EC Declaration of Conformity

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

Description of Machinery:
Models BTT25, 35, 57 families of hydraulic installation tools and specials based on their design (e.g. PR####).  

Relevant provisions complied with:
British Standard related to hand held, non-electric power tools (ISO 11148-1:2011)

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)

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Declared dual number noise emission values in accordance with ISO 4871

A weighted sound power level, LWA: 79 dB (reference 1 pW) Uncertainty, KWA: 3 dB
A weighted emission sound pressure level at the work station, LpA: 68 dB (reference 20 μPa) Uncertainty, KpA: 3 dB
C-weighted peak emission sound pressure level, LpC, peak: 96 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.

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Declared vibration emission values in accordance with EN 12096

Measured Vibrations emission value, a: 0.32 m/s²
Uncertainty, K: 0.06 m/s²

Values measured and determined according to ISO 28662-1, ISO 5349-2, and EN 1033

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Test data to support the above information is on file at:
Arconic Fastening Systems and Rings, Kingston Operations, Kingston, NY, USA.
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This instruction manual must be read, with particular attention to the following safety guidelines, by any person servicing or operating this tool.

1. Safety Glossary
   - Product complies with requirements set forth by the relevant European directives.
   - Read manual prior to using equipment.
   - Eye protection required while using this equipment.
   - Hearing protection required while using this equipment.

2. A half hour long hands-on training session with qualified personnel is recommended before using Huck equipment.

3. Huck equipment must be maintained in a safe working condition at all times. Tools and hoses should be inspected on a regular basis for damage or wear. Any repair should be done by a qualified repairman trained on Huck procedures.

4. Repairman and Operator must read manual prior to using equipment. Warning and Caution stickers/labels supplied with equipment must be understood before connecting equipment to any primary power supply. As applicable, each of the sections in this manual have specific safety and other information.

5. Read MSDS Specifications before servicing the tool. MSDS Specifications are available from the product manufacturer or your Huck representative or is included with your tool.

6. When repairing or operating Huck installation equipment, always wear approved eye protection. Where applicable, refer to ANSI Z87.1 - 2003

7. Disconnect primary power source before doing maintenance on Huck equipment.

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

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

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

11. Never remove any safety guards or pintail deflectors.

12. Never install a fastener in free air. Personal injury from fastener ejection may occur.

13. When using an offset nose, always clear spent pintail out of nose assembly before installing the next fastener.

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

15. Do not abuse tool by dropping or using it as a hammer. Never use hydraulic or air lines as a handle or to bend or pry the tool. Reasonable care of installation tools by operators is an important factor in maintaining tool efficiency, eliminating downtime, and in preventing an accident which may cause severe personal injury.


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

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

Operating Temperature Range: 32-125°F (0-51.7°C)

The operator pushes the Tool’s Nose over the end of the fastener until the Tool’s Puller bottoms on the fastener. When the Tool’s Limit Switch Rod makes contact with the end of the fastener, the Limit Switch in the back of the Tool is activated. This sends an input signal to the tool control. When the operator presses the Trigger on the Tool an input is sent to the tool control. When both conditions are met, the tool control will turn on the hydraulic pump, PULL pressure, for fastener installation. The Piston moves back to start the swaging process.

A Pressure Transmitter on the Relief Valve assembly sends a signal to the control to indicate the "pressure set point" has been reached and the "hold timer" can start. The "hold timer" will keep the hydraulic pump, PULL pressure, on until the timer times out. An external Relief Valve will control the amount of pull pressure that can be reached.

After the "hold timer" times out, the hydraulic pump shifts to RETURN pressure and the Tool’s Anvil is ejected off of the:

<table>
<thead>
<tr>
<th>PROGRAM CYCLE</th>
</tr>
</thead>
<tbody>
<tr>
<td>Start</td>
</tr>
<tr>
<td></td>
</tr>
<tr>
<td></td>
</tr>
<tr>
<td></td>
</tr>
<tr>
<td>Cycle Does Not Start</td>
</tr>
<tr>
<td></td>
</tr>
<tr>
<td></td>
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<tr>
<td></td>
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<td></td>
</tr>
</tbody>
</table>

NOTES:
- Trigger is the go signal.
- If trigger is released, cycle back out.
- Limit switch may be made before trigger is pulled and cycle will start.
- Limit switch must be made for .1 seconds after cycle starts; then program no longer looks for limit switch during cycle.
- If hydraulic cycle is started/proceeding when trigger is released, the combination valve is de-energized (released output), then continue to back out of cycle. (The Pressure-Not-Reached light will turn on.)
- Exception: If hydraulic pressure set point is reached and TD-2 is timed out, the operation may re-activate trigger and the program will finish normally.

<table>
<thead>
<tr>
<th>Timer Ranges</th>
</tr>
</thead>
<tbody>
<tr>
<td>TD-1: 10 sec</td>
</tr>
<tr>
<td>TD-2: Adjustable 0-3 sec</td>
</tr>
<tr>
<td>TD-3: Adjustable .25-3.75</td>
</tr>
<tr>
<td>TD-4: 1 sec</td>
</tr>
<tr>
<td>TD-5: 1/2 sec</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Timer Uses</th>
</tr>
</thead>
<tbody>
<tr>
<td>TD-1: Stop hydraulics from staying on too long in case a hydraulic leak occurs</td>
</tr>
<tr>
<td>TD-2: Time to hold hydraulics after pressure is met</td>
</tr>
<tr>
<td>TD-3: Time to eject or release hydraulics</td>
</tr>
</tbody>
</table>

Operating Instructions:

1. Push the tool's nose over the end of the fastener until it bottoms out.
2. Press the trigger and hold until the collar is swaged and the tool's Anvil is ejected off the collar and the tool is released from the fas-
**Optional Equipment**

To maintain CE conformity, only CE compatible equipment should be used with these tools. Installation tools and nose assemblies are the only CE components unless otherwise noted. Controls and other hardware shown in the manual are for domestic use only.

Service Kit - BTT57KIT
Teflon Stick - 503237
Loctite* 242 - 505016
Anti-seize Lubricant - 508183
CE Compatible Pump/Controller - HK432BT
Hose Cable Extension Assy - 128461-(length)
Test Plates:
- 12mm Small: 128484
- 12mm Large: 128483
- 14mm Small: 128467
- 14mm Large: 128466
- 16mm Small: 128465
- 16mm Large: 128464
- 20mm Small: 128486
- 20mm Large: 128485

Load Cell Assembly - 128433
(Shown Below)

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**Specifications BTT57**

**BTT57 Tool Assembly**

INCHES

- Stroke: 2.2 in
- Weight: 20.5 lbs.
99-7852 Nose Assembly

20mm

**Figure 2**

- **128768** Anvil Assy
- **128769** Anvil Holder
- **501736** Setscrew (Qty. 1)
- **501920** Setscrew (Qty. 3)
- Apply Anti-seize Lubricant P/N 508183 to Outside of Puller and inside of Anvil
- Apply Loctite 242 P/N 505016 to these threaded joints

Apply Vibra-lite P/N 505125 to Setscrew threads per manufacturer's instructions.
GOOD SERVICE PRACTICES
CAUTION: Keep dirt and other harmful material out of hydraulic system, which includes tool, hoses, couplers and POWERIG Hydraulic Unit. Parts must be kept away from unclean work surfaces. Dirt in hydraulic system causes valve failure in hydraulic unit.

Individual parts must be handled carefully and examined for damage or wear. Replace parts where required. Always replace O-rings and Back-up Rings when tool is disassembled for any reason.

WARNING: Inspect tool for damage or wear before each use. Do not operate if damaged or worn, as severe personal injury may occur.

The efficiency and life of your tool depends on proper maintenance. Using the manual will help give a clear understanding of the tool and basic maintenance procedures. Please read this section completely before proceeding with maintenance and repair. Use proper hand tools in a clean and well-lighted area. Only standard hand tools are required in most cases. Where a special tool is required, the description and part number are given.

While clamping tool or parts in a vise, and when parts require force, use suitable soft materials to cushion impact. For example, using a half-inch brass drift, wood block and vise with soft jaws greatly reduces possibility of damaging tool. Remove components in a straight line without bending, cocking or undue force. Reassemble tool with the same care.

Consult Troubleshooting section of this manual if a malfunction occurs and then see appropriate assembly and/or component illustration sections.

Sealants, Lubricants, Hydraulic Fluid & Service Kits
• Use automatic transmission fluid DEXRON® III or equivalent. Fire resistant hydraulic fluid must be used to comply with OSHA regulation 1926.302 paragraph (d). An optional fire resistant fluid that may be used is Quintolubric® 822-220. Fluid viscosity 300 SUS @ 100°F and 50 SUS at 210°F is recommended for ambient temperatures 0° to 130° F.

• Rub Slic-Tite® with PTFE thread compound, or equivalent, on pipe plug threads and quick connect fitting. CAUTION: Do not use TEFLOW® 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 502723.)

• Smear LUBRIPLATE® 130AAA®, or equivalent lubricant, on O-Rings and mating surfaces to aid assembly and to prevent damage to O-Rings. (LUBRIPLATE 130-AA is available in a tube as Huck P/N 502723.)

• Each Service Kit contains perishable parts for your specific tool. As foreseeable use may indicate, keep extra kits (O-rings, Back-up Rings, other standard items) and tool parts in stock. When stock is depleted, you can get kit items from any regular retailer of these items. See kit parts list for: O-ring size (AS568- number); material; durometer. For kit parts lists and related information, see General Notes.

* DEXRON is a registered trademark of General Motors Corporation. Quintolubric is a registered trademark of Quaker Chemical Corp. Slic-Tite is a registered trademark of LA-CO Industries, Inc. TEFLOW is a registered trademark of DuPont Corp. LUBRIPLATE is a registered trademark of Fiske Brothers Refining Co.

PREVENTIVE MAINTENANCE
System Inspection
Operating efficiency of the tool is directly related to the performance of the complete system, including the tool with nose assembly, hydraulic hoses, trigger switch and control cord, and POWERIG Hydraulic Unit. Therefore, an effective preventive maintenance program includes scheduled inspections of the system to detect and correct minor troubles. At the beginning of each shift/day:

• Inspect tool and nose assembly for external damage.

• Verify that hydraulic hose fittings, couplings, and electrical connections are secure.

• Inspect hydraulic hoses for damage and deterioration. Do not use hoses to carry tool. Replace hoses if damaged.

• Observe tool, hoses, and hydraulic unit during operation to detect abnormal heating, leaks, or vibration.

• Max contamination level: NAS 1638 class 9, or ISO CODE 18/15, or SAE level 6.

POWERIG Hydraulic Unit Maintenance
Refer to the applicable POWERIG instruction manual.

Tool Maintenance
Whenever disassembled and also at regular intervals (depending on severity and length of use), replace all seals, wipers, and back-up rings in tool. Service Kits, hoses, and extra parts should be kept in stock. Inspect cylinder bore, pistons, and piston rods for scored surfaces and excessive wear or damage. Replace as necessary. Always replace seals, wipers, and back-up rings, and always grease gears whenever the tool is disassembled for any reason.

Nose Assembly Maintenance
Clean nose assembly often. Dip in mineral spirits or similar solvent to clean puller and wash away metal chips and debris. At regular intervals, as experience shows, disassemble nose and use a sharp “pick” to remove imbedded particles from grooves of puller.
1. With the Nose Assembly in place on the Installation Tool, begin setup. First connect the Hydraulic Hoses to the Powerig.

2. Connect the Relief Valve to the other end of the Powerig Hydraulic Hoses.

3. Connect 125926 Hose Assy to the Transducer (PULL pressure) and Relief Valve (RETURN pressure).

4. Connect 118308 Cord Assy from the Controller to the Powerig labeled TOOL 1.

5. Connect 128457 Cable Assy from the Controller to the Transducer.

6. Connect the 125926 Hose Assy to the installation tool.

7. Connect the 128418 Cord Assy to the installation tool.

8. a. Connect the other end of 128418 Cord Assy to the Controller at TOOL 1.
     b. Connect optional 128461-* Hose/Cable Assy.

9. Connect the electrical plug from the Controller to a 120 VAC 15amp power.

continued

**WARNING:** To prevent tripping hazard, suspend tools and route hoses off of floors.

**WARNING:** Only use compatible equipment with this tool.

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* Two digit number after dash indicates hose length in feet. (Example: 118308-12 is 12 foot hose assembly.)
8. Set Pull and Return pressures on Powerig using Huck Gage P/N: T-124833CE and Table 1.

9. Using a load cell (see PHOTO-A) or a skidmore, and a test fastener in the tool, energize the Powerig using a trigger switch. Adjust the Relief Valve (see PHOTO - B) so the tool generates 31,000-32,000 lbs. force. This is a direct force reading, not pressure. It equals approximately 4,650 psi Powerig pressure. **NOTE: It is important to Release the Trigger while adjusting pressure, then re-energizing to re-check pressure. Otherwise, the reading on the pressure display may be incorrect.** When the desired pressure is achieved, reconnect the Controller Cord.

10. Tool #2 and Tool #3 - Set up the same way as Tool 1.

11. Once the system is set up, Install test fastener. Check to be sure that the fastener is installed correctly. This can be checked by inspecting the dimples on the collar flange. At least one dimple should be marked by the anvil. If not, add time to Timer #2 (Hold Timer) in the Controller box, and test with fasteners until the proper installation is achieved. See “Set Point Adjustments” in CONTROLLER section of this manual to adjust timer.

<table>
<thead>
<tr>
<th>Fastener Size</th>
<th>Tool</th>
<th>Powerig PULL Pressure Setting, psi</th>
<th>Powerig RETURN Pressure Setting, psi</th>
<th>Controller Pressure Setting, psi</th>
</tr>
</thead>
<tbody>
<tr>
<td>20mm</td>
<td>BTT25</td>
<td>7500 min.</td>
<td>6500</td>
<td>4200</td>
</tr>
</tbody>
</table>

**Wrenching-up of Pipe Threads**

The following table pertains to 1/8, 1/4, and 3/8 NPTF joints in this product. All turn counts listed are beyond hand-tight. Teflon stick or equivalent (NOT tape) must be used without exception.

<table>
<thead>
<tr>
<th>Pipe Thread Size</th>
<th>Number of Turns</th>
</tr>
</thead>
<tbody>
<tr>
<td>1/8 NPTF</td>
<td>2 - 2 1/4</td>
</tr>
<tr>
<td>1/4 NPTF</td>
<td>1 1/2 - 1 3/4</td>
</tr>
<tr>
<td>3/8 NPTF</td>
<td>1 1/2 - 1 3/4</td>
</tr>
</tbody>
</table>
SET POINT ADJUSTMENTS

The active set points are displayed continuously while the Controller is in RUN mode. Stopping the Controller (which also stops Tool sequencing) allows the user to enter the Controller menu to make adjustments. **Do not begin this procedure if any of the Tools are still in use.**

1. Move the 3-Position Mode Switch on the PLC to “STOP” (right-most position).

2. Press the **MENU** Command Button to enter the “Monitor” menu.

3. Press the **ENT** Command Button to select “Data Monitor”. Press **ENT** again to select “V” data type.

4. Enter the address button of the value you need to alter. Use the left (◄) and right (►) buttons to position the cursor. Use the up (▲) and down (▼) buttons to change individual digits. Press the **ENT** Command Button when finished.

5. Press the **ENT** Command Button to enter the “Change” menu.

6. Use the arrow buttons again to enter the new value. Press **ENT** when finished.

7. Press the **ESC** Command Button 5 times to exit.

8. Move the Mode Switch back to “RUN” (left-most position).

9. Check the continuously scrolling display for your new value before using the Tool again.

<table>
<thead>
<tr>
<th>ADDRESS</th>
<th>DESCRIPTION</th>
<th>RANGE</th>
<th>DEFAULT</th>
<th>UNITS</th>
</tr>
</thead>
<tbody>
<tr>
<td>07411</td>
<td>T1 Press. SetPt</td>
<td>1000-9999</td>
<td>4200</td>
<td>psi</td>
</tr>
<tr>
<td>07412</td>
<td>T2 Press. SetPt</td>
<td>1000-9999</td>
<td>4200</td>
<td>psi</td>
</tr>
<tr>
<td>07413</td>
<td>T3 Press. SetPt</td>
<td>1000-9999</td>
<td>4200</td>
<td>psi</td>
</tr>
<tr>
<td>07421</td>
<td>T1 Hold Timer</td>
<td>0-3000</td>
<td>500</td>
<td>msec</td>
</tr>
<tr>
<td>07422</td>
<td>T2 Hold Timer</td>
<td>0-3000</td>
<td>500</td>
<td>msec</td>
</tr>
<tr>
<td>07423</td>
<td>T3 Hold Timer</td>
<td>0-3000</td>
<td>500</td>
<td>msec</td>
</tr>
<tr>
<td>07431</td>
<td>T1 Eject Timer</td>
<td>250-3750</td>
<td>600</td>
<td>msec</td>
</tr>
<tr>
<td>07432</td>
<td>T2 Eject Timer</td>
<td>250-3750</td>
<td>600</td>
<td>msec</td>
</tr>
<tr>
<td>07433</td>
<td>T3 Eject Timer</td>
<td>250-3750</td>
<td>600</td>
<td>msec</td>
</tr>
</tbody>
</table>
Figure 6

BTT57 Tool Assembly
Refer to Parts List for individual part numbers.
Figure 8.1 - 128784 Trigger & Terminal Box Assembly
Refer to Parts List for individual part numbers.

Figure 8.2 - 128745 Limit Switch Housing Assembly
Refer to Parts List for individual part numbers.

* Loctite is a trademark of Henkel Corporation, U.S.A.
# BTT57 Tool Assembly Parts List

Refer to Figures 6, 7, and 8 on the following pages for Tool Assembly Item numbers.

<table>
<thead>
<tr>
<th>Item</th>
<th>Description</th>
<th>Part Number</th>
<th>Qty.</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Main Housing Assembly contains:</td>
<td>128716</td>
<td>1</td>
</tr>
<tr>
<td>1a</td>
<td>Main Housing</td>
<td>128726</td>
<td>1</td>
</tr>
<tr>
<td>1b</td>
<td>Lockscrew</td>
<td>121343-57</td>
<td>1</td>
</tr>
<tr>
<td>1c</td>
<td>O-Ring</td>
<td>506079</td>
<td>1</td>
</tr>
<tr>
<td>1d</td>
<td>Back-up Ring</td>
<td>501144</td>
<td>2</td>
</tr>
<tr>
<td>2</td>
<td>Piston Assembly contains:</td>
<td>128717</td>
<td>1</td>
</tr>
<tr>
<td>2a</td>
<td>Piston</td>
<td>128727</td>
<td>1</td>
</tr>
<tr>
<td>2b</td>
<td>Pipe Plug</td>
<td>503703</td>
<td>2</td>
</tr>
<tr>
<td>2c</td>
<td>Back-up Ring</td>
<td>502855</td>
<td>2</td>
</tr>
<tr>
<td>2d</td>
<td>O-Ring</td>
<td>506085</td>
<td>1</td>
</tr>
<tr>
<td>3</td>
<td>Rear Piston Assy contains:</td>
<td>128718</td>
<td>1</td>
</tr>
<tr>
<td>3a</td>
<td>Rear Piston</td>
<td>128726</td>
<td>1</td>
</tr>
<tr>
<td>3b</td>
<td>Polyseal</td>
<td>505919</td>
<td>1</td>
</tr>
<tr>
<td>3c</td>
<td>Back-up Ring</td>
<td>501144</td>
<td>3</td>
</tr>
<tr>
<td>3d</td>
<td>O-Ring</td>
<td>500850</td>
<td>2</td>
</tr>
<tr>
<td>4</td>
<td>Forward Gland Assy contains:</td>
<td>121891</td>
<td>1</td>
</tr>
<tr>
<td>4a</td>
<td>Forward Gland</td>
<td>121879</td>
<td>1</td>
</tr>
<tr>
<td>4b</td>
<td>Wiper</td>
<td>506066</td>
<td>1</td>
</tr>
<tr>
<td>4c</td>
<td>Back-up Ring</td>
<td>501155</td>
<td>1</td>
</tr>
<tr>
<td>4d</td>
<td>O-Ring</td>
<td>506090</td>
<td>1</td>
</tr>
<tr>
<td>4e</td>
<td>Back-up Ring</td>
<td>503610</td>
<td>1</td>
</tr>
<tr>
<td>4f</td>
<td>O-Ring</td>
<td>506082</td>
<td>1</td>
</tr>
<tr>
<td>5</td>
<td>Rear Piston Shield</td>
<td>128721</td>
<td>1</td>
</tr>
<tr>
<td>6</td>
<td>Locater Button</td>
<td>125902-1</td>
<td>2</td>
</tr>
<tr>
<td>7</td>
<td>Retaining Ring</td>
<td>503448</td>
<td>2</td>
</tr>
<tr>
<td>8</td>
<td>Suspension Sleeve</td>
<td>128722</td>
<td>1</td>
</tr>
<tr>
<td>9</td>
<td>Locking Screw</td>
<td>128701</td>
<td>1</td>
</tr>
<tr>
<td>10</td>
<td>Hydraulic Hose</td>
<td>123749-2</td>
<td>2</td>
</tr>
<tr>
<td>12</td>
<td>Male Coupler</td>
<td>110438</td>
<td>1</td>
</tr>
<tr>
<td>13</td>
<td>Female Coupler</td>
<td>110439</td>
<td>1</td>
</tr>
<tr>
<td>15</td>
<td>Trig./Term. Box Assy contains:</td>
<td>128784</td>
<td>1</td>
</tr>
<tr>
<td>15a</td>
<td>Trigger Box</td>
<td>128782</td>
<td>1</td>
</tr>
<tr>
<td>15b</td>
<td>Trigger Assembly</td>
<td>128756</td>
<td>1</td>
</tr>
<tr>
<td>15c</td>
<td>Trigger Box Cover</td>
<td>128780</td>
<td>1</td>
</tr>
<tr>
<td>15d</td>
<td>Screw</td>
<td>505879</td>
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<td>26</td>
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1. Using Dial Calipers or interchangeable Anvil Micrometers, measure the Puller to determine if it is worn out or new. (The Puller does not have to be removed from the tool to be measured.)

2. Remove the Setscrews from the Anvil Holder, and unscrew the Anvil Holder from the Tool.

3. Unscrew the Setscrews from the Puller, then unscrew the Puller from the Piston.

4. Once unscrewed from the Piston, remove and clean all the components from the Puller. Note: To add life to the Puller, always clean components upon changing or checking Puller.
   a) Insert Spring into Piston
   b) Insert Actuator Rod into Piston
   c) Insert Rod Guide into Piston
   d) Screw Puller onto Piston

5. Reinstall the components before screwing a NEW Puller onto the Piston.

6. Apply Loctite Anti-Seize or some other form of lubricant to the Puller to keep it from wearing against the Anvil during the first several drives.

7. a) Bottom Anvil Holder on Piston.
    b) Back off Anvil Holder until a groove is visible through Setscrew hole.
    c) Install Setscrew.

8. Check the Limit Switch setting using the Controller or a Light Box and the depth micrometers. Adjust within the specification of .520"-.530". (See Limit Switch Adjustment on the next page.)
**LIMIT SWITCH ADJUSTMENT**

**TOOLS NEEDED**
1. Controller or Light Box
2. Depth Micrometer
3. Allen Wrench

Where a Light Box is mentioned in these instructions, the Controller may be used instead when convenient.

NOTE: It is important to ensure that the face of the micrometer is firmly against the Puller Head, and the micrometer depth pin is in contact with the Actuator Rod when measuring.

1. Check to see where the Limit Switch is set using the Light Box and the Depth Micrometer.

2. Using an Allen wrench, loosen the Lockdown Screw.

3. To increase the switch setting turn the Limit Switch Adjustment Screw counterclockwise; to decrease it, turn it clockwise.

4. Adjust the switch to the specification of .520”-.530”. You will notice the Light Box light will come on once the switch has been made.

5. Tighten the Lockdown Screw.
   NOTE: After tightening the Lockdown Screw, verify the adjustment again by measuring with the depth micrometer. In some cases, because of the tight tolerance, it is possible for the adjustment to be jarred during tightening the Lockdown Screw.

6. Once adjusted to the specification of .520”-.530”, disconnect the Light Box and reconnect the system. The tool is now ready to drive fasteners.

**SERVICE NOTES**
18

WIRING INSTRUCTIONS

Figure 12
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.
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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

**Carson Operations**
900 Watson Center Rd.
Carson, CA 90745
800-421-1459
310-830-8200
FAX: 310-830-1436

**Waco Operations**
PO Box 8117
8001 Imperial Drive
Waco, TX 76714-8117
800-388-4825
254-776-2000
FAX: 254-751-5259

**Tucson Operations**
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520-747-9898
FAX: 520-748-2142

**Acuña Operations**
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TELEX: 1173530 LUKSME

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