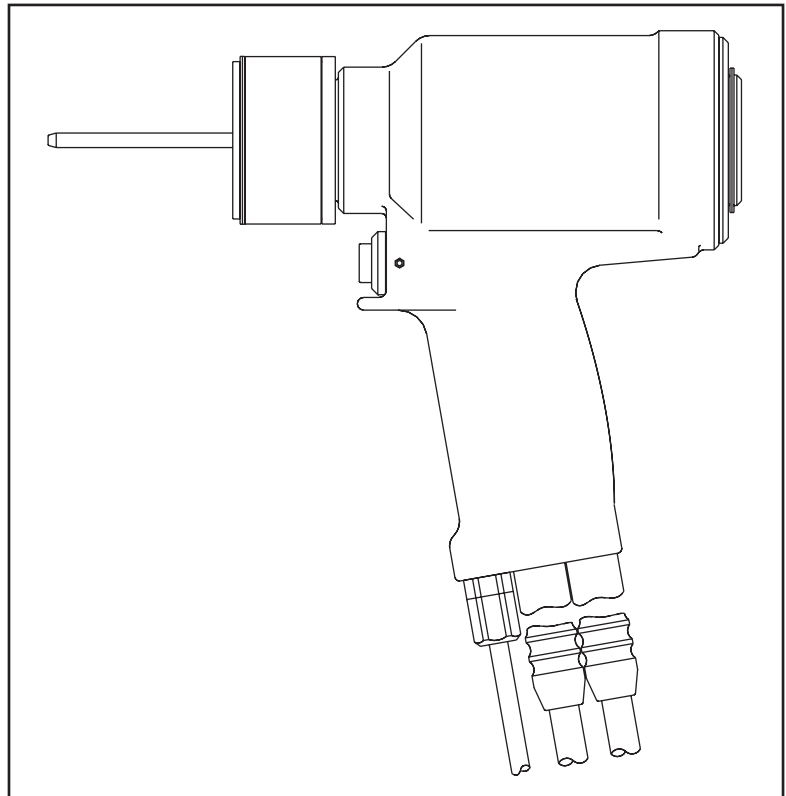


Alcoa
Fastening
Systems



INSTRUCTION MANUAL
2620
A2620
2620-PT
A2620-PT
HYDRAULIC INSTALLATION TOOLS



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

10-22-2004
HK1012



EU Declaration of Conformity

Manufacturer:

Alcoa Fastening Systems, Commercial Products Division, 1 Corporate Drive, Kingston, NY, 12401, USA

Description of Machinery:

Model numbers **2620 series** fastener installation tools

Relevant provisions complied with:

Council Directive related to Machinery, (89/392/EEC), (91/368/EEC), (93/44/EEC), (93/68/EEC)
Council Directive related to EMC/EMI, (89/336/EEC)

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: Henk Rosier

Position: Engineering Manager
Installation Systems Division

Place: Kingston, New York, USA

Date: October, 2004

Sound Levels

Models: 2620, A2620, 2620-PT, and A2620-PT

SEL = 92.2 dB (A)
peak value = 108.2 dB (C)

For an eight hour work day, installing 1,000 typical Huck fasteners will result in an equivalent noise level (Leq) of 77.7 dB (A).

To calculate equivalent noise level for other quantities of fasteners in an eight hour period, use the formula:

$$\text{Leq} = \text{SEL} + 10 \log (n/28,800)$$

where n = number of fasteners in eight hours.

Vibration Levels

Models: 2600, 2600-12, 2600-16, and 2600-16-12

For an eight hour work day, installing 1,000 typical Huck fasteners will result in an equivalent weighted RMS vibration level (Aeq) of 4.6m/s².

To calculate equivalent vibration level for other quantities of fasteners in an eight hour period, use the formula:

$$\text{Equivalent Vibration Level, Aeq (m/s}^2\text{)} = (n/480) \times 2.00$$

where n = number of fasteners in eight hours, and 2.00(m/s²) = Aeq for 60 seconds.

Test data to support the above information is on file at Alcoa Fastening Systems, Commercial Products Division, Kingston Operations, Kingston, NY, USA. Vibration measurements are frequency weighted in accordance with ISO 8041 (1990).


CONTENTS


EU DECLARATION OF CONFORMITY	2
CONTENTS	3
SAFETY	4
PRINCIPLE OF OPERATION	5
SPECIFICATIONS	6-7
PREPARATION FOR USE	8
SERVICING THE TOOL	
Good Service Practices	8-9
Preventive Maintenance	9
Disassembly	9-10
Assembly	11-12
Tool Assembly Drawings	13-16
Parts List	17
Hose Assembly For Electric Trigger Models	18
Hose Assembly For Air Trigger Models	19
TROUBLESHOOTING	20
KITS & ACCESSORIES	20


SAFETY


This instruction manual must be read with particular attention to the following safety guide lines, by any person servicing or operating this tool.

1. Safety Glossary

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

 — Read manual prior to using equipment.

 — Eye protection required while using this equipment.

 — Hearing protection required while using this equipment.



WARNINGS - Must be understood to avoid severe personal injury.

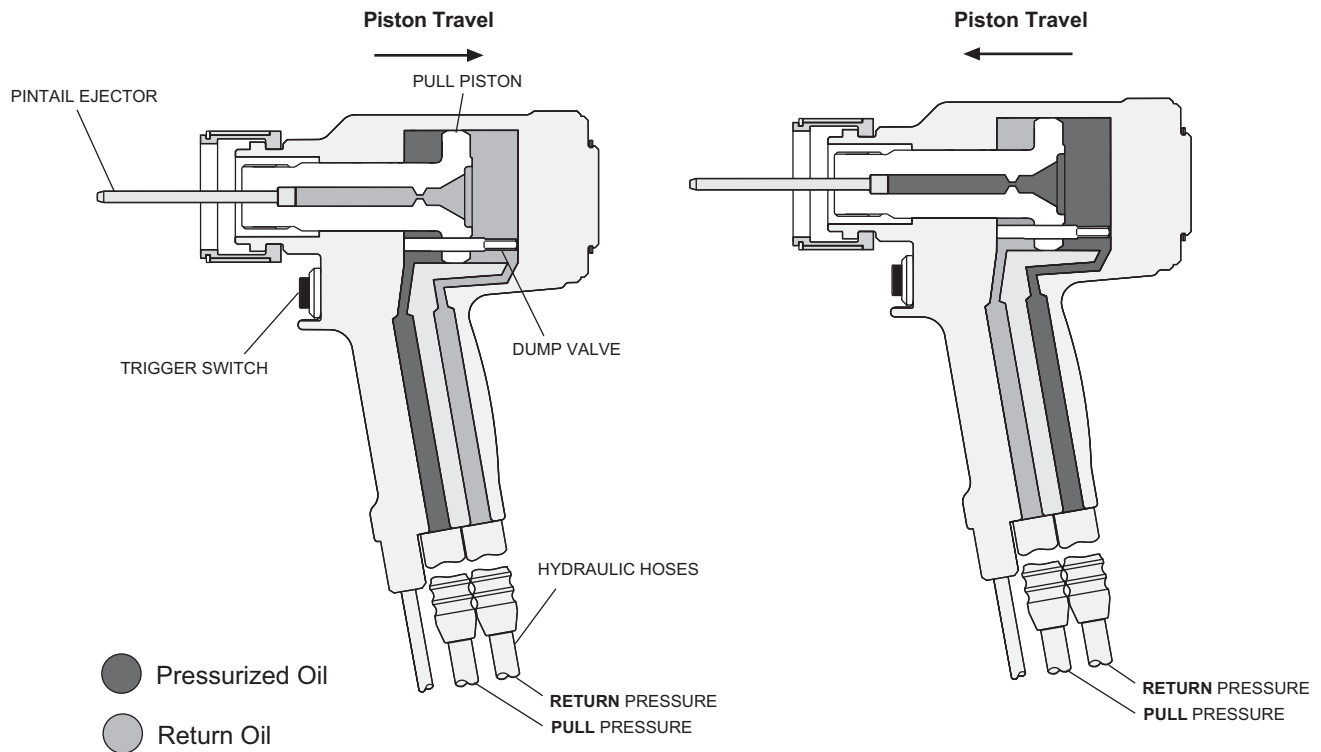
CAUTIONS - show conditions that will damage equipment and or structure.

Notes - are reminders of required procedures.

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

2. Huck equipment must be maintained in a safe working condition at all times and inspected on a regular basis for damage or wear. Any repair should be done by a qualified repairman trained on Huck procedures.
3. Repairman and Operator must read manual prior to using equipment and understand any Warning and Caution stickers/labels supplied with equipment before connecting equipment to any primary power supply. As applicable, each of the sections in this manual have specific safety and other information.
4. See MSDS Specifications before servicing the tool. MSDS Specifications are available from you Huck representative or on-line at www.huck.com. Click on Installation Systems Division.
5. When repairing or operating Huck installation equipment, always wear approved eye protection. Where applicable, refer to ANSI Z87.1 - 1989
6. Disconnect primary power source before doing maintenance on Huck equipment.
7. If any equipment shows signs of damage, wear, or leakage, do not connect it to the primary power supply.
8. Make sure proper power source is used at all times.
9. Never remove any safety guards or pintail deflector.
10. Never install a fastener in free air. Personal injury from fastener ejecting may occur.
11. When using an offset nose always clear spent pintail out of nose assembly before installing the next fastener.
12. If there is a pinch point between trigger and work piece use remote trigger. (Remote triggers are available for all tooling).
13. Do not abuse tool by dropping or using it as a hammer. Never use hydraulic or air lines as a handle. Reasonable care of installation tools by operators is an important factor in maintaining tool efficiency, eliminating downtime, and in preventing an accident which may cause severe personal injury.
14. Never place hands between nose assembly and work piece.
15. Tools with ejector rods should never be cycled with out nose assembly installed.
16. When two piece lock bolts are being used always make sure the collar orientation is correct. See fastener data sheet of correct positioning.

PRINCIPLE OF OPERATION



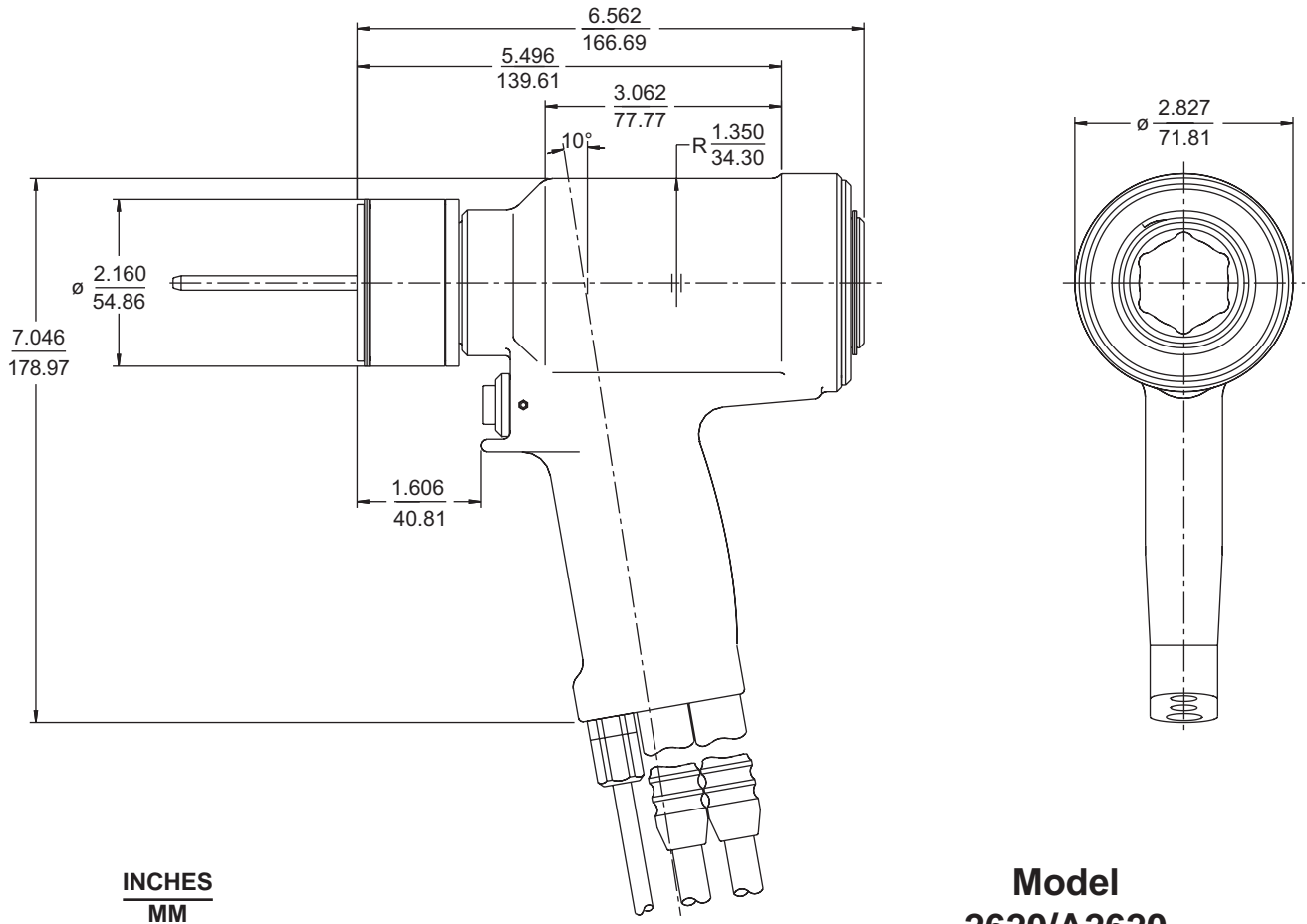
**Pull Pressure (Pull Cycle)
Fig. 1(a)**

**Return Pressure (Return Cycle)
Fig. 1(b)**

When the trigger is depressed, a solenoid operated valve in the POWERIG® directs pressurized hydraulic fluid through the PULL hose to the front side of the piston, and allows fluid on the RETURN side to flow back to the tank (Fig 1a). The piston and nose assembly collet moves rearward installing the fastener. When the piston reaches the end of the PULL stroke, it uncovers flats on the rear end of the unloading valve. These flats are designed to provide a passage for hydraulic fluid from the PULL side to the RETURN side of

the piston, "unloading" or "dumping" the pressurized fluid back to the tank (Fig 1a). When the trigger is released the solenoid is de-energized and the valve directs pressurized fluid to the rear side of the piston and allows fluid on the PULL side to flow back to the tank (Fig. 1b). This causes piston and collet to move forward and pushes the nose assembly and tool off the swaged (installed) fastener. When the piston reaches the end of the return stroke, pressure is built up, causing the power rig to shut off, completing the cycle.

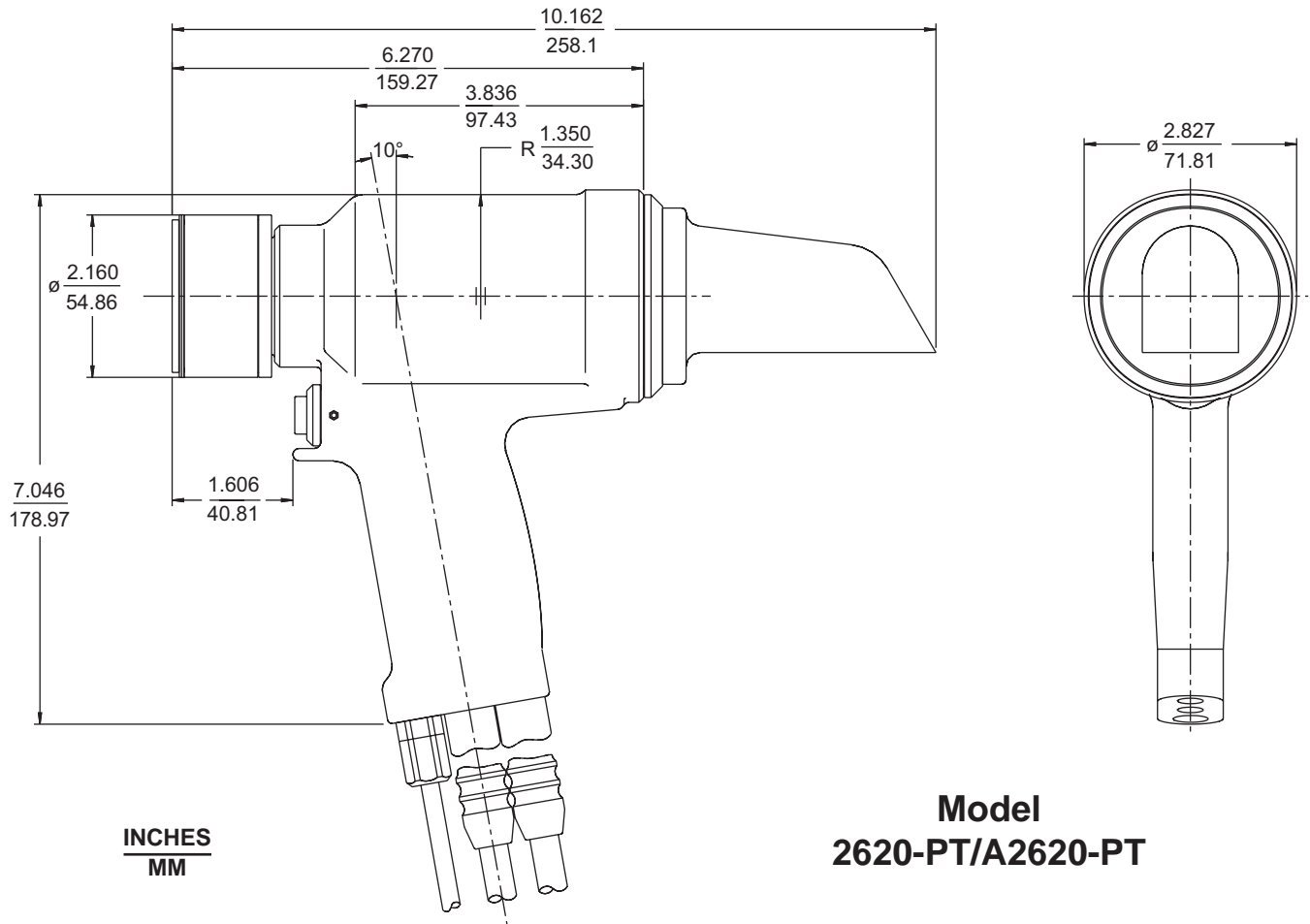
SPECIFICATIONS (2620/A2620)



Model
2620/A2620

- **Stroke:** 1.437in
- **Weight:** 9 lbs 14oz
- **Pull Pressure:** 7,400 psi
- **Return Pressure:** 3,200 psi
- **Capacity:** 17,745 lbs @ 6,500 psi
-

SPECIFICATIONS (2620-PT/A2620-PT)



- **Stroke:** 1.437 in
- **Weight:** 9 lbs 14oz
- **Pull Pressure:** 7,400 psi
- **Return Pressure:** 3,200 psi
- **Capacity:** 17,745 lbs @ 6,500 psi
-

PREPARATION FOR USE



1. Use Huck POWERIG® Hydraulic Unit, or equivalent, that has been prepared for operation per applicable **instruction manual**. Check both PULL and RETURN pressures, and if required, adjust to pressures given in **specifications of this manual**.



WARNING - Proper PULL and RETURN pressures are important for proper function of Installation Tools. Severe personal injury or damage to equipment may occur without correct pressures. Huck Pressure Gauge P/N T-10280 (old style) or the new T124833 is now available for checking these pressures using instructions furnished with the gauge and in applicable POWERIG® Hydraulic Unit instruction manuals. See Specifications.

2. First, turn hydraulic unit to OFF, and then, disconnect power supply from unit. Connect tool's hoses to unit.



WARNING - Be sure to connect tool hoses to hydraulic unit BEFORE connecting tool electrical switch cord to unit. Hoses and switch must be connected in this order and disconnected in the reverse order to prevent possible severe personal injury.

3. Connect tool's control switch electrical cord to hydraulic unit.
4. Connect hydraulic unit to power supply. Turn unit to ON. Hold tool trigger depressed for 30 seconds; depress trigger a few times to cycle tool and to circulate hydraulic fluid. Observe action of tool and check for leaks. Turn unit to OFF.
5. Select nose assembly for fastener to be installed. Disconnect tool's control switch electrical cord from hydraulic unit; disconnect unit from power supply. Attach nose assembly to tool.
6. Reconnect hydraulic unit to power supply. Reconnect tool's switch control cord to unit. Check operation of nose assembly; install fasteners in test plate of correct thickness with proper size holes. Inspect installed fasteners. If fasteners do not pass inspection, see **Troubleshooting** to locate and correct tool malfunction.

SERVICING THE TOOL



GOOD SERVICE PRACTICES

CAUTION: Keep dirt and other harmful material out of hydraulic system, which includes tool, hoses, couplers and POWERIG Hydraulic Unit. Parts must be kept away from unclean work surfaces. Dirt in hydraulic system causes valve failure in hydraulic unit.

Individual parts must be handled carefully and examined for damage or wear. Replace parts where required. Always replace O-rings and Back-up Rings when tool is disassembled for any reason. See applicable Service Kit.



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

- The efficiency and life of your tool depends on proper maintenance. Using the manual will help

give a clear understanding of the tool and basic maintenance procedures. Please read this page completely before proceeding with maintenance and repair. Use proper hand tools in a clean and well-lighted area. Only standard hand tools are required in most cases. Where a special tool is required, the description and part number are given.

- While clamping tool or parts in a vise, and when parts require force, use suitable soft materials to cushion impact. For example, using a half-inch brass drift, wood block and vise with soft jaws greatly reduces possibility of damaging tool. Remove components in a straight line without bending, cocking or undue force. Reassemble tool with the same care.

(continued)

- Consult **TROUBLESHOOTING** section of this



SERVICING THE TOOL (CONT.)

GOOD SERVICE PRACTICES (continued)

manual if a malfunction occurs and then see appropriate section of *DISASSEMBLY*; *ASSEMBLY*; Assembly and/or Component illustration(s).

Sealants, Lubricants, Hydraulic Fluid and Service Kits

- Rub SLIC-TITE TEFLON thread compound, or equivalent, on pipe threads to prevent leaks and for ease of assembly. **CAUTION:** *Do not use TEFLON tape on pipe threads.* Particles of shredded tape cause hydraulic unit valve failure. (SLIC-TITE in stick form, 503237).
- Smear LUBRIPLATE 130AA, or equivalent, on O-rings and mating surfaces to prevent damaging O-rings on rough or sharp surfaces. Also, increases ease of assembly. (LUBRIPLATE in a tube, 502723).
- Each Service Kit contains perishable parts for your specific tool. As foreseeable use may indicate, keep extra kits (O-rings, Back-up Rings, other standard items) and tool parts in stock. When stock is depleted, you can get kit items from any regular retailer of these items. See kit parts list for: O-ring size (AS568- number); material; durometer. For kit parts lists and related information, see General Notes.

PREVENTIVE MAINTENANCE

System Inspection

Operating efficiency of the tool is directly related to the performance of the complete system, including the tool with nose assembly, hydraulic hoses, trigger switch and control cord, and POWERIG Hydraulic Unit. Therefore, an effective preventive maintenance program includes scheduled inspections of the system to detect and correct minor troubles.

- Inspect tool and nose assembly for external damage.
- Verify that hydraulic hose fittings and couplings, and electrical connections are secure.
- Inspect hydraulic hoses for damage and deterioration. Do not use hoses to carry tool. Replace hoses if damaged.
- Observe tool, hoses and hydraulic unit during

operation to detect abnormal heating, leaks or vibration.

POWERIG Hydraulic Unit Maintenance

Refer to the applicable POWERIG instruction manual.

Tool Maintenance

Whenever disassembled and also at regular intervals (depending on severity and length of use) replace all seals, wipers and back-up rings in tool. Service Kits, hoses and extra parts should be kept in stock. Inspect cylinder bore, pistons and piston rods for scored surfaces and excessive wear or damage. Replace as necessary.

Nose Assembly Maintenance

Clean nose often. Dip in mineral spirits, or similar solvent, to clean jaws and wash away metal chips and debris. At regular intervals, as experience shows, disassemble nose and use a sharp "pick" to remove imbedded particles from grooves of jaws.

DISASSEMBLY All Models

(Refer to Figures 2-4 & 8-13)

For component identification and Parts Lists refer to Figures 8-13.

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.



WARNING: Be sure to disconnect tool's electric control trigger system from Hydraulic Unit before disconnecting tool's hoses from unit. Before any maintenance is done, **DISCONNECT IN THIS ORDER (RECONNECT IN THE OPPOSITE ORDER)** to avoid possible severe personal injury.

1. Disconnect electrical or air connector from Powerig. Uncouple tool hydraulic hoses.
2. Remove nose assembly.



SERVICING THE TOOL (CONT.)

- Unscrew coupling nipple and coupling body. Drain hydraulic hoses into container. Discard fluid.
- Push rearward on Piston (4) until remaining hydraulic fluid is drained into container. Discard fluid.
- NOTE:** Do not remove hydraulic hoses from tool unless replacing hoses. If necessary to remove hoses, uncover hose fittings by sliding plastic shrouds back.

- NOTE:** Use the following steps **only** if the switch, wire or connector needs repair.

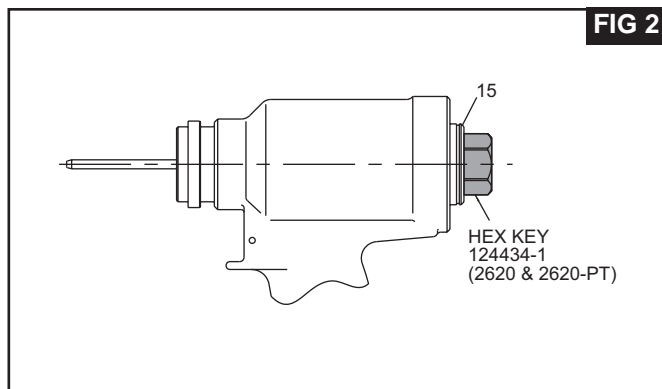
2620, 2620-PT Models Only

Remove Retaining Nut and Locking ferrule from Strain Relief (20). Loosen set screw (37) and remove switch (21). Loosen and remove the two wires from the switch. Remove cord from tool. Disassemble electrical connector (110686) (Figs. 8,9&12).

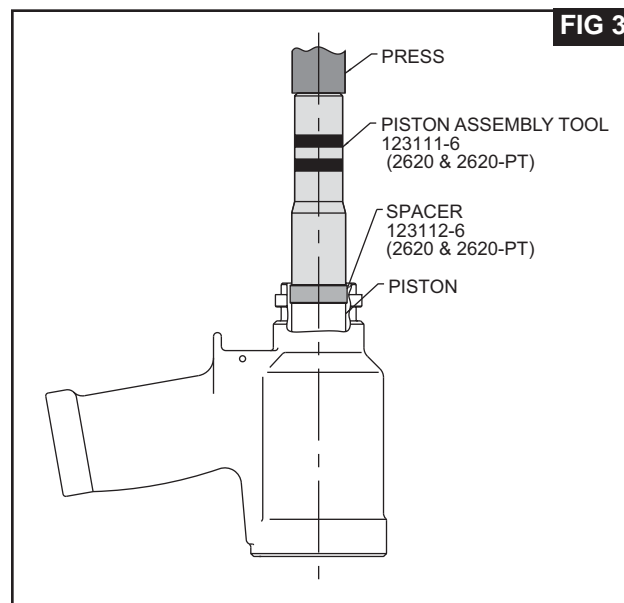
A2620, A2620-PT Models Only

Unscrew and remove Air Switch (21). Remove Retaining Nut and Locking ferrule from Air Fitting (20). Remove plastic tubing and unscrew remaining part of fitting (20) from handle (Fig. 10,11&13).

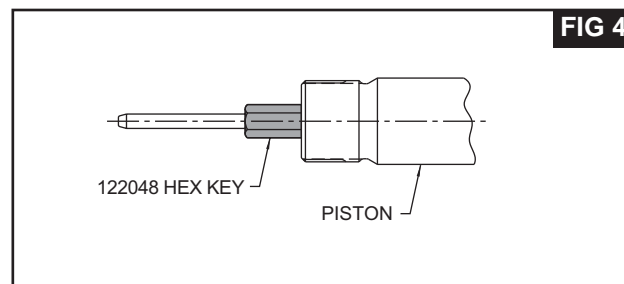
- Standard Models: (Fig. 8 & 10)
Remove Retaining Ring (17), cover plate (16) and Locking Disk (18).
- 2620-PT Model: (Fig. 9 & 11)
Remove Deflector (32), Screws (31), Barbed Retainer (30) and locking disk (18).



- Insert hex key in End Cap (15) as shown in figure 2. Using a wrench unscrew end cap from cylinder.
- Standard Models: (Fig. 8 & 10)
Remove O-ring (9) and Back-up Ring (8)
- 2620-PT Model: (Fig.9 & 11)
Remove O-ring (9), Back-up Ring (8), retaining ring (36), washer (35), polyseal (34) and wiper seal (33).



- Remove Dump Valve (19) from rear of cylinder.
- Slide Spacer (123112-6/7) over piston and thread on Piston Assembly Tool (123111-6/7). Using a press push front gland and piston assemblies out of the back of the cylinder. (Fig. 3)
- Remove Piston Assembly Tool (123111-6/7) and Spacer (123112-6/7) (Fig.3).
- Slide Front Gland (11) off of Piston (4) and remove Wiper (6), Wiper Housing (7), Back-up Ring (8), O-ring (9) and Polyseal (10) (Fig. 8 - 11).



- Remove GLYD Ring (13) from Piston (4) (Fig. 5).
- Standard Models Only: (Fig. 4, 8 & 10)
Hold Piston (4) in a vise with soft jaws and remove Ejector Gland Assembly (22) with Hex Key 122048
- Standard Models Only: (Fig. 4, 8 & 10)
Remove from gland, Ejector Rod (29), Washer (23), O-rings (24), Wiper (26) Quad-Ring (28) and Back-up Ring (27).

SERVICING THE TOOL (CONT.)



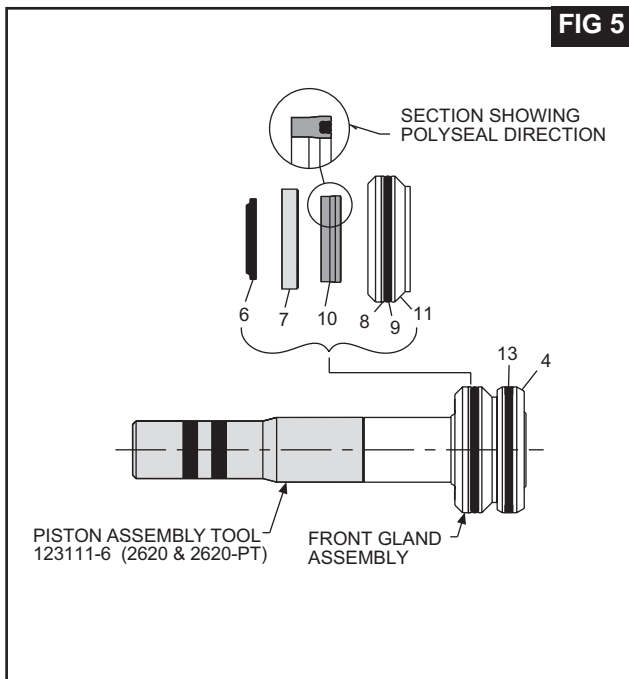
ASSEMBLY All Models

(Refer to Figures 2, 4, 5, & 8-13)

For component identification and Parts Lists, refer to Figures 8-11.

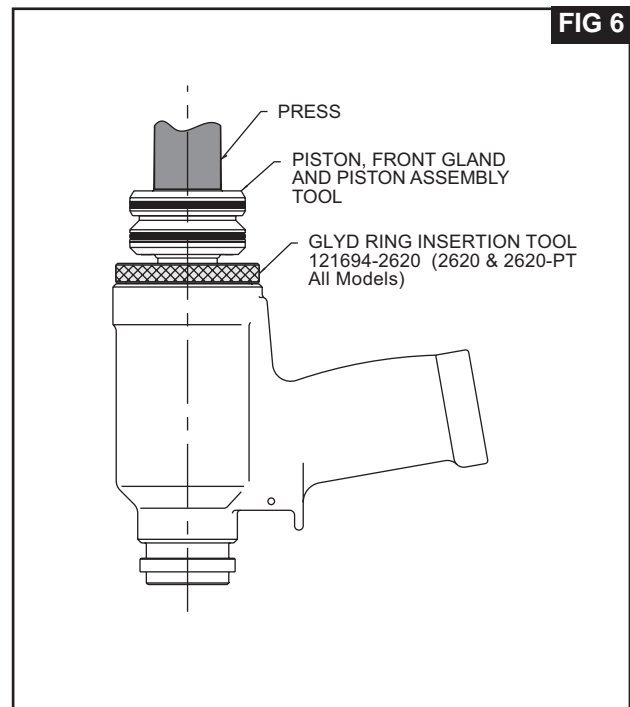
NOTE: Clean components with mineral spirits, or similar solvent. Inspect for wear/damage and replace as necessary. Replace all seals of disassembled components. Use O-rings, Quad-Rings and Back-up Rings in **Service Parts Kit 2620KIT (all models) and 2620-PTKIT (all models)**. Smear LUBRIPLATE 130AA or PARKER-O-LUBE on O-rings, Quad-Rings, Back-up Rings and mating parts to ease assembly. Assemble tool taking care not to damage O-rings, Quad-Rings, or Back-up Rings.

1. **Standard Models Only: (Fig. 8 & 10)**
Install Back-up Ring (27), Quad-Ring (28), Wiper (26), O-rings (24), Washer (23) and Ejector Rod (29) into Ejector Gland (25).
2. **Standard Models Only: (Fig. 4, 8 & 10)**
Hold Piston (4) in a vise with soft jaws and install assembled Ejector Gland (22). Use Hex Key 122048 to tighten.



3. Thread Piston Assembly Tool (123111-6/7), onto piston (4) (Fig. 5). **Note: Do not install spacer 123112-6/7.**

4. Install GLYD Ring (13) onto Piston (4) (Fig. 5).
5. Install Polyseal (10), O-ring (9), Back-up Ring (8), Wiper Housing (7) and Wiper (6) into Front Gland (11) (Fig.5).
6. Lube Piston Assembly Tool and Piston, then slide assembled Gland (11) over Piston Assembly Tool onto Piston (Fig. 5).



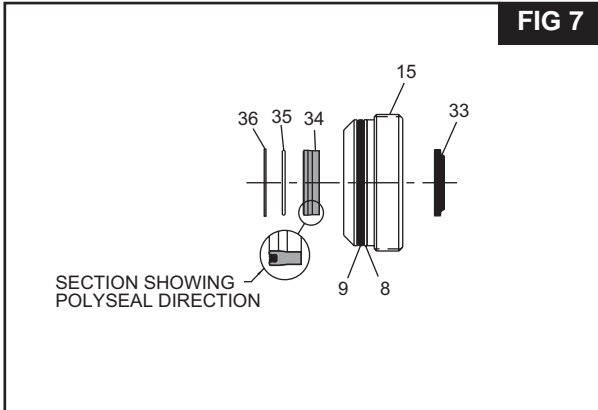
7. Thread GLYD Ring Insertion Tool (121694-2620) into the back of the Cylinder (Fig. 6).
8. Using a press, push Piston and Front Gland Assemblies into the back of Cylinder (5). (Fig. 6)
9. Remove Piston Assembly Tool (123111-6/7) (Fig. 5).
10. Remove the GLYD Ring Insertion Tool (121694-2620) from the back of the Cylinder (Fig.6).
11. From the rear of Cylinder, install Dump Valve (19) with the four flats facing the rear of the tool (Figures 8-11).

(continued)

SERVICING THE TOOL (CONT.)



- 12. Standard Models: (Fig. 8 & 10)
Install O-ring (9) and Back-up Ring (8) on End Cap (15).
- 2620-PT Model: (Fig.7, 9 & 11)
Install Back-up Ring (8), O-ring (9), Wiper Seal (33), Polyseal (34), Washer (35) and Retaining Ring (36) into End Cap (15).



- 13. Insert Hex Key into the End Cap (15). Using a wrench thread the End Cap into the back of the Cylinder and tighten (Fig. 2).
- 14. Standard Models: (Fig. 8 & 10)
Install Locking Disk (18), Cover Plate (16) and Retaining Ring (17).
- 2620-PT Model: (Fig. 9 & 11)
Install Locking Disk (18), Barbed Retainer (30), Screws (31) and Deflector (32).

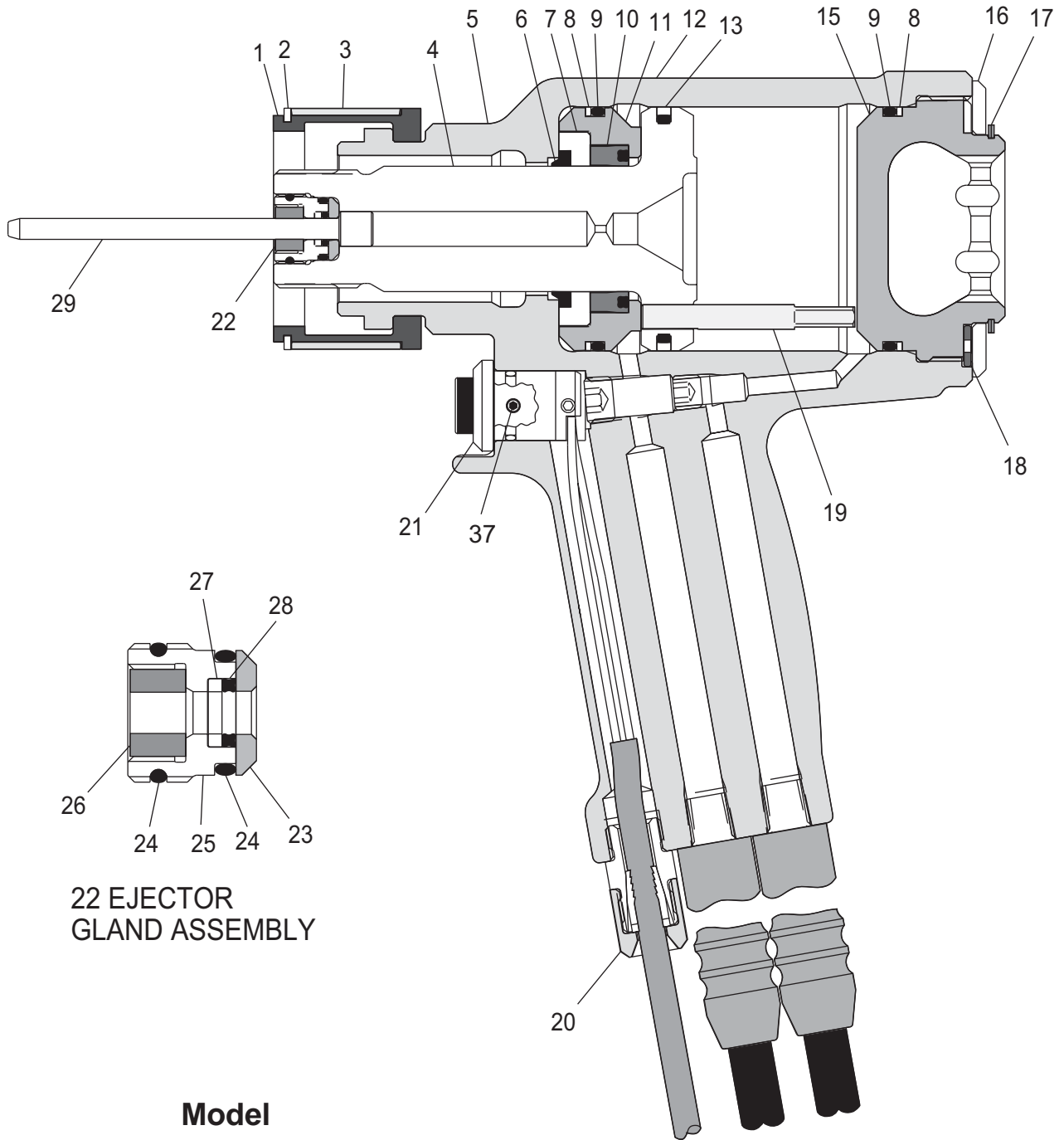
- 15. If removed, reinstall Electrical/Air Connector (Fig.12 & 13).
- 16. **NOTE:** *If switch or wire have been removed, replace as follows:*
2620, 2620-PT Models Only
Slide Retaining Nut and Ferrule onto Electrical Wire. Feed Wire through Handle and pull out through the Trigger Switch hole. Attach Wires to Switch (21) and push the assembly back into the Handle. Tighten Screw (37) to hold Trigger Switch in place. Slide Ferrule into Strain Relief Housing, then thread and tighten Retaining Nut (Fig. 8,9 & 12).
- A2620, A2620-PT Models Only
Install fitting (20) into handle. Slide retaining nut and ferrule over plastic tubing. Slide tubing into fitting (20) and tighten retaining nut. Screw in air trigger (21) and tighten(Fig. 8,9 & 13).

- 17. If removed, install one hydraulic Hose in Handle port marked "P" and one in port marked "R".
CAUTION: *Do not use TEFLON tape on pipe threads.(See Good Service Practices Page 9)*
- 18. Install Coupler Nipple 110438, (PULL pressure hose); Coupler Body 110439, (RETURN pressure hose) (Fig. 12 & 13).

..... Use Area Below for Service Notes:

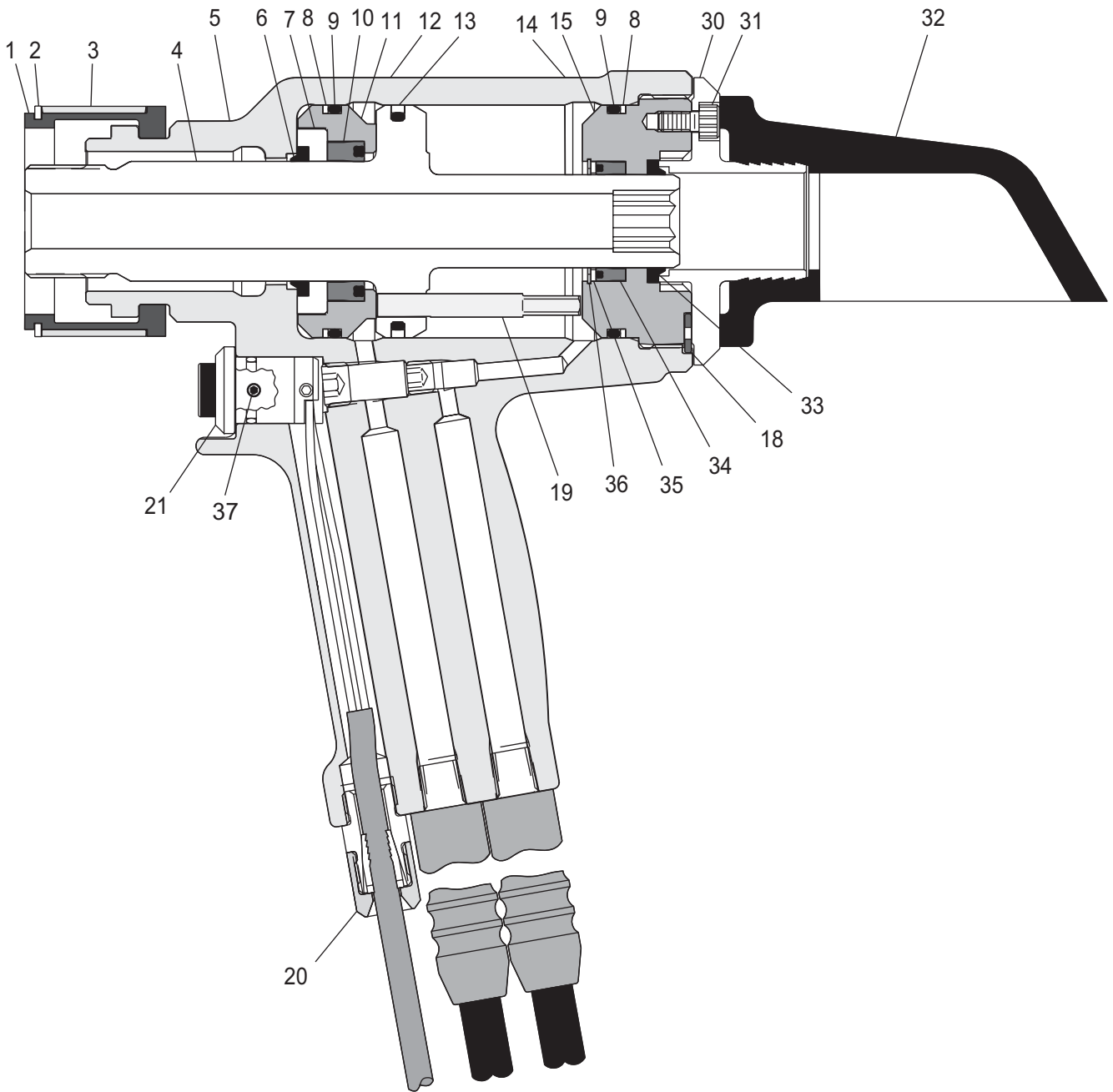
ASSEMBLY DRAWING 2620 & 2620-15

FIG 8



ASSEMBLY DRAWING 2620-PT & 2620-PT-15

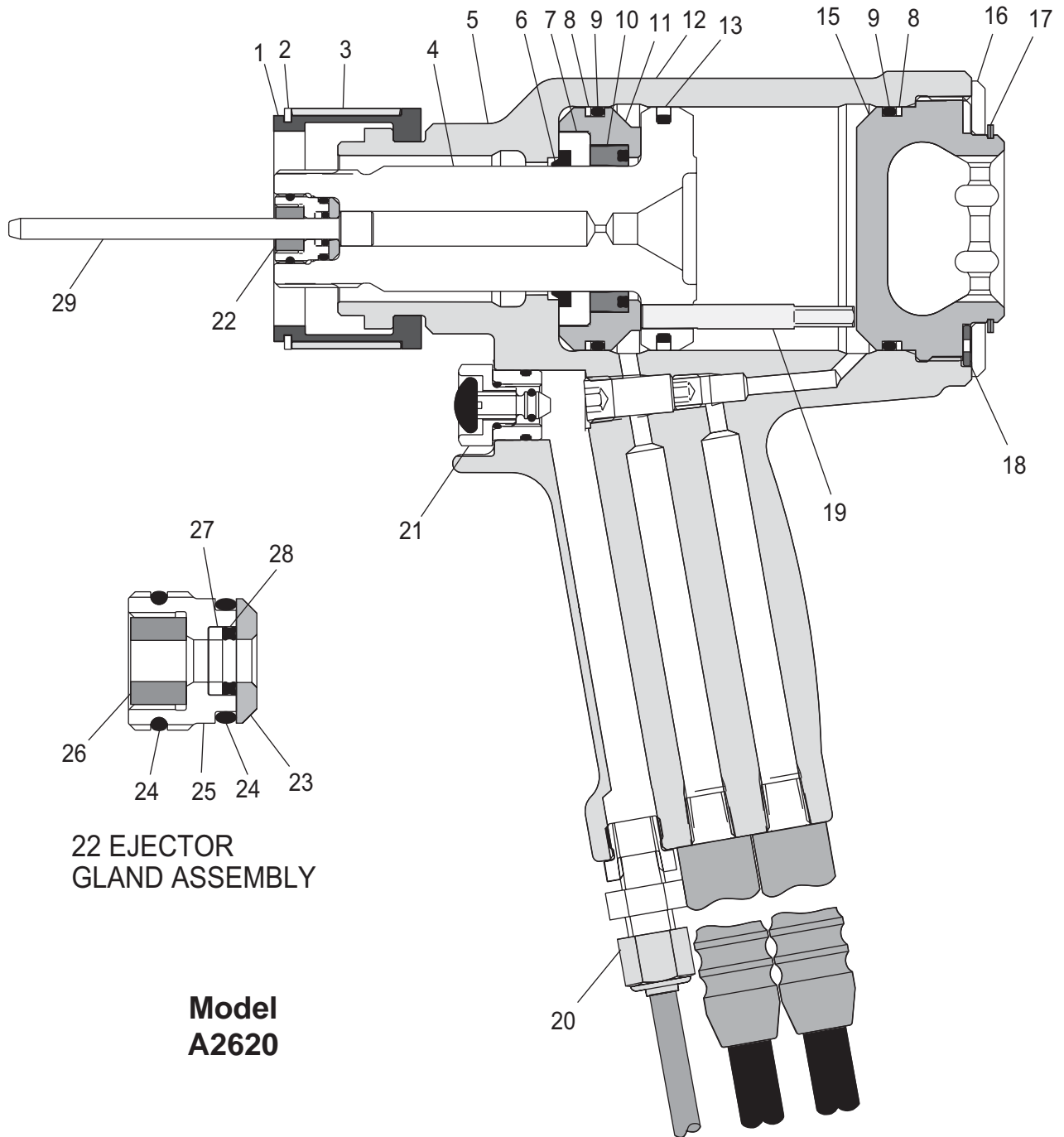
FIG 9



**Model
2620-PT & 2620-PT-15**

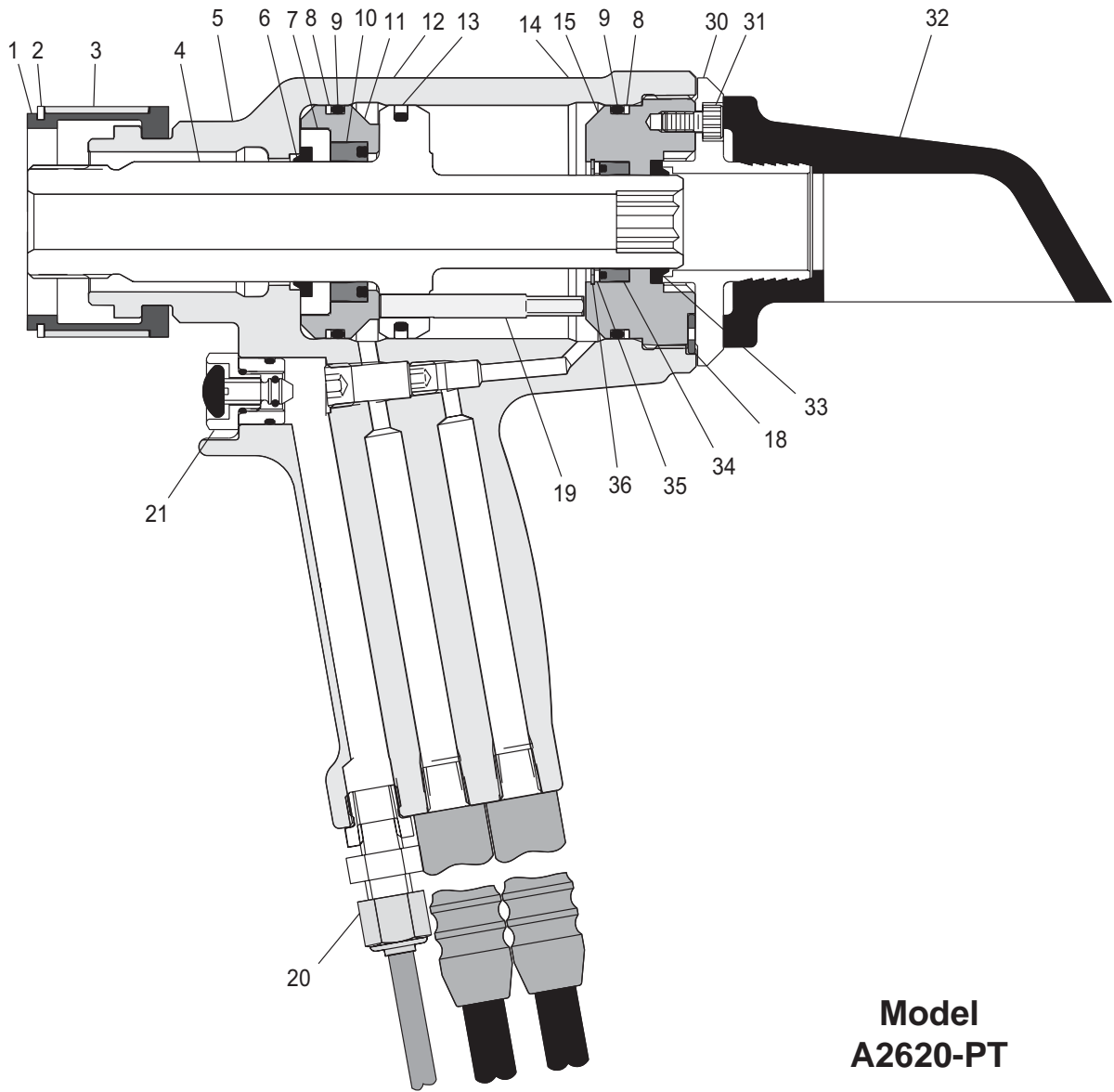
ASSEMBLY DRAWING A2620

FIG 10



ASSEMBLY DRAWING A2620-PT

FIG 11



**Model
A2620-PT**

PARTS LIST (Figures 1, 2A, 2B, and 2C)

Item	Description	Qty	2620 2620-15	A2620	2620-PT 2620-PT-15	A2620-PT
1	Split Ring	1	102147	102147	102147	102147
2	Retaining Ring	1	501514	501514	501514	501514
3	Retaining Sleeve	1	102148	102148	102148	102148
4	Piston	1	125612*	125612*	125761**	125761**
5	Cylinder Assembly	1	126152	126152	126152	126152
6	Wiper Seal	1	507407	507407	507407	507407
7	Wiper Housing	1	125610	125610	125610	125610
8	Back-up Ring	2	501127	501127	501127	501127
9	O-ring	2	507412	507412	507412	507412
10	Polyseal	1	507408	507408	507408	507408
11	Front Gland	1	125609	125609	125609	125609
12	Caution Sticker	1	590189-2	590189-2	590189-2	590189-2
13	GLYD Ring Assembly	1	122769-1	122769-1	122769-1	122769-1
14	Warning Sticker	1	-----	-----	590240	590240
15	End Cap	1	125614	125614	125763	125763
16	Cover Plate	1	125617	125617	-----	-----
17	Retaining Ring	1	507406	507406	-----	-----
18	Locking Disc	1	122764	122764	122764	122764
19	Dump Valve	1	125616	125616	125616	125616
20	Strain Relief or Air Fitting	1	505344	503902	505344	503902
21	Trigger Switch Assembly	1	120361	119345-1	120361	119345-1
22	Ejector Gland Assembly	1	120653	120653	-----	-----
23	Ejector Washer	1	120652	120652	-----	-----
24	O-ring	2	500779	500779	-----	-----
25	Gland	1	122047	122047	-----	-----
26	Rod Wiper	1	122742	122742	-----	-----
27	Back-up Ring	1	501080	501080	-----	-----
28	Quad-Ring	1	501411	501411	-----	-----
29	Pintail Ejector	1	122705	122705	-----	-----
30	Barbed Retainer	1	-----	-----	125765	125765
31	Screws	3	-----	-----	500060	500060
32	Deflector	1	-----	-----	122766	122766
33	Wiper Seal	1	-----	-----	505894	505894
34	Polyseal	1	-----	-----	506160	506160
35	Spacer	1	-----	-----	122762	122762
36	Retaining Ring	1	-----	-----	506159	506159
37	Set Screw	1	501731	501731	501731	501731

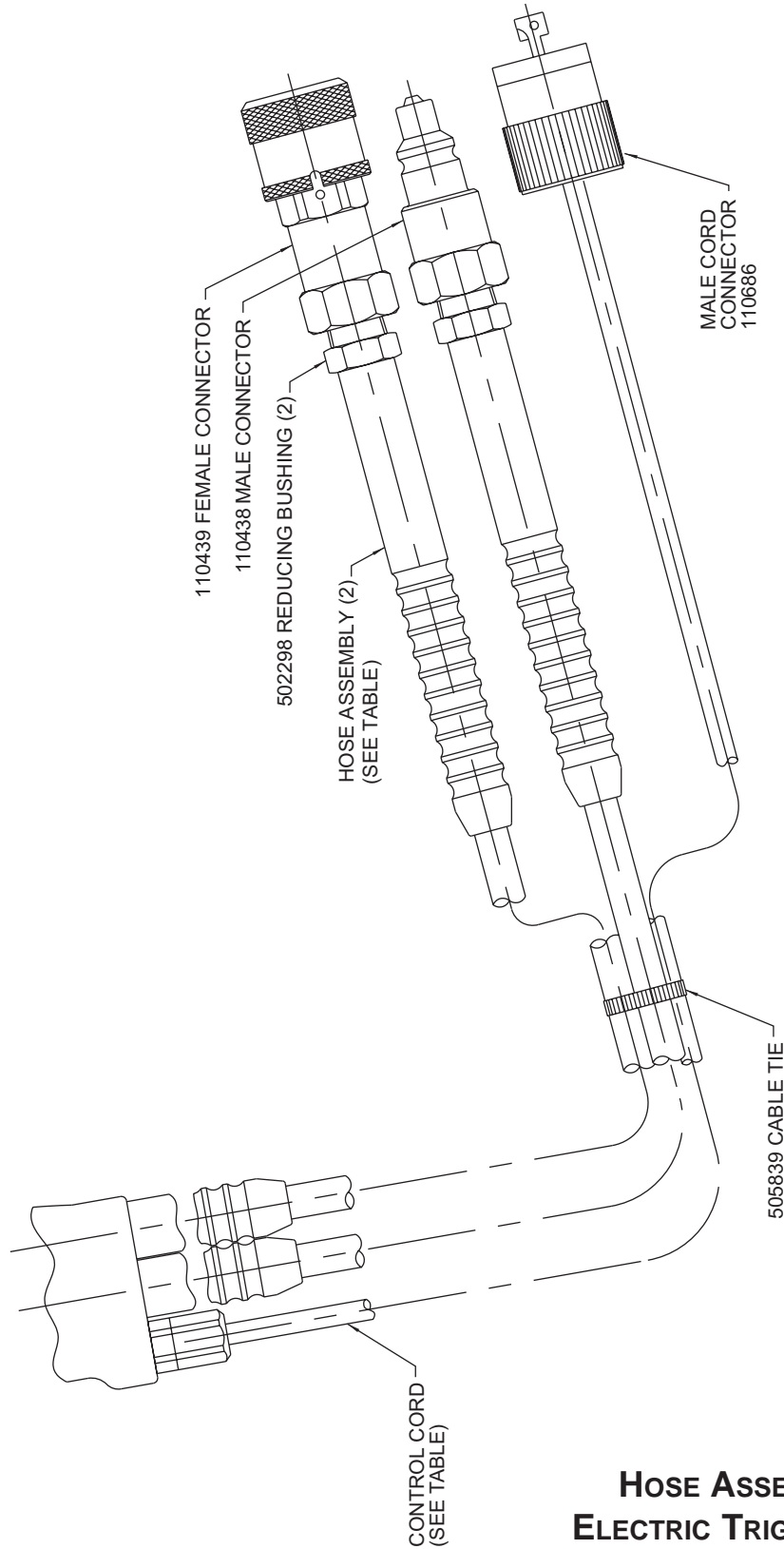
* Piston 125612 is not sold separately. It may be purchased as Piston Assembly part no. 125613, which contains Piston 125612 and GLYD Ring Assembly 122769-1.

** Piston 125761 is not sold separately. It may be purchased as Piston Assembly part no. 125762, which contains Piston 125761 and GLYD Ring Assembly 122769-1.

FIG 12

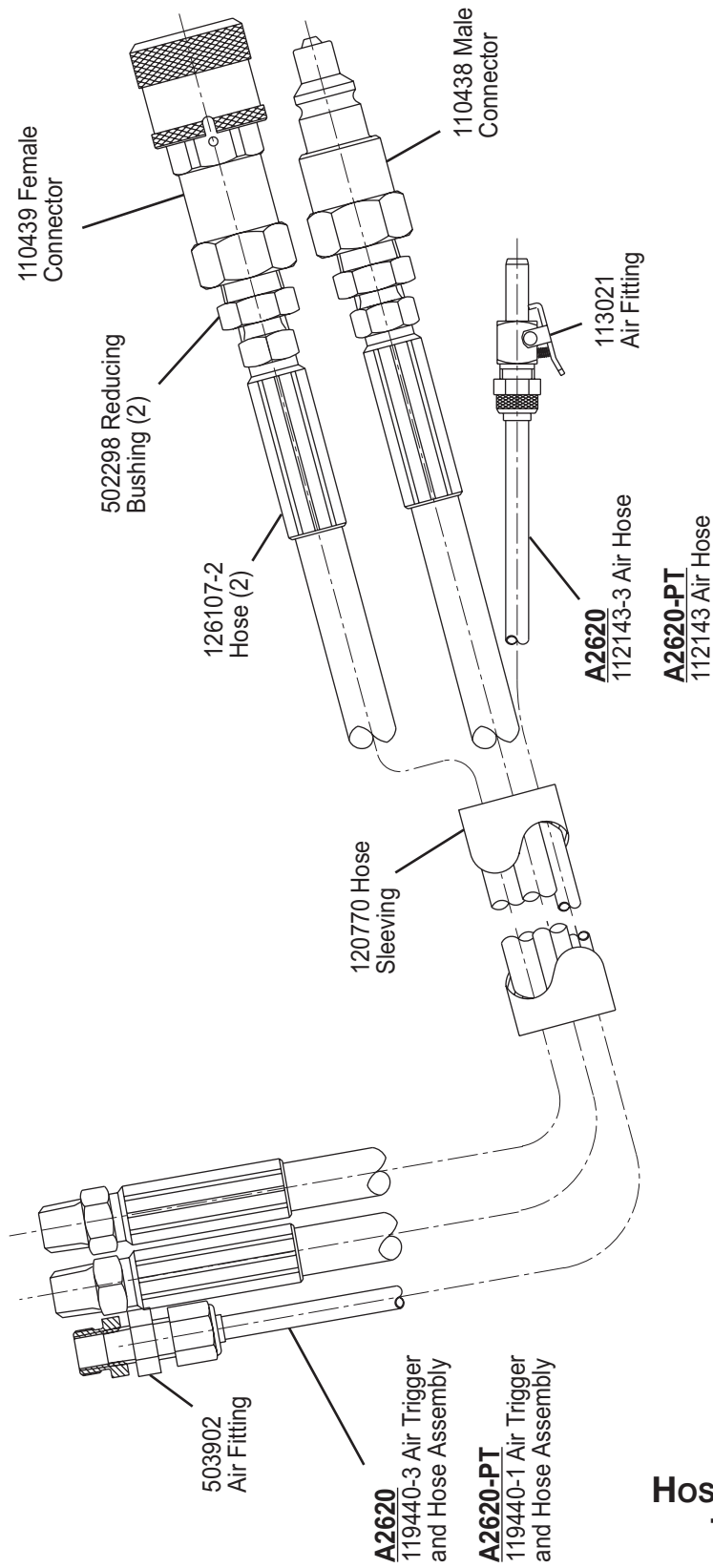
MODEL SELECTION

MODEL(S)	HOSE ASSEMBLY	CONTROL CORD
2620, 2620PT	126107-1	123337-1
2620-15, 2620-PT-15	126107-2	123336



HOSE ASSEMBLY FOR
ELECTRIC TRIGGER MODELS

FIG 13



HOSE ASSEMBLY FOR AIR TRIGGER MODELS

TROUBLESHOOTING



Always check the simplest possible cause of a malfunction first. For example, a loose or disconnected trigger line. Then proceed logically and eliminate each possible cause until the defect is found. Where possible, substitute known good parts for suspected defective parts. Use the following steps as an aid in troubleshooting.

1. *Tool fails to operate when trigger is pressed.*
 - a. Inoperative POWERIG® Hydraulic Unit. See applicable instruction manual.
 - b. Loose electrical connections.
 - c. Damaged trigger assembly.
 - d. Loose or faulty hose coupling.
2. *Tool operates in reverse.*
 - a. Reversed hose connections between hydraulic unit and tool.
3. *Tool leaks hydraulic fluid.*
 - a. Defective tool O-rings or loose connections at tool.
4. *Hydraulic couplers leak fluid.*
 - a. Damaged or worn O-rings in Coupler Body Coupler P/N 110440.
5. *Hydraulic fluid overheats.*
 - a. Unit not operating properly - - see units manual.
 - b. Unit running in reverse (918; 918-5 only) - - see units manual.
6. *Tool operates erratically and fails to install fastener properly.*
 - a. Low or erratic hydraulic pressure - - air in system.
 - b. Damaged or worn Piston O-ring in tool.
 - c. Excessive wear on sliding surfaces of tool parts.
7. *Pull grooves on fastener pintail stripped during PULL stroke.*
 - a. Operator not sliding anvil completely onto fastener pintail.
 - b. Incorrect fastener grip.
 - c. Worn or damaged jaw segments.
 - d. Metal particles in jaw grooves.
 - e. Excessive sheet gap.
8. *Collar of fastener not completely swaged.*
 - a. Improper tool operation - - see No. 6.
 - b. Scored anvil.
9. *Tool "hangs up" on swaged collar of fastener.*
 - a. Improper tool operation - - see No. 6.
 - b. RETURN pressure too low.
10. *Pintail of fastener fails to break.*
 - a. Improper tool operation - - see No. 6.
 - b. Pull grooves on fastener stripped - - see No. 7.
 - c. PULL pressure too low.
11. *Nose will not release broken pintail.*
 - a. Nose assembly not installed per NOSE ASSEMBLY DATA SHEET.
- c. Not enough collar lubricant.
- d. Nose assembly not installed per NOSE ASSEMBLY DATA SHEET.

KITS AND ACCESSORIES

Service Kits:

2620/A2620	-	2620KIT
2620-PT/A2620-PT	-	2620-PTKIT

Assembly Tool Kits:

2620/A2620 & 2620-PT/A2620-PT Tool Kit	-	123110-7
<i>Includes: (Fig. 3 & 6)</i>		
Spacer	-	123112-6
Piston Assembly Tool	-	123111-6
GLYD Ring Insertion Tool	-	121694-2620

Accessories:

Ejector Hex Wrench (All Models)	-	122048
End Cap Hex Wrench		
2620 & 2620-PT	-	124434-1
2620-PT/A2620-PT	-	124434-1
Remote Trigger (All Models)	-	123381-24

LIMITED WARRANTIES

Tooling Warranty: 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.

Warranty on "non standard or custom manufactured products": With regard to non-standard products or custom manufactured products to customer's specifications, Huck warrants for a period of ninety (90) days from the date of purchase that such products shall meet Buyer's specifications, be free of defects in workmanship and materials. Such warranty shall not be effective with respect to non-standard or custom products manufactured using buyer-supplied molds, material, tooling and fixtures that are not in good condition or repair and suitable for their intended purpose.

THERE ARE NO WARRANTIES WHICH EXTEND BEYOND THE DESCRIPTION ON THE FACE HEREOF. HUCK MAKES NO OTHER WARRANTIES AND EXPRESSLY DISCLAIMS ANY OTHER WARRANTIES, INCLUDING IMPLIED WARRANTIES AS TO MERCHANTABILITY OR AS TO THE FITNESS OF THE TOOLING, OTHER ITEMS, NONSTANDARD OR CUSTOM MANUFACTURED PRODUCTS FOR ANY PARTICULAR PURPOSE AND HUCK SHALL NOT BE LIABLE FOR ANY LOSS OR DAMAGE, DIRECTLY OR INDIRECTLY, ARISING FROM THE USE OF SUCH TOOLING, OTHER ITEMS, NONSTANDARD OR CUSTOM MANUFACTURED PRODUCTS OR BREACH OF WARRANTY OR FOR ANY CLAIM FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES.

Huck's sole liability and Buyer's exclusive remedy for any breach of warranty shall be limited, at Huck's option, to replacement or repair, at FOB Huck's plant, of Huck manufactured tooling, other items, nonstandard or custom products found to be defective in specifications, workmanship and materials not otherwise the direct or indirect cause of Buyer supplied molds, material, tooling or fixtures. Buyer shall give Huck written notice of claims for defects within the ninety (90) day warranty period for tooling, other items, nonstandard or custom products described above and Huck shall inspect products for which such claim is made.

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

HUCK MAKES NO WARRANTY WITH RESPECT TO THE TOOLING, PART(S) OR OTHER ITEMS MANUFACTURED BY THIRD PARTIES. HUCK EXPRESSLY DISCLAIMS ANY WARRANTY EXPRESSED OR IMPLIED, AS TO THE CONDITION,

DESIGN, OPERATION, MERCHANTABILITY OR FITNESS FOR USE OF ANY TOOL, PART(S), OR OTHER ITEMS THEREOF NOT MANUFACTURED BY HUCK. HUCK SHALL NOT BE LIABLE FOR ANY LOSS OR DAMAGE, DIRECTLY OR INDIRECTLY, ARISING FROM THE USE OF SUCH TOOLING, PART(S) OR OTHER ITEMS OR BREACH OF WARRANTY OR FOR ANY CLAIM FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES.

The only warranties made with respect to such tool, part(s) or other items thereof are those made by the manufacturer thereof and Huck agrees to cooperate with Buyer in enforcing such warranties when such action is necessary.

Huck shall not be liable for any loss or damage resulting from delays or nonfulfillment of orders owing to strikes, fires, accidents, transportation companies or for any reason or reasons beyond the control of the Huck or its suppliers.

Huck Installation Equipment

Huck International, Inc. reserves the right to make changes in specifications and design and to discontinue models without notice.

Huck Installation Equipment should be serviced by trained service technicians only.

Always give the Serial Number of the equipment when corresponding or ordering service parts.

Complete repair facilities are maintained by Huck International, Inc. Please contact one of the offices listed below.

Eastern

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

Canada

6150 Kennedy Road Unit 10, Mississauga, Ontario, L5T2J4, Canada.
Telephone (905) 564-4825 FAX (905) 564-1963

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.



For the Long Haul™

A Global Organization

Alcoa Fastening Systems (AFS) maintains company offices throughout the United States and Canada, with subsidiary offices in many other countries. Authorized AFS distributors are also located in many of the world's

industrial and Aerospace centers, where they provide a ready source of AFS fasteners, installation tools, tool parts, and application assistance.

Alcoa Fastening Systems world-wide locations:

Americas

Alcoa Fastening Systems

Aerospace Products

Tucson Operations

3724 East Columbia
Tucson, AZ 85714
800-234-4825
520-747-9898
FAX: 520-748-2142

Alcoa Fastening Systems

Aerospace Products

Carson Operations

PO Box 5268
900 Watson Center Rd.
Carson, CA 90749
800-421-1459
310-830-8200
FAX: 310-830-1436

Alcoa Fastening Systems

Commercial Products

Waco Operations

PO Box 8117
8001 Imperial Drive
Waco, TX 76714-8117
800-388-4825
254-776-2000
FAX: 254-751-5259

Alcoa Fastening Systems

Commercial Products

Kingston Operations

1 Corporate Drive
Kingston, NY 12401
800-431-3091
845-331-7300
FAX: 845-334-7333
www.hucktools.com

Alcoa Fastening Systems

Commercial Products

Canada Operations

6150 Kennedy Road, Unit 10
Mississauga, Ontario L5T2J4
Canada
905-564-4825
FAX: 905-564-1963

Alcoa Fastening Systems

Commercial Products

Latin America Operations

Avenida Parque Lira. 79-402
Tacubaya Mexico, D.F.
C.P. 11850
FAX: 525-515-1776
TELEX: 1173530 LUKSME

Far East

Alcoa Fastening Systems

Commercial Products

Australia Operations

14 Viewtech Place
Rowville, Victoria
Australia 3178
03-764-5500
Toll Free: 008-335-030
FAX: 03-764-5510

Europe

Alcoa Fastening Systems

Commercial Products

United Kingdom Operations

Unit C, Stafford Park 7
Telford, Shropshire
England TF3 3BQ
01952-290011
FAX: 0952-290459

Alcoa Fastening Systems

Aerospace Products

France Operations

Clos D'Asseville
BP4
95450 Us Par Vigny
France
33-1-30-27-9500
FAX: 33-1-34-66-0600



For The Long Haul, The Future of Fastening Technology, The Future of Assembly Technology, The Future of Tooling Technology, and Tools of Productivity are service marks of Huck International. Huck provides technical assistance regarding the use and application of Huck fasteners and tooling.

NOTICE: The information contained in this publication is only for general guidance with regard to properties of the products shown

and/or the means for selecting such products, and is not intended to create any warranty, express, implied, or statutory; all warranties are contained only in Huck's written quotations, acknowledgements, and/or purchase orders. It is recommended that the user secure specific, up-to-date data and information regarding each application and/or use of such products.

HWB898 1003-5M

Alcoa Fastening Systems



One Great ConnectionSM