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SAFETY

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

1. Glossary

- 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.

8. Tools and hoses should be inspected for leaks at the beginning of each shift/day. If any equipment shows signs of damage, wear, or leakage, do not connect it to the primary power supply.

9. Mounting hardware should be checked at the beginning of each shift/day.

10. Make sure proper power source is used at all times.

11. Release tool trigger if power supply is interrupted.

12. Tools are not to be used in an explosive environment unless specifically designed to do so.

13. Never remove any safety guards or pintail deflectors.

14. Ensure deflector or pintail collector is installed and operating prior to use.

15. Never install a fastener in free air. Personal injury from fastener ejecting may occur.

16. Always clear spent pintail out of nose assembly before installing the next fastener.

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

18. If there is a pinch point between trigger and work piece, use remote trigger. (Remote triggers are available for all tooling).

19. Unsuitable postures may not allow counteracting of normal expected movement of tool.

20. 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 in preventing an accident which may cause severe personal injury.


22. There is a risk of crushing if tool is cycled without Nose Assembly installed.

23. Tools with ejector rods should never be cycled with out nose assembly installed.

24. When two piece lock bolts are being used always make sure the collar orientation is correct. See fastener data sheet of correct positioning.

25. There is a risk of whipping compressed air hose if tool is pneudraulic or pneumatic.

26. Tool is only to be used as stated in this manual. Any other use is prohibited.
**PRINCIPLE OF OPERATION**

*READ INSTRUCTIONS THOROUGHLY PRIOR TO OPERATING THE RIVETER. THIS RIVETER IS DESIGNED FOR INTERMITTENT DUTY AND MAINTENANCE WORK ONLY.*

The AK-175 is a pneumatic tool designed to set from 1/8" up to and including 1/4 inch diameter steel, stainless steel, aluminum and plastic rivets by changing only the nosepiece. The AK-175 has a rated pull pressure of over 3,500 lbs. The AK-175 riveter will operate effectively at any air pressure between 90 and 120 psi. WHEN SETTING 1/4" RIVETS OR MAGNALOK® A MINIMUM AIR PRESSURE OF 110 p.s.i. MUST BE MAINTAINED. The maximum air pressure used with the tool should not exceed 120 psi.

The AK-175 utilizes totally different principles than any other riveter. The air pressure activates a reciprocating hydraulic pump which generates the force required to set the fastener. The hydraulic system is sealed and, although there may be some visible residue around the trigger area, oil need not be added. If the AK-175 should become damaged and leaks oil from the tool, IT SHOULD BE RETURNED TO AN AUTHORIZED SERVICE CENTER. *(Authorized Service Centers may be found in Tool Service Center Section of the Manual)*

**TOOL SPECIFICATIONS**

<table>
<thead>
<tr>
<th>Model</th>
<th>Weight</th>
<th>Min PSI</th>
<th>Max PSI</th>
<th>Rivet Diameter</th>
<th>Pull Pressure</th>
<th>Stroke</th>
</tr>
</thead>
<tbody>
<tr>
<td>AK-175</td>
<td>32 oz</td>
<td>90*</td>
<td>120</td>
<td>1/8&quot;-1/4&quot;</td>
<td>3500 lbs.</td>
<td>5/8&quot;</td>
</tr>
</tbody>
</table>

*When setting 1/4" MAGNALOK® rivets, MIN Air pressure is 110 psi

**APPROX. 3/4 GAP AT FULL EXTENSION**

![Diagram of riveter parts](image)

**Accessories**

* Nose Extension Kit
  P/N 205490

For more accessories see the optional accessories section

Figure 1
**OPERATING INSTRUCTIONS**

The AK-175 pneumatic riveter installs fasteners by a pull and release system. Squeezing the ACTUATING TRIGGER “A” only (Fig. 2) will actuate the tool. The tool must be actuated when installing fasteners and changing nose pieces. After installing the fastener or changing the NOSE PIECE, the tool must be returned to its original position. This releases the pintail if a fastener was installed. To do this, point the tool downward and squeeze RELEASING TRIGGER “B” only (Fig. 3). See sections on NOSE PIECE INSTALLATION and FASTENER INSTALLATION for detailed instructions.

**SELECT THE PROPER NOSE PIECE FOR THE CORRECT INSTALLATION OF FASTENER AND FUNCTION OF TOOL.**

### Fastener Installation:

**Install correct nose piece on tool (see NOSE PIECE installation section).**

1. Insert pintail of rivet in to the nose piece.
2. Then Position the rivet body in to work piece to be fastened.
3. Hold the tool steady against the work piece and squeeze ACTUATING TRIGGER “A” only, until fastener is installed and rivet pintail is broken* (See figure 2 below)

### Nose Piece Installation:

**To change the Nose Piece**

1. Remove the NOSE PIECE in the tool by unscrewing it in a counterclockwise direction.
2. Actuate tool until it is fully extended. (There should be gap of approximately 3/4” in between the RESERVOIR SHIELD and the tool body.(See figure 1)
3. Hand tighten the NOSE PIECE into the NOSE TUBE and release the tool by squeezing the releasing trigger “B” only.

**CAUTIONS:**

- Before operating tool, ensure that all nose parts have been screwed in HAND TIGHT.
- Frequently check that nose components do not vibrate loose during operation.

**IMPORTANT NOTICE:**

*The AK-175 has a 5/8 inch work travel and will set most rivets in one cycle. If the tool reaches the end of its travel before the rivet breaks, the hydraulic system will lug down. DO NOT continue lugging the tool. Release the tool by squeezing the RELEASING TRIGGER “B”, regrip the rivet, squeeze the ACTUATING TRIGGER “A” and finish the installation.*

---

**Figure 2**

- **RIVET PINTAIL (INSIDE NOSE PIECE)**
- **RIVET BODY**
- **ACTUATING TRIGGER “A”**
- **RELEASING TRIGGER “B”**
- **WORK PIECE**
- **PINTAIL**
- **BODY**
- **(Typical Rivet)**
AK-175 Quick tips and Operating Instructions

1. AK-175 will install all diameter blind rivets 3/32 to 1/4 by changing only the nose piece.
2. Pull force of over 5000 lbs.
3. Operating Air pressure: 90 to 120 psi. DO NOT EXCEED 120 PSI.

IMPORTANT: 110 psi must be maintained when setting all 1/4” rivets.

The hydraulic system is sealed and may show visible residue on the trigger area. No need to add oil. If the AK-175 is damaged and leaks oil, it must be returned to an authorized service center.

Installing rivet: With rivet mandrel inserted in the tool nose, insert the rivet body into the application hole. Hold the tool steady against the work surface and depress the upper trigger. The tool will press forward to install rivet from 1 to 3 seconds max. Rivet mandrel should break in one pull. If not, stop and pull the lower lever to reverse tool and re-grip the rivet for a second pull. After the mandrel breaks, press the lower trigger to reverse the tool and ready for next rivet. Mandrel will drop out of the nose when you point the tool downward.

DO NOT OVER EXTEND... by holding the upper trigger or turn up air pressure to try increase tool stroke. This may cause tool to leak and require returning it to an authorized service center for repair.

1. Jaws should be washed in solvent and lube after 300 rivets.
2. The nose tube and nose piece can be changed “only” when the tool nose is extended.
3. Do not use the tool as a lever if rivet mandrel is jammed while re-gripping. Instead, with the lower trigger depressed, push riveter against the work for the jaws to get a deeper grip.
4. If rivet mandrel is stuck in tool after breaking, depress lower trigger, lightly tap the nose against a hard surface. This will release the mandrel from the jaws and allow it to drop free.
5. Frequently check the nose piece to insure it does not vibrate loose during operation.
6. To extend tool life… DO NOT hold trigger more than 3 seconds.
7. Operating temperature should not drop below freezing.
8. If the tool will not reverse, check for broken jaw holder or chips of metal in the nose tube… clean or replace as needed.
9. Before operating tool make sure that the nose tube and nose piece are completely screwed down snug by hand.

**OPERATION AND MAINTENANCE TIPS**

**TIPS: PROPER TOOL MAINTENANCE AK-175**

<table>
<thead>
<tr>
<th>NOSE PIECES:</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Part Number</td>
<td>Description</td>
</tr>
<tr>
<td>202193</td>
<td>Spec. GM Glass Stop Travel, Pop Rivets</td>
</tr>
<tr>
<td>202142</td>
<td>1/4” Magna Lok</td>
</tr>
<tr>
<td>202142</td>
<td>1/4” Pop Rivets</td>
</tr>
<tr>
<td>202186</td>
<td>1/4” Plastic Rivets</td>
</tr>
<tr>
<td>205490</td>
<td>Replaces tip 202157</td>
</tr>
<tr>
<td>126016</td>
<td>Nose Extension Kit</td>
</tr>
<tr>
<td>202122</td>
<td>Rivet Stem Removal Tool- “Punch Assy”</td>
</tr>
<tr>
<td>202929</td>
<td>Two Piece Jaws</td>
</tr>
<tr>
<td>202929</td>
<td>Three Piece Jaws</td>
</tr>
</tbody>
</table>

**OTHER ACCESSORIES:**

1. Discontinued. Use tip 202142.
2. 1/4” Monobolts
3. 1/4” Auto Split “T” Rivets
4. 5/32” & 3/16” Pop and Plastic Rivets
5. 1/8” for Trim Molding Pop Rivets
6. 3/32” & 1/8” Pop Rivets
7. 1/8” Stand Off Pop Rivets
Rivet Pintail Removal:

Once Rivet is installed, pintail must be removed
1. Point tool downward
2. Squeeze RELEASING TRIGGER “B”.

**CAUTION:** It is necessary to remove pintail before attempting to install another rivet.

Three/Two Piece Jaw Installation and Removal:

1. The jaws are installed at the factory and should only need to be removed for periodic inspection and cleaning. To remove the jaws unscrew the NOSE TUBE from the tool in a counterclockwise direction

2. **TWO PIECE JAW SYSTEM**
   Remove the JAW HOLDER by unscrewing it in a counterclockwise direction. Drop JAWS out from SPRING side. Push JAW PUSHER flush with PULLER SHAFT while squeezing the RELEASING TRIGGER (See Figure 3 above).

2. **THREE PIECE JAW SYSTEM**
   Remove the JAW HOLDER by unscrewing it in a counterclockwise direction. Drop JAWS out from SPRING side. Actuate tool by squeezing the ACTUATING TRIGGER (see fig 3 above) until the jaw pusher is fully extended. Stop as soon as the JAW PUSHER is in the extended position.
3. **TWO PIECE JAW SYSTEM**
To replace JAWS, hold JAW HOLDER large end down and at a slight angle. Place jaws in one at a time. Add a small amount of jaw lubricant to jaws and jaw holder prior to assembly.

4. When jaws are in place, insert jaw holder into spring, being sure to keep large end of jaw holder pointing downward.

5. **TWO JAW SYSTEM**
Hold tool with the PULLER SHAFT pointing down and screw the jaw holder on to the PULLER SHAFT. HAND TIGHTEN ONLY.

6. Replace the NOSE TUBE and NOSE PIECE, HAND TIGHTEN ONLY. The tool is now ready to use.
TOOL MAINTENANCE

Steps for Proper Tool Maintenance and Operation

1. Disassemble and clean NOSE components periodically. If the pintails do not drop out freely, use a pick to clean the jaw grooves. Wash components in mineral spirits or isopropyl alcohol. Apply a small amount of light weight oil to the JAWS and inside of JAW HOLDER prior to assembly.

2. To ease NOSE TUBE and NOSE PIECE installation, extend tool by squeezing actuating trigger.

3. DO NOT USE TOOL AS A LEVER if rivet pin tail is jammed while re-gripping. Instead, with releasing trigger depressed, push tool nose against work piece for the jaws to get a deeper grip.

4. If rivet pintail is stuck in tool after breaking, lightly tap nose against a hard surface while squeezing the releasing trigger, pintail should then fall out.

5. Before operating tool, make sure that all NOSE PARTS have been screwed in HAND TIGHT.

6. For long life of tool, do not continue to run tool at the end of travel.

7. The AK-175 should not be used at temperatures below 35° F. unless it is first brought to room temperature and cycled several times, normal use of the tool after warming should keep it warm enough for proper operation.

8. If tool will not reverse, remove NOSE TUBE and inspect for any foreign matter that might have caused jamming between JAW HOLDER and inside of NOSE TUBE.

9. Frequently check that nose components do not vibrate loose during operation.

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### Nose Pieces

*Included in AK-175 kit

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
<th>Part No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>202156</td>
<td>* 1/8&quot; for Trim Molding Pop Rivets</td>
<td>202155</td>
<td>* 1/4&quot; Auto Split &quot;T&quot; Rivets</td>
</tr>
<tr>
<td>Ø.093</td>
<td></td>
<td>Ø.160</td>
<td></td>
</tr>
<tr>
<td>202159</td>
<td>'3/32&quot; &amp; 1/8&quot; Pop Rivets</td>
<td>202157</td>
<td>Discontinued - Replaced by tip 202142 (pictured below)</td>
</tr>
<tr>
<td>Ø.098</td>
<td></td>
<td>Ø.160</td>
<td>1/4&quot; Pop &amp; Plastic Rivets</td>
</tr>
<tr>
<td>202190</td>
<td>1/8&quot; Stand Off Pop Rivets</td>
<td>202169</td>
<td>1/4&quot; Monobolts</td>
</tr>
<tr>
<td>Ø.093</td>
<td></td>
<td>Ø.160</td>
<td></td>
</tr>
<tr>
<td>202158</td>
<td>* 5/32&quot; &amp; 3/16&quot; Pop &amp; Plastic Rivets</td>
<td>202193</td>
<td>Spec. GM Glass Stop Travel, Pop Rivets</td>
</tr>
<tr>
<td>Ø.130</td>
<td></td>
<td>Ø.160</td>
<td></td>
</tr>
<tr>
<td>202168</td>
<td>3/16&quot; Monobolts</td>
<td>202142</td>
<td>1/4&quot; Magna Lok 1/4&quot; Pop Rivets 1/4&quot; Plastic Rivets Replaces Tip 202157</td>
</tr>
<tr>
<td>Ø.125</td>
<td></td>
<td>Ø.172</td>
<td></td>
</tr>
</tbody>
</table>
## Troubleshooting

<table>
<thead>
<tr>
<th>Problem</th>
<th>Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.) Rivet Pintail is stuck in tool</td>
<td><strong>First Step:</strong> Lightly tap nose against a hard surface while after breaking squeezing HANDLES and pressing down the RELEASING BUTTON with tool pointing downward Pintail should then fall out, see fig. 4. <em>(If that does not work try Second Step.)</em></td>
</tr>
<tr>
<td></td>
<td><strong>Second Step:</strong> <em>(Use this only if first step does not work)</em> Remove NOSE TUBE and JAW HOLDER (for help see figure 5) take out pintail and reassemble.</td>
</tr>
<tr>
<td>2.) Tool will not reverse</td>
<td>Push on the handles until you feel a slight give, then press the RELEASING BUTTON and continue pushing on the handles, the tool should then reverse. If this does not work Remove NOSE TUBE and inspect for any foreign matter that may have cause the jamming between JAW HOLDER and the inside of NOSE TUBE.</td>
</tr>
<tr>
<td>3.) Fastener does not pull rivet</td>
<td>The JAW HOLDER is loose. Remove the NOSE TUBE and tighten the JAW HOLDER by turning it counter clockwise <em>(See Three Piece Jaw Installation and Removal.)</em></td>
</tr>
<tr>
<td>4.) The Rivet does not Fit into the Tool</td>
<td>The rivet is to large, or the wrong NOSE PIECE is on the tool. To find the correct NOSE PIECE <em>(see chart on page 11)</em>. If you do not have the needed NOSE PIECE, See next page for how to order the correct one.</td>
</tr>
<tr>
<td>5.) Premature Breaking</td>
<td>See solution for problem 4. Also verify the grip of the fastener and make sure you are not rocking the tool during installation.</td>
</tr>
<tr>
<td>6.) Jamming of Tool</td>
<td>See solution for problem 4. Also verify that you have the proper jaw engagement and that all parts are hand tight and that the jaws are cleaned and properly assembled in jaw pusher <em>(See Three Piece Jaw Installation and Removal)</em></td>
</tr>
<tr>
<td>7.) Rivet not installed properly</td>
<td>See solution for problem 4. Also verify that appropriate fastener is being used and proper fastener grip length for the application has been selected</td>
</tr>
<tr>
<td>8.) Jaws Breaking</td>
<td>See solution for problem 4. Check to see all parts are properly assembled and hand tight.</td>
</tr>
<tr>
<td>9.) Damaged Jaw Pusher</td>
<td>See solution for problem 4. Check to see if all parts are properly assembled.</td>
</tr>
</tbody>
</table>
90 Day Warranty on AK-175 Riveter

All Arconic Fastening Systems tools and parts have been carefully tested and checked at the factory and are guaranteed to be free from defects in material and workmanship, subject to the following conditions.

A.) The tools manufactured by Arconic Fastening Systems will be repaired free of charge or replaced at our discretion within 90 days of sale to the first user if, upon examination at our service center, we find a defect in material or workmanship in the hydraulic system.

B.) The tool must be returned intact and prepaid to one of our service centers. Proof of date of sale must accompany any tool returned. This warranty will be void if repairs have been made or attempted by others, or if the tool has been subject to abuse, neglect, accident or improper application.

C.) The foregoing obligation is Arconic Fastening Systems’ sole liability under this or any implied warranty, and no one is authorized to vary its terms or conditions.

D.) If you have any problems please contact Customer Service at the factory: 209-839-3000.

Before returning tools to the service center, please use the operation and maintenance tips on page 9 of this manual. If the tool continues to malfunction call the Customer Technical Support at Arconic Fastening Systems 209-839-3000 for additional assistance.

Authorized Tool Service Center:

Bay Fastening Systems
30 Banfi Plaza N.
Farmingdale, NY 11735
800 718 8818 (Toll Free)
516 294 4100
516 294 3448 (Fax)
Web: www.baysupply.com

Universal Repair Shop
1611 Boylston Avenue
Seattle, WA 98122
206 322 2726
206 322 2126 (Fax)

Mountainair Rivet Tools
115 West Broadway
Mountainair, NM 87036
479 936 7577
505 847 2207
505 847 2465 (Fax)

Professional Tool Center
2236 S.116th Street
West Allis, WI 53227
414 321 1234
414 321 2524 (Fax)

FSI
1206 East Mac Arthur St
Sonoma, CA 95476
707 935 1170
800 344 2394 (Toll Free)
707 935 1828 (Fax)
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.

Authorized Tool Service Centers (ATSC's) offer repair services, spare parts and Nose inserts and accessories. Please contact your Huck Representative or the nearest Huck office listed on the back cover for the ATSC in your area.
Arconic Fastening Systems

a business unit of Arconic, is a leading worldwide designer and manufacturer of fastening systems, including specialty fasteners, fluid fittings, assembly components and installation systems for aerospace and industrial applications.

Headquartered in Torrance, California, the company has over 8,300 employees at 39 manufacturing and distribution/logistics locations in 13 countries.

Arconic Fastening Systems world-wide locations:

**AMERICAS**

Arconic Fastening Systems
Aerospace Fasteners Division
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Tucson, AZ 85714
800-234-4825
520-747-9898
FAX: 520-748-2142

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

Arconic Fastening Systems
Industrial Fasteners Division
PO Box 8117
8001 Imperial Drive
Waco, TX 76714-8117
800-388-4825
254-776-2000
FAX: 254-748-2142

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Aerospace Fasteners Division
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Kingston, NY 12401
800-278-4825
845-331-7300
FAX: 845-334-7333

Arconic Fastening Systems
Industrial Products
Latin America Operations
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Tacubaya, Mexico, D.F.
C.P. 11850
FAX: 525-515-1776
TELEX: 1173530 LUKE

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Aerospace Products
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33-1-30-27-9500
FAX: 33-1-34-66-0600

afshuck.net/us

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