



# Huck® Fasteners for Agriculture







ON THE FARM.  
IN THE FIELD.





HuckBolts are unmatched in vibration-resistance and strength for tractors and harvesters and the grain carts, ploughs, planters, balers, tillers, and rotary cutters they pull across fields for endless hours.



## Row after Row. Year after Year.

The machines of farming really take a beating in the fields and along the food production line. They face constant shaking and mechanical stresses to joined components, so assembly integrity of major equipment is critical to the world's food supply.

Huck fasteners are also reliable performers in mobile and permanent structures, grain silos, solar arrays, irrigation assemblies, and chassis attachments like cab frame, seats, and access panels. Unlike welding, HuckBolts are fast, easy, safe and easily removed for major repairs.

## 4 Huck® Fasteners for Agriculture







## Lighter-Weight Farm Equipment Without Any Welding

The strong clamp of HuckBolts delivers a powerful attachment of aluminum components without any welding. So manufacturers can lightweight heavy equipment by using aluminum instead of steel. Further reducing weight, there are fewer Huck fasteners than traditional nuts and bolts for any assembly because of higher shear, tensile and clamp strengths.

These engineered fasteners install with a unique direct-tension/swaged-on collar that stays secure under extreme vibration. Compared to welding, Huck fasteners make equipment assembly lines faster and safer with accurate assemblies that do not require highly-trained and certified installation personnel.



## Huck® Outperforms Torque

	FREE RUNNING NUT	NYLON LOCK NUT	STOVERIZED LOCK NUT	HUCK® BOBTAIL
				
TORQUE	226 FT-LB	226 FT-LB	226 FT-LB	N/A
TEST 1	15,000 LBF	21,500 LBF	26,000 LBF	27,100 LBF
TEST 2	20,000 LBF	18,000 LBF	21,000 LBF	27,500 LBF
TEST 3	21,000 LBF	18,000 LBF	28,500 LBF	27,800 LBF
TEST 4	18,000 LBF	24,000 LBF	23,000 LBF	28,100 LBF
VARIANCE	40%	33%	36%	2%

Consistent clamp is the ultimate goal to maintain structural integrity. Without it, you risk bolt failure. HuckBolts are applied with direct tension to provide consistent clamp from each fastener.

When the same torque is applied to standard nuts and bolts, there is a wide range of clamp force among each fastener. The tightest bolt can end up carrying the load of 4 or 5 bolts, causing it to fail from fatigue strength. This puts even more tensile force on fewer bolts.

In a series of bench tests on a variety of conventional nuts and bolts, scientists found that, even when torque is consistent, clamp is not. Friction that can be caused by dust, heat, inconsistent manufacturing, and other invisible elements causes inconsistent clamp.

The consistent clamp of direct tension HuckBolts ensures a more secure joint than conventional nuts and bolts.

## Huck® Replaces Welding

## HuckBolts Change The Equation.

While welding has long been utilized to deliver a secure joint, there are several strong reasons to consider a proven alternative – direct-tension, swaged-on HuckBolts. Fastening with vibration-resistant HuckBolts instead of welding offers five key benefits over welding: safety, simplicity, speed, cost-savings, and structural integrity. Huck fasteners are tested and proven in the most challenging agricultural applications for planting, harvesting, processing and more.





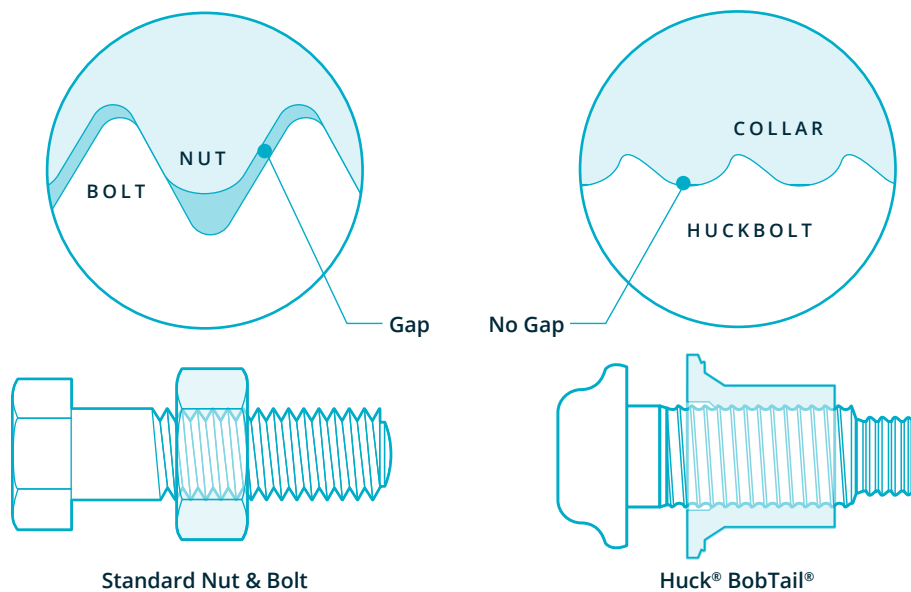




# Huck Overshadows All Other Fasteners

Our fastening technologies are known the world over for clamp performance that withstands the effects of vibration without ever loosening. After decades of applications in nearly every major industry, HuckBolts are well proven to never have to be inspected, tightened, or re-torqued. From planting through harvest, season after season, Huck delivers performance you can count on..

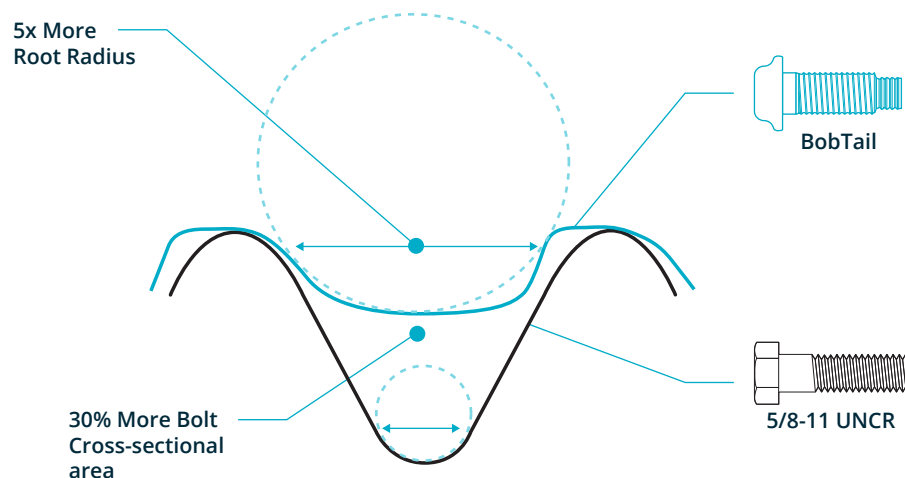
## Maintenance-Free Holding Power



Regular nuts and bolts have gap, which allows for loosening by vibration.

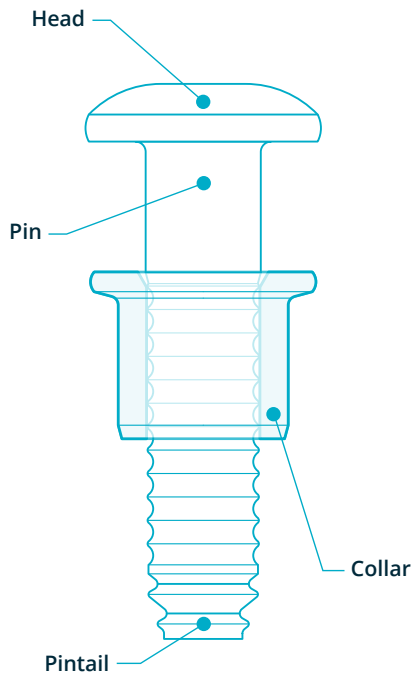
The swaged collar forms over the lock thread, and eliminates the gap.

Conventional nut and bolt installations leave gaps between the threads that lead to loosening in high-vibration conditions. HuckBolts use a unique swaged metal collar that is pressed into the steel threads of the pin as part of the direct-tension installation process; thus eliminating these problematic gaps.



The unique design of our lockbolt pins have shallow locking grooves so they have a larger root radius than conventional nuts and bolts of the same size. This provides 30% more pin cross sectional area and improved notch factor for 5X improvement in bending and tensile fatigue strength.





## Fast, Reliable Installations

Installation of a Huck fastener is typically less than two seconds, and requires minimal training. A quick visual inspection is all that is needed to verify an accurate installation.



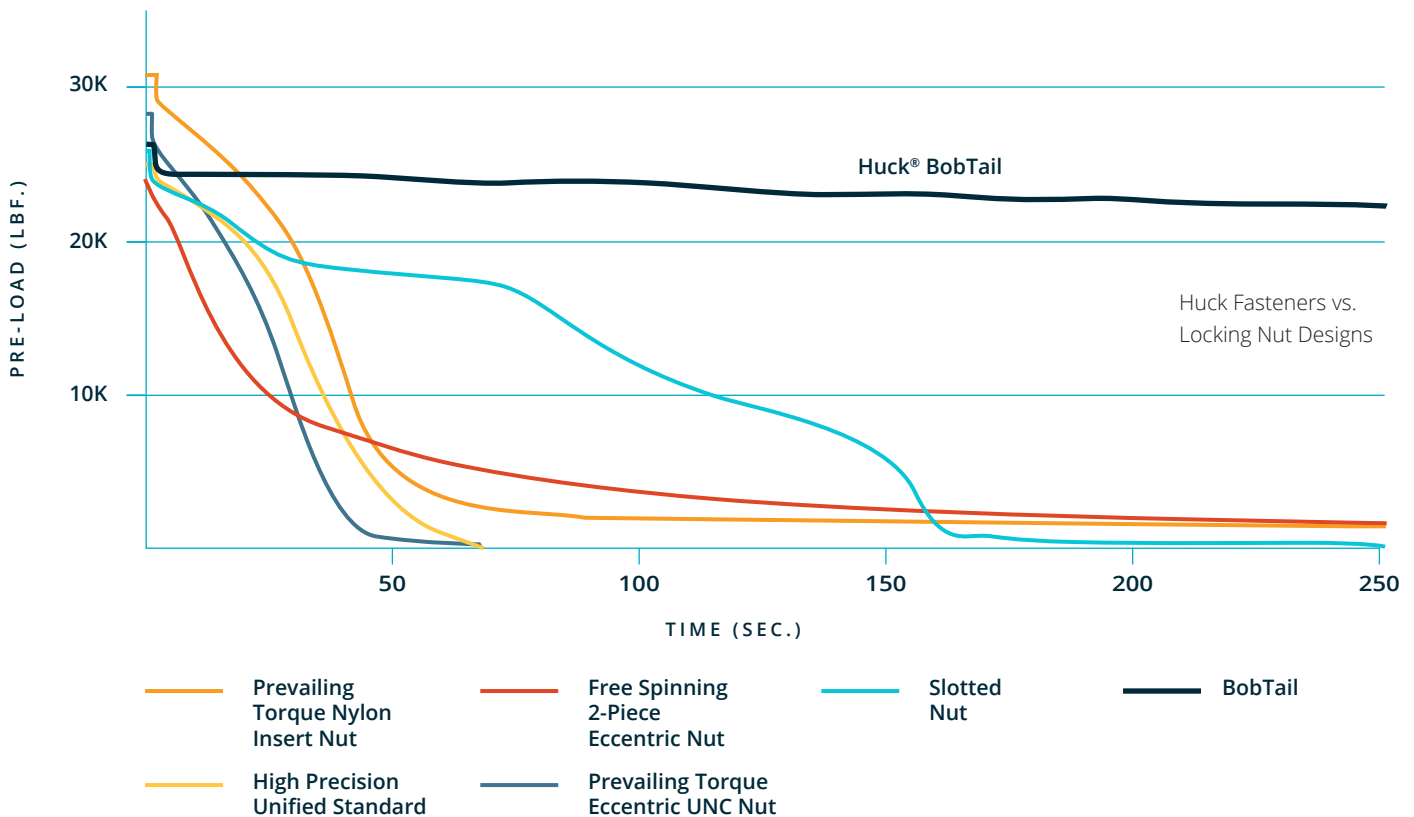
## Corrosion has Met Its Match

Coatings for Huck fasteners are designed to fit your application conditions and applied at our fastener plant in Waco, Texas, to ensure quality control and speedy delivery.



## Holding Power That Won't Shake Loose

HuckBolts are not subjected to the twisting force of torsion that a torque wrench applies to a conventional bolt. So they can safely be taken to higher preload values, resulting in higher clamp and the highest level of vibration resistance of any fastener, as shown in the Junkers Test results below.

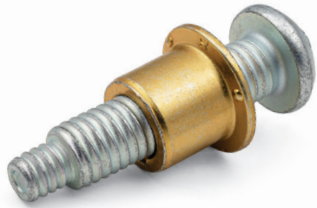








# Huck® Fasteners for Agriculture



## BobTail®

Engineered to meet the challenges of a wide range of heavy equipment assembly applications, Huck® BobTail® offers high performance, vibration resistance, and reliability in a unique, pintail-less design.

**Available Sizes:** 1/4", 5/16", 3/8", 1/2", 5/8", 3/4", 7/8", 1", 12mm, 14mm, 16mm, 20mm

**Materials:** Steel, Aluminum, Stainless Steel

**Headstyles:** Round, Truss, 90° Flush, Flanged, 98T



## C6L®

The Huck C6L is among the most popular and enduring fastening systems today. It's exclusive locking 6-groove design and consistent, high clamp force ensure a secure, permanent, vibration-resistant seal.

**Available Sizes:** 3/16", 1/4", 5/16", 3/8"

**Materials:** Steel, Aluminum, Stainless, Steel Pin w/ Stainless Head

**Headstyles:** Round, Truss, 90° Flush, Rivet



## Magna-Grip®

Huck Magna-Grip is the ideal fastener for applications where a wide grip range is required. It offers vibration-resistant, reliable grade 2 fasteners with consistently high, uniform installed values.

**Available Sizes:** 3/16", 1/4", 5/16", 3/8"

**Materials:** Steel, Aluminum

**Headstyles:** Button, Truss, Broad Truss, 90° Flush, Rivet



## BOM®

The Huck BOM® (Blind, Oversized Mechanically locked) fastener can do the work of up to four conventional fasteners. Its unique push-and-pull installation design makes it ideal for heavy equipment assembly.

**Available Sizes:** 3/16", 1/4", 5/16", 3/8", 1/2", 5/8", 3/4"

**Materials:** Steel, Stainless Steel



## Magna-Lok®

Hole-filling fastener with excellent gap pull-out and moisture resistance. Solid circle lock has been engineered into the fastener eliminating error and virtually eliminating pin push-out.

**Available Sizes:** 3/16", 1/4", 3/8", 1/2"

**Materials:** Steel, Aluminum, Stainless Steel, 316 Stainless Steel

**Headstyles:** Protruding, Truss, 100° Flush



# Advanced Huck® Tooling

Huck offers a full line of advanced, pneudraulic and heavy-duty hydraulic installation tools and nose assemblies that work with each engineered fastener. Supporting Huck hydraulic tooling is Huck's line of Powerig® power units.



## SF20 Hydraulic

Huck's proprietary, advanced SWAGEFORWARD® tooling is designed to be a lightweight, high-performance tool for installation of BobTail fasteners. In tight, space-constrained applications, this tool allows the operator to position his or her hand at a safe distance.



## SF32 Hydraulic

The SF32 is Huck's Swageforward® BobTail® Tool makes the installation process quicker and easier by reducing the force required to install each fastener. The SF32 is designed for production value installation of 3/4" (20mm) BobTail fasteners.



## 2025 Pneudraulic

The 2025 tool is ideal for high-volume installation of structural blind fasteners and HuckBolts up to 1/4". It features an ergonomically designed handle, plated piston rods, and an efficient in-line piston. Also available with extended piston (2025L) or vacuum-assist pintail collector (2025V).



## BTT35LS Hydraulic

Huck Model BTT35LS hydraulic installation tool installs and removes BobTail fasteners in limited clearance applications. The tool design consists of a cylinder housing with two chambers with tandem pull pistons to increase pull capacity while maintaining optimum clearance.



## Range Force™ by Makita®

The Huck Range Force BV4500 and BV2200 are durable, full-featured battery tools with long 1.18" strokes and electronically adjustable pulling-force from 0 to 4500 pounds or 0 to 2200 pounds. Install a wide variety of blind rivets as well as Huck fasteners up to 1/4" in diameter.



## Hydraulic Powerigs

Huck has a range of Powerigs that offers reliable hydraulic tooling power. Our portable Model 940 goes where you go, operating on 110 or 120 volt AC power. Our Model 918 can power 2 tools simultaneously on the factory floor using 220 or 440 volt 3 phase.





## Related Howmet Fastening Systems Products

**KEYSERT**



### Solid Inserts

Keysert® solid, one-piece, key-locking inserts are used to repair damaged threads or for use in original equipment. The Keysert® locking keys provide a positive mechanical lock, which prevents rotation due to vibration or torsion. Available in carbon or stainless steel.

**RECOIL**  
QUALITY THREAD INSERT SYSTEMS



### Threaded Inserts

Recoil® threaded inserts deliver positive locking performance and long thread life. Made from 304 Stainless Steel as a standard, Recoil inserts are also available in a wider range of materials including Inconel, 316 Stainless Steel, and Phosphor Bronze. In sizes from #2 through 1-1/2" (inch series) and M2 through M39.

**marson**



### Blind Rivets

Proven in a wide range of assembly applications, Marson® blind rivets are available in Buttonhead, Large Flange, and Countersunk headstyles in a wide range of materials including aluminum, steel, stainless, plastic and brass and sizes ranging from 3/32" to 1/4".

**marson**



### Rivet Nuts

Marson® offers a wide selection of rivet nuts that provide permanent thread placement in thin materials while reducing the surface damage that can occur with other fastening methods. These rivet nuts are available in a wide variety of styles, with grip ranges from 0.020" to 0.500".





**HOWMET  
AEROSPACE**

# Howmet Fastening Systems

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