

ENGINEERED HUCK® FASTENERS

STAR FASTENERS

An alternative to welding

For more than 60 years, the Huck® range of LockBolts and blind fasteners have been solving the problem of extreme stress and vibration in joints, providing strength and facilitating lighter, stronger, more durable structures... without loosening.

Today the Huck product range, based on the original HuckBolt® design, has evolved to include small & large diameter LockBolts® medium & heavy-duty blind fasteners and the associated installation tooling, each specially engineered to offer superior performance".

WHAT IS A HUCKBOLT AND HOW DO THEY WORK?

Structural HuckBolts, also known as Lockbolts are available in a wide range of sizes (up to 1 3/8 inch) and materials, consist of a pin and a collar. These advanced fasteners are installed using a direct tension technique, in which the pin is pulled and the collar is simultaneously swaged into the locking grooves of the pin, deforming the collar into the grooves. Based on their design and unique direct tension installation, HuckBolts deliver consistent clamp for a strong, stable, and vibration-resistant joint. Huck Lockbolts provide direct metal-to-metal contact when installed, which eliminates the transverse vibration often found in conventional nuts and bolts. Engineered for a wide range of applications, Huck Lockbolts deliver superior joining strength, shear, and tensile strength for an unmatched fastening solution.

HUCKBOLT FASTENING TECHNOLOGY – ELIMINATING THE EFFECTS OF VIBRATION


In addition to providing for faster, safer, and more accurate joining, there are several unique design elements of HuckBolts that ensure their ultimate resistance to the effects of vibration. Conventional nut and bolt installations, can loosen in high-vibration environments and need continual checking and maintenance, by comparison Huck LockBolts provide a consistent jointing solution.

HUCK BLIND STRUCTURAL FASTENERS

For applications where only one side of the joint material is accessible, performance engineered Huck structural blind fasteners can often meet design requirements. These

HUCK LOCKBOLTS

BobTail®




Unique helical lock groove (upwards from 9.5mm): Holds pins and collar in place prior to installation*
No pin-tail: Reduced wastage, low installation noise
No pin-break: High corrosion resistance
Semi-automatic tooling installation: Minimises installation time
Pin head style: Brazier, truss, countersunk
Collar style: Flanged
Materials: Steel (5.8/8.8 up to 9.5mm, 8.8/10.9 12mm and above)
Coating: High corrosion resistant coatings available

Diameters (mm)

6.4	7.5	9.5	12
12.7	14	16	19.1
20	22.2	24	25.4
27	30	36	

C6L® - The Original Huck Design




5.8 grade small diameter Lockbolt
Made to British Standard B7805; Part 1: 1997: A mark of quality, safety and performance
Wide flange collar available: Enables installation into non-metallic materials
Pin head style: Brazier, truss, countersunk, specific headstyle for palisade fencing
Collar style: Standard, flanged, wide flanged and low profile
Materials: Steel, stainless steel, aluminium

Diameters (mm)

4.8	6.4	7.9	9.5
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Magna-Grip®




Huge grip range: Accommodates wide variations in joint thickness - 14/23/39mm**
One pin and one collar cover a wide variety of applications: Reducing the risk of incorrect fastener installation
Wide grip range minimises fastener inventory
Flush pinbreak: No catching on clothes, skin or goods
Pin head style: Button, truss, countersunk, rivet, broad truss
Collar style: Standard flange, medium flange, wide flange
Materials: Steel, aluminium

Diameters (mm)

4.8	6.4	7.9	9.5
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Hucktainer® - Designed specifically for joining composite board in trailer applications




Will not crush or damage the composite board
Integral seal around pin head prevents moisture ingress
Low profile on both sides when installed: No catching on clothes, skin or goods. Not as grip sensitive as some competitor products

Pin head style: Standard low profile, encapsulated in plastic
Sleeve style: Wide bearing, medium bearing, clearance
Short grip version available
Materials: Steel

Diameter (mm)

9.5

C50L®



8.8 grade large diameter Lockbolt
Made to British Standard B7805; Part 2: 1997: A mark of quality, safety and performance
High tensile friction grip fastener
Pin head style: Round, truss, countersunk, thread head
Collar style: Standard, flanged, low profile
Materials: Steel, stainless steel, aluminium
Thread head variety available for rail track applications

Diameters (mm)

12.7	15.9	19.1	22.2
25.4	28.6	31.8	34.9

C120L®




8.8 grade small diameter Lockbolt
High tensile strength version of C6L
Pin head style: Brazier, truss, countersunk
Collar style: Standard, flanged
Materials: Steel

Diameters (mm)

4.8	6.4	7.9	9.5
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Huck 360® - Unique Lockbolt Solution



No special tooling system required: Can be installed using a standard torque wrench
Ideal for use where installation accessibility is limited for a standard Lockbolt
Can be removed and re-tightened***
High speed installation: No prevailing torque
All the performance benefits of a 10.9 grade Lockbolt

Diameters (mm)

16	20	24	28
32	36	40	44

Imperial sizes available on request

* Special tab collar is needed to perform this function. ** Based on 6.4mm diameter. Two different grip lengths available. *** As long as the nut and bolt set remain free spinning after removal. Individual fastener benefits will vary depending on the application they are used in.

blind fasteners can deliver the shear and tensile strength to meet the demands of a number of demanding applications. Available in diameters ranging from 3/16 inch to 3/4 inch, these fasteners offer a combination of strength and vibration resistance, easy installation, and a high level of safe operation.

WHERE ARE HUCK FASTENERS USED?

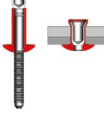
Huck Fasteners are used in many industrial markets including truck, trailer, automotive, heating, ventilation and air conditioning, bus, coach, portable buildings, agricultural machinery, green energy and rail, but the

application possibilities are endless.

HUCK® LOCKBOLTS, AN ALTERNATIVE TO WELDING?

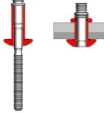
HuckBolts and Huck structural blind fasteners have not been designed to replace all welds, but there are many applications where welding has been traditionally employed where Huck fasteners are a viable alternative. Engineered for easy installation, and long, reliable life, these direct tension HuckBolts and structural blind fasteners can be a faster, more cost efficient, and safer alternative to traditional welding processes.

HUCK BLIND FASTENERS

Magna-Lok®


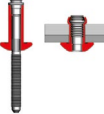
Wide grip range: Accommodates large variations in joint thickness
Structural fastener: High shear & tensile strength
Excellent gap closure capability
Outstanding hole filling on the blind side: Excellent joint tightness and very resistant to water ingress
Flush pinbreak: No catching on clothes, skin or goods. Quick and easy visual inspection
Internal pin locking mechanism: Secure within the rivet body and protected from corrosion
Headstyles: Protruding, truss, countersunk
Materials: Steel, stainless steel, aluminium

except 4.8mm
Diameters (mm)
 4.8 6.4 9.5 12.7

Magna-Bulb®


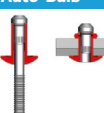
Extra large blind side footprint: Ideal for lower strength or thin sheet joint materials
Structural fastener: Very high shear strength and high tensile strength
Flush pinbreak: No catching on clothes, skin or goods. Quick and easy visual inspection
Internal pin locking mechanism: Secure within the rivet body and protected from corrosion
Headstyles: Protruding
Materials: Steel

Diameters (mm)
 4.8 6.4 7.9

HuckLok™


Wide grip range: Accommodates large variations in joint thickness
Structural fastener: High shear & tensile strength
Large blind side footprint: Ideal for lower strength or thin sheet joint materials
Flush pinbreak: No catching on clothes, skin or goods. Quick and easy visual inspection
Internal pin locking mechanism: Secure within the rivet body and protected from corrosion, plus additional blind side pin locking for increased fatigue life
Headstyles: Protruding
Materials: Steel

Diameters (mm)
 4.8 6.4

Auto-Bulb™


Purpose design blind side shape for easy hole location: Ideal for automated assembly
Large blind side footprint: Ideal for lower strength or thin sheet joint materials
Good blind side clearance: Less space required on the blind side prior to installation
High pin retention: Prevents possibility of noise or vibration in dynamic assemblies
Recessed pinbreak: No catching on clothes, skin or goods
Headstyles: Protruding, Oval Countersunk
Materials: Steel, Stainless Steel

Diameters (mm)
 6.4

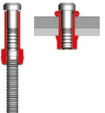
* Individual fastener benefits will vary depending on the application they are used in.

Today, HuckBolt fasteners doing the job in a wide range of applications that once solely belonged to welding, they can be effectively used with virtually any metal, and dissimilar metals with dissimilar coefficients of thermal expansion present no problems. Varying material thicknesses in a joint are readily accommodated, and surface finishes are not damaged. And most importantly, HuckBolts are proven to hold up over years of service in demanding high-stress, high-vibration environments.

Reasons to specify Huck Fasteners into your next project?


Huck Fasteners offer benefits that other fastening methods cannot, including: -

- Quick and easy installation – minimal training & fast installation.
- Will not loosen even under extreme vibration.
- Maintenance free joints - eliminates checking / replacement, and ultimately cost reductions.
- Superior, permanent and a reliable alternative to welding and nuts & bolts.
- Tamperproof – once installed cannot be removed without specialist tooling.

BOM®


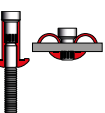
Very high strength/diameter ratio: Can be used in demanding structural applications as an alternative to threaded fasteners or welding
Very high joint tightness when compared to conventional blind fasteners
Very resistant to tampering, extremely hard to remove
Excellent gap closure capability
Large blind side footprint: Ideal for lower strength or thin sheet joint materials
Headstyles: Protruding
Materials: Steel

Diameters (mm)
 4.8 6.4 7.9 9.5 12.7 15.9 19.1

FloorTight™ - The flooring specialist fastener



Self countersinking head: Ideal for use on timber flooring and phenolic faced plywood
Superior strength to conventional flooring screws: Reduces the number of fasteners required and number of drilled holes
3 Clamp strengths available to suit your joint. No crushing or pulling through the board
Recessed pinbreak: No catching on clothes, skin or goods
Headstyles: Standard flange and wide flange
Materials: Steel

Diameters (mm)
 7.9

Penta-Lok™ - Specifically Designed for the Composite Panel Market


Specifically for joining load restrain profiles to lightweight panel
Penta-Lok "claws" unfurl and install inside the actual panel not on the blind side/back of panel
High pull out strength: Due to the load spread of the "claws" inside the lightweight panel of approximately 16mm.
No through hole required in the lightweight panel: Penta-Lok only needs a minimum 8mm of depth in the lightweight panel to insert the blind side of the fastener
Headstyles: Protruding
Materials: Steel

Diameters (mm)
 6.4

Magna-Tite™ - The roofing specialist fastener


Polymer watertight seal: Ideal for roofing or similar applications
Extra large blind side footprint: Ideal for lower strength or thin sheet joint materials
Low clamp load: Perfect for use in thin sheet material, composites and plastics
Flush pinbreak: No catching on clothes, skin or goods. Quick and easy visual inspection
Headstyles: Protruding, Low Profile, Shaveable, 100° Oval
Materials: Aluminium

Diameters (mm)
 4.8 6.4

Each Huck Fastener has its own unique characteristics ensuring that there is a product for every application.

HOW TO INSTALL AND REMOVE HUCKBOLT AND STRUCTURAL BLIND FASTENERS

Star Fasteners offer a wide variety of quality tools that stand up to the rigours of a busy workshop environment, we can demonstrate the latest pneumatic, battery, hydraulic and hand tools and offer advice on options best suited to both the application and the environment.

HIRE FLEET

If your workshop needs additional tools, or a specialist tool is needed for a specific contract, Star



Huck 202 Tool

Huck RangeForce Battery Tool

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In addition to providing for faster, safer, and more accurate joining, there are several unique design elements of HuckBolts that ensure their ultimate resistance to the effects of vibration.

Fasteners have a hire fleet for both short and long-term hire.

IN-HOUSE TOOL SERVICE / REPAIRS

We can help with that too! Every production environment, workshop and tool benefits from a regular maintenance program. Our in-house service and repair workshop ensures: -

- fasteners are being installed properly.
- Satisfy your health and safety obligations.
- Keep production moving and makes sure that the tools are operating correctly.

STAR FASTENERS TECHNICAL SUPPORT

Star Fasteners have been a Huck fastener distributor for over thirty years and are the UK's largest stockists - we have a wealth of knowledge and experience gained from working in a wide variety of markets. If required, we can work closely with our customers to understand their applications and can help to introduce new products that might not have initially considered.