An important notice
Please read this manual before servicing or using Tool. Comply with WARNINGS to prevent serious personal injury. Observe CAUTIONS, Notes and bold face type to avoid damage to equipment.
The SAFETY GLOSSARY helps in understanding our safety language.

If you require more information, contact our local representative, or the nearest office listed on the back cover. Since our only concern is keeping you as a valued customer, please let us know your requirements -- this includes equipment, literature and safety information. For a quick response, call any time during business hours.

CAUTION

Reasonable care of installation tools by operators is an important factor in maintaining tool efficiency and in reducing down-time.

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

BE SURE THERE IS ADEQUATE CLEARANCE FOR THE TOOL AND OPERATOR'S HANDS BEFORE PROCEEDING.

The pintail collector must be in place before using the tool.

WARNING

When operating Huck installation equipment, always wear approved eye protection.

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

SAFETY GLOSSARY

Bold Italic type is for stronger emphasis and requires particular attention. Wherever used, underlining is for additional emphasis.

WARNINGS require complete understanding to avoid severe personal injury.

CAUTIONS indicate conditions that will damage equipment/structure.

Notes are reminders of required procedures.

Bold type within a sentence is for emphasis concerning a particular procedure.
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DESCRIPTION

Model 242 Pneudraulic Installation Tool

Tool installs 3/16" and 1/4" MAGNA-LOK®, MAGNA-BULB® and MONOBOLT® blind fasteners including commonly used standard blind rivets.

Features of this high speed production tool include:
- Nose assembly with screw-in inserts for various blind rivets.
- Vacuum controlled pintail collection system for safety enhancement.
- Hydraulic fluid reservoir, with a visual indicator, which automatically replenishes hydraulic system.
- Easy filling and bleeding using fill bottle included.
- Shock free to prevent user fatigue.

Specifications:

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<tr>
<td>Length</td>
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<tr>
<td>Height</td>
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<td>Weight</td>
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<td>Stroke</td>
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<tr>
<td>Capacity</td>
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<tr>
<td>Power source</td>
<td>80/100 psi</td>
<td>5.5/7 bar</td>
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PRINCIPLE OF OPERATION

Tool is connected to air supply. Trigger is depressed. Air pressure is directed against air piston and moves it upward. Air piston rod acts as a hydraulic piston that pressurizes hydraulic fluid in handle. Pressurized fluid is forced into head to move pull piston/nose assembly which starts fastener installation.

When fastener installation is completed, trigger is released. Pressurized fluid is directed behind hydraulic piston and against opposite side of air piston to return moving parts to their starting position.

A control lever directs an air vacuum for automatic collection of spent pintails in collection bottle.
(1) Nose Insert (7 pcs.)

(2) Removable Mandrel Collector Bottle

Figure 1 Outline Dimension Drawing

2
MAIN COMPONENTS

A) Nose Assembly Insert for 3/16"(5mm) & 1/4"(6.4mm)
B) Hanger
C) Pintail Collector (Quick disconnect)
D) Vacuum Control Lever
E) Tool Operating Trigger
F) Oil Fill Port / Reservoir
G) Air Inlet
H) Nose Assembly
I) Reservoir -Ring Nut
PREPARATION and OPERATION

Use air supply with regulator - filter - lubricator unit to protect tool from premature wear. Replenish oil using MOBILE DTE 24, only - - DO NOT USE HYDRAULIC BRAKE FLUID. Vacuum system holds fastener securely in nose assembly - - this allows tool to be turned to any position while still holding fastener. Vacuum is controlled by turning lever (1). For increased efficiency, remove collector and attach tube at (2).

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

To install fastener:
Push fastener pintail onto, or insert pintail into, tool/nose assembly. Depress trigger to start fastener installation sequence. After fastener installation, pintail is pulled by vacuum into pintail collector or collecting tube. Release trigger.

Figure 3 - - Vacuum Control Lever

Figure 4 - - Pintail Collector

Figure 5 - - Collection Tube Adapter

Figure 6 - - Collection Tube
CAUTION
Keep dirt and other harmful material out of hydraulic and pneumatic system. Parts must be kept away from unclean work surfaces. Dirt in hydraulic fluid causes valve failure.

Good Service Practices
The efficiency and life of your Installation Tool depends upon proper maintenance and good service practices. Using our manual will help give you a clear understanding of your tool and basic maintenance procedures -- please read entire page before proceeding with maintenance/repair.

Use proper hand tools in a clean well-lighted area for maintenance/repair -- always be careful to keep dirt/debris out of pneumatic and hydraulic systems. Only standard hand tools are required.

While clamping Installation Tool and/or parts in a vise, and when parts require force, use suitable soft materials to cushion impact -- for example, using a brass drift, wood block and/or vise with soft jaws greatly diminishes the possibility of a damaged Tool. Remove components in a straight line without bending, cocking or undue force -- reassemble Tool with the same care.

Note: Individual parts must be handled carefully and examined for damage or wear -- replace parts where required. Always replace O-rings and seals when the tool is disassembled for any reason -- see SERVICE KIT.

Consult manual's TROUBLESHOOTING if malfunction occurs.

Standard Sealants, Lubricants, and Service Kit
Smear LUBRIPLATE 130AA, or equivalent lubricant, on O-rings, seals and mating surfaces -- this prevents nicking/pinching O-rings on any rough/tight spot and increases ease of assembly. (LUBRIPLATE 130AA -- in tube: Huck, 502723.)

Clean threads of pull piston (14) and spindle tube (10) with LOCTITE #764 (grade "N") cleaner/primer (LOCTITE #764: Huck, 503765) and then, apply LOCTITE #242 Adhesive/sealant to threads -- follow directions on containers. (LOCTITE #242: Huck, 505016).

Rub SLIC-TITE TEFLON thread compound, or equivalent, on pipe threads to prevent leaks and for ease of assembly -- CAUTION: Do not use TEFLON tape on pipe threads -- particles of shredded tape cause tool failure/malfunction. Use TEFLON (SLIC-TITE -- in stick form: Huck, 503237.)

Service Kit
242KIT contains perishable parts for your tool. For convenience and as experience indicates, keep extra service kits and tool parts on hand.
NOSE ASSEMBLY MAINTENANCE

To extend jaw life, disassemble, clean and inspect parts periodically -- use a pick to clean jaw grooves. Wash parts in mineral spirits or isopropyl alcohol ONLY. Dry parts immediately after cleaning. Keep spare parts, and other perishable parts, on hand. Remove anvil holder (4) -- use 27 mm wrench. With 17 & 13 mm wrenches, remove collet (5).

Remove jaws (6) from collet. When re-assembling nose components, tighten collet (5) and holder (4) on tool. Tool can install MAGNA-LOK, MAGNA-BULB and MONOBOLT fasteners in both 3/16 and 1/4 sizes. Install correct screw-in anvil insert in anvil holder -- use wrench supplied.

Figure 7 -- Anvil Holder Removal

Figure 8 -- Collet Removal

Figure 9 -- Chuck Jaw Removal

Figure 10 -- Anvil Insert Replacement
FILLING and BLEEDING TOOL

If Indicator Washer (8) bottoms out on min. oil level, (see detail), or if tool fails to install fasteners properly (short stroke), tool must be replenished with fluid.

Note: Good practice is to drain/exhaust dirty fluid out of Port (12) first, and then, refill tool with new/clean fluid following steps 1. through 7.

To add fluid: 1. Turn Ring Nut (9) all the way clockwise. 2. Remove Fill Plug (10) -- use 5mm hex key supplied. 3. Pour MOBILE DTE 24 hydraulic fluid, or equivalent, approximately 2/3 full into Fill Bottle (11). 4. Screw fill bottle into tool fill port. 5. With trigger, cycle tool several times until fluid is clear of air bubbles. 6. Remove fill bottle and reinstall Plug (10). 7. Reset Ring Nut (9) by turning counter-clockwise until it stops.

CAUTION: Do not install fasteners when Ring Nut (9) has not been RESET in the COUNTER-CLOCKWISE position -- see 7.
Troubleshooting

Always check out the simplest possible cause of a malfunction first. For example, an air hose not connected. Then proceed logically, eliminating each possible cause until the defective part is located - - where possible, substitute known good parts for suspected bad parts. Use this guide as an aid in locating and correcting malfunction.

1. Tool fails to operate when trigger is depressed.
   a. Air line disconnected.
   b. Trigger O-ring (33) or O-ring (32) worn or damaged.
   c. Damaged parts in Air Valve, check (50) thru.(60).

2. Tool does not complete fastener installation or break pintail.
   a. Air pressure too low.
   b. Hydraulic fluid low causing short stroke.
   c. Air piston O- ring (70) worn or damaged.
   d. Air in hydraulic system (see Filling and Bleeding Tool)
   e. Damaged or worn nose components.

3. Hydraulic fluid exhausts with air.
   a. Worn or damaged seal (35)

4. Hydraulic fluid leaks at Front Gland (11)
   a. Worn or damaged O-rings (12) & (13).

5. Hydraulic fluid leaks at Pull Piston Rod (14).
   a. Worn or damaged Pull Piston Rod Seal (25)

6. Chuck jaws slip on pintail.
   a. Grooves in chuck jaw are full of debris.
   b. Incorrect Anvil Insert used for fastener being used.

7. Air leaks at tool.
   a. Damaged O-rings due to air pressure in excess of 100psi.

8. Fluid leaks at rear of head/handle.
   a. Worn or damaged O-rings (12 or13).

   a. Switch level (28) to "ON " position.
   b. O-Ring (9) worn or damaged.
   c. Dirty or damaged vacuum tube (8).
Parts Ordering Information

These Sub-assem. Part Nos. should be used for ordering the complete sub-assembly. Each sub-assembly below lists pertinent components by 242 P/L Item No. -- see 242 Parts List for complete description of each part. Individual parts within sub-assemblies can be purchased, also. Parts not included in a sub-assembly MUST be ordered by each individual part number on 242 Parts List.

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<th>Part Nos.</th>
<th>Sub-assembly Description with P/L Item No.</th>
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<td>123591</td>
<td>Basic Assembly -- incl. each Part No.</td>
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<td>Hyd. Cyl. Gland Assembly -- incl. 65, 66 &amp; 77</td>
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<td>123052</td>
<td>Air Piston Assembly -- incl. 17, 68, 69, 70, 71, 78, 79, 80, 81, 82, 83, 84 &amp; 107</td>
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<td>123053</td>
<td>Bottom Plate &amp; Reservoir Assem. -- incl. 72, 73, 74, 75, 76, 85, 86, 87, 88, 89, 90, 91, 92, 93, 108, 109 &amp; 110</td>
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<td>Rear Gland Assembly -- incl. 13, 17 &amp; 18</td>
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<td>Head/Tube Assembly -- incl. 15, 35, 37, 38, 39, 40, 42, 43 &amp; 105</td>
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<td>Cylinder Tool Assembly -- incl. 16, 39, 44, 45, 48, 49, 50, 51, 52, 53, 54, 55, 56, 57, 58, 59, 60, 61, 62, 63, 64, 114 &amp; 116</td>
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**NOTE**
1. ITEMS WITH ASTERISKS (*) ARE PARTS AND QUANTITIES INCLUDED IN SERVICE KIT, 242KIT.
Note: 101 and 102 are GOLD CHROMATE for identification
DISASSEMBLY of Major Assemblies

1. Remove nose assembly components from tool.

2. Remove tool hanger (16) by gently spreading apart and lifting.

3. Unscrew pintail collector bottle (21) -- turn counter-clockwise.

4. Remove connector bolt (20) with 3/4" deep drive socket wrench.

5. Turn tool upside-down. Clamp padded vise jaws on plastic handle.

6. In two opposite holes of bottom cap, place 5/16 dia. x 1 3/4 long dowel pins. Use a bar across pins and unscrew bottom cap (94) from cylinder (49).

7. Remove bottom plate (85) from tool.

WARNING: If steps 8. and 9. are not followed exactly, severe personal injury may result.

8. Reinstall bottom cap (94) part-way down on cylinder -- leave no more than three threads exposed.

CAUTION: Do not pry or try to turn air piston out of cylinder. There is an air tube that is not shown on the exploded view that can be bent or broken if air piston is not removed as explained in step 9.

9. With tool clamped in vise, direct bottom of cylinder away from you -- cover bottom with rag. Set air regulator to 10 psi before attaching air line -- listen for a loud pop. Popping sound indicates air piston has been forced out of cylinder and into bottom cap.

10. Repeat step 6. -- remove bottom cap.

11. Lift air piston assembly (69) out of cylinder.

12. Remove gland (65) from cylinder using wrench, 122693, a 7/8" deep drive socket with extension and breaker bar.

13. Remove air cylinder from head/tube assembly (15) after removing fill port plug (43) and seal (42).

14. Remove head/tube assembly -- drain oil into container -- discard.

13
15. Place head/tube assembly (15) back into vise. Remove rear gland assembly (18).

16. Remove front gland and piston assembly as a whole unit. Hold rear of piston assembly in vise (jaws grip on 17mm hex.). With 13mm wrench, separate piston assembly. These two parts require great force to separate as LOCTITE binds them. After separation, parts can be removed from head/handle.

17. Remove front gland (11).

18. Trigger assembly is not serviceable. Do not remove unless assembly is to be replaced.

19. Remove air connector (44) and muffler (46) from cylinder with 17mm wrench.

*Tool has now been disassembled into major sub-assemblies*

**DISASSEMBLY and ASSEMBLY of Bottom Plate Assembly**

1. Remove O-ring (84) from bottom plate (85).

2. Remove retaining ring (93) from bottom plate assembly. With two screwdrivers, and using light pressure, pry out guide bushing (75) and ring nut (74).

3. Remove ring nut recovery spring (92). Remove oil plug (76) from feeding piston (89).

4. Remove retaining ring (93) from bottom plate (85).

5. Remove spacer (73). Note: Chamfer on outside is toward spring.

6. Remove compensator spring (90).

7. Pull feeding piston (89) from bottom plate (85). Remove O-ring (86) from bottom plate.

8. Before reassembling any assemblies, coat all O-rings, seals, back-up rings and mating parts with a light coat of LUBRIPLATE, or equivalent.

9. Replace thin O-ring (109) under opening tube; thick O-ring (110) on tube.
10. Install new O-ring (86) in bottom plate (85). Slide feeding piston into bottom plate. Replace compensating spring (90); spacer (75). 
**Note:** Chamfer is toward spring.
   Install: Retaining ring and oil plug; ring nut on bottom plate. Place recovery spring in ring nut and slide guide bushing over spring.

11. Reassemble bottom plate (85), opening tube (87), feeding piston (89), spring (90), spacer (73), retaining ring (91), ring nut (74), spring (92) and retaining ring (91).

**DISASSEMBLY and ASSEMBLY of Air Piston/Compensator Valve;**

**ASSEMBLY of Hydraulic Cylinder Gland**

1. Use tool, 122694, to hold piston rod (79) while removing bushing (84) - - use 7/8" socket.

2. Remove air piston (69), O-ring (70) and washer (83).

3. From bottom of piston rod (79), pick out two O-rings (71), spacer (107) and sleeve (82).

4. Use long shank screwdriver inside piston to hold spring ring nut (81) while unscrewing compensator valve (68).

5. Remove compensator valve, O-ring (78), spring (80) and spring ring nut from piston rod.


7. Slide sleeve (82) into piston rod followed by replacement O-ring (71), spacer (107) and O-ring (71).

8. Install piston rod into piston (69) using washer (83).

9. Press new seal (35) and spacer (40) into base of head/tube assembly (cup end toward top of tool - - spacer goes in last).

10. Assemble head/tube assembly (15) into cylinder/handle (49).

11. Place assembled parts in vise - - see step 6.

12. Install new O-rings in gland (65) and install gland between head/tube and cylinder/handle.
DISASSEMBLY and ASSEMBLY of Air Valve;

ASSEMBLY of Miscellaneous Components

1. Remove retaining ring (60). Note: Remove air valve components by gently tapping red button plug (50) (on other side) with small drift. Clean all components and replace O-rings (56), (57), (58), (61), (63) and (64) - - use LUBRIPLATE or PARKER "O-LUBE" on seals and mating surfaces.

WARNING: Retaining ring (60) must be seated with sharpest edge out to obtain best contact. If ring is not seated completely, forcible ejection of valve parts may cause severe personal injury.

2. Reassemble all components of air valve assembly - - see WARNING above and install retaining ring (60).

3. Lightly lubricate cylinder wall and air piston (69) O-ring. While guiding piston down over brass air tube, slide piston into tool.

4. Install bottom plate assembly, with new O-ring, onto tool.

5. Hold tool upside-down - - clamp padded vise jaws on plastic handle area. In two opposite holes of bottom cap (94), place 5/16 dia. x 1 3/4 long dowel pins - - bar across pins tightens cap.

6. Lubricate all seals and O-rings. Note: Lips of seal (25) must face toward rear of tool; lips of seal (26) must face toward front of tool. Install new O-rings and seals on front gland (11), pull piston (14) and spindle tube assembly (10).

7. Install front gland in head/tube assembly.

8. Slide spindle tube (10) into front gland (11).
ASSEMBLY of Miscellaneous Components  (continued)

9. **Note**: See directions on container and use LOCTITE Primer/cleaner (grade "N") #764 to clean threads where pull piston (14) and spindle tube (10) join. Use LOCTITE #242 to lock threads of pull piston and spindle tube together -- see MAINTENANCE; Standard Sealants

Slide pull piston into rear of head/tube (15). Thread pull piston (14) and spindle tube (10) together -- tighten wrench tight.


11. Attach connector (19) and connector bolt (20) to rear gland (18).


13. Attach nose assembly after tool has been refilled and bled -- see Filling and Bleeding Tool.

**Note**: Trigger is not serviceable. If required, order a complete trigger assembly.


15. Install oil plug (43) and new seal (42) in handle.

16. After tool is filled and bled, install oil plug (76). Measure stroke of tool after bleeding -- stroke must be .900 minimum.
Spare Parts and Service Kit, 242KIT

Service kits containing perishable parts such as O-rings and seals should be kept on hand at all times. The quantity of spare parts and service kits that should be kept on hand may vary due to the application and number of tools in service.

Service Kit - - 242KIT

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Special Tools Available from Huck:
Gland Wrench, 122693 and Piston Wrench, 122694

![Diagram of Gland Wrench and Piston Wrench]

NOTES:
1 ASSEMBLE DOWEL PINS IN POSITION 'A' FOR THE 242 TOOL.
2 PRESS OUT PINS AND INSTALL INTO POSITION 'B' FOR THE 240 TOOL.

Figure 16
Gland Wrench Assembly, 122693
For gland hydraulic cylinder, 122541 (65)

![Diagram of Gland Wrench and Piston Wrench]

Figure 17
Piston Wrench, 122694
For air piston, 122545 (69)
Warranties

Warranty
THE NINETY DAY WARRANTY HEREIN EXPRESSED SHALL BE THE EXCLUSIVE WARRANTY ON ITEMS MANUFACTURED BY SELLER AND SHALL BE IN THE PLACE AND stead of ANY OTHER WARRANTY, EXPRESSED OR IMPLIED, INCLUDING BUT NOT LIMITED TO THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.

Seller 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 seller or its suppliers.

All warranty claims must be submitted to the seller in writing, within 90 days from date of shipment, and no returns will be accepted without written permission.

Other provisions hereof notwithstanding, seller shall not be liable for any loss of business, profits or any incidental or consequential damages incurred by Buyer or any third person in connection with the items or use thereof, however caused.

Tool Warranty
Seller expressly disclaims any warranty express or implied, as to the condition, design, operation, merchantability or fitness for use of any tool, or part(s) thereof not manufactured by seller. The only warranties made with respect to such tool or part(s) thereof are those made by the manufacturer thereof and seller agrees to cooperate with buyer in enforcing such warranties when such action is necessary. Seller agrees to repair or replace F.O.B. seller's plant, any tool or part(s) thereof manufactured by it and proved to be defective due to faulty workmanship or material.

Warranty on "Other Items"
With regard to items other than FASTENERS and TOOLS ("OTHER ITEMS"), seller expressly disclaims any warranty, express or implied, as to the condition, design, operation, merchantability or fitness for use of any "OTHER ITEMS", or part(s) thereof not manufactured by seller. The only warranties made with respect to such "OTHER ITEMS" or part(s) thereof are those made by the manufacturer thereof and seller agrees to cooperate with buyer in enforcing such warranties when such action is necessary.

Seller agrees to repair or replace F.O.B. seller's plant, any "OTHER ITEMS" or part(s) thereof manufactured by it and proved to be defective due to faulty workmanship or material.

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 servicemen only.

Always give the Serial No. of the equipment when corresponding or ordering service parts.

Complete repair faciliites are maintained by Huck International Inc. Please contact one of the offices listed below.

Eastern
85 Grand Street, Kingston, New York 12401-0250
Telephone 914-331-7300, FAX 914-334-7333

Western
900 Watson Center Road, Carson, California 90745
Telephone 310-830-8200, FAX 310-830-1436

Canada
326 Humber College Boulevard, Rexdale, Ontario M9W 5P4, Canada. Telephone 416-675-3400, FAX 416-675-5917

Outside USA and Canada
Contact your nearest Huck International Office. See Back Cover.

In addition to the above repair faciliites, there are Authorized Tool Service Centers (ATSC) 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 Office listed on the back cover for the ATSC in your area.
Huck Acceptance is World-wide

Huck International Inc. maintains company offices throughout the United States and Canada with subsidiary offices in many foreign countries. Sales engineers and systems specialists located in your area can help in solving your fastener problems.

Huck International Inc. world-wide locations:

**Americas**

Huck International, Inc.  
**Installation Systems Division**  
P.O. Box 2270  
85 Grand Street  
Kingston, NY 12401  
800-431-3091  
814-331-7300  
FAX: 814-334-7333

Huck International, Inc.  
**World Headquarters**  
6 Thomas Street  
P.O. Box 19590  
Irvine, CA 92718  
714-855-9000  
FAX: 714-855-8537

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

Huck International, Inc.  
**Aerospace Fastener Division**  
Lakewood Operation  
3969 Paramount Blvd.  
Lakewood, CA 90712  
800-344-6566  
310-421-3711  
FAX: 310-425-3242

**Far East**

Huck Australia, Pty. Ltd.  
Private Bag 6  
Rowville, Victoria  
Australia 3178  
03-764-5500  
Toll Free: 008-335-030  
FAX: 03-764-5510

Huck Limited  
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No. 2-1, 3 Chome Toyosaki  
Kita-Ku, Osaka 531 Japan  
06-372-1193  
FAX: 06-372-9346  
TELEX: 63632

Huck International Singapore PTE, Ltd  
7500A Beach Road  
#10-323 The Plaza  
Singapore 0719  
65-298-2791  
FAX: 65-298-2792

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FAX: 0952-290459

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FAX: 34-66-07-00