



HOWMET
AEROSPACE

HuckLok[®]

Double-Locking,
Wide-Grip Fasteners



HUCK

HuckLok®

Wide Grip-Range and Double-Locking Action for a Secure Hold

The HuckLok® structural blind rivet features a wide grip-range and a unique double-locking action. A large, blindside footprint prevents pull-through, securing assemblies from both sides even when joining a variety of materials with varying thicknesses.

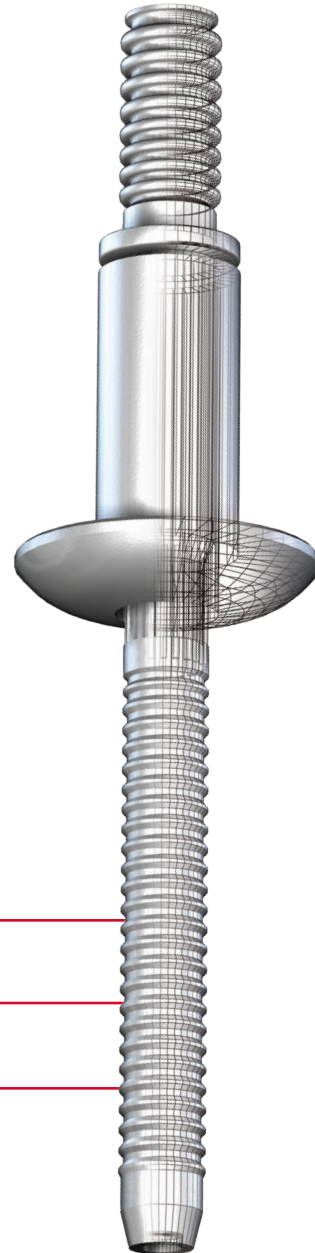
HuckLok is engineered with positive, mechanical-core, pin-retention to ensure structural integrity and long joint life. The breakaway ring design allows the shear ring to settle into the appropriate catch groove, keeping pressure on the blindside and securing a consistent clamp throughout the entire wide grip-range.

These structural blind rivets add efficiency to the production line by quickly installing in just seconds. A quick visual check that the core pin is flush on the head of the sleeve is proof of successful installation.

Available Sizes 3/16", 1/4"

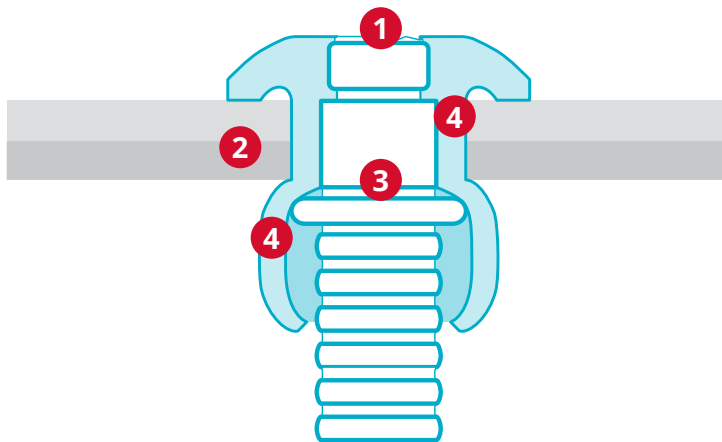
Materials Steel

Headstyles Protruding, Truss, 100° Oval Flush

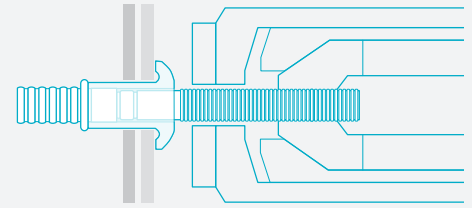


- ✓ Unique bulbing system for superior blind side strength
- ✓ Wide grip-range and unique double-locking action
- ✓ Positive mechanical pin retention ensures structural integrity
- ✓ Large, blind-side footprint prevents pull-through
- ✓ Annular grooves keep pressure on the back side

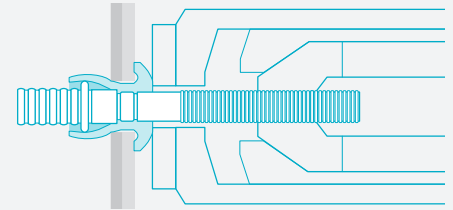
Secure, Fast Installation



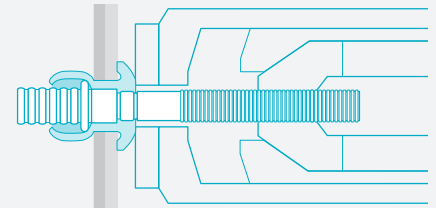
- 1 Breaking flush throughout its grip range, HuckLock allows at-a-glance verification of installation accuracy.
- 2 Undercut fillet allows seating in burred holes.
- 3 Solid pin provides exceptionally high strength in the shear plane.
- 4 Lock groove on pin engages shoulder on rivet head, while the extruded support ring double locks the pin within the bulb.



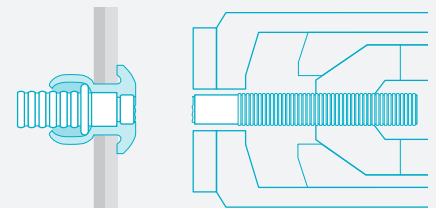
- 1 Insert the fastener into the hole and slip the installation tool over the pintail.



- 2 Press the trigger to initiate pulling action. As the tool pulls on the pintail, the shear ring feature on the pin pulls inside the sleeve fully expanding the diameter and drawing the work pieces together.

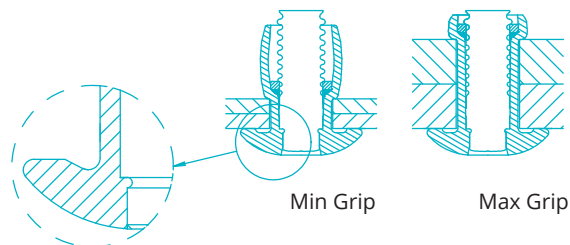
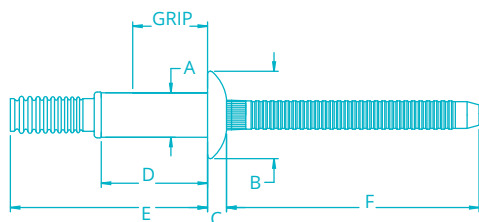


- 3 Continued pulling on the pintail expands the sleeve to maximum allowable diameter. As the shear ring reaches the backside of the work piece it breaks and catches on the tapered annular grooves, keeping high pressure on the blind side of the work pieces as the pin continues to draw down inside the sleeve.



- 4 A solid circle lock between the pin and sleeve is formed just prior to the pin breaking flush with the sleeve head, completing the installation

Data and Dimensions

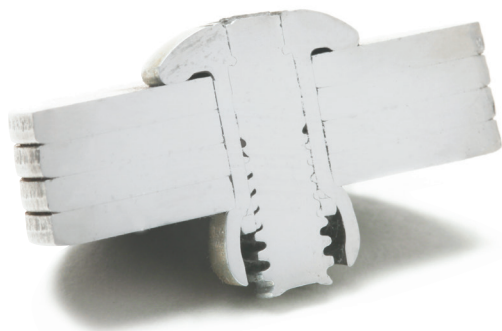


HuckLok Dimensions

| DIA. | PART NUMBER | | GRIP RANGE (IN) | GRIP RANGE (MM) | HOLE SIZE | A NOM | B MAX | | C MAX | D MAX | E MAX | F MIN |
|--------------|-------------|------------|-----------------|-----------------|-------------|-------|------------|-------|-------|-------|--------|-------|
| | PROTRUDING | TRUSS | | | | | PROTRUDING | TRUSS | | | | |
| 6 (3/16") | HKLP-R6-5 | - | .062 - .312 | 1.6 - 7.9 | .191 - .201 | 0.187 | 0.395 | - | 0.101 | 0.458 | 0.8555 | 0.988 |
| | HKLP-R6-7 | - | .187 - .437 | 4.7 - 11.1 | .191 - .201 | 0.187 | 0.395 | - | 0.101 | 0.583 | 0.9805 | 0.978 |
| 8 (1/4") | HKLP-R8-6 | HKLT-R8-6 | .100 - .375 | 2.5 - 9.5 | .261 - .272 | 0.253 | 0.530 | 0.592 | 0.122 | 0.560 | 1.019 | 1.082 |
| | HKLP-R8-6X | HKLT-R8-6X | .080 - .375 | 2.0 - 9.5 | .261 - .272 | 0.253 | 0.530 | 0.592 | 0.122 | 0.560 | 1.019 | 1.082 |
| | HKLP-R8-X6 | - | .160 - .375 | 4.6 - 9.5 | .261 - .272 | 0.253 | 0.530 | - | 0.122 | 0.560 | 1.019 | 1.102 |
| | HKLP-R8-7 | HKLT-R8-7 | .187 - .437 | 4.7 - 11.1 | .261 - .272 | 0.253 | 0.530 | 0.592 | 0.122 | 0.622 | 1.081 | 1.065 |
| | HKLP-R8-10 | HKLT-R8-10 | .375 - .625 | 9.5 - 15.9 | .261 - .272 | 0.253 | 0.530 | 0.592 | 0.122 | 0.810 | 1.269 | 1.065 |
| | HKLP-R8-12 | HKLT-R8-12 | .500 - .750 | 12.7 - 19.1 | .261 - .272 | 0.253 | 0.530 | 0.592 | 0.122 | 0.934 | 1.393 | 1.066 |
| | HKLP-R8-14 | HKLT-R8-14 | .625 - .875 | 15.9 - 22.2 | .261 - .272 | 0.253 | 0.530 | 0.592 | 0.122 | 1.060 | 1.519 | 1.065 |
| | HKLP-R8-18 | HKLT-R8-18 | .875 - 1.125 | 22.2 - 28.6 | .261 - .272 | 0.253 | 0.530 | 0.592 | 0.122 | 1.310 | 1.769 | 1.065 |
| | HKLP-R8-20 | HKLT-R8-20 | 1.000 - 1.250 | 25.4 - 31.8 | .261 - .272 | 0.253 | 0.530 | 0.592 | 0.122 | 1.435 | 1.894 | 1.065 |

Installed Values - lbf (Minimum)

| DIA. | PART NUMBER | GRIP | SHEAR | | TENSILE | | RETENTION | |
|--------------|-------------|-----------|-------|------|---------|------|-----------|-----|
| | | | MIN | TYP | MIN | TYP | MIN | TYP |
| 6 (3/16") | HKLP | All Grips | 1900 | 2500 | 1000 | 1300 | 150 | 450 |
| 8 (1/4") | HKLP/HKLT | All Grips | 3500 | 3800 | 1900 | 2200 | 300 | 650 |



Lock groove on pin engages shoulder on rivet head, while the support ring "double locks" the pin within the bulb.

Ordering Information

Follow the form below to construct a part number for ordering HuckLok®.
Refer to the Grip Tables for grip numbers.

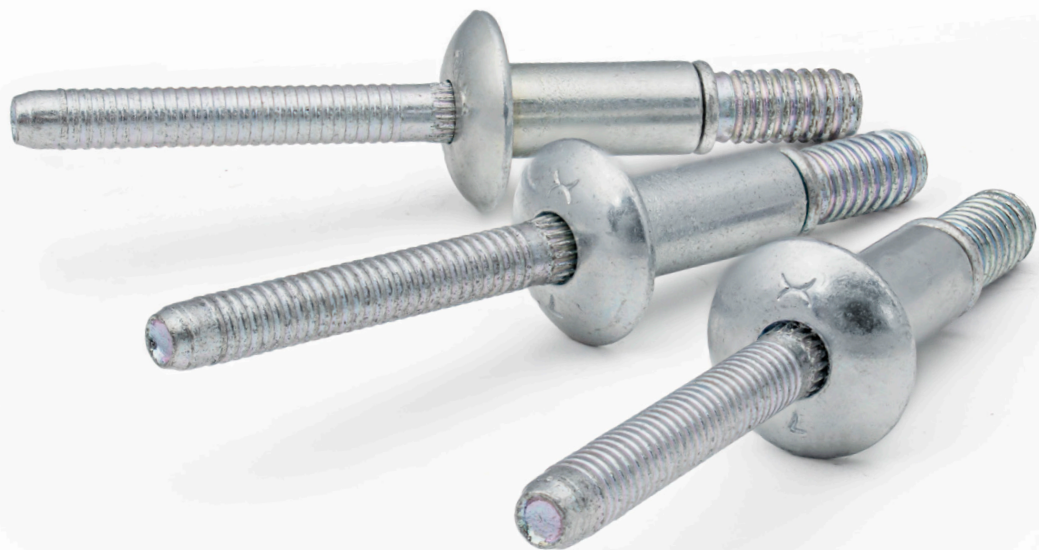
HKL(HEAD STYLE) – (MATERIAL) (DIAMETER) — (GRIP NUMBER)

Example: HKLP-R6-5 is a Protruding Head HuckLok, Steel, 3/16" Diameter, 5/16" Grip

| HEAD STYLE | PREFIX | MATERIAL | CODE | DIA. | CODE |
|-----------------|--------|----------|------|-------|------|
| Protruding Head | P | Steel | R | 3/16" | 6 |
| Truss Head | T | - | - | 1/4" | 8 |

Materials and Finishes

| MATERIAL | SLEEVE | PIN | SLEEVE FINISH | PIN FINISH |
|----------|------------------|---------------------|--|--|
| Steel | Low Carbon Steel | Medium Carbon Steel | Zinc Plate with Clear Gold Dye Optional | Zinc Plate with Clear Gold Dye Optional |



Installation Tooling

Tooling Weight and Dimensions

| MODEL | TYPE | WEIGHT | LENGTH | HEIGHT | WIDTH |
|------------|-------------|----------|--------|--------|-------|
| BV4500-118 | Battery | 5 lbs | 9.06" | 9.42" | 3.15" |
| 256 | Pneudraulic | 11.1 lbs | 7.9" | 14.9" | 6.3" |
| 2024* | Pneudraulic | 5.75 lbs | 8.9" | 12.6" | 4.4" |
| 2480 | Hydraulic | 2.2 lbs | 8.2" | 6.6" | 1.9" |
| 2581 | Hydraulic | 5.5 lbs | 8.4" | 7.1" | 2.1" |

Nose Assembly

| SIZE | BATTERY TOOLS | PNEUDRAULIC TOOLS | | HYDRAULIC TOOLING | |
|--------------|---------------|-------------------|-----------|-------------------|---------|
| | TOOL MODEL | | | | |
| | BV4500-118 | 256 | 2024* | 2480 | 2581 |
| 3/16" | 99-3303 | 99-3327 | 99-3303 | 99-3303 | 99-3327 |
| 3/16" & 1/4" | 99-3487** | - | 99-3487** | - | - |
| 1/4" | 99-3305 | 99-3328 | 99-3305 | 99-3305 | 99-3328 |

* Recommended ** Not recommended for high volume production



Huck Pneudraulic Tooling



256

Designed for quick installation of fasteners, the 256 tool features optimum stroke for one-cycle fastener installation, and minimal moving parts. Comes with standard inline and offset nose assemblies, ranging from 4mm to 10mm.



2024

Designed for production volume fastening, the 2024 offers a number of outstanding features, including an ergonomically designed handle, plated piston rods and an efficient in-line piston. An extended piston version (2024L) is available and an optional vacuum assist pintail collection system (2024V) can be added.

Huck Hydraulic Tooling



2480

The Model 2480 is a very lightweight tool which provides for the high-speed installation of a wide range of HuckBolt and Huck blind bolt fasteners. The tool has only one moving part, resulting in outstanding reliability and minimal maintenance. The tight centerline-to-edge measurement of the Model 2480 and its light weight (2.21 pounds) allow for its use in limited clearance areas.



2581

The Model 2581 is a lightweight tool (only 6.58 pounds) designed for use in a wide range of high-speed production applications. With only one moving part, the tool provides for increased reliability and requires minimal maintenance. An offset piston design allows the Model 2580 to easily fit in limited clearance applications.

Huck Battery Tooling



BV4500-118

The Huck Range Force battery tool has an electronically adjustable pull force and long stroke to enable installation of structural and non-structural rivets and up to 1/4" two-piece HuckBolt fasteners. Along with an 18V 5Ah battery, the Huck Range Force by Makita is a force to be reckoned with in portability, reliability and versatility.



Howmet Fastening Systems

Industrial Division Brands



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Contact Applifast

251 Cree Crescent
Winnipeg, MB
Canada R3J 3X4

Tel: 204 837 8361 • 1 800 563 1293

Fax: 204 837 3520 • 1 800 974 1494

info@applifast.com



applifast.com