

| NOMINAL DIA. | A (Max) | B (Max) | C (Min) | D (Max) |
|--------------|---------|---------|---------|---------|
| DT16 | 13.76 | 25.76 | 17.7 | 24.1 |



Inspection Data-HEX HEAD METRIC (MM)

| NOMINAL DIA. | A (Max) | B (Max) | C (Min) | D (Max) |
|--------------|---------|---------|---------|---------|
| DT16 | 17.2 | 25.76 | 17.7 | 24.1 |
| DT20 | 17.2 | 29.2 | 21.2 | 30.3 |



Grip Data

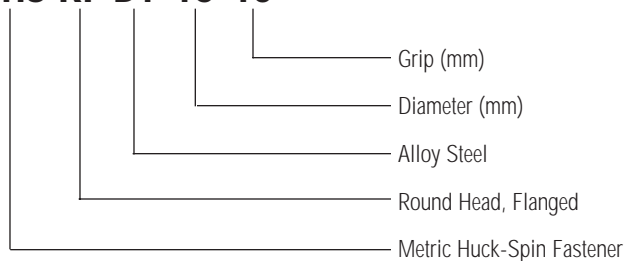
| Grip Number | Range (mm) min-max | Grip Number | Range (mm) min-max |
|-------------|--------------------|-------------|--------------------|
| 10 | 4 - 6 | 40 | 34 - 46 |
| 15 | 9 - 21 | 45 | 39 - 51 |
| 17 | 10 - 24 | 50 | 44 - 56 |
| 20 | 14 - 26 | 55 | 49 - 61 |
| 25 | 19 - 31 | 60 | 54 - 66 |
| 30 | 24 - 36 | 65 | 59 - 71 |
| 35 | 29 - 41 | 70 | 64 - 76 |

Installation Tooling

| Dia. | Installation Tool | Nose Assembly | Type | Use |
|------|-------------------|---------------|-----------|------------|
| 12mm | HS37 | 99-7412-1 | Hydraulic | Production |
| 14mm | HS52 | 99-7415-1 | Hydraulic | Production |
| 16mm | HS52 | 99-7315-1 | Hydraulic | Production |
| 20mm | HS52 | 99-7418-1 | Hydraulic | Production |

Part Number Identification

MHS RF DT 16 10





Designed to install Grip-Rite™ and Auto-Clamp™ SureSet™ Rivets, as well as LockBolt™ fasteners, these pneudraulically powered tools offer both a lightweight, easy-to-use design and proven durability.

SureSet™ 229 Economy priced tool for maintenance and repair. Use with 3/32" to 1/4" diameter fasteners.

SureSet™ 230 Lightweight tool designed for higher volume maintenance and repair. Use with 3/32" to 1/4" diameter fasteners.

SureSet™ 229

Pneudraulic Installation Tool

Specifications

Weight:

4.75 lbs.

Required Air Pressure:

90-100 psi

Air Consumption:

6 CFM based on

30 fastener installations/minute

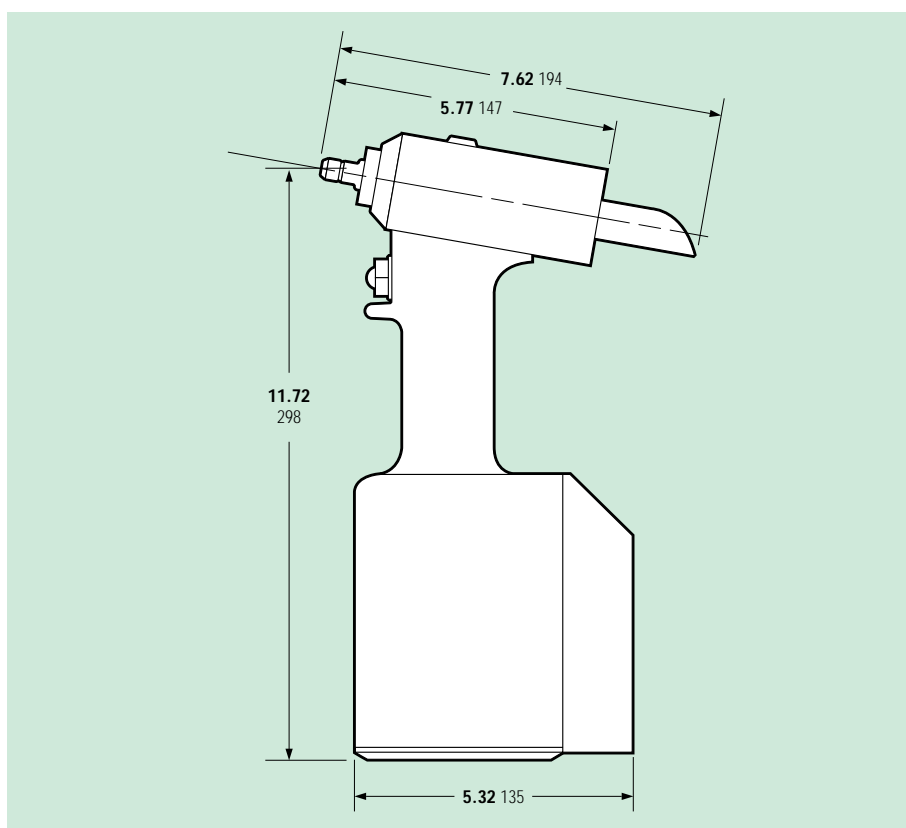
Hydraulic Fluid:

Automatic Transmission Fluid

DEXTRON II® or equivalent

Stroke:

.750 in.



Compatible Fastener

| Type | Diameter | Nose Assembly | |
|------------|----------|---------------|------------------------------|
| MAGNA-LOK | 3/16 | 99-3300 | |
| | | 99-3316-68 | |
| | 1/4 | 99-3301 | |
| | | 99-3316-68 | |
| MAGNA-BULB | 3/16 | 99-3300 | |
| | | 99-3301 | |
| | 3/32 | 99-3422-34 | 99-3422-3456 99-3423-3456 |
| | | 1/8 | 99-3422-34 |
| | 5/32 | 99-3422-3456 | 99-3422-56 |
| | | 99-3423-3456 | 99-3423-56 |
| | 3/16 | 99-3422-3456 | 99-3422-56 |
| | | 99-3423-3456 | 99-3423-56 |
| | 1/4 | 99-3445-68 | 99-3446-68 |
| | | 99-3445-68 | 99-3446-68 |
| A-LOCK | 3/16 | 99-3422-3456 | 99-3422-56 |
| | | 99-3423-3456 | 99-3423-56 |
| | | 99-3445-68 | 99-3446-68 |
| PEEL | 3/16 | 99-3460 | 99-3461 |
| | | 1/4 | 99-3462 |
| STRONGHOLD | 1/8 | 99-3422-34 | 99-3422-3456 99-3423-3456 |
| | | 5/32 | 99-3422-3456 |
| | 3/16 | 99-3423-3456 | 99-3423-56 |
| | | 99-3445-68 | 99-3446-68 |
| | 1/4 | 99-3445-68 | 99-3446-68 |



| Type | Diameter | Nose Assembly | |
|------------|----------|---------------|------------|
| AUTO-CLAMP | 3/16 | 99-3422-3456 | 99-3422-56 |
| | | 99-3423-3456 | 99-3423-56 |
| | | 99-3445-68 | 99-3446-68 |
| | 1/4 | 99-3445-68 | 99-3446-68 |

SureSet™ 230

Pneudraulic Installation Tool

Specifications

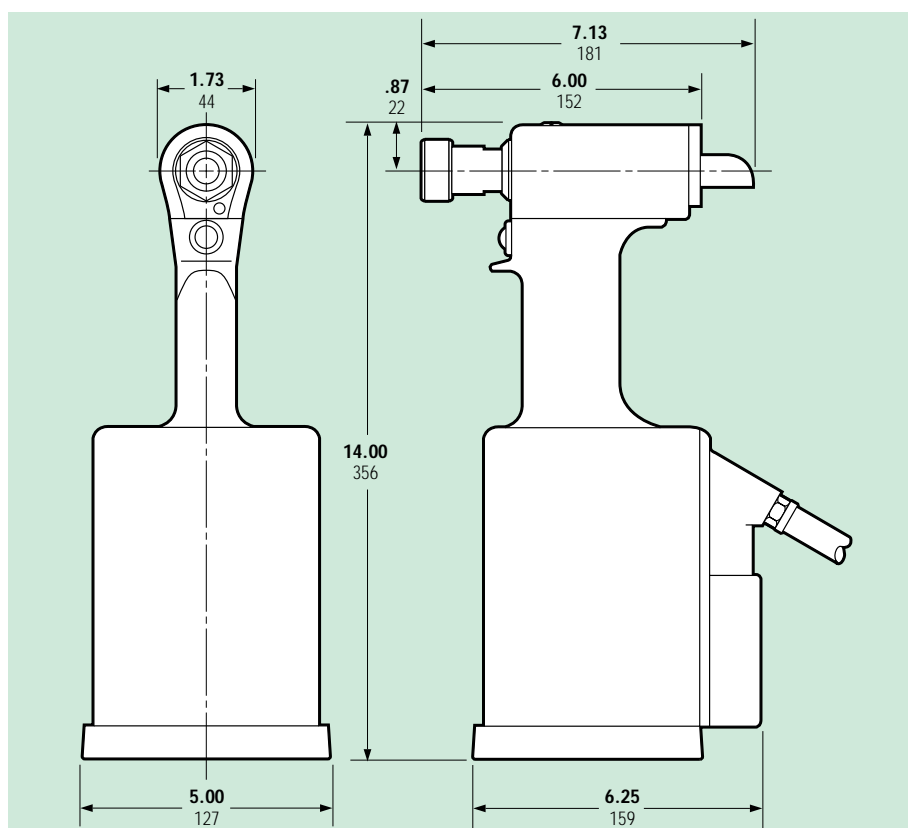
Weight:
4.80 lbs.

Required Air Pressure:
90-100 psi

Air Consumption:
3.9 CFM based on 18-20
fastener installations/minute

Hydraulic Fluid:
Automatic Transmission Fluid
DEXTRON II® or equivalent

Stroke:
1.00 in.



Compatible Fastener

| Type | Diameter | Nose Assembly |
|------------|----------|---------------|
| BOM | 3/16 | 99-994 |
| MAGNA-LOK | 3/16 | 99-3300 |
| | | 99-3316-68 |
| | 1/4 | 99-3301 |
| | | 99-3316-68 |
| MAGNA-BULB | 3/16 | 99-3300 |
| | | 1/4 |
| AUTO-BULB | 3/16 | 99-3305 |
| | | 1/4 |
| MAGNA-GRIP | 3/16 | 99-3201 |
| | | 1/4 |
| HUCKTAINER | -12 | 99-3465 |
| C6L/120L | 3/16 | 99-999 |
| | | 1/4 |



The SureSet™ 230 is a lightweight, high speed production tool. The design incorporates a one piece, high impact polymer handle and cylinder. The in-line piston extends the life of the cylinder and seals, and a pull piston wiper prevents damage from abrasive particles.



HUCK LockSet™ pneudraulic tools are proven in both production and maintenance/repair applications, designed to reliably install Peel, A-Lock, StrongHold™ and Magna-Tite™ LockRivets™.

LockSet™ 2015 Lightweight, high speed tool for maintenance and production work. Use with 3/32" to 1/4" diameter fasteners.

LockSet™ 202 A lightweight tool for high volume maintenance and production applications. Use with 3/32" to 1/4" diameter fasteners.

LockSet 2015

Pneudraulic Installation Tool

Specifications

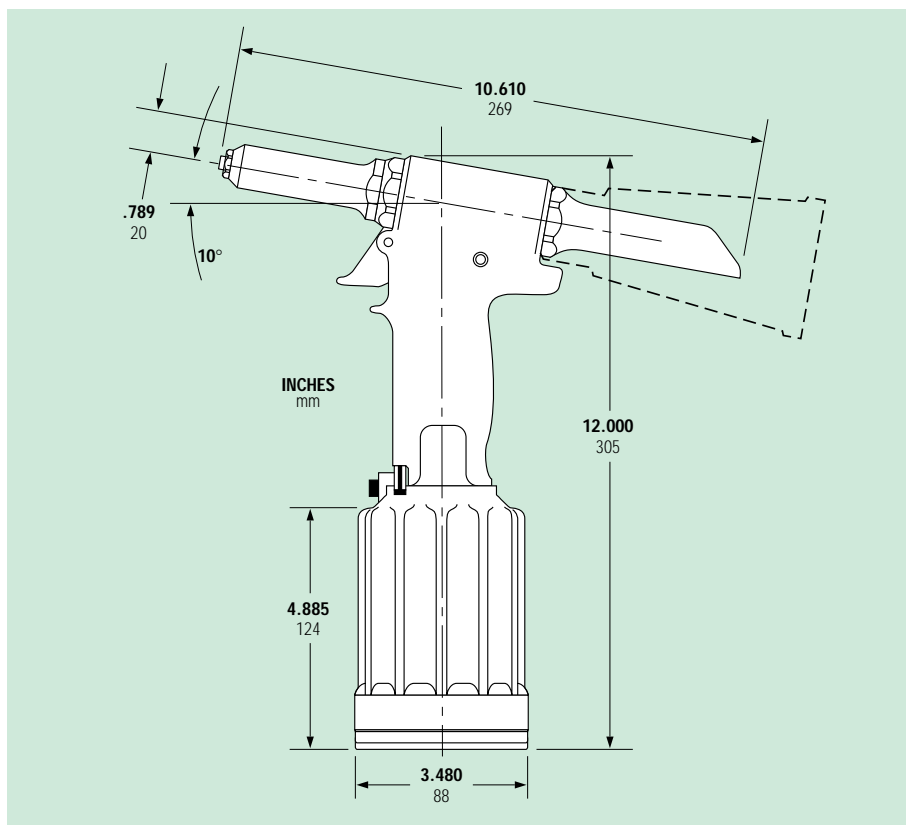
Weight:
5.6 lbs.

Required Air Pressure:
90-100 psi

Air Consumption:
6 CFM based on
30 fastener installations/minute

Hydraulic Fluid:
Automatic Transmission Fluid
DEXTRON II[®] or equivalent

Stroke:
.683 in.



Compatible Fastener

| Type | Diameter | Insert |
|------------|----------|----------|
| A-LOCK | 3/16 | 125154 |
| AUTO-CLAMP | 3/16 | 125154 |
| MAGNA-LOK | 3/16 | 125154 |
| MAGNA-BULB | 3/16 | 125154 |
| AUTO-BULB | 3/16 | 125154 |
| MAGNA-TITE | 3/16 | 125280** |
| | 1/4 | 125280** |
| GRIP-RITE | 3/32 | 125151 |
| | 1/8 | 125152 |
| | 5/32 | 125153 |
| | 3/16 | 125154 |
| STRONGHOLD | 1/8 | 125152 |
| | 5/32 | 125153 |
| | 3/16 | 125154 |
| PEEL | 3/16 | 125283 |
| | 1/4 | 125284 |

Nose Inserts **125154** & **125155** are furnished with tool. All others are available as options.

* Countersunk 125154

** Button Head 125281

*** Flat Head 125154



The LockSet 2015 is a lightweight, high speed production tool designed to install 1/4 and smaller blind fastener.

LockSet 202

Pneudraulic Installation Tool

Specifications

Weight:

5.1 lbs.

Required Air Pressure:

90-110 psi

Air Consumption:

6 CFM based on
30 fastener installations/minute

Hydraulic Fluid:

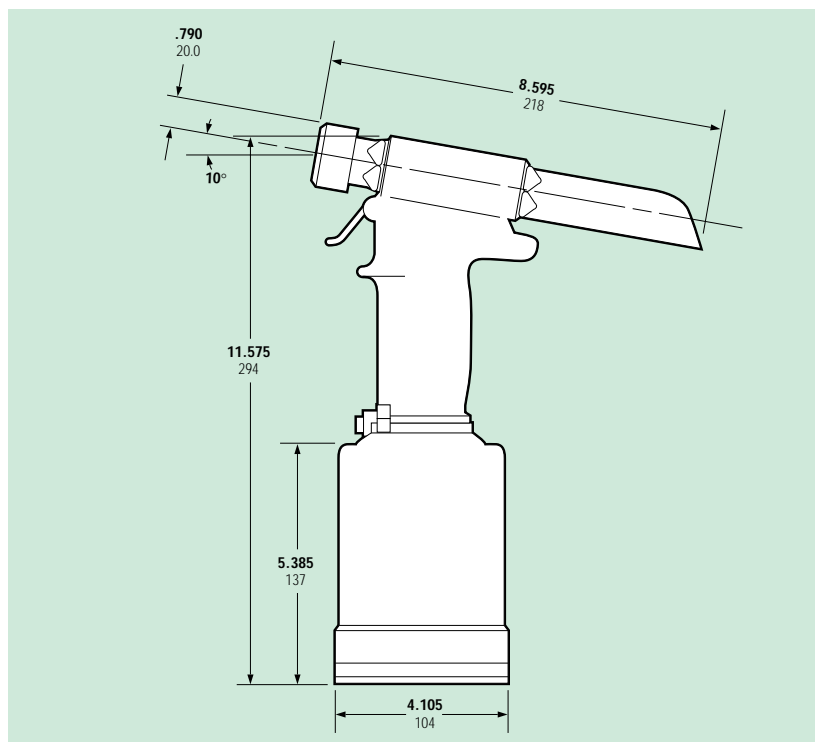
Automatic Transmission Fluid
DEXTRON II® or equivalent

Stroke:

.750 in.

Options:

202B-Bottle Mandrel
Collection System
202V-Vacuum Mandrel
Collection System



Compatible Fastener

| Type | Diameter | Nose Assembly | |
|------------|------------|---------------|------------------------------|
| MAGNA-LOK | 3/16 | 99-3303 | 99-3316-68 |
| | 1/4 | 99-3301 | 99-3316-68 |
| MAGNA-TITE | 3/16 | 99-3310F/P | |
| | 1/4 | 99-3311F/P | 99-3312F/P |
| MAGNA-BULB | 3/16 | 99-3303 | |
| | 1/4 | 99-3301 | |
| AUTO-BULB | 3/16 | 99-3303 | |
| | 1/4 | 99-3303 | |
| GRIP-RITE | 3/32 | 99-3422-34 | 99-3422-3456 99-3423-3456 |
| | | 99-3422-34 | 99-3422-3456 99-3423-3456 |
| | 5/32 | 99-3422-3456 | 99-3422-56 |
| | | 99-3423-3456 | 99-3423-56 |
| | 3/16 | 99-3422-3456 | 99-3422-56 |
| | | 99-3423-3456 | 99-3423-56 |
| 1/4 | 99-3445-68 | 99-3446-68 | |
| A-LOCK | 3/16 | 99-3422-3456 | 99-3422-56 |
| | | 99-3423-3456 | 99-3423-56 |
| | | 99-3445-68 | 99-3446-68 |
| PEEL | 3/16 | 99-3460 | 99-3461 |
| | 1/4 | 99-3462 | 99-3463 |
| STRONGHOLD | 1/8 | 99-3422-34 | 99-3422-3456 99-3423-3456 |
| | | 99-3422-3456 | 99-3422-56 |
| | 5/32 | 99-3422-3456 | 99-3422-56 |
| | | 99-3423-3456 | 99-3423-56 |
| | 3/16 | 99-3422-3456 | 99-3422-56 |
| | | 99-3423-3456 | 99-3423-56 |
| 1/4 | 99-3445-68 | 99-3446-68 | |



| Type | Diameter | Nose Assembly | |
|------------|----------|---------------|------------|
| AUTO-CLAMP | 3/16 | 99-3422-3456 | 99-3422-56 |
| | | 99-3423-3456 | 99-3423-56 |
| | | 99-3445-68 | 99-3446-68 |
| | 1/4 | 99-3445-68 | 99-3446-68 |



Featuring both pneudraulic and hydraulic operation, HUCK's LockForce™ Tools are designed to install a wide range of two-piece LockBolt™ fasteners.

- LockForce™ 212** A high-speed pneudraulic production tool. Use with 3/16" to 1/4" diameter fasteners.
- LockForce™ 2025** Highly durable pneudraulic installation tool. Use with 3/16" to 1/4" diameter fasteners in production volume applications.
- LockForce™ 2480** A lightweight, high-speed hydraulic tool for limited space production applications. Powered by a HUCK POWERIG® Hydraulic Power System.



LockForce 212

Pneudraulic Installation Tool

Specifications

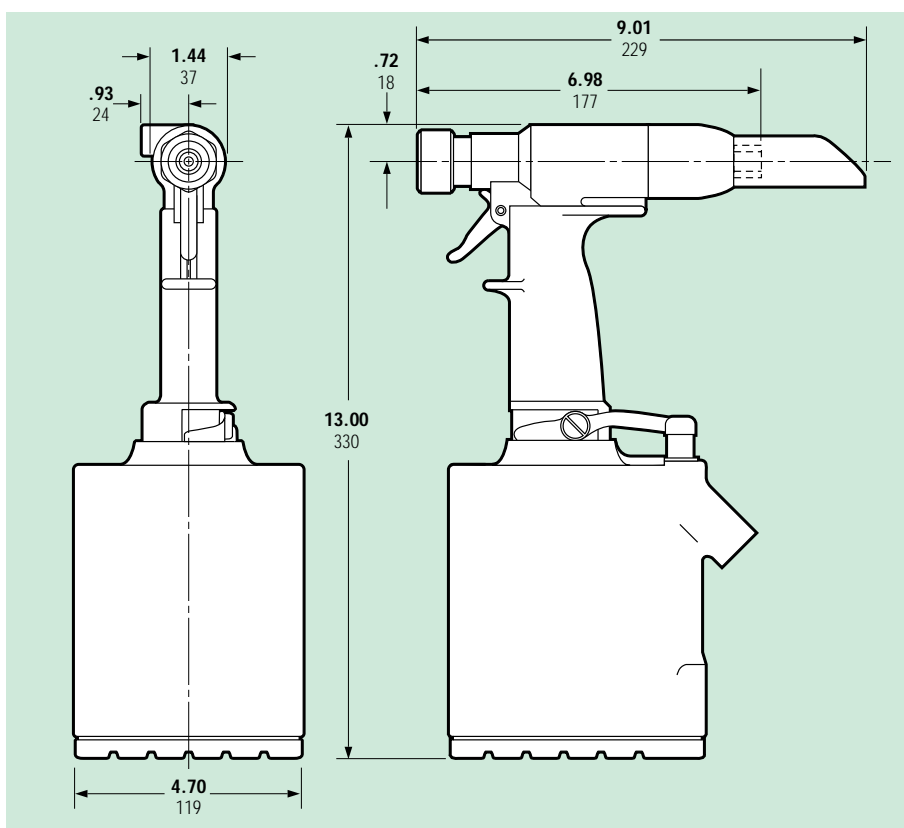
Weight:
8.50 lbs.

Required Air Pressure:
90-100 psi

Air Consumption:
3 CFM based on
30 fastener installations/minute

Hydraulic Fluid:
Automatic Transmission Fluid
DEXTRON II® or equivalent

Stroke:
.85 in.



Compatible Fastener

| Type | Diameter | Nose Assembly | |
|------------|----------|-----------------|---------|
| BOM | 3/16 | 99-994 | |
| MAGNA-LOK | 3/16 | 99-3300 | 99-3303 |
| | | 99-3316-68 | |
| | 1/4 | 99-3301 | 99-3305 |
| | | 99-3316-68 | |
| MAGNA-BULB | 3/16 | 99-3300 99-3303 | |
| | | 99-3301 99-3305 | |
| MAGNA-GRIP | 3/16 | 99-3201 | |
| | | 99-3204 | |
| HUCKTAINER | -12 | 99-3464 | |
| C6L/120L | 3/16 | 99-999 | |
| | | 99-1000 | |



The LockForce 212 has been designed to provide reduced shock at pinbreak, and a straight on head/handle design for maximum comfort while holding the tool.

LockForce 2025

Pneudraulic Installation Tool

Specifications

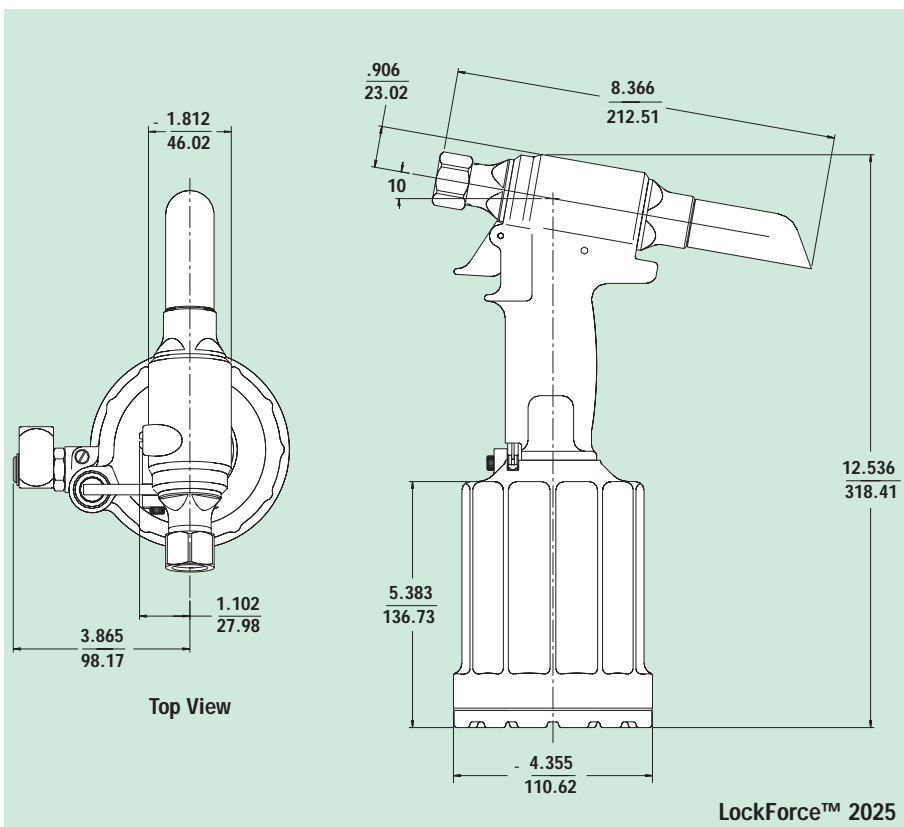
Weight:
5.75 lbs.

Required Air Pressure:
90-110 psi

Air Consumption:
1.4 CFM based on 30 cycles per minute

Hydraulic Fluid:
Automatic Transmission Fluid
DEXTRON II® or equivalent

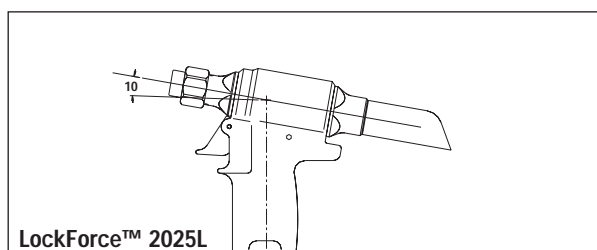
Stroke:
0.675 in.



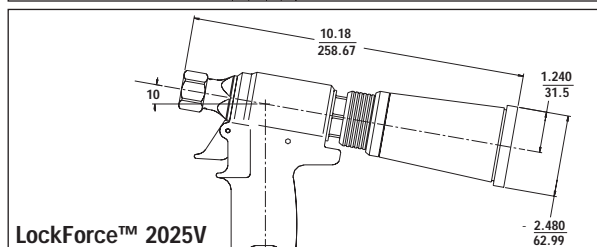
LockForce™ 2025

Compatible Fastener

| Type | Diameter | Nose Assembly |
|------------|----------|---------------|
| BOM | 3/16 | 99-994 |
| MAGNA-LOK | 3/16 | 99-3300 |
| | 1/4 | 99-3301 |
| MAGNA-BULB | 3/16 | 99-3300 |
| | 1/4 | 99-3301 |
| AUTO-BULB | 3/16 | 99-3305 |
| | 1/4 | 99-3305 |
| MAGNA-GRIP | 3/16 | 99-3201 |
| | 1/4 | 99-3204 |
| HUCKTAINER | -12 | 99-3465 |
| C6L/120L | 3/16 | 99-999 |
| | 1/4 | 99-1000 |



LockForce™ 2025L



LockForce™ 2025V



Designed for production volume fastening, the LockForce™ 2025 offers a number of outstanding features, including an ergonomically designed handle, plated piston rods and efficient in-line piston. An extended piston version (2025L) is available and an optional vacuum assist pintail collection system (2025V) can be added.

LockForce 2480

Hydraulic Installation Tool

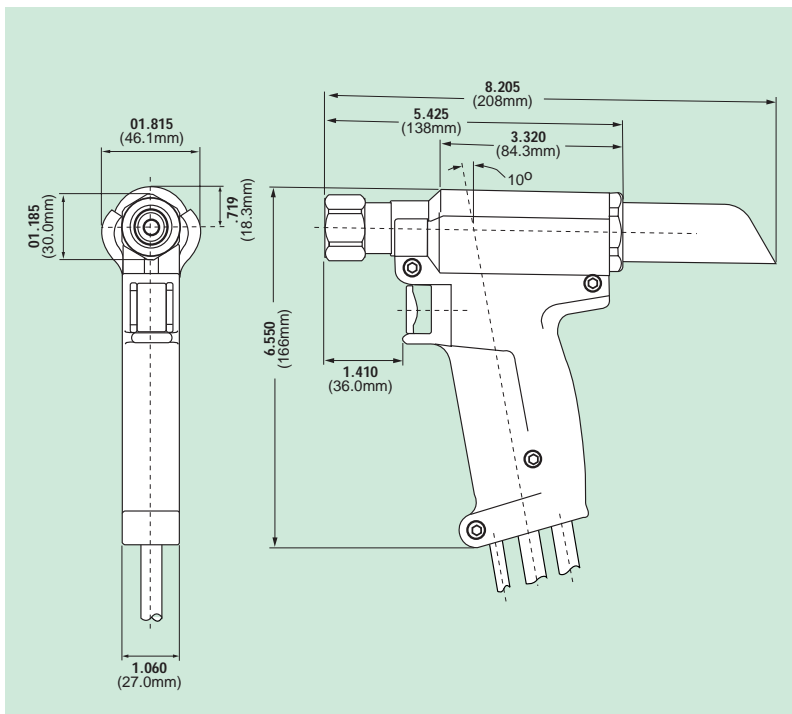
Specifications

Weight:
2.2 lbs.

Stroke:
.85 in.

Recommended Operating Air Pressure:
90-100 psi

The LockForce 2480 is a very lightweight tool, which provides for the high-speed installation of a wide range of HUCK PowerLock and LockBolt fasteners. The tool has only one moving part for increased reliability and minimal maintenance.



Compatible Fastener

| Type | Diameter | Nose Assembly | | |
|------------|------------|---------------|--------------------|------------------------------|
| BOM | 3/16 | 99-994 | | |
| MAGNA-LOK | 3/16 | 99-3316-68 | 99-3300 99-3303 | |
| | | 1/4 | 99-3316-68 | 99-3301 99-3305 |
| | 3/16 | 99-3300 | 99-3303 | |
| MAGNA-BULB | 1/4 | 99-3301 | 99-3305 | |
| | 3/16 | 99-3201 | | |
| MAGNA-GRIP | 1/4 | 99-3204 | | |
| | 3/16 | 99-3310F/P | | |
| MAGNA-TITE | 1/4 | 99-3311F/P | 99-3312F/P | |
| | GRIP-RITE | 3/32 | 99-3422-34 | 99-3422-3456 99-3423-3456 |
| 1/8 | | | 99-3422-34 | 99-3422-3456 99-3423-3456 |
| 5/32 | | | 99-3422-56 | 99-3422-3456 99-3423-3456 |
| 3/16 | | 99-3422-56 | 99-3422-3456 | |
| | | 99-3423-56 | 99-3423-3456 | |
| 99-3445-68 | 99-3446-68 | | | |
| STRONGHOLD | 1/4 | 99-3445-68 | 99-3446-68 | |
| | | 1/8 | 99-3422-34 | 99-3422-3456 99-3423-3456 |
| | 5/32 | 99-3422-56 | 99-3422-3456 | |
| | | 99-3423-56 | 99-3423-3456 | |
| | 3/16 | 99-3422-56 | 99-3422-3456 | |
| 99-3423-56 | | 99-3423-3456 | | |
| 99-3445-68 | | 99-3446-68 | | |
| 1/4 | 99-3445-68 | 99-3446-68 | | |
| HUCKTAINER | -12 | 99-3464 | | |
| C6L | 3/16 | 99-999 | | |
| | 1/4 | 99-1000 | | |



| Type | Diameter | Nose Assembly | |
|------------|----------|---------------|--------------|
| AUTO-CLAMP | 3/16 | 99-3422-56 | 99-3422-3456 |
| | | 99-3423-56 | 99-3423-3456 |
| | | 99-3445-68 | 99-3446-68 |
| | 1/4 | 99-3445-68 | 99-3446-68 |
| | | 99-3422-56 | 99-3422-3456 |
| A-LOCK | 3/16 | 99-3423-56 | 99-3423-3456 |
| | | 99-3445-68 | 99-3446-68 |
| | | 99-3460 | 99-3461 |
| PEEL | 3/16 | 99-3460 | 99-3461 |
| | 1/4 | 99-3462 | 99-3463 |

SUPER LOCK FORCE TOOLS™

HUCK's line of Super LockForce™ tools are designed for production volume installation of HUCK LockBolts™. Available in a choice of hydraulic or pneudraulic power, these tools have been proven both reliable and productive in thousands of manufacturing applications.

- Super LockForce™ 245** A high-speed pneudraulic production tool. Use with 1/4", 5/16" to some 3/8" diameter blind and LockBolt™ fasteners.
- Super LockForce™ 246** A high-speed pneudraulic production tool for all fasteners up to 3/8" diameter
- Super LockForce™ 2580** A lightweight hydraulic tool featuring both high speed performance and outstanding ergonomics. Powered by a HUCK POWERIG® Hydraulic Power System
- Super LockForce™ 2600** A compact, lightweight hydraulic production tool designed for limited clearance use. Powered by a HUCK POWERIG® Hydraulic Power System

Super LockForce 245

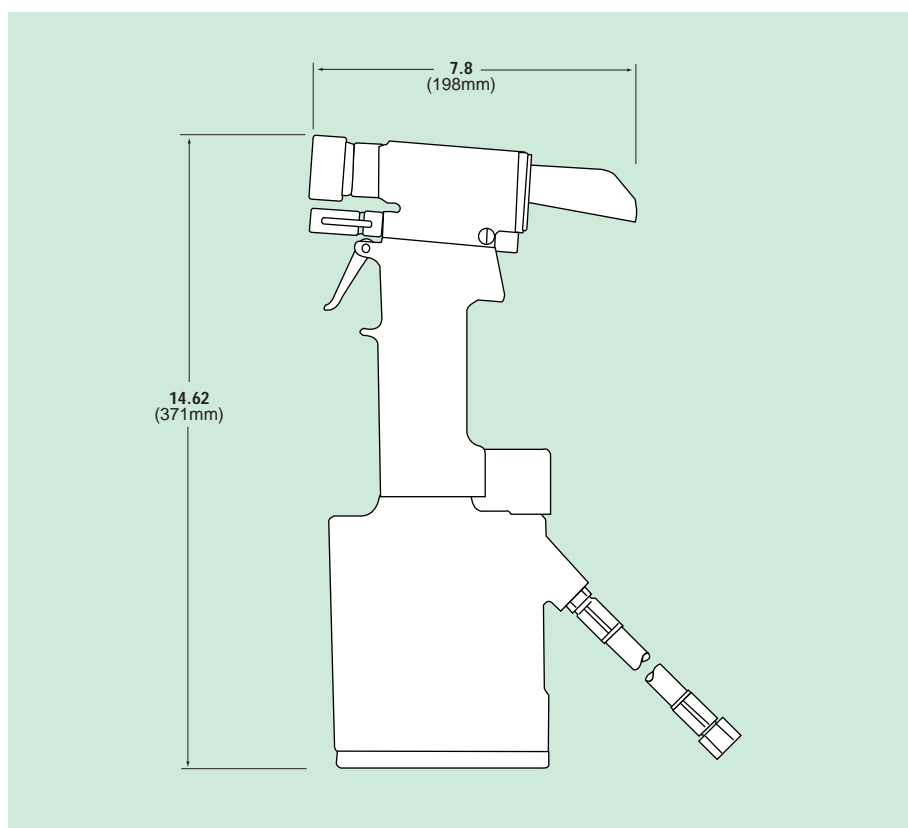
Pneudraulic Powered Installation Tool

Specifications

Weight:
9.3 lbs.

Stroke:
.88 in.

Required Air Pressure:
90-100 psi



Compatible Fastener

| Type | Diameter | Nose Assembly |
|------------|----------|---------------|
| BOM | 3/16 | 99-1053 |
| | 1/4 | 99-830-1 |
| MAGNA-GRIP | 3/16 | 99-3206 |
| | 1/4 | 99-3207 |
| | 5/16 | 99-1439 |
| | 3/8* | 99-1440 |
| FLOORTIGHT | 5/16 | 99-3452 |

*Note: Aluminum Only



The Super LockForce 245 is sized for high-speed production applications, up to 20 fastener installations per minute. This tool provides optimum stroke for one-cycle installations, and features an eccentric pull piston for limited clearance applications. Chrome-plated piston rods in the Super LockForce 245 extend the life of the seals.

Super LockForce 246

Pneudraulic Installation Tool

Specifications

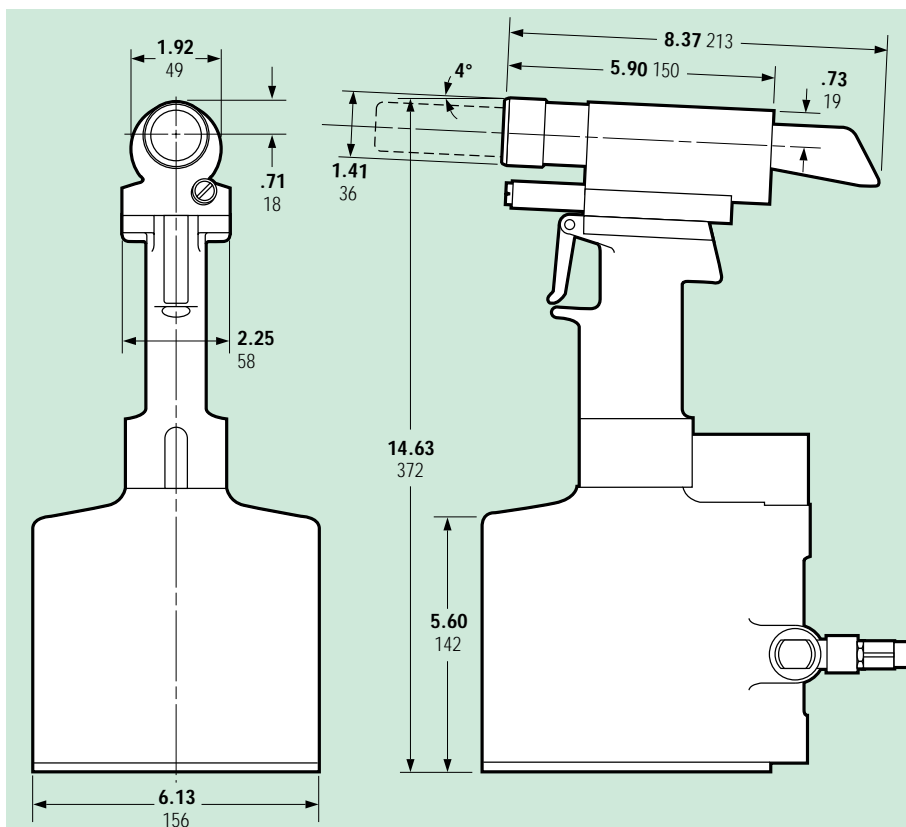
Weight:
12.30 lbs.

Required Air Pressure:
90-110 psi

Air Consumption:
30 CFM based on 18-20
fastener installations/minute

Hydraulic Fluid:
Automatic Transmission Fluid
DEXTRON II® or equivalent

Stroke:
.88 in.



Compatible Fastener

| Type | Diameter | Nose Assembly |
|------------|----------|---------------|
| BOM | 3/16 | 99-1053 |
| | 1/4 | 99-830-1 |
| | 5/16 | 99-769 |
| MAGNA-LOK | 3/8 | 99-3318 |
| MAGNA-BULB | 5/16 | 99-3307 |
| HUCKTAINER | -12 | 99-3438 |
| C6L | 5/16 | 99-99-245 |
| | 3/8 | 99-100-245 |
| MAGNA-GRIP | 3/16 | 99-3206 |
| | 1/4 | 99-3207 |
| | 5/16 | 99-1439 |
| | 3/8 | 99-1440 |
| FLOORTIGHT | 5/16 | 99-3452 |



The high speed Super LockForce 246 production tool features optimum stroke for one-cycle installation and has an eccentric pull piston for limited clearance applications. Factory tested for 2,000 cycles, the Model 246 has chrome plated piston rods to extend the life of the seals.

Super LockForce 2580

Hydraulic Powered Installation Tool

Specifications

Weight:

5 lbs.

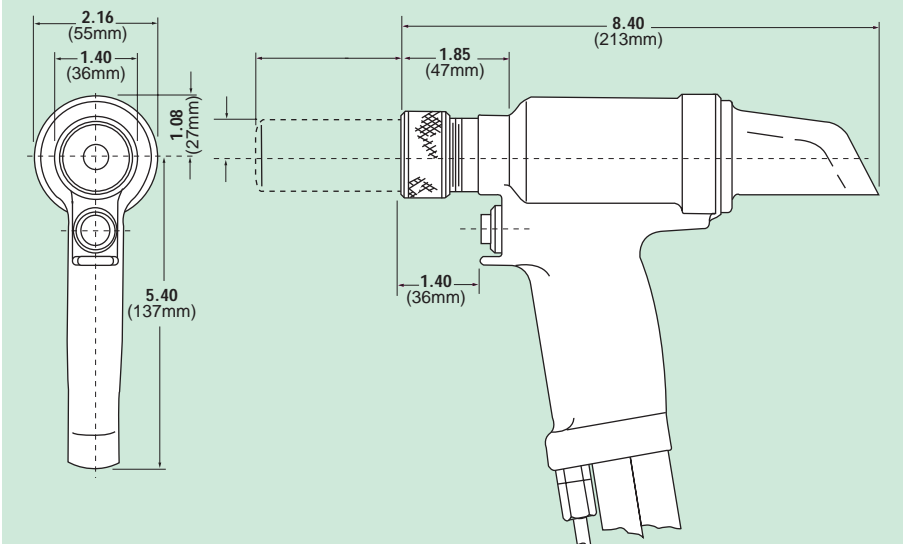
Stroke:

.94 in.

Pressure:

Pull-7,400 psi

Return-3,200 psi



Compatible Fastener

| Type | Diameter | Nose Assembly |
|------------|----------|---------------|
| BOM | 3/16 | 99-1053 |
| | 1/4 | 99-830-1 |
| | 5/16 | 99-769 |
| C6L | 5/16 | 99-99-245 |
| | 3/8 | 99-100-245 |
| FLOORTIGHT | 5/16 | 99-3452 |
| HUCKTAINER | -12 | 99-3438 |
| MAGNA-BULB | 5/16 | 99-3307 |
| MAGNA-GRIP | 3/16 | 99-3206 |
| | 1/4 | 99-3207 |
| | 5/16 | 99-1439 |
| | 3/8 | 99-1440 |
| MAGNA-LOK | 3/8 | 99-3318 |



The Super LockForce 2580 is a lightweight tool for use in a wide range of high-speed production applications. With only one moving part, the tool provides for increased reliability and requires minimal maintenance. An offset piston design allows the Super LockForce 2580 to easily fit in limited clearance applications.

Super LockForce 2600

Hydraulic Powered Installation Tool

Specifications

Weight:

7.3 lbs.

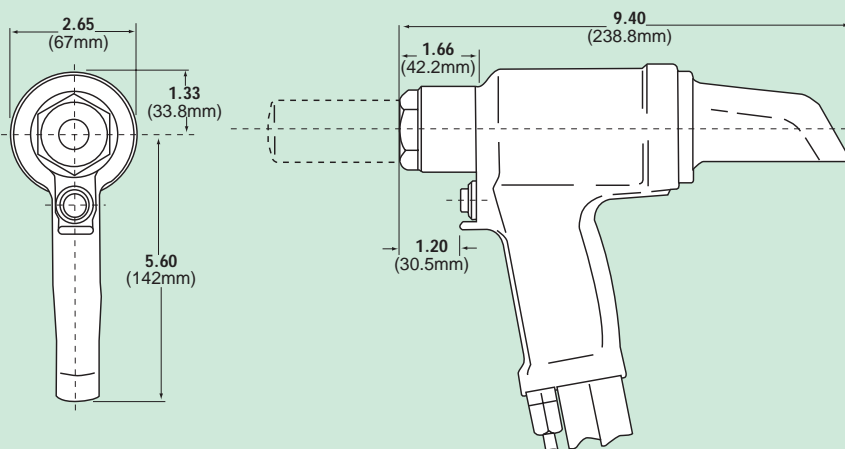
Stroke:

1.22 in.

Pressure:

Pull-5,700 psi

Return-2,800 psi



Compatible Fastener

| Type | Diameter | Nose Assembly |
|------------|----------|---------------|
| BOM | 5/16 | 99-3119 |
| | 3/8 | 99-3122 |
| MAGNA-GRIP | 5/16 | 99-3217 |
| | 3/8 | 99-3220 |



The Model 2600 is a lightweight and versatile installation tool designed use with a wide range of HUCK blind fasteners and HuckBolt fasteners. The tool's compact size allows it to fit into limited clearance applications, while its light weight provides for outstanding operator productivity.



These hydraulically powered tools are designed to effectively install HUCK's two-piece PowerBolts™. When driven by one of the company's POWERIG® Hydraulic Power Systems, these PowerDrive™ tools combine speed, ease of use and reliability in applications ranging from truck frame to rail crossing fastening.

- | | |
|---------------------------|--|
| PowerDrive™ 506 | A front ejection tool, designed for installation of larger fasteners to 7/8" diameter |
| PowerDrive™ 507 | A longer stroke model designed to install fasteners of up to 1" diameter in a production environment |
| PowerDrive™ 585 | Installs up to 3/4" in a high volume production environment |
| PowerDrive™ 586 | A longer stroke production tool, for installation of larger fasteners up to 3/4" diameter |
| PowerDrive™ 5901 | Same design and capabilities as the FE5901. Features rear ejection of pintail. |
| PowerDrive™ FE5901 | A front ejection tool, designed for installation of larger fasteners to 1/2" diameter |
| PowerDrive™ 12142 | A heavy duty tool designed for installation of 1-3/8" diameter PowerBolts™ |

PowerDrive 506

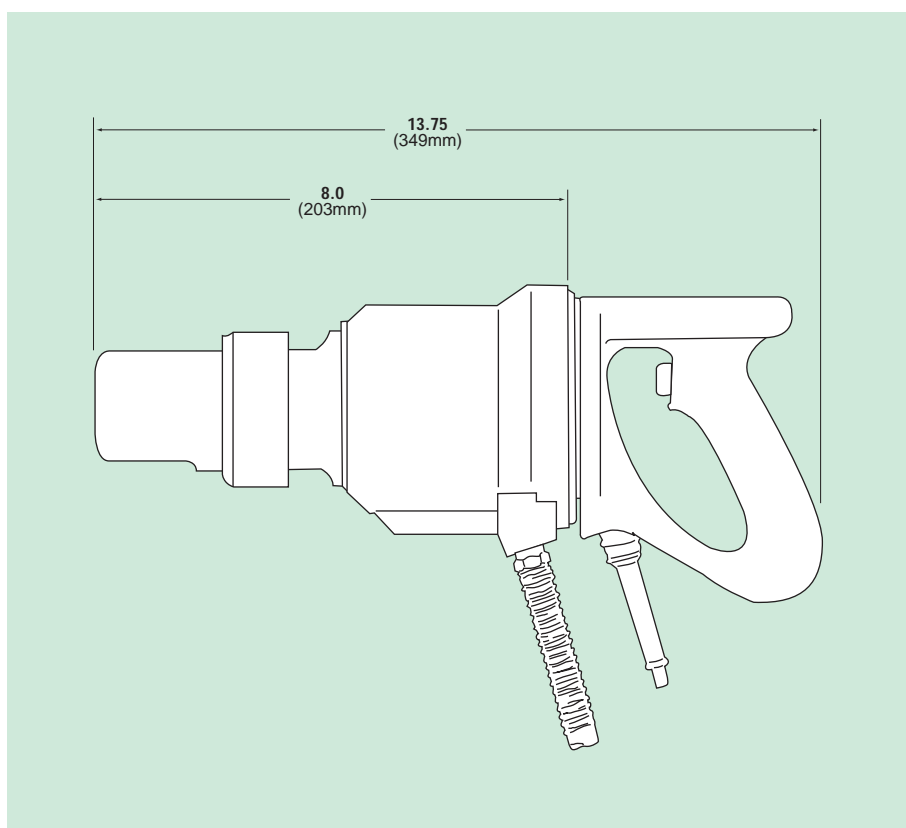
Hydraulic Powered Installation Tool

Specifications

Weight:
33 lbs.

Stroke:
2.0 in.

Pressure:
Pull-5,400 psi
Return-2,800 psi



Compatible Fastener

| Type | Diameter | Nose Assembly |
|------|----------|---------------|
| C50L | 7/8 | 99-5014 |



The PowerDrive 506 is a heavy-duty tool sized for the installation of a number of larger C50L LockBolt fasteners, up to 7/8" in diameter. This rugged tool provides high-speed installation in a wide range of production applications.

PowerDrive 507

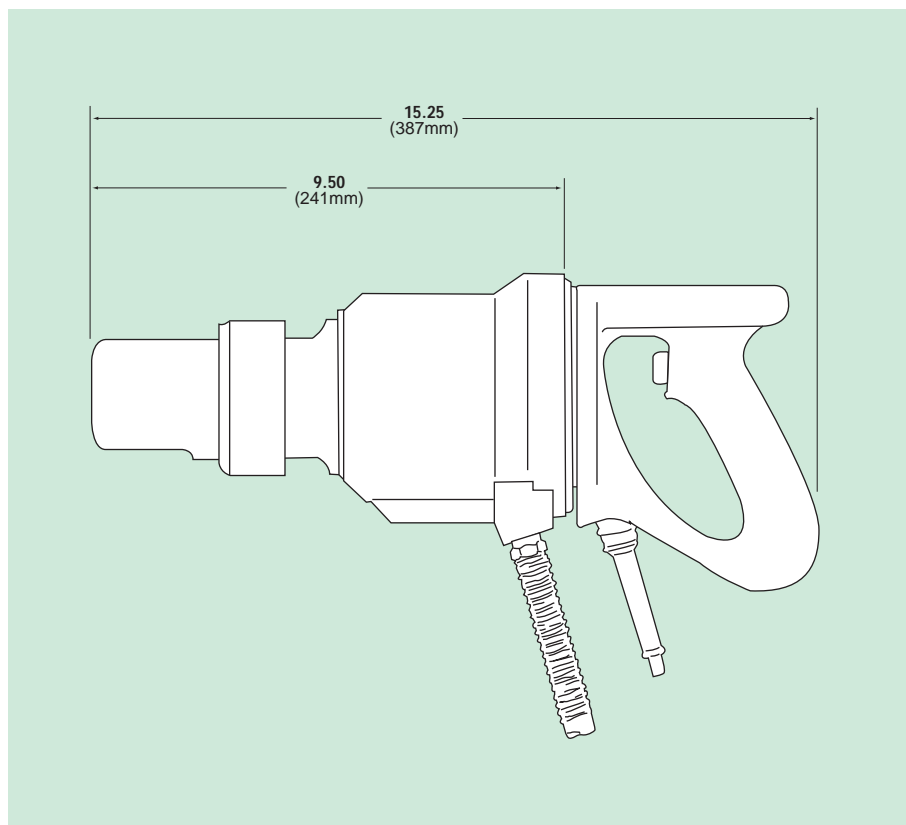
Hydraulic Powered Installation Tool

Specifications

Weight:
43 lbs.

Stroke:
2.5 in.

Pressure:
Pull-5,400 psi
Return-2,800 psi



Compatible Fastener

| Type | Diameter | Nose Assembly |
|---------|----------|---------------|
| C50L | 1 | 99-5016 |
| | 1 1/8 | 99-5019 |
| HUCKFIT | 20mm | 99-5414 |
| | 5/8 | 99-5414 |



The PowerDrive 507 is a heavy-duty tool sized for the installation of a number of larger C50L LockBolt fasteners, up to 1-1/8" in diameter. This rugged tool provides high-speed installation in a wide range of production applications.

PowerDrive 585

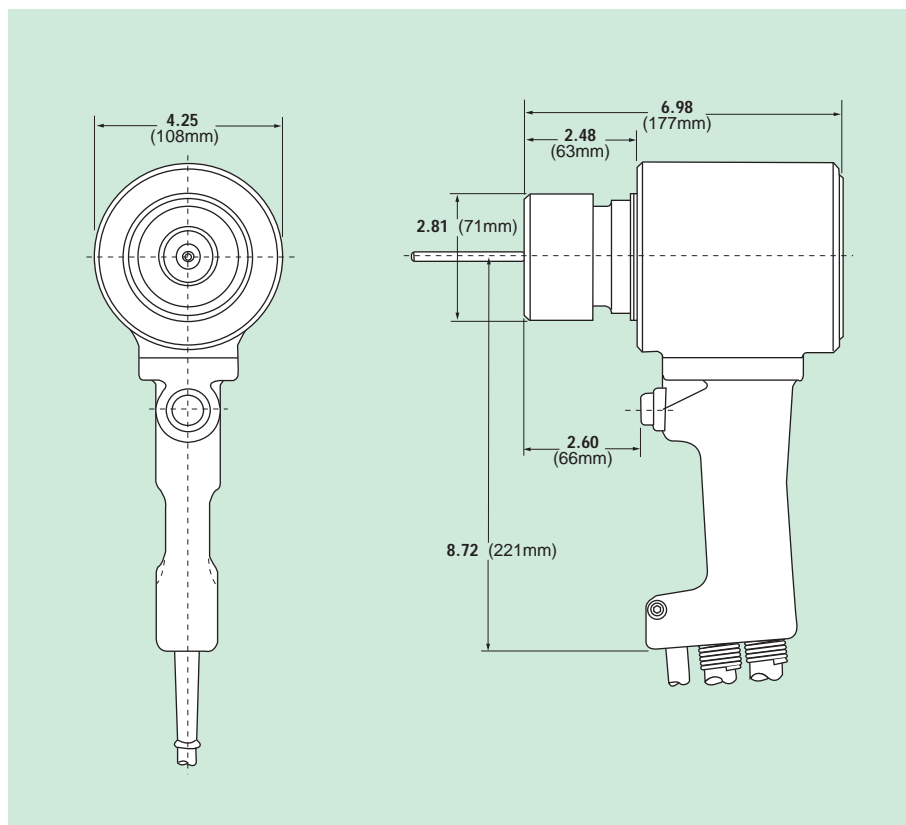
Hydraulic Powered Installation Tool

Specifications

Weight:
19 lbs.

Stroke:
1.60 in.

Pressure:
Pull-5,400 psi
Return-2,800 psi



Compatible Fastener

| Type | Diameter | Nose Assembly |
|---------|----------|---------------|
| BOM | 5/8 | 99-5102 |
| C50L | 5/8 | 99-5008 |
| | 3/4 | 99-5010 |
| HUCKFIT | 3/4 | 99-5303 |
| HP8 | 5/8 | 99-5301 |
| | 3/4 | 99-5303 |



The PowerDrive 585 is sized for the high-speed installation of HUCK's larger fasteners. The tool features an in-line piston which extends seal life. The PowerDrive 585 has only one moving part, which further minimizes maintenance.

PowerDrive 586

Hydraulic Powered Installation Tool

Specifications

Weight:

21.5 lbs.

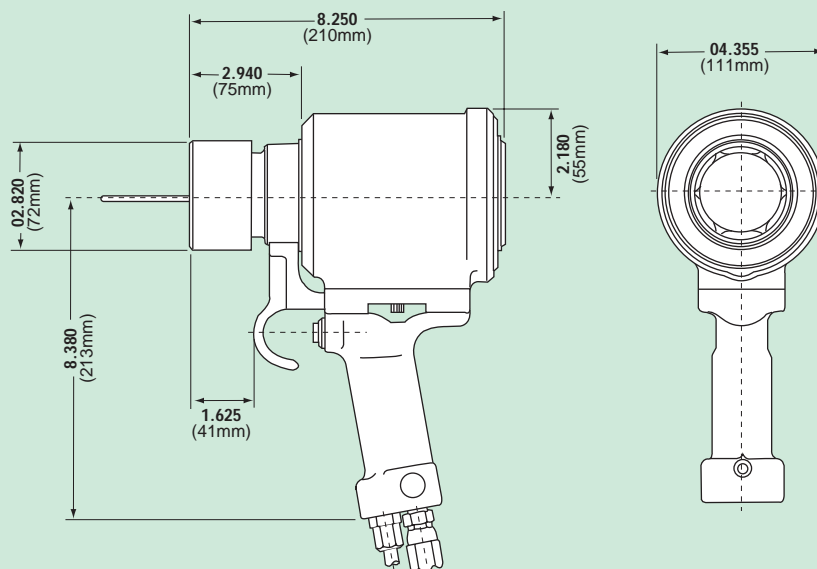
Stroke:

2.0 in.

Pressure:

Pull-5,400 psi

Return-2,800 psi



Compatible Fastener

| Type | Diameter | Nose Assembly |
|---------|----------|---------------|
| BOM | 5/8 | 99-5102 |
| | 3/4 | 99-5103 |
| C50L | 5/8 | 99-5008 |
| | 3/4 | 99-5010 |
| HUCKFIT | 16mm | 99-5300 |
| | 3/4 | 99-5303 |
| HP8 | 5/8 | 99-5301 |
| | 3/4 | 99-5303 |



The PowerDrive 586 tool is sized for the high-speed installation of HUCK's larger fasteners. Although similar in design to the PowerDrive 585 tool, the 586 provides a slightly larger production capacity. The tool features an in-line piston which extends seal life. The PowerDrive 586 features the reliability with a single moving part.

PowerDrive 5901

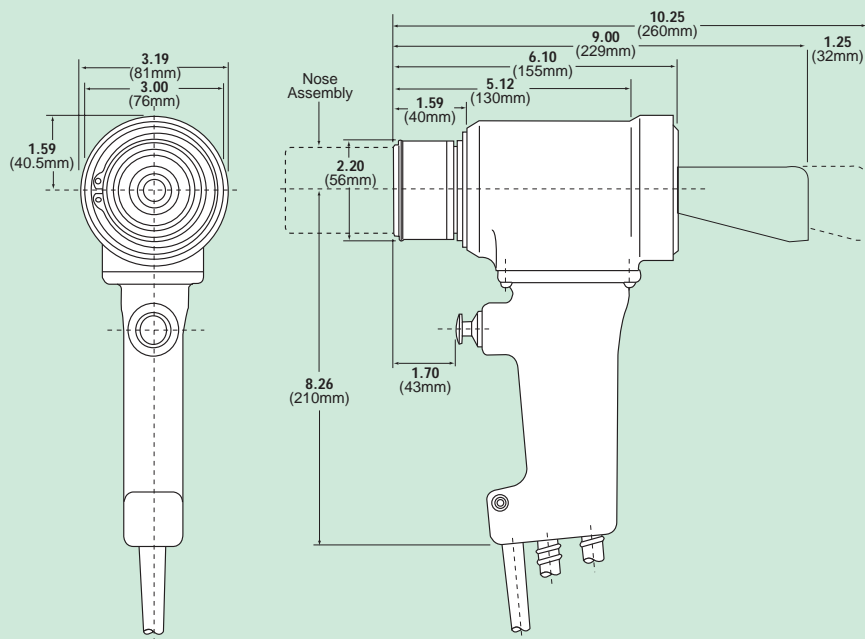
Hydraulic Powered Installation Tool

Specifications

Weight:
13 lbs.

Stroke:
1.25 in.

Pressure:
Pull-5,700 psi
Return-2,800 psi



Compatible Fastener

| Type | Diameter | Nose Assembly |
|------------|----------|-----------------|
| BOM | 1/2 | 99-5100 |
| C50L | 1/2 | 99-5002 |
| MAGNA-GRIP | 3/8 | H99-1492 |
| HP8 | 1/2 | 99-5300 |
| HUCK-FIT | 12mm | 99-5404 99-5406 |
| | 1/2 | 99-5404 |



The PowerDrive 5901 tool is suited for heavy duty installation of lockbolts and large blind bolts. This rugged tool features an in-line piston which extends seal life. Maintenance is minimized by the tool's design which requires a single moving part.

PowerDrive FE5901

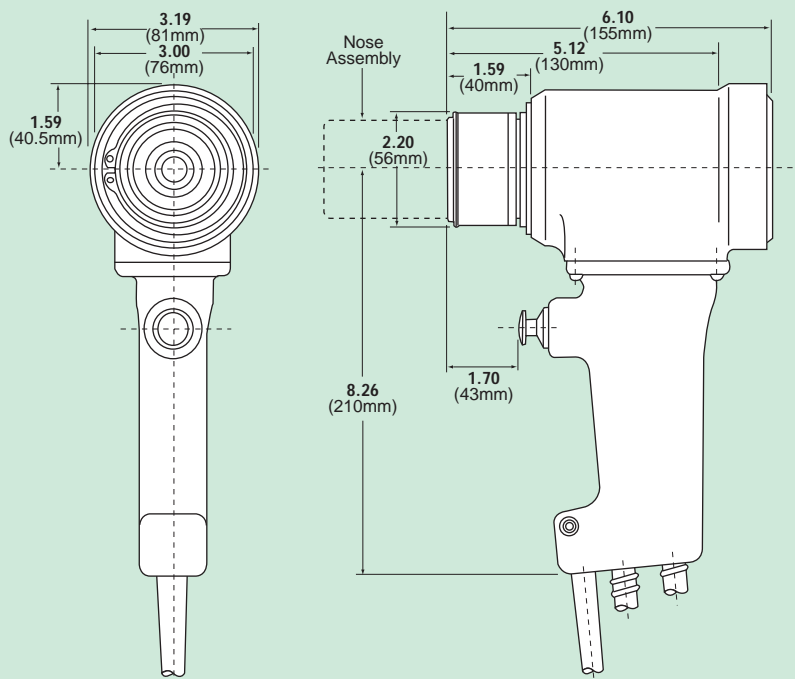
Hydraulic Powered Installation Tool

Specifications

Weight:
13 lbs.

Stroke:
1.25 in.

Pressure:
Pull-5,700 psi
Return-2,800 psi



Compatible Fastener

| Type | Diameter | Nose Assembly |
|------------|----------|---------------|
| BOM | 1/2 | 99-5100 |
| C50L | 1/2 | 99-5000 |
| MAGNA-GRIP | 3/8 | 99-1492 |
| HP8 | 1/2 | 99-5300 |



The PowerDrive FE5901 tool is suited for heavy duty installation of lockbolts and large blind bolts. This rugged tool features an in-line piston which extends seal life. Maintenance is minimized by the tool's design which requires a single moving part. Special front pintail ejection system ensures operation safety.

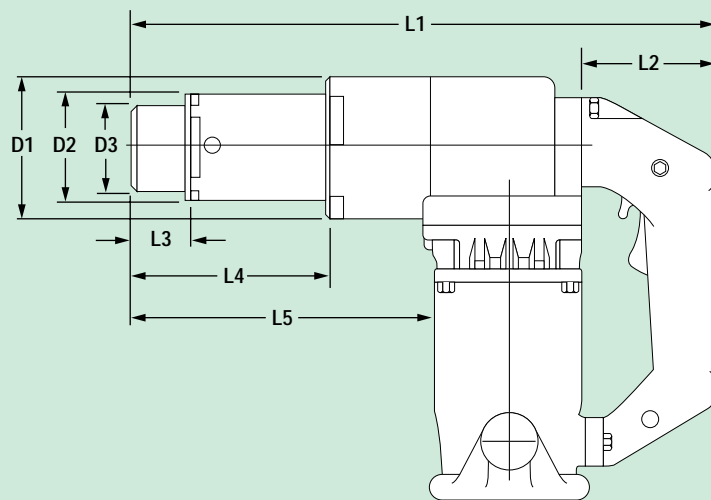
Ultra-Twist™ Tool

Hydraulic Construction Tool

Specifications

Weight:
13.5-32.1 lbs.

Power:
110 VAC or 220 VAC



Model Specifications (in.)

| Model | D1 | D2 | D3 | L1 | L2 | L3 | L4 | L5 |
|--------|-------|------|------|-------|------|------|-------|-------|
| S60EZ | 73.0 | 54.0 | 47.0 | 255.0 | 25.0 | 39.0 | 92.0 | 135.0 |
| S90EZ | 85.0 | 62.0 | 57.0 | 276.0 | 80.0 | 35.0 | 124.0 | 180.0 |
| S170EZ | 121.0 | 87.0 | 70.0 | 383.0 | 80.0 | 24.0 | 113.0 | 215.0 |

Compatible Fastener

| Type | Diameter | Tool |
|-------------|----------|--------|
| ULTRA-TWIST | 20mm | S60EZ |
| (metric) | 24mm | S90EZ |
| | 27mm | S170EZ |



This tooling is designed to be 100% compatible with electric shear wrenches used for the installation of twist-off bolts. An operator can use the same tool to drive the same size of Ultra-Twist fastener without changing the drive wrench socket.

Huck-Spin™

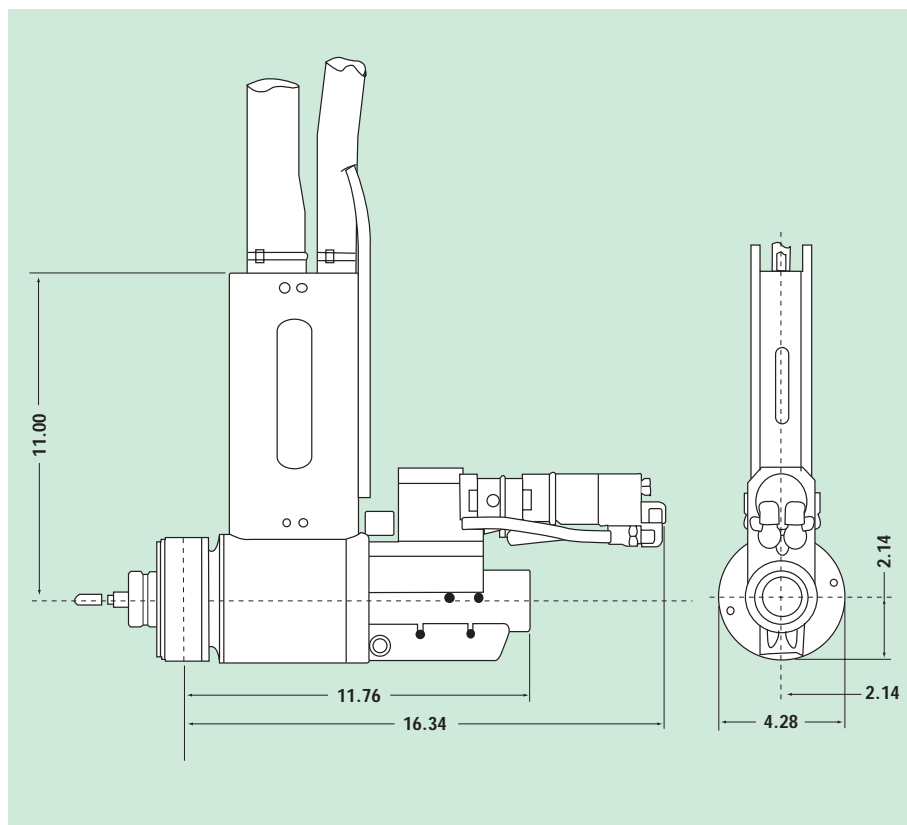
Hydraulic Production Tool

Specifications

Weight:

HS37: 30 lbs.

HS52: 40 lbs.



Compatible Fastener

| Type | Diameter | Nose Assembly | Tool |
|-----------------------|----------|---------------|------|
| HUCK-SPIN (metric) | 12mm | 99-7412-1 | HS37 |
| | 14mm | 99-7415-1 | HS52 |
| | 16mm | 99-7315-1 | HS52 |
| | 20mm | 99-7418-1 | HS52 |
| HUCK-SPIN (inches) | 1/2 | 99-7313-1 | HS52 |
| | 5/8 | 99-7315-1 | HS52 |
| | 3/4 | 99-7314-1 | HS52 |



The Huck-Spin™ Installation Tool employs a unique spin on, swage, spin off routine to install Huck-Spin fasteners with a secure clamp, but without the typical pinbreak. Hydraulic power for the tool is provided by the electric-powered HUCK POWERIG® 918.

POWERIG[®] Hydraulic Power Systems

HUCK offers three basic POWERIG[®] hydraulic power units for both in-plant and on-site use. Available in a choice of gasoline or electric power, there is a POWERIG[®] available to deliver a hydraulic flow rate ranging from 70 cu. inches to 2 gallons per minute.

POWERIG[®] 913

Specifications

Weight:

135 lbs. w/o hydraulic fluid

Power:

gasoline

Length:

24 in.

Height:

27 in.

Width:

21 in.

Flow Rate:

70 cu."/min.

The Model 913 POWERIG[®] is a portable hydraulic unit developed for use with the HUCK line of hydraulic tooling. While this gasoline-powered unit is sized for moderate production and repair applications, its rugged construction makes it well-suited for field use.

POWERIG[®] 918

Specifications

Weight:

780 lbs. operational

585 lbs. w/o hydraulic fluid

Power:

electric, 220 or 440 volts,
3 phase

Length:

44 in.

Height:

30 in.

Width:

25 in.

Flow Rate:

1.3 gpm

The Model 918 POWERIG[®] is the largest hydraulic unit offered by HUCK. Sized for high production applications the unit can operate up to three tools independently. This electrically powered model also delivers sufficient power to operate the tools up to 100 feet away. A 22-gallon reservoir stores hydraulic fluid, with a filter-strainer in the suction line to assure clean, filtered fluid.



POWERIG[®] 940

Specifications

Weight:

74.5 lbs. operational

66 lbs. w/o hydraulic fluid

Power:

electric, 115 or 220 volts,
single phase

Length:

12.5 in.

Height:

18 in.

Width:

10.5 in.

Flow Rate:

70 gpm

Reservoir Capacity:

1.5 gallons

Options:

220V, 60/50 hertz single phase,
250VDC, direct current

The Model 940 POWERIG[®] is a portable unit sized for moderate production and repair applications. This unit features rugged construction for durability in the field, and the choice of 115 or 220 Volt AC power. The Model 940 includes a handle for easy transport, simple adjustable hydraulic outputs and quick-connect couplers for connecting installation tool hoses.



AfterMarket™ TOOLS

HUCK's line of aftermarket installation tooling is designed to install SureSet™ Rivets and LockRivets™ fasteners, ranging from 3/32" to 1/4".

HandSet HK150-I™ Manually operated, hydraulically intensified tool delivers the power to set fasteners from 3/32" to 1/4", while weighing only 18 oz.

AirSet AK180-I™ Develops 3,500 lbs. of pulling force to set rivets from 1/8" through 1/4"

HandSet HK150-I

Manually Operated
Hydraulically Powered
Installation Tool

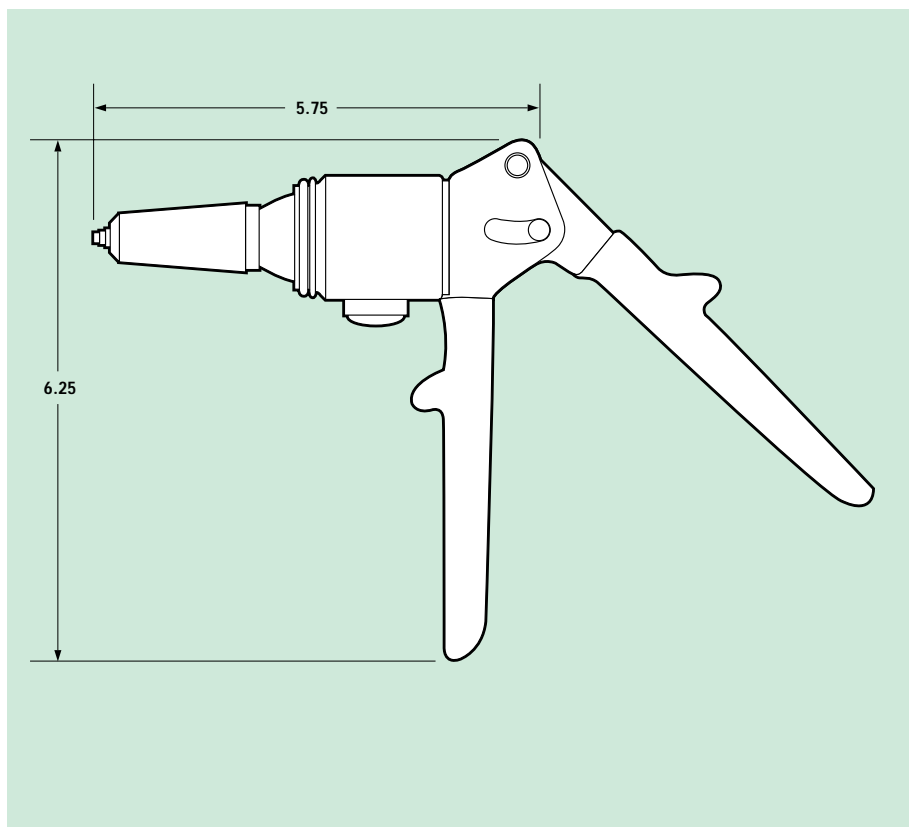
Specifications

Weight:

18 oz.

Stroke:

.63 in.



Compatible Fastener

| Type | Diameter | Insert |
|-----------|----------|--------|
| GRIP-RITE | 3/32 | 202159 |
| | 1/8 | 202159 |
| | 5/32 | 202158 |
| | 3/16 | 202158 |
| | 1/4 | 202157 |
| A-LOCK | 3/16 | 202158 |
| PEEL | 1/4 | 202155 |

Optional: Nose Extension Kit-205490

Metric Rivnut Accessory Kit-205401

Nutsert Accessory Kit-205403

HK150-I Installs These Rivets

| Type | Diameter | | | |
|------------|----------|------|------|-----|
| Aluminum | 1/8 | 5/32 | 3/16 | 1/4 |
| Alum/Steel | 1/8 | 5/32 | 3/16 | 1/4 |
| Steel | 1/8 | 5/32 | 3/16 | 1/4 |
| Stainless | 1/8 | 5/32 | 3/16 | 1/4 |
| Peel | - | - | - | 1/4 |



The HandSet HK150-I Kit consists of a manually operated, hydraulically powered installation tool and inserts for a variety of rivets. This kit is designed for repair and maintenance applications.

AirSet AK180-I

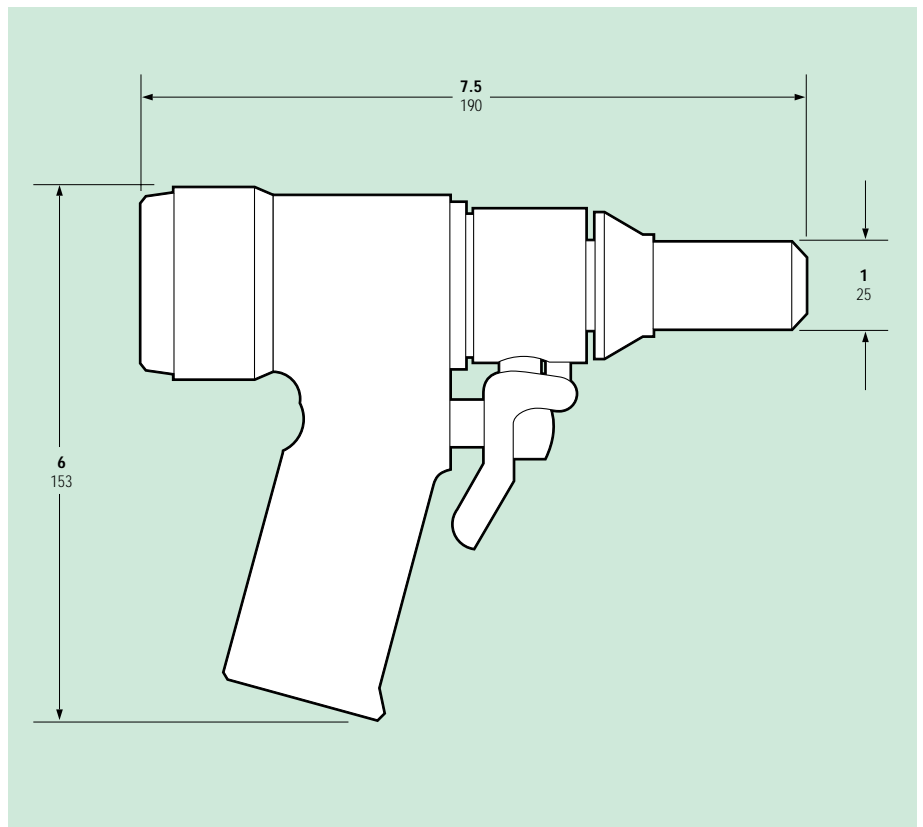
Pneudraulic Powered Installation Tool

Specifications

Weight:
28 oz.

Stroke:
.625 in.

Recommended Operating Air Pressure:
90-120 psi



Compatible Fastener

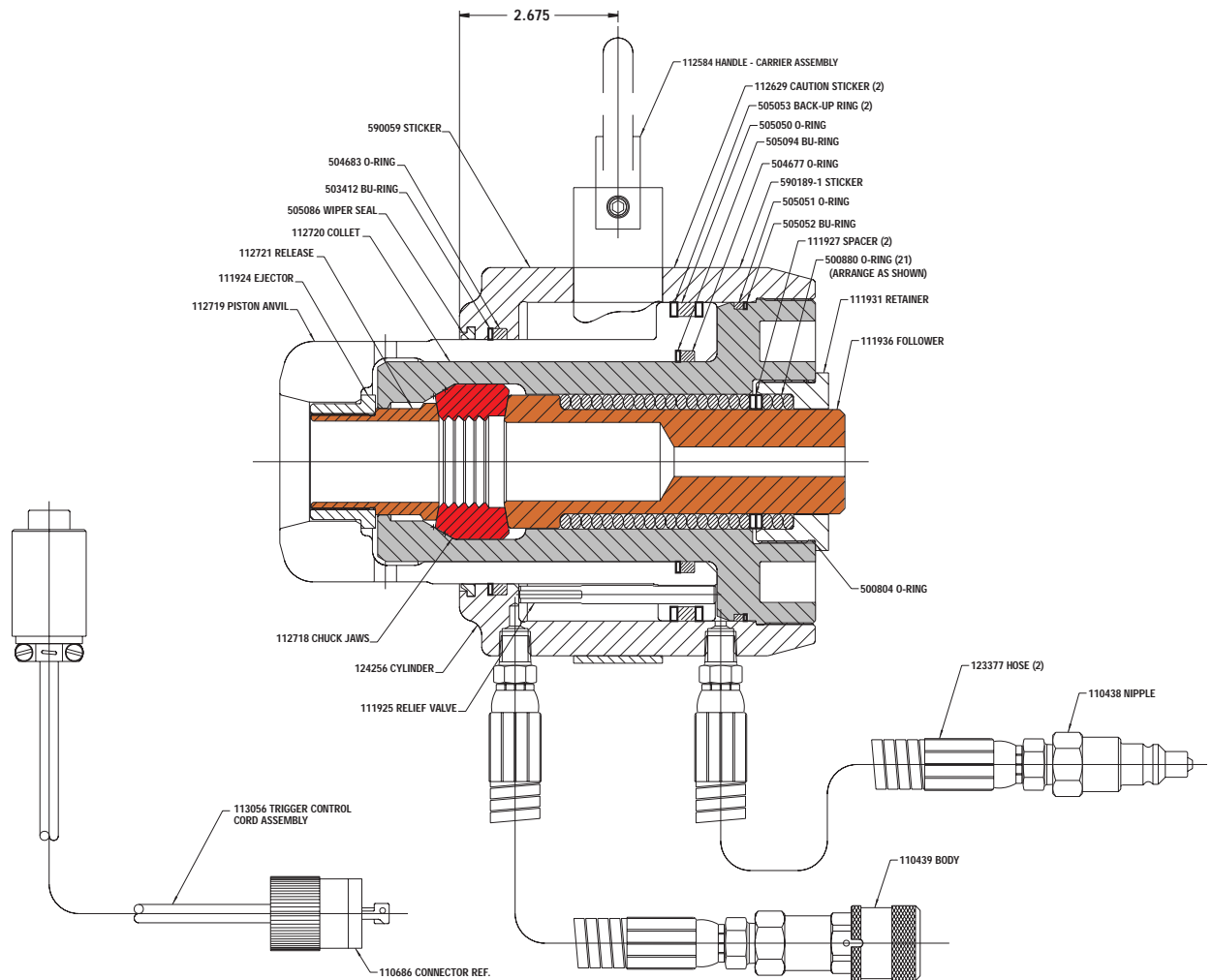
| Type | Diameter | Insert |
|-----------|----------|--------|
| MAGNA-LOK | 3/16 | 120982 |
| | 1/4 | 202142 |
| A-LOCK | 3/16 | 202158 |
| GRIP-RITE | 3/32 | 202159 |
| | 1/8 | 202159 |
| | 5/32 | 202158 |
| | 3/16 | 202158 |
| | 1/4 | 202157 |
| PEEL | 1/4 | 202155 |

Optional Nose Extension Kit—205490



Compact and lightweight, the AirSet AK180-I develops 3,500 pounds of pulling force. Its unique jaw system allows the AK-1801 to set rivets from 1/8" through 1/4" using easily changed inserts. Ideal for maintenance and repair work.

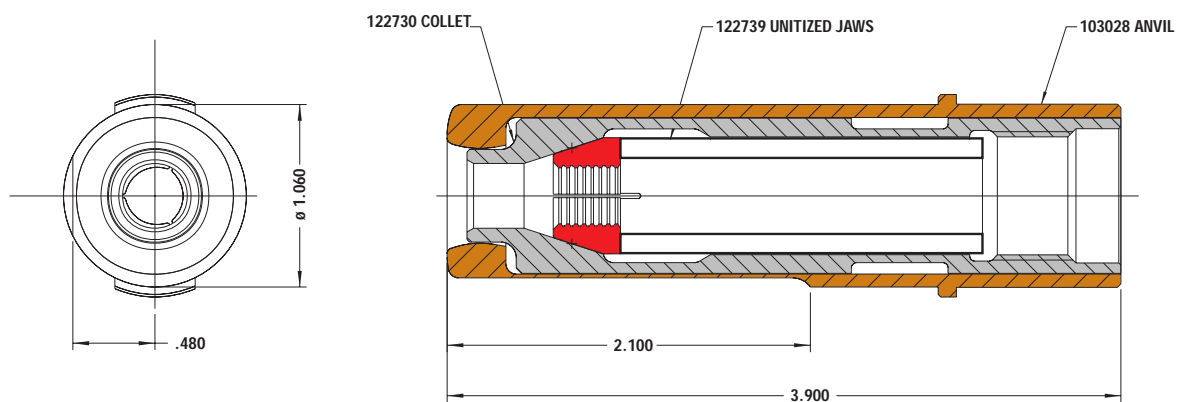
12142 Nose Piece



Compatible Fastener

| Type | Diameter | Tool |
|---------|----------|------------------|
| RamBolt | 1 3/8 | PowerDrive 12142 |
| C50L | 1 3/8 | PowerDrive 12142 |

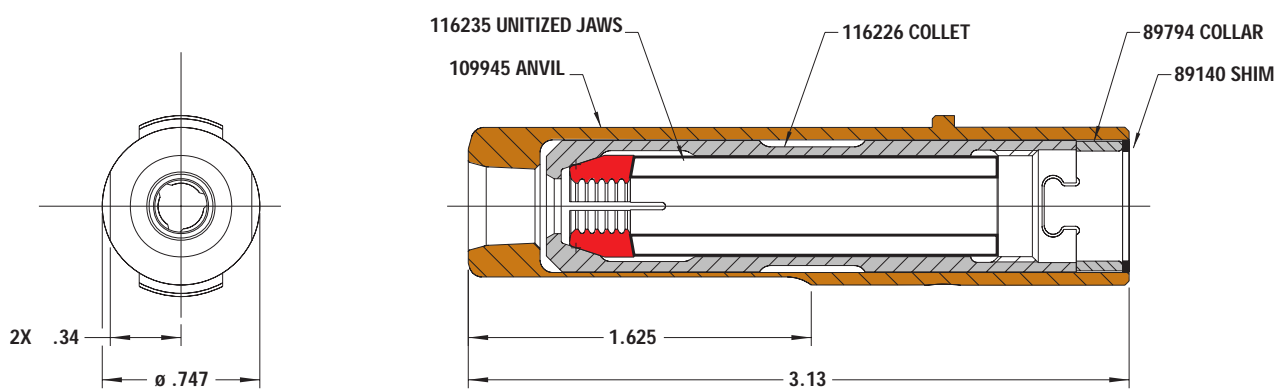
99-100-245 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------|----------|----------------------|
| C6L | 3/8 | Super LockForce 246 |
| | | Super LockForce 2580 |

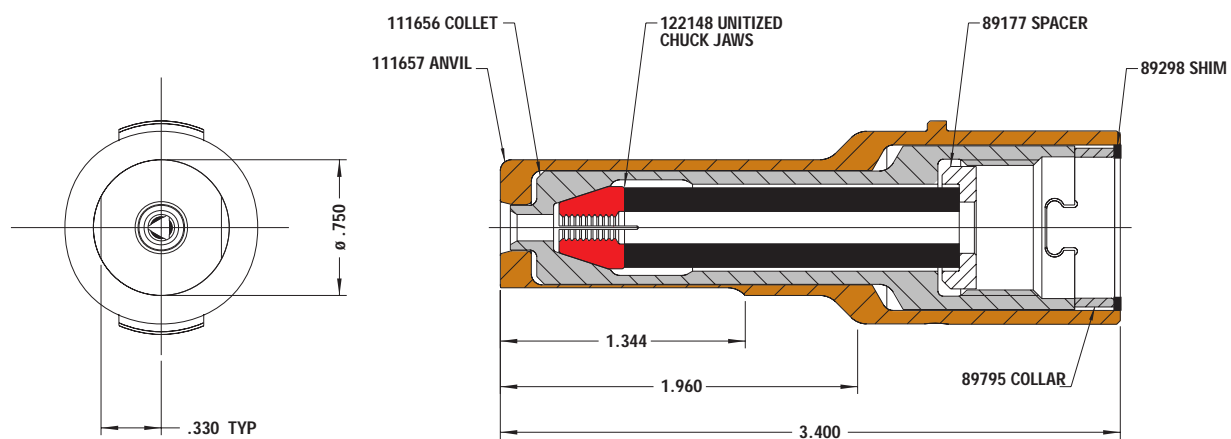
99-1000 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|----------|----------|----------------|
| C6L/120L | 1/4 | SureSet 230 |
| | | LockForce 212 |
| | | LockForce 2025 |
| | | LockForce 2480 |

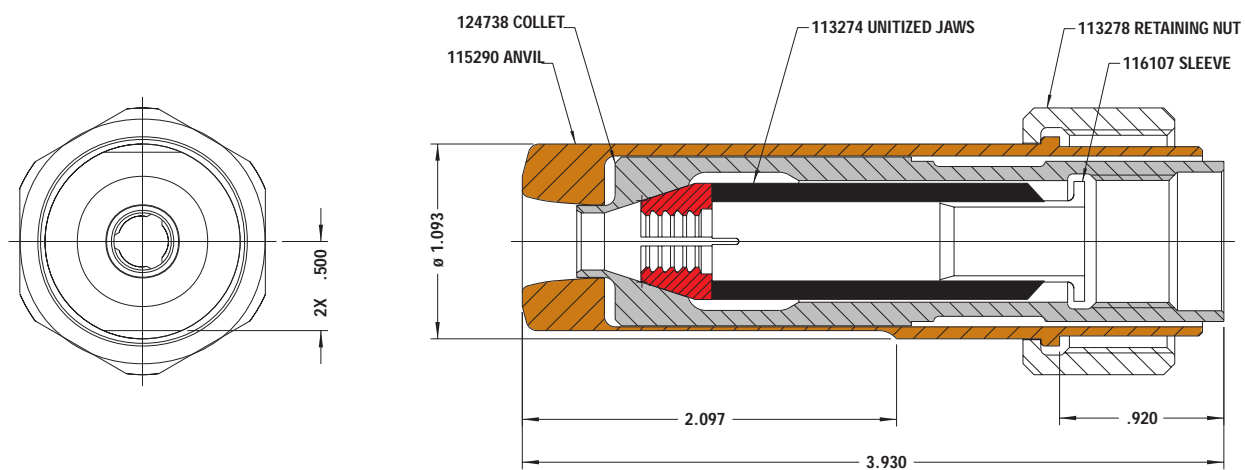
99-1053 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------|----------|---------------------|
| BOM | 3/16 | SuperLockForce 245 |
| | | SuperLockForce 246 |
| | | SuperLockForce 2580 |

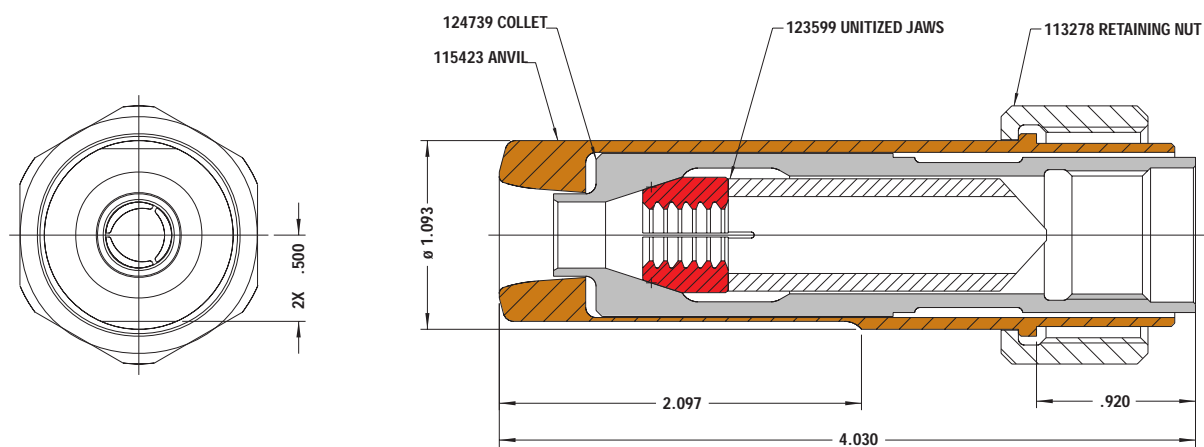
99-1439 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|---------------------|
| Magna-Grip | 5/16 | SuperLockForce 245 |
| | | SuperLockForce 246 |
| | | SuperLockForce 2580 |

99-1440 Nose Assembly

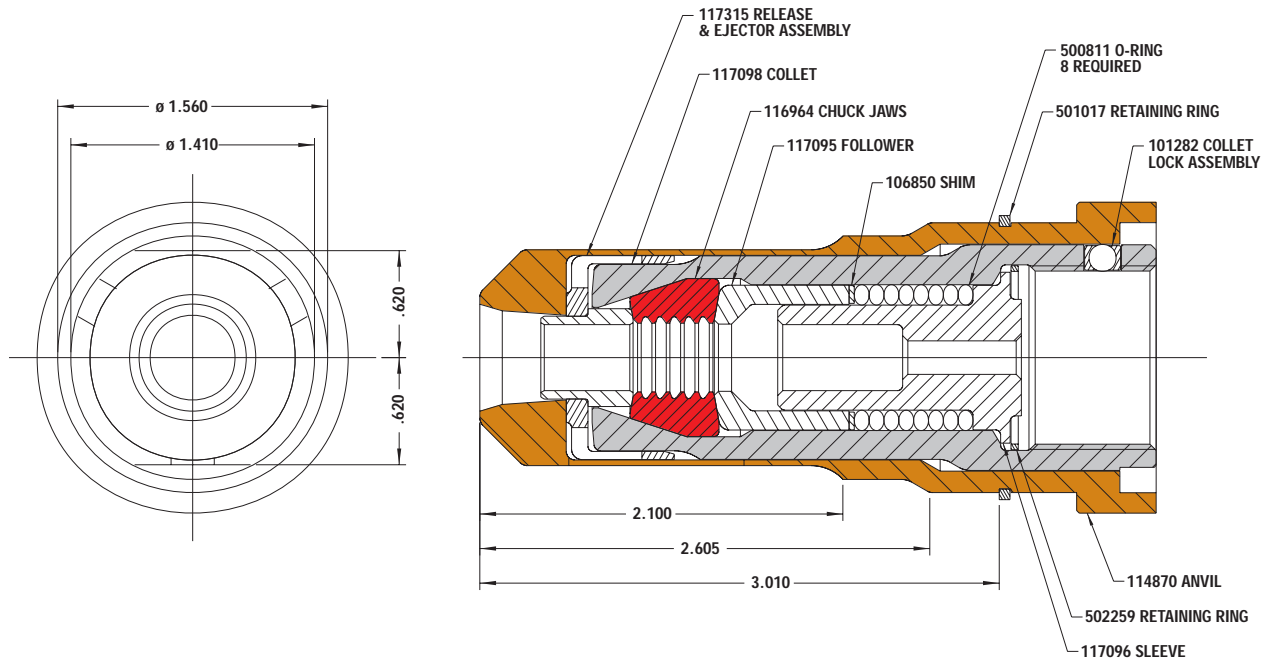


Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|---------------------|
| Magna-Grip | 3/8 | SuperLockForce 245 |
| | | SuperLockForce 246 |
| | | SuperLockForce 2580 |

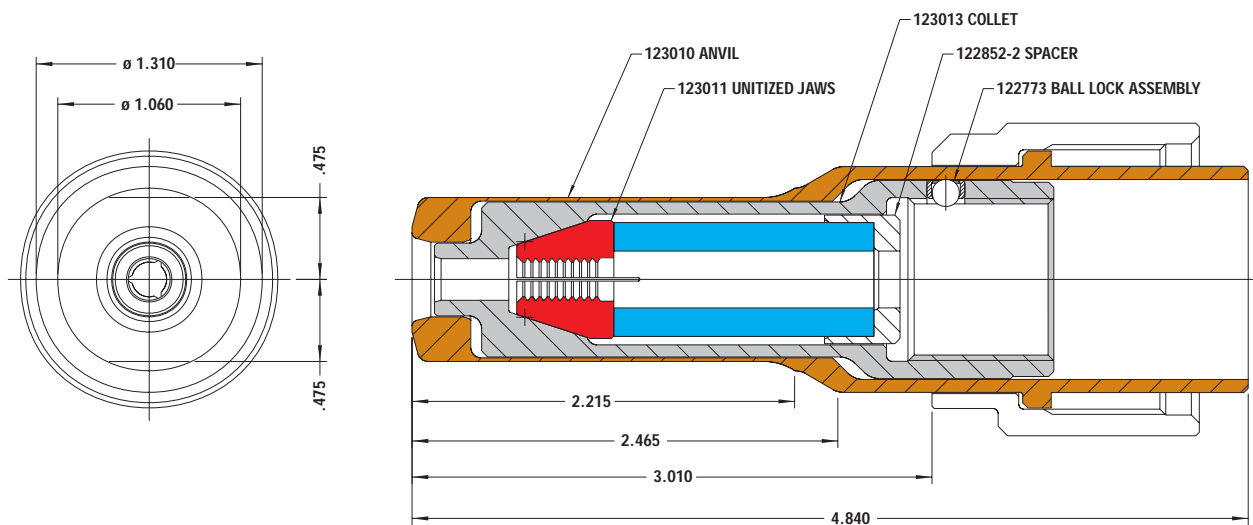
99-1492 Nose Assembly

99-1492 Nose Assembly

**Compatible Fastener**

| Type | Diameter | Tool |
|------------|----------|-------------------|
| Magna-Grip | 3/8 | PowerDrive FE5901 |

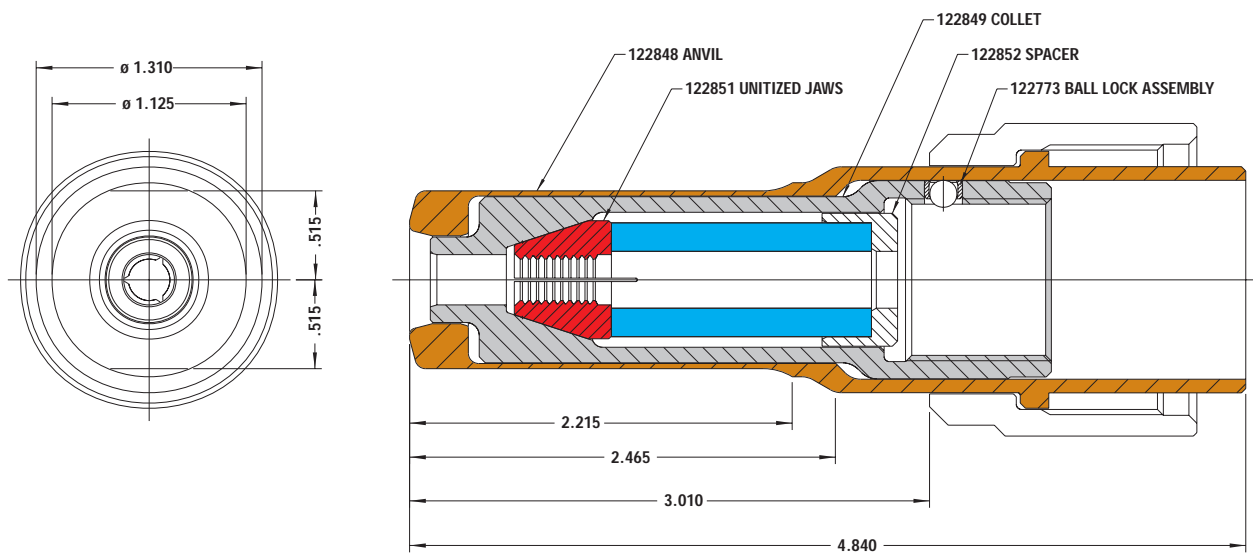
99-3119 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------|----------|---------------------|
| BOM | 5/16 | SuperLockForce 2600 |

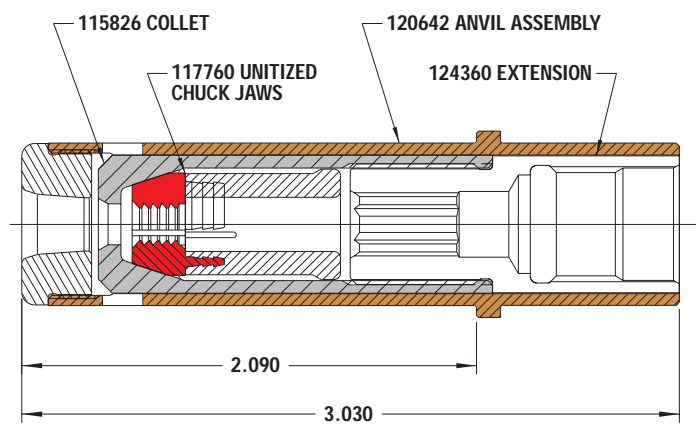
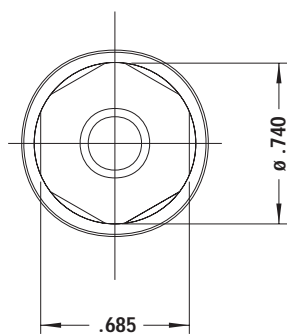
99-3122 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------|----------|---------------------|
| BOM | 3/8 | SuperLockForce 2600 |

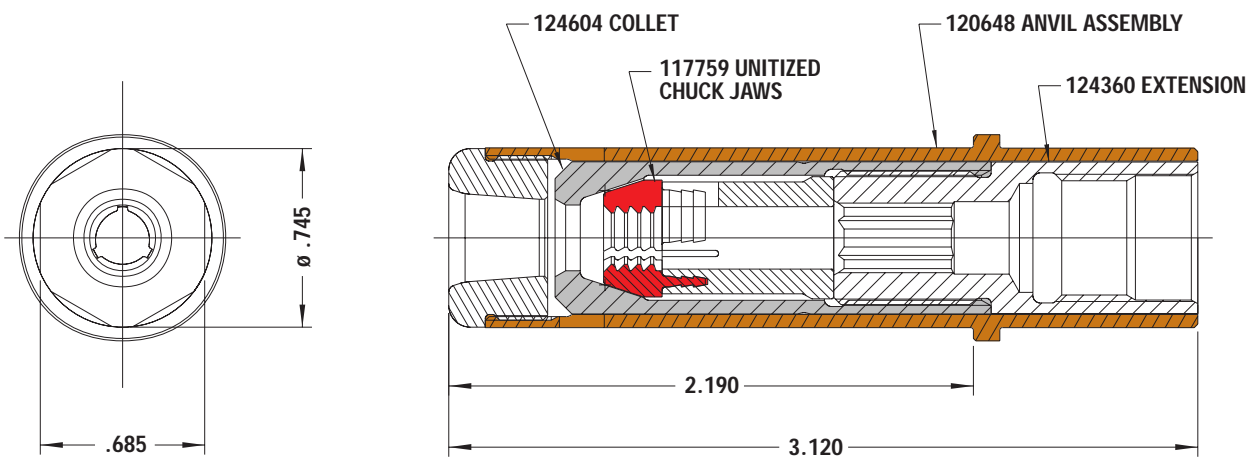
99-3201 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|----------------|
| Magna-Grip | 3/16 | SureSet 230 |
| | | LockForce 212 |
| | | LockForce 2025 |
| | | LockForce 2480 |

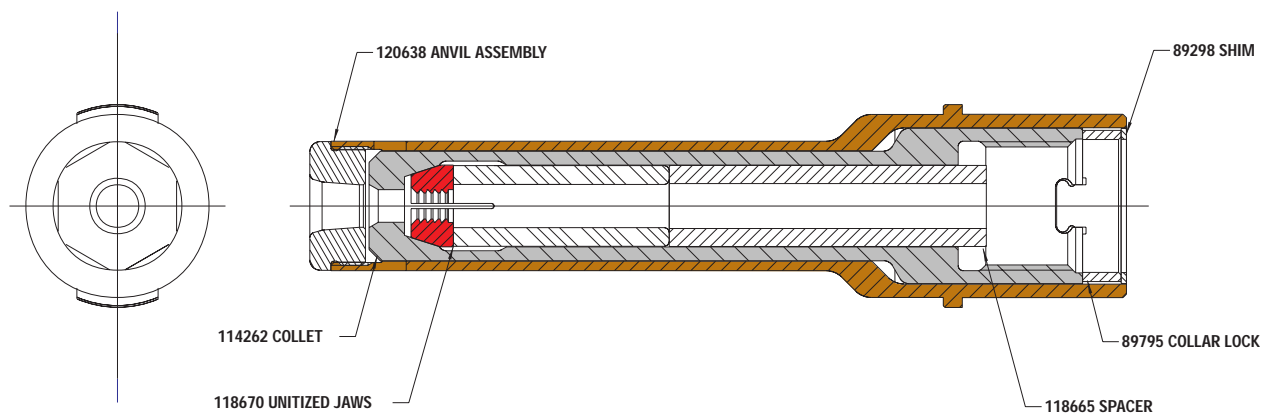
99-3204 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|----------------|
| Magna-Grip | 1/4 | SureSet 230 |
| | | LockForce 212 |
| | | LockForce 2025 |
| | | LockForce 2480 |

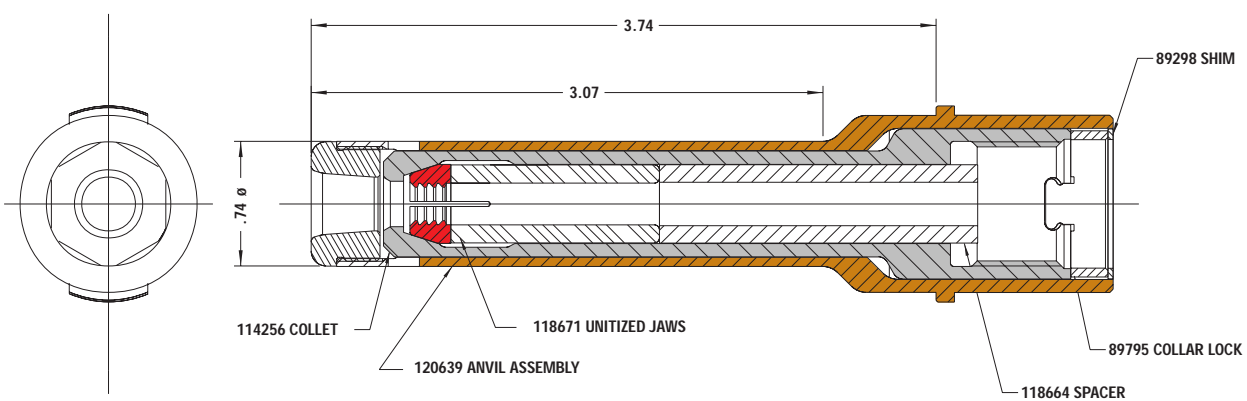
99-3206 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|----------------------|
| Magna-Grip | 3/16 | Super LockForce 245 |
| | | Super LockForce 246 |
| | | Super LockForce 2580 |

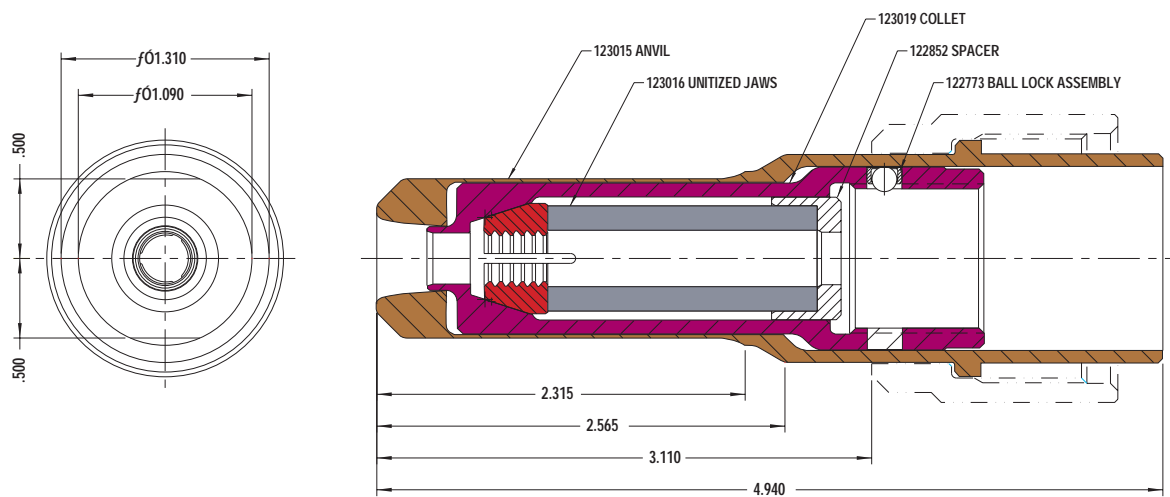
99-3207 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|----------------------|
| Magna-Grip | 1/4 | Super LockForce 245 |
| | | Super LockForce 246 |
| | | Super LockForce 2580 |

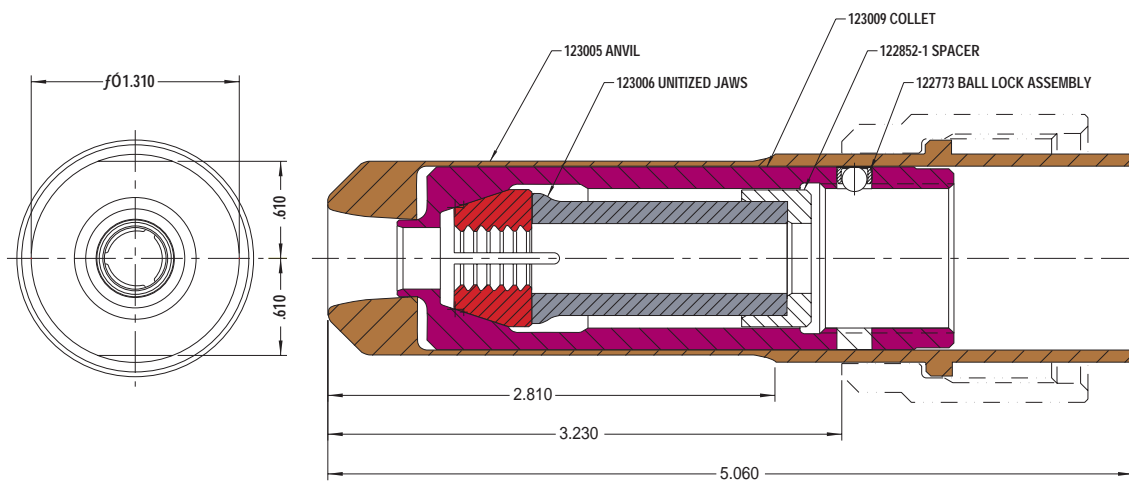
99-3217 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|----------------------|
| Magna-Grip | 5/16 | Super LockForce 2600 |

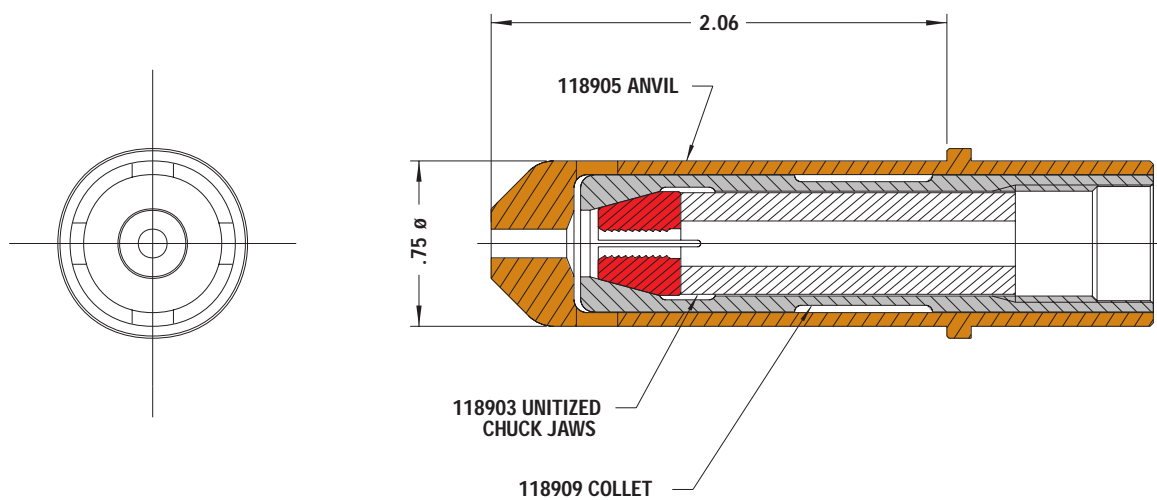
99-3220 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|----------------------|
| Magna-Grip | 3/8 | Super LockForce 2600 |

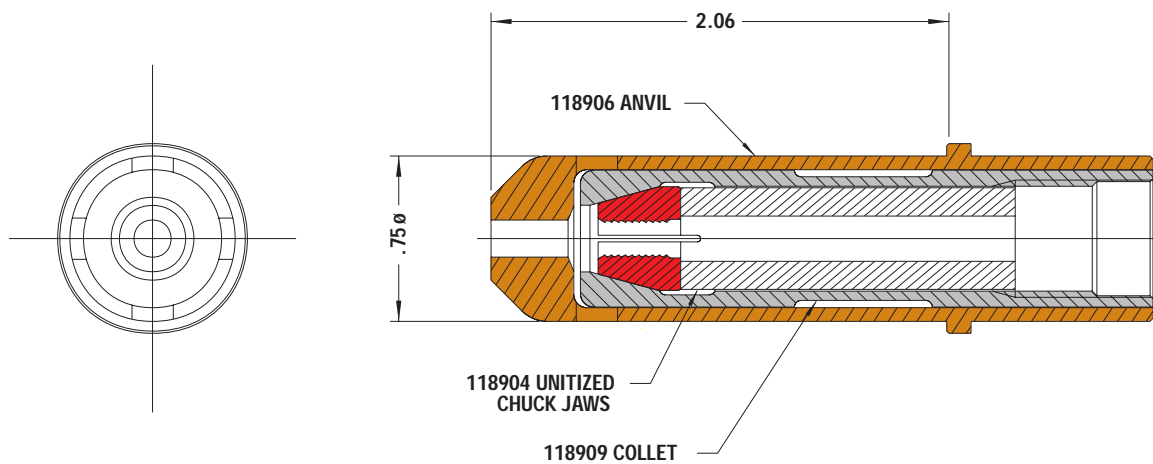
99-3300 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|----------------|
| Magna-Lok | 3/16 | SureSet 229 |
| | | SureSet 230 |
| | | LockForce 212 |
| | | LockForce 2025 |
| | | LockForce 2480 |
| Magna-Bulb | 3/16 | SureSet 229 |
| | | SureSet 230 |
| | | LockForce 212 |
| | | LockForce 2025 |
| | | LockForce 2480 |

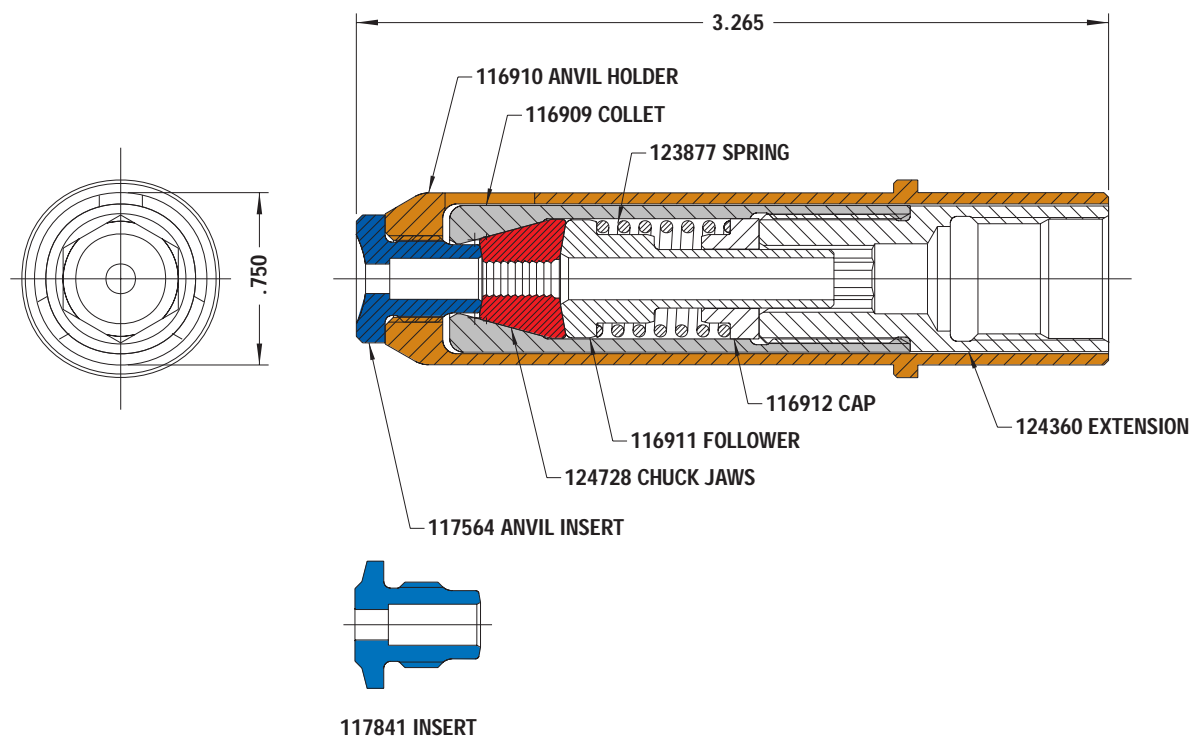
99-3301 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|----------------|
| Magna-Lok | 1/4 | SureSet 229 |
| | | SureSet 230 |
| | | LockSet 202 |
| | | LockForce 212 |
| | | LockForce 2025 |
| | | LockForce 2480 |
| Magna-Bulb | 1/4 | SureSet 229 |
| | | SureSet 230 |
| | | LockSet 202 |
| | | LockForce 212 |
| | | LockForce 2025 |
| | | LockForce 2480 |

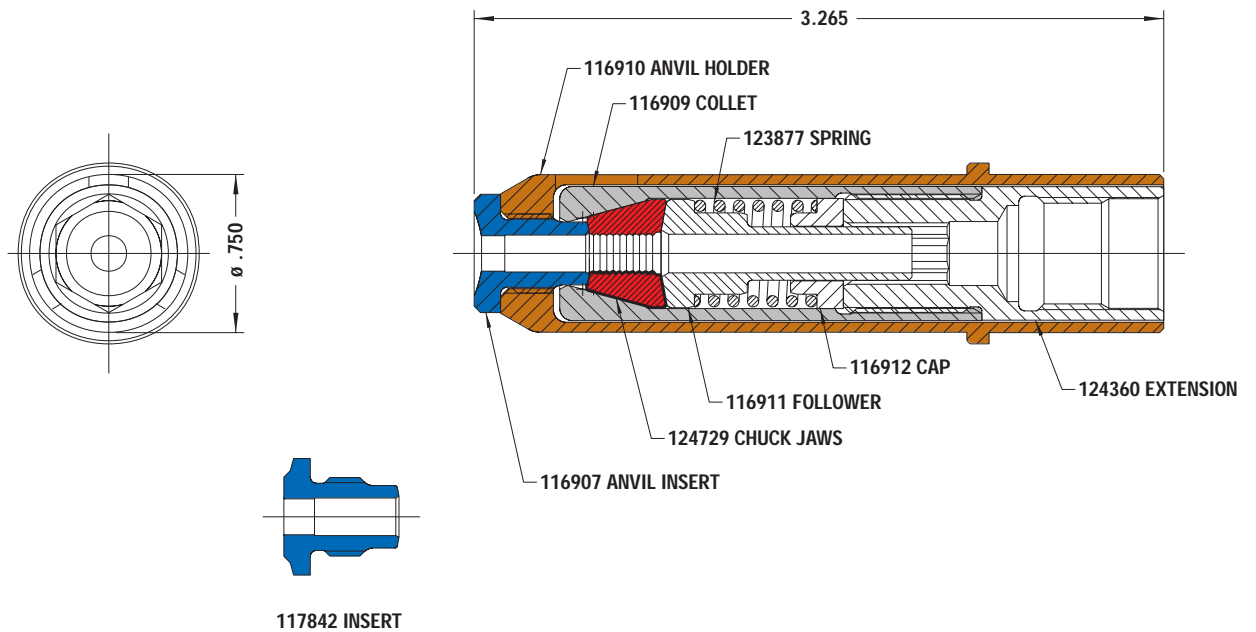
99-3303 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|----------------|
| Magna-Lok | 3/16 | LockSet 202 |
| | | LockForce 212 |
| | | LockForce 2480 |
| Magna-Bulb | 3/16 | LockSet 202 |
| | | LockForce 212 |
| | | LockForce 2480 |
| Auto-Bulb | 3/16 | LockSet 202 |
| | 1/4 | LockSet 202 |

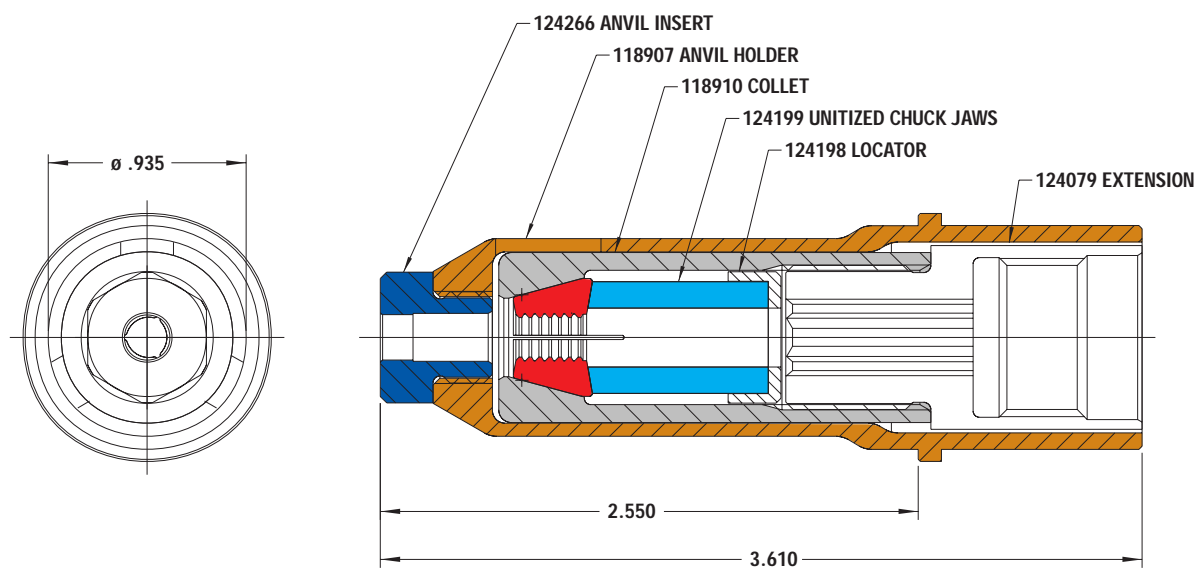
99-3305 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|----------------|
| Magna-Lok | 1/4 | LockForce 212 |
| | | LockForce 2480 |
| Magna-Bulb | 1/4 | LockForce 212 |
| | | LockForce 2480 |
| Auto-Bulb | 3/16 | SureSet 230 |
| | | LockForce 2025 |
| | 1/4 | SureSet 230 |
| | | LockForce 2025 |

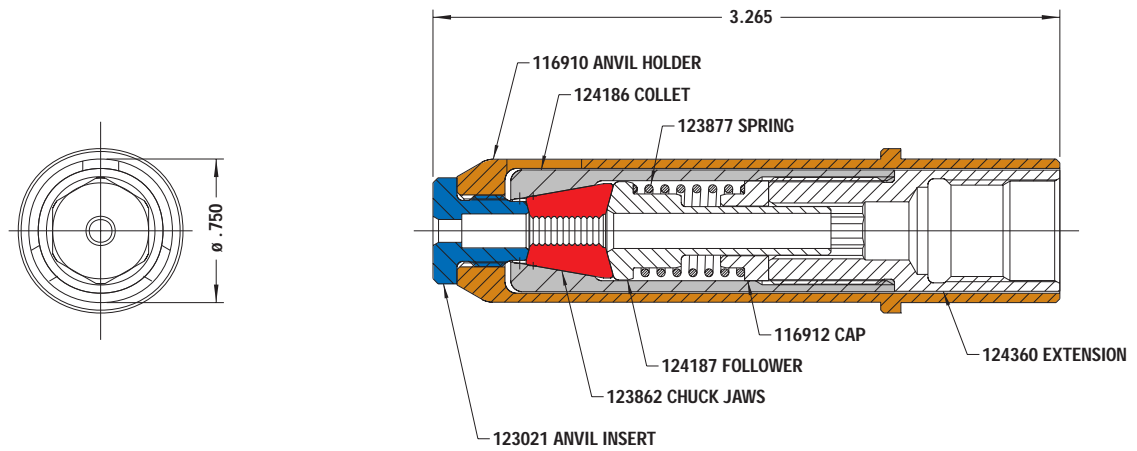
99-3307 Nose Assembly



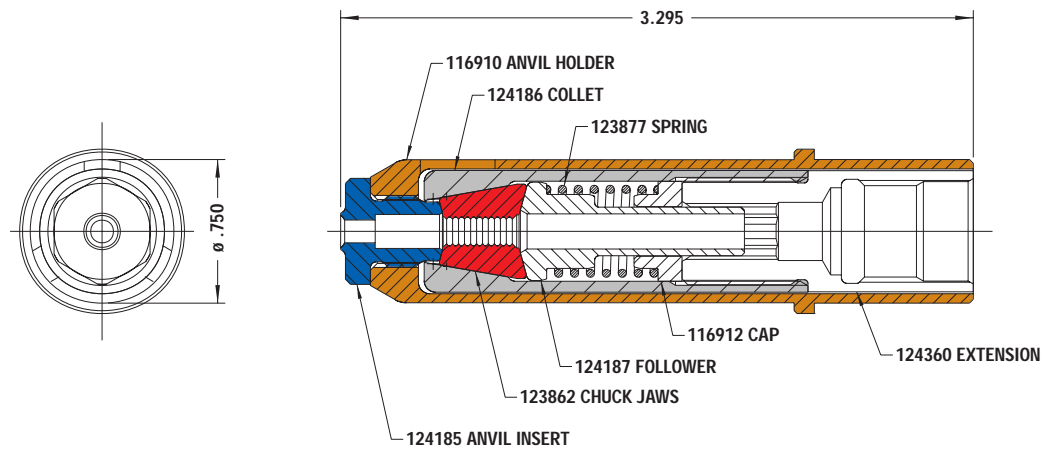
Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|---|
| Magna-Bulb | 5/16 | Super LockForce 246 Super LockForce 2580 |

99-3310 f Nose Assembly



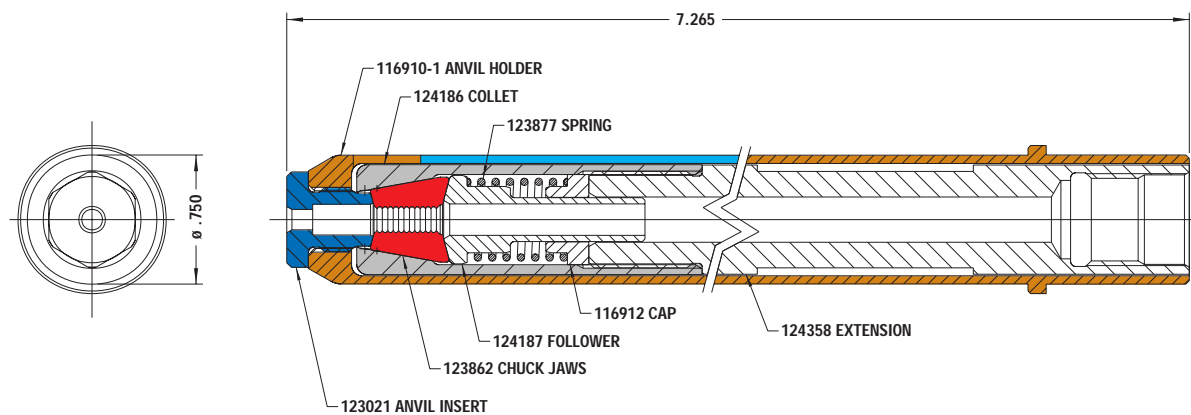
99-3310 p Nose Assembly



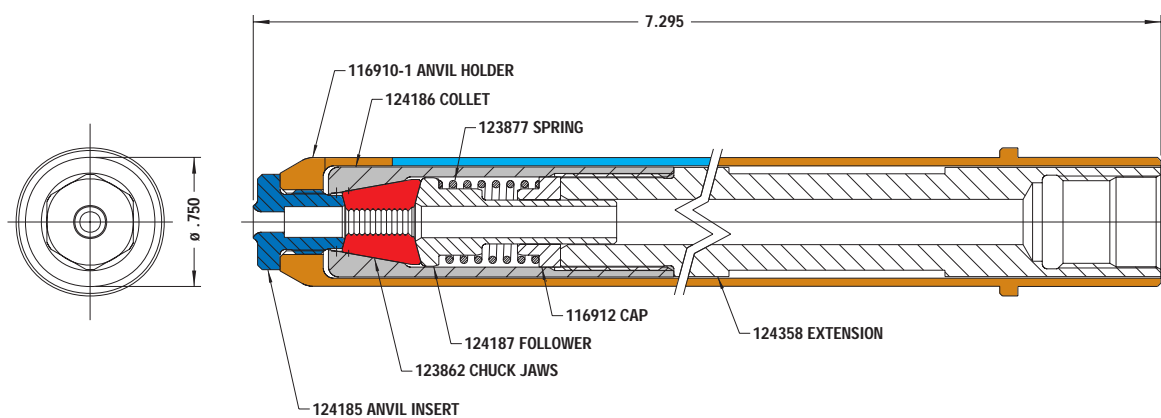
Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|----------------|
| Magna-Tite | 3/16 | LockSet 202 |
| | | LockForce 2480 |

99-3311 f Nose Assembly



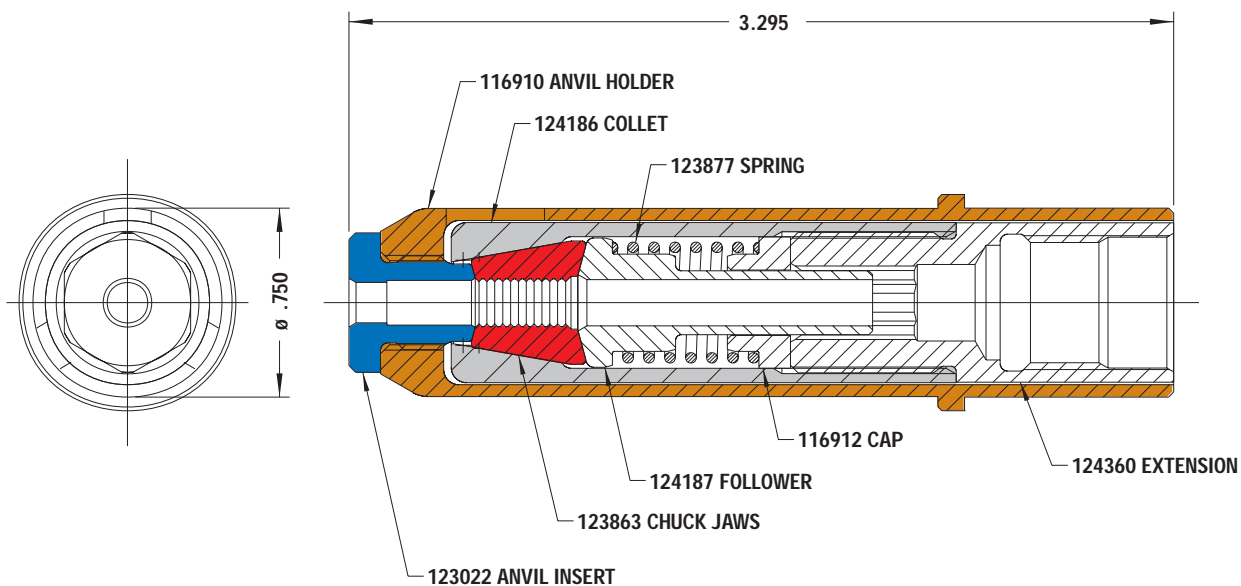
99-3311 p Nose Assembly



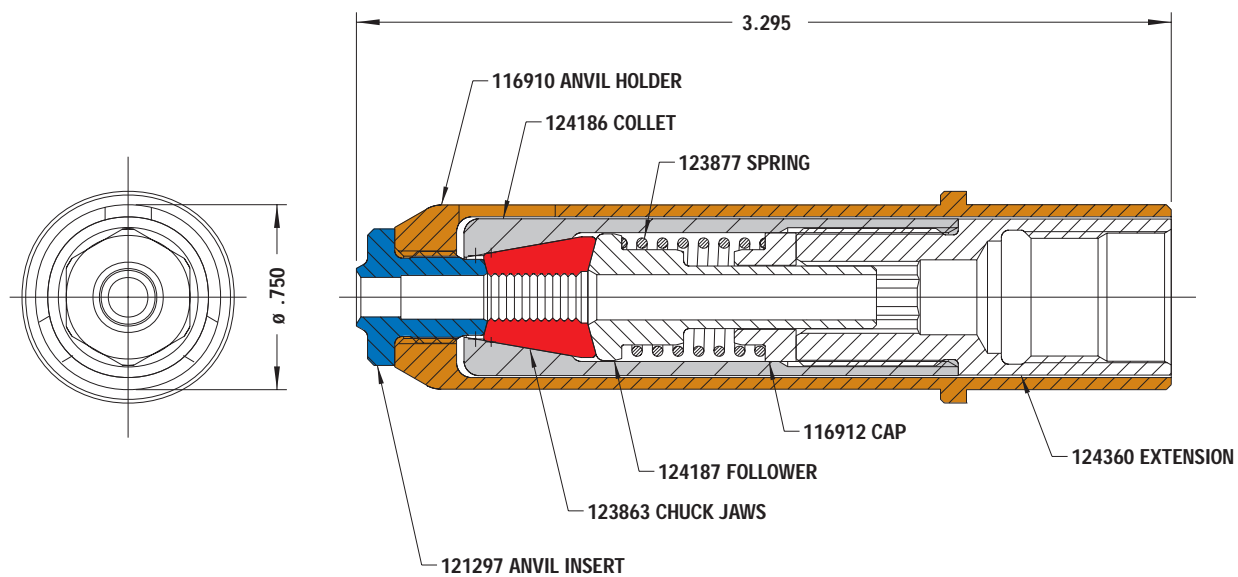
Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|----------------|
| Magna-Tite | 1/4 | LockSet 202 |
| | | LockForce 2480 |

99-3312 f Nose Assembly



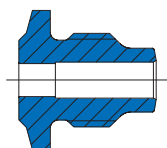
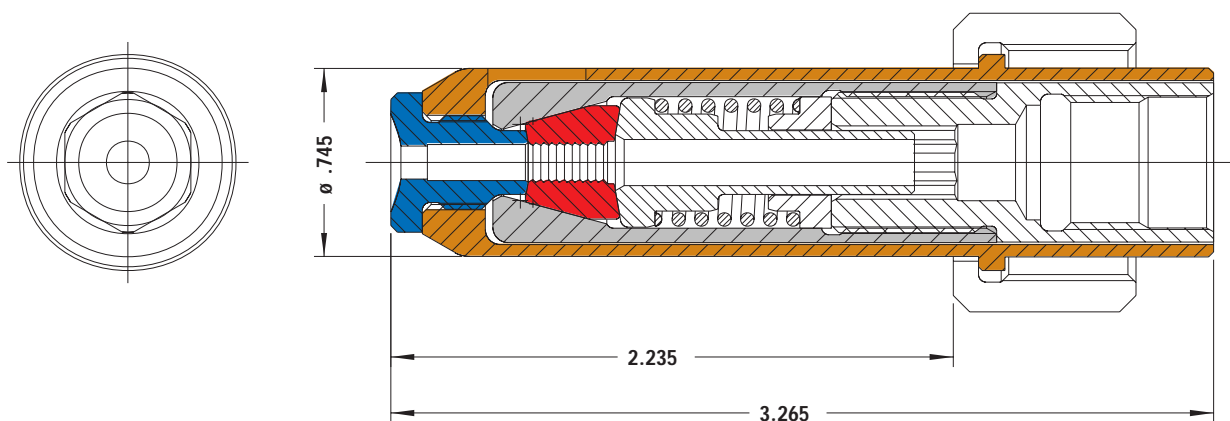
99-3312 p Nose Assembly



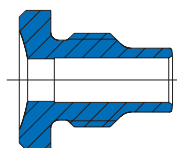
Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|-------------------------------|
| Magna-Tite | 1/4 | LockSet 202 LockForce 2480 |

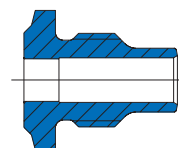
99-3316-68 Nose Assembly



125105 INSERT
-06 FLUSH HEAD



125106 INSERT
-08 PROTRUDING & TRUSS HEAD

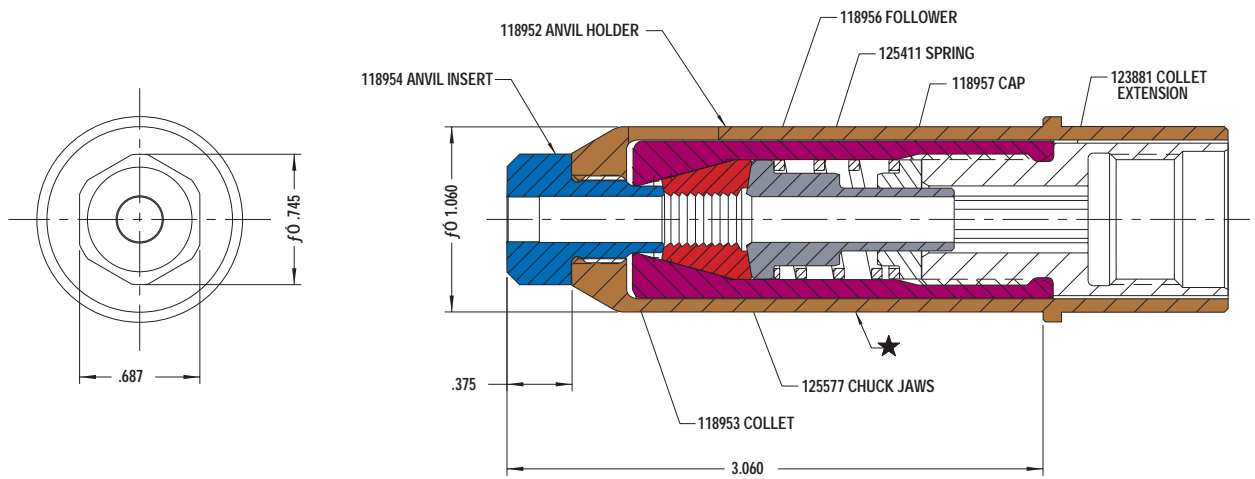


125107 INSERT
-08 FLUSH HEAD

Compatible Fastener

| Type | Diameter | Tool |
|-----------|----------|----------------|
| Magna-Lok | 3/16 | SureSet 229 |
| | | SureSet 230 |
| | | LockSet 202 |
| | | LockForce 212 |
| | | LockForce 2480 |
| | 1/4 | SureSet 229 |
| | | SureSet 230 |
| | | LockSet 202 |
| | | LockForce 212 |
| | | LockForce 2480 |

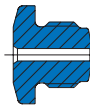
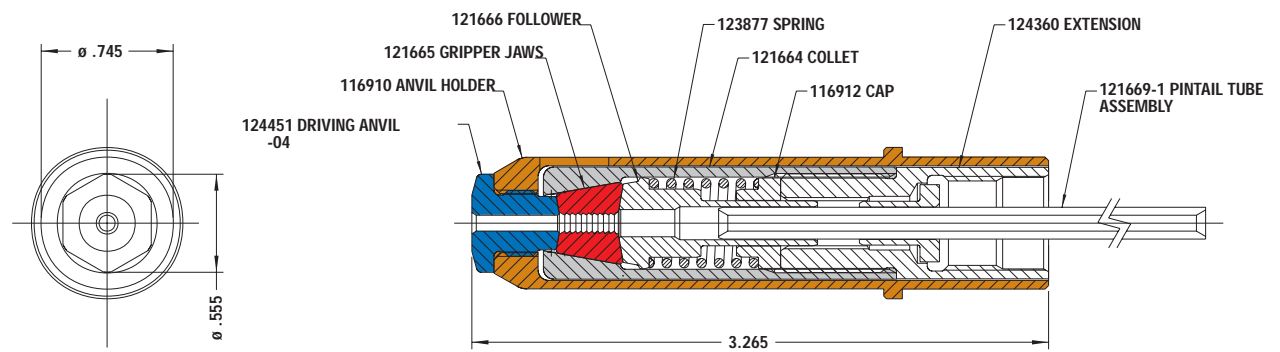
99-3318 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|-----------|----------|----------------------|
| Magna-Lok | 3/8 | Super LockForce 246 |
| | | Super Lockforce 2580 |

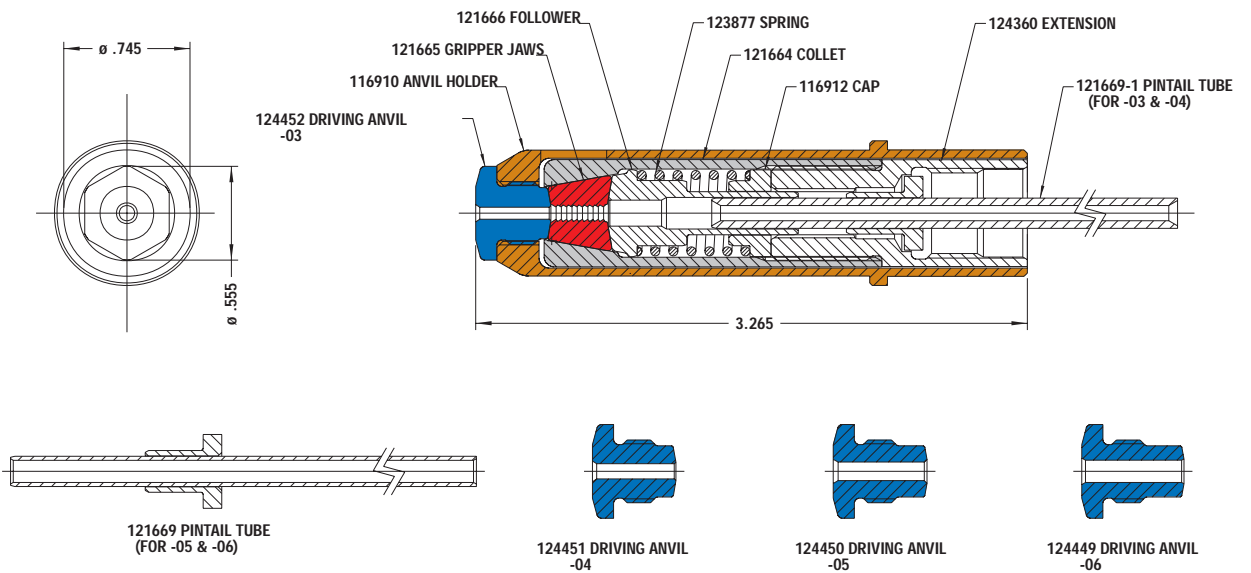
99-3422-34 Nose Assembly

124452 DRIVING ANVIL
-03

Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|----------------|
| Grip-Rite | 3/32 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| | 1/8 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| StrongHold | 1/8 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |

99-3422-3456 Nose Assembly



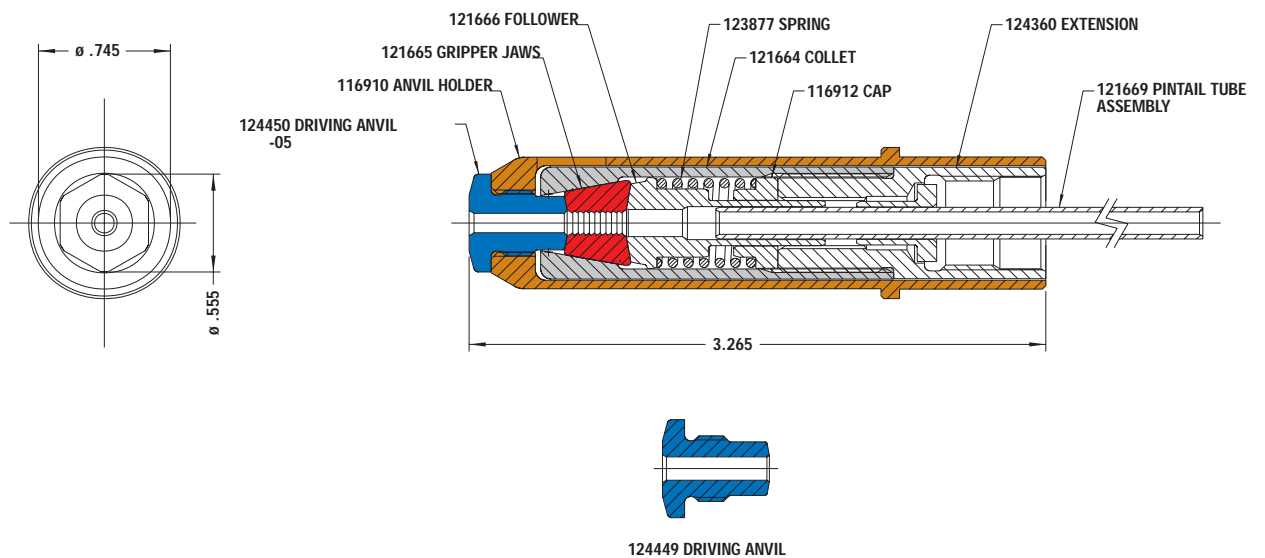
Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|----------------|
| Grip-Rite | 3/32 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| | 1/8 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| | 5/32 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| | 3/16 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| Auto-Clamp | 3/16 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |

Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|----------------|
| StrongHold | 1/8 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| | 5/32 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| A-Lock | 3/16 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |

99-3422-56 Nose Assembly



Compatible Fastener

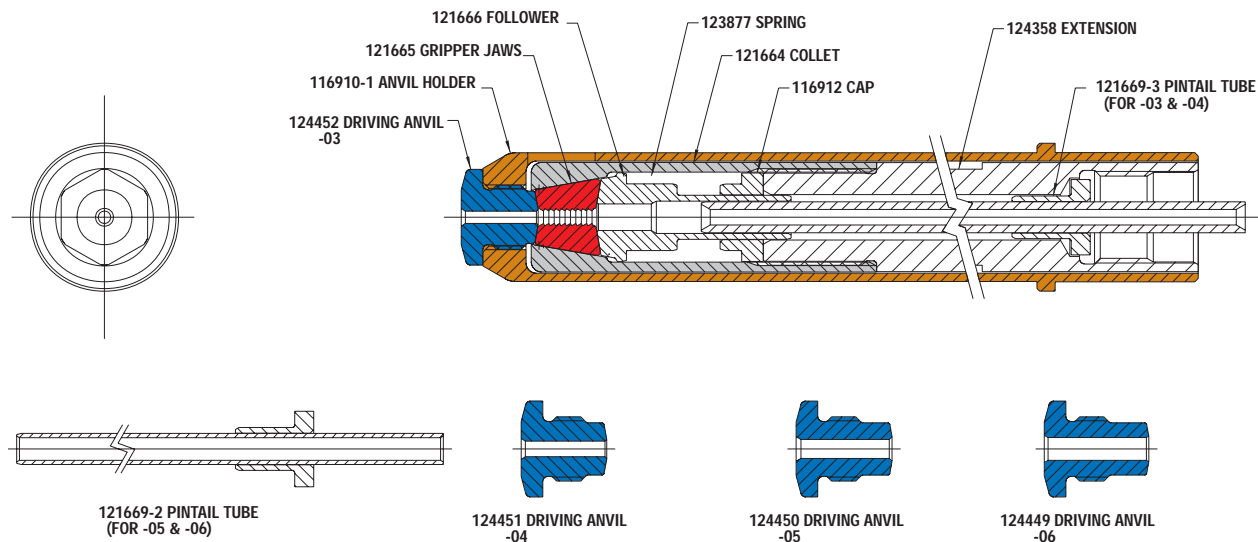
| Type | Diameter | Tool |
|------------|----------|----------------|
| Grip-Rite | 5/32 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| | 3/16 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| Auto-Clamp | 3/16 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |

Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|----------------|
| StrongHold | 5/32 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| | 3/16 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| A-Lock | 3/16 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |

99-3423-3456 Nose Assembly

99-3423-3456 Nose Assembly



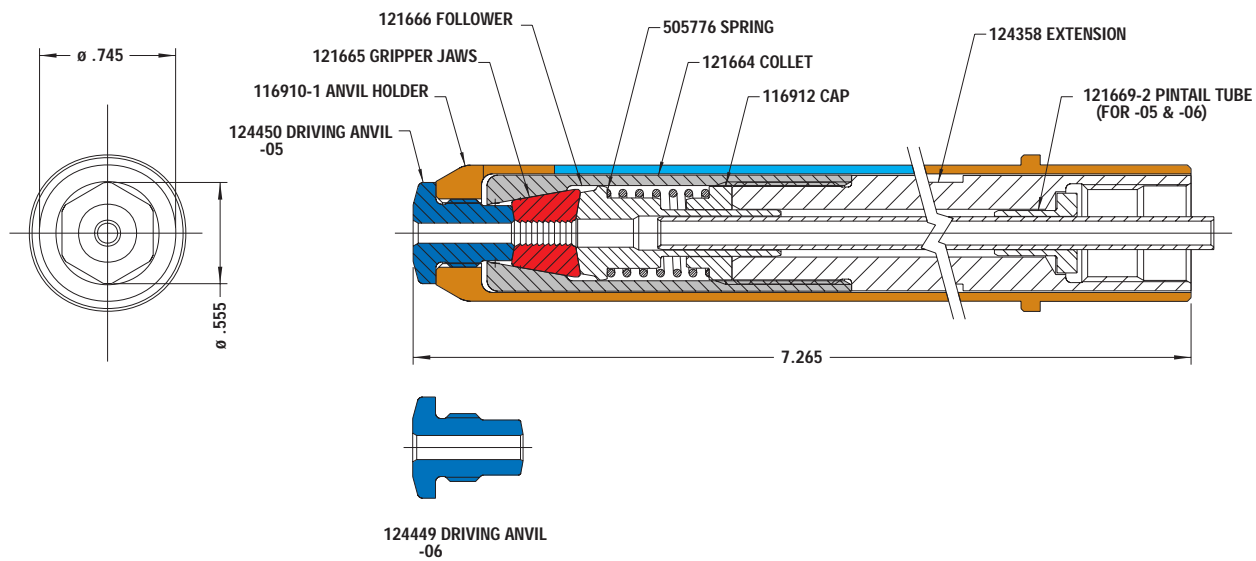
Compatible Fastener

| Type | Diameter | Tool |
|------------|----------------|----------------|
| Grip-Rite | 3/32 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| | 1/8 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| | 5/32 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| 3/16 | SureSet 229 | |
| | LockSet 202 | |
| | LockForce 2480 | |
| Auto-Clamp | 3/16 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |

Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|----------------|
| StrongHold | 1/8 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| | 5/32 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| | 3/16 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| A-Lock | 3/16 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |

99-3423-56 Nose Assembly



Compatible Fastener

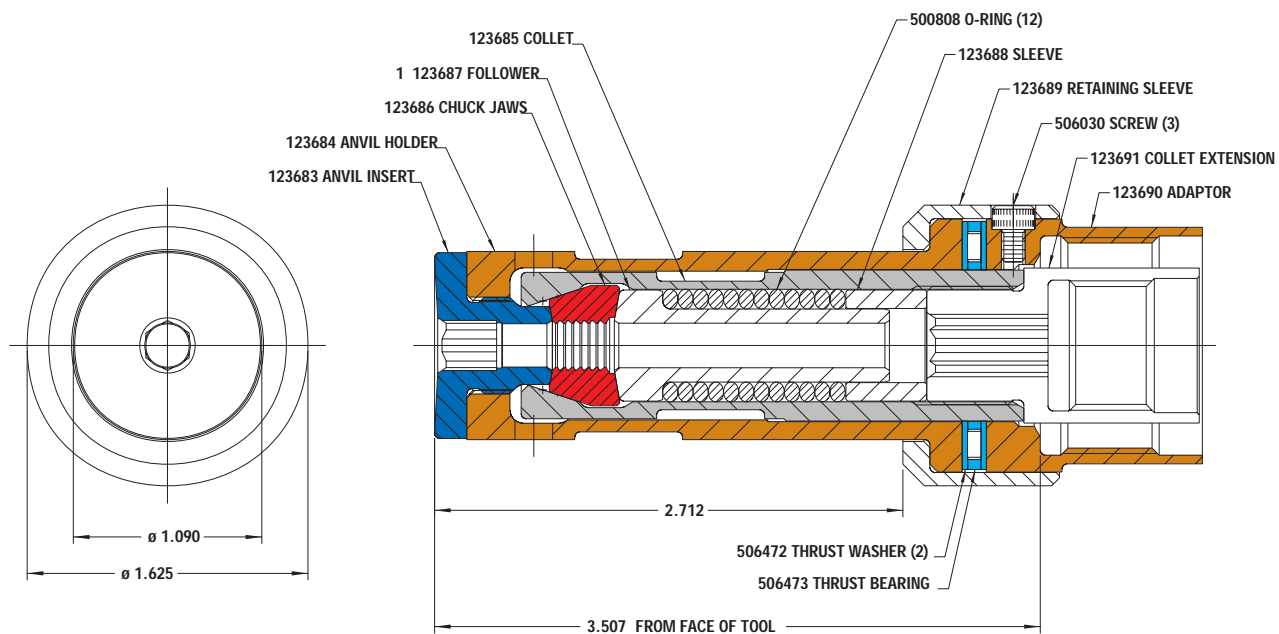
| Type | Diameter | Tool |
|------------|----------|----------------|
| Grip-Rite | 5/32 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| | 3/16 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| Auto-Clamp | 3/16 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |

Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|----------------|
| StrongHold | 5/32 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| | 3/16 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| A-Lock | 3/16 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |

99-3438 Nose Assembly

99-3438 Nose Assembly

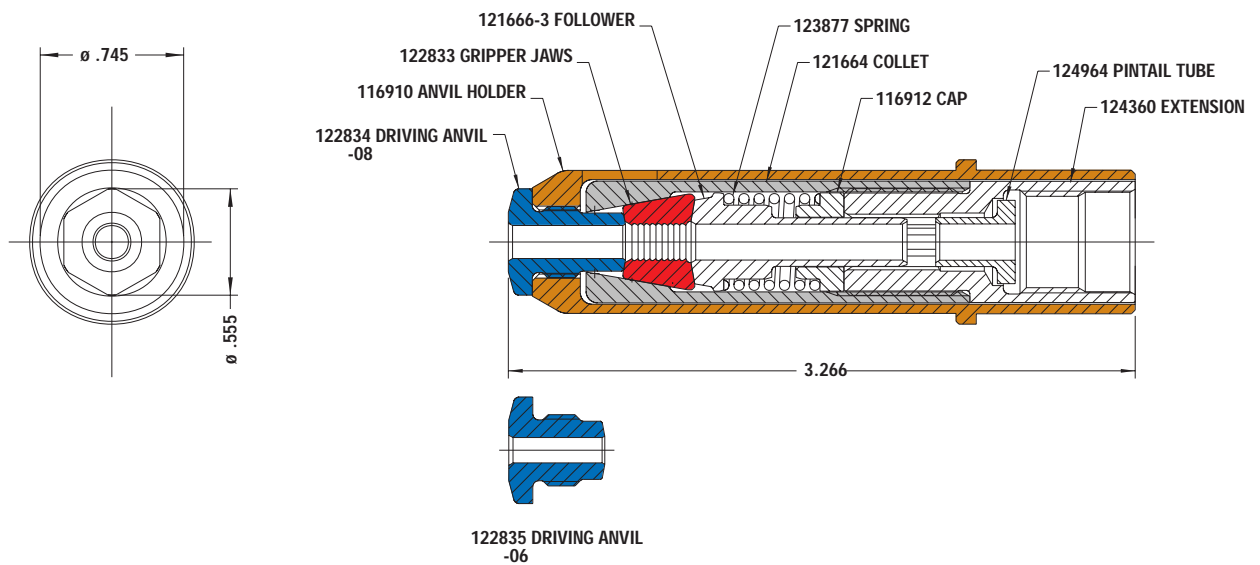


Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|----------------------|
| Hucktainer | -12 | Super LockForce 246 |
| | | Super LockForce 2580 |

99-3445-68 Nose Assembly

99-3445-68 Nose Assembly

**Compatible Fastener**

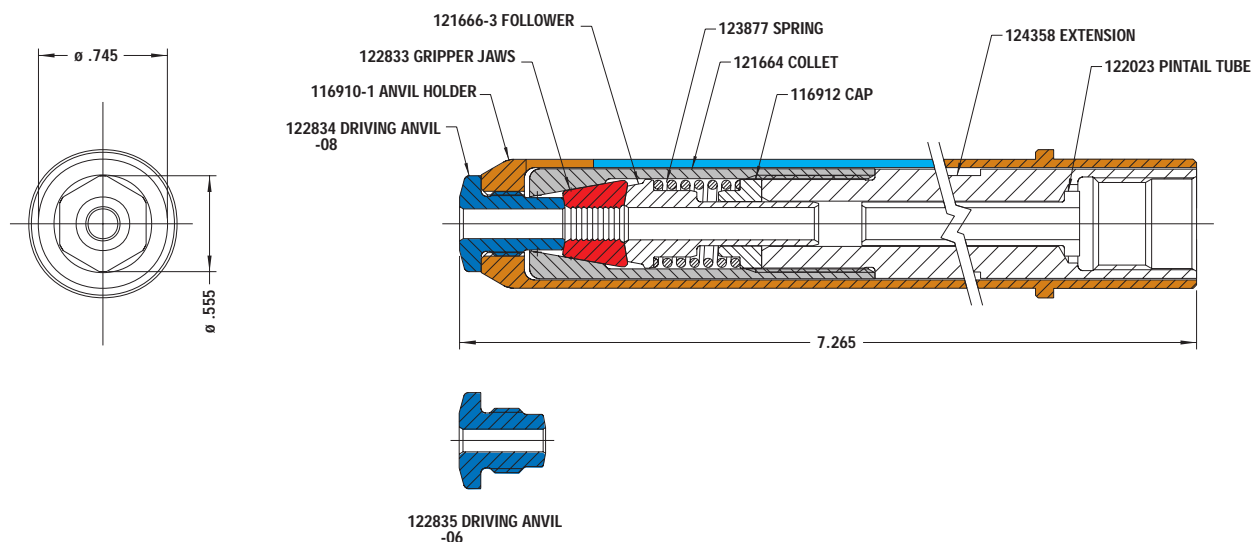
| Type | Diameter | Tool |
|------------|----------|----------------|
| Grip-Rite | 3/16 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| | 1/4 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| Auto-Clamp | 3/16 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| | 1/4 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |

Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|----------------|
| StrongHold | 3/16 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| | 1/4 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| A-Lock | 3/16 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |

99-3446-68 Nose Assembly

99-3446-68 Nose Assembly

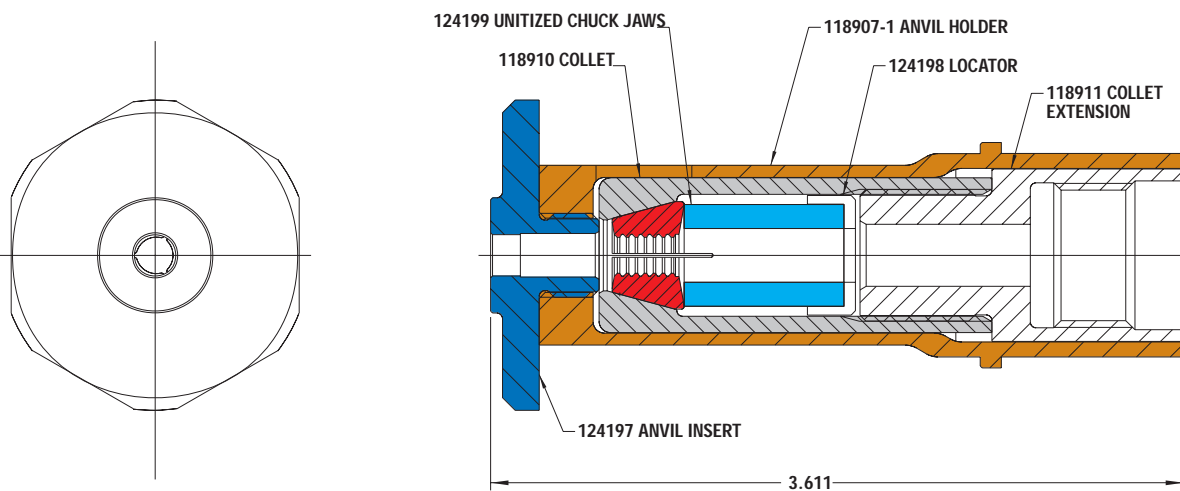
**Compatible Fastener**

| Type | Diameter | Tool |
|------------|----------|----------------|
| Grip-Rite | 3/16 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| | 1/4 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| Auto-Clamp | 3/16 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| | 1/4 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |

Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|----------------|
| StrongHold | 3/16 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| | 1/4 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |
| A-Lock | 3/16 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |

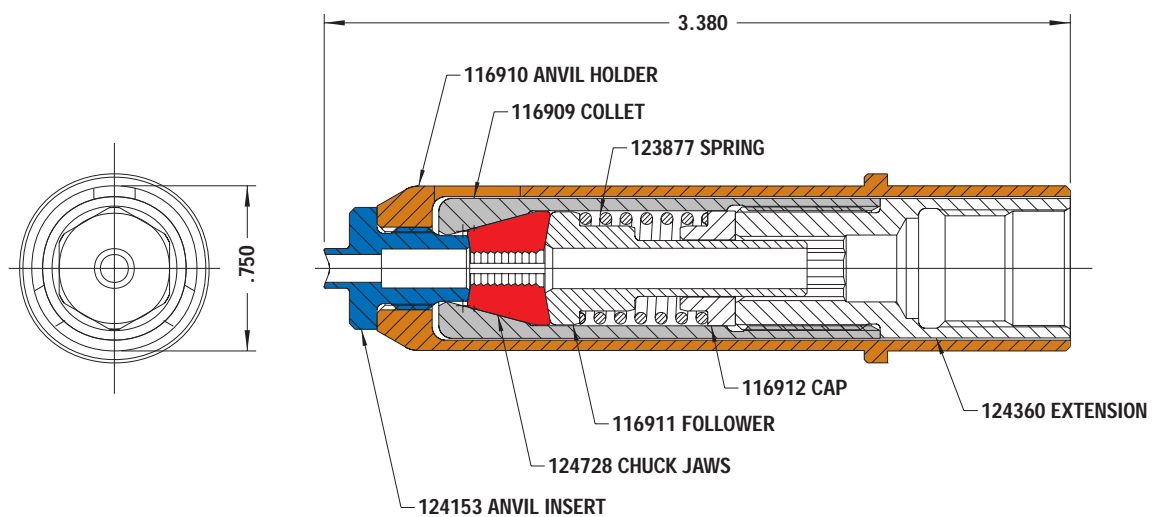
99-3452 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|----------------------|
| FloorTight | 5/16 | Super LockForce 245 |
| | | Super Lockforce 246 |
| | | Super LockForce 2580 |

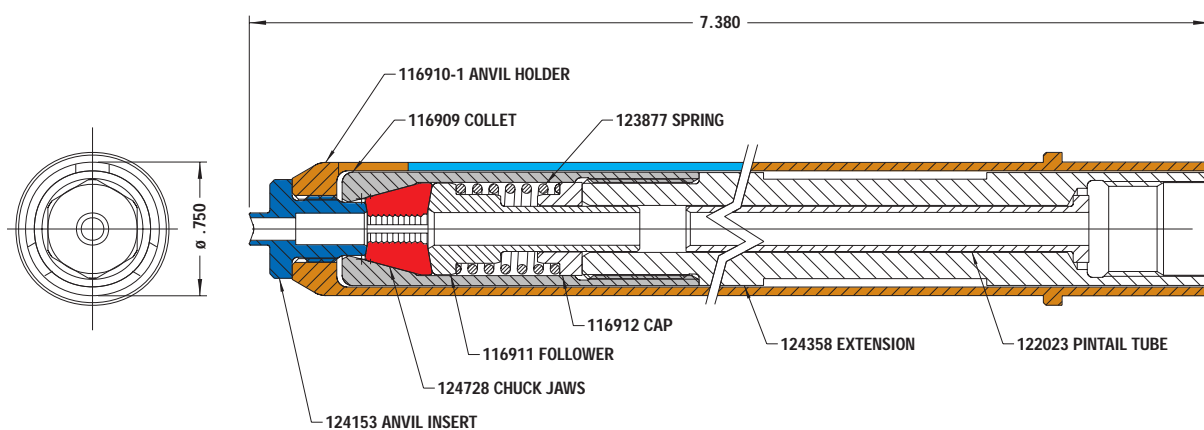
99-3460 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------|----------|----------------|
| Peel | 3/16 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |

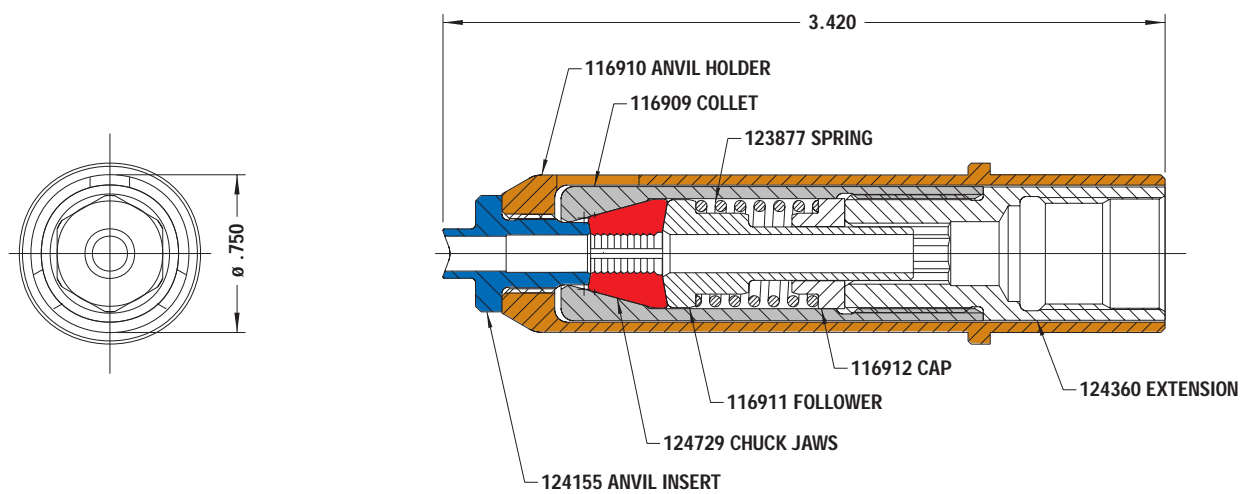
99-3461 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------|----------|----------------|
| Peel | 3/16 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |

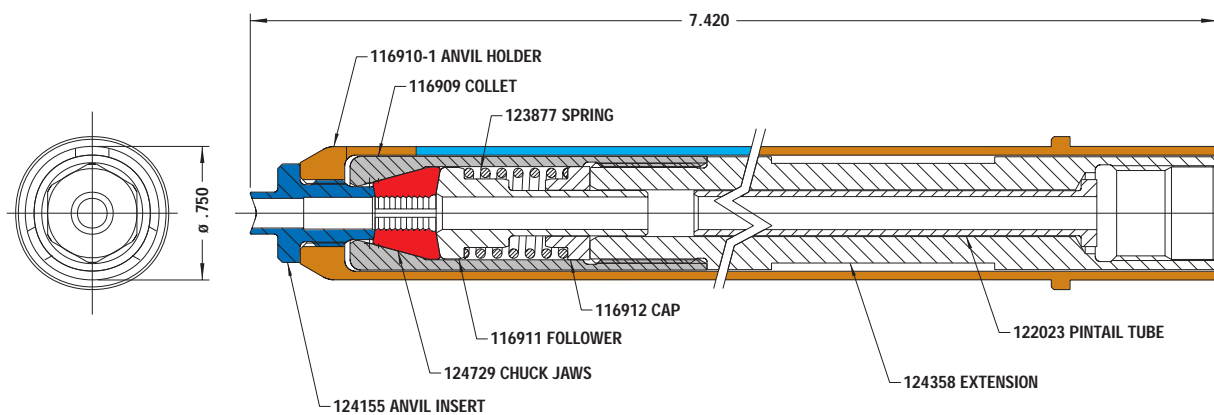
99-3462 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------|----------|----------------|
| Peel | 1/4 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |

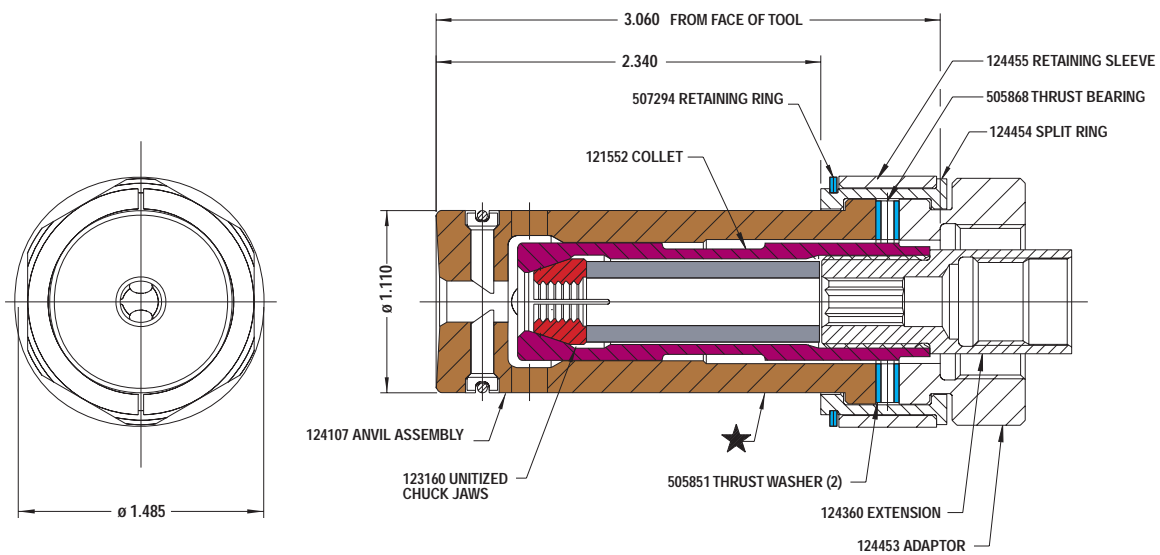
99-3463 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------|----------|----------------|
| Peel | 1/4 | SureSet 229 |
| | | LockSet 202 |
| | | LockForce 2480 |

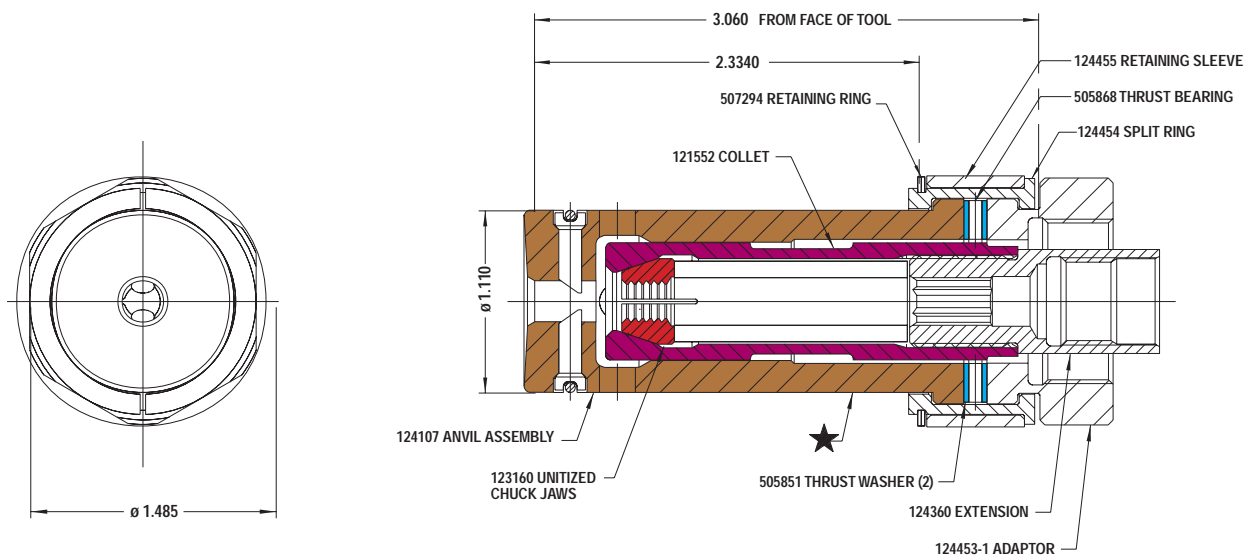
99-3464 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|----------------|
| Hucktainer | -12 | LockForce 212 |
| | | LockForce 2480 |

99-3465 Nose Assembly

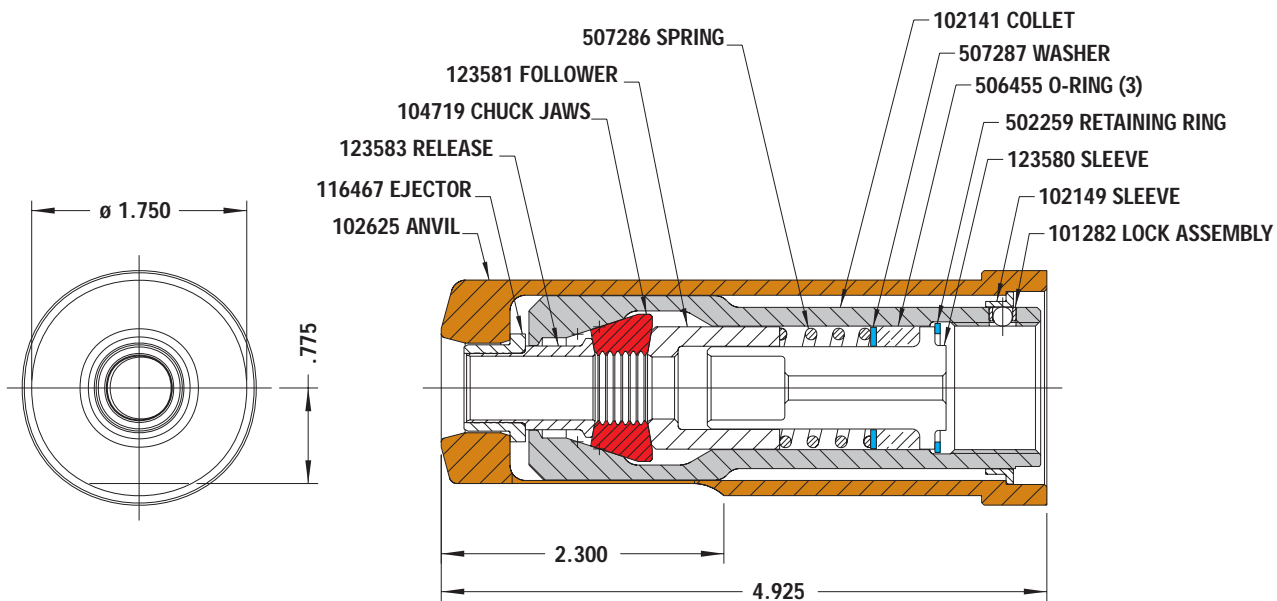


Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|-------------------------------|
| Hucktainer | -12 | SureSet 230 LockForce 2025 |

99-5000 Nose Assembly

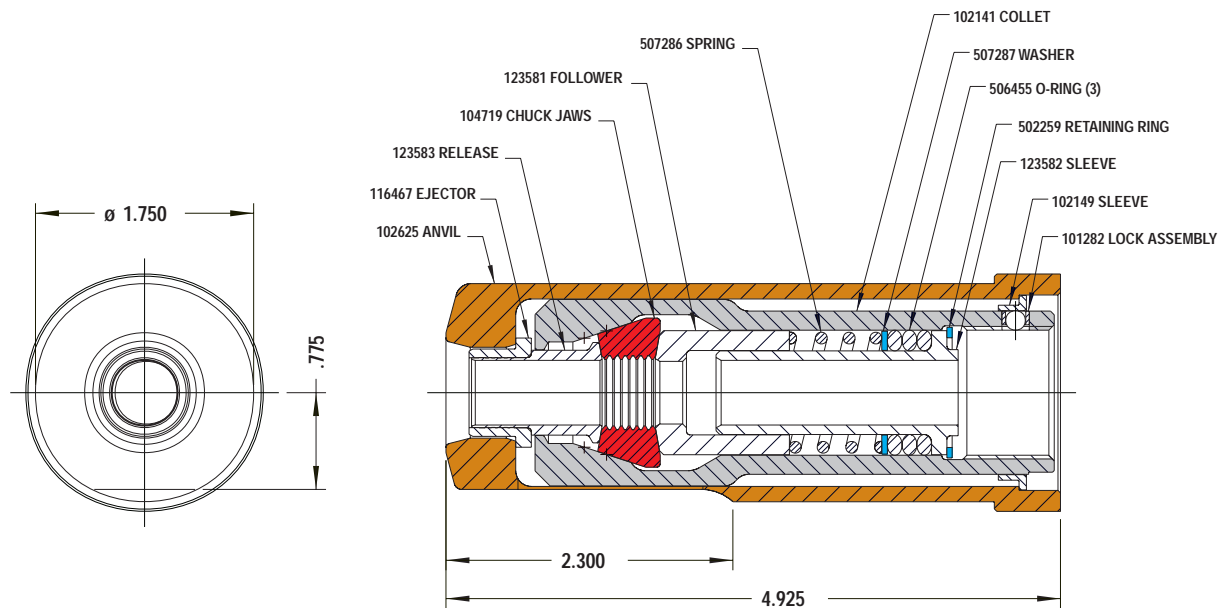
99-5000 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------|----------|-------------------|
| C50L | 1/2 | PowerDrive FE5901 |

99-5002 Nose Assembly

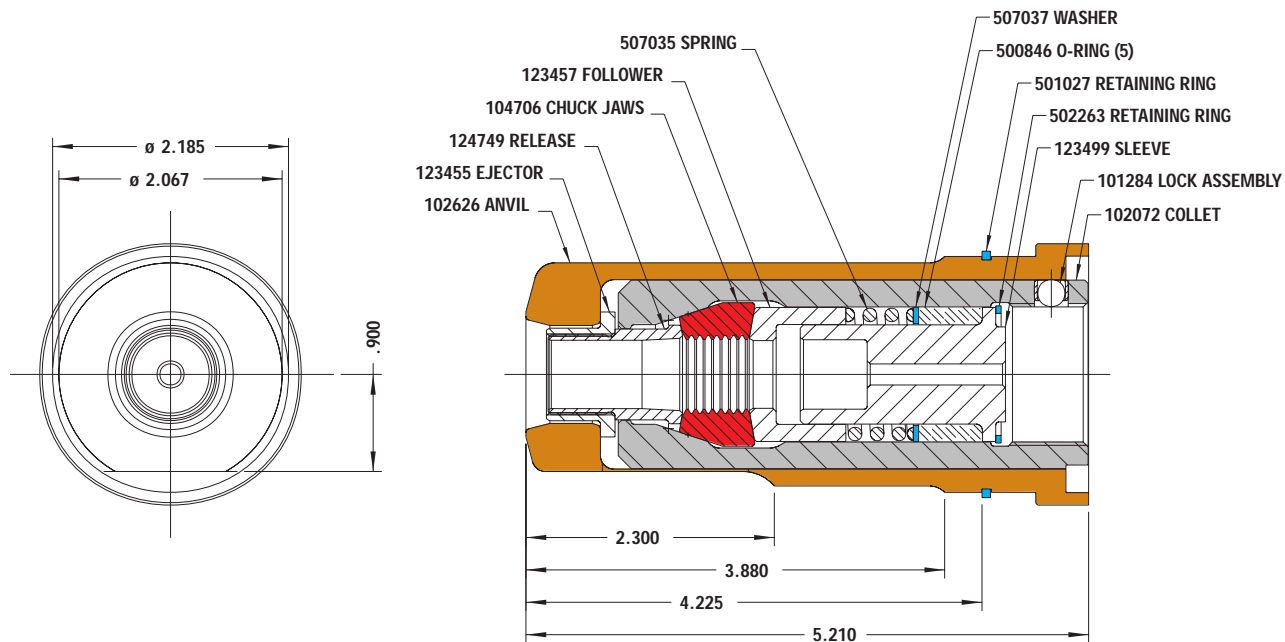


Compatible Fastener

| Type | Diameter | Tool |
|------|----------|-----------------|
| C50L | 1/2 | PowerDrive 5901 |

99-5008 Nose Assembly

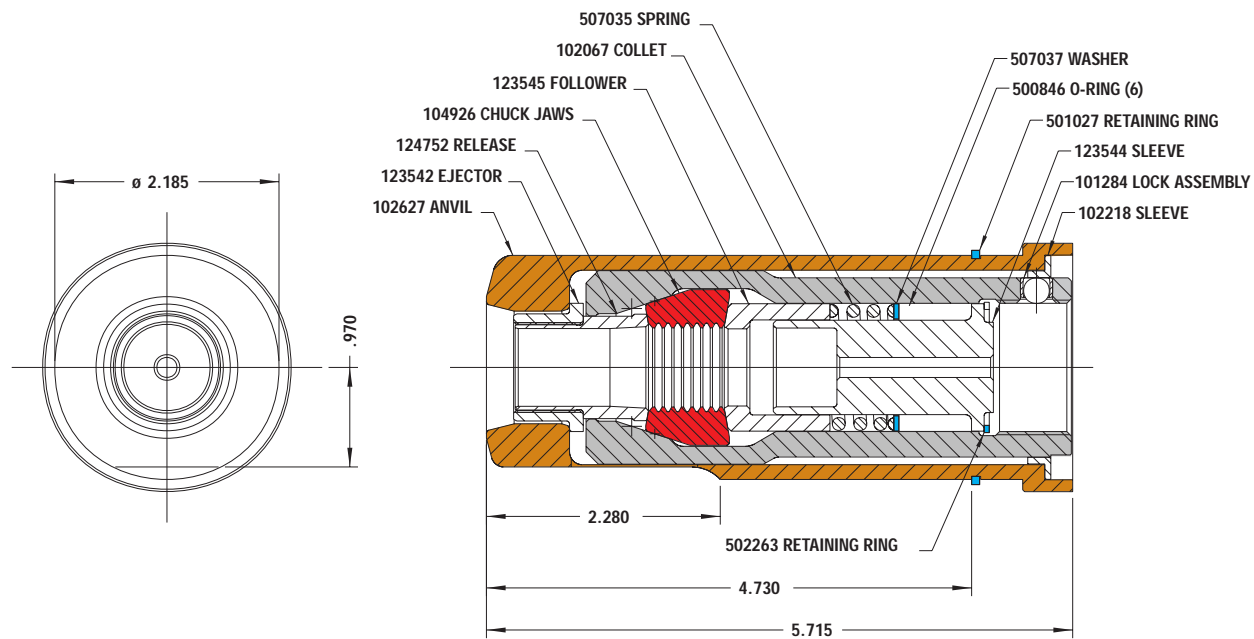
99-5008 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------|----------|----------------|
| C50L | 5/8 | PowerDrive 585 |
| | | PowerDrive 586 |

99-5010 Nose Assembly

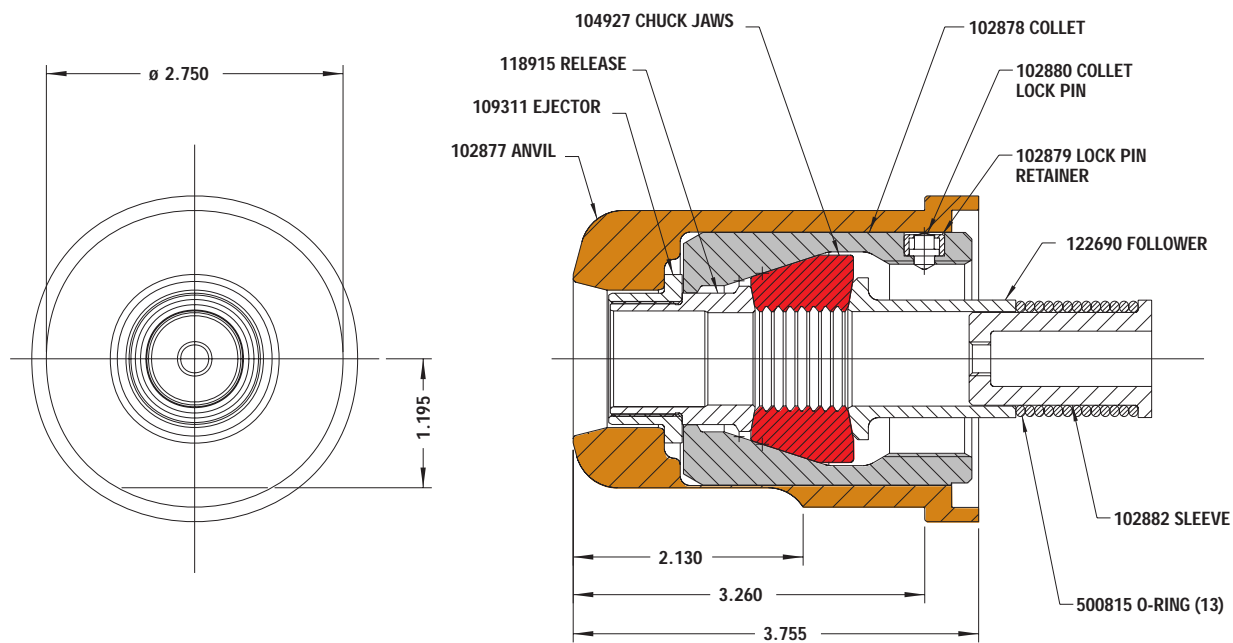


Compatible Fastener

| Type | Diameter | Tool |
|------|----------|----------------|
| C50L | 3/4 | PowerDrive 585 |
| | | PowerDrive 586 |

99-5014 Nose Assembly

99-5014 Nose Assembly

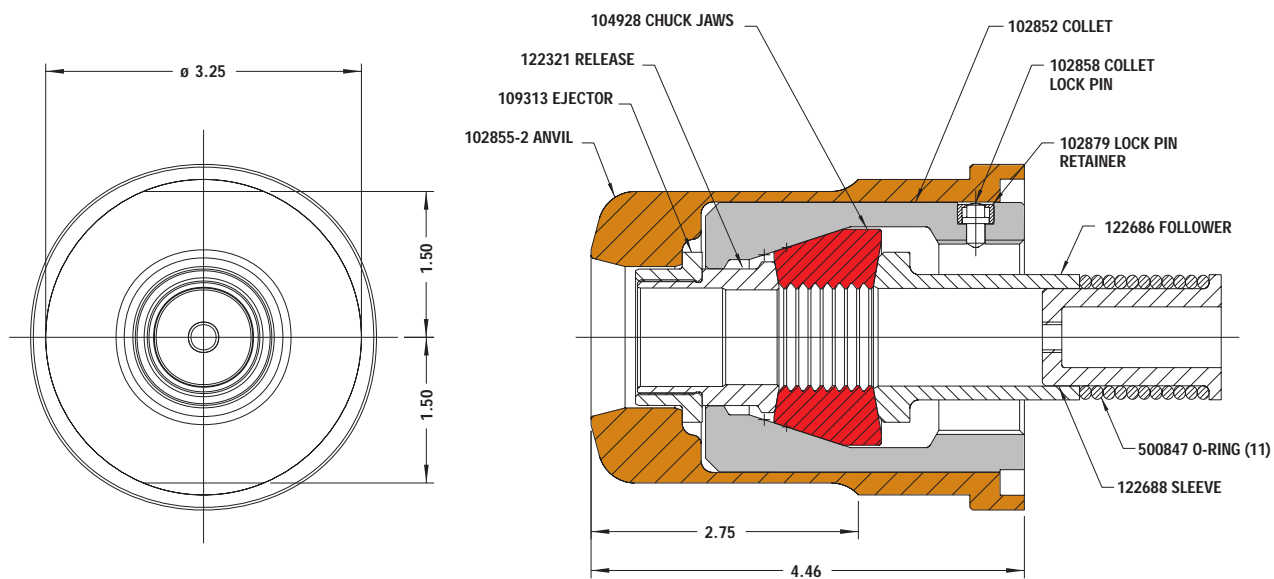


Compatible Fastener

| Type | Diameter | Tool |
|------|----------|----------------|
| C50L | 7/8 | PowerDrive 506 |

99-5016 Nose Assembly

99-5016 Nose Assembly

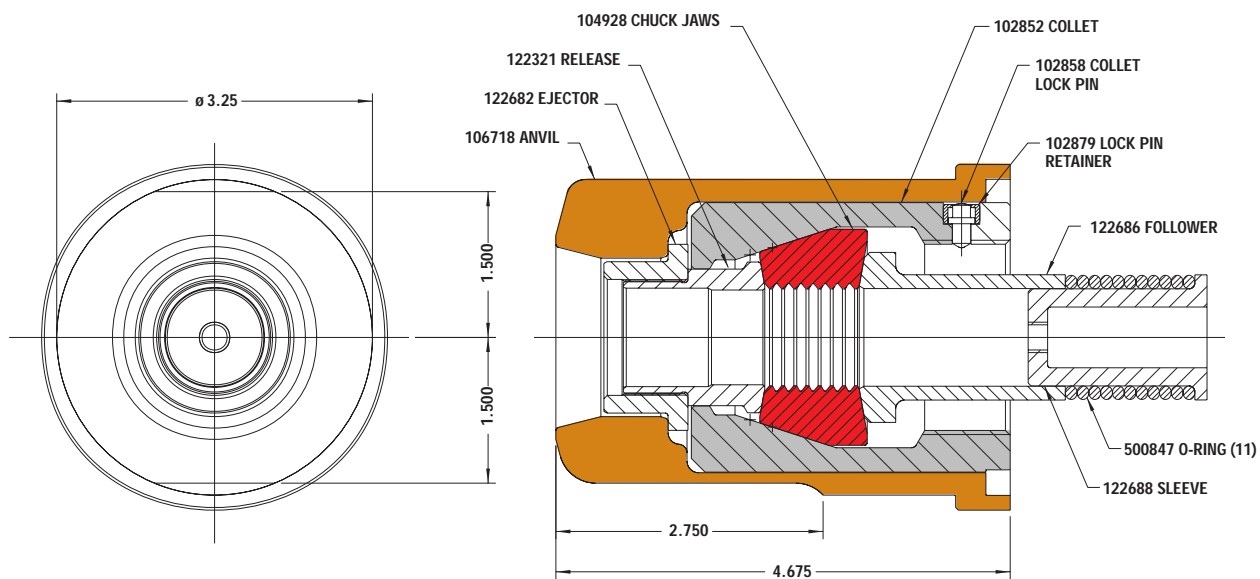


Compatible Fastener

| Type | Diameter | Tool |
|------|----------|----------------|
| C50L | 1" | PowerDrive 507 |

99-5019 Nose Assembly

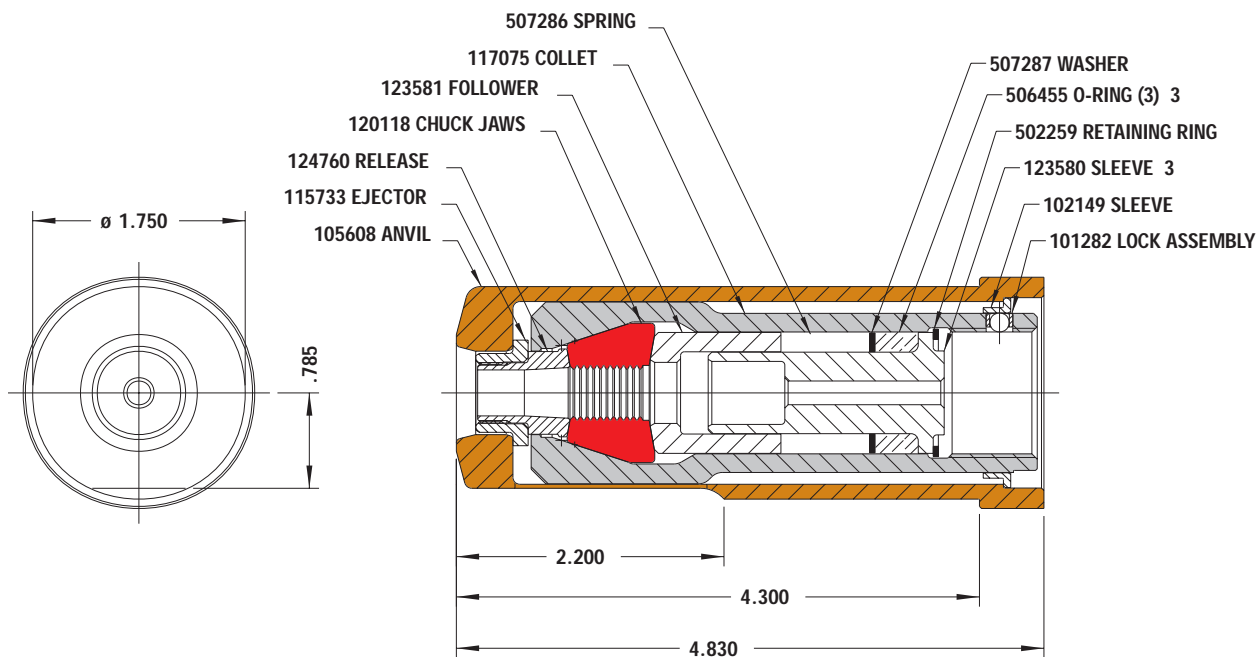
99-5019 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------|----------|----------------|
| C50L | 1 1/8 | PowerDrive 507 |

99-5100 Nose Assembly

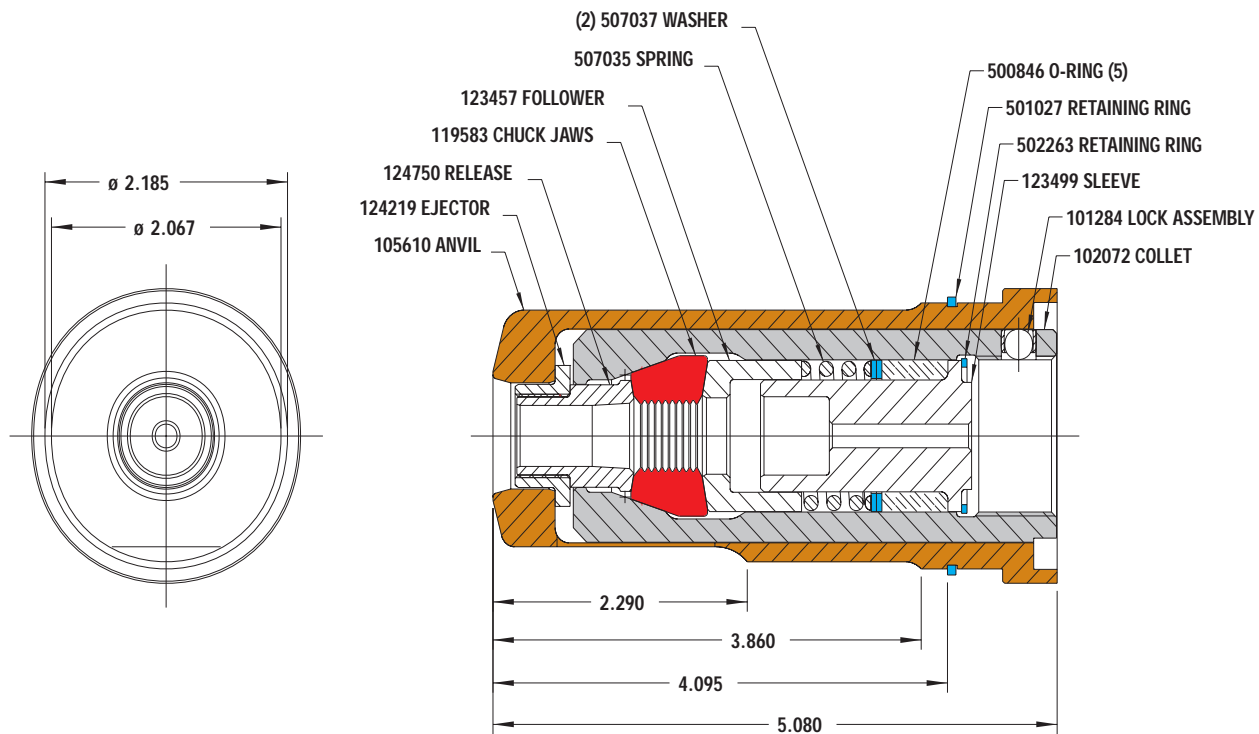


Compatible Fastener

| Type | Diameter | Tool |
|------|----------|-------------------|
| BOM | 1/2 | PowerDrive FE5901 |
| | | PowerDrive 5901 |

99-5102 Nose Assembly

99-5102 Nose Assembly

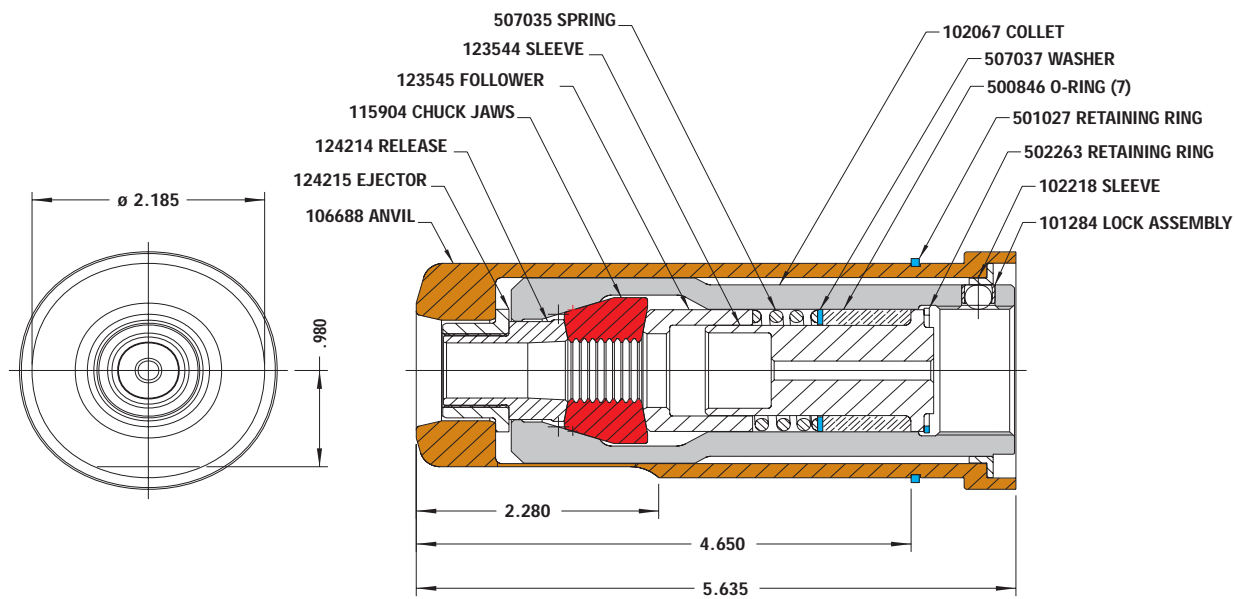


Compatible Fastener

| Type | Diameter | Tool |
|------|----------|----------------|
| BOM | 5/8 | PowerDrive 585 |
| | | PowerDrive 586 |

99-5103 Nose Assembly

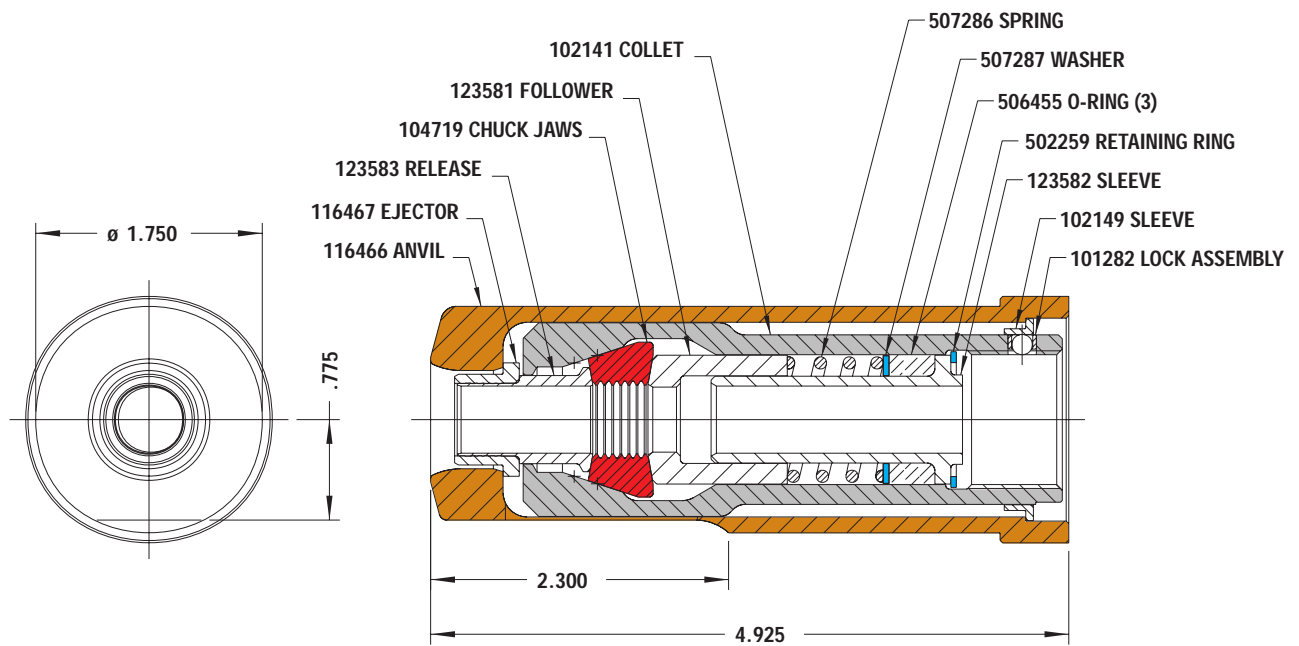
99-5103 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------|----------|----------------|
| BOM | 3/4 | PowerDrive 586 |

99-5300 Nose Assembly

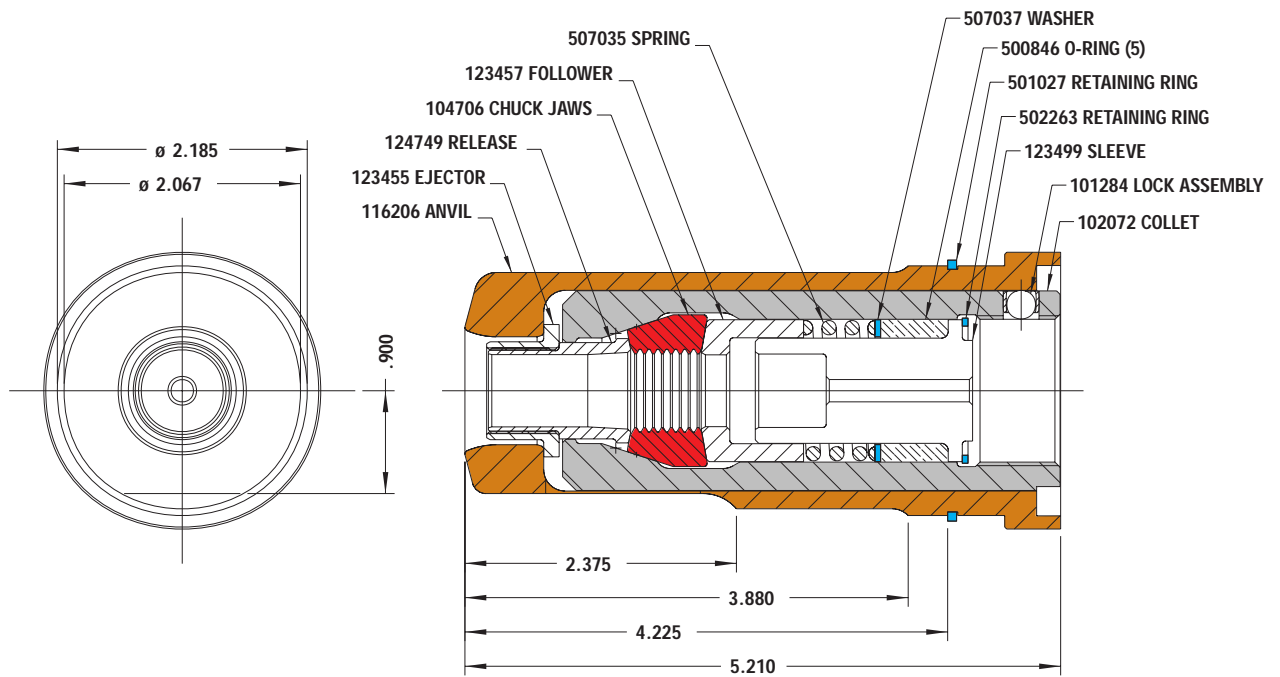


Compatible Fastener

| Type | Diameter | Tool |
|---------|----------|-------------------|
| HP8 | 1/2 | PowerDrive FE5901 |
| | | PowerDrive 5901 |
| HuckFit | 16mm | PowerDrive 586 |

99-5301 Nose Assembly

99-5301 Nose Assembly

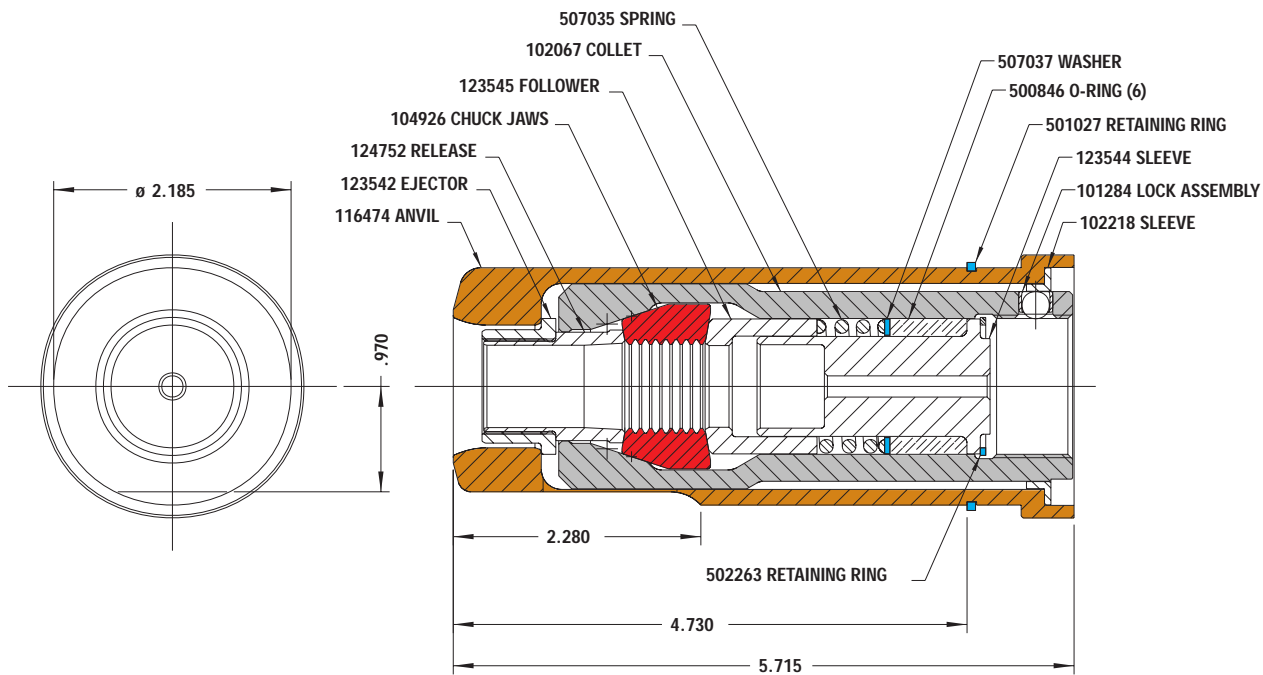


Compatible Fastener

| Type | Diameter | Tool |
|------|----------|----------------|
| HP8 | 5/8 | PowerDrive 585 |
| | | PowerDrive 586 |

99-5303 Nose Assembly

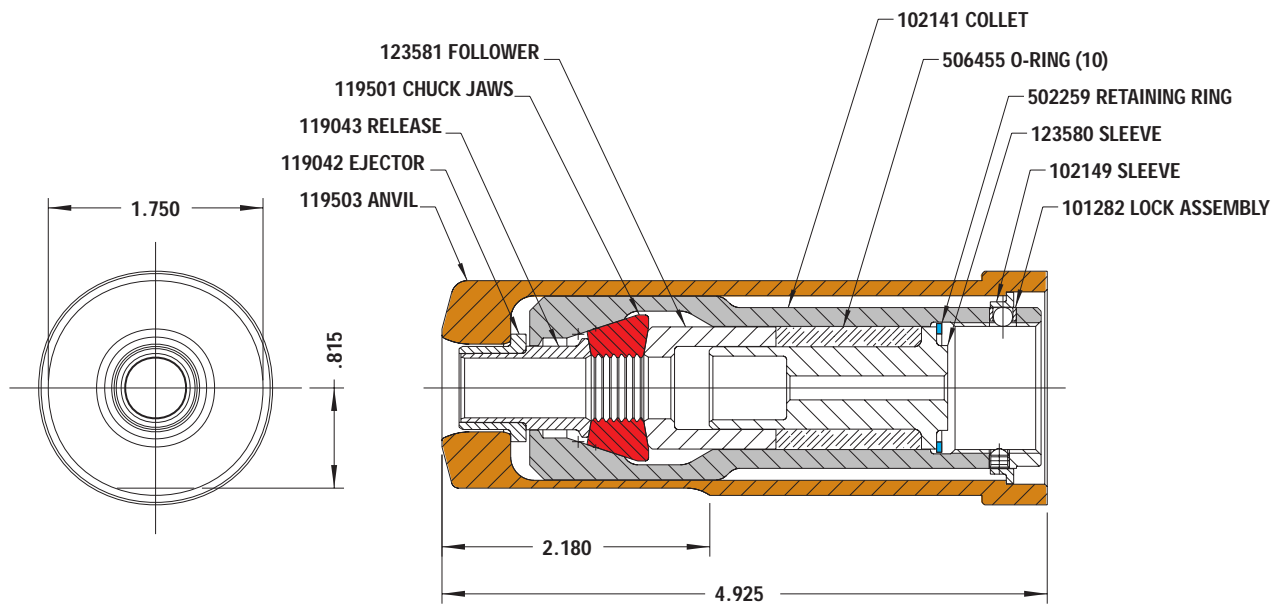
99-5303 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|----------|----------|----------------|
| HP8 | 3/4 | PowerDrive 585 |
| | | PowerDrive 586 |
| Huck-Fit | 3/4 | PowerDrive 585 |
| | | PowerDrive 586 |

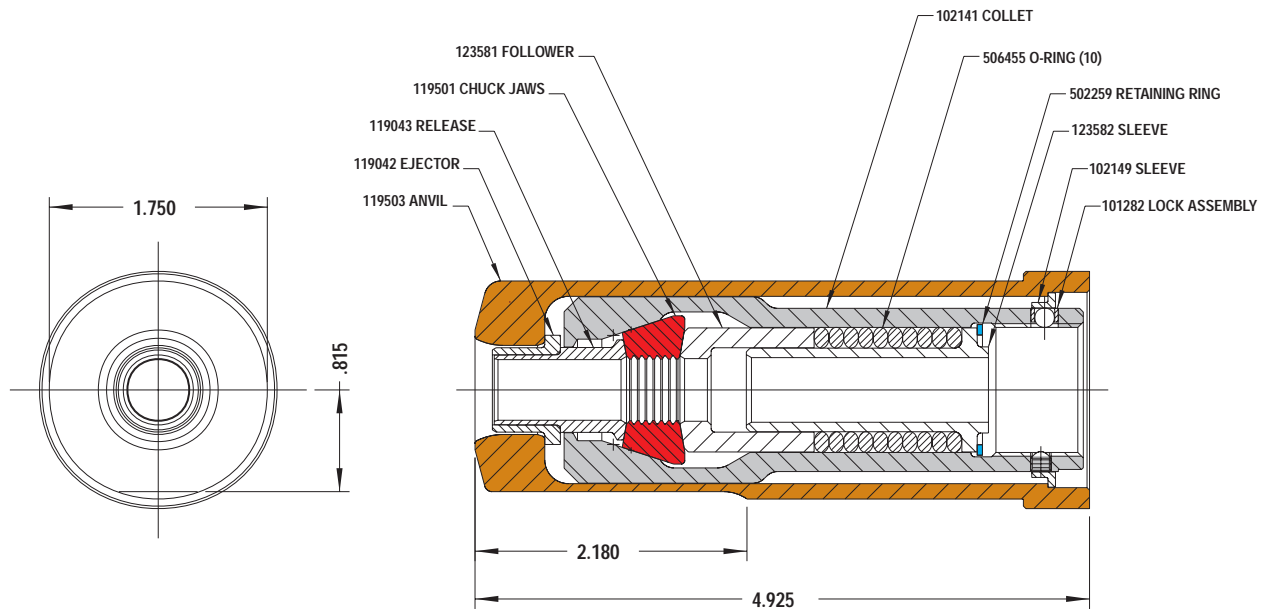
99-5404 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|---------|----------|-----------------|
| HuckFit | 12mm | PowerDrive 5901 |
| | 1/2 | PowerDrive 5901 |

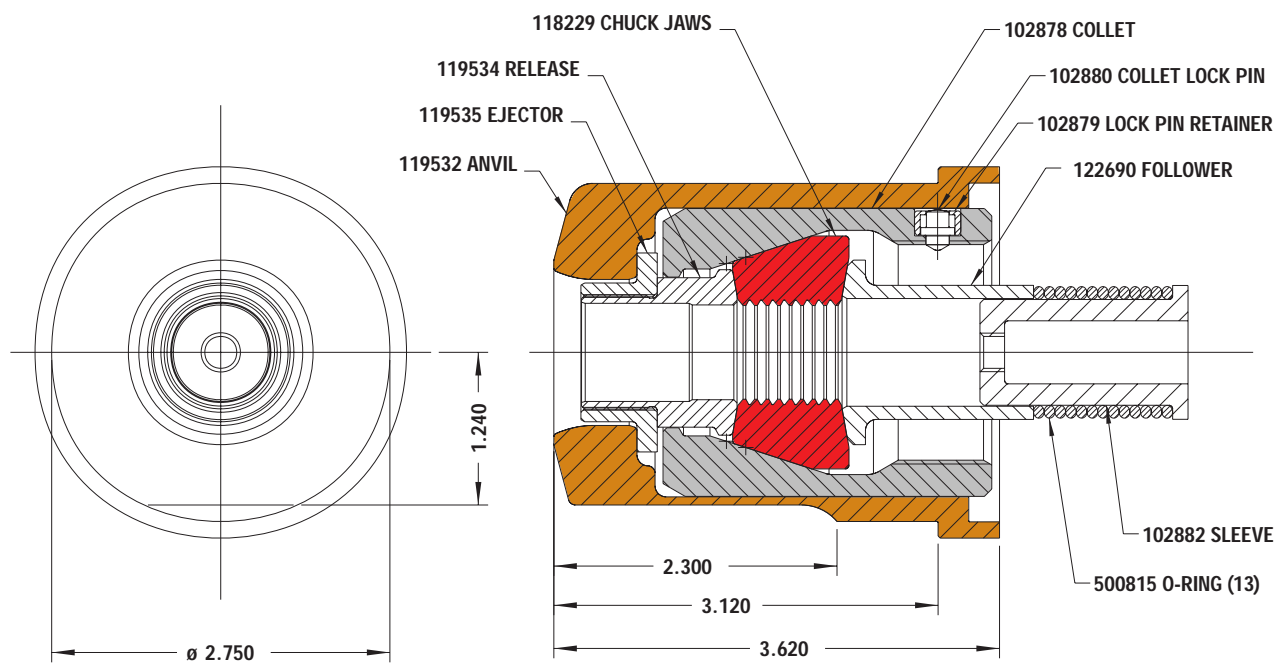
99-5406 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|----------|----------|-----------------|
| Huck-Fit | 12mm | PowerDrive 5901 |

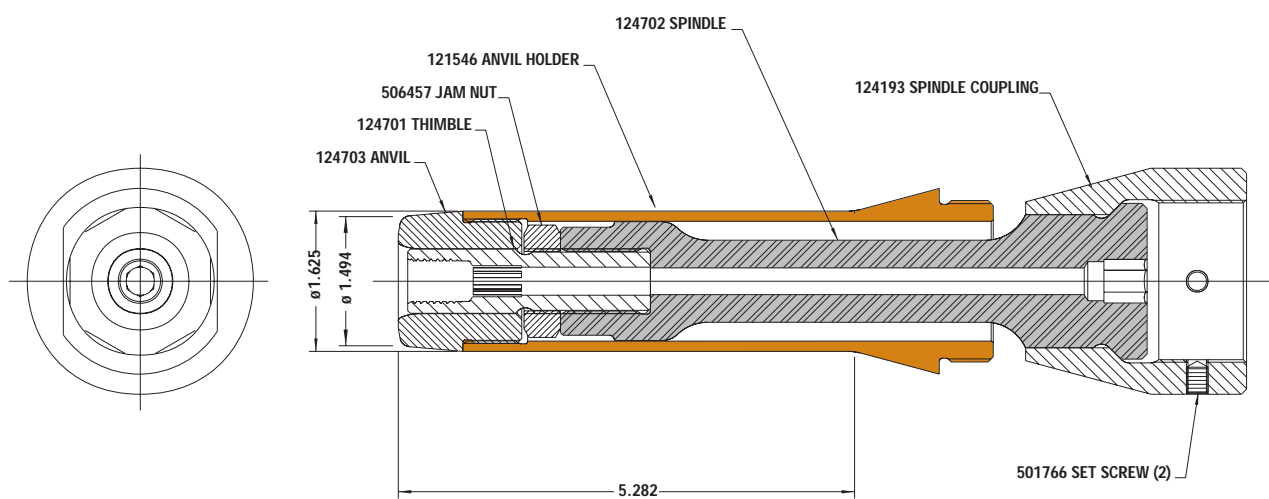
99-5414 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|---------|----------|----------------|
| HuckFit | 20mm | PowerDrive 507 |
| | 5/8 | PowerDrive 507 |

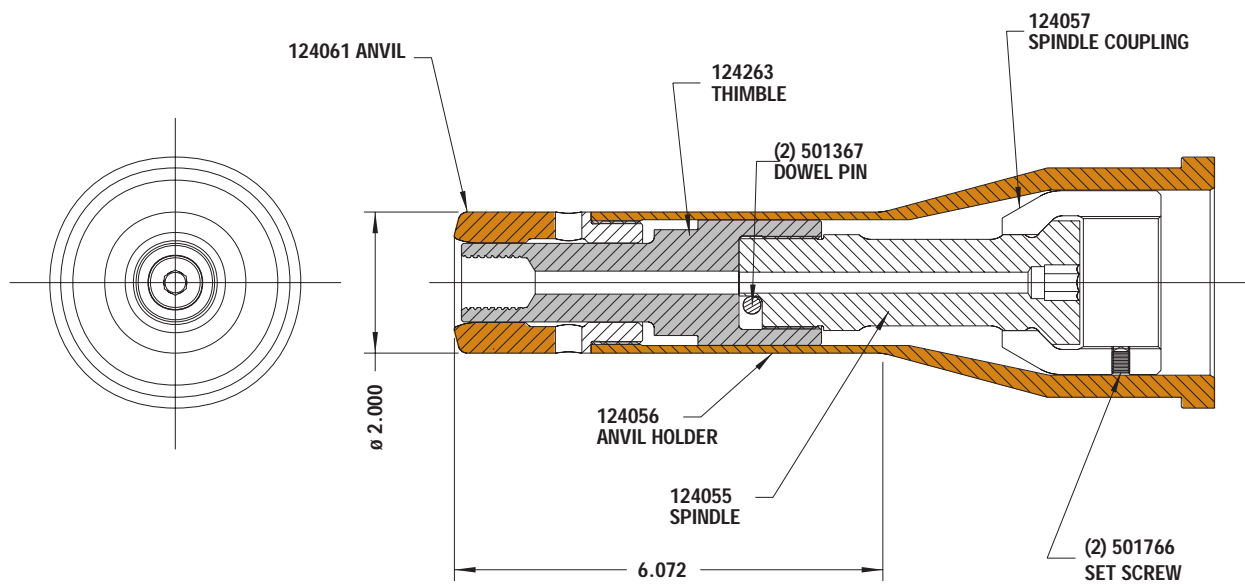
99-7313-1 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|----------|----------|------|
| HuckSpin | 1/2 | HS52 |

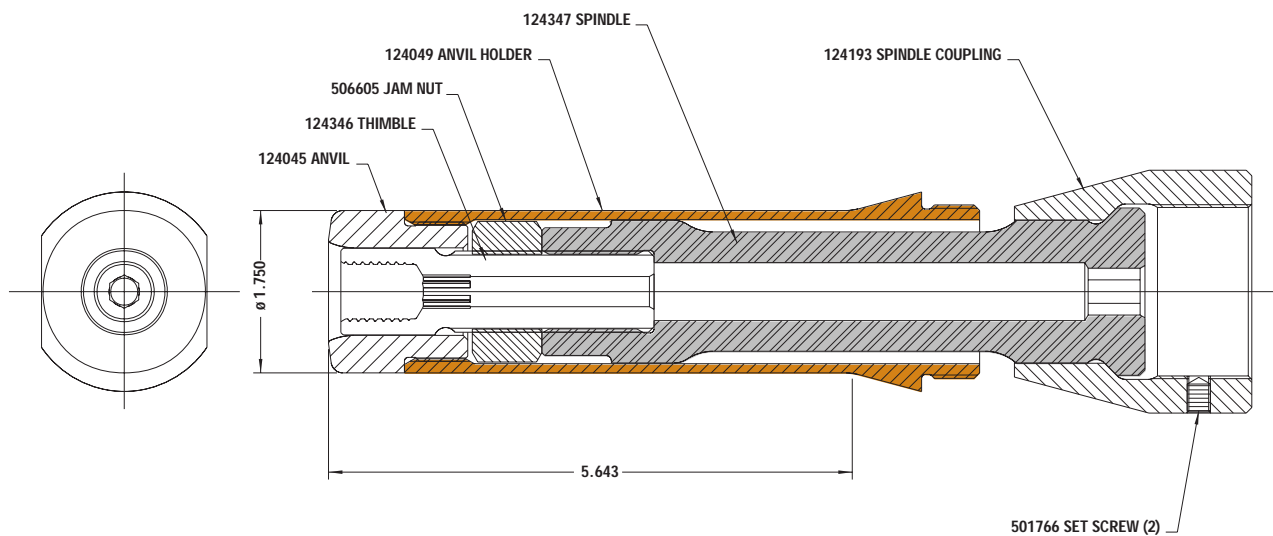
99-7314-1 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|----------|----------|------|
| HuckSpin | 3/4 | HS52 |

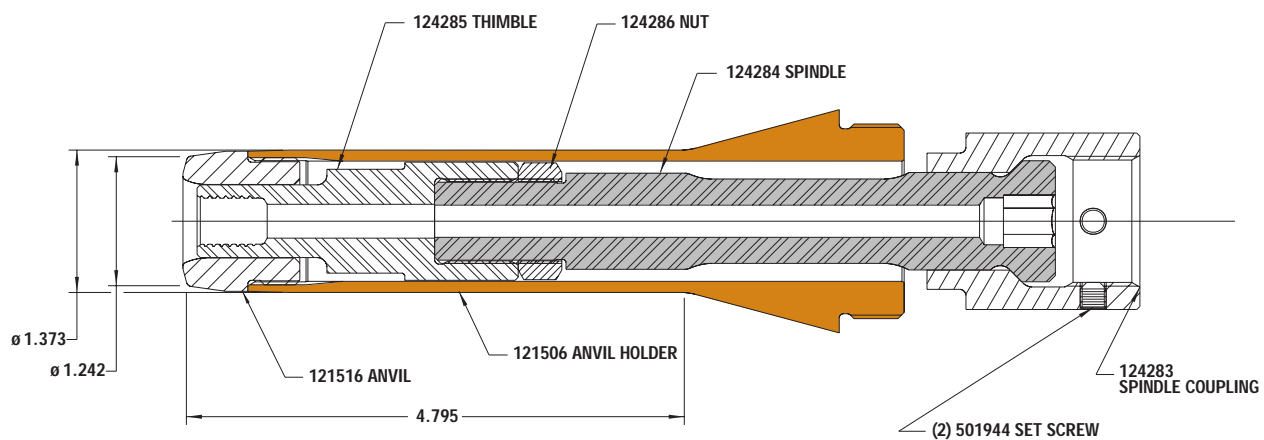
99-7315-1 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|----------|----------|------|
| HuckSpin | 16mm | HS52 |
| | 5/8 | HS52 |

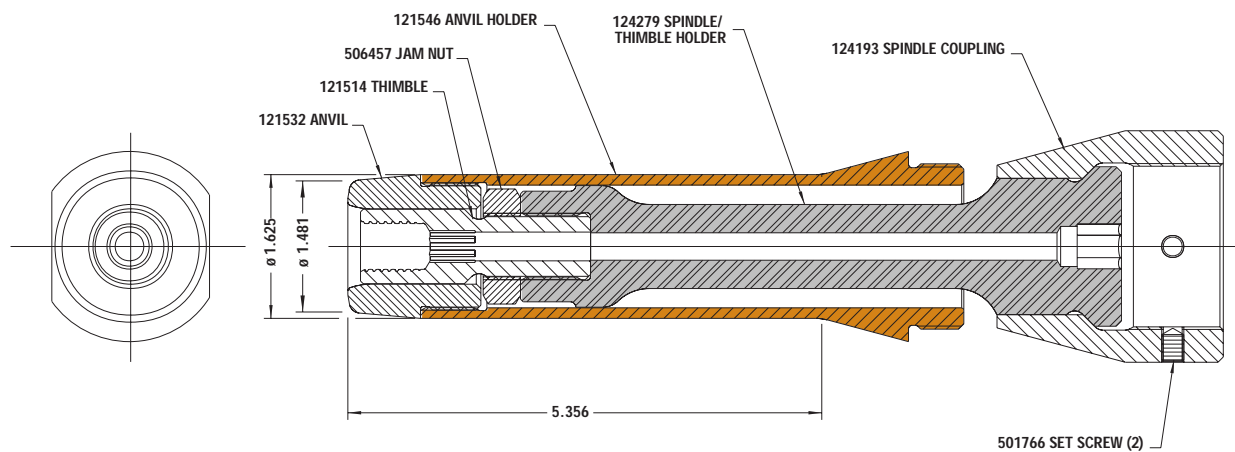
99-7412-1 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|----------|----------|------|
| HuckSpin | 12mm | HS37 |

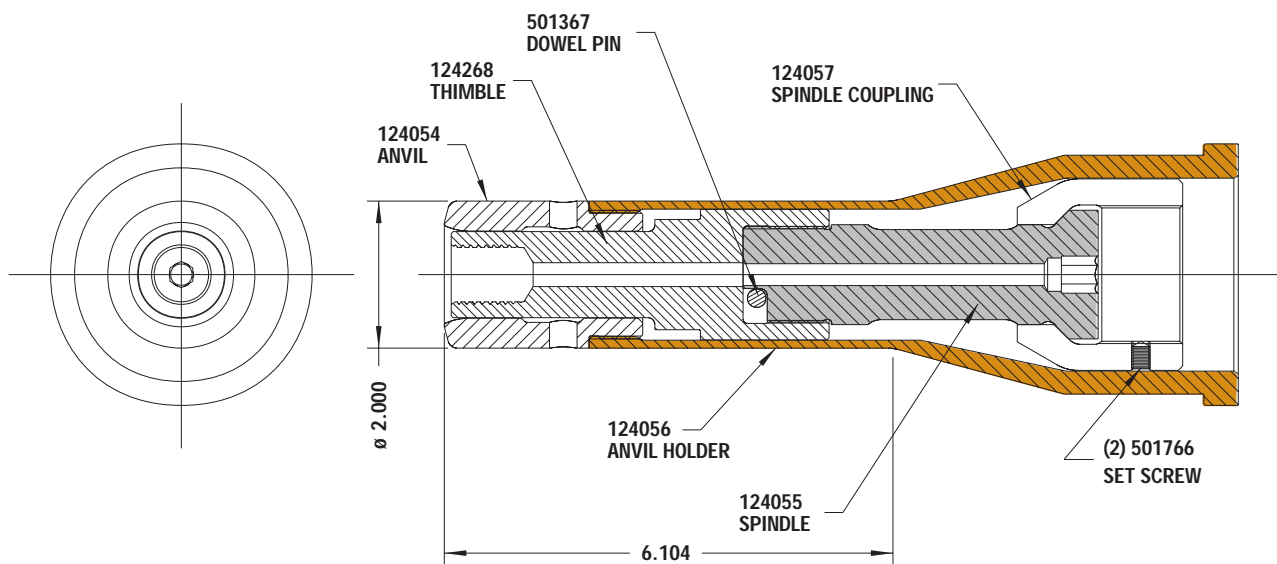
99-7415-1 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|----------|----------|------|
| HuckSpin | 14mm | HS52 |

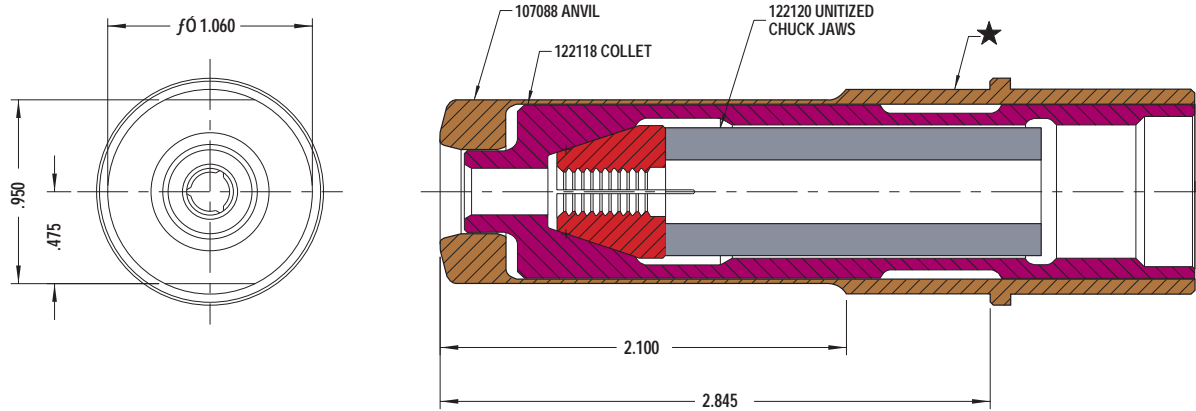
99-7418-1 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|----------|----------|------|
| HuckSpin | 20mm | HS52 |

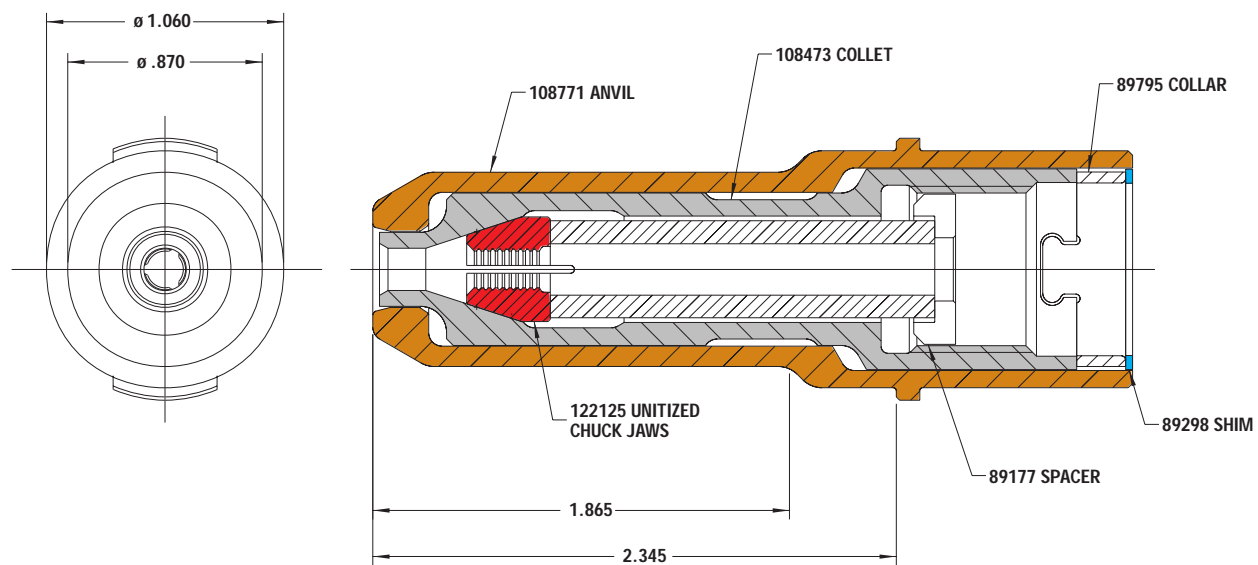
99-769 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------|----------|---|
| BOM | 5/16 | Super LockForce 246 Super Lockforce 2580 |

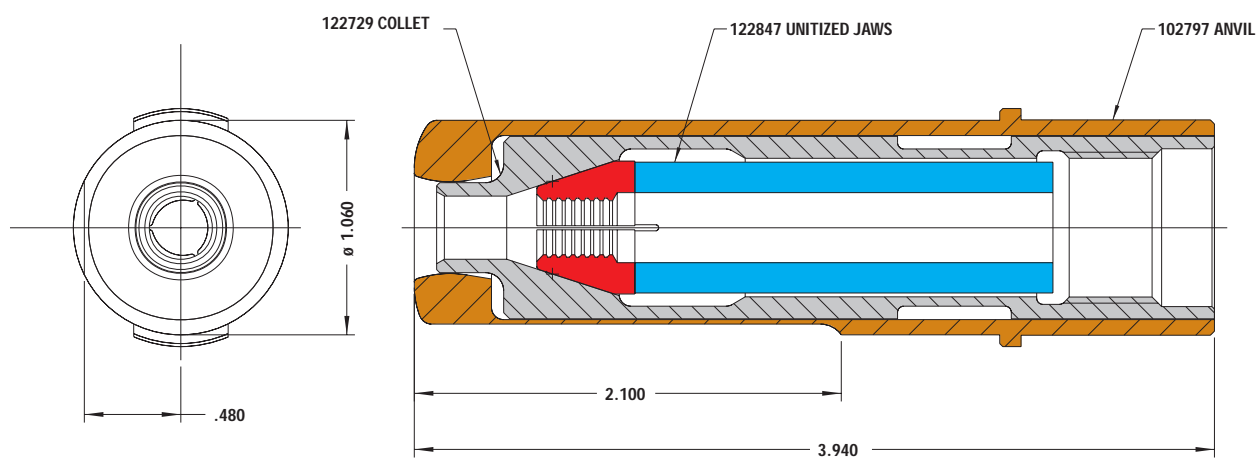
99-830-1 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------|----------|----------------------|
| BOM | 1/4 | Super LockForce 245 |
| | | Super LockForce 246 |
| | | Super LockForce 2580 |

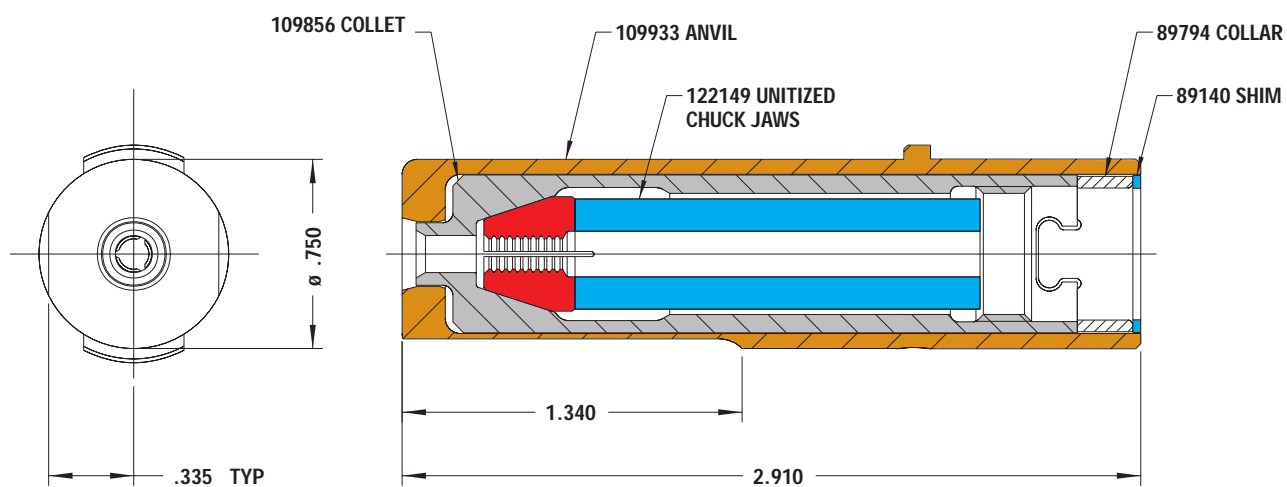
99-99-245 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------|----------|----------------------|
| C6L | 5/16 | Super LockForce 246 |
| | | Super LockForce 2580 |

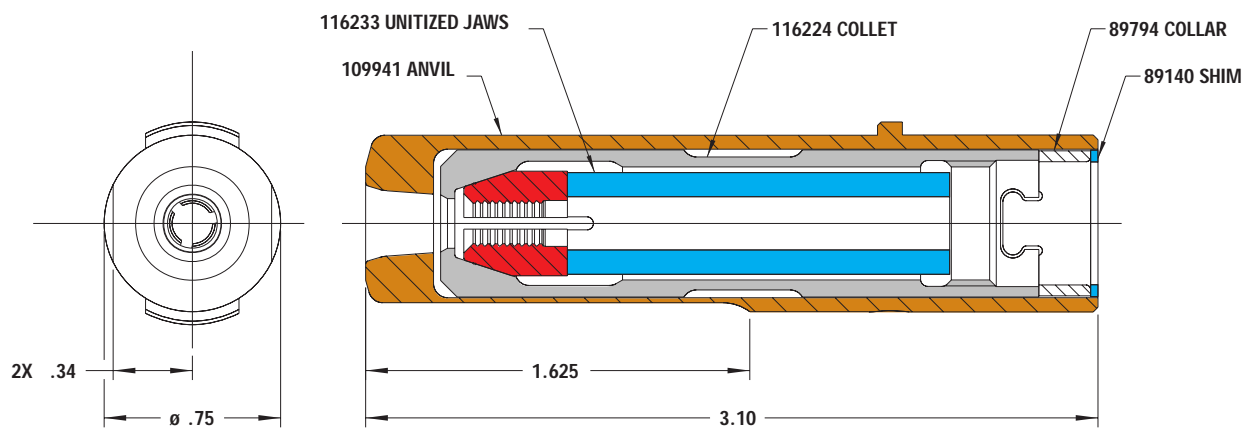
99-994 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------|----------|----------------|
| BOM | 3/16 | SureSet 230 |
| | | LockForce 212 |
| | | LockForce 2025 |
| | | LockForce 2480 |

99-999 Nose Assembly

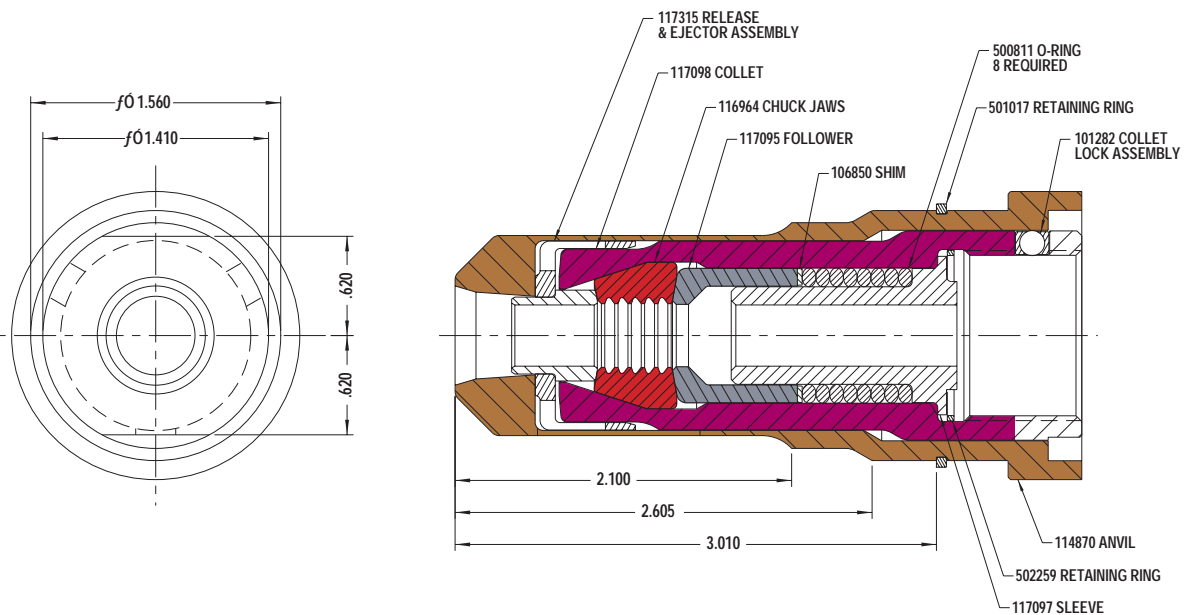


Compatible Fastener

| Type | Diameter | Tool |
|----------|----------|----------------|
| C6L/120L | 3/16 | SureSet 230 |
| | | LockForce 212 |
| | | LockForce 2025 |
| | | LockForce 2480 |

H99-1492 Nose Assembly

H99-1492 Nose Assembly



Compatible Fastener

| Type | Diameter | Tool |
|------------|----------|-----------------|
| Magna-Grip | 3/8 | PowerDrive 5901 |

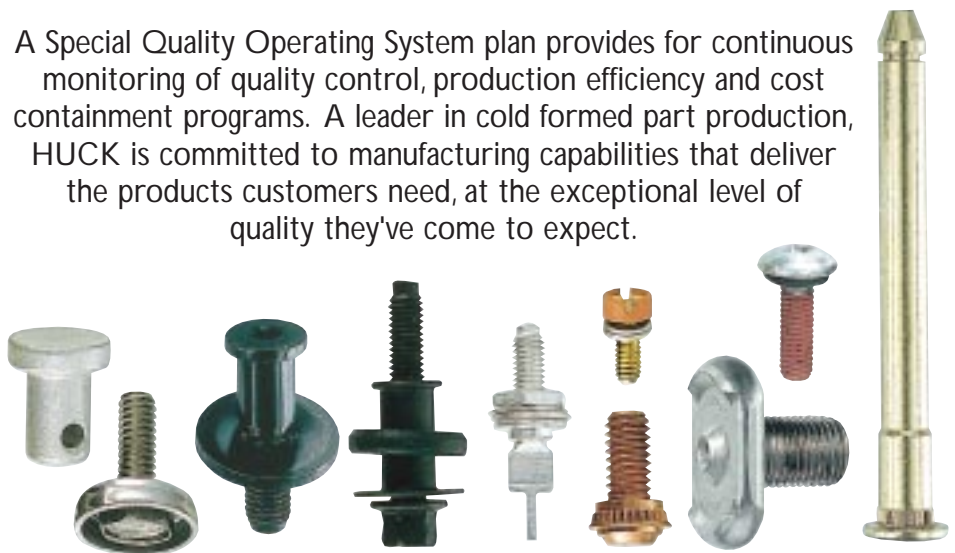
HUCK Medina

HUCK Altoona

HUCK designs and manufactures high volume custom cold formed parts, all to appropriate ANSI, IFI, ASME and ASTM standards. With facilities strategically located in Medina, Ohio and Altoona, Pennsylvania, HUCK produces almost three quarters of a billion cold formed parts annually. The company offers a complete in-house design and engineering department, allowing it to create a cold formed part that precisely meets the most demanding application requirements. Full lot control and traceability based on ISO-9002/QS-9000, along with SPC programs are tailored to specific customer needs.

HUCK offers a broad selection of metals including carbon and alloy steel, stainless, brass and aluminum. The company also provides a wide range of capabilities, including injection molding, heat treat and plating operations, as well as specialized assembly and advanced vision inspection systems for crucial applications.

A Special Quality Operating System plan provides for continuous monitoring of quality control, production efficiency and cost containment programs. A leader in cold formed part production, HUCK is committed to manufacturing capabilities that deliver the products customers need, at the exceptional level of quality they've come to expect.



Blind Fastener Cross Reference

| HUCK | AVDEL | POP | CHERRY | CHERRY | MARSON |
|---------------------------------|-------|--------------|-----------|-------------|--------------|
| Grip-Rite™ Rivets | | | | | |
| ALL ALUMINUM | | | | | |
| ABA 32 | | AD 32 ABS | AAP - 32 | | AB 3 - 2 A |
| ABA 34 | | AD 34 ABS | AAP - 34 | | AB 3 - 4 A |
| ABA 41 | | AD 41 ABS | AAP - 41 | | AB 4 - 1 A |
| ABA 410 | | - | - | - | - |
| ABA 42 | | AD 42 ABS | AAP - 42 | AAP S 04 02 | AB 4 - 2 A |
| ABA 42L | | AD 42 ABSLF | AAL - 42 | AAL S 04 02 | ABL 4 - 2 A |
| ABA 43 | | AD 43 ABS | AAP - 43 | AAP S 04 03 | AB 4 - 3 A |
| ABA 43L | | AD 43 ABSLF | AAL - 43 | | ABL 4 - 3 A |
| ABA 44 | | AD 44 ABS | AAP - 44 | AAP S 04 04 | AB 4 - 4 A |
| ABA 44L | | AD 44 ABSLF | AAL - 44 | AAL S 04 04 | ABL 4 - 4 A |
| ABA 45 | | AD 45 ABS | AAP - 45 | AAP S 04 05 | AB 4 - 5 A |
| ABA 46 | | AD 46 ABS | AAP - 46 | AAP S 04 06 | AB 4 - 6 A |
| ABA 48 | | AD 48 ABS | AAP - 48 | AAP S 04 08 | AB 4 - 8 A |
| ABA 52 | | AD 52 ABS | AAP - 52 | AAP S 05 02 | AB 5 - 2 A |
| ABA 53 | | AD 53 ABS | - | AAP S 05 03 | AB 5 - 3 A |
| ABA 54 | | AD 54 ABS | AAP - 54 | AAP S 05 04 | AB 5 - 4 A |
| ABA 56 | | AD 56 ABS | AAP - 56 | AAP S 05 06 | AB 5 - 6 A |
| ABA 58 | | AD 58 ABS | AAP - 58 | AAP S 05 08 | AB 5 - 8 A |
| ABA 610 | | AD 610 ABS | - | AAP S 06 10 | AB 6 - 10 A |
| ABA 610L | | AD 610 ABSLF | AAL - 610 | AAL S 06 10 | ABL 6 - 10 A |
| ABA 612 | | AD 612 ABS | AAP - 612 | | AB 6 - 12 A |
| ABA 612L | | AD 612 ABSLF | AAL - 612 | AAL S 06 14 | ABL 6 - 12 A |
| ABA 614 | | - | - | - | - |
| ABA 616 | | - | - | - | - |
| ABA 62 | | AD 62 ABS | AAP - 62 | AAP S 06 02 | AB 6 - 2 A |
| ABA 64 | | AD 64 ABS | AAP - 64 | AAP S 06 04 | AB 6 - 4 A |
| ABA 64L | | AD 64 ABSLF | AAL - 64 | AAL S 06 04 | ABL 6 - 4 A |
| ABA 66 | | AD 66 ABS | AAP - 66 | AAP S 06 06 | AB 6 - 6 A |
| ABA 66L | | AD 66 ABSLF | AAL - 66 | AAL S 06 06 | ABL 6 - 6 A |
| ABA 68 | | AD 68 ABS | AAP - 68 | AAP S 06 08 | AB 6 - 8 A |
| ABA 68L | | AD 68 ABSLF | AAL - 68 | AAL S 06 08 | ABL 6 - 8 A |
| ABA 810 | | AD 810 ABS | AAP - 810 | - | AB 8 - 10 A |
| ABA 812 | | AD 812 ABS | AAP - 812 | - | AB 8 - 12 A |
| ABA 84 | | AD 84 ABS | AAP - 84 | - | AB 8 - 4 A |
| ABA 86 | | AD 86 ABS | AAP - 86 | - | AB 8 - 6 A |
| ABA 88 | | AD 88 ABS | AAP - 88 | - | AB 8 - 8 A |
| ALUMINUM BODY, STEEL PIN | | | | | |
| ABS 32 | | AD 32 BS | BSP - 32 | BSP S 03 02 | AB 3 - 2 |
| ABS 34 | | AD 34 BS | BSP - 34 | BSP S 03 04 | AB 3 - 4 |
| ABS 41 | | AD 41 BS | BSP - 41 | BSP S 04 01 | AB 4 - 1 |
| ABS 410 | | AD 410 BS | BSP - 410 | BSP S 04 10 | - |
| ABS 42 | | AD 42 BS | BSP - 42 | BSP S 04 02 | AB 4 - 2 |
| ABS 42L | | AD 42 BSLF | BSL - 42 | BSL S 04 02 | ABL 4 - 2 |
| ABS 43 | | AD 43 BS | BSP - 43 | BSP S 04 03 | AB 4 - 3 |
| ABS 43L | | AD 43 BSLF | BSL - 43 | BSL S 04 03 | ABL 4 - 3 |
| ABS 44 | | AD 44 BS | BSP - 44 | BSP S 04 04 | AB 4 - 4 |
| ABS 44L | | AD 44 BSLF | BSL - 44 | BSL S 04 04 | ABL 4 - 4 |
| ABS 45 | | AD 45 BS | BSP - 45 | BSP S 04 05 | AB 4 - 5 |
| ABS 46 | | AD 46 BS | BSP - 46 | BSP S 04 06 | AB 4 - 6 |
| ABS 48 | | AD 48 BS | BSP - 48 | BSP S 04 08 | AB 4 - 8 |
| ABS 52 | | AD 52 BS | BSP - 52 | BSP S 05 02 | AB 5 - 2 |
| ABS 53 | | AD 53 BS | - | BSP S 05 03 | AB 5 - 3 |
| ABS 54 | | AD 54 BS | BSP - 54 | BSP S 05 04 | AB 5 - 4 |
| ABS 56 | | AD 56 BS | BSP - 56 | BSP S 05 06 | AB 5 - 6 |
| ABS 58 | | AD 58 BS | BSP - 58 | BSP S 05 08 | AB 5 - 8 |
| ABS 610 | | AD 610 BS | BSP - 610 | BSP S 06 10 | AB 6 - 10 |
| ABS 610L | | AK 610 BS | BSL - 610 | BSL S 06 10 | ABL 6 - 10L |
| ABS 612 | | AD 612 BS | BSP - 612 | BSP S 06 12 | AB 6 - 12 |
| ABS 612L | | AK 612 BS | BSL - 612 | BSL S 06 14 | ABL 6 - 12L |
| ABS 614L | | AK 614 BS | - | BSL S 06 14 | - |
| ABS 616 | | AD 616 BS | - | BSP S 06 16 | - |
| ABS 62 | | AD 62 BS | BSP - 62 | BSP S 06 02 | AB 6 - 2 |
| ABS 64 | | AD 64 BS | BSP - 64 | BSP S 06 04 | AB 6 - 4 |
| ABS 64L | | AK 64 BS | BSL - 64 | BSL S 06 04 | ABL 6 - 4 |
| ABS 66 | | AD 66 BS | BSP - 66 | BSP S 06 06 | AB 6 - 6 |
| ABS 66L | | AK 66 BS | BSL - 66 | BSL S 06 06 | ABL 6 - 6 |
| ABS 68 | | AD 68 BS | BSP - 68 | BSP S 06 08 | AB 6 - 8 |
| ABS 68L | | AK 68 BS | BSL - 68 | BSL S 06 08 | ABL 6 - 8 |
| ABS 810 | | AD 810 BS | BSP - 810 | - | AB 8 - 10 |
| ABS 812 | | AD 812 BS | BSP - 812 | - | AB 8 - 12 |
| ABS 84 | | AD 84 BS | BSP - 84 | - | AB 8 - 4 |
| ABS 86 | | AD 86 BS | BSP - 86 | - | AB 8 - 6 |

Blind Fastener Cross Reference

| HUCK | AVDEL | POP | CHERRY | CHERRY | MARSON |
|----------------------------------|-------|-------------|-----------|-------------|-------------|
| ABS 88 | | AD 88 BS | BSP - 88 | - | AB 8 - 8 |
| ACA 42 | | AK 42 ABS | AAC - 42 | | AC 4 - 2 A |
| ACA 43 | | AK 43 ABS | AAC - 43 | | AC 4 - 3 A |
| ACA 44 | | AK 44 ABS | AAC - 44 | | AC 4 - 4 A |
| ACS 42 | | AK 42 BS | BSC - 42 | BSC S 04 02 | AC 4 - 2 |
| ACS 43 | | AK 43 BS | BSC - 43 | BSC S 04 03 | AC 4 - 3 |
| ACS 44 | | AK 44 BS | BSC - 44 | BSC S 04 04 | AC 4 - 4 |
| COPPER BODY, STEEL PIN | | | | | |
| CBS 42 | | CD 42 BS | USP - 42 | | CB 4 - 2 |
| CBS 44 | | CD 44 BS | USP - 44 | | CB 4 - 4 |
| ALL STAINLESS | | | | | |
| FBF 42 | | SSD 42 SSBS | CCP - 42 | CCP S 04 02 | SSB 4 - 2 S |
| FBF 43 | | SSD 43 SSBS | CCP - 43 | CCP S 04 03 | SSB 4 - 3 S |
| FBF 44 | | SSD 44 SSBS | CCP - 44 | CCP S 04 04 | SSB 4 - 4 S |
| FBF 46 | | - | CCP - 46 | CCP S 04 06 | SSB 4 - 6 S |
| FBF 48 | | - | - | - | SSB 4 - 8 S |
| FBF 52 | | - | CCP - 52 | CCP S 05 02 | SSB 5 - 2 S |
| FBF 54 | | - | CCP - 54 | CCP S 05 04 | SSB 5 - 4 S |
| FBF 56 | | - | CCP - 56 | CCP S 05 06 | SSB 5 - 6 S |
| FBF 62 | | SSD 62 SSBS | CCP - 62 | CCP S 06 02 | SSB 6 - 2 S |
| FBF 64 | | SSD 64 SSBS | CCP - 64 | CCP S 06 04 | SSB 6 - 4 S |
| FBF 66 | | SSD 66 SSBS | CCP - 66 | CCP S 06 06 | SSB 6 - 6 S |
| FBF 68 | | SSD 68 SSBS | CCP - 68 | CCP S 06 08 | SSB 6 - 8 S |
| STAINLESS BODY, STEEL PIN | | | | | |
| FBS 42 | | SSD 42 BS | CSP - 42 | CSP S 04 02 | SSB 4 - 2 |
| FBS 43 | | SSD 43 BS | CSP - 43 | CSP S 04 03 | SSB 4 - 3 |
| FBS 44 | | SSD 44 BS | CSP - 44 | CSP S 04 04 | SSB 4 - 4 |
| FBS 46 | | SSD 46 BS | CSP - 46 | CSP S 04 06 | SSB 4 - 6 |
| FBS 48 | | - | - | - | SSB 4 - 8 |
| FBS 52 | | SSD 52 BS | CSP - 52 | CSP S 05 02 | SSB 5 - 2 |
| FBS 54 | | SSD 54 BS | CSP - 54 | CSP S 05 04 | SSB 5 - 4 |
| FBS 56 | | SSD 56 BS | CSP - 56 | CSP S 05 06 | SSB 5 - 6 |
| FBS 62 | | SSD 62 BS | CSP - 62 | CSP S 06 02 | SSB 6 - 2 |
| FBS 64 | | SSD 64 BS | CSP - 64 | CSP S 06 04 | SSB 6 - 4 |
| FBS 66 | | SSD 66 BS | CSP - 66 | CSP S 06 06 | SSB 6 - 6 |
| FBS 68 | | SSD 68 BS | CSP - 68 | CSP S 06 08 | SSB 6 - 8 |
| ALL STEEL | | | | | |
| SBS 32 | | SD 32 BS | SSP - 32 | | SB 3 - 2 |
| SBS 34 | | SD 34 BS | SSP - 34 | | SB 3 - 4 |
| SBS 41 | | SD 41 BS | SSP - 41 | SSP S 04 01 | SB 4 - 1 |
| SBS 42 | | SD 42 BS | SSP - 42 | SSP S 04 02 | SB 4 - 2 |
| SBS 42L | | SD 42 BSLF | SSL - 42 | SSL S 04 02 | SBL 4 - 2 |
| SBS 43 | | SD 43 BS | SSP - 43 | SSP S 04 03 | SB 4 - 3 |
| SBS 44 | | SD 44 BS | SSP - 44 | SSP S 04 04 | SB 4 - 4 |
| SBS 44L | | SD 44 BSLF | SSL - 44 | SSL S 04 04 | SBL 4 - 4 |
| SBS 45 | | SD 45 BS | SSP - 45 | SSP S 04 05 | SB 4 - 5 |
| SBS 46 | | SD 46 BS | SSP - 46 | SSP S 04 06 | SB 4 - 6 |
| SBS 48 | | SD 48 BS | SSP - 48 | SSP S 04 08 | SB 4 - 8 |
| SBS 52 | | SD 52 BS | SSP - 52 | SSP S 05 02 | SB 5 - 2 |
| SBS 53 | | SD 53 BS | - | - S 05 03 | SB 5 - 3 |
| SBS 54 | | SD 54 BS | SSP - 54 | SSP S 05 04 | SB 5 - 4 |
| SBS 54L | | SD 54 BSLF | SSL - 54L | SSL S 05 04 | - |
| SBS 56 | | SD 56 BS | SSP - 56 | SSP S 05 06 | SB 5 - 6 |
| SBS 58 | | SD 58 BS | SSP - 58 | SSP S 05 08 | SB 5 - 8 |
| SBS 610 | | SD 610 BS | SSP - 610 | SSP S 06 10 | SB 6 - 10 |
| SBS 610L | | SD 610 BSLF | SSL - 610 | SSL S 06 10 | SBL 6 - 10 |
| SBS 612 | | SD 612 BS | SSP - 612 | | SB 6 - 12 |
| SBS 612L | | SD 612 BSLF | SSL - 612 | SSL S 06 12 | SBL 6 - 12 |
| SBS 614 | | SD 614 BS | - | | SB 6 - 14 |
| SBS 616 | | SD 616 BS | SSP - 616 | SSP S 06 16 | SB 6 - 16 |
| SBS 62 | | SD 62 BS | SSP - 62 | SSP S 06 02 | SB 6 - 2 |
| SBS 64 | | SD 64 BS | SSP - 64 | SSP S 06 04 | SB 6 - 4 |
| SBS 64L | | SD 64 BSLF | SSL - 64 | SSL S 06 04 | SBL 6 - 4 |
| SBS 66 | | SD 66 BS | SSP - 66 | SSP S 06 06 | SB 6 - 6 |
| SBS 66L | | SD 66 BSLF | SSL - 66 | SSL S 06 08 | SBL 6 - 6 |
| SBS 68 | | SD 68 BS | SSP - 68 | SSP S 06 08 | SB 6 - 8 |
| SBS 68L | | SD 68 BSLF | SSL - 68 | SSL S 06 08 | SBL 6 - 8 |
| SBS 810 | | SD 810 BS | SSP - 810 | | SB 8 - 10 |
| SBS 812 | | SD 812 BS | SSP - 812 | | SB 8 - 12 |
| SBS 84 | | SD 84 BS | SSP - 84 | | SB 8 - 4 |
| SBS 86 | | SD 86 BS | SSP - 86 | | SB 8 - 6 |
| SBS 88 | | SD 88 BS | SSP - 88 | | SB 8 - 8 |
| SCS 42 | | - | SSC - 42 | SSC S 04 02 | SC 4 - 2 |
| SCS 43 | | - | SSC - 43 | | SC 4 - 3 |
| SCS 44 | | - | SSC - 44 | SSC S 04 04 | SC 4 - 4 |

Sorted By Huck Number

Blind Fastener Cross Reference

| HUCK | AVDEL | POP | CHERRY | CHERRY | MARSON |
|---|-------|--------------|-------------|--------|--------|
| PEEL[®] RIVETS | | | | | |
| ALUMINUM BODY, STEEL PIN | | | | | |
| TABS 6062 | | | BSPTS 6 062 | | |
| TABS 6093 | | | BSPTS 6 093 | | |
| TABS 6125 | | AD 6140 TFBS | BSPTS 6 125 | | |
| TABS 6156 | | AD 6187 TFBS | BSPTS 6 156 | | |
| TABS 6187 | | | BSPTS 6 187 | | |
| TABS 6218 | | | BSPTS 6 218 | | |
| TABS 6250 | | AD 6250 TFBS | BSPTS 6 250 | | |
| TABS 6281 | | | BSPTS 6 281 | | |
| TABS 6312 | | AD 6312 TFBS | BSPTS 6 312 | | |
| TABS 6343 | | | BSPTS 6 343 | | |
| TABS 6375 | | AD 6375 TFBS | BSPTS 6 375 | | |
| TABS 6406 | | | BSPTS 6 406 | | |
| TABS 6437 | | AD 6437 TFBS | BSPTS 6 437 | | |
| TABS 6468 | | | BSPTS 6 468 | | |
| TABS 6500 | | | BSPTS 6 500 | | |
| TABS 6062L | | AD 6519 TFBS | BSLT 6 062 | | |
| TABS 6093L | | | BSLT 6 093 | | |
| TABS 6125L | | | BSLT 6 125 | | |
| TABS 6156L | | | BSLT 6 156 | | |
| TABS 6187L | | | BSLT 6 187 | | |
| TABS 6218L | | | BSLT 6 218 | | |
| TABS 6250L | | | BSLT 6 250 | | |
| TABS 6281L | | | BSLT 6 281 | | |
| TABS 6312L | | | BSLT 6 312 | | |
| TABS 6343L | | | BSLT 6 343 | | |
| TABS 6375L | | | BSLT 6 375 | | |
| TABS 6406L | | | BSLT 6 406 | | |
| TABS 6437L | | | BSLT 6 437 | | |
| TABS 6468L | | | BSLT 6 468 | | |
| TABS 6500L | | | BSLT 6 500 | | |
| TABS 8125 | | AD 8140 TFBS | BSPT 8 125 | | |
| TABS 8187 | | AD 8187 TFBS | BSPT 8 187 | | |
| TABS 8250 | | AD 8250 TFBS | BSPT 8 250 | | |
| TABS 8312 | | AD 8312 TFBS | BSPT 8 312 | | |
| TABS 8375 | | AD 8375 TFBS | BSPT 8 375 | | |
| TABS 8437 | | AD 8437 TFBS | BSPT 8 437 | | |
| TABS 8500 | | AD 8519 TFBS | BSPT 8 500 | | |
| TABS 8562L | | AD 8620 TFBS | BSPT 8 562 | | |
| TABS 8125 | | | BSLT 8 125 | | |
| TABS 8187L | | | BSLT 8 187 | | |
| TABS 88L | | | BSLT 8 250 | | |
| TABS 810L | | | BSLT 8 312 | | |
| TABS 812L | | | BSLT 8 375 | | |
| TABS 814L | | | BSLT 8 437 | | |
| TABS 816L | | | BSLT 8 500 | | |
| TABS 818L | | | BSLT 8 562 | | |
| TABS 8140 | | | | | |
| TABS 814L | | | | | |
| TABS 814R | | | | | |
| TABS 8187Y | | | | | |
| TABS 8250 | | | | | |
| TABS 8620 | | | | | |
| TABS 8715 | | | | | |
| TABS 6203MG | | | | | |
| TABS 625MSG | | | | | |
| TABS 66MSG | | | | | |
| TABS 82MSG | | | | | |
| TABS 84MSG | | | | | |
| TABS 865MSG | | | | | |
| STRONGHOLD[™] RIVETS, ALL STEEL | | | | | |
| ALL STEEL | | | | | |
| SBS 42MG | | - | SSPQ - 42 | | - |
| SBS 42LMG | | - | SSLQ - 42 | | - |
| SBS 43MG | | - | SSPQ - 43 | | - |
| SBS 54MG | | - | SSPQ - 54 | | - |
| SBS 54LMG | | - | SSLQ - 54 | | - |
| SBS 62MG | | - | SSPQ - 62 | | - |
| SBS 64MG | | - | SSPQ - 64 | | - |
| SBS 66MG | | - | SSPQ - 66 | | - |
| SBS 68MG | | - | SSPQ - 68 | | - |

Blind Fastener Cross Reference

| HUCK | AVDEL | POP | CHERRY | CHERRY | MARSON |
|---|----------------|---------------|------------|-------------|--------|
| SBS 84MG | | - | SSPQ - 84 | | - |
| SBS 84LMG | | - | SSLQ - 84 | | - |
| SBS 86MG | | - | SSPQ - 86 | | - |
| SBS 86LMG | | - | SSLQ - 86 | | - |
| MAGNA-LOK[®], ALL STEEL | | | | | |
| ALL STEEL | | | | | |
| MGLP -R6-4 | 2771 -0613 | SD 6270 UG | SSPV - 64 | SSPI - 64 | - |
| MGLP -R6-7 | 2771 -0617 | SD 6437 UG | SSPV - 67 | SSPI - 67 | - |
| MGLP -R8-6 | 2771 -0817 | SD 8375 UG | SSPV - 86 | SSPI - 86 | - |
| MGLP -R8-10 | 2771 -0821 | SD 8625 UG | SSPV - 810 | SSPI - 810 | - |
| MGLP -R12-12 | - | - | - | - | - |
| MGLP -R6-E | - | SD 6437 UGX | - | SSPI - E67 | - |
| MGLP -R8-E | 2771 -0824 | SD 8625 UGX | - | SSPI - E810 | - |
| MGLT -R6-4 | 2771 -0613 | SD 6270 UGLF | - | - | - |
| MGLT -R6-7 | 2771 -0617 | SD 6437 UGLF | - | - | - |
| MGLT -R6-E | - | SD 6437 UGLFX | - | - | - |
| MGLT -R8-6 | 2771 -0817 | SD 8375 UGLF | - | - | - |
| MGL100 -R6-6 | 2761 -0615 (?) | SK 6331 UG | SSCV - 66 | SSCI - 66 | - |
| MGL100 -R6-9 | - | SK 6500 UG | - | - | - |
| MGL100 -R8-8 | 2761 -0821 | SK 8475 UG | SSCV - 88 | SSCI - 88 | - |
| MGL100 -R8-12 | - | SK 8725 UG | - | - | - |
| ALL ALUMINUM | | | | | |
| MGLP -B6-4 | 2774 -0613 | AD 6270 UG | BAPV - 64 | BAPI - 64 | - |
| MGLP -B6-7 | 2774 -0617 | AD 6437 UG | BAPV - 67 | BAPI - 67 | - |
| MGLP -B8-6 | 2774 -0817 | AD 8375 UG | BAPV - 86 | BAPI - 86 | - |
| MGLP -B8-10 | 2774 -0821 | AD 8625 UG | BAPV - 810 | BAPI - 810 | - |
| MGLP 12-12 | - | - | - | - | - |
| MGLP -B6-E | - | AD 6437 UGX | - | BAPI - E67 | - |
| MGLP -B8-E | 2774 -0824 | AD 8625 UGX | - | BAPI - E810 | - |
| MGLT -B6-4 | - | AD 6270 UGLF | BALVA - 64 | - | - |
| MGL100 -B6-6 | 2764 -0615 | AK 6331 UG | - | - | - |
| MGL100 -B6-9 | - | AK 6500 UG | - | - | - |
| MGL100 -B8-8 | 2761 -0821 | AK 8475 UGLF | - | - | - |
| MGL100 -B8-12 | - | AK 8725 UG | - | - | - |
| ALL STAINLESS | | | | | |
| MGLP -U6-4 | 2711 -0613 | SSD 6500 UG | CCPV - 64 | CCPI - 64 | - |
| MGLP -U6-7 | 2711 -0617 | - | - | - | - |
| MGLP -U6-E | - | - | - | - | - |
| MGLP -U8-6 | 2711 -0817 | SSD 8375 UG | CCPV - 86 | CCPI - 86 | - |
| MGLP -U8-10 | - | - | - | - | - |
| MGL100 -U6-6 | - | SSK 6331 UG | - | - | - |
| MGL100 -U8-8 | - | SSK 8475 UG | - | - | - |
| MAGNA-BULB[®] | | | | | |
| ALL STEEL | | | | | |
| MBP-R6-M3 | - | | | | |
| MBP-R6-M4 | - | | | | |
| MBP-R6-M5 | - | | | | |
| MBP-R6-M6 | - | | | | |
| MBP-R6-M7 | - | | | | |
| MBP-R6-M8 | - | | | | |
| MBP-R6-M9 | - | | | | |
| MBP-R8-M2 | 2221 -0812 | | | | |
| MBP-R8-M3 | 2221 -0813 | | | | |
| MBP-R8-M4 | - | | | | |
| MBP-R8-M5 | 2221 -0815 | | | | |
| MBP-R8-M6 | - | | | | |
| MBP-R8-M7 | 2221 -0817 | | | | |
| MBP-R8-M8 | - | | | | |
| MBP-R8-M9 | 2221 -0819 | | | | |
| MBP-R8-M10 | - | | | | |
| MBP-R8-M11 | 2221 -0821 | | | | |
| MBP-R8-M12 | - | | | | |
| MBP-R8-M13 | - | | | | |
| MBP-R10-3 | - | | | | |
| MBP-R10-4 | - | | | | |
| MBP-R10-5 | - | | | | |
| MBP-R10-6 | - | | | | |
| MBP-R10-7 | - | | | | |
| MBP-R10-8 | - | | | | |
| MBCP-R8-M3 | 2221 -0813 | | | | |
| MBCP-R8-M5 | 2221 -0815 | | | | |
| MBCP-R8-M7 | 2221 -0817 | | | | |

Blind Fastener Cross Reference

| HUCK | AVDEL | POP | CHERRY | CHERRY | MARSON |
|---------------------------|------------|-----|--------------|--------|------------------|
| MBCP-R8-M8 | - | | | | |
| MBCP-R8-M9 | 2221 -0819 | | | | |
| MBCP-R8-M11 | 2221 -0821 | | | | |
| MAGNA-GRIP® RIVETS | | | | | |
| MGDR-R8-5 | | | | | |
| MGDR-R8-10 | | | | | |
| MGDR-B8-10 | | | | | |
| FLOORTIGHT® RIVETS | | | | | |
| PMF-R10-20 | | | | | |
| PMF-R10-26 | | | | | |
| PWF-R10-20 | | | | | |
| PWF-R10-26 | | | | | |
| MAGNA-TITE® RIVETS | | | | | |
| ALL ALUMINUM | | | | | GESIPA |
| MTP-B6-5S | 3901 -0623 | | BAPKTR - 64 | | RV6606 - 6 - 4W |
| MTP-B6-6S | 3901 -0623 | | BAPKTR - 66 | | RV6606 - 6 - 6W |
| MTP-B6-8S | 3901 -0633 | | BAPKTR - 69 | | RV6606 - 6 - 8W |
| MTP-B6-10S | - | | - | | RV6606 - 6 - 10W |
| MTP-B6-12S | - | | BAPKTR - 612 | | RV6606 - 6 - 12W |
| MTV-B6-5S | - | | - | | RV6601 - 6 - 4 |
| MTV-B6-7S | - | | - | | RV6601 - 6 - 6 |
| MTV-B6-8S | - | | - | | RV6601 - 6 - 8 |
| MTV-B6-10S | - | | - | | - |
| MTV-B6-12S | - | | - | | - |
| MTLP-B6-4 | - | | - | | RV6602 - 6 - 4 |
| MTLP-B6-8 | - | | - | | RV6602 - 6 - 8 |
| MTLP-B6-12 | - | | - | | RV6602 - 6 - 12 |
| MTLP-B6-12X | - | | - | | RV66X? - 6 - 12 |
| MTS-B6-8S | - | | - | | RV6507 - 6 - 8W |
| MTS-B6-12S | - | | - | | RV6508 - 6 - 12W |

A Global Organization

HUCK International, Inc. maintains company offices throughout the United States and Canada, with subsidiary offices in many other countries.

Authorized HUCK fastener distributors are also available in many of the world's industrial centers, where they provide a ready source of HUCK fasteners, installation tools, tool parts and application assistance.

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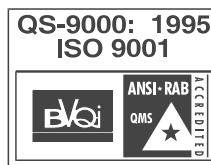


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