Nose assemblies are designed to install HUCKBOLT Fasteners and are attached to the Huck installation tool. There are different versions of nose assemblies depending on the fastener type and fastener diameter. Refer to the applicable selection chart to identify the proper nose assembly required for your needs.

**Unacceptable**

Partial Swage - An incomplete swage is an indication of an incorrect or worn nose assembly.

**Acceptable**

Full Swage - A properly installed Huckbolt Fastener will resemble the above illustration.

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THE HUCK NOSE ASSEMBLY:
MAINTENANCE AND REPAIR

Groove starts to form on a worn anvil. One of a number of nose assembly problems that can lead to poor fastener installations.
**The Nose Assembly**

**Anvil** - Houses a cavity or die for swaging the fastener collar into the pin's locking grooves. Is attached to the installation tool cylinder with split rings and sleeve.

**Collet** - Houses the jaw set, release/ejector, follower, O-rings and other components. It is threaded onto the installation tool piston.

**Release/Ejector** - Housed in the collet, the release portion pushes the jaw set rearward to open the jaw set when the piston is in the full forward position. This action releases the pintoil allowing it to be ejected from the tool. The ejector pushes the swaged collar out of the anvil swage die.

**Jaw Set** - Housed in the collet, the jaw set pulling grooves grip the pintoil portion of the pin during the fastener installation cycle.

**Good Maintenance Practices**

Frequent cleaning and inspection of the nose assembly is recommended. Dip nose assembly in suitable solvent to clean jaw set and wash away metal chips and dirt. Use a sharp pointed pick to remove imbedded particles from pull grooves of jaw set.

Inspect anvil swage die, collet inside diameter and threads and release/ejector for scored or ridged surfaces, excessive wear or damage and replace as necessary.

**Sleeve, followers, O-rings**

Housed in the collet and assembled behind the jaw set, these components are designed to hold the jaw set in the full forward position so they can grip the pintoil.

**Troubleshooting**

**Problem**

Pintoil stripping.

**Solution**

Cause: worn or broken jaw set or jaw grooves are filled with dirt, sealant or grease.

Replace or clean jaw set.

Cause: inadequate jaw set and pintoil engagement.

Remove gap condition.

**Scored or partially swaged collar**

**Cause:** worn anvil or swage die.

Replace anvil.

Check collar orientation. Position flange against workpiece. Position non-flanged collar with beaded portion facing up away from workpiece.

Improper nose assembly type and/or diameter. Verify proper nose assembly selection.

**Nose assembly will not release broken pintoil.**

**Cause:** tool piston and collet are not returning to full forward position.

Replace worn or damaged release/ejector.

Clean inside diameter of anvil to allow collet to move to full forward position.

Check installation tool to assure full piston travel/stroke.

Check installation tool ejector rod.

**Jaw will not grip pintoil**

**Cause:** dirt accumulation or physical damage causes release ejector to stick in released position.

Clean collet or replace damaged components.