Instruction Manual

516, 520, 524, 528, 532, 536

Hydraulic Collar Cutter Models
EC Declaration of Conformity

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

Description of Machinery:
Models 5## family of Collar Cutters and specials based on their design (e.g. PR####).

Relevant provisions complied with:
British Standard related to hand held, non-electric power tools (ISO 11148-2:2011)

European Representative:
Andrew Smith, 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: Nicholas Gougoutris
Position: Engineering Manager
Location: Huck International, LLC d/b/a Arconic Fastening Systems
Kingston, New York, USA
Date: 01/05/2018 (May 1, 2018)

Declared dual number noise emission values in accordance with ISO 4871

A weighted sound power level, LWA: 91.3 dB (reference 1 pW) Uncertainty, KWA: 3 dB

A weighted emission sound pressure level at the work station, LpA: 80.3 dB (reference 20 μPa) Uncertainty, KpA: 3 dB

C-weighted peak emission sound pressure level, LpC, peak: 106.6 dB (reference 20 μPa) Uncertainty, KpC: 3 dB

Values determined according to noise test code ISO 3744. 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: .48 m/s²
Uncertainty, K: .15 m/s²

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:
Arconic Fastening Systems, Kingston Operations, Kingston, NY, USA.
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 cutting-off/crimping power tool.
5. Do not modify this cutting-off/crimping 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 cutting-off / crimping 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. Only genuine Huck parts shall be used for replacements or spares. Use of any other parts can result in tooling damage or personal injury.
11. Never remove any safety guards or pintail deflectors.
12. 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.
13. 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.

II. PROJECTILE HAZARDS:
1. Disconnect the cutting-off / crimping power tool from energy source when changing inserted tools or accessories.
2. Be aware that failure of the workpiece, accessories, or the inserted tool itself can generate high velocity projectiles.
3. Always wear impact resistant eye protection during tool operation. The grade of protection required should be assessed for each use.
4. For overhead work, wear a safety helmet.
5. Ensure that the workpiece is securely fixed.
6. The risk to others should also be assessed at this time.
7. Be aware of the risk of being exposed to the ejection of cuttings or chips.
8. Be aware that working on brittle material can cause harmful splinters.

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 direct contact with the inserted tool as it can become hot.
8. Sharp tools shall always be used.
10. Be aware of risk of cutting with tools with large dimensions.

IV. REPETITIVE MOTION HAZARDS:
1. When using cutting-off / crimping 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.
Safety Instructions

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 cutting-off / crimping 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. DUST AND FUME HAZARDS:
1. Dust and fumes generated when using cutting-off and crimping power tools can cause ill health; risk assessment and implementation of appropriate controls for these hazards are essential.
2. Risk assessment should include dust created by the use of the tool and the potential for disturbing existing dust.
3. Operate and maintain the cutting-off or crimping power tool as recommended in the instruction handbook, in order to minimize dust or fume emissions.
4. Direct the exhaust so as to minimize disturbance of dust in a dust-filled environment.
5. Where dust or fumes are created, the priority shall be to control them at the point of emission.
6. All integral features or accessories for the collection, extraction or suppression of airborne dust or fumes should be correctly used and maintained.
7. Use respiratory protection in accordance with employer’s instructions and as required by occupational health and safety regulations.

VIII. 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.

IX. 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. 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.

X. HYDRAULIC TOOL SAFETY INSTRUCTIONS:

WARNING: Do not exceed maximum pull or return settings on tool.

1. Carry out a daily check for damaged or worn hoses or hydraulic connections and replace if necessary.
2. Wipe all couplers clean before connecting. Failure to do so can result in damage to the quick couplers and cause overheating.
3. Ensure that couplings are clean and correctly engaged before operation.
4. Use only clean oil and filling equipment.
5. Power units require a free flow of air for cooling purposes and should therefore be positioned in a well ventilated area free from hazardous fumes.
6. Do not inspect or clean the tool while the hydraulic power source is connected. Accidental engagement of the tool can cause serious injury.
7. Be sure all hose connections are tight.
8. Wipe all couplers clean before connecting. Failure to do so can result in damage to the quick couplers and cause overheating.
Huck 500 series Collar Cutters are used to remove the collars from 1/2 through 1-1/8 installed HUCKBOLT® Fasteners. These Collar Cutters cut through the swaged collars. Hydraulic pressure is supplied by HUCK hydraulic Powerig®’s at maximum of 5700 psi.

**Description**

Collar Cutters are accessories and use installation tool’s operating switch and hose. An auxiliary switch and control cord is available separately and is used where a tool switch is not accessible.

**Specifications**

**POWER SOURCE:** Huck Powerig® Hydraulic Unit

**HOSE KITS:** Use only genuine HUCK Hose Kits rated @ 10,000 psi working pressure.

**MAX OPERATING TEMPERATURE:** 125°F (51.7°C)

**MAX FLOW RATE:** 2 gpm (7.5 l/m)

**MAX INLET PRESSURE:** 5700 psi (393 bar)

**HYDRAULIC FLUID:** Hydraulic fluid shall meet DEXRON® III, DEXRON VI, MERCON®, Allison C-4 or equivalent Automatic Transmission Fluid (ATF) specifications. Fire-resistant fluid may be used if it is an ester-based fluid such as Quintolubric® HFD or equivalent. Water-based fluid shall NOT be used as serious damage to equipment will occur.

Where the following trade names are used in this manual, please note:

- **DEXRON** is a registered trademark of General Motors Corporation.
- **Loctite** is a registered trademark of Henkel Corporation, U.S.A.
- **LUBRIPLATE** is a registered trademark of Fiske Brothers Refining Co.
- **MERCON** is a registered trademark of Ford Motor Corp.
- **MOLYKOTE** is a registered trademark of Dow Corning Corporation
- **Never-Seez** is a registered trademark of Bostik, Inc.
- **Quintolubric** is a registered trademark of Quaker Chemical Corp.
- **Slic-tite** is a registered trademark of LA- CO Industries, Inc.
- **Spirolox** is a registered trademark of Smalley Steel Ring Company
- **Teflon** is a registered trademark of E. I. du Pont de Nemours and Company.
- **Threadmate** is a registered trademark of Parker Intangibles LLC.
- **TRUARC** is a trademark of TRUARC Co. LLC.
- **Vibra-Tite** is a registered trademark of ND Industries, Inc. U.S.A.

**Model No.**

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<th>Collar Size</th>
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<td>-36</td>
<td>9.40 (239)</td>
<td>4.25 (108)</td>
<td>5.50 (140)</td>
</tr>
</tbody>
</table>

**Sticker Locations**

These hydraulic collar cutters come labeled with important safety and pressure information stickers.

It is necessary that these stickers remain on the cutter easily readable at all times.

If a sticker becomes damaged or worn, or if it has been removed from the tool, a new sticker must be ordered and placed in the location shown.

**Figure 1** PLACEMENT OF CE, CAUTIONS, AND WARNING STICKERS

- **590273** Warning Sticker
- **590514-1** CE and Caution Sticker
- **590513** Pinch Point Sticker
- **590517** HUCK Year of Manufacture Sticker
**Principle of Operation**

The PULL Pressure hose of an installation tool is connected to a Collar Cutter. Cutting stroke is controlled by installation tool switch or an auxiliary switch. When switch is depressed, a solenoid-operated valve in the Powerig directs pressurized hydraulic fluid through hose and against Cutter Piston. Piston with Blade moves forward. When Cutter is positioned on swaged collar, moving Blade presses collar against stationary Blade. Cutting begins and continues until Piston stroke is completed. Opposing force of Blades cuts Collar on opposite sides. When cutting is completed, switch is released. Solenoid is de-energized, and valve releases pressure from Piston and Blade. Powerig idling valve diverts hydraulic fluid to reservoir. Return Spring moves Piston to rear of Cylinder, and Blades are opened. The Cutter is removed from cut collar and is ready to cut next swaged collar.

**Preparation for Use**

**WARNINGS:**

**READ FULL MANUAL BEFORE USING TOOL.**

Be sure there is adequate clearance for the operator’s hands before proceeding.

Correct PULL and RETURN pressures are required for operator safety and for Installation Tool function. Pressure Gauge T-124833CE is available for checking pressures. See Tool Specifications and Gauge Instruction Manual. Failure to verify pressures may result in severe personal injury.

Connect Tool’s hydraulic hoses to POWERIG Hydraulic Unit before connecting Tool’s switch control cord to unit. If not connected in this order, severe personal Injury may occur.

RETURN pressure port on Powerig® hydraulic power source must be plugged with a steel 3/8-18 NPTf (HUCK Part No. 502375) pipe plug to prevent hydraulic fluid from being discharged.

**CAUTIONS:**

Do not let disconnected hoses and couplers contact a dirty floor. Keep harmful material out of hydraulic fluid. Dirt in hydraulic fluid causes valve failure in tool and in Powerig Hydraulic Unit.

Do not use TEFiON® tape on pipe threads. Pipe threads may cause tape to shred resulting in tool malfunction. (Slic-Tite is available in stick form as HUCK P/N 503237.)

Rub Slic-Tite® with PTFE thread compound, or equivalent, on pipe plug threads and quick connect fitting.

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

2. First, turn hydraulic unit to OFF. Then disconnect power supply from hydraulic unit. Disconnect trigger control system from hydraulic unit.

3. Connect PULL pressure hose, with coupler nipple, into Cutter. Use only with HUCK supplied hoses rated at 10,000 psi or greater. Check trigger assembly for apparent damage or wear. If required, adjust position of trigger assembly on return pressure hose. Connect trigger control system to hydraulic unit. If auxiliary switch and control cord is used, installation tool is not required to actuate powerig. With auxiliary switch and control cord, the tool hose alone, or an equivalent hose, may be coupled to cutter. The RETURN pressure port must be plugged with a steel pipe plug HUCK Part No. 502375 (3/8-18 NPTf).

4. Connect tool switch cord to Powerig cord, or connect auxiliary switch cord to powerig cord.

5. Turn hydraulic unit to ON. Depress and release switch a few times to cycle tool and to circulate hydraulic fluid. Observe action of Cutter and check for fluid leaks.
Checking Hydraulic Pressures

**WARNINGS:**
For adjusting the pressure, see the applicable Powerig® hydraulic power source instruction manual. Neglecting to verify pressures may lead to catastrophic failure of hoses, tool or other part of system. This could cause severe or fatal injury to anyone nearby.

When hydraulic unit is running, be sure to connect tool’s hoses to unit before connecting tool’s control cord to unit. If a malfunctioning cord switch is connected first, tool may begin to cycle unexpectedly. An accidentally cycling tool could severely injure a hand.

When disconnecting hoses, switch control cord **must** be disconnected first, before disconnecting hoses.

**Conditions that require checking and adjusting output pressures:**
1. If tool with higher pressure has been used.
2. When changing collar cutter size.
3. When changing tools, if pressure requirements differ.
4. First time startup.
5. After overhauling unit.
6. When troubleshooting.

**Preparation for checking pressures:**
Prime and bleed hydraulic unit per the applicable Powerig® hydraulic power source instruction manual.

Operating Instructions

**WARNINGS:**
Do not operate cutter if directed toward the operator or any person.

Beware of ejection of cutting material or chips; turn head in each operation to avoid exposure.

Working on brittle material can cause harmful splinter.

Do not bend cutter to free if stuck.

Cutter must be disconnected prior to clearing collar segments.

**CAUTIONS:**
Tool **must** be centered on collar to assure proper cutting action.

Check Cutter for collar segments after each stroke. Segments not removed from Cutter will cause damage to Cutter and to fastened structure.

**HuckBolt® FASTENER REMOVAL:**

1. Place Collar Cutter over swaged collar. Hold bottom flat against sheet surface.

2. Press installation tool switch or auxiliary switch. The moving blade cuts through side of collar as stationary blade is pulled into, and simultaneously cuts, opposite side.

3. Release switch when cut is completed. Return spring pushes the piston back to starting position, and causes blades to open.

4. Cutter can now be removed from cut collar, and cutting cycle repeated on next swaged collar.
Maintenance

With proper care, the cutter will remove 100 collars before it may be necessary to replace the blades. The estimated life of the Collar Cutter is 10,000 cycles, or 5 years, depending upon service conditions.

GOOD SERVICE PRACTICES

The efficiency and life of any installation or removal tool depends upon proper maintenance and good service practices. Tools should be serviced in a clean, well-lit area by personnel who are thoroughly familiar with them and how they operate. Special care must be given to prevent contamination of hydraulic systems.

All parts must be handled carefully and examined for damage or wear. Perishable parts such as o-rings and seals should be kept on hand for replacement whenever tool is disassembled.

See Specifications for fluid type. Dispose of fluid in accordance with local environmental regulations. Recycle steel, aluminum, and plastic parts in accordance with local lawful and safe practices.

Disassemble and assemble components in a straight line without bending, cocking or undue force.

Disassembly and assembly procedures outlined in this manual should be followed. Keep hand tools and soft materials to protect cutter available. Only standard hand tools are required. A half inch brass drift, wood block and a vise with soft jaws will prevent damaging tool.

SYSTEM INSPECTION

Operating efficiency of the cutter is directly related to the performance of the complete system, including the cutter, hydraulic hoses, trigger assembly and the Powerig® hydraulic power source. Therefore, an effective preventive maintenance program includes scheduled inspections of the system to detect and correct minor defects.

1. Inspect cutter for external damage.
2. Verify that hoses, fittings and trigger connections are secure.

CUTTER MAINTENANCE

At regular intervals, depending upon use, replace all seals in the cutter. Spare seals and parts should be kept on hand.

Inspect cylinder bore and piston for scored surfaces, excessive wear or damage, and replace as necessary.

NEEDLE VALVE ADJUSTMENT

A needle valve has been designed into the hydraulic cylinder of some of the cutters. The adjustment provides for the proper piston RETURN stroke when using various hydraulic units and hose combinations. Tool is shipped with the valve set in the closed position.

Needle Valve Adjustment for the 940 Powerig® Hydraulic Unit:

2. Open needle valve by turning slightly counterclockwise. Jog or activate switch. If valve is correctly adjusted, piston will return to rear and pump shuts off. Repeat procedure until cutter cycles normally.
3. If normal cutter operation cannot be attained, close needle valve completely and start over at 1. Repeat until requirements are met.

Needle Valve Adjustment Troubleshooting:

Note: A normal piston cycle is when the piston goes fully forward and fully back with one actuation of the switch.

Q. Piston partially returns, and pump shuts off.
A. Needle valve not open enough.

Q. Piston partially or fully returns, and pump will not shut off.
A. Needle valve is open too far.

HYDRAULIC COUPLINGS

Use a fine India stone to remove any nicks or burrs areas to prevent damage to O-ring of Female Connector.
Disassembly and Assembly Procedures

GENERAL GUIDELINES
During disassembly and assembly, take the following precautions to avoid damaging tool or components:

(a) Always work on a clean surface.

(b) Use relatively soft materials, such as brass, aluminum or wood, to protect tool when applying pressure.

(c) Apply a continuous strong pressure, rather than sharp blows, to disassemble or assemble a component. An arbor press provides steady pressure to press a component in or out.

(d) Never continue to force a component if it “hangs up” due to misalignment. Reverse the procedure to correct misalignment and start over.

(e) Smear Lubriplate 130AA, T.M or equivalent, on O-rings and mating surfaces to aid assembly and prevent damage to O-rings. (Lubriplate is manufactured by Fiske Brothers Refining Co. and is available in most localities. A handy tube of Lubriplate 130AA is available from Huck as part number 502723).

DISASSEMBLY AND ASSEMBLY TOOLS
Standard hand tools such as wrenches, drifts, copper or lead hammers, screwdrivers, socket screw hexagon keys, long forceps (tweezers), etc. Which can be purchased at most local supply firms are required. If possible, an arbor press and vise with soft jaws should be available. Standard tools available from Huck are shown in Table 3.

Disassembly Procedure

For component identification, see Figure 2. Numbers in parenthesis indicate the item number on the components drawing. The following procedure is for complete disassembly. Disassemble only those parts necessary. Check and replace damaged/worn components. Always replace O-rings, wipers, and back-up rings of disassembled subassemblies.

1. Uncouple hydraulic hose at Cutter, and disconnect electrical control cord.

2. Remove Screw (1) from Blade (2). Remove blade from Cylinder Body (3).

3. Remove four Flat Head Screws (12) from Cylinder Head (7), and lift out Keeper Plate (11).

4. While observing the WARNING below, remove the Retaining Ring (10).

5. Pull on Hydraulic Coupler (14) to remove Cylinder Head (7) from Cylinder Body (3). Unscrew Coupler and Pipe Nipple (13) from Cylinder Head.

6. While observing WARNING above, remove the Shoulder Screw (9) and Washer (8); then carefully life Piston (15) and Piston Return Spring (5) out of Cylinder Body.

7. Pull Piston Blade (6) from cylinder body, and remove Guide Pin (4).

8. Use a small diameter, dull-pointed rod to remove O-Rings and Back-up Rings from all components.
Assembly Procedure

Before assembling tool:
(a) Clean components in mineral spirits or other solvent compatible with O-Ring seals.
(b) Clean out O-Ring grooves.
(c) Inspect components for scoring, excessive wear or damage.
(d) Replace O-Rings and Back-up Rings. Be sure that relative positions of the O-Rings and Back-up Rings are as shown in Cutter assembly drawing.
(e) Smear Lubriplate 130AA on O-Rings and mating surfaces to prevent damage to O-Rings and to aid assembly.

1. Fasten Piston Blade (6) to Piston (15) with Washer (8) and Shoulder Screw (9). Tighten screw to 390 in./lbs.
2. Drop Return Spring (5) into Cylinder Body (3). Align slot in blade with Guide Pin (4) hole in Cylinder and push assembled Piston (15), including Back-up Rings and O-Rings (15a-15d) and blade into Cylinder.
3. Install Guide Pin (4).
4. Attach Pipe Nipple (13) and Hydraulic Coupler (14) to Cylinder Head (7), and push assembled Cylinder Head, including Back-up Rings and O-Rings (7a & 7b), into Cylinder Body (3). While holding Cylinder Head in position, install Retaining Ring (10).
5. Install Keeper Plate (11) in Cylinder Head with four Flat Head Screws (12). Tighten Screws to 75 in./lbs.
6. Hold Body Blade (2) in Cylinder Body while installing Screw (1). Tighten Screw to 245 in./lbs.
7. Couple hydraulic hose to the assembled Cutter, and connect electrical control cord.

Troubleshooting

Always check out the simplest possible cause of a malfunction first. For example, a switch turned off or a power cord not connected. Then proceed logically, eliminating each possible cause until the defective circuit or part is located. Where possible, substitute known good parts for suspected bad parts. Use a Troubleshooting Chart as an aid in locating and correcting it.

1. Cutter fails to operate:
   (a) Inoperative Powerig - See Powerig® hydraulic power source Instruction Manual
   (b) Loose or disconnected control cord
   (c) Defective tool switch assembly or auxiliary switch assembly
   (d) Loose or faulty hydraulic hose coupling

2. Cutter blades do not completely cut through collar:
   (a) RETURN pressure hydraulic hose connected to cutter

3. Cutter leaks hydraulic fluid:
   (a) Depending on where the leak occurs - defective or worn O-rings and/or loose hydraulic hose connection at cutter

4. Hydraulic Couplers leak fluid:
   (a) Defective or worn O-ring in coupler body (See Hydraulic Couplings Figure in MAINTENANCE section.)

5. Hydraulic Fluid overheats:
   (a) Powerig not operating properly - Pump motor rotation reversed
   (b) Restriction in hydraulic line

6. Cutter operates erratically and does not cut collar quickly:
   (a) Low or erratic hydraulic fluid supply
   (b) Defective or excessively worn piston O-ring in cutter
   (c) Excessive wear or scoring of sliding surfaces
   (d) Blades are dull or damaged

7. Cutter blades fail to open when switch is released:
   (a) Return spring is weak or broken
Components Drawing for All Models

**Figure 2**

![Diagram of components]

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<th>ITEM</th>
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Kits, Accessories, and Service Tools

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O-Rings*

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Spare Parts Kits

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The quantity of spare parts that should be kept on hand varies with the number of tools in service. Spare Parts Kits containing perishable parts such as O-Rings and Back-up Rings should always be kept available to replace worn items.

Miscellaneous Parts

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Standard Service Tools

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<td>502860</td>
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Also available are:

- Auxiliary Electric Trigger Assembly - 113056
- Slic-Tite Stick - 503237
- Lubriplate 130A - 502723
- Never-Seez - 505565
Limited Warranties

Limited Lifetime Warranty on BobTail® Tools:

Huck International, Inc. warrants to the original purchaser that its BobTail® installation tools manufactured after 12/1/2016 shall be free from defects in materials and workmanship for its useful lifetime. This warranty does not cover special order / non-standard products, or part failure due to normal wear, tool abuse or misapplication, or user non-compliance with the service requirements and conditions detailed in the product literature.

Two Year Limited Warranty on Installation Tools:

Huck International, Inc. warrants that its installation tools and Powerig® hydraulic power sources manufactured after December 1, 2016 shall be free from defects in materials and workmanship for a period of two years from date of purchase by the end user. This warranty does not cover special order / non-standard products, or part failure due to normal wear, tool abuse or misapplication, or user non-compliance with the service requirements and conditions detailed in the product literature.

90 Day Limited Warranty on Nose Assemblies and Accessories:

Huck International, Inc. warrants that its nose assemblies and accessories shall be free from defects in materials and workmanship for a period of 90 days from date of purchase by the end user. This warranty does not cover special clearance noses, or special order / non-standard product, or part failure due to normal wear, abuse or misapplication, or user non-compliance with the service requirements and conditions detailed in the product literature.

Useful lifetime is defined as the period over which the product is expected to last physically, up to the point when replacement is required due to either normal in-service wear, or as part of a complete overhaul. Determination is made on a case-by-case basis upon return of parts to Huck International, Inc. for evaluation.

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.

Huck shall not be liable for any loss or damage resulting from delays or non-fulfillment 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

Outside USA and Canada
Contact your nearest Huck International location (see reverse).

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 Tool Kits and Nose Assemblies. Please contact your Huck Representative or the nearest Huck International location (see reverse) for the ATSC in your area.
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Through the ingenuity of our people and cutting-edge advanced manufacturing, we deliver these products at a quality and efficiency that ensures customer success and shareholder value.

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845-331-7300  
FAX: 845-334-7333

**Tucson Operations**  
3724 East Columbia Street  
Tucson, AZ 85714  
800-234-4825  
520-519-7400

**Carson Operations**  
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Carson, CA 90745  
800-421-1459  
310-830-8200  
FAX: 310-830-1436

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Parque Industrial Amistad  
Acuña, Coahuila 26220  
Mexico  
FAX: 525-515-1776

**Waco Operations**  
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8001 Imperial Drive  
Waco, TX 76714-8117  
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**Melbourne Operations**  
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FAX: +613 8545 3391


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