EC Declaration of Conformity

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

Description of Machinery:
Models CC, OSCC, CCX, & CCXS families (-05 to -12) 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 1148-1:2011)

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

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

Signature:

Full Name: Robert B. Wilcox
Position: Engineering Manager
Location: Huck International, LLC d/b/a Arconic Fastening Systems and Rings
Kingston, New York, USA
Date: 01/11/2016 (November 1, 2016)

Declared dual number noise emission values in accordance with ISO 4871

<table>
<thead>
<tr>
<th>Description</th>
<th>Value</th>
<th>Uncertainty</th>
</tr>
</thead>
<tbody>
<tr>
<td>A weighted sound power level, LWA</td>
<td>85 dB</td>
<td>3 dB</td>
</tr>
<tr>
<td>A weighted emission sound pressure level at the work station, LpA</td>
<td>74 dB (reference 20 µPa)</td>
<td>3 dB</td>
</tr>
<tr>
<td>C-weighted peak emission sound pressure level, LpC, peak</td>
<td>106 dB (reference 20 µPa)</td>
<td>3 dB</td>
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</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Description</th>
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<tbody>
<tr>
<td>Measured Vibrations emission value, a</td>
<td>0.20 m/s²</td>
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<tr>
<td>Uncertainty, K</td>
<td>0.21 m/s²</td>
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</tbody>
</table>

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

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

III. OPERATING HAZARDS:
1. Use of tool can expose the operator’s hands to hazards including: crushing, impacts, cuts, abrasions and heat. Wear suitable gloves to protect hands.
2. Operators and maintenance personnel shall be physically able to handle the bulk, weight and power of the tool.
3. Hold the tool correctly and be ready to counteract normal or sudden movements with both hands available.
4. Maintain a balanced body position and secure footing.
5. Release trigger or stop start device in case of interruption of energy supply.
6. Use only fluids and lubricants recommended by the manufacturer.
7. Avoid unsuitable postures, as it is likely for these not to allow counteracting of normal or unexpected tool movement.
8. If the assembly power tool is fixed to a suspension device, make sure that fixation is secure.
9. Beware of the risk of crushing or pinching if nose equipment is not fitted.
IV. REPETITIVE MOTION HAZARDS:
1. When using assembly power tool, the operator can experience discomfort in the hands, arms, shoulders, neck or other parts of the body.
2. When using tool, the operator should adopt a comfortable posture while maintaining a secure footing and avoid awkward or off balanced postures.
3. The operator should change posture during extended tasks to help avoid discomfort and fatigue.
4. If the operator experiences symptoms such as persistent or recurring discomfort, pain, throbbing, aching, tingling, numbness, burning sensations or stiffness, these warnings should not be ignored. The operator should tell the employer and consult a qualified health professional.

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

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

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

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

X. HYDRAULIC TOOL SAFETY INSTRUCTIONS:
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.
Description

The series **CCFT, CCFT-QD, ACCFT, OSCCFT, and AOSCCFT** hydraulic Collar Cutters remove LGP® HUCKBOLT® fasteners with flanged titanium collars.

Series **CC-LGP-QD** and **ACC-LGP** hydraulic Collar Cutters remove LGP HUCKBOLT fasteners with unflanged steel and aluminum collars.

Series CCMG and ACCMG Hydraulic Collar Cutters are designed to remove MAGNA-GRIP® HUCKBOLT fasteners with flanged steel and aluminum collars. These mini collar cutters are light weight and compact which makes them adaptable for removing fasteners in limited clearance areas.

The QD series of collar cutters are designed to be used with the quick disconnect hose and switch kits for time-saving efficiency. These mini collar cutters are light weight and compact which makes them adaptable for removing fasteners in limited clearance areas.

Huck Hydraulic Collar Cutters are designed to be powered by Huck POWERIG® Hydraulic Units. Cutters operate on 5700 psi (39300kPa) PULL pressure as supplied by POWERIG Hydraulic Units.

The ACC series are air triggered tools designed for use with Models 942 and 970 POWERIG Hydraulic Units, or equivalent.

The CC series are electric triggered tools designed for use with Models 913, 918 and 940, or equivalent.

Power source must be set to correct pressure per applicable POWERIG Hydraulic Unit instruction manual.

Specifications

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

**HOSE KITS:**
Use only genuine HUCK Hose Kits rated at 10,000 psi (689.5 bar) working pressure.

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

**MAX FLOW RATE:**
2 gpm (7.6 l/m)

**MAX PULL PRESSURE:**
4CC through 8CC: 5,700 psi (393 bar)
10CC through 12CC: 6,000 psi (413 bar)

**WEIGHT:**
5, 6, & 8CC & OS series: 2.6 lbs (.95 kg)
10 & 12CC series: 3.1 lbs (1.42 kg)

**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.
**Quintolubric** is a registered trademark of Quaker Chemical Corp.
**Threadmate** is a registered trademark of Parker Intangibles LLC.
**Loctite** is a registered trademark of Henkel Corporation, U.S.A.
**Slic-tite** is a registered trademark of LA-CO Industries, Inc.
**Teflon** is a registered trademark of E. I. du Pont de Nemours and Company.
**LUBRIPLATE** is a registered trademark of Fiske Brothers Refining Co.
5CC and 6CC Dimensions

8CC Dimensions

Specifications (continued)
**Principle of Operation**

The hydraulic hose and trigger control cord are connected to the Huck Powerig® hydraulic power unit. The trigger, when depressed, controls the PUSH stroke of the tool. Hydraulic pressure is directed to the piston, which then moves forward.

Fastener removal (collar cutting) begins as the lever moves, forcing the collar against stationary blades, cutting the collar. When the cutting is completed, the trigger is released. Spring pressure moves the piston rearward to the starting position; and the cutter is ready for the next cutting cycle.

**Sticker Placement**

All Collar Cutters are equipped with important information, safety, and WARNING stickers. If a sticker becomes unreadable, damaged, worn, or is missing, a replacement sticker must be ordered and placed as shown. Please review the components drawings for other important CAUTION and pressures stickers exclusive to individual cutters.
Preparation for Use

**WARNINGS:** Huck recommends that only Huck Powerigs be used as a power source for Huck installation equipment.

When operating Huck equipment always wear approved eye protection. Severe eye injury may occur if eyes are not protected.

Tool moves forcibly while cutting collars. Be sure there is adequate clearance for the tool and the operator's hands before proceeding. Otherwise, severe personal injury may result.

Hydraulic power units that deliver high PULL and RETURN pressures—but which are NOT equipped with RELIEF VALVES—are specifically NOT RECOMMENDED and may be dangerous.

Set the PULL and RETURN pressures as specified in Specifications. Failure to properly set these pressures could result in serious personal injury.

Use Huck Pressure Gauge T-124833CE for setting pressures. Improper pressure settings may result in severe personal injury.

**CAUTIONS:**

Keep dirt and other foreign matter out of the hydraulic systems of tools, hoses, couplers Powerig® hydraulic unit.

Do not let hose and couplers contact a dirty floor or unclean work surface. Foreign matter in hydraulic fluid may cause valve failures in the tool and Powerig.

Do not use Teflon® tape on pipe threads. Tape can shred, resulting in malfunctions.

Apply Parker Threadmate®, Loctite® 567, or Slic-Tite® to male pipe threads, hose fitting threads, and quick connect fittings (per manufacturer’s instructions) to prevent leaks and to ease assembly.

Do not abuse the tool by dropping it, using it as a hammer, or otherwise causing unnecessary wear and tear.

Reasonable care of tools by operators is an important factor in maintaining tool efficiency and reducing downtime.

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1. Use a Huck Powerig hydraulic unit, or equivalent, that has been prepared for operation per applicable instruction manual. Check the PULL and RETURN pressures, and adjust as required.

2. Screw the PULL pressure hose, with the coupler nipple, into the port of tool.

3. Adjust the trigger assembly on the pressure hose for convenient position if required.

4. Connect the tool hose to the Powerig.

5. Connect the trigger control cord or air line to the Powerig.

6. Connect the Powerig to the power supply (air or electric). Depress the trigger a few times to cycle the tool and to circulate the hydraulic fluid. Observe the action of the tool and check for leaks. Disconnect the tool from power supply.

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**Hydraulic Couplings**

- O-ring (P/N 504438)
- Back-up ring (P/N 501102)

**TIP:** Use a fine India stone to remove nicks and burrs from diameter A and leading edge to prevent damage to O-ring.
Unequal loading of the blades caused by misalignment is the cause of most tool malfunctions. Experience will show the most efficient procedure in each situation. Collars must be cut on the first attempt. Repeated cycling of the tool is likely to cause blade damage. The blades follow the previous blade path without cutting.

1. Place tool over fastener to be removed. (Fig. 5 or 6) Check position of blades before triggering tool. IMPORTANT: When using titanium collars, lubricate the tool blades with an anti-seize lubricant before each cut.

2. Depress tool trigger, and release it when cutting action stops. Remove the tool.

3. If tool is adjusted correctly for swaged condition of the collar, one stroke will remove the collar. (See Adjustments for detailed instructions.) When collar is cut but still attached to fastener, use appropriate hand tools to complete collar removal.

4. Tap the end of the fastener with soft-faced mallet to remove it from the hole.

**Removing Partially Cut Collars** (Figure 7)

1. Place the **G57F** over the fastener to be removed, and squeeze the handles, closing the blades around the pin.

2. Move the **G57F** handles up and down as shown in direction of arrows until the collar separates from the pin.
**Maintenance**

**GOOD SERVICE PRACTICES**
The operating efficiency of any installation or removal tool depends upon proper maintenance and good service practices. Tools should be serviced by personnel who are thoroughly familiar with them and how they operate.

Service the tool in a clean, well-lighted area. Give special care to prevent contamination of pneumatic and hydraulic systems.

Carefully handle all parts and components. Before reassembly, examine hoses, parts, and components for damage and wear; replace when necessary.

Disassemble and assemble tool components in a straight line without bending, cocking, or undue force. Follow the disassembly and assembly procedures in this manual.

Appropriate hand tools and soft materials to protect tool must be available. Only standard hand tools are required. A half-inch brass drift, and wood block and vise with soft jaws will prevent damaging tools.

**NOTE: As experience shows, components such as jaws should be kept on hand for repairs. Keep perishable parts such as O-rings and seals on hand for replacement whenever the tool is disassembled.**

**PREVENTIVE MAINTENANCE**
With proper care, the cutter will remove 200 collars before it may be necessary to replace the blades. Lubricate the area between the housing, wedge, and lever with Never-Seez every fifty fasteners. After 200 fasteners, the cutter should be disassembled, cleaned in mineral spirits, and blown dry with compressed air. When parts are completely dry, coat the specified areas with molybdenum disulfate solution (suggested product is MOLYKOTE® 106). When replacing a blade set, coat it with Never-Seez during assembly.

**SYSTEM INSPECTION**
The operating efficiency of the tool is directly related to the performance of the complete system, including the tool, hydraulic hoses, trigger assembly, and the Powerig® hydraulic unit. Therefore, an effective preventive maintenance program includes scheduled inspections of the system to detect and correct minor troubles.

Inspect the tool for external damage.

Verify that hoses and fittings, and trigger connections are secure.

Inspect hydraulic hoses for signs of damage; replace if necessary.

Inspect tool, hoses, and Powerig during operation to detect abnormal heating, leaks, or vibration.

**POWERIG MAINTENANCE**
Maintenance instructions and repair procedures are in the applicable Powerig Instruction Manual.

**TOOL MAINTENANCE**
Whenever disassembled, and at regular intervals, replace all seals in the tool. Spare seals and parts should be kept on hand.

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

Never-Seez is a registered trademark of Bostik, Inc.
MOLYKOTE is a registered trademark of Dow Corning Corporation

**Assembly of NPTF Threaded Components**

**AIR FITTINGS**
1) Apply TEFLON® stick to male threads which do not have pre-applied sealant per manufacturer’s recommendations. (Proceed to All Fittings step 2)

**HYDRAULIC FITTINGS**
1) Apply Threadmate™ to male and female threads which do not have pre-applied sealant per manufacturer’s recommendations. (Proceed to All Fittings step 2)

**ALL FITTINGS:**
2) Tighten to finger-tight condition.
3) Wrench tighten to 2-3 turns past finger-tight condition.
4) Final thread engagement can be checked (optional) by measuring the dimension from the flange of male fitting to the end of the thread before assembly and subtracting the distance under the flange after assembly.

<table>
<thead>
<tr>
<th>Thread Size</th>
<th>Final thread engagement at full make-up</th>
</tr>
</thead>
<tbody>
<tr>
<td>1/8-27 NPTF</td>
<td>.235 inch (.59 cm)</td>
</tr>
<tr>
<td>1/4-18 NPTF</td>
<td>.339 inch (.86 cm)</td>
</tr>
<tr>
<td>3/8-18 NPTF</td>
<td>.351 inch (.89 cm)</td>
</tr>
</tbody>
</table>
Standard Tools Available from Huck

**CAUTION:** Do not use Teflon® tape on pipe threads. Tape can shred, resulting in malfunctions.

### Adjustments

The Collar Cutter is designed to remove a fully swaged collar in one stroke when adjusted with the set plug gauge that is supplied with the tool. (Set plug gage part number is 130045-*, where *= fastener size. e.g. 130045-6 is shipped with cutter 6CCX; 130045-10 is shipped with cutter 10CCX, etc.) The Collar Cutter can be adjusted to cut partially swaged collars by increasing the opening between the lever and the blades. **NOTE:** See the applicable tool drawing for set plug gauge part number. Check fastener size.

#### LEVER ADJUSTMENT

**Fully Swaged Collar**

1. Adjust the gap opening between the blades and the lever by inserting a 3/16" hex key through the hole in the end cap and into the piston hex. The turning key moves the wedge and lever simultaneously. Adjust until a slight interference is felt on the flange diameter of the collar between the blade and the lever.
2. Check the tool on a test plate with properly installed fasteners. See **ADDITIONAL PROCEDURES AFTER ADJUSTMENT**.
3. Fill the tool with fluid and replace the hose kit.

**Partially Swaged Collar**

Simulate the “partially swaged” condition by installing fasteners in a test plate using spacers (shim stock) equally spaced under the anvil of the nose assembly. Install the fasteners with various shims until the desired “partial swage” is obtained.

1. Follow **Fully Swaged Collar** steps 1–3.
2. Remove the gauge.

#### Additional Procedures After Adjustment

After final adjustments have been made, if the collar cannot be cut with one stroke, remove the collar with appropriate hand tools. See Figure 7. If increased efficiency is required, more than one cutter can be used: one adjusted to cut fully swaged collars and one adjusted to cut partially swaged collars.

### LUBRICANTS & SEALANTS

Apply Parker Threadmate®, Loctite® 567, or Slic-Tite® to male pipe threads—per manufacturer’s instructions—to ease assembly and to prevent leaks.

<table>
<thead>
<tr>
<th>P/N</th>
<th>Description</th>
<th>USE ON</th>
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</thead>
<tbody>
<tr>
<td>502723</td>
<td>SUPER-O-LUBE</td>
<td>500989 &amp; 500991</td>
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<tr>
<td>505565</td>
<td>Never-Seez</td>
<td>500054</td>
</tr>
<tr>
<td>503237</td>
<td>Slic-Tite</td>
<td>119513 &amp; 123703</td>
</tr>
<tr>
<td>508517</td>
<td>Threadmate</td>
<td></td>
</tr>
</tbody>
</table>

**CAUTION:** Do not use Teflon® tape on pipe threads. Tape can shred, resulting in malfunctions.

**PART NO.**

**DESCRIPTION**

**USE ON**

502865  Truarc Pliers #0200  500989 & 500991
502655  9/64" Hex Key  500054
502296  3/16" Hex Key  119513 & 123703
Disassembly

Refer to MAINTENANCE and the Assembly Drawings in this manual. The following procedure is for complete disassembly. Disassemble only those subassemblies necessary to check and replace damaged seals and components.

1. Uncouple the hydraulic hose connector and electrical control cord connector or air connector from the power source.

2. Use the 1/8" hex key to remove the socket-head cap screw from blade. Remove blade from the housing.

3. Use a mallet and brass rod to tap the split pin from the housing. Remove the torsion spring.

4. Use TRUARC pliers #0200 to remove the retaining ring from the pin.

5. Push the pin from the housing. Remove the lever.

6. Remove the hydraulic hose from the elbow. Remove the quick disconnects.

7. Unscrew the elbow from the cap. Hold the cap wrench flats to prevent the cap from turning.

8. Unscrew cap retainer from the cap. Hold the flats.

9. READ WARNINGS above. Remove the retaining ring using a pointed tool.

10. READ WARNINGS. Use the 3/16" hex key to unscrew the piston from the wedge.

11. Carefully release the pressure from the cap, piston, and spring. Remove these components from the housing.

12. Use a small-diameter rod with a dull point to remove Polyseal and O-rings from the components.


See Assembly Drawing SWITCH AND ELECTRIC CORD KIT

14. Loosen the strain relief that is holding the electric cord. Unscrew the strain relief from the switch housing.

15. Use a thin screwdriver to pry the trigger switch assembly from the housing.

16. Unscrew both socket screws attaching the wires to the switch. Pull the cord from the switch and strain relief.

17. Loosen both screws on the face of the connector; disassemble the connector. Loosen the screws and remove the wires.

See Assembly Drawing AIR TRIGGER AND HOSE ASSEMBLY

18. Loosen the large hex on the air fitting and the hex on the disconnect fitting. Remove the tubing. Unscrew the air fitting from the trigger housing assembly.

19. Unscrew the hose fitting; then unscrew the air trigger assembly.

20. Disassemble the air trigger assembly.

Store all re-usable parts (screws and disassembled components) in a clean, dry area.
Assembly and Filling Cutter

Clean all components with mineral spirits. Inspect for wear and damage; replace as necessary. **Replace all seals of disassembled components.** Use O-rings and Polyseals supplied in Spare Parts Service Kits. See applicable service kit parts list. Smear LUBRIPLATE® 130-AA (Huck P/N 502723) or SUPER-O-LUBE® (Huck P/N 505476) on rings, polyseal, and mating components to facilitate assembly. When assembling the tool, do NOT damage the O-ring or the polyseal.

**CAUTION: Remove Elastomer Spring from Polyseal prior to assembly in tool.**

**See Assembly Drawing Air Trigger and Hose Assembly**
1. Assemble air trigger assembly.
2. Screw hose fitting into housing. Screw air trigger assembly into housing. Tighten both parts.
3. Start air fitting onto hose fitting. Push tubing into fitting, then tighten fitting.
4. Push other end of tubing into disconnect fitting and tighten.

**See Assembly Drawing Switch and Electric Cord Kit**
5. With connector disassembled, push cord through top of connector. Push both wires into holes in base; tighten both retaining screws.
6. Squeeze assembled base and top together until both connecting screws are seated. Continue tightening screws until cord is firmly gripped.
7. Screw strain relief into housing and tighten.
8. Push cord through strain relief. Push each wire into an attaching hole in back of electric switch assembly and tighten both screws.
9. Lubricate the O-ring and, using arbor press, press electric switch into housing. Tighten the strain relief on the cord.
10. Position air trigger hose/electric switch cord and hose spacer in lower half of housing clamp. Put hydraulic hose in clamp near cutter end of hose. Allow extra space on hose so hose guard can be pulled back to allow access to hex hose fitting.
11. Place upper half of housing clamp over components in lower half. Join halves with two screws, lockwashers, and nuts. When properly aligned, tighten screws.
12. Hold housing in a soft-jawed vise.
13. Slide spring over piston. Push piston into housing. Hold cylinder cap against back of piston and push both into housing until retainer can be installed.
14. Screw retainer cap onto cylinder cap and tighten.
15. Apply Vibra-Tite® to piston threads. Hold wedge in position in housing. Insert 3/16” hex key through back of cap, and screw piston onto wedge. **NOTE: Apply NEVER-SEEZ® and MOLYKOTE® 106 to contact surfaces between wedge and lever.** (Figure 9)
16. Hold lever in position in housing, and push pin through housing and lever. Use TRUARC Pliers #0200 to install the retaining ring.
17. Position torsion spring in housing, and tap split pin through housing and spring.
18. Place blade in housing and use 1/8” hex key to install cap screw. **NOTE: Adjust tool lever before elbow is attached to tool. See Adjusting for Partially Swaged Collars.**
19. Screw in elbow after adjusting lever. Apply Parker Threadmate®, Loctite® 567, or Slic-Tite® to pipe threads and tighten the connection. **NOTE: Elbow can be omitted and hose installed directly into cylinder cap. This configuration provides advantages with some structural forms.**
20. Install hose assembly into elbow. Install quick disconnects.
21. To prevent air being trapped in tool, causing loss of hydraulic pressure, fill hydraulic hose and tool with hydraulic fluid before screwing hose into elbow. Use TEFLO® thread compound.
Notes and Specifications for Standard Parts

Parts that have part numbers shown are available from Huck. The 500000 series numbers are standard parts that can generally be purchased locally. O-ring sizes are specified as AS dash numbers. (AS 568- is an Aerospace size standard for O-rings and was formerly known as ARP.)

<table>
<thead>
<tr>
<th>PART NO.</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>505841</td>
<td>Polyseal Microdot 125-00.500 SQB</td>
</tr>
<tr>
<td>505865</td>
<td>Polyseal Microdot 125-00.875 SQB</td>
</tr>
<tr>
<td>504555</td>
<td>O-ring AS568-016 C9250 90D</td>
</tr>
<tr>
<td>505446</td>
<td>O-ring AS568-010 C9250 90D</td>
</tr>
<tr>
<td>500777</td>
<td>O-ring AS568-011 C366Y 70D</td>
</tr>
<tr>
<td>500773</td>
<td>O-ring AS568-007 C366Y 70D</td>
</tr>
<tr>
<td>500780</td>
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<td>O-ring AS568-111 CV747 75D</td>
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<td>505855</td>
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<tr>
<td>506478</td>
<td>Spring Lee #LC-100K-8</td>
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**Figure 10**

127252 End Cap & Swivel Assy

**Figure 11**

127270 End Cap & Swivel Assy
**5CCFT & 5CC-LGP Series**

**Figure 12**

This fitting combination is shipped with QD versions only and can be connected to Air or Hydraulic Hose Assembly. They must be ordered separately.

### Table A

<table>
<thead>
<tr>
<th>Collar Cutter Connection Type</th>
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<th>5CC-LGP</th>
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Connection Assemblies are not included with these QD Cutters.
**Table B**

<table>
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<th>Collar Cutter No.</th>
<th>Type</th>
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* Connection Assemblies are not included with these QD Cutters. They must be ordered separately.
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<table>
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<th>Type</th>
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<th>Blades</th>
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* Connection Assemblies are not included with these QD Cutters. They must be ordered separately.

This fitting combination is shipped with QD versions only and can be connected to Air or Hydraulic Hose Assembly.
**4-12 series Small Diameter Collar Cutters (HK1066)**

**8CCMFT, 8CCMFT-QD, & 8CC-MLGP Series**

Connection Assemblies are not included with these QD Cutters. They must be ordered separately.

**Table D**

<table>
<thead>
<tr>
<th>Collar Cutter No.</th>
<th>Type</th>
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</tr>
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</table>

* Connection Assemblies are not included with these QD Cutters. They must be ordered separately.
**TABLE E**

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<th>Type</th>
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<th>Blades</th>
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* Connection Assemblies are not included with these QD Cutters. They must be ordered separately.

This fitting combination is shipped with QD versions only and can be connected to Air or Hydraulic Hose Assembly.
**TABLE F**

<table>
<thead>
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* Connection Assemblies are not included with these QD Cutters. They must be ordered separately.
Table H

<table>
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<th>Type</th>
<th>Blades</th>
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<td>Hyd. or Air</td>
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</table>

*Connection Assemblies are not included with these QD Cutters. They must be ordered separately.*
Connection Assemblies are not included with these QD Cutters. They must be ordered separately.

### TABLE J

<table>
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<th>Collar Cutter No.</th>
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<th>Blades</th>
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</table>

* Connection Assemblies are not included with these QD Cutters. They must be ordered separately.
**TABLE K**

<table>
<thead>
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<th>Connection Type</th>
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<th>Blades</th>
<th>Gage Pin</th>
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<td>124324-1</td>
</tr>
</tbody>
</table>

* Connection Assemblies are not included with these QD Cutters. They must be ordered separately.

**Connection Assembly**

*Figure 20*

This fitting combination is shipped with QD versions only and can be connected to Air or Hydraulic Hose Assembly.
Stickers:
- 590273 Warning
- 590375 Caution

500989 Retaining Ring

500054 Screw (Not shown)

590245 Caution Sticker

124324-1 Lever

119525 Pin

508130 Split Pin

119783 Torsion Spring

119511 Wedge

590513 Pinch Point Sticker

508179 Spring

590272 Sticker

127270 End Cap & Swivel Assy

505841 Polyseal

506106 Elbow

505856 Spirolox Ring

120347 Hose & Switch Assembly includes:
- 120340 Clamp Assy
- 120345 Switch & Electric Cord Assy

Apply Never-Seez® Lubricating Compound (HUCK p/n 508183) to these surfaces during assembly.

Adjust gap opening between Blades and Lever by inserting a 3/16 Allen wrench through port opening in Cap. Turning wrench moves Wedge and Lever simultaneously. Adjust until a slight interference is felt on the .312 diameter of Gage.

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

Never-Seez is a registered trademark of Bostik, Inc.
**Table L**

<table>
<thead>
<tr>
<th>Collar Cutter No.</th>
<th>Connection Type</th>
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<th>Blades</th>
<th>Housing</th>
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<td>120720</td>
</tr>
</tbody>
</table>

* Connection Assemblies are not included with these QD Cutters. They must be ordered separately.
Figure 38

Switch and Electrical Cord Kit, 120245-2

If needed for replacement, the Housing must be purchased separately.

Figure 39

Air Trigger and Hose Assembly, 120346

119345 - Air Trigger Assem. Includes:
112556 - Air Trigger Body
112555 - Air Trigger Stem
500777 - O-Ring (Large)
500773 - O-Ring (Small)

112143 - Tubing
113021 - Male Disconnect

503902 - Air Fitting

120344 - Housing
119332 - Hose Fitting
500780 - O-Ring
Assembly Drawings (continued)

**Figure 40**

120345 Switch & Electric Cord Assy
122447 Switch Guard
108278 Clamp Assy includes:
- 108294 Clamp
- 500428 Screw (2)
- 500180 Lock Washer (2)
- 503141 Nut (2)

118944-1 Hydraulic Hose
503431 Reducing Bushing
110438 Coupler Nipple

**Hose and Switch Kit, 120347**

**Figure 41**

120245-2 Switch & Electric Cord Assy
120344 Housing (Not shown)
503431 Reducing Bushing (2)

108278 Clamp Assy
118944-3 Hydraulic Hose
124312 Valve Body
124313 Valve Check
107022 Spring
502727 Nipple
503431 Reducing Bushing (2)

110439 Coupler Body
110438 Coupler Nipple

**Hose and Switch Kit, 120347-25QDR**
Assembly Drawings (continued)

**Figure 42**

Hose and Switch Kit, 120347-25QDRS

Restricted hose with slave cylinder to be used with HYDRANET™ System.

**Figure 43**

Hydraulic Hoses and Air Trigger Assembly, 120348
Troubleshooting

Always check the simplest possible cause (such as a loose or disconnected trigger line) of a malfunction first. Then proceed logically, eliminating other possible causes until the cause is discovered. Where possible, substitute known good parts for suspected defective parts. Use this troubleshooting information to aid in locating and correcting trouble.

1. **Cutter fails to operate when trigger is pressed.**
   a. Inoperative Powerig® hydraulic power source. See applicable instruction manual.
   b. Loose electric connections.
   c. Damaged trigger assembly.
   d. Loose or faulty hydraulic hose couplings.

2. **Cutter blades do not cut through collar.**
   a. Reversed hydraulic hose connections between hydraulic unit and collar cutter.

3. **Cutter leaks hydraulic fluid.**
   a. Defective seals or loose hose connections at tool.

4. **Hydraulic couplers leak fluid.**
   a. Damaged or worn O-rings in coupler body. See illustration.

5. **Hydraulic fluid overheats.**
   a. Powerig not operating properly; see unit’s manual.

6. **Cutter operates erratically and fails to quickly cut collar.**
   a. Low or erratic hydraulic pressure supply; air in system.
   b. Damaged or worn piston Polyseal in cutter.
   c. Excessive wear on sliding surfaces of tool parts.
   d. Excessive wear of blades or damage.

7. **Cutter blades fail to open when trigger is released.**
   a. Return spring is weak or broken.

Service Notes

Use this space to record any references you may need.
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 Powerigs® manufactured after 12/1/2016 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.
Arconic Inc. (NYSE: ARNC) creates breakthrough products that shape industries. Working in close partnership with our customers, we solve complex engineering challenges to transform the way we fly, drive, build and power.

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.

---

**Arconic Fastening Systems and Rings world-wide locations:**

### AMERICAS

<table>
<thead>
<tr>
<th>Location</th>
<th>Address</th>
<th>Phone Numbers</th>
<th>Fax Numbers</th>
</tr>
</thead>
<tbody>
<tr>
<td>Kingston Operations</td>
<td>1 Corporate Drive, Kingston, NY 12401</td>
<td>800-278-4825, 845-331-7300</td>
<td>845-334-7333</td>
</tr>
<tr>
<td>Carson Operations</td>
<td>900 Watson Center Rd, Carson, CA 90745</td>
<td>800-421-1459, 310-830-8200</td>
<td>310-830-1436</td>
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<td>Waco Operations</td>
<td>PO Box 8117, Waco, TX 76714-8117</td>
<td>800-388-4825, 254-776-2000</td>
<td>254-751-5259</td>
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### EUROPE

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<td>Telford Operations</td>
<td>Unit C, Stafford Park 7, Telford, Shropshire</td>
<td>01952-290011</td>
<td>0952-290459</td>
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### FAR EAST

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<td>Melbourne Operations</td>
<td>11508 Centre Road, Clayton, Victoria, Australia 3168</td>
<td>03-764-5500</td>
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