

Alcoa
Fastening
Systems



INSTRUCTION MANUAL

254

PNEUDRAULIC INSTALLATION TOOL



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

February 21, 2014
HK1172





EC Declaration of Conformity

Manufacturer:

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

Description of Machinery:

Models 24# and 25# pneudraulic installation tools and specials based on their designs (e.g. PR#####).

Relevant provisions complied with:

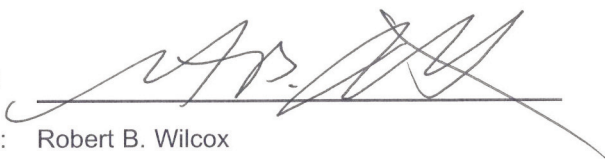
Council Directive related to Machinery (2006/42/EC)
 British Standard related to hand held, non-electric power tools (ISO 11148-1:2011)

European Representative:

Rob Pattenden, Huck International, Ltd. Unit C Stafford Park 7, Telford Shropshire TF3 3BQ, England, United Kingdom

Authorized Signature/date:

I, the undersigned, do hereby declare that the equipment specified above conforms to the above Directive(s) and Standard(s).

Signature: 

Full Name: Robert B. Wilcox

Position: Engineering Manager

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

Date: 27/03/2013



Declared dual number noise emission values in accordance with ISO 4871	
A weighted sound power level, LWA: 91 dB (reference 1 pW) Uncertainty, KWA: 3 dB	
A weighted emission sound pressure level at the work station, LpA: 80 dB (reference 20 µPa) Uncertainty, KpA: 3 dB	
C-weighted peak emission sound pressure level, LpC, peak: 115 dB (reference 20 µPa) Uncertainty, KpC: 3 dB	
Values determined according to noise test code ISO 15744, using as basic standards ISO 3744 and ISO 11203. The sum of a measured noise emission value and its associated uncertainty represents an upper boundary of the range of values which is likely to occur in measurements.	

Declared vibration emission values in accordance with EN 12096	
Measured Vibrations emission value, a:	.63 m/s ²
Uncertainty, K:	.72 m/s ²
Values measured and determined according to ISO 28662-1, ISO 5349-2, and EN 1033	

Test data to support the above information is on file at Alcoa Fastening Systems, Industrial Products Group, Kingston Operations, Kingston, NY, USA.







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SAFETY INSTRUCTIONS

GLOSSARY OF TERMS AND SYMBOLS:

-  - Product complies with requirements set forth by the relevant European directives.
-  - **READ MANUAL** prior to using this equipment.
-  - **EYE PROTECTION IS REQUIRED** while using this equipment.
-  - **HEARING PROTECTION IS REQUIRED** while using this equipment.

 **WARNINGS: Must be understood to avoid severe personal injury.**

 **CAUTIONS: show conditions that will damage equipment and or structure.**

Notes: are reminders of required procedures.

Bold, Italic type and underlining: emphasizes a specific instruction.

I. GENERAL SAFETY RULES:

1. A half hour long hands-on training session with qualified personnel is recommended before using Huck equipment.
2. Huck equipment must be maintained in a safe working condition at all times. Tools and hoses should be inspected at the beginning of each shift/day for damage or wear. Any repair should be done by a qualified repairman trained on Huck procedures.
3. For multiple hazards, read and understand the safety instructions before installing, operating, repairing, maintaining, changing accessories on, or working near the assembly power tool. Failure to do so can result in serious bodily injury.
4. Only qualified and trained operators should install, adjust or use the assembly power tool.
5. Do not modify this assembly power tool. This can reduce effectiveness of safety measures and increase operator risk.
6. Do not discard safety instructions; give them to the operator.
7. Do not use assembly power tool if it has been damaged.
8. Tools shall be inspected periodically to verify all ratings and markings required, and listed in the manual, are legibly marked on the tool. The employer/operator shall contact the manufacturer to obtain replacement marking labels when necessary. Refer to assembly drawing and parts list for replacement.
9. Tool is only to be used as stated in this manual. Any other use is prohibited.
10. Read MSDS Specifications before servicing the tool. MSDS specifications are available from the product manufacturer or your Huck representative.
11. Only genuine Huck parts shall be used for replacements or spares. Use of any other parts can result in tooling damage or personal injury.
12. Never remove any safety guards or pintail deflectors.
13. Never install a fastener in free air. Personal injury from fastener ejecting may occur.
14. Where applicable, always clear spent pintail out of nose assembly before installing the next fastener.
15. Check clearance between trigger and work piece to ensure there is no pinch point when tool is activated. Remote triggers are available for hydraulic tooling if pinch point is unavoidable.
16. Do not abuse tool by dropping or using it as a hammer. Never use hydraulic or air lines as a handle or to bend or pry the tool. Reasonable care of installation tools by operators is an important factor in maintaining tool efficiency, eliminating downtime, and preventing an accident which may cause severe personal injury.
17. Never place hands between nose assembly and work piece. Keep hands clear from front of tool.
18. Tools with ejector rods should never be cycled with out nose assembly installed.
19. When two piece lock bolts are being used always make sure the collar orientation is correct. See fastener data sheet for correct positioning.

II. PROJECTILE HAZARDS:

1. Risk of whipping compressed air hose if tool is pneudraulic or pneumatic.
2. Disconnect the assembly power tool from energy source when changing inserted tools or accessories.
3. Be aware that failure of the workpiece, accessories, or the inserted tool itself can generate high velocity projectiles.
4. Always wear impact resistant eye protection during tool operation. The grade of protection required should be assessed for each use.
5. The risk of others should also be assessed at this time.
6. Ensure that the workpiece is securely fixed.
7. Check that the means of protection from ejection of fastener or pintail is in place and operative.

8. There is possibility of forcible ejection of pintails or spent mandrels from front of tool.

III. OPERATING HAZARDS:

1. Use of tool can expose the operator's hands to hazards including: crushing, impacts, cuts, abrasions and heat. Wear suitable gloves to protect hands.
2. Operators and maintenance personnel shall be physically able to handle the bulk, weight and power of the tool.
3. Hold the tool correctly and be ready to counteract normal or sudden movements with both hands available.
4. Maintain a balanced body position and secure footing.
5. Release trigger or stop start device in case of interruption of energy supply.
6. Use only fluids and lubricants recommended by the manufacturer.
7. Avoid unsuitable postures, as it is likely for these not to allow counteracting of normal or unexpected tool movement.
8. If the assembly power tool is fixed to a suspension device, make sure that fixation is secure.
9. Beware of the risk of crushing or pinching if nose equipment is not fitted.

IV. REPETITIVE MOTION HAZARDS:

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

V. ACCESSORIES HAZARDS:

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

VI. WORKPLACE HAZARDS:

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

VII. NOISE HAZARDS:

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

VIII. VIBRATION HAZARDS:

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

IX. PNEUMATIC / PNEUDRAULIC TOOL SAFETY INSTRUCTIONS:

1. Air under pressure can cause severe injury.
2. Always shut off air supply, drain hose of air pressure and disconnect tool from air supply when not in use, before changing accessories or when making repairs.
3. Never direct air at yourself or anyone else.
4. Whipping hoses can cause severe injury, always check for damaged or loose hoses and fittings.
5. Cold air should be directed away from hands.
6. Whenever universal twist couplings (claw couplings) are used, lock pins shall be installed and whipcheck safety cables shall be used to safeguard against possible hose to hose or hose to tool connection failure.
7. Do not exceed maximum air pressure stated on tool.
8. Never carry an air tool by the hose.



SPECIFICATIONS

POWER SOURCE:

90-100psi shop air

HYDRAULIC FLUID:

ATF meeting DEXRON III, DEXRON IV, MERCON, Allison C-4 or equivalent specifications. Fire resistant hydraulic fluid may also be used, and is required to comply with OSHA regulation 1926.302 paragraph (d): "the fluid used in hydraulic power tools shall be fire resistant fluid approved under schedule 30 of the US Bureau of Mines, Department of Interior, and shall retain its operating characteristics at the most extreme temperatures to which it will be exposed."

MAX OPERATING TEMP:

125°F (51.7°C)

MAX FLOW RATE:

13.5 scfm (382.28 l/m)

MAX AIR PRESSURE:

100 psi (6.9 bar)

MIN PULL CAPACITY:

8,620 lbs (38.34 kN) @ 90 psi

MIN STROKE:

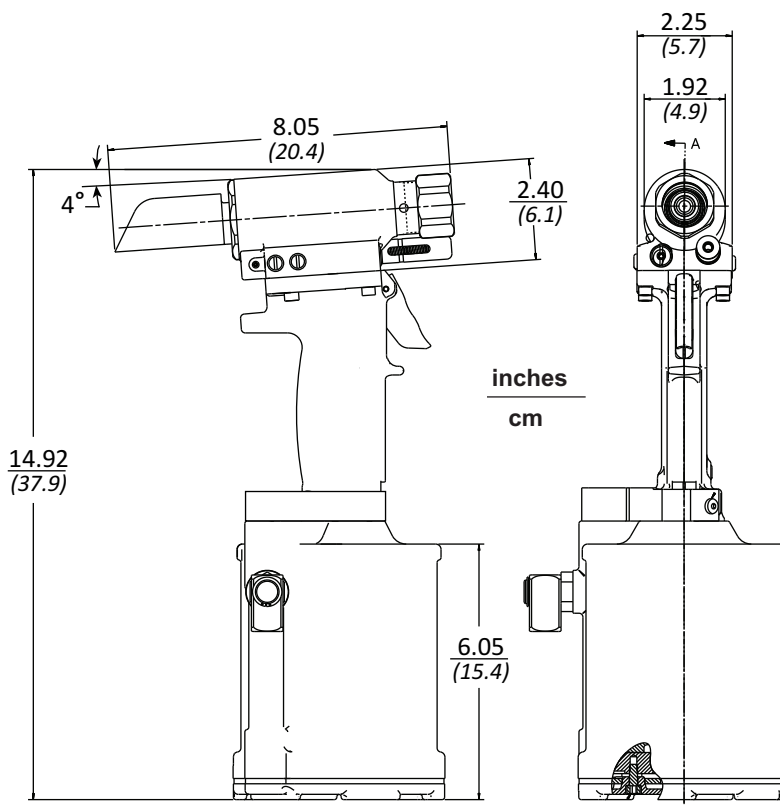
.565 inches (1.43 cm)

SPEED/CYCLES:

30 per minute

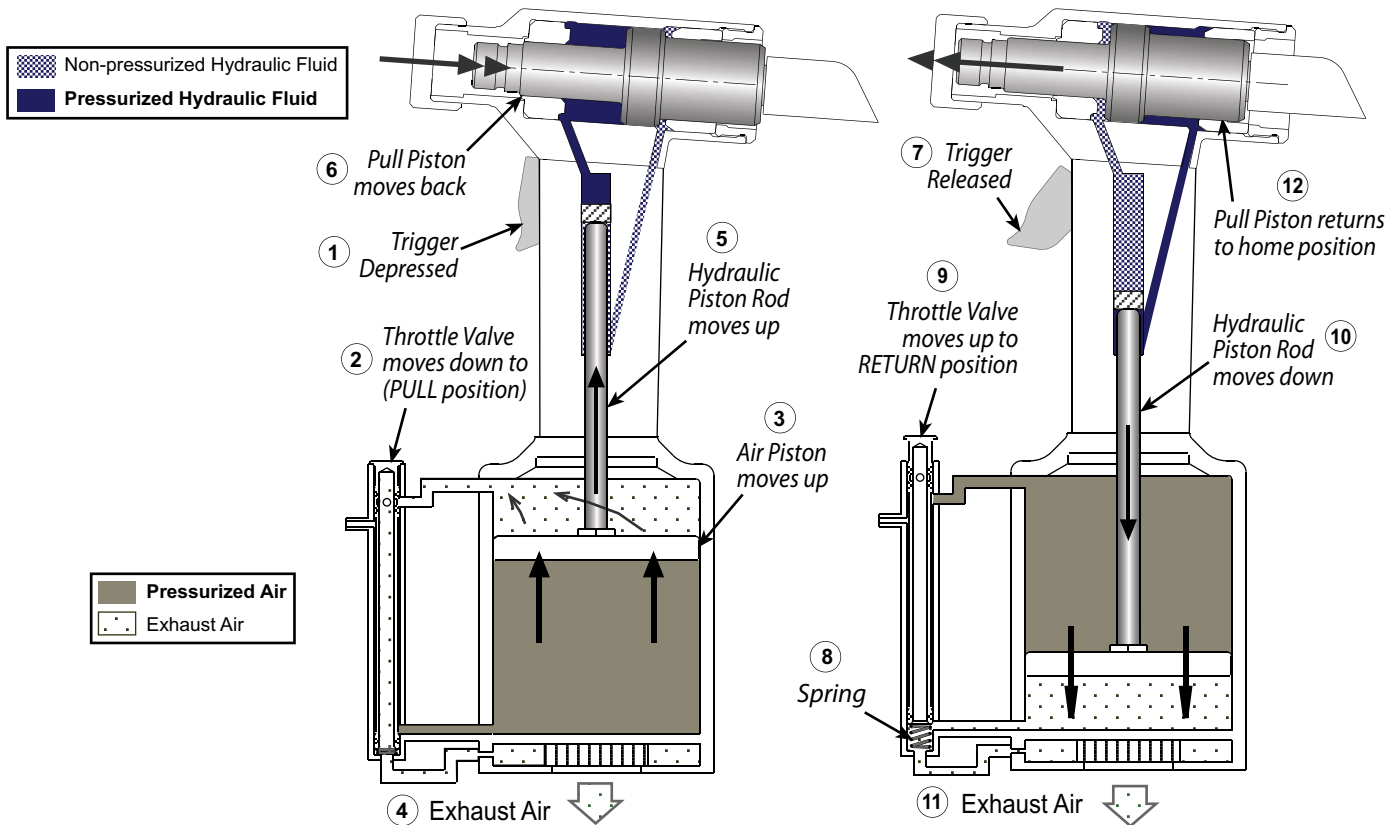
WEIGHT:

8.67 lbs (3.9 kg)





PRINCIPLE OF OPERATION



PULL

When the trigger is depressed, the throttle valve moves to down position, and pressurized air is directed to the bottom of the air piston, causing the piston to move upward. The air above the piston is exhausted and directed through the center of the throttle valve and out the bottom of the tool. The air piston has a rod and a hydraulic piston attached. When the air piston rod moves upward, a column of pressurized fluid is forced into the head, which moves the pull piston back. The attached nose assembly moves with the pull piston to start fastener installation.

RETURN

When fastener installation is completed, the trigger is released. Air pressure, with the assistance of a spring, causes the throttle valve to return to its up position. Pressurized air is re-directed to the top of the air piston, causing the piston to move downward. The air from below the piston is exhausted through bottom of tool. The rod and hydraulic piston move downward, hydraulic pressure is reversed and the pull piston is returned forward. The return pressure relief valve protects the tool against pressure spikes. The reservoir replenishes the hydraulic system as needed.



PREPARATION FOR USE

The Model 254 Installation Tool is shipped with a plastic plug in the air inlet connector. The connector has 1/4-18 female pipe threads to accept the air hose fitting. Quick disconnect fittings and 1/4" inside diameter air hose are recommended. An air supply of 90-100 psi capable of 13.5 CFM must be available. Air supply should be equipped with a filter-regulator-lubricator unit.

1. Remove plastic shipping plug from Air Inlet Connector and put in a few drops of Automatic Transmission Fluid, DEXRON III, or equivalent.
2. Screw quick disconnect fitting into Air Inlet Connector.



CAUTION: Do not use TEFLON® tape on pipe threads. Pipe threads may cause tape to shred resulting in tool malfunction. (Threadmate™ is available from Huck in a 4oz. tube as part number 508517.)

3. Set air pressure on regulator to 90-100 psi.
4. Attach optional Air Hose (38), supplied with tool, to air inlet connector.
5. Connect air hose to tool.
6. Cycle tool a few times by depressing and releasing trigger.

7. Disconnect air hose from tool.
8. Remove Retaining Nut and Stop.
9. Select proper Nose Assembly for fastener to be installed.
10. Screw Collet Assembly (including lock collar and shim if applicable) onto Spindle holding Pull Piston (11) with 3/8 hex key. (Wrench Tight)
11. Slide Anvil over Collet Assembly and into counterbore.
12. Slide Stop and Retaining Nut over Anvil and screw Nut onto Head.
13. Connect air hose to tool and install fastener(s) in test plate of proper thickness with proper size holes. Inspect fastener(s).

NOTES:

1. Air quick disconnect fittings and air hoses are not available from Huck International, Inc.
2. Loctite® 243 threadlocker (Huck P/N 508567) should be used on collet threads for nose assemblies without lock collars. All other noses should be staked.

* *Threadmate is a registered trademark of Parker Intangibles LLC*

* *TEFLON is a registered trademark of DuPont Corp.*

* *Loctite is a registered trademark of Henkel Corporation, U.S.A.*

MAINTENANCE

GENERAL

1. The efficiency and life of any tool depends upon proper maintenance. Regular inspection and correction of minor problems will keep tool operating efficiently and prevent downtime. The tool should be serviced by personnel who are thoroughly familiar with how it operates.
2. A clean, well-lighted area should be available for servicing the tool. Special care must be taken to prevent contamination of pneumatic and hydraulic systems.
3. Proper hand tools, both standard and special, must be available.
4. All parts must be handled carefully and examined for damage or wear. Always replace Seals, when tool is disassembled for any reason. Components should be disassembled and assembled in a straight line without bending, cocking, or undue force. Disassembly and assembly procedures outlined in this manual should be followed.
5. **Service Parts Kit 254KIT** includes consumable parts and should be available at all times. Other components, as experience dictates, should also be available.



WARNING: Inspect tool for damage or wear before each use. Do not operate if damaged or worn, as severe personal injury may occur.

DAILY

1. If a Filter-Regulator-Lubricator unit is not being used, uncouple air disconnects and put a few drops of Automatic Transmission Fluid or light oil into the air inlet of the tool. If the tool is in continuous use, put a few drops of oil in every two to three hours.
2. Bleed the air line to clear it of accumulated dirt or water before connecting air hose to the tool.
3. Check all hoses and couplings for damage or air leaks, tighten or replace if necessary.
4. Check the tool for damage or air/hydraulic leaks, tighten or replace if necessary.
5. Check the nose assembly for tightness or damage, tighten or replace if necessary.
6. Check oil level in tool reservoir, replenish if necessary.

WEEKLY

1. Disassemble and clean nose assemblies and reassemble.
2. Check the tool and all connecting parts for damage or oil/air leaks, tighten or replace if necessary.



OPERATING INSTRUCTIONS

READ ALL WARNINGS AND CAUTIONS PRIOR TO USING YOUR SYSTEM.

Failure to understand WARNINGS may cause serious personal injury.

Failure to understand CAUTIONS may cause damage to structure and Tool.

Additional safety information can be found on page 4.

LOCKBOLT® FASTENER INSTALLATION:



WARNING: Do not pull on a pin without a collar. The pin will eject with velocity and force when the pintail breaks off. This may cause serious injury.



CAUTION: Remove excess gap from between the sheets. This permits enough pintail to emerge from collar for ALL jaw teeth to engage with pintail. If ALL teeth do not engage properly, jaws will be stripped/damaged.

Place pin in work hole and place collar over pin. See **WARNING**. (If Collar has only one tapered end, that end must be out toward tool, not next to sheet.) Hold pin and push nose assembly onto pin protruding through collar until nose assembly anvil touches collar. Depress trigger and hold depressed until collar is swaged and pintail breaks. Release trigger and tool will go into return stroke. The tool and nose assembly are ready for the next fastener installation cycle.

BLIND FASTENER INSTALLATION:



WARNING: Do not pull on a fastener's pin without first placing fastener in a work piece. The fastener will eject forcibly when the pintail breaks off. This may cause serious injury.

Remove excess gap from between the sheets to permit correct fastener installation. Fastener may be placed in work hole or in end of nose assembly. See **WARNING**. In either case, tool and nose assembly must be held against work and at right angles to it. Depress trigger and hold it depressed until fastener is installed and pintail breaks. Release trigger and tool will go into its return stroke. The tool and nose assembly are ready for next fastener installation cycle.

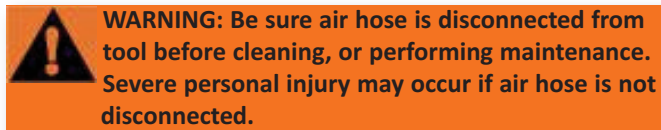


CAUTION: To avoid structural and Tool damage, be sure enough clearance is allowed for nose assembly at full stroke. Do not abuse the tool by dropping it, using it as a hammer or otherwise causing unnecessary wear and tear. Reasonable care of installation tools by operators is an important factor in maintaining tool efficiency and reducing downtime.



DISASSEMBLY

For component identification see Figures 1 thru 4 and 9.

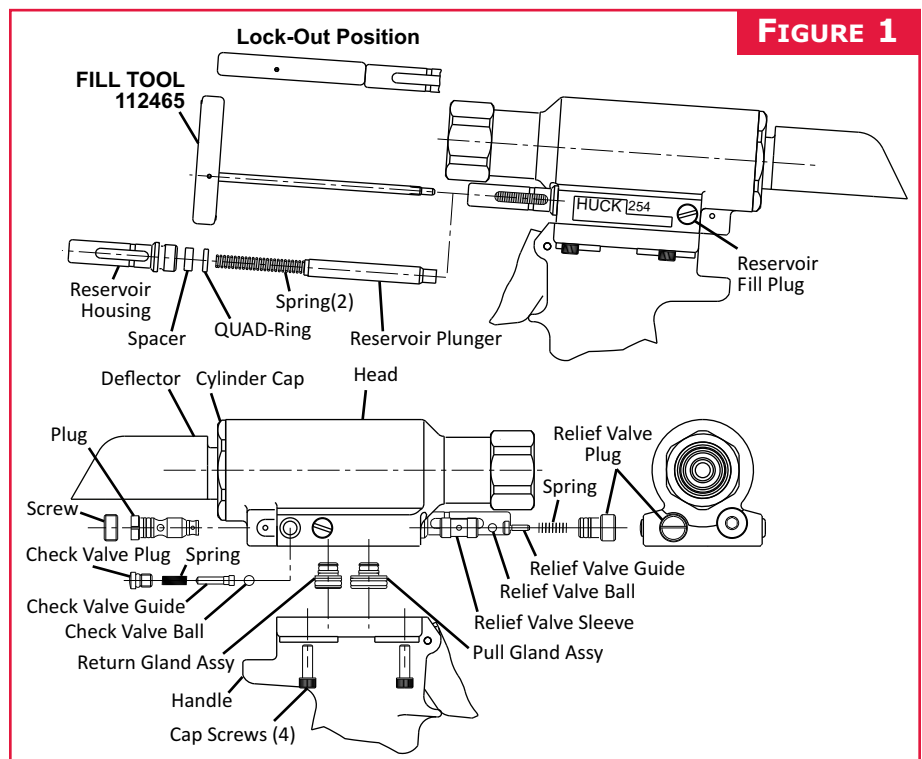


NOTE: The following procedure is for complete disassembly of tool. Disassemble **only** components necessary to replace damaged O-Rings, Quad Rings, Back-up Rings, and worn or damaged components. Always use soft jaw vice to avoid damage to tool.

1. Disconnect air hose from tool.
2. Remove nose assembly. Follow instructions on Nose Assembly Data sheet.
3. Insert Fill Tool P/N 112465 through reservoir housing and screw into Reservoir Plunger locking it in the out position.
4. Unscrew Cap Screws with 5/32 hex key. Carefully lift Head straight up from Handle, remove Pull Gland and Return Gland from separated assemblies. Remove seals from glands.
5. Unscrew Plug of return Pressure Relief Valve from front of head. Remove Spring, Valve Guide, Sleeve and Steel Ball. A small magnet is helpful.
6. Unscrew Bleed Plug. Hold over waste oil container and release fill tool slowly.
7. Unscrew Reservoir Housing from head. Remove two Springs. Slide Reservoir Plunger from head. Remove spacer and Quad ring. A pick may be used to remove the quad ring.
8. Unscrew Plug of reservoir check Valve from side of head. Remove Spring, check Valve Guide and Stainless Steel Ball.
9. If check Valve Seat is damaged contact your Huck representative. If Seat is damaged it can be removed (*through the front of the tool head only*) by using the following procedure.
NOTE: If seat is taken out it can not be reused, it must be replaced.
10. **SEAT REMOVAL**
NOTE: All parts in the reservoir check valve must be removed before Plug can be removed. Unscrew Plug, insert a #10 screw in the thread of Plug, and pull to remove. Using a small drift and hammer,

from the rear side of the head, drive Seat out towards the front of the head.

11. Pintail Deflector can be pulled off barbed end at rear of Pull Piston.
12. Unscrew End Cap from Head with 1 9/16 open end wrench.
13. Place Spacer (123112-1) on Pull Piston, and screw Assembly/disassembly Bullet (123111-1) onto piston. Tap or press piston assembly out of head.
NOTE: This will push out front and rear gland assemblies and wiper and wiper housing.
14. Remove Screw from Throttle Arm. Remove throttle arm. Pull Throttle Valve out of cylinder. Remove Spring.
15. With a small punch and hammer, drive Roll Pin that retains the trigger from Handle. Remove trigger pin. Remove ball end of Cable from throttle arm, and pull cable out of handle.
16. Remove Bleed Plug from handle.





DISASSEMBLY (CONTINUED)

17. Hold tool inverted in vice. Unscrew three Button Head Screws with 1/8 hex key (Fig 3).
18. Remove Muffler End Cap, Bottom Exhaust Gasket, Muffler and O-Ring.
19. Remove Retaining Ring from Cylinder Assembly.
NOTE: Tap cylinder head down into cylinder for easier removal of retaining ring.
20. Screw Button Head Screws into Cylinder Head. Carefully pry under screws to remove cylinder head.
21. Push air piston all the way down in cylinder, and lay tool on its side. Hold Self-locking Nut with a 9/16 socket and extension and with 3/16 hex key, remove piston (Fig 4).

22. Turn cylinder and handle upside down and secure in a vise.
23. Grip Self-locking Nut under Air Piston with pliers and pull piston and rod assembly from handle and cylinder assembly.



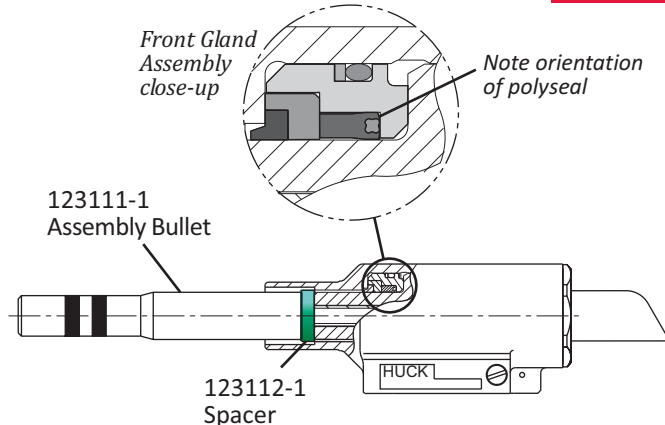
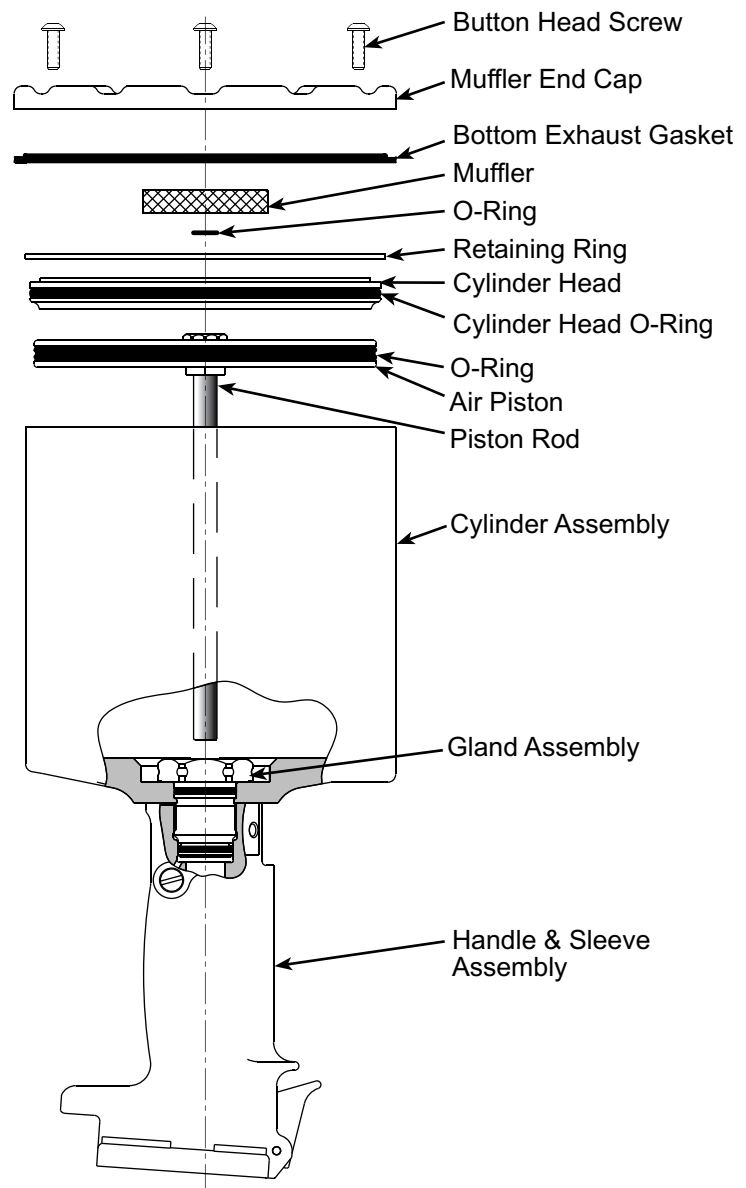
CAUTION: Care must be given not to scratch piston rod or cylinder during removal.

24. With a 1 3/8 socket and extension, remove Gland Assembly. Handle and cylinder will now separate.
25. Push Hydraulic Piston out of handle. Push out from top to bottom.



CAUTION: A plastic or wooden drift must be used to avoid damaging the handle bore.

26. To remove Polyseal from Gland Assembly, remove Retaining Ring and Spacer.

FIGURE 2

FIGURE 3




ASSEMBLY

(Refer to Figures 1 thru 5 and 9.) Clean components with mineral spirits, or similar solvent. Inspect for wear or damage and replace as necessary. Replace all seals of disassembled components. Use O-Rings, Quad rings and Back-up rings in **Service Parts Kit 254KIT**. Smear LUBRIPLATE 130AA or PARKER-O-LUBE on O-Rings, Quad rings, Back-up rings and mating parts to ease assembly. Assemble tool giving care not to damage O-Rings, Quad rings, or Back-up rings.

1. Holding handle inverted in a vice, place Cylinder on handle with Timing Pin positioned in matching hole. Assemble Gland Assembly, screw it into handle, and torque to 75-80 ft. lbs. using 1 3/8 socket wrench.
2. Push Air Piston/Rod assembly with O-Ring in place into Air Cylinder until it bottoms at top of Cylinder. (Fig 3) Clean threads on piston rod 130296 and apply Loctite 243 to threads per manufacturer's instructions.

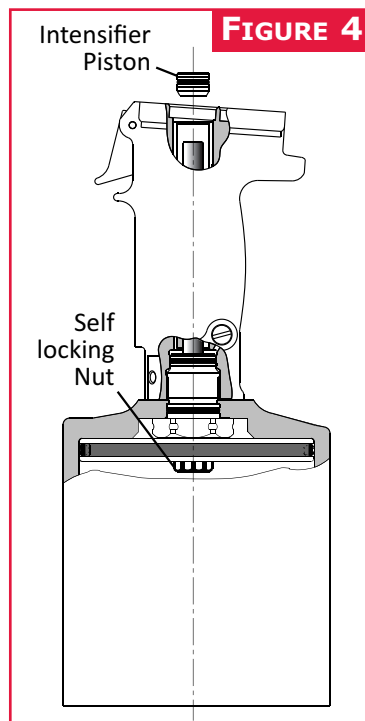
3. Turn tool upright. Install Intensifier Piston Assembly (with O-Ring and Back-up Rings in place) in handle. Press in from top of handle **without damaging seals**. (Fig. 4)

4. Hold Self-locking Nut with 9/16 socket and extension and torque Piston using 3/16 hex key to 14-16 ft. lbs. Torque Nut to 28-32 ft. lbs.

5. Hold handle in vise with bottom facing up. Push Cylinder Head with O-Ring in place squarely into cylinder. Install Retaining Ring.

6. Position O-Ring and Muffler on center of Cylinder Head. Place Gasket on Cylinder Assembly.

NOTE: Lip must face Muffler End Cap. Place Muffler End Cap on top of Gasket, and secure with 3 Button Head Screws using 1/8 hex key.



7. Turn tool upright. Drop Spring into Throttle valve hole in cylinder. Push Throttle Valve with O-Rings in place into cylinder.

8. Assemble Trigger Cable and Trigger Pin, and slide cable into Handle. Align hole in trigger with hole in handle and install Roll Pin with a hammer and punch.

9. Slide Throttle Arm onto ball end of Throttle Cable. Swing arm until other end fits over throttle valve. Push Screw through Throttle Arm. Tighten with 5/32 hex key.

10. Reinstall Air Hose Assembly if it was removed.

11. (If seat is being replaced) Push Plug 120204 (Fig. 10) (with O-Ring & Back-up Ring in place) into head. Install Screw.

12. Install O-Ring and Back-up rings onto seat. Drive seat and seal assembly in using soft drift taking care not to damage ball seat surface.

13. Assemble Pull Piston with new Seals. Lubricate with LUBRIPLATE or PARKER SUPER-O-LUBE.

14. Thread Assembly Bullet (123111-1) onto Pull Piston (11) and push entire assembly into head.

NOTE: Spacer (123112-1) is **not** needed for this procedure.

15. Push Front Gland with O-Ring, Back-up Ring, Polyseal, Wiper Housing and Wiper Seal in place onto Pull Piston.

16. Install O-Rings and Back-up Rings on Rear Gland. Push complete assembly into head, screw in End Cap and torque Cap to 55-60 ft.lbs.

17. Install O-Ring & Back-up Ring on Relief Valve Plug. (Fig. 10) Install Ball, Valve Guide, Sleeve, Spring and Plug into head.

18. Install O-Ring on Check Valve Plug. Install Ball, Guide, Spring and Plug into head.

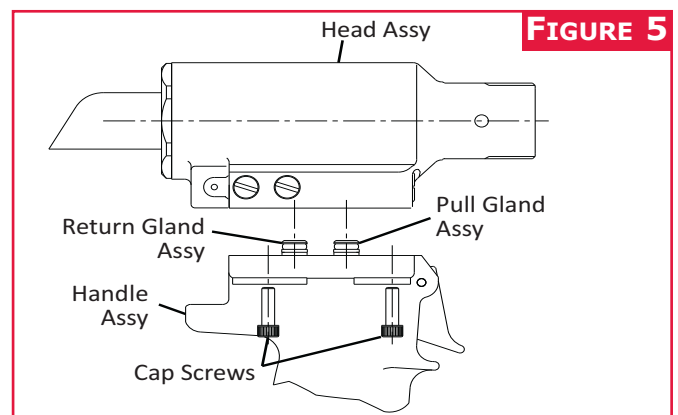
19. Push Pintail Deflector onto end of Pull Piston.

20. Place O-Ring on Bleed Plug and screw assembly into Handle.

21. Install O-Rings & Back-up Rings on Pull Gland, O-Rings and Back-up Rings on Return Gland, and push Gland Assemblies into handle. Push Head down on glands. Place tool in a vise, head down, and install 4 Screws and torque to 170 inch pounds.

22. To adjust Throttle Valve and Arm: With tool connected to the air source and the air on, depress trigger and hold. Screw Oval Point Setscrew 502053 (Fig. 12) down until top of Throttle Valve is almost flush with top of bronze bushing. Release trigger install Cone Point Setscrew 501763. Tighten Cone Point Setscrew against Oval Point Setscrew to lock adjustment. **NOTE:** Throttle Valve must be adjusted prior to fastener installation.

23. Tool is now assembled and ready for Fill and Bleed.





FILL AND BLEED

Equipment Required:

- Shop airline with 90-100 psi max.
- Air regulator
- Fill Bottle 120337 (supplied with tool).
- Fill Tool Assy 112465
- Large flat blade screwdriver
- Stall Nut 124090
- Nose assembly
- Fasteners (Optional)

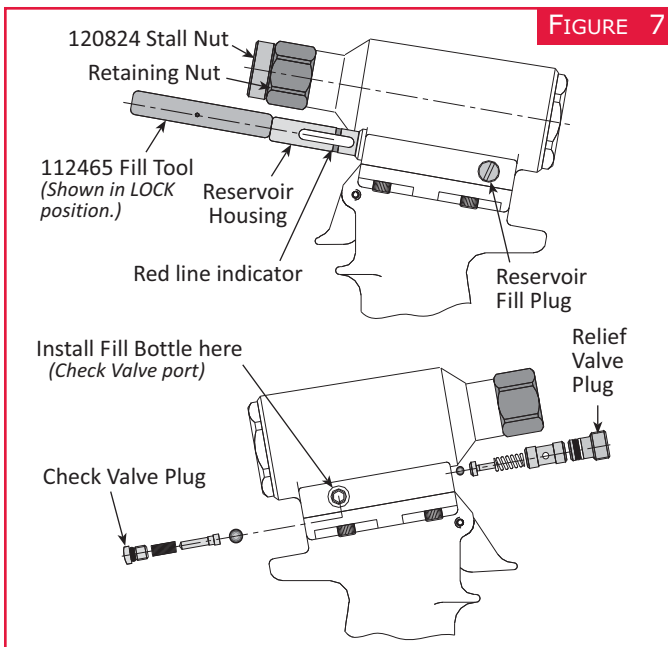
Preparation:

1. Install air regulator in airline and set pressure to 20-40 psi.
2. Fill bottle almost full of DEXRON III - ATF (automatic transmission fluid). NOTE: Refill tool only when red line on plunger drops below the red line on the reservoir housing or when tool is rebuilt.

WARNING: Avoid contact with hydraulic fluid. Hydraulic fluid must be disposed of in accordance with Federal, State and Local Regulations. Please see MSDS for Hydraulic fluid shipped with tool.

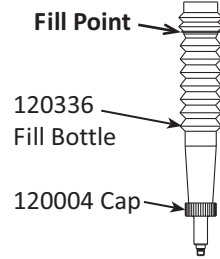
STEP 1: Screw Fill Tool into Reservoir Plunger, pull Plunger into Reservoir Housing and lock Fill Tool in full forward position by tilting handle (long side touching tool) and locking in place. (Figure 7)

STEP 2: Remove Relief and Check Valve Plugs, Guides, Springs and Balls from ports in head. Reinstall Plug and Sleeve in head in Relief Valve port (front of tool).



STEP 3: Screw retaining nut onto Head Assembly. Screw Stall Nut onto Hydraulic Piston and tighten to ensure full thread engagement. Back off Retaining Nut until it engages Stall Nut. Check that Hydraulic Piston is all the way forward and locked with Retaining Nut and with (or without) Stall Nut.

FIGURE 6
120337 Fill Bottle Assy

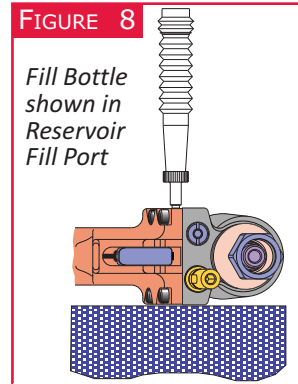


STEP 4: Attach the tool air source momentarily to seat Air Piston at bottom of Air Cylinder, then disconnect tool. **With Reservoir Fill port facing up, lay tool on its side.**

STEP 5: Install Fill Bottle in Reservoir Fill port. (Figure 8)

STEP 6: Connect tool to shop air 20 to 40 psi. Cycle tool 20-30 times, watch for air bubbles escaping from the tool into bottle. (You may rock the tool to free trapped air in the tool.) Do not allow the air to re-enter the tool. When cycling tool, always hold bottle up as shown in Figure 10 to prevent drawing in air from empty part of bottle.

STEP 7: When air bubbles no



WARNING: Air pressure MUST be set to 20 to 40 psi to prevent possible injury from high pressure spray. If plug is removed, fill bottle must be in place before cycling tool.

longer appear in bottle, remove Fill Bottle and replace the Reservoir Fill Plug while tool is lying on its side.

STEP 8: Install the Check Valve Ball, Guide and Spring. Replace the Check Valve Plug.

STEP 9: Turn tool so front of head faces you. Prior to removing Relief Valve Plug, using a 3/32 Allen wrench, back out setscrew inside of the plug approximately 1/2 turn counterclockwise. This ensures that the Piston will remain in full-forward position. Remove the Relief Valve Plug, install Ball, Guide, Sleeve and Spring, and replace the plug.

STEP 10: Unlock Fill Tool and check Reservoir red line. Cycle the tool the with Stall Nut attached and Retaining Nut locked in the full-forward position ("Dead Stall"). Reservoir should not drop below the red line on the Reservoir housing.

STEP 11: Re-lock the fill tool. Lay tool on its side and remove Reservoir Fill Plug. Top off Reservoir by placing a few drops of oil in hole and waiting for air bubbles to escape. Push a pin or a scribe into hole to check for trapped air bubbles. Replace Plug.

WARNING: Failure to re-lock the fill tool will result in oil being ejected from the head under pressure during the topping off of the reservoir. Severe personal injury may result.

STEP 12: Unlock the Fill Tool and cycle tool as in step 10. Reservoir may drop slightly. If so, repeat step 11 until, when the Fill Tool handle is touched, it has no pressure against it and it drops out of the lock position, and the Reservoir Plunger does not drop when tool is cycled.

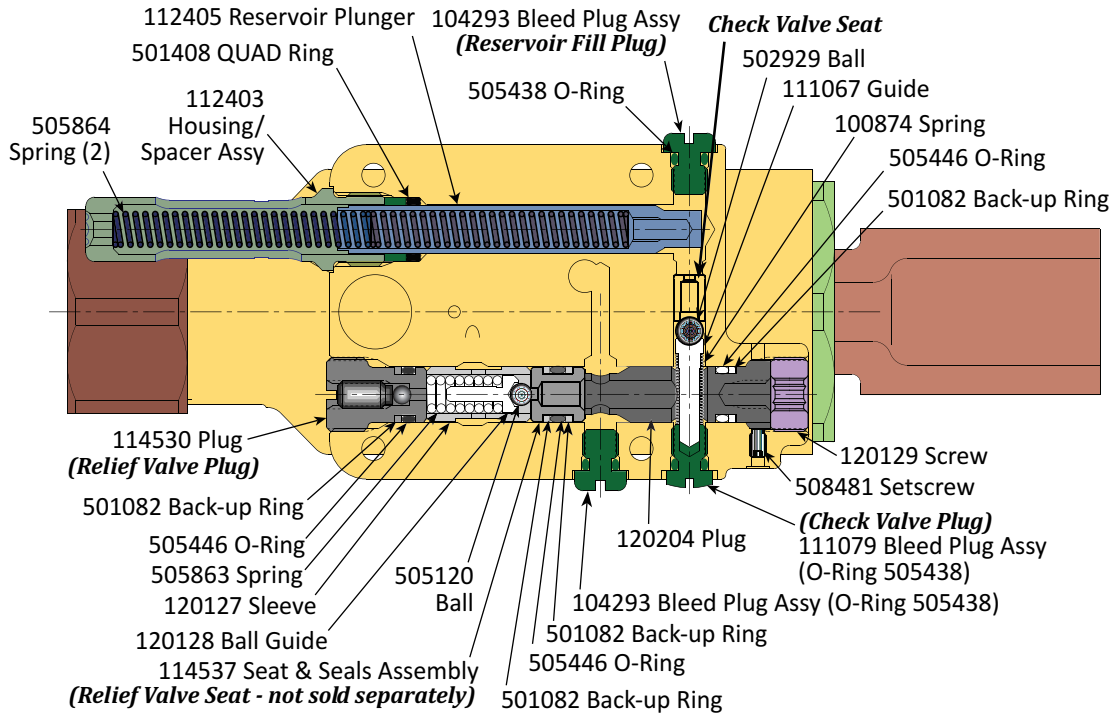
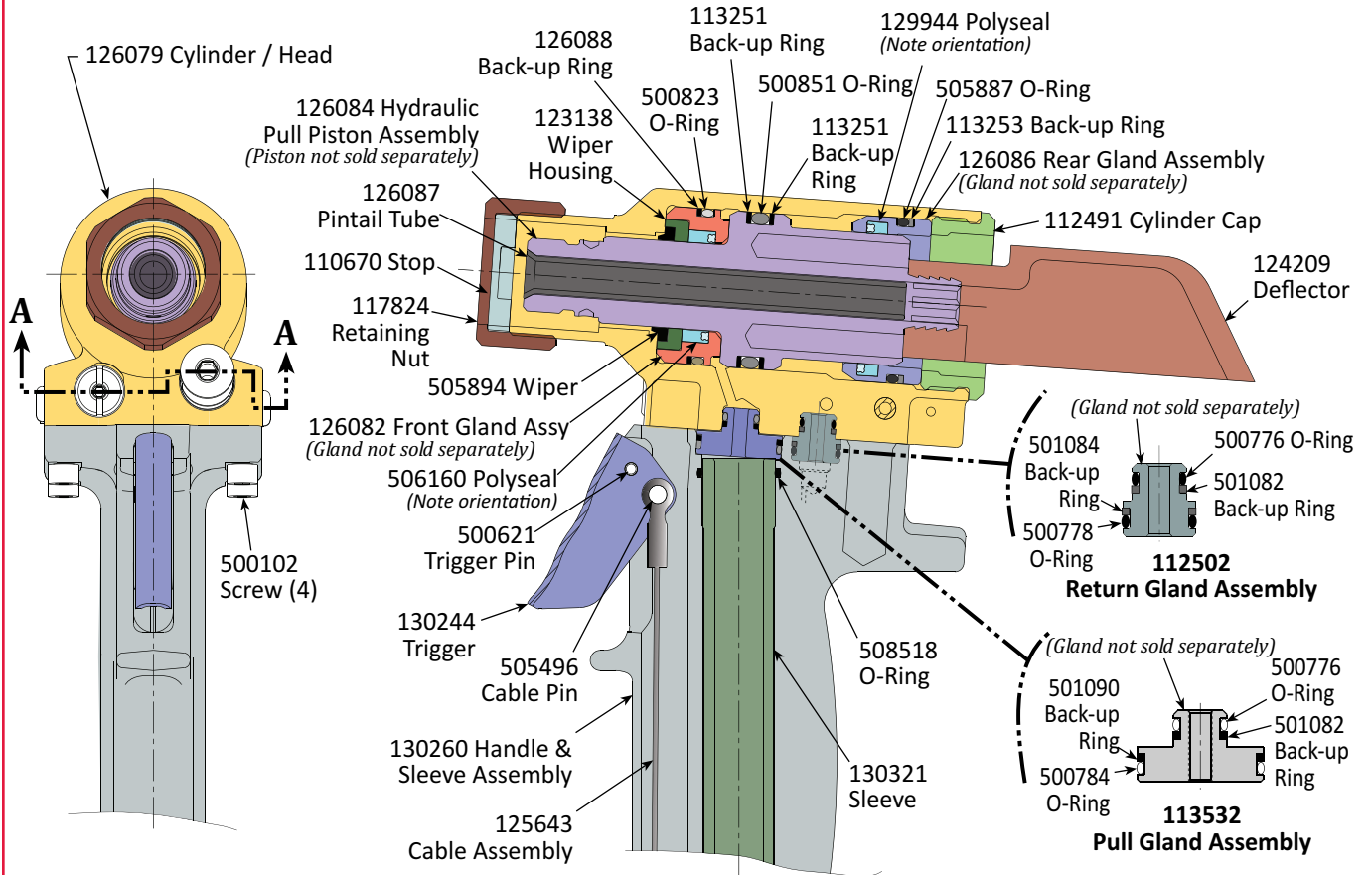
NOTE: This usually requires 3 to 4 times topping off.

STEP 13: Remove Fill Tool and Stall Nut. Install a nose assembly and pull several fasteners to test function.



ASSEMBLY DRAWING

FIGURE 10

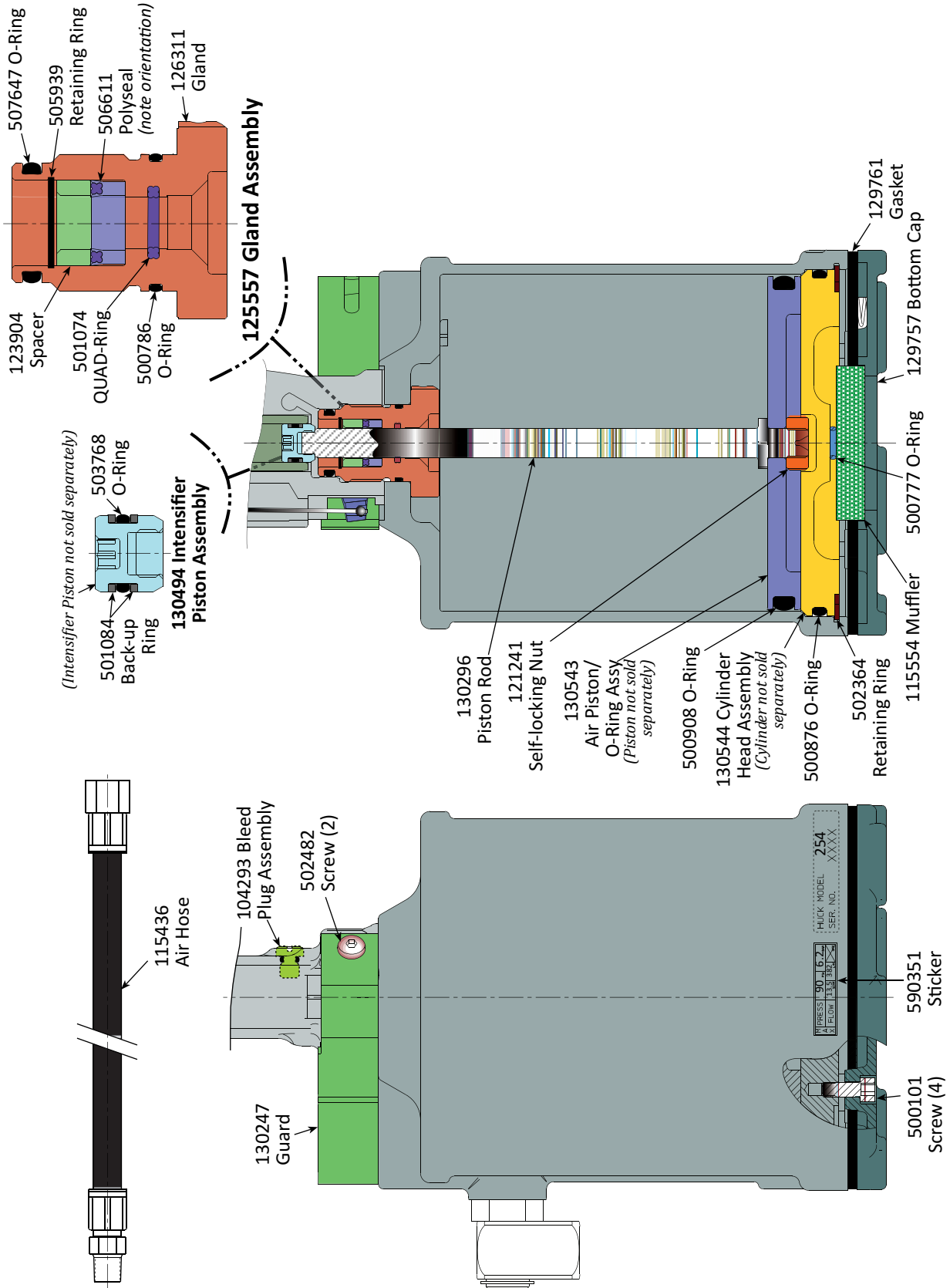


SECTION A-A
Rotated 90° CCW



ASSEMBLY DRAWING

FIGURE 11





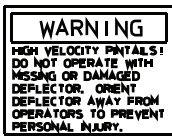
ASSEMBLY DRAWING

FIGURE 12

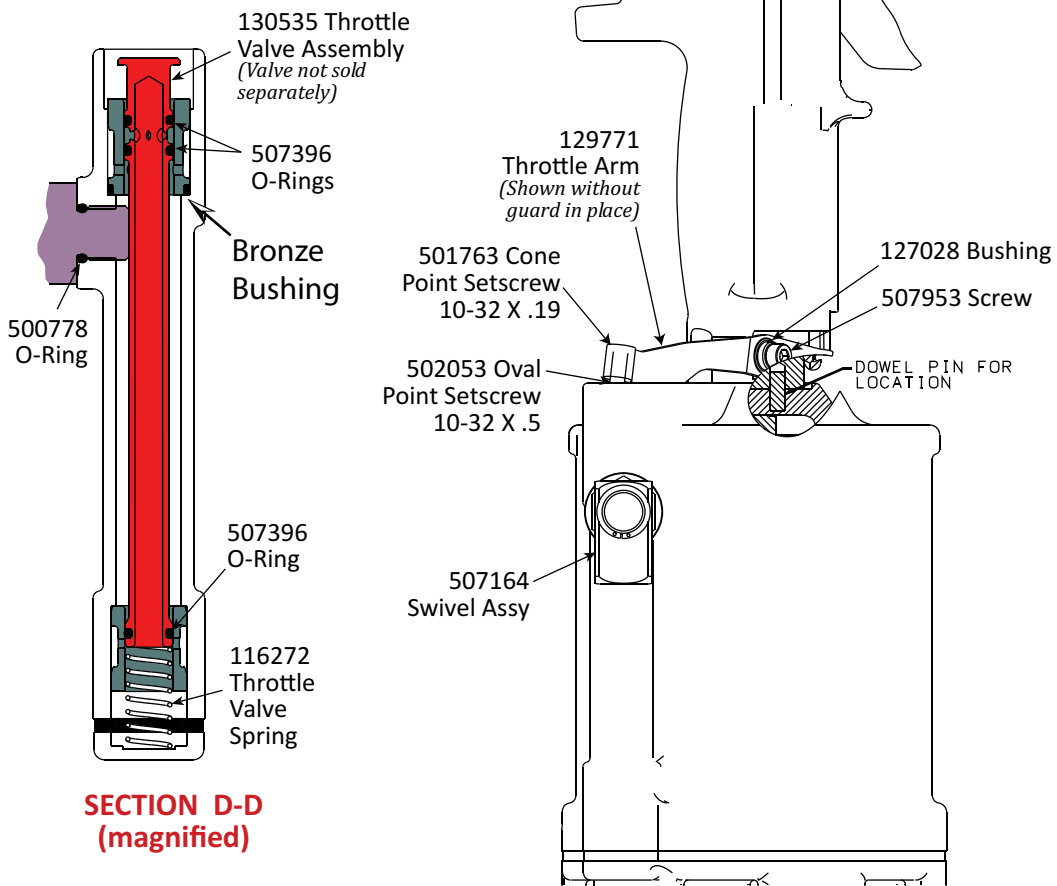
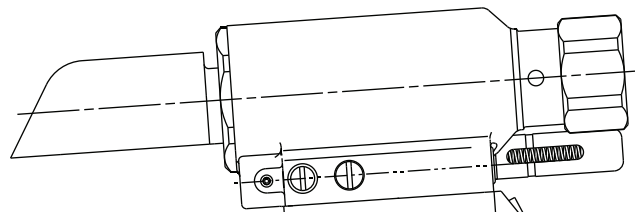
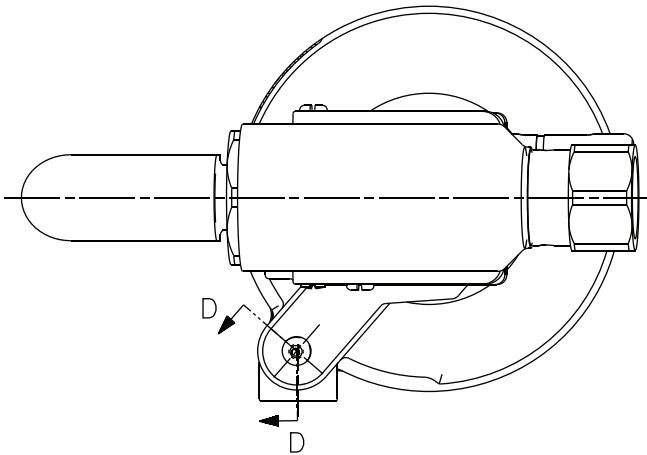
The 254 tool comes labeled with important stickers on the outside of the cylinder which contain safety information.

It is necessary that these stickers remain on the tool and are easily read. If stickers become damaged or worn, or if they have been removed from the tool, they must be replaced.

59240-1
WARNING Sticker



590517
Trademark / Year of Manufacture Sticker





TROUBLESHOOTING

Always check out the simplest possible cause of a malfunction first. For example, an air hose not connected. Then proceed logically, eliminating each possible cause until the cause is located. Where possible, substitute known good parts for suspected bad parts. Use TROUBLESHOOTING CHART as an aid in locating and correcting malfunction. **NOTE:** "Piston drift" is when the air piston is in the down position, but the hydraulic pull piston is not in the full forward position. This causes an out of sequence condition.

1 Tool fails to operate when trigger is depressed.

- a) Air line not connected
- b) Throttle Valve O-rings worn or damaged.
- c) Throttle Valve Cable is broken.

2 Tool does not complete fastener installation and break pintail.

- a) Air pressure too low
- b) Air Piston Quad Ring worn or damaged.
- c) Reservoir empty or low, refer to Fill and Bleed section.
- d) Air in hydraulic system, refer to Fill and Bleed section.
- e) Reservoir Springs worn or damaged
- f) Check for piston drift

3 Pintail stripped and/or swaged collar not ejected.

- a) Check for broken or worn jaws in nose assembly, refer to nose assembly data sheet.
- b) Check for loose Retaining Nut
- c) Check for piston drift.

4 Tool has piston drift.

- a) Loose collet crashing into the front of the anvil causes the relief valve to open allowing the piston to drift. Tighten the collet and refer to Fill and Bleed section.
- b) Worn or damaged Return Pressure Relief Valve in tool, inspect Seat, O-Ring, Back-up Rings, Steel Ball and Valve Spring. Replace if necessary.
- c) Worn or damaged Intensifier Piston Assembly: Inspect O-Rings and Back-up Rings, and replace if necessary.

5 Hydraulic fluid exhausts with air or leaks at base of handle.

- a) Worn or damaged Gland Assembly: Inspect Polyseal, O-rings, Quad Ring, and Back-up Ring, and replace if necessary.

6 Hydraulic fluid leaks at rear of Pull Piston

- a) Worn or damaged Rear Gland: Inspect O-Rings and Back-up Rings, and replace if necessary.

7 Hydraulic fluid leaks at front of Pull Piston.

- a) Worn or damaged Front Gland: Inspect Polyseal and replace if necessary.

8 Pull Piston will not return.

- a) Throttle Valve stuck: Lubricate O-Rings.
- b) Throttle Arm, Cable, or Trigger binding.

9 Air leaks at Air Cylinder Head.

- a) Worn or damaged O-Ring. Replace if necessary.

ACCESSORIES

Service Kit - 254KIT
(includes most consumable parts such as seals, deflector, springs, etc.)

Stall Nut (Fig. 7) - 120824

Service Tool Kit - 126104

Includes:

Assembly Bullet (Fig.2) - 123111-1
Spacer (Fig. 2) - 123112-1



LIMITED WARRANTIES

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Huck warrants that tooling and other items (excluding fasteners, and hereinafter referred as "other items") manufactured by Huck shall be free from defects in workmanship and materials for a period of ninety (90) days from the date of original purchase.

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One Corporate Drive Kingston, New York 12401-0250
Telephone (845) 331-7300 FAX (845) 334-7333

Outside USA and Canada

Contact your nearest Huck International Office, see back cover.

In addition to the above repair facilities, there are Authorized Tool Service Centers (ATSC's) located throughout the United States. These service centers offer repair services, spare parts, Service Parts Kits, Service Tools Kits and Nose Assemblies. Please contact your Huck Representative or the nearest Huck office listed on the back cover for the ATSC in your area.

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One Great ConnectionSM

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