Instruction Manual
ERT1S  ERT2S  ERT3S  ERT4S
Ebbert Engineering® Riveting Tools

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HK1038
**Safety Instructions**

**GLOSSARY OF TERMS AND SYMBOLS:**
- **ce** - Product complies with requirements set forth by the relevant European directives.
- **Book** - Read manual prior to using this equipment.
- **Helmet** - Eye protection is required while using this equipment.
- **Hearing** - Hearing protection is required while using this equipment.

Notes: are reminders of required procedures.

Bold, Italics, and underline: emphasize a specific instruction.

**WARNINGS: Must be understood to avoid severe personal injury.**

**CAUTIONS: Show conditions that will damage equipment or structure.**

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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.

III. OPERATING 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.

Continued on next page...
Safety Instructions (continued)

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:

![Safety Instructions](image)

**WARNINGS:**
Do not exceed maximum pull or return settings on tool.
Be sure all hose connections are tight. All tool hoses must be connected.

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.
General Information

This manual contains operating and service procedures for the Ebbert Rivet Tool models ERT1S, ERT2S, ERT3S, ERT4S, and their optional tool configurations. It is suggested that close attention be directed to the recommended service procedures in this manual.

Specific instructions for each tool are given under that tool model number heading. While they may appear to be similar, each tool contains parts not used on other models, and removal and replacement methods may vary.

Principal of Operation

Incoming non-oiled plant air is regulated at 90psi through the Air Filter/Regulator to the Four-way Valve on the Power Unit and through the Red Air Line to the valve in the rivet tool handle.

When the tool trigger is pulled, a trigger/plunger unseats a valve ball and directs air from the tool handle back through the Green Air Line to the Four-way Valve. The Four-way Valve is shifted, directing air pressure through the Blue Air Line into the Power Booster. As the Power Booster air piston advances, hydraulic fluid is forced through the black Hydraulic Line into the tool, forcing the tool to retract. This delivers the necessary force to install the fastener and break the pintail. (In the EPS1V, the pintail then travels through the pintail collection tube from the tool into the Pintail Collection Box.)

When the trigger is released, the Four-way Valve shifts to its default position; air pressure returns the Power Booster air piston to the full-back position and the tool piston to the full-forward position. The cycle is complete.
ERT_S series Ebbert Rivet Tools (HK1038)

Specifications

**ERT1S**

**WEIGHT:** 3 lbs. (1.36 kg)

**STROKE:** 0.75 in (19.05 mm)

**RATED PULL FORCE:** 1,992 lbs.

**FASTENER SIZES:** 3/32” through 3/16”

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**ERT2S**

**WEIGHT:** 3.25 lbs. (1.47 kg)

**STROKE:** 0.9375 in (23.81 mm)

**RATED PULL FORCE:** 4,330 lbs.

**FASTENER SIZES:** 1/8” through 1/4”
**ERT3S**

- **WEIGHT**: 3.5 lbs. (1.58 kg)
- **STROKE**: 0.75 in (19.05 mm)
- **RATED PULL FORCE**: 1,992 lbs.
- **FASTENER SIZES**: 3/32” through 3/16”

**ERT4S**

- **WEIGHT**: 3.5 lbs. (1.58 kg)
- **STROKE**: 0.9375 in (23.81 mm)
- **RATED PULL FORCE**: 4,330 lbs.
- **FASTENER SIZES**: 1/8” through 1/4”
Disassembly ERT1S & ERT2S

This procedure is for the complete disassembly of the ERT1S & ERT2S tools. For component identification, see Figure 2.

1. Unscrew two socket head screws (ERT1S) or four screws (ERT2S) that secure piston rod guide to the front of the tool, and remove piston rod guide.
2. Loosen hose clamp/sleeve at rear of tool, and pull it back far enough to allow clearance for removal of end cap. From rear of tool, remove two socket head screws (ERT1S) or four screws (ERT2S) and support loop assembly.
3. Push piston toward rear of cylinder to remove end cap/guide tube assembly, piston, and piston forward stop.
4. Remove remaining seal from front of cylinder.
5. The cylinder is now stripped of parts except retaining ring. For typical tool service, it is not necessary to remove this retaining ring. If it is removed, when replacing it, relocate retaining ring ears at bottom of cylinder, allowing clearance for hydraulic inlet port.
6. ERT1S: Remove retaining ring and all seals from piston, and piston rod wiper from piston rod guide. ERT2S: Remove retaining ring, front seal retainer and all seals from piston, and O-ring, Back-up ring, seal, and piston rod wiper from piston rod guide. NOTE: When servicing the tool to this extent, the piston rod wiper must be replaced.
7. Remove the O-ring from the end cap.
8. Clean disassembled parts in cleaning solution. While cleaning the piston, ensure that the small hole in the "V" groove is open.

Assembly ERT1S & ERT2S

This procedure is for the re-assembly of the ERT1S & ERT2S tools.

1. When replacing seals, make sure they are correctly positioned as shown on the Tool Schematic. Wipe all seals with a thin film of seal lubricant before reassembly.
2. It is important to inspect the cylinder wall to ensure surface is free of gouges and nicks that will damage a new seal. Small nicks and gouges can be removed using a fine crocus cloth.
3. After all seals, O-rings and Back-up rings are replaced:

   ERT1S: With piston forward stop placed on the piston shaft, insert end cap assembly into piston, then slide the complete assembly into tool cylinder.
   ERT2S: Insert end cap assembly into piston, then slide the complete assembly into tool cylinder.
   NOTE: Use caution when inserting this assembly into cylinder to keep piston from cocking in cylinder and nicking cylinder wall. This could ultimately cause a seal edge to be cut.
   Secure end cap and support loop assembly with two screws (ERT1S) or four screws (ERT2S).
Assembly ERT1S & ERT2S (continued)

4. Reposition tool in vise with open front of cylinder pointing straight up. Use option “a” or “b” to fill tool with hydraulic fluid:
   a) Gravity fill: Connect hydraulic line to power unit and allow hydraulic fluid to flow from the higher positioned reservoir into tool cylinder until it is level with the front retaining ring; then disconnect hydraulic line for installation of remaining components.
   b) Optional fill: Using Model 300509 Bleed Pump Assembly, pump from hydraulic connector through the line; filling the tool in the same manner and to the same level as above.

5. ERT2S: Replace front seal retainer by positioning the cut-out section so it will clear the two ears of retaining ring when it is dropped into place. If retainer does not lay flat, tap it gently with a screwdriver until it assumes a flat position.

6. Slide the hydraulic seal down over piston threads and wrench flats carefully to prevent nicking seal edges.

7. ERT1S: Insert piston rod guide and wiper assembly, pushing the hydraulic seal down into cylinder. Secure piston rod guide with two screws. Torque screws at both ends of the tool to 12–15 ft-lbs.

ERT2S: It is not necessary to push the seal all the way into cylinder. It will assume its position in the piston rod guide when the guide is next installed and secured with two bearing plates and four screws. Torque screws at both ends of tool to 74-81 in-lbs.

This method of refilling the tool with hydraulic fluid relieves any further requirement for bleeding air. The tool can now be connected to power unit and be test-cycled. The pulling head assembly can now be installed.

Disassembly ERT3S & ERT4S

This procedure is for the complete disassembly of the ERT3S & ERT4S tools. For component identification, see Figure 3.

1. Remove the handle from the front of the tool.
2. Loosen the hose clamp/sleeve at the rear of the tool, and pull it back far enough to allow clearance for the removal of the end cap.
3. After removing support loop assembly, piston and end cap can be removed by pushing back on front of the piston for removal through back of the tool.
4. Remove O-ring from end cap.
5. The front seal retainer must be removed from the front of the tool. This retainer is a snug fit and requires a soft hammer blow to the end of a brass dowel held against the seal retainer.
6. The cylinder is now stripped of parts except the retaining ring. For typical tool service, it is not necessary to remove this retaining ring. If it is removed, when replacing it, relocate retaining ring ears at the bottom of the cylinder, allowing clearance for the hydraulic inlet port.
7. ERT3S: Remove retaining ring, piston forward stop, and all seals from the piston.

ERT4S: Remove retaining ring, piston seal retainer and all seals from the piston, and O-ring, Back-up ring, and hydraulic seal from the front seal retainer.

NOTE: When servicing the tool to this extent, the piston rod wiper must be replaced.

8. Clean disassembled parts in cleaning solution. While cleaning the piston, ensure that the small hole in the “V” groove is open.
Assembly ERT3S & ERT4S

This procedure is for reassembly of ERT3S & ERT4S.

1. When replacing seals, make sure they are correctly positioned as shown on the Tool Schematic. Wipe all seals with a thin film of seal lubricant before reassembly.

2. It is important to inspect the cylinder wall to ensure the surface is free of gouges and nicks that will damage a new seal. Small nicks and gouges can normally be removed using a fine crocus cloth.

3. After all seals, O-rings and Back-up rings are replaced, insert end cap assembly into piston, and insert as a combination into the tool cylinder. NOTE: Use caution when inserting this assembly into cylinder. Keep the piston from cocking in the cylinder and nicking the cylinder wall. This could ultimately cause a seal edge to be cut. Secure the end cap and support loop assembly with four screws.

4. Reposition the tool in the vise with the open front of the cylinder pointing straight up. Use Option “a” or “b” for filling the tool with hydraulic fluid:

   a) Gravity fill: Connect the hydraulic line to the power unit and allow hydraulic fluid to flow from the higher positioned reservoir into the tool cylinder until it is level with the front retaining ring, then disconnect the hydraulic line for installation of remaining components.

   b) Optional fill: Using the Model 300509 Bleed Pump Assembly, pump from the hydraulic connector through the line, filling the tool in the same manner and to the same level as above.

5. ERT3S: Slide the front seal retainer down, using care to get it positioned straight in the cylinder. The retainer does not easily slide into the cylinder; it will be drawn into place later when the handle is secured. ERT4S: Making sure the cut-out section will clear the ears of the retaining ring, slide front seal retainer down, using care to get it positioned straight in the cylinder. The retainer does not easily slide into the cylinder; it will be drawn into place later when the handle is secured.

6. Slide hydraulic seal down over piston threads and wrench flats carefully to prevent nicking seal edges, and position in cylinder (ERT3S) or front seal retainer (ERT4S). Positioning this seal requires some effort to work it in. Start it down on one side and slowly work it in until the last small area may be assisted by using the flat side of a common screwdriver.

7. Install handle and piston rod wiper down over piston and into contact with front seal (ERT3S) or front seal retainer (ERT4S). While doing this, hold trigger in position to allow it to drop behind lock-in pin. Install four screws with bearing plates with equal pressure to draw handle (and seal retainer - ERT4S) into position in cylinder. Torque screws at both ends of the tool to 74-81 in-lbs.

8. Air-bleed tool if necessary and connect to the power unit for test cycle. The pulling head assembly can now be installed.
Rivet Tool Handle Function

The rivet tool handle contains the air valve mechanism which, when actuated, initiates the rivet station cycle. Figure 4A shows the valve components in the “at rest” position. The steel ball is sealing air pressure within the red air line chamber.

Figure 4B shows how the double Quad-rings function to seal the forward section of the chamber when the trigger is pressed, directing air pressure through the green air line back to the Four-way Valve.

After prolonged use, the Quad-rings will wear down resulting in a poor seal when the trigger is actuated. This can slow down the cycle time of the tool due to the rivet tool operator holding the trigger in a tighter position when setting the rivet. It is easy to remedy the problem. Remove the trigger pin, trigger, and valve plunger for Quad-ring replacement.

On models ERT1S and ERT2S, the handle is adjustable through a 20-degree arc. This patented design allows relief to the wrist when work heights are high or low to the operator’s normal body position.

Each tool is provided with a 5/32” hex ball driver for the handle adjustment. By loosening the socket head screw located inside the handle, the handle can be moved into the desired position and locked into that location with the hex ball driver.

In some operations requiring excessive loads on the handle, it is suggested that the clamp block be reversed, placing the flat surface into contact with the handle for higher locking force.

NOTE: Make sure the trigger is square to the handle slot and moves freely after tightening the clamp block.

Air Bleeding Instructions

1. Disconnect the rivet tool air-line from the Power Unit.
2. Attach Bleed Pump 300509 to the hydraulic hose on the rivet tool.
3. Remove the bleed screw from the tool.
4. Pump the bleed pump until no more bubbles appear out of the bleed port of the tool.
### Components Drawing ERT1S

**Notes:**

1. Torque end Screws to 12-15 ft-lbs (4 places).

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<th>Part No.</th>
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**Item Breakdown:**

- **1.** Torque end Screws to 12-15 ft-lbs (4 places).
Components Drawing ERT2S

**Notes:**
- Torque end Screws to 74-81 in./lbs (8 places).
- Item Part No. Description Qty. Item Part No. Description Qty.

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ERT2S_revK
### Notes:

1. When tool is used without hanger, two screw bearing plates, part no. 300064, are required in this location.
2. Piston assembly bullet, part no. 300072, is optionally available.
3. Service parts kit, part no. 300467, is optionally available.
4. Torque end screws to 74-81 in./lbs. (8 places)

### Components Drawing ERT3S

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## Components Drawing ERT4S

### Notes:
1. When tool is used without hanger, two screw bearing plates, part no. 300064, are required in this location.
2. Piston assembly kit, part no. 300466, is optionally available.
3. Service parts kit, part no. 300466, is optionally available.

### Figure 8

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</table>

### Item List:
- When tool is used without hanger, two screw bearing plates, part no. 300064, are required in this location.
- Piston assembly kit, part no. 300466, is optionally available.
- Service parts kit, part no. 300466, is optionally available.
Optional Tool Configurations

Figures 9–13 show the five optional ERT1S and ERT2S configurations that are available from Huck. Based on the application needed, the optional-configuration tools may ship:

- Without Handle (L series)
- Without Handle but with "Energized" Seals (LE series)
  NOTE: Energized Seals keep the hydraulic seal tighter when the tool is under no load. See KITS & ACCESSORIES.
- Without Handle but with Tool Head Assembly mounted on a Manifold Base (MQ series)
  NOTE: The Manifold Base allows the tool to be directly mounted to an assembly machine. This series also includes a Quick Disconnect for rapid tool removal and replacement.

Figure 9

![ERT1SL](ERT1SL_revF)

Notes:

1. Torque end Screws to 12-15 ft/lbs (4 places).

Figure 10

![ERT2SL](ERT2SL_revK)

Notes:

1. Torque end Screws to 74-81 in./lbs (8 places).

ERT1SL
Refer to ERT1S Parts List (Figure 5)

ERT2SL
Refer to ERT2S Parts List (Figure 6)
Optional Tool Configurations (continued)

**ERT2SLE**
Refer to ERT2S Parts List (Figure 6)

**ERT1SMQ**
Refer to ERT1S Parts List (Figure 5)
### Optional Tool Configurations (continued)

**Figure 13**

**Notes:**
- Torque end Screws to 74-81 in./lbs (8 places).

**ERT2SMQ**

Refer to ERT2S Parts List (Figure 6)

### Kits & Accessories

**SERVICE KITS**
- Energized Seal Service Kit (for ERT2SLE) - 300473
- Service Kit ERT1S, 1SL, 1SMQ - 300467
  *(also fits ERT3S)*
- Service Kit ERT2S, 2SL, 2SMQ - 300466
  *(also fits ERT4S)*

**ACCESSORIES**
- Piston Assembly Bullet - 300072
- Filler / Bleed Pump Assembly - 300509

### Troubleshooting

Always check the simplest possible cause (such as a disconnected air hose) 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. **Slow tool cycle.**
   a. Check air pressure and hydraulic pressure. Reference Principle of Operation schematic on page 5 of this manual.
   b. Incoming air-line must be 3/8” ID minimum. If longer that 20’, air-line should increase to 1/2” ID.

2. **Tool will not pull rivet.**
   a. Air in hydraulic system; requires bleeding. NOTE: Air entrapment is identifiable by sound. As trigger is actuated, the normal “thud” produced by the power unit is replaced by a metallic “clack”.
   To bleed rivet tool, fill the reservoir, and:
   1. Unhook RED air-line from power unit.
   2. Lay tool in pan and remove bleed screw.
   3. Allow fluid to flow until it is free of bubbles.
   If condition persists, replace the seals.
   b. 1. Unhook RED air-line from power unit.
   2. Attach Filler / Bleed Pump Assembly to tool hydraulic hose.
   3. Remove bleed screw on Rivet Tool.
   4. Pump the Bleed Pump until bubbles quit coming out of the bleed port on the tool.
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 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.

<table>
<thead>
<tr>
<th>Eastern</th>
<th>One Corporate Drive Kingston, New York 12401-0250 Telephone (845) 331-7300 FAX (845) 334-7333</th>
</tr>
</thead>
<tbody>
<tr>
<td>Outside USA and Canada</td>
<td>Contact your nearest Huck International location (see reverse).</td>
</tr>
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</table>

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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FAX: 310-830-1436

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