EC Declaration of Conformity

Manufacturer:
Alcoa Fastening Systems, Industrial Products Group, 1 Corporate Drive, Kingston, NY, 12401, USA

Description of Machinery:
Models 2400 series, 2500 series, and 2580 hydraulic installation tools, and specials based on their designs. (e.g. PR####)

Relevant provisions complied with:
British Standard related to hand held, non-electric power tools (EN 792-1)

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: [Signature]
Full Name: Larry M. Krieg
Position: Engineering Manager
           Installation Systems Division
Place: Kingston, New York, USA
Date: December, 2011

Declared dual number noise emission values in accordance with ISO 4871

A weighted sound power level, LWA: 85 dB (reference 1 pW)
Uncertainty, KWA: 3 dB

A weighted emission sound pressure level at the work station, LpA: 74 dB (reference 20 µPa)
Uncertainty, KpA: 3 dB

C-weighted peak emission sound pressure level, LpC, peak: 119 dB (reference 20 µPa)
Uncertainty, KpC: 3 dB

Values determined according to noise test code ISO 15744, using as basic standards ISO 3744 and ISO 11203. 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

Measured Vibrations emission value, e:
20 m/s²
Uncertainty, K:
.17 m/s²

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 Alcoa Fastening Systems, Industrial Products Group, Kingston Operations, Kingston, NY, USA.
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## SAFETY INSTRUCTIONS

### GLOSSARY OF TERMS AND SYMBOLS:

- **Product complies with requirements set forth by the relevant European directives.**
- **READ MANUAL** prior to using this equipment.
- **EYE PROTECTION IS REQUIRED** while using this equipment.
- **HEARING PROTECTION IS REQUIRED** while using this equipment.

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

### CAUTIONS: show conditions that will damage equipment and or structure.

### Notes: are reminders of required procedures.

**Bold, Italic type and underlining:** emphasizes a specific instruction.

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. 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.
4. Read MSDS Specifications before servicing the tool. MSDS Specifications are available from the product manufacturer or your Huck representative.
5. When repairing or operating Huck installation equipment, always wear approved eye protection. Where applicable, refer to ANSI Z87.1 - 2003
6. Only genuine Huck parts shall be used for replacements or spares. Use of any other parts can result in tooling damage or personal injury.
7. If a part affixed with warning labels is replaced, or labels are missing or damaged, the end user is responsible for replacement. Refer to assembly drawing and parts list for replacement part number and proper placement.
8. Disconnect primary power source before performing maintenance on Huck equipment or changing Nose Assembly.
9. 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.
10. Mounting hardware should be checked at the beginning of each shift/day.
11. Make sure proper power source is used at all times.
12. Release tool trigger if power supply is interrupted.
13. Tools are not to be used in an explosive environment unless specifically designed to do so.
14. Never remove any safety guards or pintail deflectors.
15. Where applicable, ensure deflector or pintail collector is installed and operating prior to use.
16. Never install a fastener in free air. Personal injury from fastener ejecting may occur.
17. Where applicable, always clear spent pintail out of nose assembly before installing the next fastener.
18. There is possibility of forcible ejection of pintails or spent mandrels from front of tool.
19. 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.
20. Unsuitable postures may not allow counteracting of normal expected movement of tool.
21. 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.
22. Never place hands between nose assembly and work piece. Keep hands clear from front of tool.
23. There is a risk of crushing if tool is cycled without Nose Assembly installed.
24. Tools with ejector rods should never be cycled with out nose assembly installed.
25. When two piece lock bolts are being used always make sure the collar orientation is correct. See fastener data sheet for correct positioning.
26. Tool is only to be used as stated in this manual. Any other use is prohibited.
27. There is a risk of whipping compressed air hose if tool is pneumatic or pneumatic.
28. Release the trigger in case of failure of air supply or hydraulic supply.
29. Use only fluids or lubricants recommended.
30. Disposal instruction: Disassemble and recycle steel, aluminum and plastic parts, and drain and dispose of hydraulic fluid in accordance with local lawful and safe practices.
31. If tool is fixed to a suspension device, ensure that the device is secure prior to operating the tool.
DESCRIPTION

Model 2580 Hydraulic Installation Tool with appropriate nose assembly installs a wide range of Huck blind fasteners and HUCKBOLT® Fasteners. This lightweight and compact mini tool is particularly adapted to installing fasteners in limited clearance areas. Each tool is complete with hydraulic hoses and couplings; electric switch and cord. The tool is basically a cylinder and piston assembly. An unloading valve, designed to relieve hydraulic pressure at end of the PULL stroke, is positioned by the piston. End of piston rod is threaded — retaining nut and stop are included for attaching nose assemblies.

Huck Hydraulic Installation Tools are designed to be powered by Huck POWERIG® Hydraulic Units. For most applications, the 2580 operates at 5,700 psi (39,000 kPa) PULL and 3,200 psi (19,300 kPa) RETURN pressures. Huck POWERIG Hydraulic Unit Models 913, 918, 918-5, 940, 956, or equivalent, are power source.

A specific nose assembly is required for each fastener type and size. Nose assemblies must be ordered separately.

SPECIFICATIONS

Length 8.40 in. (21.3 cm)
Width 2.16 in. (5.5 cm)
Height (incl. handle) 6.48 in. (16.5 cm)
Weight 6.58 lbs. (3.0 kg)
Max PULL pressure 7400 psi (51,000 kPa)
Max RETURN pressure 3200 psi (22,100 kPa)
Min. effective stroke .94 in. (2.4 cm)
Max Operating Temp: 125°F (51.7°C)
Max Flow Rate: 2 gpm (7.5 l/m)

(1) Length and weight does not include hoses/cord or nose assembly.
(2) For fastener size -12 and above, set PULL pressure to 7400 psi.

Pull capacity at 5700 psi: 8,240 lbs. (36.6 kN).

Pull capacity at 7400 psi: 10700 lbs. (47.5 kN).

Power Source: Huck POWERIG Hydraulic Unit

Hydraulic Fluid:
ATF meeting DEXRON III, DEXRON IV, MERCON, Allison C-4 or equivalent specifications.
Fire resistant hydraulic fluid may also be used, and is required to comply with OSHA regulation 1926.302 paragraph (d): "the fluid used in hydraulic power tools shall be fire resistant fluid approved under schedule 30 of the US Bureau of Mines, Department of Interior, and shall retain its operating characteristics at the most extreme temperatures to which it will be exposed."
Outside Dimensions
Main Components
PRINCIPLE OF OPERATION

Refer to Figure 2

An electric trigger controls PULL and RETURN strokes of tool. Press trigger to direct hydraulic pressure to PULL side of piston - fastener installation begins.

At end of PULL stroke, before trigger is released, piston uncovers flats of unloading valve - pressure is unloaded by allowing fluid to flow back to POWERIG hydraulic unit. Release trigger at end of PULL stroke when fastener is installed - pressure is directed to RETURN side of piston and moves piston forward. Nose assembly, with tool, is pushed off fastener.

CAUTION: Keep dirt and other foreign matter out of hydraulic systems of the tools, hoses, couplers and POWERIG Hydraulic Unit. Do not let hose fittings and couplers contact a dirty floor or unclean working surface. Foreign matter in hydraulic fluid may cause hydraulic unit valves and tool valves to malfunction.

WARNINGS:

Operators of Huck Installation equipment must always wear approved eye protection.

Only Huck POWERIG ® Hydraulic Units are recommended as the power source for Huck tools. Units that deliver high pressure for both PULL and RETURN, and are not equipped with relief valves, are specifically not recommended. Severe personal injury or damage to equipment may occur when using other units.

Proper PULL and RETURN pressures are important for proper function of Installation Tools. Severe personal injury or damage to equipment may occur without correct pressures.

Gauge Set-up, P/N T-124833CE, is available for checking these pressures using instructions furnished with T-124833CE and in applicable POWERIG Hydraulic Unit instruction manuals. See Checking and Adjusting Output Pressures.
Checking and Adjusting Output Pressures
POWERIG® Hydraulic Unit pressures must be checked and adjusted at first time start-up, after overhauling the unit and when troubleshooting.

1. Use Huck POWERIG Hydraulic Unit, or equivalent, that has been prepared per INSTRUCTION MANUAL. Check both PULL and pressures and adjust to pressures given in Table 1 - SPECIFICATIONS of this manual. See both hydraulic unit’s and T-124833’s manuals.

2. First, turn hydraulic unit to OFF, then, disconnect unit’s power supply.

3. Connect tool’s switch electrical cord to hydraulic unit.

4. Connect hydraulic unit to power supply. Turn unit to ON. Hold tool trigger depressed for 30 seconds; depress trigger a few times to cycle tool and to circulate hydraulic fluid. Observe action of tool and check for leaks. Turn unit to OFF.

5. Select nose assembly for fastener to be installed. Disconnect tool’s control switch electrical cord from hydraulic unit; disconnect hydraulic unit from power supply. Attach nose assembly to tool.

6. Reconnect hydraulic unit to power supply; reconnect tool’s switch control cord to unit. Check operation of nose assembly. Install fasteners in test plate of correct thickness with proper size holes. Inspect installed fasteners. If fasteners do not pass inspection, see TROUBLESHOOTING to locate and correct tool malfunction.

WARNING: Correct PULL and RETURN pressures are required for operator’s safety and for installation tool’s function. Gauge Set-up T-124833CE is available for checking pressures. See tool’s Table I - Specifications and INSTRUCTION MANUAL for T-124833CE. Failure to verify pressures may result in severe injury.

WARNING: Be sure to connect tool’s hydraulic hoses to POWERIG Hydraulic Unit before connecting tool’s switch control cord to unit. IF NOT CONNECTED IN THIS ORDER, severe personal injury may occur.

CAUTION: Do not let disconnected hoses and couplers contact a dirty floor. Keep harmful material out of hydraulic fluid. Dirt in hydraulic fluid causes valve failure In Tool and In POWERIG Hydraulic Unit.
**OPERATING INSTRUCTIONS**

**WARNINGS:**

Do not pull on a pin unless fastener is placed in a workpiece with collar chamfer out toward tool. If collar is incorrectly placed, pin will eject from front with great force when pintail breaks off or when pin grooves are stripped. Also, broken pintails eject from deflector with speed and force - - be sure pintail deflector is attached to tool, and directed safely. Pins/pintails, as described, can cause serious injury.

Be sure of adequate clearance for both tool and operator’s hands before proceeding as severe personal injury may occur.

**CAUTION:** Remove excessive gap from between sheets for enough of the pintail to stick out of the collar for all the jaw teeth to grip into pintail grooves. Jaws not fully gripping pintail grooves will be stripped or broken.

**HUCKBOLT® Fastener Installation**

Place pin in work-hole and place collar over pin - - see **WARNINGS**. (if collar has only one tapered end, that end **MUST** be out toward tool.) Hold pin in hole. Push nose assembly onto pin protruding from collar until anvil touches collar Press trigger and hold down until collar is swaged and pintail breaks. Release trigger - - tool/nose returns to starting position and is ready for next installation cycle.

**Blind Fastener Installation**

Fastener may be placed in work-hole or in end of nose assembly. Hold tool/nose at a right angle against work. Press trigger and hold down until fastener is installed and pintail breaks. Release trigger - - tool/nose returns to starting position and is ready for next installation cycle.

**CAUTION:** Do not abuse tool by dropping it, using 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.
Preventive Maintenance

NOTE - Refer to the applicable section for DIS-ASSEMBLY or ASSEMBLY. For extra information refer to TROUBLESHOOTING and illustrations.

System Inspection

Operating efficiency of the tool is directly related to performance of complete system, including tool with nose assembly, hydraulic hoses, trigger 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.

1. Inspect tool and nose assembly for external damage.
2. Verify that hydraulic hose fittings and couplings, and electrical connections are secure.
3. Inspect hydraulic hoses for damage. Replace hoses if damaged. Do not use hoses to carry tools.
4. Observe tool, hoses and POWERIG Hydraulic Unit during operation to detect abnormal heating, leaks or vibration.

POWERIG® Hydraulic Unit Maintenance

Refer to the applicable POWERIG Hydraulic Unit Instruction Manual.

Tool Maintenance

At regular intervals, depending upon use, replace all seals, wipers and back-up rings in tool. Service Kits and hoses should be kept on hand. Inspect cylinder bore, piston and piston rod, and unloading valve for scored surfaces, excessive wear or damage, and replace as necessary. Always replace seals, wipers and back-up rings whenever the tool is disassembled for any reason.

Nose Assembly Maintenance

Nose assemblies with UNITIZED™ jaws must be disassembled and cleaned in mineral spirits or isopropyl alcohol. Do not let UNITIZED jaws (urethane) soak in solvent. Do not use solvents that cause urethane to swell. Dry components immediately after cleaning. Use sharp “pick” to remove particles packed in jaw grooves. Reassemble.
General Precautions

During disassembly and assembly, take the following precautions to avoid damaging tool or components:

(A) A clean, well-lighted area should be available for servicing the tool. Special care must be given to prevent contamination of hydraulic systems.

(B) Use soft materials, such as brass, aluminum or wood, to protect the tool when applying pressure. Only standard hand tools are required. Brass drifts, wood blocks, a vise with soft jaws and an arbor press will prevent damaging tool. Standard tools available Huck are listed in this manual.

(C) Apply continuous strong pressure, rather than sharp blows, to disassemble or assemble a component. An arbor press provides steady pressure to press a component in or out of an assembly.

(D) Never continue to force a component if it "hangs-up" due to misalignment. Reverse the procedure to correct misalignment and start over.

(E) Smear SUPER O-LUBE*, or equivalent lubricant, on seals and mating surfaces to facilitate assembly and to prevent damage to seals (SUPER O-LUBE is available, in a tube as Part Number 505476, from Huck.) *SUPER O-LUBE is a trademark of Parker Seal

(F) Rub SLIC-TITE TEFLON* thread compound, or equivalent, on pipe threads, to aid assembly and sealing.

(G) All parts must be handled carefully and examined for damage or wear. Always replace seals, wipers and back-up rings when tool is disassembled for any reason. Components should be disassembled and assembled in a straight line without bending, cocking, or undue force. Disassembly and assembly procedures outlined in this manual should be followed.

CAUTION: Do not use TEFLON® 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 503237.)

* Slic-Tite is a registered trademark of LA-CO Industries, Inc.
* TEFLON is a registered trademark of DuPont Corp.
Always check out simplest possible cause of malfunction first. For example, switch turned off or power cord not connected. Then proceed logically, eliminating each possible cause until the defective circuit or part is located. Where possible, substitute known good parts for suspected bad parts. Use TROUBLESHOOTING chart as an aid in locating and correcting malfunction.

1. **Tool fails to operate when trigger is depressed:**
   a. Inoperative POWERIG® Hydraulic Unit. See applicable instruction manual.
   b. Loose or disconnected control cord.
   c. Damaged trigger assembly.
   d. Loose or faulty hydraulic hose couplings.
   e. Unloading valve not installed in tool.

2. **Tool operates in reverse:**
   a. Reversed hydraulic hose connections between hydraulic unit and tool.

3. **Tool leaks hydraulic fluid:**
   a. Depending on where leak occurs, defective or worn O-rings, or loose hydraulic hose connection at tool.

4. **Hydraulic couplers leak fluid:**
   a. Damaged or worn O-ring in coupler body. See Figure 4.

5. **Hydraulic fluid overheats:**
   a. Hydraulic unit not operating properly. See applicable POWERIG Hydraulic Unit Instruction Manual.
   b. Unloading valve installed backwards.

6. **Tool operates erratically and fails to install fastener properly:**
   a. Low or erratic hydraulic pressure supply - air in system. See applicable POWERIG Instruction Manual.
   b. Damaged or excessively worn piston O-ring in tool.
   c. Unloading valve installed backwards.
   d. Excessive wear or scoring of sliding surfaces of tool parts.
   e. Excessive wear of unloading valve.
7. Pull grooves on fastener pintail stripped during pull stroke:
   a. Operator not sliding jaws completely onto fastener pintail.
   b. Incorrect fastener length.
   c. Worn or damaged jaw segments.
   d. Metal particles accumulated in pull grooves of jaw segments.
   e. Excessive sheet gap.
   f. Nose assembly not properly attached - see NOSE ASSEMBLY DATA SHEET

8. Collar of HUCKBOLT® Fastener not completely swaged:
   b. Scored anvil in nose assembly.

9. Shear collar on Huck blind fastener not properly installed:
   b. Worn or damaged driving anvil in nose assembly.

10. Tool “hangs-up” on swaged collar of HUCKBOLT Fastener:
    b. RETURN pressure too low.
    c. Nose assembly not properly attached - see NOSE DATA SHEET.

11. Pintail of fastener fails to break:
    b. Pull grooves on fastener stripped. See 7.
    c. Worn piston and/or unloading valve.
    d. Hydraulic pressure too low.
    e. Damaged O-ring on piston.

12. Operator cannot slide nose assembly (completely) onto fastener:
    a. Broken pintails jammed in tool. Install pintail tube if broken pintails will pass through.
DISASSEMBLY

Refer to MAINTENANCE: General Precautions and illustrations.

The following procedure is for complete disassembly - disassemble only sub-assemblies necessary to check and replace damaged seals, wipers, back-up rings and components. **Always replace seals, wiper, O-rings and back-up rings of disassembled sub-assemblies** - see **CAUTION** at beginning of ASSEMBLY.

**WARNING:** Be sure electric control cord is disconnected from POWERIG® Hydraulic Unit before disconnecting tool’s hoses from hydraulic unit. **ALWAYS** disconnect connections in this order to prevent possible severe personal injury.

1. Disconnect electrical connector. Uncouple tool hydraulic hoses.

2. Remove tool’s retaining nut and nose assembly anvil. Unscrew collet from tool’s piston rod.


4. Push rearward on piston until remaining hydraulic fluid is drained into container. Discard fluid.

5. **NOTE:** **Do not remove hydraulic hoses from tool unless replacing hoses.** If necessary to remove hoses, uncover hose fittings by sliding plastic shrouds back.

6. **2580:** Loosen strain relief grommet. Loosen set screw and carefully pry switch out with a small screwdriver. Loosen two wires at rear of switch. Remove switch from cord. Pull cord out. Remove grommet. Disassemble electrical connector to replace connector, or to rewire it.

7. **A2580:** Unscrew air trigger assembly. Loosen air fitting. Pull out hose. Loosen air quick disconnect and remove.

8. Remove socket screw from rear gland and barbed retainer.

9. Insert two 5/16 pins in opposite holes in rear of barbed retainer. Using bar placed between pins, unscrew retainer.

10. Remove dump valve from open cylinder.

11. See Fig. 5- place Spacer, 123112-1, over threaded end of piston. Screw Piston Assembly Tool onto piston. Press or drive piston, front gland and rear gland out of cylinder - place hose ends in container to catch oil that is forced out by piston.

12. Use a small diameter dull pointed rod to remove all O-rings and seals - clean parts and examine for wear and other defects.
ASSEMBLY

Refer to appropriate illustrations and MAINTENANCE:
General Precautions - - clean out O-ring grooves and reinstall perishable parts - - see below.

1. Install GLYD RING assembly on piston as follows: Place the special O-ring in groove. Roll glyd ring’s diameter to a diameter smaller than piston before placing glyd ring on top of O-ring - - coat glyd ring with suitable lubricant to insure that ring stays in place during piston installation.

2. Taking care not to pinch inner ring, press POLY-SEAL into front gland housing. Install O-ring and back-up ring on front gland assembly.

3. See Fig. 6. Screw Assembly Tool, 123111-1, onto piston.

4. **CAUTION: Lubricate POLYSEAL’s inside diameter.**

   **NOTE:** To keep POLYSEAL in front gland, push front wiper housing into front gland. Hold housing against POLYSEAL while pressing front gland/POLY-SEAL onto piston.

5. **CAUTION: Be sure that seal does not hang up on edge of Piston chamfer.**

   See NOTE above - - press with suitable pressing drift against back of piston. While holding wiper housing in place, guide POLY-SEAL onto piston.

6. Press wiper into groove on wiper housing.

   **NOTE:** Thread retaining nut onto cylinder to act as stand-off.

7. Lubricate piston’s outer seal and POLY SEAL.

8. See Fig. 6 - - install GLYD RING Insertion Tool, 121694-2580 into cylinder to prevent damage to GLYD RING Assembly.

9. Carefully drive, or press, piston into cylinder.

10. Remove Tools, 121694-2580 and 123111-1. Install relief valve into piston with four flats toward REAR of tool.

11. **Install following in rear gland:** O-ring and back-up ring; POLY-SEAL, spacer and retaining ring; press assembled gland into cylinder; press wiper into groove in rear gland.


13. Screw barbed retainer into cylinder until it bottoms out. Back retainer out to first visible threaded hole in rear gland. Install and tighten locking screw to 35 +/-3 in. lbs. dash numbers correspond to the O-ring dash numbers.

14. **CAUTION: Do not use TEFLON® 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 503237.)**

If hydraulic hoses have been removed, thread hoses into handle. Slide shrouds over fittings.
15. **2580**: Assemble electrical cord to connector. Screw strain relief grommet into handle. Push cord through grommet. Attach cord to trigger switch. Press switch into handle and tighten set screw against switch. Pull excess cord down through handle and strain relief grommet. Tighten grommet.

**A2580**: Thread hose fitting into handle. Attach quick disconnect to airline. Attach air line to handle’s hose fitting. Screw air trigger assembly into handle’s trigger fitting and tighten set screw against fitting.


17. Before attaching nose assembly and using tool, read entire **PREPARATION FOR USE** section. Hold 3/8” hex wrench in back of tool when tightening collet. Use pintail tube if necessary.

**CAUTION**: Anvils with ears must have stop installed in position as shown to prevent damage to ears - - slide stop over anvil before installing retaining nut.

18. See **WARNING** in **DISASSEMBLY** and reverse the given procedure i. e. **CONNECT HOSES FIRST** and then, connect electrical control cord.

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**Subassembly Part Numbers and Notes**

Refer to Illustrations

1 A matching 12 ft. Hose Kit, 122854, is available.

2 123139 - Front Grand Assembly includes:

3 123136 - Piston Assembly includes:

4 123142 - Rear Gland Assembly includes:

5 123338 - Trigger Cord Assembly includes:

6 **CAUTION**: Install cups of POLY-SEALS and wipers as shown.

7 Torque screw, 506030, to 20+/-3 in. lbs.

8 Blind fasteners require pintail tube, 108279.
2580 Series Sectional View
**Fig. 3b**

A2580 Sectional View
2580 series Hydraulic Installation Tools (HK961) Alcoa Fastening Systems

Fig. 3c

2580-25 Sectional View
2580-12 Sectional View
Sticker Locations

The 2580 series tools come labeled with Sticker part number 590424-7400, which contains safety and pressure settings information. It is necessary that this sticker remain on the tool and is easily read. If sticker becomes damaged or worn, or if it have been removed from the tool, or when replacing Cylinder, this sticker must be ordered and placed in the location shown. Sticker locations and part numbers may be found in Figure3 through 3j.

Spare Parts Service Kit

The quantity of spare parts that should be kept on hand varies with the application and number of tools in service. Spare service kits, 2580KIT, containing perishable parts such as seals, back-up rings, etc., should be kept on hand at all times.

Table 2 - Service Kit, 2580KIT

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
<th>Quan.</th>
</tr>
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<tbody>
<tr>
<td>500824</td>
<td>O-RING</td>
<td>2</td>
</tr>
<tr>
<td>501118</td>
<td>BACK-UP RING</td>
<td>2</td>
</tr>
<tr>
<td>500780</td>
<td>O-RING</td>
<td>1</td>
</tr>
<tr>
<td>505991</td>
<td>WIPER</td>
<td>1</td>
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<tr>
<td>505894</td>
<td>WIPER</td>
<td>1</td>
</tr>
<tr>
<td>506160</td>
<td>POLY-SEAL</td>
<td>1</td>
</tr>
<tr>
<td>506181</td>
<td>POLY-SEAL</td>
<td>1</td>
</tr>
<tr>
<td>506180</td>
<td>GLYD-RING</td>
<td>1</td>
</tr>
<tr>
<td>* 500777</td>
<td>O-RING</td>
<td>1</td>
</tr>
<tr>
<td>* 500773</td>
<td>O-RING</td>
<td>1</td>
</tr>
<tr>
<td>* 504438</td>
<td>O-RING</td>
<td>1</td>
</tr>
<tr>
<td>* 501102</td>
<td>BACK-UP RING</td>
<td>1</td>
</tr>
<tr>
<td>8-2580</td>
<td>ASSEMBLY DWG. 2580 H.I.T.</td>
<td>1</td>
</tr>
<tr>
<td>* 8-A2580</td>
<td>ASSEMBLY DWG. A2580 H.I.T.</td>
<td>1</td>
</tr>
</tbody>
</table>

- Extra part numbers shown with asterisks are for A2580.
Conversion Kit, 123020

Conversion Kit, 123020, is supplied with each tool. Changing to kit’s older, heavier type hoses will then accommodate the following extension hose kits:

- 110838 12ft.
- 110839 26ft.
- 110840 38ft.
- 110841 52ft.

See appropriate section of DISASSEMBLY and ASSEMBLY

CAUTION: Do not use TEFLON® 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 503237.)

See MAINTENANCE: General Precautions.

123020 - Conversion Kit Includes:
110439 - Female Connector (1)
110438 - Male Connector (1)
503431 - Reducing Bushing (2)
110686 - Electric Male Connector (1)
505839 - Cable Tie (1)
Removing Piston
Installing Piston

Fig. 6

Press

121694-2580 GLYD-RING Insertion Tool

123111-1 Piston Assembly Tool
Optional Hose Kit, 122854

**IMPORTANT NOTE**

1. To use the new lighter type hoses/cord that are attached to the tool when purchased, one or more, optional 12' Hose Kit(s), 122854, must be purchased separately.

2. Female cord connector to extend beyond hose male connector 4.5 to 5.0 inches as shown.
Air and Hydraulic Conversion Kit, 125149
Converts existing tool into the -2 version with 2’ hoses.

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
<th>Quan.</th>
</tr>
</thead>
<tbody>
<tr>
<td>118944-2</td>
<td>Light Weight Hi-pressure Hose</td>
<td>2</td>
</tr>
<tr>
<td>122839</td>
<td>Female Q. D. Hyd. Fitting</td>
<td>1</td>
</tr>
<tr>
<td>122840</td>
<td>Male Q. D. Hyd. Fitting</td>
<td>1</td>
</tr>
<tr>
<td>112143-2</td>
<td>Air Hose</td>
<td>1</td>
</tr>
<tr>
<td>506973</td>
<td>Female Straight Connector</td>
<td>1</td>
</tr>
<tr>
<td>506267</td>
<td>Male Q. D. Air Fitting</td>
<td>1</td>
</tr>
</tbody>
</table>

Stroke Limiter Kit, 125143
Changes stroke of any 2580 tool to .625 in.

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
<th>Quan.</th>
</tr>
</thead>
<tbody>
<tr>
<td>125143</td>
<td>Stroke Limiter</td>
<td>1</td>
</tr>
<tr>
<td>123145-1</td>
<td>Dump Valve</td>
<td>1</td>
</tr>
</tbody>
</table>
1 INCLUDE 119345 AND CABLE TIE P/N 505833 LOOSE IN BAG.
2580 series Hydraulic Installation Tools (HK961)

- 590247 HUCK STICKER
- 620084 "MADE IN USA" STICKER
- 590337 HUCK ADDRESS STICKER
- 590189-2 PULL & RETURN PRESSURE STICKER
- 590240-1 PINTAIL DEFLECTOR WARNING STICKER
- 590350 CE SYMBOLS STICKER
- 590351 MAX PRESSURE & FLOW STICKER

506160 POLYSEAL
123138 FRONT WIPER HOUSING
505894 WIPER SEAL
123130 PIN TAIL TUBE
110670 STOP
117824 RETAINING NUT
123135 PISTON
501118 BACK-UP RING
500824 O-RING
123137 FRONT GLAND
506180 GLYD RING
123140 REAR GLAND
506181 POLYSEAL
505991 WIPER
122764 LOCKING DISC
123141 SPACER
506182 RETAINING RING
123145 DUMP VALVE
123639 CYLINDER/TUBE & FITTINGS ASSEMBLY

500824 O-RING
501118 BACK-UP RING
506030 SCREW

NOTES:
1. STROKE: 9.27 INCHES NOMINAL
   PULL CAPACITY AT 5700 PSI: 8240 LBS.
   PULL CAPACITY AT 7400 PSI: 10700 LBS.
2. SERVICE KIT A2580KIT AVAILABLE.
3. ASSEMBLE AND TEST PER HUCK SPEC 43-571
4. ASSEMBLY TOOL KIT 123110-1 IS AVAILABLE
   CONSISTING OF:
   GLYD RING INSERTION TOOL, 127396-2580, (1)
   PILOT ASSEMBLY TOOL, 123111-1, (1)
   SPACER 123112-1, (1)

PRINT THE FOLLOWING VALUES ON STICKER 590351 IN INDELIBILE INK: 7600 PSI, 56 BAR
CROSS OUT SCFM, I.WM, & BPM BLOCKS AS SHOWN.

110439 FEMALE CONNECTOR
110438 MALE CONNECTOR
118944-1 HOSE ASSEMBLY (2)
120770-2 HOSE SLEEVE
503431 REDUCING BUSHING (2)
2580 series Hydraulic Installation Tools (HK961)

**NOTES:**

1. **STROKE:** 9.7 INCHES NOMINAL
   - Pull capacity at 5700 PSI: 8240 LBS.
   - Pull capacity at 7400 PSI: 10700 LBS.

2. **SERVICE KIT** 2580HT AVAILABLE.

3. **ASSEMBLE AND TEST HUCK SPEC 42-571.**

4. **ASSEMBLY TOOL KIT 12310-1 AVAILABLE CONSISTING OF:**
   - GLYD RING INSERTION TOOL 12694-2086, (3)
   - PINION ASSEMBLY TOOL 12311-1, (1)
   - SPACER 12312-1, (4)

5. **REMOTE TRIGGER PARTS 12338-24**
   - Optionally Available
**LIMITED WARRANTIES**

**Tooling Warranty:**
Huck warrants that tooling and other items (excluding fasteners, and hereinafter referred to as "other items") manufactured by Huck shall be free from defects in workmanship and materials for a period of ninety (90) days from the date of original purchase.

**Warranty on "Non Standard or Custom Manufactured Products":**
With regard to non-standard products or custom manufactured products to customer's specifications, Huck warrants for a period of ninety (90) days from the date of purchase that such products shall meet Buyer's specifications, be free of defects in workmanship and materials. Such warranty shall not be effective with respect to non-standard or custom products manufactured using buyer-supplied molds, material, tooling and fixtures that are not in good condition or repair and suitable for their intended purpose.

**There are no warranties which extend beyond the description on the face hereof. Huck makes no other warranties and expressly disclaims any other warranties, including implied warranties as to merchantability or as to the fitness of the tooling, other items, nonstandard or custom manufactured products for any particular purpose and Huck shall not be liable for any loss or damage, directly or indirectly, arising from the use of such tooling, other items, nonstandard or custom manufactured products or breach of warranty or for any claim for incidental or consequential damages.**

Huck's sole liability and Buyer's exclusive remedy for any breach of warranty shall be limited, at Huck's option, to replacement or repair, at FOB Huck's plant, of Huck manufactured tooling, other items, nonstandard or custom products found to be defective in specifications, workmanship and materials not otherwise the direct or indirect cause of Buyer supplied molds, material, tooling or fixtures. Buyer shall give Huck written notice of claims for defects within the ninety (90) day warranty period for tooling, other items, nonstandard or custom products described above and Huck shall inspect products for which such claim is made.

**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.

The only warranties made with respect to such tool, part(s) or other items thereof are those made by the manufacturer thereof and Huck agrees to cooperate with Buyer in enforcing such warranties when such action is necessary.

Huck shall not be liable for any loss or damage resulting from delays or nonfulfillment 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 Office, see back cover.

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 Tools 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.