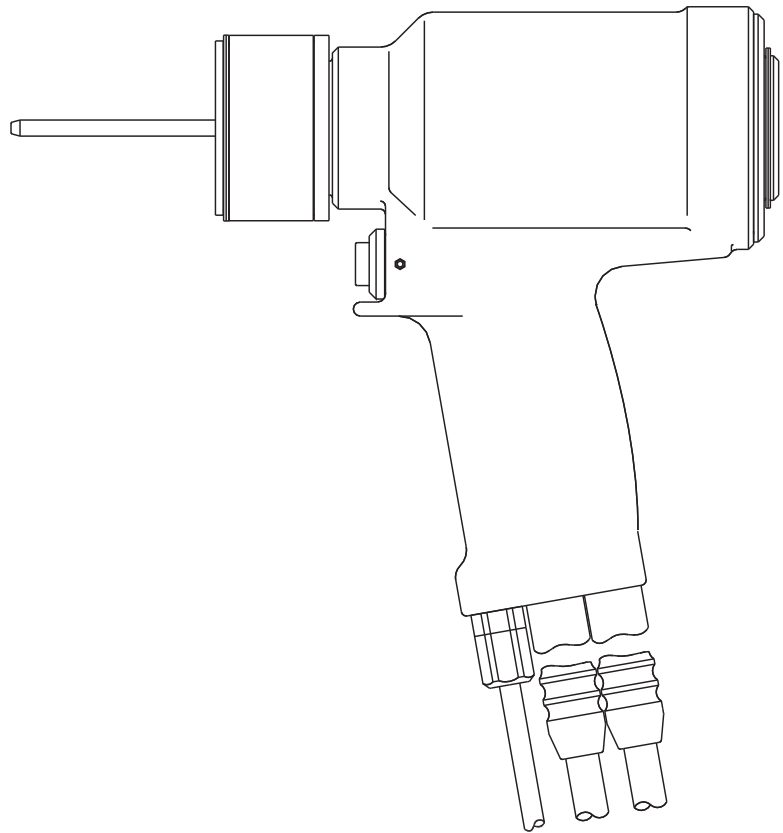


**Alcoa
Fastening
Systems**



INSTRUCTION MANUAL
2620
A2620
2620-PT
A2620-PT
HYDRAULIC INSTALLATION TOOLS



Makers of Huck®, Marson®, Recoil®
Brand Fasteners, Tools & Accessories





EC Declaration of Conformity

Manufacturer:

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

Description of Machinery:

Models 2600 and 2620 hydraulic installation tools, and specials based on their designs.(e.g. PR####)

Relevant provisions complied with:

Council Directive related to Machinery (2006/42/EC)

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:

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: 89 dB (reference 1 pW)
Uncertainty, KWA: 3 dB

A weighted emission sound pressure level at the work station, LpA: 78 dB
(reference 20 μ Pa)
Uncertainty, KpA: 3 dB

C-weighted peak emission sound pressure level, LpC, peak: 122 dB
(reference 20 μ Pa)
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, a: 1.5 m/s²

Uncertainty, K: .51 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.

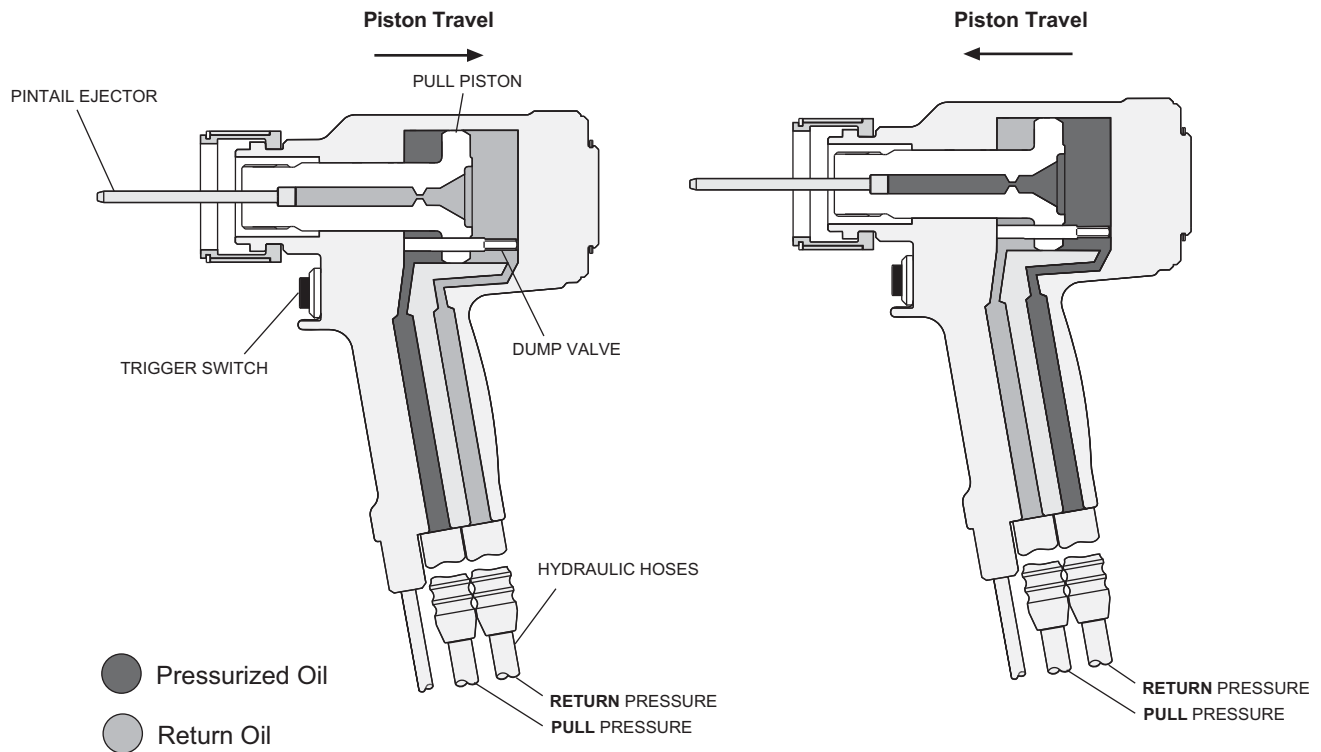
Notes: are reminders of required procedures.

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 pneudraulic 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.



PRINCIPLE OF OPERATION



Pull Pressure (Pull Cycle)
Fig. 1(a)

Return Pressure (Return Cycle)
Fig. 1(b)

When the trigger is depressed, a solenoid operated valve in the POWERIG® directs pressurized hydraulic fluid through the PULL hose to the front side of the piston, and allows fluid on the RETURN side to flow back to the tank (Fig 1a). The piston and nose assembly collet moves rearward installing the fastener. When the piston reaches the end of the PULL stroke, it uncovers flats on the rear end of the unloading valve. These flats are designed to provide a passage for hydraulic fluid from the PULL side to the RETURN side of

the piston, “unloading” or “dumping” the pressurized fluid back to the tank (Fig 1a). When the trigger is released the solenoid is de-energized and the valve directs pressurized fluid to the rear side of the piston and allows fluid on the PULL side to flow back to the tank (Fig. 1b). This causes piston and collet to move forward and pushes the nose assembly and tool off the swaged (installed) fastener. When the piston reaches the end of the return stroke, pressure is built up, causing the power rig to shut off, completing the cycle.



SPECIFICATIONS - ALL MODELS

POWER SOURCE:

Huck POWERIG Hydraulic Unit

HOSE KITS:

Use only genuine HUCK Hose Kits rated @ 10,000 psi working pressure.

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."

MAX OPERATING TEMP:

125°F (51.7°C)

MAX FLOW RATE:

2 gpm (7.5 l/m)

MAX PULL PRESSURE:

7400 psi (510 bar)

PULL CAPACITY:

19,830 lbs (88.21 kN) @ 7400 psi

STROKE:

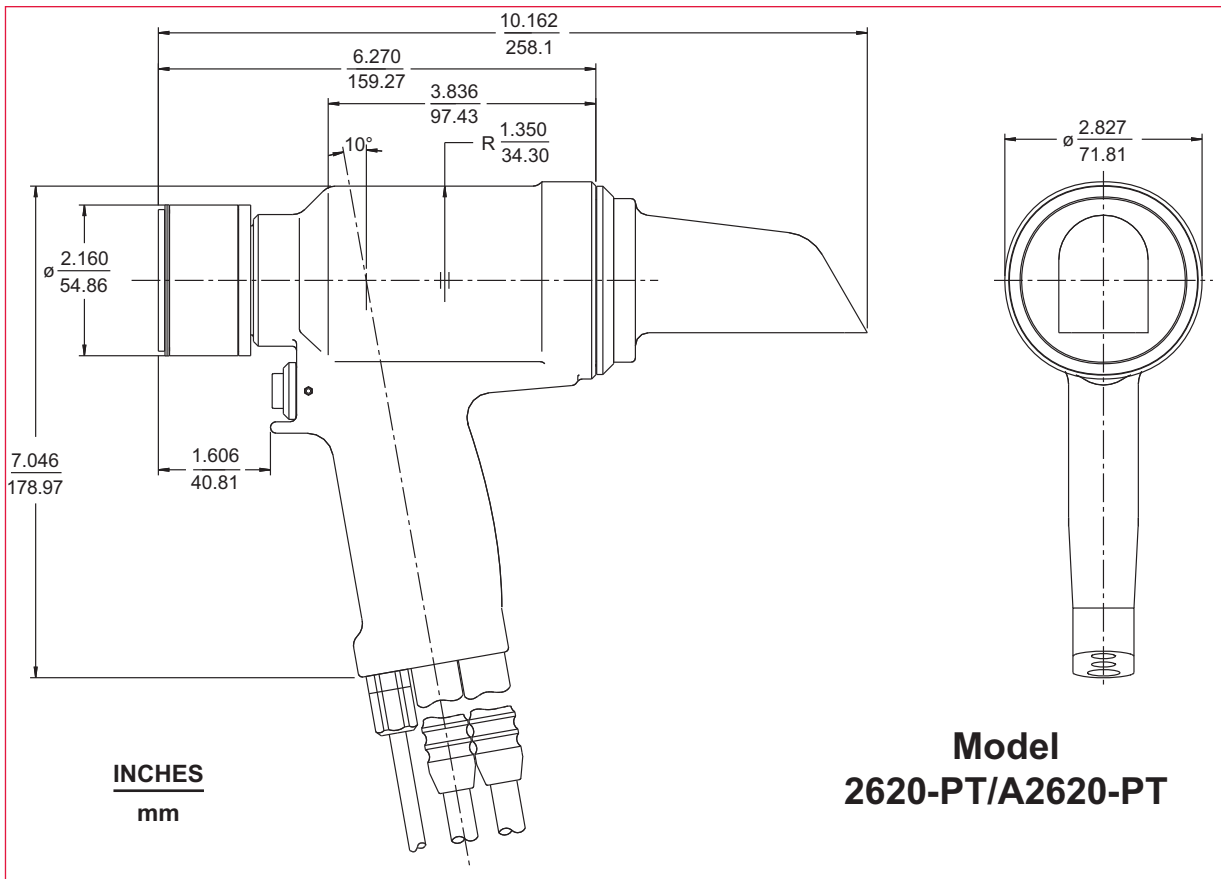
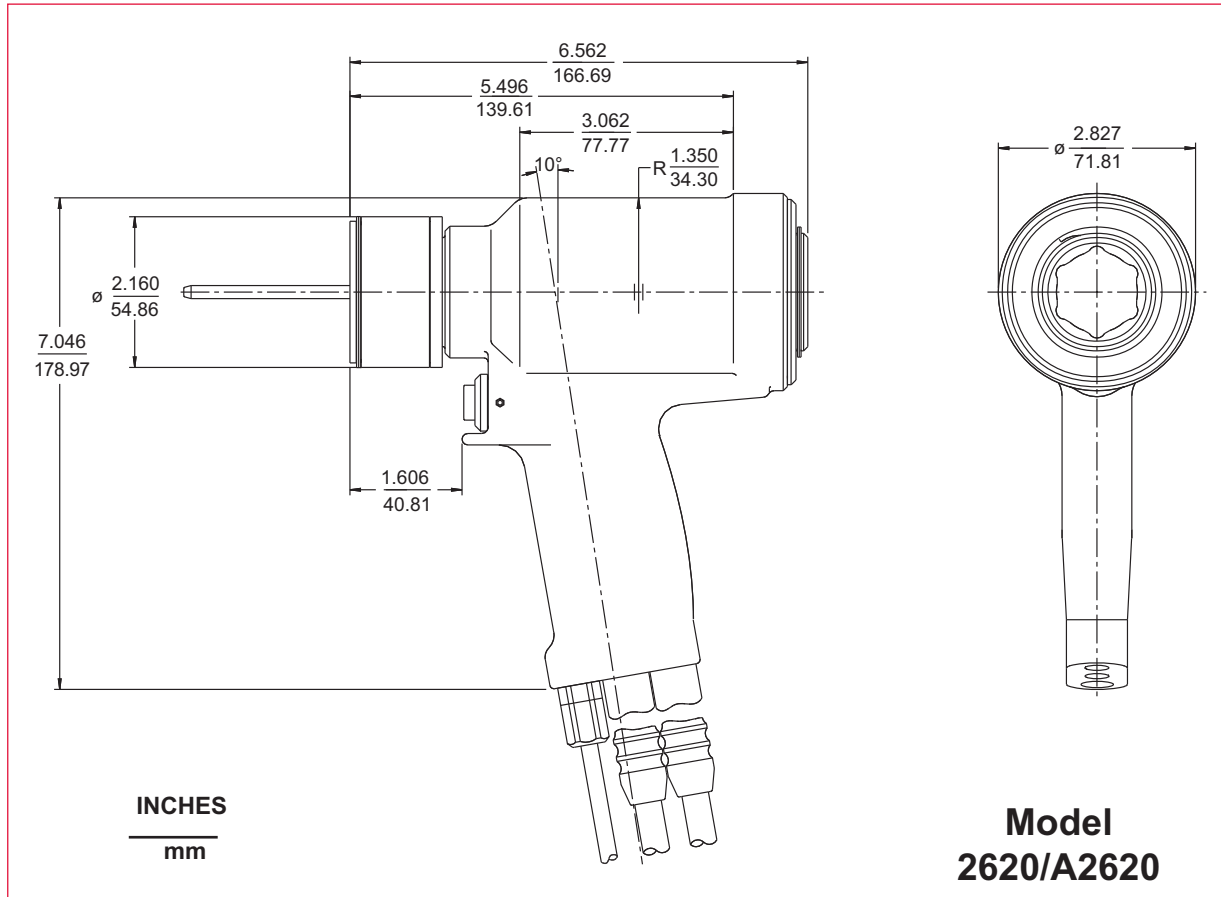
1.437 inches (3.65 cm)

WEIGHT:

9.87 lbs (4.48 kg)



SPECIFICATIONS (CONTINUED)





PREPARATION FOR USE



WARNINGS:

Read full manual before using tool.

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

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

Be sure there is adequate clearance for the operator's hands before proceeding.



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.



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.)



Huck recommends that only Huck Powerig Hydraulic Units be used as a power source for Huck installation equipment. Hydraulic power units that deliver high pressure for both PULL and RETURN, **AND ARE NOT EQUIPPED WITH RELIEF VALVES ARE SPECIFICALLY NOT RECOMMENDED AND MAY BE DANGEROUS.**

POWER SOURCE CONNECTIONS

Coat hose fitting threads with a non-hardening Teflon™ thread compound such as Slic-tite.™

1. Use Huck POWERIG® Hydraulic Unit, or equivalent, that has been prepared for operation per applicable instruction manual. Check both PULL and RETURN pressures, and if required, adjust to pressures given in **SPECIFICATIONS**.
2. First, turn hydraulic unit to OFF, and then, disconnect power supply from unit. Connect tool's hoses to Powerig unit.
3. Connect tool's control switch electrical cord to hydraulic unit.



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 and **disconnected in the reverse order**, severe personal injury may occur.

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 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. Pressure Gauge T-124883CE is available for checking pressures. See Tool SPECIFICATIONS and Gauge Instruction Manual. Failure to verify pressures may result in severe personal injury.

GOOD SERVICE PRACTICES

Sealants, Lubricants, Hydraulic Fluid & Service Kits

- Rub Slic-Tite TEFLON thread compound, or equivalent, on pipe threads to prevent leaks and for ease of assembly.
- Smear LUBRIPLATE®* No. 130-AA, or equivalent, on O-rings and mating surfaces to prevent damaging O-rings on rough or sharp surfaces. Also, increases ease of assembly. (LUBRIPLATE in a tube, 502723).

* Slic-Tite is a registered trademark of LA-CO Industries, Inc.

* TEFLON is a registered trademark of DuPont Corp.

* LUBRIPLATE is a registered trademark of LUBRIPLATE Lubricants Co.



OPERATING INSTRUCTIONS



WARNING: Reasonable care of installation tools by operators is an important factor in maintaining tool efficiency and in reducing repair downtime. 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. Do not connect tool's hoses to each other or use hoses as a handle for carrying.



WARNING: Do not pull on a fastener without a collar. If a fastener is pulled without a collar, the fastener will eject forcibly when the pintail breaks off.

TO INSTALL A HUCKBOLT® FASTENER

1. Check work and remove excessive gap in the space between sheets. Gap is excessive if not enough pintail sticks through the collar for the nose assembly jaws to grab onto.

2. Put fastener into hole.
3. Slide collar over fastener. (The beveled end of the collar must be towards the nose assembly and tool.)
4. Push nose assembly onto the fastener until the nose assembly anvil stops against the collar. Tool and nose assembly must be held at right angles (90°) to the work.
5. Depress tool switch to start installation cycle.
6. When forward motion of nose assembly anvil stops and pintail breaks off, release switch. Tool will go into its return stroke, push off the installed fastener and eject the pintail.
7. The tool and nose assembly is ready for the next installation cycle.

SERVICING THE TOOL



CAUTIONS:

- Consult MSDS before servicing tool.
- Keep dirt and other material out of hydraulic system.
- Separated parts must be kept away from dirty work surfaces.
- Dirt/debris in hydraulic fluid causes Dump Valve failure in Tool and in POWERIG® Hydraulic Unit's valves.
- Always check tool assembly drawing for the proper direction of the flats on the Dump Valve.

See SPECIFICATIONS for fluid type. Dispose of fluid in accordance with local environmental regulations. Recycle steel, aluminum, and plastic parts in accordance with local lawful and safe practices.

PREVENTIVE MAINTENANCE

NOTE: For supplementary information refer to TROUBLESHOOTING, Parts Lists, and DISASSEMBLY AND ASSEMBLY procedures in this manual.



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.)



CAUTION: Always replace seals, wipers, and back-up rings when tool is disassembled for any reason.

SYSTEM INSPECTION

Operating efficiency of the installation tool is directly related to performance of the complete system, including the tool with nose assembly, hydraulic hoses, trigger and control cord, and POWERIG. Therefore, an effective preventive maintenance program includes scheduled inspections of the system to detect and correct minor troubles.

1. Inspect tool and nose for external damage.
2. Verify that hydraulic hose fittings and couplings and electrical connections are secure.
3. Inspect hydraulic hose for signs of damage or aging. Replace hoses if damaged.
4. Inspect tool, hose, and POWERIG during operation to detect abnormal heating, leaks, or vibration.

POWERIG MAINTENANCE

Maintenance instructions and repair procedures are in the appropriate POWERIG Instruction Manual.

TOOL MAINTENANCE

At regular intervals, depending on use, replace all O-rings and back-up rings in the tool. Spare Parts Kit part no. **2620KIT** or **2620-PTKIT** 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.

NOSE ASSEMBLY MAINTENANCE

Daily cleaning of the nose assembly is recommended. This can usually be accomplished by dipping nose assembly in mineral spirits, or other suitable solvent, to clean jaws and wash away metal chips and dirt. If more thorough cleaning or maintenance is necessary, disassemble the nose assembly. Use a sharp pointed "pick" to remove imbedded particles from the pull grooves of the jaws.



DISASSEMBLY - ALL MODELS

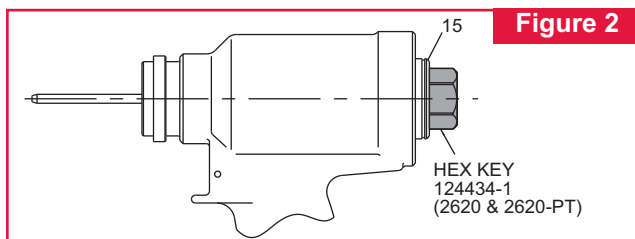
(Refer to Figures 2-4 & 8-13) **For component identification and Parts Lists refer to Figures 8-13.**

NOTE: The following procedure is for complete disassembly of tool. Disassemble **only** components necessary to replace damaged O-rings, Quad-Rings, Back-up Rings, and worn or damaged components. Always use soft jaw vice to avoid damage to tool.

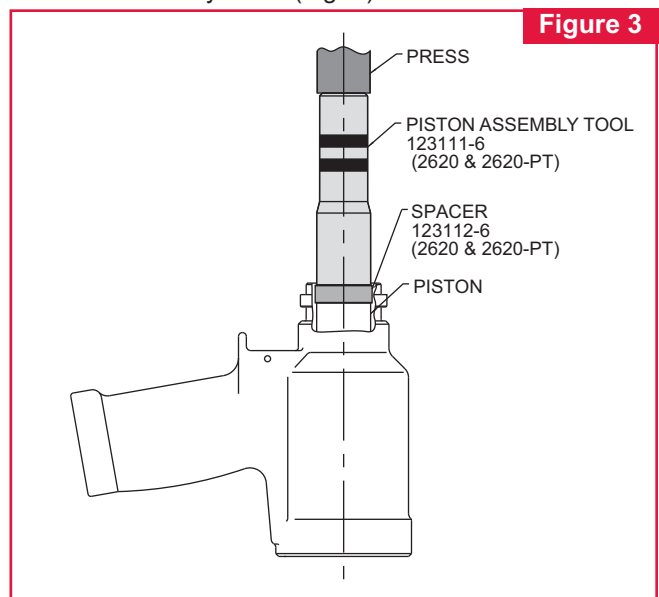


WARNING: Be sure to disconnect tool's electric control trigger system from Hydraulic Unit before disconnecting tool's hoses from unit. Before any maintenance is done, DISCONNECT IN THIS ORDER (RECONNECT IN THE OPPOSITE ORDER) to avoid possible severe personal injury.

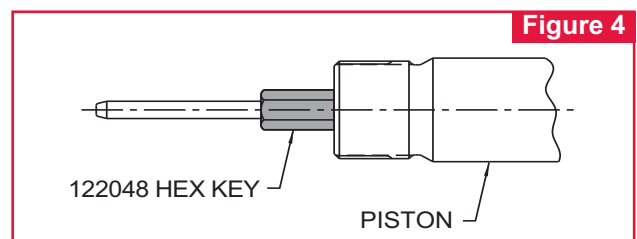
1. Disconnect electrical or air connector from Powerig. Uncouple tool hydraulic hoses.
2. Remove nose assembly.
3. Unscrew coupling nipple and coupling body. Drain hydraulic hoses into container. Discard fluid.
4. Push rearward on Piston (4) until remaining hydraulic fluid is drained into container. Discard fluid.
5. **NOTE:** Do not remove hydraulic hoses from tool unless replacing hoses. If it is necessary to remove hoses, uncover hose fittings by sliding plastic shrouds back.
6. **NOTE:** Use the following steps **only** if the switch, wire or connector needs repair.
2620, 2620-PT Models Only
 Remove Retaining Nut and Locking ferrule from Strain Relief (20). Loosen setscrew (37) and remove switch (21). Loosen and remove the two wires from the switch. Remove cord from tool. Disassemble electrical connector (110686) (Figs. 8, 9, & 12).
A2620, A2620-PT Models Only
 Unscrew and remove Air Switch (21). Remove Retaining Nut and Locking ferrule from Air Fitting (20). Remove plastic tubing and unscrew remaining part of fitting (20) from handle (Fig. 10, 11 & 13).
7. Standard Models: (Fig. 8 & 10)
 Remove Retaining Ring (17), cover plate (16) and Locking Disk (18).
2620-PT Model: (Fig. 9 & 11)
 Remove Deflector (32), Screws (31), Barbed Retainer (30) and locking disk (18).



8. Insert hex key in End Cap (15) as shown in Figure 2. Using a wrench unscrew end cap from cylinder.
9. Standard Models: (Fig. 8 & 10)
 Remove O-ring (9) and Back-up Ring (8)
2620-PT Model: (Fig. 9 & 11)
 Remove O-ring (9), Back-up Ring (8), retaining ring (36), washer (35), polyseal (34) and wiper seal (33).
10. Remove Dump Valve (19) from rear of cylinder.
11. Slide Spacer (123112-6/7) over piston and thread on Piston Assembly Tool (123111-6/7). Using a press push front gland and piston assemblies out of the back of the cylinder. (Fig. 3)



12. Remove Piston Assembly Tool (123111-6/7) and Spacer (123112-6/7) (Fig. 3).
13. Slide Front Gland (11) off of Piston (4) and remove Wiper (6), Wiper Housing (7), Back-up Ring (8), O-ring (9) and Polyseal (10) (Fig. 8 - 11).
14. Remove GLYD Ring (13) from Piston (4) (Fig. 5).
15. Standard Models Only: (Fig. 4, 8 & 10)
 Hold Piston (4) in a vise with soft jaws and remove Ejector Gland Assembly (22) with Hex Key 122048
16. Standard Models Only: (Fig. 4, 8 & 10)
 Remove from gland, Ejector Rod (29), Washer (23), O-rings (24), Wiper (26) Quad-Ring (28) and Back-up Ring (27).





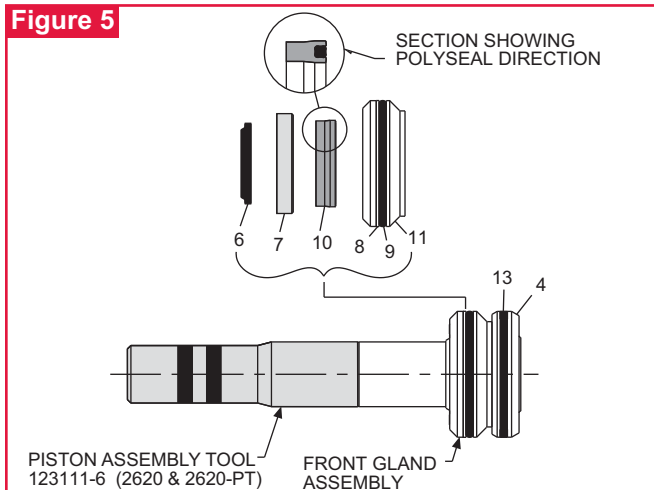
ASSEMBLY - ALL MODELS

(Refer to Figures 2, 4, 5, & 8-13) **For component identification and Parts Lists, refer to Figures 8-11.**

NOTE: Clean components with mineral spirits, or similar solvent. Inspect for wear/damage and replace as necessary. Replace all seals of disassembled components. Use O-rings, Quad-Rings and Back-up Rings in **Service Parts Kit 2620KIT and 2620-PTKIT**. Smear LUBRIPLATE 130AA or PARKER-O-LUBE on O-rings, Quad-Rings, Back-up Rings and mating parts to ease assembly. Assemble tool taking care not to damage O-rings, Quad-Rings, or Back-up Rings.

1. Standard Models Only: (Fig. 8 & 10) Install Back-up Ring (27), Quad-Ring (28), Wiper (26), O-rings (24), Washer (23) and Ejector Rod (29) into Ejector Gland (25).
2. Standard Models Only: (Fig. 4, 8 & 10) Hold Piston (4) in a vise with soft jaws and install assembled Ejector Gland (22). Use Hex Key 122048 to tighten.
3. Thread Piston Assy Tool (123111-6/7), onto Piston (4) (Fig. 5). **Note: Do not install spacer 123112-6/7.**

Figure 5



4. Install GLYD Ring (13) onto Piston (4).
5. Install Polyseal (10), O-ring (9), Back-up Ring (8), Wiper Housing (7) and Wiper (6) into Front Gland (11).
6. Lubricate Piston Assembly Tool and Piston, then slide assembled Gland (11) over Piston Assembly Tool onto Piston.
7. Thread GLYD Ring Insertion Tool (121694-2620) into the back of the Cylinder (Fig. 6).
8. Using a press, push Piston and Front Gland Assemblies into the back of Cylinder (5). (Fig. 6)
9. Remove Piston Assembly Tool (123111-6/7).
10. Remove the GLYD Ring Insertion Tool (121694-2620) from the back of the Cylinder (Fig.6).
11. From rear of Cylinder, install Dump Valve (19) with the four flats facing the rear of the tool (Figs. 8-11).

12. Standard Models: (Fig. 8 & 10) Install O-ring (9) and Back-up Ring (8) on End Cap (15).
2620-PT Model: (Fig.7, 9 & 11) Install Back-up Ring (8), O-ring (9), Wiper (33), Polyseal (34), Washer (35) and Retaining Ring (36) into End Cap (15).

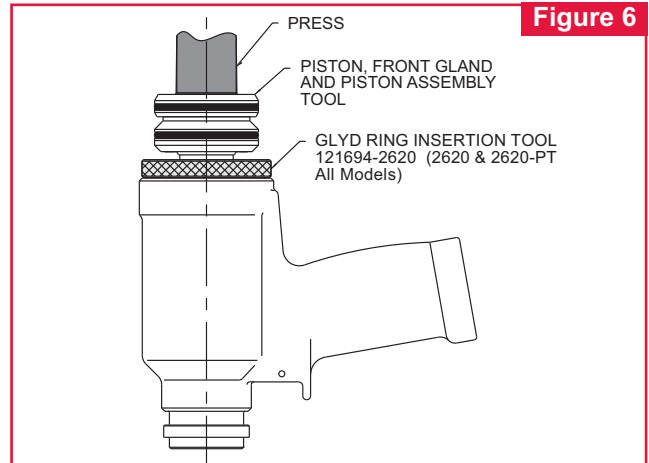


Figure 6

13. Insert Hex Key into the End Cap (15). Using a wrench thread the End Cap into the back of the Cylinder and tighten (Fig. 2).
14. Standard Models: (Fig. 8 & 10) Install Locking Disk (18), Cover Plate (16) and Retaining Ring (17).
2620-PT: (Fig. 9 & 11) Install Locking Disk (18), Barbed Retainer (30), Screws (31) and Deflector (32).
15. If removed, reinstall Electrical/Air Connector.
16. **NOTE:** If switch or wire have been removed, replace as follows:
2620, 2620-PT Only Slide Retaining Nut and Ferrule onto Electrical Wire. Feed Wire through Handle and pull out through Trigger Switch hole. Attach Wires to Switch (21) and push assembly back into Handle. Tighten Screw (37) to hold Trigger Switch in place. Slide Ferrule into Strain Relief Housing, then thread and tighten Retaining Nut (Fig. 12).
A2620, A2620-PT Only Install fitting (20) into handle. Slide retaining nut and ferrule over plastic tubing. Slide tubing into fitting (20) and tighten retaining nut. Screw in air trigger (21) and tighten(Fig. 13).
17. If removed, install one hydraulic Hose in Handle port marked "P" and one in port marked "R".



CAUTION: Do not use Teflon tape on pipe threads. See SERVICING THE TOOL section of this manual.

18. Install Coupler Nipple 110438, (PULL pressure hose); Coupler Body, (RETURN pressure hose) (Fig. 12 & 13).

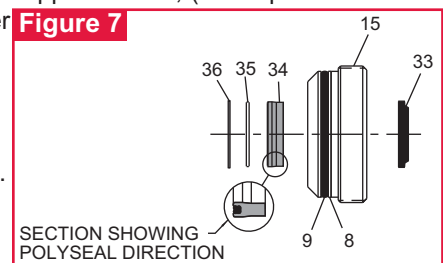
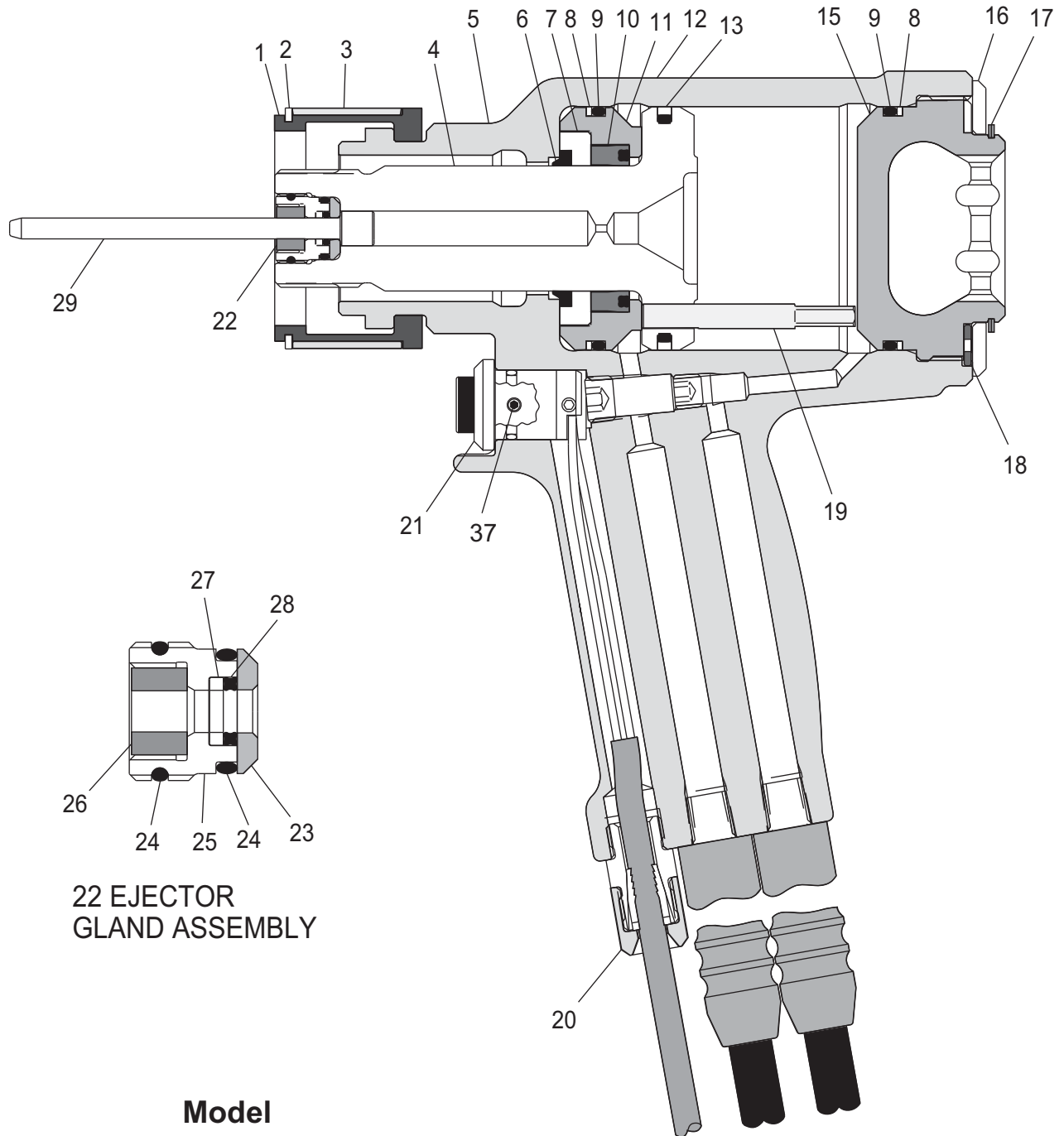


Figure 7



ASSEMBLY DRAWING 2620 & 2620-15

FIG 8

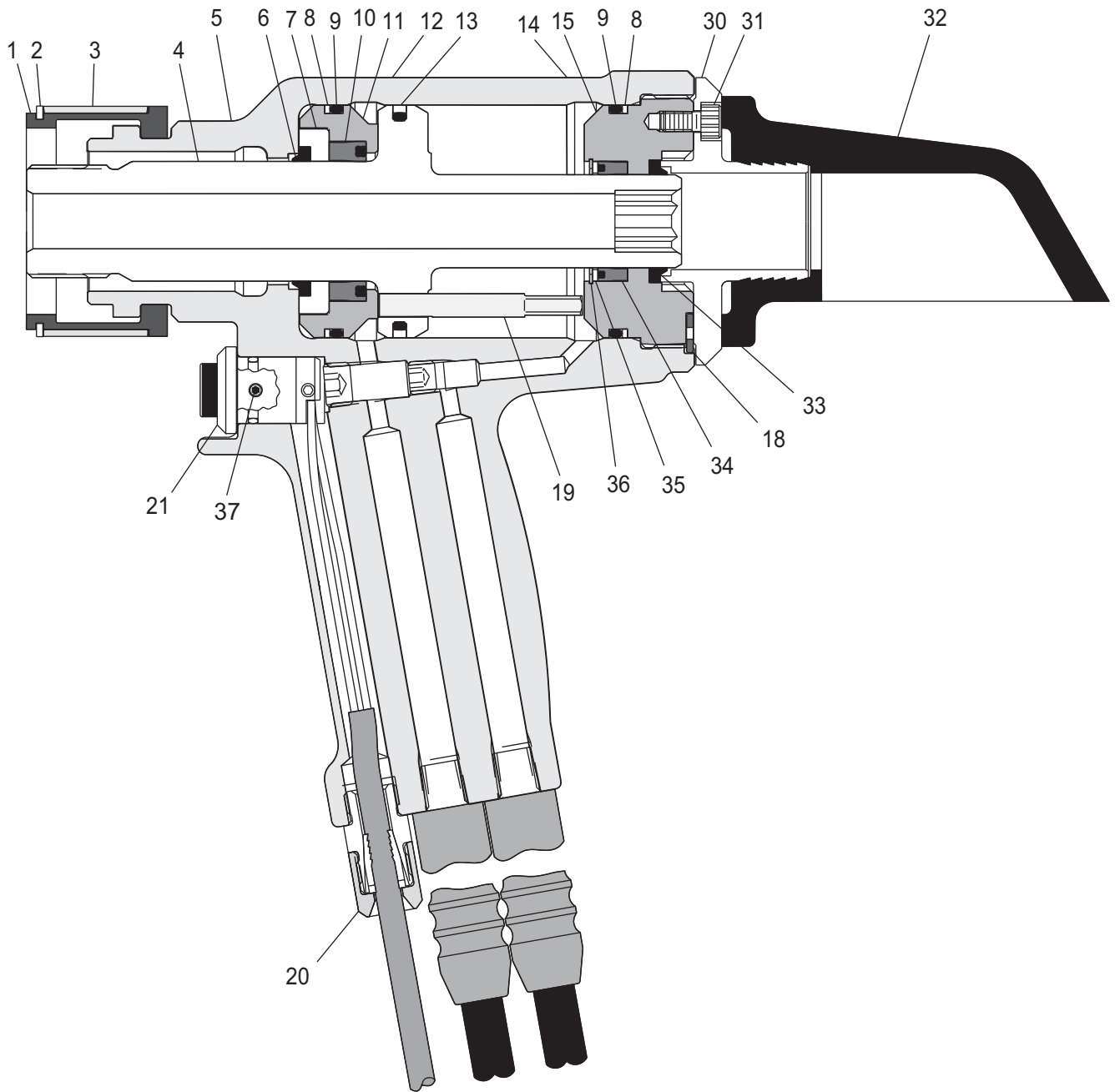


**Model
2620 & 2620-15**



ASSEMBLY DRAWING 2620-PT & 2620-PT-15

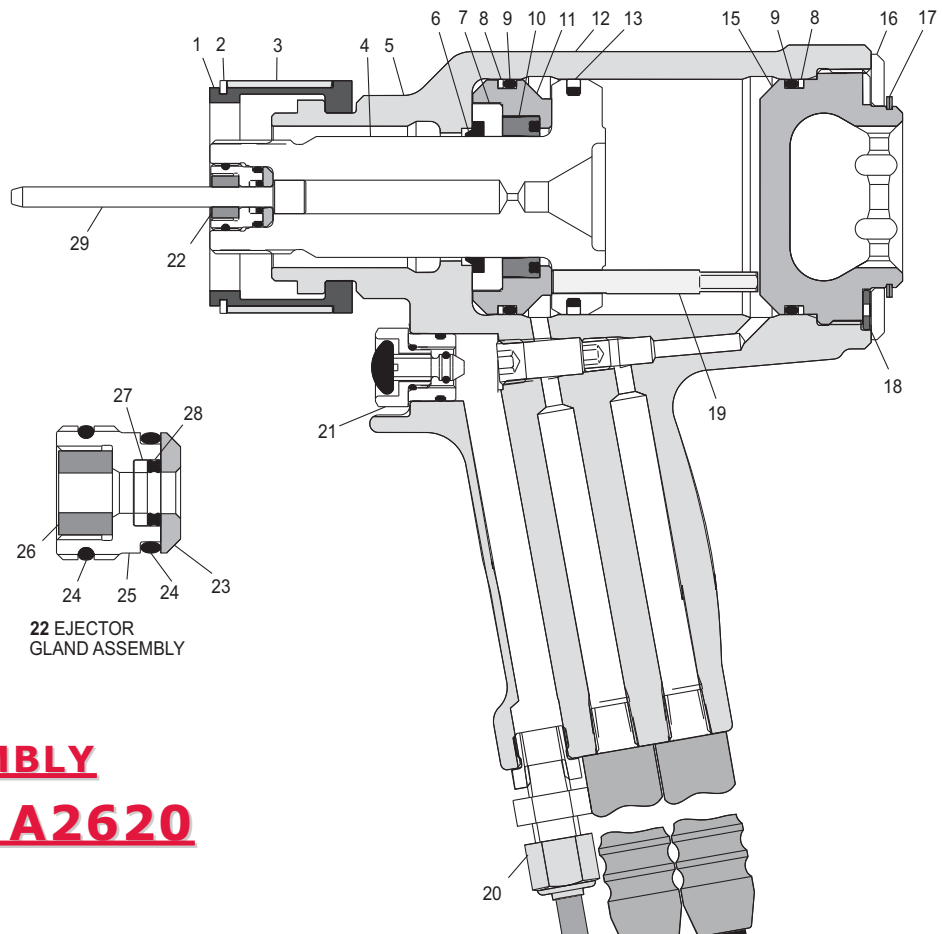
FIG 9



Model
2620-PT & 2620-PT-15



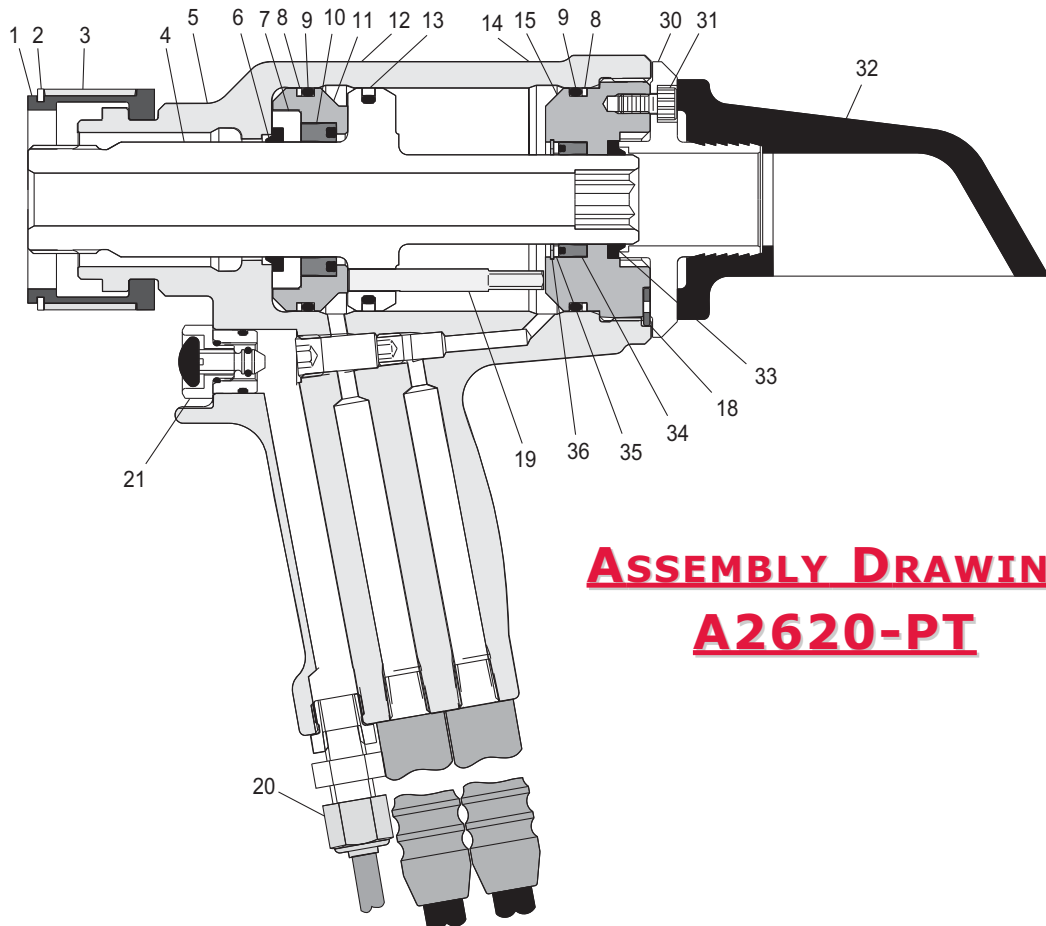
Figure 10



22 EJECTOR
GLAND ASSEMBLY

ASSEMBLY
DRAWING A2620

Figure 11



ASSEMBLY DRAWING
A2620-PT



PARTS LIST (Figures 1, 2A, 2B, and 2C)

Item	Description	Qty	2620 2620-15	A2620	2620-PT 2620-PT-15	A2620-PT
1	Split Ring	1	102147	102147	102147	102147
2	Retaining Ring	1	501514	501514	501514	501514
3	Retaining Sleeve	1	102148	102148	102148	102148
4	Piston	1	125612*	125612*	125761**	125761**
5	Cylinder Assembly	1	126152	126152	126152	126152
6	Wiper Seal	1	507407	507407	507407	507407
7	Wiper Housing	1	125610	125610	125610	125610
8	Back-up Ring	2	501127	501127	501127	501127
9	O-ring	2	507412	507412	507412	507412
10	Polyseal	1	507408	507408	507408	507408
11	Front Gland	1	125609	125609	125609	125609
12	HUCK Sticker	1	590517	590517	590517	590517
13	GLYD Ring Assembly	1	122769-1	122769-1	122769-1	122769-1
14	CE & Warning Sticker	1	590424-7400	590424-7400	590424-7400	590424-7400
15	End Cap	1	125614	125614	125763	125763
16	Cover Plate	1	125617	125617	-----	-----
17	Retaining Ring	1	507406	507406	-----	-----
18	Locking Disc	1	122764	122764	122764	122764
19	Dump Valve	1	125616	125616	125616	125616
20	Strain Relief or Air Fitting	1	505344	503902	505344	503902
21	Trigger Switch Assembly	1	120361	119345-1	120361	119345-1
22	Ejector Gland Assembly	1	120653	120653	-----	-----
23	Ejector Washer	1	120652	120652	-----	-----
24	O-ring	2	500779	500779	-----	-----
25	Gland	1	122047	122047	-----	-----
26	Rod Wiper	1	122742	122742	-----	-----
27	Back-up Ring	1	501080	501080	-----	-----
28	Quad-Ring	1	501411	501411	-----	-----
29	Pintail Ejector	1	122705	122705	-----	-----
30	Barbed Retainer	1	-----	-----	125765	125765
31	Screws	3	-----	-----	500060	500060
32	Deflector	1	-----	-----	122766	122766
33	Wiper Seal	1	-----	-----	505894	505894
34	Polyseal	1	-----	-----	506160	506160
35	Spacer	1	-----	-----	122762	122762
36	Retaining Ring	1	-----	-----	506159	506159
37	Set Screw	1	501731	501731	501731	501731

* Piston 125612 is not sold separately. It may be purchased as Piston Assembly part no. 125613, which contains Piston 125612 and GLYD Ring Assembly 122769-1.

** Piston 125761 is not sold separately. It may be purchased as Piston Assembly part no. 125762, which contains Piston 125761 and GLYD Ring Assembly 122769-1.

STICKER LOCATIONS

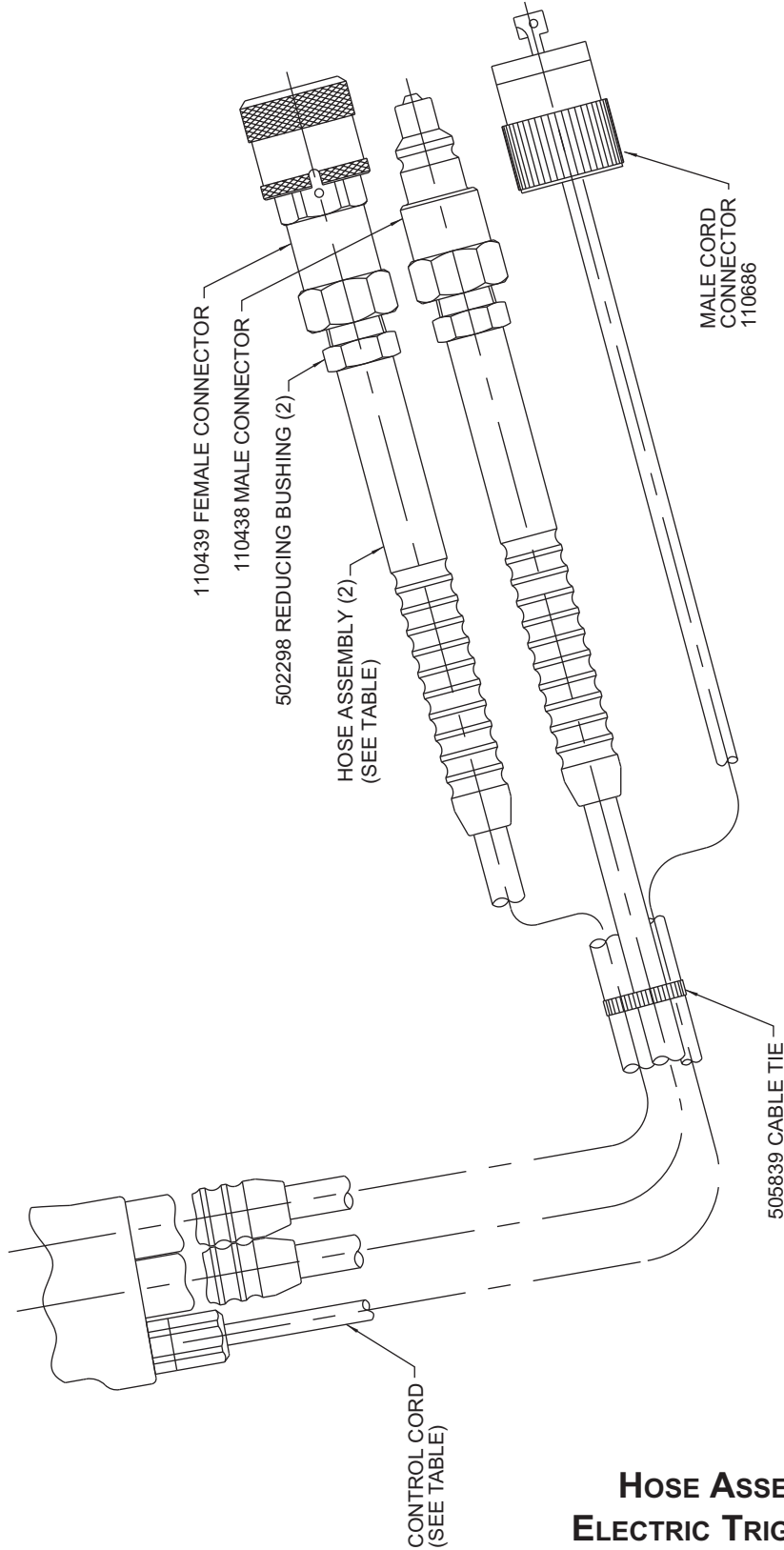
The 2620 series tools come labeled with Sticker part number 590424-7400, which contains safety and pressure settings information. It is necessary that this sticker remain on the tool and is easily read. If sticker becomes damaged or worn, or if it have been removed from the tool, or **when replacing Cylinder, this sticker must be ordered and placed in the location shown.** Sticker locations and part numbers may be found in Figure 6 and Parts List.



FIG 12

MODEL SELECTION

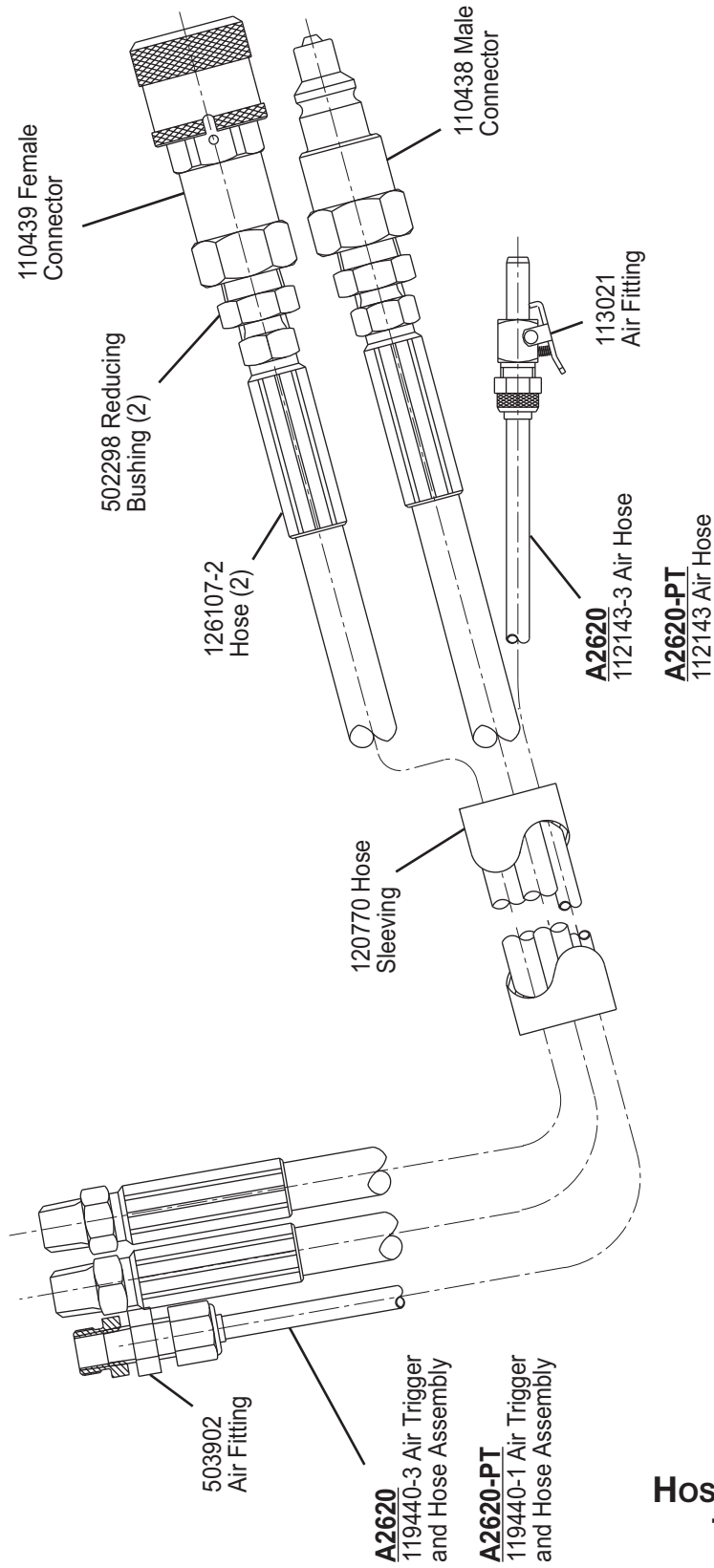
MODEL(S)	HOSE ASSEMBLY	CONTROL CORD
2620, 2620PT	126107-1	123337-1
2620-15, 2620-PT-15	126107-2	123336



HOSE ASSEMBLY FOR
ELECTRIC TRIGGER MODELS



FIG 13



HOSE ASSEMBLY FOR AIR TRIGGER MODELS



TROUBLESHOOTING

Always check the simplest possible cause of a malfunction first. For example, a loose or disconnected trigger line. Then proceed logically and eliminate each possible cause until the defect is found. Where possible, substitute known good parts for suspected defective parts. Use the following steps as an aid in troubleshooting.

1. *Tool fails to operate when trigger is pressed.*
 - a. Inoperative POWERIG® Hydraulic Unit. See applicable instruction manual.
 - b. Loose electrical connections.
 - c. Damaged trigger assembly.
 - d. Loose or faulty hose coupling.
2. *Tool operates in reverse.*
 - a. Reversed hose connections between hydraulic unit and tool.
3. *Tool leaks hydraulic fluid.*
 - a. Defective tool O-rings or loose connections at tool.
4. *Hydraulic couplers leak fluid.*
 - a. Damaged or worn O-rings in Coupler Body Coupler P/N 110440.
5. *Hydraulic fluid overheats.*
 - a. Unit not operating properly - - see units manual.
 - b. Unit running in reverse (918; 918-5 only) - - see units manual.
6. *Tool operates erratically and fails to install fastener properly.*
 - a. Low or erratic hydraulic pressure - - air in system.
 - b. Damaged or worn Piston O-ring in tool.
 - c. Excessive wear on sliding surfaces of tool parts.
7. *Pull grooves on fastener pintail stripped during PULL stroke.*
 - a. Operator not sliding anvil completely onto fastener pintail.
 - b. Incorrect fastener grip.
 - c. Worn or damaged jaw segments.
 - d. Metal particles in jaw grooves.
 - e. Excessive sheet gap.
8. *Collar of fastener not completely swaged.*
 - a. Improper tool operation - - see No. 6.
 - b. Scored anvil.
9. *Tool "hangs up" on swaged collar of fastener.*
 - a. Improper tool operation - - see No. 6.
 - b. RETURN pressure too low.

- c. Not enough collar lubricant.
 - d. Nose assembly not installed per NOSE ASSEMBLY DATA SHEET.
10. *Pintail of fastener fails to break.*
 - a. Improper tool operation - - see No. 6.
 - b. Pull grooves on fastener stripped - - see No. 7.
 - c. PULL pressure too low.
11. *Nose will not release broken pintail.*
 - a. Nose assembly not installed per NOSE ASSEMBLY DATA SHEET.

KITS AND ACCESSORIES

Service Kits:

2620/A2620	-	2620KIT
2620-PT/A2620-PT	-	2620-PTKIT

Assembly Tool Kits:

2620/A2620 & 2620-PT/A2620-PT Tool Kit	-	123110-7
<i>Includes: (Fig. 3 & 6)</i>		
Spacer	-	123112-6
Piston Assembly Tool	-	123111-6
GLYD Ring Insertion Tool	-	121694-2620

Accessories:

Ejector Hex Wrench (All Models)	-	122048
End Cap Hex Wrench		
2620 & 2620-PT	-	124434-1
2620-PT/A2620-PT	-	124434-1
Remote Trigger (All Models)	-	123381-24



LIMITED WARRANTIES

TOOLING WARRANTY:

Huck warrants that tooling and other items (excluding fasteners, and hereinafter referred 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.

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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.

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HUCK MAKES NO WARRANTY WITH RESPECT

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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.

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