

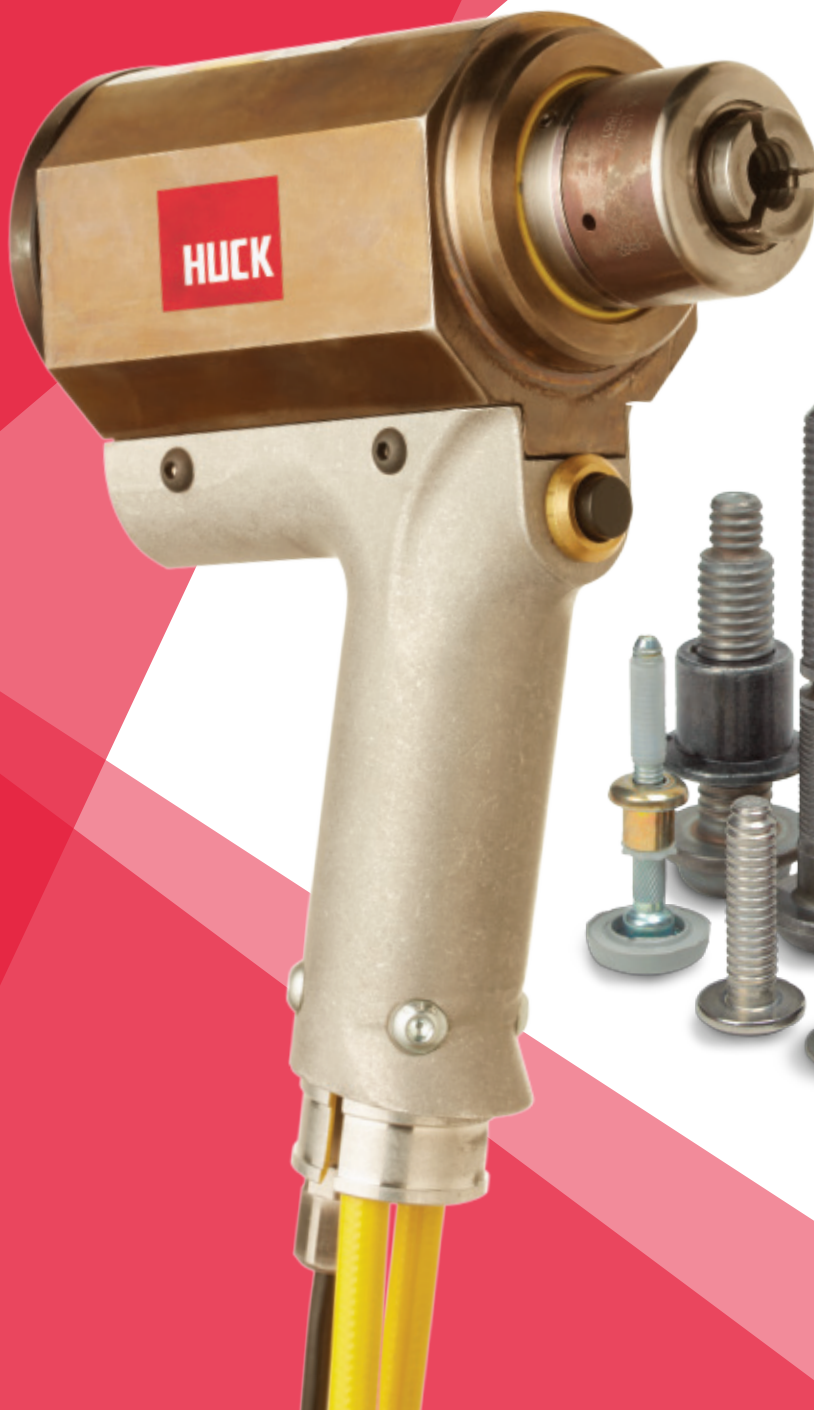
**Alcoa
Fastening
Systems & Rings**

Industrial Fasteners Division



Huck®

Lockbolts,
Structural Blind
Rivets and Tooling



Durable Locking Performance in High Vibration Environments

It's the proven reliable, vibration-resistant locking performance that made Alcoa Fastening Systems & Rings famous.

You'll find it in every HuckBolt®. Delivering uniform, consistent clamp load and high shear and tensile strength, HuckBolts are ideal for applications ranging from general manufacturing to high-vibration environments such as HVAC, trailer and container assembly, rotating equipment, shopping carts, railroad and transit cars, geodesic structures, and many others.

HuckBolts feature an exclusive locking groove design that ensures a tight, permanent fit. In addition to superior fastening performance regardless of which lockbolt type you require, HuckBolts have been proven to reduce labor and installation costs, along with rework and warranty expenses. Stronger, easier to install, and more durable than welding, adhesives, or conventional threaded fastening systems, HuckBolts have been the professionals' choice for decades.

HuckBolt® Tooling



Model SF20
SWAGEFORWARD®

Lightweight and technologically advanced, HuckBolt tooling makes the installation process quick and easy. For instance, this tool represents our most advanced installation tool yet.

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Types



BobTail®

Huck's swaged-on fastener with no break-off pintail. Corrosion resistant and installs with lightweight ergonomic tooling.



C50L®

Superior vibration resistance and durability for heavy-duty applications. Meets or exceeds all ASTM A-325 standards for shear, tensile and fatigue life.

C6L®/C120L/C150L

The classic 6-groove locking fastener ideal for a wide range of applications. Available in grades, 2, 5, and 8.



Magna-Grip®

Vibration-resistant, reliable grade 2 fasteners offering high uniform installed values with a wide grip range.



Hucktainer®

Panel fastener that installs with consistent pressure, reducing crushing or crazing.



Huck 360®

The engineered nut-and-bolt fastening system with a unique, embedded thread design for superior vibration resistance.

Contact Alcoa Fastening Systems & Rings for availability



BobTail®

Huck's next-generation, pintail-less HuckBolt.

Representing the most advanced fastening technology to date, the BobTail® has been developed to deliver the highest level of performance and reliability.

Engineered to meet the challenges of a wide range of assembly applications, BobTail offers safe, quiet, swaged-on installation technology in a unique, pintail-less design. Available in both Grade 5 and Grade 8 and in an assortment of sizes, BobTail offers 5 times the fatigue strength of conventional nuts and bolts, and unmatched installation speed – often under 2 seconds per fastener.

Its unique no-break-off pintail offers the highest corrosion-resistance in its class, while advanced, low-swage technology enables installation with lightweight, ergonomic tools. When you factor in the cost of fasteners with installation and inspection labor, BobTail often provides an overall lower installed cost.

Available Sizes:

3/16", 1/4", 5/16", 3/8", 1/2", 5/8", 3/4", 7/8", 1"
12mm, 14mm, 16mm, 20mm

Materials:

Steel, Aluminum, Stainless Steel

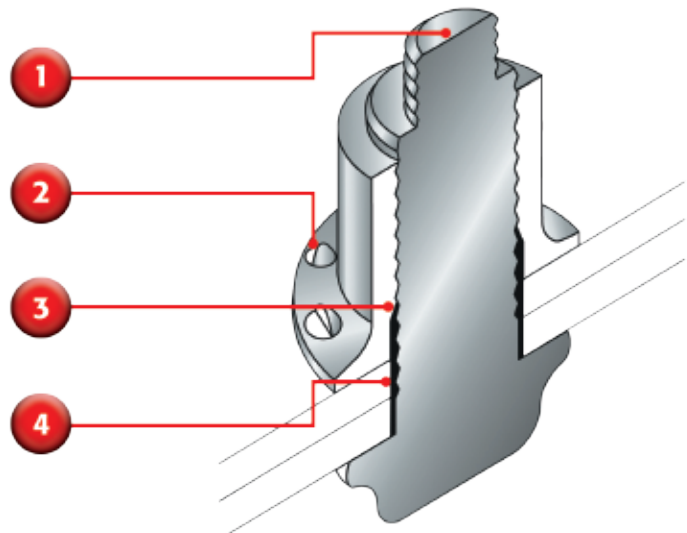
Headstyles:

Round, Truss, 90° Flush, Flanged, 98T



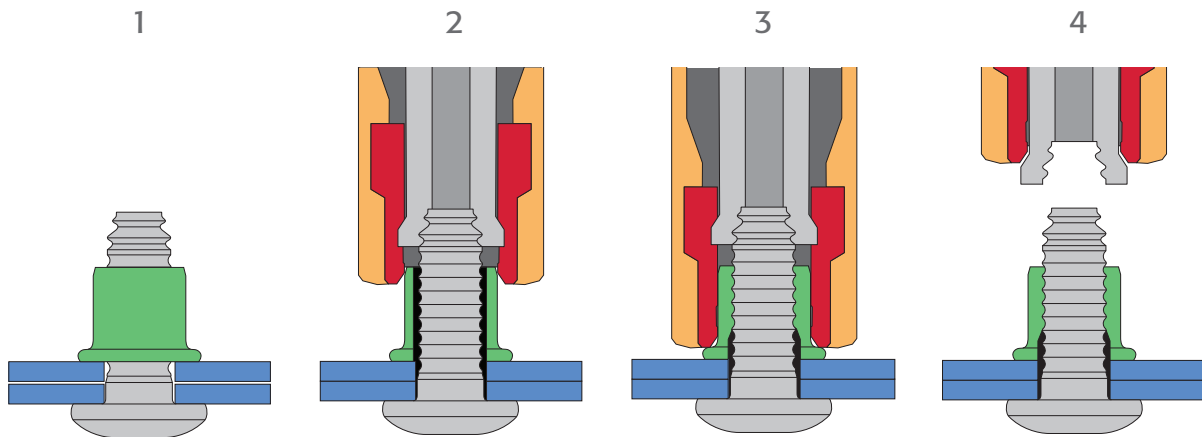
Swage indicators allow easy visual inspection

1. Pintail-less design means reduced noise, no waste, and improved corrosion resistance.
2. Visual evidence of successful installation provided by installation indicator.
3. Collar material swaged into the lockgrooves forms a permanent, vibration-resistant connection.
4. Low-swage technology allows for faster, lighter, ergonomic tooling with parts that last longer.



BobTail® Installation Sequence

The BobTail® System delivers a lightning-quick installation cycle time for greater productivity. This quick cycle is due, in part, to the short time required to apply the tool to the pin and complete the installation cycle. Once the operator engages the trigger, the swage sequence begins. Releasing the trigger ejects the fastener.



The pin is inserted into the prepared hole, and the collar is placed onto the pin.

The installation tool is applied to annular pull grooves. When the tool is activated, a puller in the nose assembly draws the pin into the tool, tension loading the joint and drawing up any sheet gap.

At a predetermined force, the anvil begins to swage the collar into the pin's lockgrooves. Continued swaging elongates the collar and pin, developing precise clamp.

When swaging of the collar into the pin lockgrooves is complete, the tool ejects the fastener and releases the puller to complete the sequence.



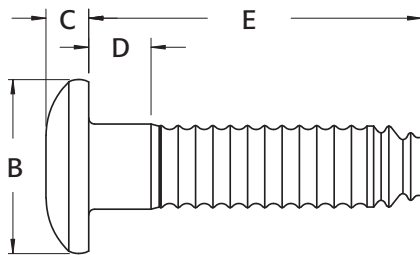
Ordering Information - Small Diameter BobTail®

Small BobTail Grip Tables

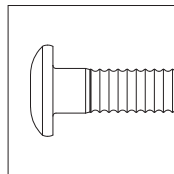
Grip	Grip Range	1/4" (8)		5/16" (10)		3/8" (12)	
		D	E	D	E	D	E
4	.125 — .375	0.187	1.000	0.187	1.156	0.187	1.310
6	.250 — .500	0.312	1.125	0.312	1.281	0.312	1.435
8	.375 — .625	0.437	1.250	0.437	1.406	0.437	1.560
10	.500 — .750	0.562	1.375	0.562	1.531	0.562	1.685
12	.625 — .875	0.687	1.500	0.687	1.656	0.687	1.810
14	.750 — 1.000	0.812	1.625	0.812	1.781	0.812	1.935
16	.875 — 1.125	0.937	1.750	0.937	1.906	0.937	2.060
18	1.000 — 1.250	1.062	1.875	1.062	2.031	1.062	2.185
20	1.125 — 1.375	1.187	2.000	1.187	2.156	1.187	2.310

Follow the form below to construct a part number for ordering BobTail® pins and their respective collars.

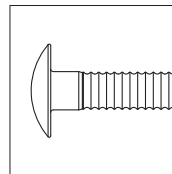
Head Style Options



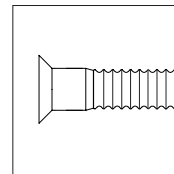
Trazier



98T



90°



Pins

BT (HEAD STYLE) - (MATERIAL) (DIAMETER) - (GRIP NUMBER) (FINISH)

Example: BT-BR8-8GA is a BobTail Pin, Grade 5 Carbon Steel, 1/4" Diameter, Grip 8, Zinc Plated

Head Style	Prefix
Trazier	BT
98T	BT98T
90°	BT90

Material	Code
Grade 2 Carbon Steel	R
Grade 5 Carbon Steel	BR
2024 Aluminum	C
305 Stainless Steel	U
430 Stainless Steel	4U

Diameter	Code
1/4"	8
5/16"	10
3/8"	12

Grip
Refer to Grip Table

Finish	Suffix
Zinc, clear chromate	GA

Collars

BTC (GRADE) - (MATERIAL) (DIAMETER) (FINISH)

Example: BTC5-R8UA is a BobTail Collar, Grade 5 Carbon Steel, 1/4" Diameter, Zinc Plated

Grade	Prefix
Grade 2	BTC
Grade 5	BTC5
Grade 8	BTC8

Material	Code
Low Carbon Steel	R
Aluminum	2B
305 Stainless Steel	U
430 Stainless Steel	4U

Diameter	Code
1/4"	8
5/16"	10
3/8"	12

Finish	Suffix
Zinc Plate (Gr 2)	GAH
Zinc Plate (Gr 5)	UA
Zinc Plate (Gr 8)	BL

Large Diameter BobTail Data and Dimensions

Steel - Metric

Diameter	Part No.	Grip Range	Max Hole Size	[B] Head Dia (max)	[C] Head Height (max)	Min Shear (lbs)	Min Clamp (lbf)	Min Tensile (lbs)
Flanged Head								
16MM Grade 10.9	MBT-DT16-15G	10-20mm	17.5mm	33.8mm	12.2mm	116 kN	116 kN	163 kN
	MBT-DT16-20G	15-25mm	17.5mm	33.8mm	12.2mm	116 kN	116 kN	163 kN
	MBT-DT16-25G	20-30mm	17.5mm	33.8mm	12.2mm	116 kN	116 kN	163 kN
	MBT-DT16-30G	25-35mm	17.5mm	33.8mm	12.2mm	116 kN	116 kN	163 kN
	MBT-DT16-35G	30-40mm	17.5mm	33.8mm	12.2mm	116 kN	116 kN	163 kN
	MBT-DT16-40G	35-45mm	17.5mm	33.8mm	12.2mm	116 kN	116 kN	163 kN
	MBT-DT16-45G	40-50mm	17.5mm	33.8mm	12.2mm	116 kN	116 kN	163 kN
	MBT-DT16-50G	45-55mm	17.5mm	33.8mm	12.2mm	116 kN	116 kN	163 kN
	MBT-DT16-55G	50-60mm	17.5mm	33.8mm	12.2mm	116 kN	116 kN	163 kN
	MBT-DT16-60G	55-65mm	17.5mm	33.8mm	12.2mm	116 kN	116 kN	163 kN
	MBT-DT16-65G	60-70mm	17.5mm	33.8mm	12.2mm	116 kN	116 kN	163 kN
	MBT-DT16-70G	65-75mm	17.5mm	33.8mm	12.2mm	116 kN	116 kN	163 kN
	MBT-DT16-80G	75-85mm	17.5mm	33.8mm	12.2mm	116 kN	116 kN	163 kN
20MM Grade 10.9	MBT-DT20-20G	15-25mm	22mm	42.4mm	16.0mm	182 kN	181 kN	255 kN
	MBT-DT20-30G	25-35mm	22mm	42.4mm	16.0mm	182 kN	181 kN	255 kN
	MBT-DT20-40G	35-45mm	22mm	42.4mm	16.0mm	182 kN	181 kN	255 kN
	MBT-DT20-45G	40-50mm	22mm	42.4mm	16.0mm	182 kN	181 kN	255 kN
	MBT-DT20-50G	45-55mm	22mm	42.4mm	16.0mm	182 kN	181 kN	255 kN

Large and Small Diameter BobTail Collars



Steel

Diameter	Part No.	Width (G)
1/4"	BTC-R8GAHL	.396
3/8"	BTC-R12GAHL	.599

430 Stainless Steel

Diameter	Part No.	Width (G)
1/4" with tab	BTC-R8GAHL	.396
3/8" with tab	BTC-R12GAHL	.599

Steel, Zinc Plated

Diameter	Part No.	Width (G)
16MM	MBTC-R16BL	24.1-24.5mm
20MM	MBTC-R20BL	30.2-30.6mm





Large BobTail Grip Tables - Inch Series

Grip	Grip Range	1/2"		5/8"		3/4"		7/8"		1"	
		D	E	D	E	D	E	D	E	D	E
4	.25-.62	0.150	1.440	0.150	1.601	0.160	1.850	0.250	2.056	0.250	2.260
8	.50-.87	0.150	1.690	0.150	1.851	0.160	2.100	0.250	2.306	0.250	2.510
12	.75-1.12	0.150	1.940	0.150	2.101	0.160	2.350	0.250	2.556	0.250	2.760
16	1.00-1.37	0.150	2.190	0.150	2.351	0.160	2.600	0.250	2.806	0.250	3.010
20	1.25-1.62	0.150	2.440	0.150	2.601	0.160	2.850	0.250	3.056	0.250	3.260
24	1.50-1.87	0.150	2.690	0.150	2.851	0.160	3.100	0.250	3.306	0.250	3.510
28	1.75-2.12	0.150	2.940	0.150	3.101	0.160	3.350	0.250	3.556	0.250	3.760
32	2.00-2.37	0.150	3.190	0.150	3.351	0.160	3.600	0.500	3.806	0.500	4.010
36	2.25-2.62	0.150	3.440	0.150	3.601	0.160	3.850	0.500	4.056	0.500	4.260
40	2.50-2.87	0.150	3.690	0.150	3.851	0.375	4.100	0.500	4.306	0.500	4.510
44	2.75-3.12	0.150	3.940	0.375	4.101	0.375	4.350	0.500	4.556	0.500	4.760
48	3.00-3.37	0.375	4.190	0.375	4.351	0.375	4.600	0.500	4.806	0.500	5.010
52	3.25-3.62	0.375	4.440	—	—	0.375	4.850	0.500	5.056	0.500	5.260
56	3.50-3.87	0.375	4.690	—	—	0.375	5.100	0.500	5.306	0.500	5.510
60	3.75-4.12	0.375	4.940	—	—	0.375	5.350	0.500	5.556	0.500	5.760
64	4.00-4.37	—	—	—	—	0.375	5.600	0.500	5.806	0.500	6.010
68	4.25-4.62	—	—	—	—	0.375	5.850	0.500	6.056	0.500	6.260
72	4.50-4.87	—	—	—	—	0.375	6.100	0.500	6.306	0.500	6.510

Large BobTail Grip Tables - Metric Series

Grip	Grip Range	12mm		14mm		16mm		20mm	
		D	E	D	E	D	E	D	E
10	5-15	3.8	34.2	3.8	37.1	3.8	40.1	3.8	45.9
15	10-20	3.8	39.2	3.8	42.1	3.8	45.1	3.8	50.9
20	15-25	3.8	44.2	3.8	47.1	3.8	50.1	3.8	55.1
25	20-30	3.8	49.2	3.8	52.1	3.8	55.1	3.8	60.9
30	25-35	3.8	54.2	3.8	57.1	3.8	60.1	3.8	65.9
35	30-40	3.8	59.2	3.8	62.1	3.8	65.1	3.8	70.9
40	35-45	3.8	64.2	3.8	67.1	3.8	70.1	3.8	75.9
45	40-50	3.8	69.2	3.8	72.1	3.8	75.1	3.8	80.9
50	45-55	3.8	74.2	3.8	77.1	9.5	80.1	3.8	85.9
55	50-60	3.8	79.2	3.8	82.1	9.5	85.1	3.8	90.9
60	55-65	3.8	84.2	3.8	87.1	9.5	90.1	3.8	95.9
65	60-70	3.8	89.2	3.8	92.1	9.5	95.1	9.5	100.9
70	65-75	3.8	94.2	3.8	97.1	9.5	100.1	9.5	105.9
75	70-80	3.8	99.2	9.5	102.1	9.5	105.1	9.5	110.9
80	75-85	9.5	104.2	9.5	107.1	9.5	110.1	9.5	115.9
85	80-90	—	—	—	—	9.5	115.1	—	—
90	85-95	—	—	—	—	9.5	120.1	—	—
95	90-100	—	—	—	—	9.5	125.1	—	—
100	95-105	—	—	—	—	9.5	130.1	—	—
105	100-110	—	—	—	—	9.5	135.1	—	—
110	105-115	—	—	—	—	9.5	140.1	—	—
115	110-120	—	—	—	—	9.5	145.1	—	—
120	115-125	—	—	—	—	9.5	150.1	—	—

Ordering Information - Large Diameter BobTail

Follow the form below to construct a part number for ordering BobTail pins and their respective collars.

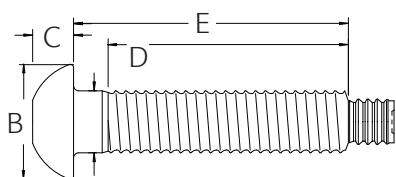
Pins BT (HEAD STYLE) - (MATERIAL) (DIAMETER) - (GRIP NUMBER) (FINISH)

Example: BTR-BR20-8 is a BobTail Pin, Round Head, Grade 5 Carbon Steel, 5/8" Diameter, Grip 8, Oil Finish

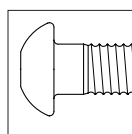
Collars BT (TYPE) - (MATERIAL) (DIAMETER) (FINISH)

Example: BTC5-R20UA is a BobTail Collar, Grade 5 Carbon Steel, 5/8" Diameter, Zinc Plated

Head Style Options

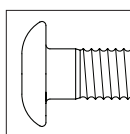


Round



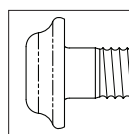
Grade 5 Standard
Class 8.8 Available

Truss



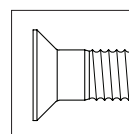
Upon Request

Flanged



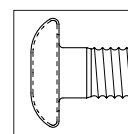
Class 10.9 Standard
Grade 8 Standard

90°



Upon Request

30 SS Cap



5/8", 16mm

Inch Series

Bolt Head Style	Prefix	Bolt Material	Code
Grade 5			
Round	BTR	Medium Carbon Steel	BR
Truss	BT30		
90° Flush	BT90		
Grade 8			
Flanged	BT	Alloy Steel	DT

Diameter	Code
1/2"	16
5/8"	20
3/4"	24
7/8"	28
1"	32

Grip

Refer to Grip Tables

Finish	Suffix
Zinc Plate, Clear Chromate	G
Zinc Plate, Clear Chromate (Heavy)	GA
Geomet - 1 Coat	NP
Geomet - 2 Coat	D1
Oil Finish	no suffix

NOTE: Geomet finish and other special coatings are available on request only.

Metric Series

Bolt Head Style	Prefix	Bolt Material	Code
Class 8.8			
Round	MBTR	Medium Carbon Steel	BR
Flanged	MBT		
Class 10.9			
Flanged	MBT	Alloy Steel	DT

Diameter	Code
12mm	12
14mm	14
16mm	16
20mm	20

Grip

Refer to Grip Tables

Finish	Suffix
Zinc Plate, Clear Chromate	G
Zinc Plate, Clear Chromate (Heavy)	GA
Geomet - 1 Coat	NP
Geomet - 2 Coat	D1
Oil Finish	no suffix

NOTE: Geomet finish and other special coatings are available on request only.

Collars

Bolt Head Style	Prefix	Material	Code
Grade 5	BTC5-	Low Carbon Steel	R
Grade 8	BTC8-	Low Carbon Steel	R
Class 8.8	MBTC-	Low Carbon Steel	BR
Class 10.9	MBTC-	Low Carbon Steel	R

Diameter	Code
1/2"	16
5/8"	20
3/4"	24
7/8"	28
1"	32
12mm	12
14mm	14
16mm	16
20mm	20

Finish	Suffix
Zinc Plate	UA
Zinc Plate	BL
Zinc Plate	UA
Zinc Plate	BL

BobTail Installation Tooling

Tooling Selection (Inch)

Diameter	Tool	Installation Nose	Cutter Nose
3/16"	244BT	99-7921	99-7921CC
	2480	99-7921	99-7921CC
1/4"	244BT	99-7932	99-7932CC
	2480	99-7932	99-7932CC
	SFBTT8-12	99-7930	99-7930CC
5/16"	256BT	99-7923	99-7923CC
	2503	99-7923	99-7923CC
	SFBTT8-12	99-7929	99-7929CC
3/8"	256BT	99-7924	99-7924CC
	2503	99-7924	99-7924CC
	SFBTT8-12	99-7928	99-7928CC
1/2"	SF20	99-7882	99-7882CX
	3585	99-7835	99-7835CX
5/8"	SF20	99-7881	99-7881CX
	3585	99-7831	99-7831CX
3/4"	SF32	99-7894	99-7894CX
	3585	99-7836	99-7832CX
7/8"	SF46	99-7863	99-7863CX
1"	SF46	99-7867	99-7867CX

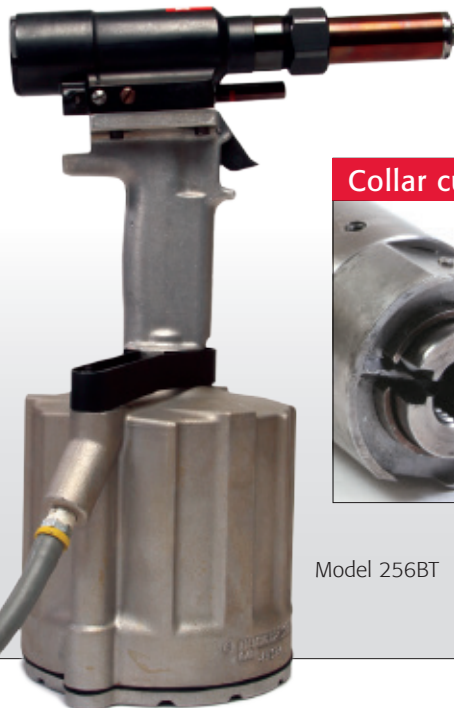
Tooling selection (Metric)

Diameter	Tool	Installation	Cutter
10mm	256BT	99-7903	-
	2503	99-7903	-
12mm	SF20	99-7880	99-7880CX
	3585	99-7830	99-7830CX
14mm	SF20	99-7884	99-7884CX
	3585	99-7834	99-7834CX
16mm	SF20	99-7881	99-7881CX
	3585	99-7831	99-7831CX
20mm	SF32	99-7893	99-7894CX
	3585	99-7832	99-7832CX

Alternative tooling are available upon request. Refer tooling section at rear of catalogue or contact our sales team for enquiry



Model SF20
SWAGEFORWARD®



Model 256BT

Collar cutter feature



While BobTail fasteners install permanently, BobTail installation tooling features a collar cutter nosepiece that makes fastener removal easier than ever.

C50L®

The fastener that has defined HuckBolts® for more than 50 years.

The C50L® offers superior vibration resistance and overall durability for heavy-duty fastening jobs, and is ideal for use within applications where consistent, uniform high clamp force is required. Testing has proven that C50L fasteners meet, or exceed the performance of torqued bolts in both shear and tensile strength, as well as fatigue life. For heavy-duty applications ranging from railcar to mining equipment manufacturing, the C50L delivers superior vibration resistance and overall durability.

Available Sizes:

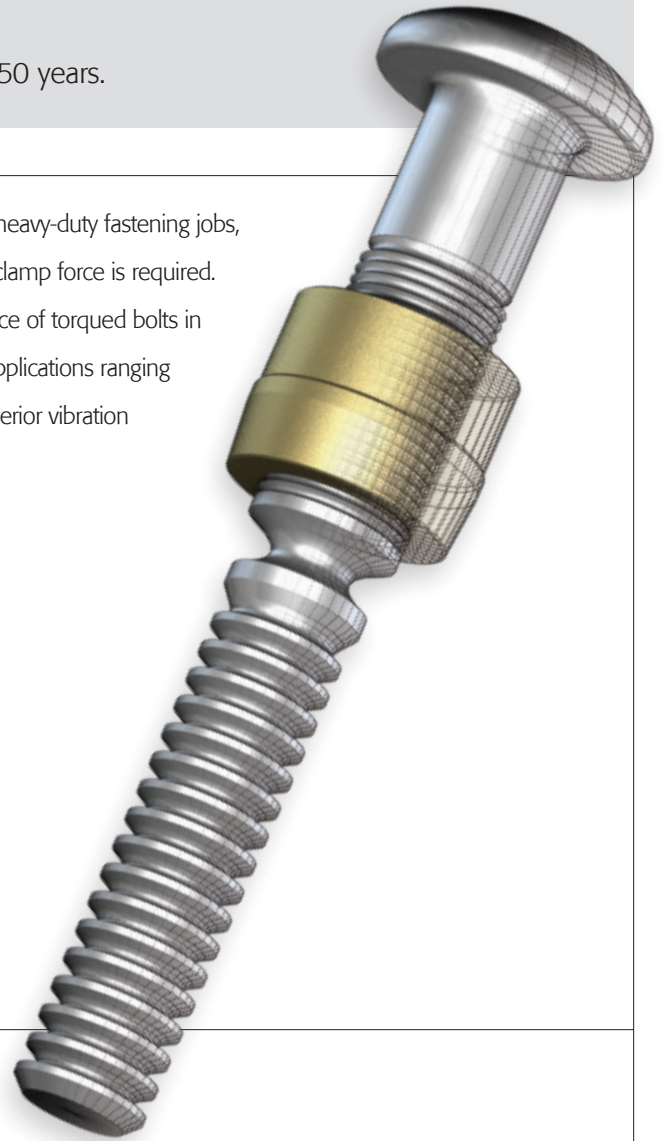
1/2", 5/8", 3/4", 7/8", 1", 1-1/8", 1-3/8"

Materials:

Steel, Aluminum

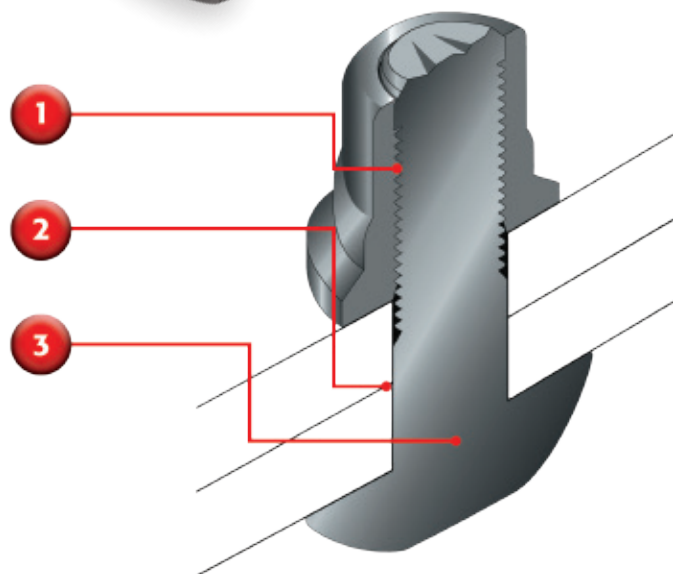
Headstyles:

Round, Truss, Large Truss, 90° Flush, Thread Head

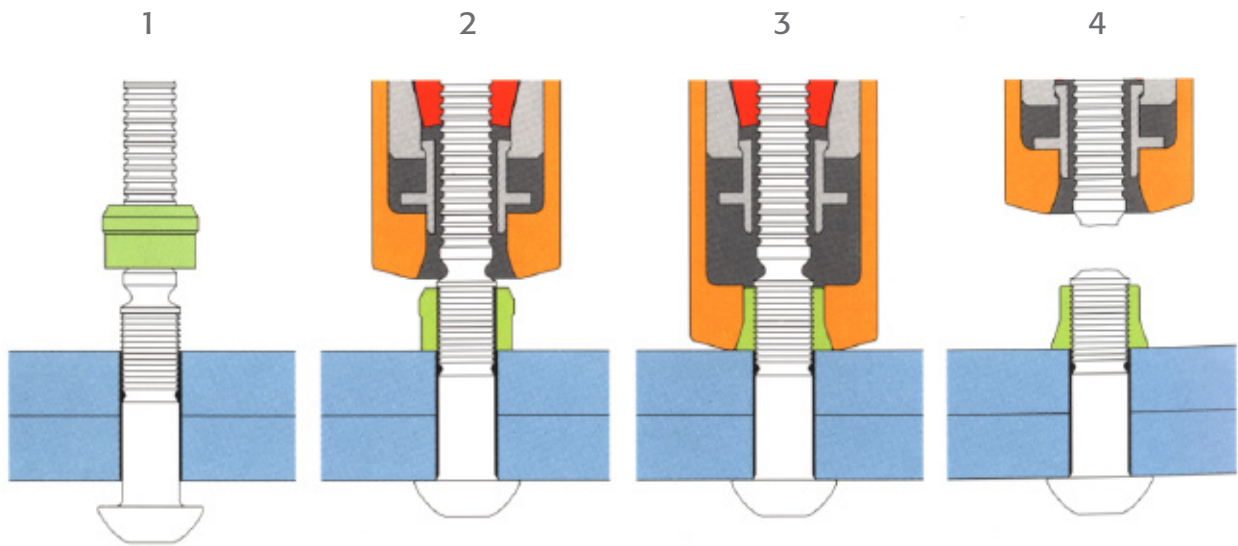


Secure, Fast Installation

1. Swaged-on collar forms a permanent, vibration-proof connection.
2. Initial long length of fastener enables pull-out of large gaps.
3. Consistent, repeatable pre-load.



C50L Installation Sequence



1
The pin is inserted into the prepared hole and the smooth bore collar is placed on the pin.

2
The installation tool is applied to the pintail. When the tool is activated, the jaws in the nose assembly pull on the pintail and the nose anvil pushes on the collar to remove any gap.

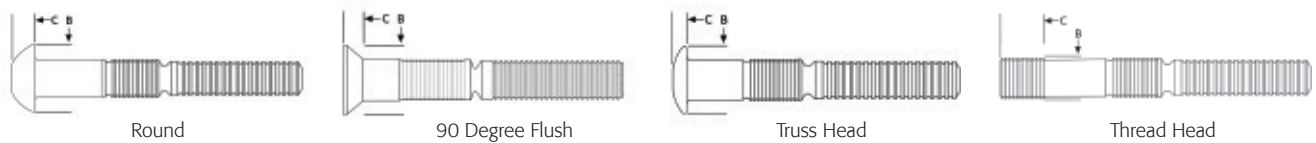
3
The nose anvil starts to swage the collar into the lockgrooves on the pin. Continued swaging causes the collar to lengthen and develop clamp.

4
When swaging of the collar into the lockgrooves is complete, the pintail separates from the pin which completes the installation cycle.

Unlike threaded fasteners, the C50L HuckBolt delivers consistent installation results. High costs of calibrating, maintaining, and replacing tools are eliminated. And installation does not require expensive, highly experienced workers.



C50L Data and Dimensions



Steel Pin - Black

Diameter	Part No.	Grip Range	Max Hole Size	[B] Head Dia (max)	[C] Head Height (max)	Typical Shear* (lbs)	Typical Clamp* (lbf)	Typical Tensile* (lbs)
Round Head								
1/2"	C50LR-BR16-4	.250-.500	.563	.906	.316	14400	12050	17050
	C50LR-BR16-8	.500-.750	.563	.906	.316	14400	12050	17050
	C50LR-BR16-12	.750-1.000	.563	.906	.316	14400	12050	17050
	C50LR-BR16-16	1.000-1.125	.563	.906	.316	14400	12050	17050
	C50LR-BR16-20	1.250-1.500	.563	.906	.316	14400	12050	17050
	C50LR-BR16-24	1.500-1.750	.563	.906	.316	14400	12050	17050
	C50LR-BR16-28	1.750-2.000	.563	.906	.316	14400	12050	17050
	C50LR-BR16-32	2.000-2.250	.563	.906	.316	14400	12050	17050
5/8"	C50LR-BR20-4	.250-.500	.688	1.141	.397	22500	19200	27100
	C50LR-BR20-8	.500-.750	.688	1.141	.397	22500	19200	27100
	C50LR-BR20-12	.750-1.000	.688	1.141	.397	22500	19200	27100
	C50LR-BR20-16	1.000-1.125	.688	1.141	.397	22500	19200	27100
	C50LR-BR20-20	1.250-1.500	.688	1.141	.397	22500	19200	27100
	C50LR-BR20-24	1.500-1.750	.688	1.141	.397	22500	19200	27100
	C50LR-BR20-28	1.750-2.000	.688	1.141	.397	22500	19200	27100
3/4"	C50LR-BR24-8	.500-.750	.813	1.383	.495	32400	28400	40100
	C50LR-BR24-12	.750-1.000	.813	1.383	.495	32400	28400	40100
	C50LR-BR24-16	1.000-1.125	.813	1.383	.495	32400	28400	40100
	C50LR-BR24-20	1.250-1.500	.813	1.383	.495	32400	28400	40100
	C50LR-BR24-24	1.500-1.750	.813	1.383	.495	32400	28400	40100
	C50LR-BR24-28	1.750-2.000	.813	1.383	.495	32400	28400	40100
	C50LR-BR24-32	2.000-2.250	.813	1.383	.495	32400	28400	40100
	C50LR-BR24-36	2.250-2.500	.813	1.383	.495	32400	28400	40100
	C50LR-BR24-40	2.500-2.750	.813	1.383	.495	32400	28400	40100
7/8"	C50LR-BR28-16	1.000-1.125	.938	1.610	.550	43400	39250	55450
	C50LR-BR28-20	1.250-1.500	.938	1.610	.550	43400	39250	55450
	C50LR-BR28-24	1.500-1.750	.938	1.610	.550	43400	39250	55450
	C50LR-BR28-28	1.750-2.000	.938	1.610	.550	43400	39250	55450
	C50LR-BR28-32	2.000-2.250	.938	1.610	.550	43400	39250	55450
	C50LR-BR28-36	2.250-2.500	.938	1.610	.550	43400	39250	55450
	C50LR-BR28-40	2.500-2.750	.938	1.610	.550	43400	39250	55450

Steel Pin - Black

Diameter	Part No.	Grip Range	Max Hole Size	[B] Head Dia (max)	[C] Head Height (max)	Typical Shear* (lbs)	Typical Clamp* (lbf)	Typical Tensile* (lbs)
Round Head								
1"	C50LR-BR32-20	1.250-1.500	1.063	1.850	.618	56500	51500	72700
	C50LR-BR32-24	1.500-1.750	1.063	1.850	.618	56500	51500	72700
	C50LR-BR32-28	1.750-2.000	1.063	1.850	.618	56500	51500	72700
	C50LR-BR32-32	2.000-2.250	1.063	1.850	.618	56500	51500	72700
	C50LR-BR32-36	2.250-2.500	1.063	1.850	.618	56500	51500	72700
	C50LR-BR32-44	2.750-3.000	1.063	1.850	.618	56500	51500	72700
	C50LR-BR32-48	3.000-3.250	1.063	1.850	.618	56500	51500	72700
	C50LR-BR32-52	3.250-3.500	1.063	1.850	.618	56500	51500	72700
	C50LR-BR32-56	3.500-3.750	1.063	1.850	.618	56500	51500	72700
	C50LR-BR32-60	3.750-4.000	1.063	1.850	.618	56500	51500	72700
	C50LR-BR32-64	4.000-4.250	1.063	1.850	.618	56500	51500	72700
	C50LR-BR32-84	5.250-5.500	1.063	1.850	.618	56500	51500	72700
	C50LR-BR32-88	5.500-5.750	1.063	1.850	.618	56500	51500	72700
1-1/8"	C50LR-BR36-52	3.250-3.500	1.188	2.063	.688	69500	58450	82950
	C50LR-BR36-56	3.500-3.750	1.188	2.063	.688	69500	58450	82950
	C50LR-BR36-60	3.750-4.00	1.188	2.063	.688	69500	58450	82950
	C50LR-BR36-64	4.00-4.250	1.188	2.063	.688	69500	58450	82950
	C50LR-BR36-68	4.250-4.500	1.188	2.063	.688	69500	58450	82950
	C50LR-BR36-72	4.500-4.750	1.188	2.063	.688	69500	58450	82950
	C50LR-BR36-76	4.750-5.000	1.188	2.063	.688	69500	58450	82950
	C50LR-BR36-80	5.000-5.250	1.188	2.063	.688	69500	58450	82950
	C50LR-BR36-84	5.250-5.500	1.188	2.063	.688	69500	58450	82950
	C50LR-BR36-88	5.500-5.750	1.188	2.063	.688	69500	58450	82950
	C50LR-BR36-92	5.750-6.000	1.188	2.063	.688	69500	58450	82950
	C50LR-BR36-6"	5.875-6.500	1.188	2.063	.688	69500	58450	82950
	C50LR-BR36-7"	6.875-7.500	1.188	2.063	.688	69500	58450	82950
	C50LR-BR36-8"	7.875-8.500	1.188	2.063	.688	69500	58450	82950
	C50LR-BR36-9"	8.875-9.500	1.188	2.063	.688	69500	58450	82950
	C50LR-BR36-10"	9.875-10.500	1.188	2.063	.688	69500	58450	82950
	C50LR-BR36-11"	10.875-11.500	1.188	2.063	.688	69500	58450	82950
	C50LR-BR36-12"	11.875-12.500	1.188	2.063	.688	69500	58450	82950
	C50LR-BR36-13"	12.875-13.500	1.188	2.063	.688	69500	58450	82950
	C50LR-BR36-14"	13.875-14.500	1.188	2.063	.688	69500	58450	82950
	C50LR-BR36-15"	14.875-15.500	1.188	2.063	.688	69500	58450	82950
	C50LR-BR36-16"	15.875-16.500	1.188	2.063	.688	69500	58450	82950
	C50LR-BR36-17"	16.875-17.500	1.188	2.063	.688	69500	58450	82950
	C50LR-BR36-18"	17.875-18.500	1.188	2.063	.688	69500	58450	82950
	C50LR-BR36-19"	18.875-19.500	1.188	2.063	.688	69500	58450	82950
	C50LR-BR36-20"	19.875-20.500	1.188	2.063	.688	69500	58450	82950
	C50LR-BR36-21"	20.875-21.500	1.188	2.063	.688	69500	58450	82950
	C50LR-BR36-22"	21.875-22.500	1.188	2.063	.688	69500	58450	82950

NOTE: Part number listings reflect typical stock. Items not listed require a minimum order. GA plating is also available in stock.
*For carbon steel pins.

NOTE: 1-3/8" Diameter Sizes are available on request

HUCKbolt XZ

Old HUCK Part Numbers	New "XZ" Numbers (if replaced)	New "XZ" Grip Ranges Non Flanged "LC" Style Collar				New "XZ" Grip Ranges Non Flanged "3LC" Style Collar			
		Grip Min mm	Grip Max mm	Grip Min Inches	Grip Max Inches	Grip Min mm	Grip Max mm	Grip Min Inches	Grip Max Inches
C50LR-BR32- 72	C50LR-BR32- 80XZ	114.3	137.3	4.50	5.41	108.3	131.3	4.26	5.17
C50LR-BR32- 76									
C50LR-BR32- 80									
C50LR-BR32- 84	C50LR-BR32- 92XZ	133.3	156.3	5.25	6.15	127.3	150.3	5.01	5.92
C50LR-BR32- 88									
C50LR-BR32- 92									
C50LR-BR32- 96	C50LR-BR32- 104XZ	152.4	175.4	6.00	6.91	146.4	169.4	5.76	6.67
C50LR-BR32- 100									
C50LR-BR32- 104									
C50LR-BR32- 108	C50LR-BR32- 116XZ	171.4	194.4	6.75	7.65	165.4	188.4	6.51	7.42
C50LR-BR32- 112									
C50LR-BR32- 116									
C50LR-BR32- 120	C50LR-BR32- 128XZ	190.5	213.5	7.50	8.41	184.5	207.5	7.26	8.17
C50LR-BR32- 124									
C50LR-BR32- 128									
C50LR-BR32- 132	C50LR-BR32- 140XZ	209.5	232.5	8.25	9.15	203.5	226.5	8.01	8.92
C50LR-BR32- 136									
C50LR-BR32- 140									
C50LR-BR32- 144	C50LR-BR32- 152XZ	228.6	251.6	9.00	9.91	222.6	245.6	8.76	9.67
C50LR-BR32- 148									
C50LR-BR32- 152									
C50LR-BR32- 156	C50LR-BR32- 164XZ	247.6	270.6	9.75	10.65	241.6	264.6	9.51	10.42
C50LR-BR32- 160									
C50LR-BR32- 164									
C50LR-BR32- 168	C50LR-BR32- 176XZ	266.7	289.7	10.50	11.41	260.7	283.7	10.26	11.17
C50LR-BR32- 172									
C50LR-BR32- 176									
C50LR-BR32- 180	C50LR-BR32- 188XZ	285.7	308.7	11.25	12.15	279.7	302.7	11.01	11.92
C50LR-BR32- 184									
C50LR-BR32- 188									
C50LR-BR32- 192	C50LR-BR32- 200XZ	304.8	327.8	12.00	12.91	298.8	321.8	11.76	12.67
C50LR-BR32- 196									
C50LR-BR32- 200									
C50LR-BR32- 204	C50LR-BR32- 212XZ	323.8	346.8	12.75	13.65	317.8	340.8	12.51	13.42
C50LR-BR32- 208									
C50LR-BR32- 212									
C50LR-BR32- 216	C50LR-BR32- 224XZ	342.9	365.9	13.50	14.41	336.9	359.9	13.26	14.17
C50LR-BR32- 220									
C50LR-BR32- 224									
C50LR-BR32- 228	C50LR-BR32- 236XZ	361.9	384.9	14.25	15.15	335.9	378.9	14.01	14.92
C50LR-BR32- 232									
C50LR-BR32- 236									
C50LR-BR32- 240	C50LR-BR32- 248XZ	381	404	15.00	15.91	375	398	14.76	15.67
C50LR-BR32- 244									
C50LR-BR32- 248									
C50LR-BR32- 252	C50LR-BR32- 260XZ	400	423	15.75	16.65	394	417	15.51	16.42
C50LR-BR32- 256									
C50LR-BR32- 260									
C50LR-BR32- 264	C50LR-BR32- 272XZ	419	442	16.50	17.40	413	436	16.26	17.17
C50LR-BR32- 268									
C50LR-BR32- 272									
C50LR-BR32- 276	C50LR-BR32- 284XZ	438.1	461.1	17.25	18.15	432.1	455.1	17.01	17.92
C50LR-BR32- 280									
C50LR-BR32- 284									
C50LR-BR32- 288	C50LR-BR32- 296XZ	457.2	480.2	18.00	18.91	451.2	474.2	17.76	18.67
C50LR-BR32- 292									
C50LR-BR32- 296									
C50LR-BR32- 300	C50LR-BR32- 308XZ	476.2	499.2	18.75	19.65	470.2	493.2	18.51	19.42
C50LR-BR32- 304									
C50LR-BR32- 308									

Steel Pin - Black

Diameter	Part No.	Grip Range	Max Hole Size	[B] Head Dia (max)	[C] Head Height (max)	Typical Shear* (lbs)	Typical Clamp* (lbf)	Typical Tensile* (lbs)
90° Flush Head								
1/2"	C50L90-BR16-8	.500-.750	.563	.906	.25	14400	12050	17050
	C50L90-BR16-12	.750-1.000	.563	.906	.25	14400	12050	17050
	C50L90-BR16-16	1.000-1.250	.563	.906	.25	14400	12050	17050
	C50L90-BR16-20	1.250-1.500	.563	.906	.25	14400	12050	17050
	C50L90-BR16-24	1.500-1.750	.563	.906	.25	14400	12050	17050
	C50L90-BR16-32	2.000-2.250	.563	.906	.25	14400	12050	17050
5/8"	C50L90-BR20-8	.500-.750	.688	1.140	.313	22500	19200	27100
	C50L90-BR20-12	.750-1.000	.688	1.140	.313	22500	19200	27100
	C50L90-BR20-16	1.000-1.250	.688	1.140	.313	22500	19200	27100
	C50L90-BR20-20	1.250-1.500	.688	1.140	.313	22500	19200	27100
	C50L90-BR20-24	1.500-1.750	.688	1.140	.313	22500	19200	27100
	C50L90-BR20-28	1.750-2.000	.688	1.140	.313	22500	19200	27100
	C50L90-BR20-32	2.000-2.250	.688	1.140	.313	22500	19200	27100
	C50L90-BR20-36	2.250-2.500	.688	1.140	.313	22500	19200	27100
	C50L90-BR20-40	2.500-2.750	.688	1.140	.313	22500	19200	27100
	C50L90-BR20-44	2.750-3.000	.688	1.140	.313	22500	19200	27100
3/4"	C50L90-BR24-8	.500-.750	.813	1.370	.375	32400	28400	40100
	C50L90-BR24-12	.750-1.000	.813	1.370	.375	32400	28400	40100
	C50L90-BR24-16	1.000-1.250	.813	1.370	.375	32400	28400	40100
	C50L90-BR24-20	1.250-1.500	.813	1.370	.375	32400	28400	40100
	C50L90-BR24-24	1.500-1.750	.813	1.370	.375	32400	28400	40100
	C50L90-BR24-28	1.750-2.000	.813	1.370	.375	32400	28400	40100
	C50L90-BR24-32	2.000-2.250	.813	1.370	.375	32400	28400	40100
	C50L90-BR24-36	2.250-2.500	.813	1.370	.375	32400	28400	40100
	C50L90-BR24-40	2.500-2.750	.813	1.370	.375	32400	28400	40100
	C50L90-BR24-44	2.750-3.000	.813	1.370	.375	32400	28400	40100
7/8"	C50L90-BR28-16	1.000-1.250	.938	1.594	.430	43400	39250	55450
	C50L90-BR28-20	1.250-1.500	.938	1.594	.430	43400	39250	55450
	C50L90-BR28-24	1.500-1.750	.938	1.594	.430	43400	39250	55450
	C50L90-BR28-28	1.750-2.000	.938	1.594	.430	43400	39250	55450
	C50L90-BR28-32	2.000-2.250	.938	1.594	.430	43400	39250	55450
1"	C50L90-BR32-16	1.000-1.250	1.063	1.771	.500	56500	51500	72700
	C50L90-BR32-20	1.250-1.500	1.063	1.771	.500	56500	51500	72700
	C50L90-BR32-24	1.500-1.750	1.063	1.771	.500	56500	51500	72700
	C50L90-BR32-28	1.750-2.000	1.063	1.771	.500	56500	51500	72700
	C50L90-BR32-32	2.000-2.250	1.063	1.771	.500	56500	51500	72700
	C50L90-BR32-40	2.500-2.750	1.063	1.771	.500	56500	51500	72700
	C50L90-BR32-44	2.750-3.000	1.063	1.771	.500	56500	51500	72700
	C50L90-BR32-52	3.250-3.500	1.063	1.771	.500	56500	51500	72700
	C50L90-BR32-56	3.500-3.750	1.063	1.771	.500	56500	51500	72700

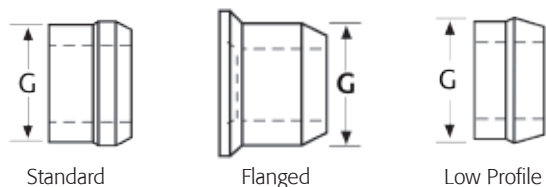
NOTE: Part number listings reflect typical stock. Items not listed require a minimum order. GA plating is also available in stock.
 *For carbon steel pins.

Steel Pin - Black

Diameter	Part No.	Grip Range	Max Hole Size	[B] Head Dia (max)	[C] Head Height (max)	Typical Shear* (lbs)	Typical Clamp* (lbf)	Typical Tensile* (lbs)
Thread Head								
1/2"	C50LH-BR16-12	.750-1.000	.563	.500	.625	14400	12050	17050
	C50LH-BR16-16	1.000-1.250	.563	.500	.625	14400	12050	17050
	C50LH-BR16-20	1.250-1.500	.563	.500	.625	14400	12050	17050
	C50LH-BR16-24	1.500-1.750	.563	.500	.625	14400	12050	17050
	C50LH-BR16-40	2.500-2.750	.563	.500	.625	14400	12050	17050
5/8"	C50LH-BR20-12	.750-1.000	.688	.625	.750	22500	19200	27100
	C50LH-BR20-16	1.000-1.250	.688	.625	.750	22500	19200	27100
	C50LH-BR20-20	1.250-1.500	.688	.625	.750	22500	19200	27100
	C50LH-BR20-28	1.750-2.000	.688	.625	.750	22500	19200	27100
3/4"	C50LH-BR24-24	1.500-1.750	.813	.750	.875	32400	28400	40100
	C50LH-BR24-32	2.000-2.250	.813	.750	.875	32400	28400	40100
	C50LH-BR24-36	2.250-2.500	.813	.750	.875	32400	28400	40100
	C50LH-BR24-44	2.750-3.000	.813	.750	.875	32400	28400	40100
	C50LH-BR24-48	3.000-3.250	.813	.750	.875	32400	28400	40100
7/8"	C50LH-BR28-24	1.500-1.750	.938	.875	1.062	43400	39250	55450
	C50LH-BR28-28	1.750-2.000	.938	.875	1.062	43400	39250	55450
	C50LH-BR28-32	2.000-2.250	.938	.875	1.062	43400	39250	55450
	C50LH-BR28-36	2.250-2.500	.938	.875	1.062	43400	39250	55450
	C50LH-BR28-48	3.000-3.250	.938	.875	1.062	43400	39250	55450
1"	C50LH-BR32-24	1.500-1.750	1.063	1.000	1.220	56500	51500	72700
	C50LH-BR32-28	1.750-2.000	1.063	1.000	1.220	56500	51500	72700
	C50LH-BR32-32	2.000-2.250	1.063	1.000	1.220	56500	51500	72700
	C50LH-BR32-36	2.250-2.500	1.063	1.000	1.220	56500	51500	72700
	C50LH-BR32-40	2.500-2.750	1.063	1.000	1.220	56500	51500	72700
	C50LH-BR32-44	2.750-3.000	1.063	1.000	1.220	56500	51500	72700
	C50LH-BR32-48	3.000-3.250	1.063	1.000	1.220	56500	51500	72700
	C50LH-BR32-56	3.500-3.750	1.063	1.000	1.220	56500	51500	72700
	C50LH-BR32-60	3.750-4.000	1.063	1.000	1.220	56500	51500	72700
	C50LH-BR32-64	4.000-4.250	1.063	1.000	1.220	56500	51500	72700
	C50LH-BR32-68	4.250-4.500	1.063	1.000	1.220	56500	51500	72700
	C50LH-BR32-80	5.000-5.250	1.063	1.000	1.220	56500	51500	72700
1-1/8"	C50LH-BR36-5	4.875-5.500	1.188	1.125	1.343	69500	58450	82950
	C50LH-BR36-6	5.875-6.500	1.188	1.125	1.343	69500	58450	82950
	C50LH-BR36-7	6.875-7.500	1.188	1.125	1.343	69500	58450	82950
	C50LH-BR36-8	7.875-8.500	1.188	1.125	1.343	69500	58450	82950
	C50LH-BR36-9	8.875-9.500	1.188	1.125	1.343	69500	58450	82950
	C50LH-BR36-10	9.875-10.500	1.188	1.125	1.343	69500	58450	82950
	C50LH-BR36-11	10.875-11.500	1.188	1.125	1.343	69500	58450	82950
	C50LH-BR36-12	11.875-12.500	1.188	1.125	1.343	69500	58450	82950
	C50LH-BR36-13	12.875-13.500	1.188	1.125	1.343	69500	58450	82950
	C50LH-BR36-14	13.875-14.500	1.188	1.125	1.343	69500	58450	82950
	C50LH-BR36-15	14.875-15.500	1.188	1.125	1.343	69500	58450	82950
	C50LH-BR36-16	15.875-16.500	1.188	1.125	1.343	69500	58450	82950
	C50LH-BR36-17	16.875-17.500	1.188	1.125	1.343	69500	58450	82950
	C50LH-BR36-18	17.875-18.500	1.188	1.125	1.343	69500	58450	82950
	C50LH-BR36-19	18.875-19.500	1.188	1.125	1.343	69500	58450	82950
	C50LH-BR36-20	19.875-20.500	1.188	1.125	1.343	69500	58450	82950

NOTE: Part number listings reflect typical stock. Items not listed require a minimum order.
*For carbon steel pins.

C50L Lockbolt Collars



Standard

Flanged

Low Profile

*When using flanged collars add 1/4" to grip

Steel, Zinc Plated

Diameter	Part No.	Width (G)
Standard, Non-Flanged		
1/2"	LC-2R16GA	.765-.800
5/8"	LC-2R20GA	.970-.985
3/4"	LC-2R24GA	1.165-1.180
7/8"	LC-2R28GA	1.360-1.375
1"	LC-2R32GA	1.550-1.570
1-1/8"	LC-2R36GA	1.750-1.770
Flanged		
1/2"	3LC-2R16GA	.793-.807
5/8"	3LC-2R20GA	.980-.996
3/4"	3LC-2R24GA	1.175-1.195
7/8"	3LC-2R28GA	1.360-1.370
1"	3LC-2R32GA	1.550-1.565
Low Profile		
5/8"	8LC-2R20GA	.972-.982
7/8"	8LC-2R28GA	1.360-1.375

C50L Installation Tooling

Diameter	Installation Tool	Nose Assembly	Type
1/2"	2620	99-5000	Hydraulic
	2620PT	99-5002	Hydraulic
5/8"	3585	99-5008	Hydraulic
3/4"	3585	99-5010	Hydraulic
7/8"	2630	99-5014	Hydraulic
1"	507	99-5016	Hydraulic
1-1/8"	507	99-5019	Hydraulic

Alternative tooling are available upon request. Refer tooling at rear of catalogue or contact our sales team for inquiry.



Model 507

Model 3585

Grip tables

Grip	Grip Range	1/2" (16)		5/8" (20)		3/4" (24)		7/8" (28)		1" (32)		1-1/8" (36)		1-3/8" (44)
		D	E	D	E	D	E	D	E	D	E	D	E	
4	.250 - .500	1.213	3.172	1.433	3.656	1.518	4.156	—	—	—	—	—	—	up to
8	.500 - .750	1.463	3.422	1.683	3.906	1.768	4.406	1.921	4.688	2.073	5.375	—	—	34.25"
12	.750 - 1.000	1.713	3.672	1.933	4.156	2.018	4.656	2.171	4.938	2.323	5.625	—	—	
16	1.000 - 1.250	1.963	3.922	2.183	4.406	2.268	4.906	2.421	5.188	2.573	5.875	—	—	Call for data.
20	1.250 - 1.500	2.213	4.172	2.433	4.656	2.518	5.156	2.671	5.438	2.823	6.125	—	—	
24	1.500 - 1.750	2.463	4.422	2.683	4.906	2.768	5.406	2.921	5.688	3.073	6.375	—	—	
28	1.750 - 2.000	2.713	4.672	2.933	5.156	3.018	5.656	3.171	5.938	3.323	6.625	—	—	
32	2.000 - 2.250	2.963	4.922	3.183	5.406	3.268	5.906	3.421	6.188	3.573	6.875	—	—	
36	2.250 - 2.500	3.213	5.172	3.433	5.656	3.518	6.156	3.671	6.438	3.823	7.125	—	—	
40	2.500 - 2.750	3.463	5.422	3.683	5.906	3.768	6.406	3.921	6.688	4.073	7.375	—	—	
44	2.750 - 3.000	3.713	5.672	3.933	6.156	4.018	6.656	4.171	6.938	4.323	7.625	—	—	
48	3.000 - 3.250	3.963	5.922	4.183	6.406	4.268	6.906	4.421	7.188	4.573	7.875	—	—	
52	3.250 - 3.500	4.213	6.172	4.433	6.656	4.518	7.156	4.671	7.438	4.823	8.125	—	—	
56	3.500 - 3.750	4.463	6.422	4.683	6.906	4.768	7.406	4.921	7.688	5.073	8.375	5.250	8.563	
60	3.750 - 4.000	4.713	6.672	4.933	7.156	5.018	7.656	5.171	7.938	5.323	8.625	5.500	8.813	
64	4.000 - 4.250	4.963	6.922	5.183	7.406	5.268	7.906	5.421	8.188	5.573	8.875	5.750	9.063	
68	4.250 - 4.500	5.213	7.172	5.433	7.656	5.518	8.156	5.671	8.438	5.823	9.125	6.000	9.313	
72	4.500 - 4.750	5.463	7.422	5.683	7.906	5.768	8.406	5.921	8.688	6.073	9.375	6.250	9.563	
76	4.750 - 5.000	5.713	7.672	5.933	8.156	6.018	8.656	—	—	6.323	9.625	6.500	9.813	
80	5.000 - 5.250	5.963	7.922	—	—	—	—	—	—	6.573	9.875	6.750	10.063	
84	5.250 - 5.500	—	—	—	—	—	—	—	—	6.823	10.125	7.000	10.313	
88	5.500 - 5.750	—	—	—	—	—	—	—	—	7.073	10.375	7.250	10.563	
92	5.750 - 6.000	—	—	—	—	—	—	—	—	7.323	10.625	7.500	10.813	

Ordering Information - C50L

Follow the form below to construct a part number for ordering C50L pins and their respective collars.
Refer to the Grip Tables for grip numbers.

Pins

C50L (HEAD STYLE) - (MATERIAL) (DIAMETER) - (GRIP NUMBER) - (FINISH)

Example: C50LR-BR16-4 is a C50L HUCKBOLT fastener, Round Head, Carbon Steel, 1/2" Diameter, Grip 4

Bolt Head Style	Prefix	Bolt Material	Code	Diameter	Code	Grip	Finish	Suffix
Round	R	Carbon Steel	BR	1/2"	16	Refer to Grip Tables	Zinc Plate, Clear Chromate	G
Truss	T			5/8"	20		Zinc Plate, Clear Chromate (Heavy)	GA
Large Truss	30	Aluminum 2024 and 6061 special order only		3/4"	24		Geomet - 1 Coat	NP
90° Flush	90			7/8"	28		Geomet - 2 Coat	D1
Thread Head	H	Stainless Steel available on request		1"	32		Geomet - 3 Coat	DL
				1-1/8"	36		Oil Finish	no suffix
				1-3/8"	44			

* Geomet and other coating options

Collars

(COLLAR STYLE) - (MATERIAL) (DIAMETER) (FINISH) (OPTIONS)

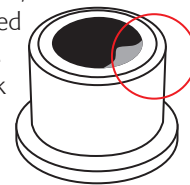
Example: LC-2R16G is a Standard Collar, Low Carbon Steel, 1/2" Diameter, Zinc Finish

Collar Style	Prefix	Material	Code	Diameter	Code	Finish	Code	Options	Suffix
Standard	LC-	Low Carbon Steel	2R	1/2"	16	Zinc	GA	Tab-Lok	L
Flanged	3LC-			5/8"	20				
Low Profile	8LC-	Aluminum special order only		3/4"	24	* Additional coating options are available on request			
Low Profile (44)	AC-R44			7/8"	28				
				1"	32				
				1-1/8"	36	Tab-Lok™			
				1-3/8"	44				

NOTE: Please contact customer service for availability of parts.
For non-stocked items, please allow up to 16 weeks for delivery.

Tab-Lok™

The Tab-Lok™ feature makes sure the collar stays on the pin, before installation, in overhead and down slanted pin placements. To order Tab-Lok collars refer to adjacent charts.



C6L[®]

The classic 6-groove locking fastener built with staying power.

A result of Huck International innovation a half-century ago, the versatile Alcoa Fastening Systems & Rings C6L[®] HuckBolt[®] remains the number one fastening system for applications that require a strong, vibration-resistant seal today.

C6L's exclusive locking groove design ensures a permanent fit that resists loosening. That means it's ideal for applications from general manufacturing to such high-vibration applications as HVAC, trailer and container assembly, rotary and rotating equipment, shopping carts, railroad and transit cars, geodesic structures, and many others.

In addition to offering superior fastening performance, the C6L system reduces labor and installation costs, along with rework and warranty expenses. For example, using the C6L eliminates the need to hire certified welders or specially trained employees, because workers can be instructed to install these foolproof fasteners in a matter of minutes. The C6L is available in Grade 2, Grade 5, and Grade 8.

Available Sizes:

3/16", 1/4", 5/16", 3/8"

Materials:

Steel, Aluminum, Stainless Steel

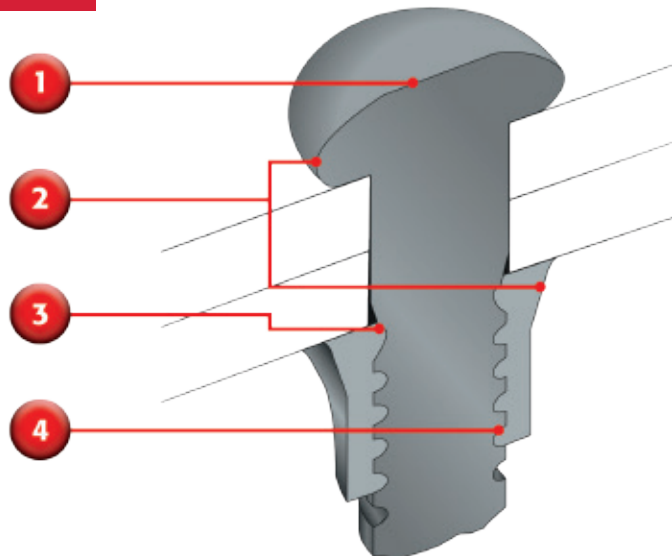
Headstyles:

Round, Truss, Flush, 98T



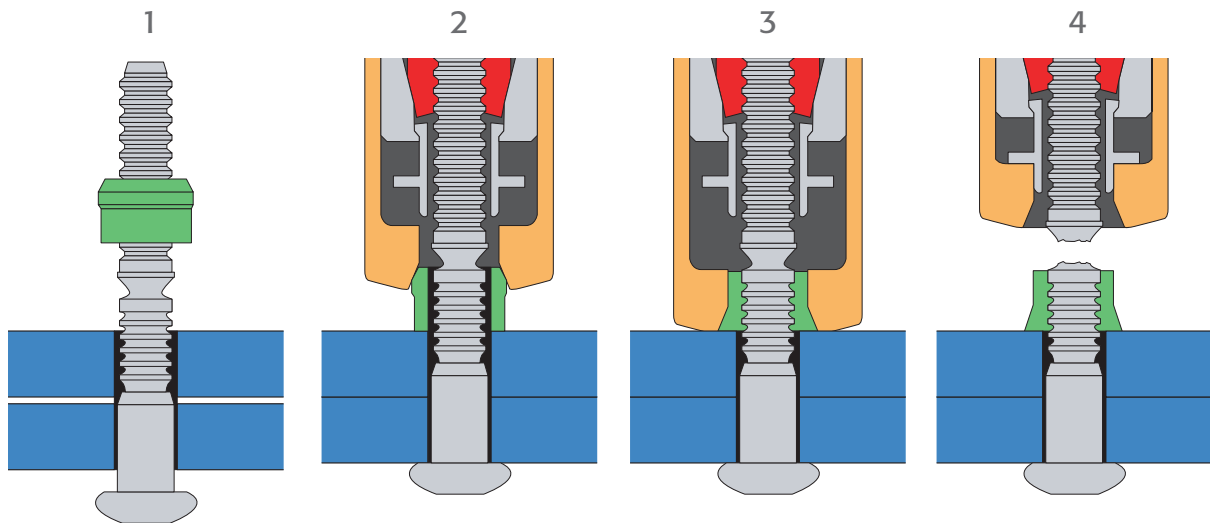
Secure, Fast Installation

1. Wide bearing collar and head spread load to ensure structural integrity.
2. Corrosion resistant coatings can be painted.
3. Excellent gap pull-out and high retained clamp.
4. High fatigue annular lock groove form extends the life of your structure.



Installation Sequence

The C6L's unique design virtually eliminates installation errors caused by operator or tool variables. The C6L ensures that once the collar swage is complete, the pintail breaks off and the fastener is tightly installed. No rework required. And you can count on consistent, high-uniform clamp force with every C6L installation, time after time.



1
The pin is inserted into the prepared hole and the smooth bore collar is placed on the pin.

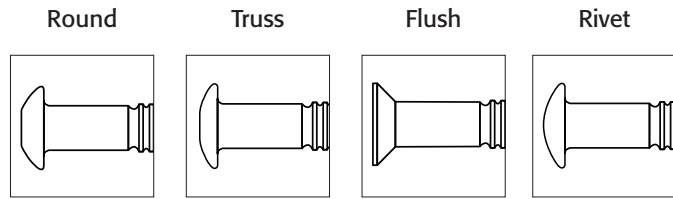
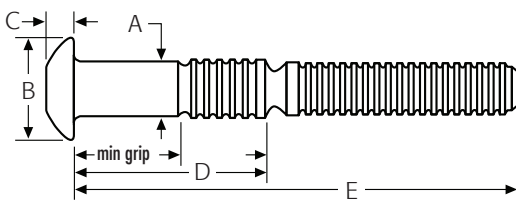
2
The installation tool is applied to the pintail. When the tool is activated, the jaws in the nose assembly pull on the pintail and the nose anvil pushes on the collar to remove any gap.

3
The nose anvil starts to swage the collar into the lockgrooves on the pin. Continued swaging causes the collar to lengthen and develop clamp.

4
When swaging of the collar into the lockgrooves is complete, the pintail separates from the pin which completes the installation cycle.



C6L Data and Dimensions



Steel Pin - Zinc Plated

Diameter	Part No.	Grip Range	Max Hole Size*	[B] Head Dia (max)	[C] Head Height (max)	Typical Shear (lbs)	Typical Clamp (lbf)	Typical Tensile (lbs)
Round Head								
1/4"	C6LB-R8-2G	0.063-0.188	.312	.525	.152	3050	1805	3000
	C6LB-R8-3G	0.125-0.250	.312	.525	.152	3050	1805	3000
	C6LB-R8-4G	0.188-0.313	.312	.525	.152	3050	1805	3000
	C6LB-R8-5G	0.250-0.375	.312	.525	.152	3050	1805	3000
	C6LB-R8-6G	0.313-0.438	.312	.525	.152	3050	1805	3000
	C6LB-R8-7G	0.375-0.500	.312	.525	.152	3050	1805	3000
	C6LB-R8-8G	0.438-0.563	.312	.525	.152	3050	1805	3000
5/16"	C6LB-R10-4G	0.125-0.375	.390	.656	.201	4725	2810	4600
	C6LB-R10-6G	0.250-0.500	.390	.656	.201	4725	2810	4600
	C6LB-R10-8G	0.375-0.625	.390	.656	.201	4725	2810	4600
3/8"	C6LB-R12-4G	0.125-0.375	.468	.787	.248	6825	4020	6500
	C6LB-R12-6G	0.250-0.500	.468	.787	.248	6825	4020	6500
	C6LB-R12-8G	0.375-0.625	.468	.787	.248	6825	4020	6500
	C6LB-R12-10G	0.500-0.750	.468	.787	.248	6825	4020	6500
	C6LB-R12-12G	0.625-0.875	.468	.787	.248	6825	4020	6500
3/8"	C6LB-R12-14G	0.750-1.000	.468	.787	.248	6825	4020	6500
Truss Head								
1/4"	C6LT-R8-4G	0.188-0.313	.312	.594	.115	3050	1805	3000
	C6LT-R8-5G	0.250-0.375	.312	.594	.115	3050	1805	3000
	C6LT-R8-7G	0.375-0.500	.312	.594	.115	3050	1805	3000
	C6LT-R8-8G	0.438-0.563	.312	.594	.115	3050	1805	3000
3/8"	C6LT-R12-4G	0.125-0.375	.468	.922	.202	6825	4020	6500
	C6LT-R12-6G	0.250-0.500	.468	.922	.202	6825	4020	6500
	C6LT-R12-8G	0.375-0.625	.468	.922	.202	6825	4020	6500
	C6LT-R12-10G	0.500-0.750	.468	.922	.202	6825	4020	6500

*Uses 3LC collar

Aluminum Pin

Diameter	Part No.	Grip Range	Max Hole Size	[B] Head Dia (max)	[C] Head Height (max)	Typical Shear (lbs)	Typical Clamp (lbf)	Typical Tensile (lbs)
Round Head								
1/4"	C6LB-C8-4	0.188-0.313	.266	.525	.152	1875	950	1800
3/8"	C6LB-C12-6	0.250-0.500	.391	.787	.248	4200	2200	4200
	C6LB-C12-8	0.375-0.625	.391	.787	.248	4200	2200	4200
	C6LB-C12-10	0.500-0.750	.391	.787	.248	4200	2200	4200
	C6LB-C12-12	0.625-0.875	.391	.787	.248	4200	2200	4200

NOTE: Part number listings reflect typical stock. Items not listed require a minimum order.

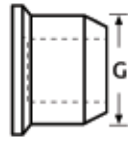
Stainless Steel Pin

Diameter	Part No.	Grip Range	Max Hole Size	[B] Head Dia (max)	[C] Head Height (max)	Typical Shear (lbs)	Typical Clamp (lbf)	Typical Tensile (lbs)
C98LT Head - Polished								
3/16"	C98LT-U6-3BR	0.125-0.250	.203	.492	.106	2000	1025	1455
	C98LT-U6-5BR	0.250-0.375	.203	.492	.106	2000	1025	1455
	C98LT-U6-6BR	0.313-0.438	.203	.492	.106	2000	1025	1455
	C98LT-U6-7BR	0.375-0.500	.203	.492	.106	2000	1025	1455
	C98LT-U6-9BR	0.500-0.625	.203	.492	.106	2000	1025	1455
	C98LT-U6-10BR	0.563-0.688	.203	.492	.106	2000	1025	1455
	C98LT-U6-11BR	0.625-0.750	.203	.492	.106	2000	1025	1455
	C98LT-U6-12BR	0.688-0.813	.203	.492	.106	2000	1025	1455
Round Head								
1/4"	C6LB-U8-3	0.125-0.250	.266	.525	.152	3550	1805	2750
	C6LB-U8-4	0.188-0.313	.266	.525	.152	3550	1805	2750
	C6LB-U8-5	0.250-0.375	.266	.525	.152	3550	1805	2750
	C6LB-U8-6	0.313-0.438	.266	.525	.152	3550	1805	2750
	C6LB-U8-8	0.438-0.563	.266	.525	.152	3550	1805	2750
	C6LB-U8-9	0.500-0.625	.266	.525	.152	3550	1805	2750
3/8"	C6LB-U12-6	0.250-0.500	.391	.787	.248	7950	4020	6100
	C6LB-U12-8	0.375-0.625	.391	.787	.248	7950	4020	6100
	C6LB-U12-10	0.500-0.750	.391	.787	.248	7950	4020	6100
Truss Head								
3/8"	C6LT-U12-4	0.125-0.375	.391	.922	.202	7950	4020	6100
	C6LT-U12-6	0.250-0.500	.391	.922	.202	7950	4020	6100
	C6LT-U12-8	0.375-0.625	.391	.922	.202	7950	4020	6100
	C6LT-U12-10	0.500-0.750	.391	.922	.202	7950	4020	6100

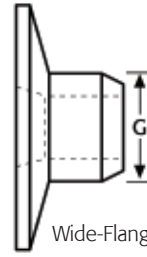
NOTE: Part number listings reflect typical stock. Items not listed require a minimum order.



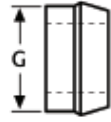
C6L Lockbolt Collars



Flanged 3LC



Wide-Flanged
3LCW



Non-Flanged
2LC

Steel, Zinc Plated

Diameter	Part No.	Width (G)
Non-Flanged		
3/16"	2LC-R6G	.304-.311
1/4"	2LC-R8G	.402-.409
5/16"	2LC-R10G	.485-.494
3/8"	2LC-R12G	.590-.600
Flanged		
3/16"	3LC-2R6G	.304-.311
1/4"	3LC-2R8G	.402-.409
5/16"	3LC-2R10G	.498-.507
3/8"	3LC-2R12G	.599-.610
Wide-Flanged		
1/4"	3LCW-2R8G	.400-.409

Aluminum

Diameter	Part No.	Width (G)
Non-Flanged		
3/16"	2LC-F6	.304-.311
1/4"	2LC-F8	.402-.409
5/16"	2LC-F10	.485-.494
3/8"	2LC-F12	.590-.600
Flanged		
1/4"	3LC-F8	.402-.409
5/16"	3LC-F10	.498-.507
3/8"	3LC-F12	.599-.610

Stainless Steel

Diameter	Part No.	Width (G)
Non-Flanged		
3/16"	2LC-2CU6	.304-.311
1/4"	2LC-2CU8	.402-.409
3/8"	2LC-2CU12	.485-.494
Flanged		
3/16"	3LC-2CU6	.304-.311
1/4"	3LC-2CU8	.402-.409
3/8"	3LC-2CU12	.599-.610

Installation Tooling

Diameter	Installation Tool	Nose Assembly	Type
3/16"	LH-224	99-3201	Pneudraulic
	2480	99-3201	Hydraulic
1/4"	LH-224	99-3204	Pneudraulic
	2480	99-3204	Hydraulic
5/16"	255	99-1439	Pneudraulic
	256	99-1439	Pneudraulic
	2581	99-1439	Hydraulic
3/8"	255*	99-1440	Pneudraulic
	256	99-1440	Hydraulic
	2581	99-1440	Hydraulic

* Aluminum Only



C6L Grip tables

Grip	Grip Range	3/16" (6)		1/4" (8)		Grip	Grip Range	5/16" (10)		3/8" (12)	
		D	E	D	E			D	E	D	E
2	0.063 - 0.188	0.394	1.404	0.485	1.520						
3	0.125 - 0.250	0.457	1.466	0.548	1.583						
4	0.188 - 0.313	0.519	1.529	0.610	1.645	4	0.125 - 0.375	0.749	1.906	0.809	2.125
5	0.250 - 0.375	0.582	1.591	0.673	1.708						
6	0.313 - 0.438	0.644	1.654	0.735	1.770	6	0.250 - 0.500	0.874	2.031	0.934	2.250
7	0.375 - 0.500	0.707	1.716	0.798	1.833						
8	0.438 - 0.563	0.769	1.779	0.860	1.895	8	0.375 - 0.625	1.000	2.156	1.059	2.375
9	0.500 - 0.625	0.832	1.841	0.923	1.958						
10	0.563 - 0.688	0.894	1.904	0.985	2.020	10	0.500 - 0.750	1.124	2.281	1.184	2.500
11	0.625 - 0.750	0.957	1.966	1.048	2.083						
12	0.688 - 0.813	1.019	2.029	1.110	2.145	12	0.625 - 0.875	1.249	2.406	1.309	2.625
13	0.750 - 0.875	1.082	2.091	1.173	2.208						
14	0.813 - 0.938	1.144	2.154	1.235	2.270	14	0.750 - 1.000	1.374	2.531	1.434	2.750
15	0.875 - 1.000	1.207	2.216	1.298	2.333						
16	0.938 - 1.063	1.269	2.279	1.360	2.395	16	0.875 - 1.125	1.500	2.656	1.559	2.875
17	1.000 - 1.125	1.332	2.341	1.423	2.458						
18	1.063 - 1.188	1.394	2.404	1.458	2.520	18	1.000 - 1.250	1.624	2.781	1.684	3.000
19	1.125 - 1.250	1.457	2.466	1.548	2.583						
20	1.188 - 1.313	1.519	2.529	1.610	2.645	20	1.125 - 1.375	1.749	2.906	1.809	3.125
21	1.250 - 1.375	1.582	2.591	1.673	2.708						
22	1.313 - 1.438	1.644	2.654	1.735	2.770	22	1.250 - 1.500	1.874	3.031	1.934	3.250
23	1.375 - 1.500	1.707	2.716	1.798	2.833						
24	1.438 - 1.563			1.866	2.895	24	1.375 - 1.625	2.000	3.156	2.059	3.375
25	1.500 - 1.625			1.923	2.958						
26	1.563 - 1.688			1.985	3.020	26	1.500 - 1.750	2.124	3.281	2.184	3.500
27	1.625 - 1.750			2.048	3.083						
28	1.688 - 1.813			2.110	3.145	28	1.625 - 1.875	2.249	3.406	2.309	3.625
29	1.750 - 1.875			2.173	3.208						
30	1.813 - 1.938			2.235	3.270	30	1.750 - 2.000	2.374	3.531	2.434	3.750
31	1.875 - 2.000			2.298	3.333						
32	1.938 - 2.063			2.368	3.395	32	1.875 - 2.125	2.500	3.656	2.559	3.875
37				2.637	3.708						

Ordering Information - C6L

Follow the form below to construct a part number for ordering C6L pins and their respective collars.
Refer to the Grip Data chart for grip numbers.

Pins (Grade 2 Steel, Aluminum, Stainless Steel)

C6L – (MATERIAL) (DIAMETER) – (GRIP NUMBER) (FINISH)

Example: C6LT-R8-4G is a C6L HuckBolt Pin, Truss Head, Carbon Steel, 1/4" Diameter, Grip 4, Zinc Finish

Head Style	Prefix	Material	Code	Diameter	Code	Grip	Finish	Suffix
Round	C6LB	Grade 2 Carbon Steel	R	3/16"	6	Refer to Grip Tables	Zinc	G
Truss	C6LT	2024 Aluminum Alloy	C	1/4"	8			
Flush	C6L90	6061 Aluminum Alloy	F	5/16"	10			
Rivet	C98LT	Stainless Steel	U	3/8"	12			

Pins (Grade 5)

C120L (HEAD STYLE) – (MATERIAL) (DIAMETER) – (GRIP NUMBER) (FINISH)

Example: C120LT-R8-4G is a C120L HuckBolt Pin, Truss Head, Carbon Steel, 1/4" Diameter, Grip 4, Zinc Finish

Head Style	Prefix	Material	Code	Diameter	Code	Grip	Finish	Suffix
Round	C120B	Grade 5 Carbon Steel	R	3/16"	6	Refer to Grip Tables	Zinc	G
Truss	C120T			1/4"	8			
Flush	C12090			5/16"	10			
				3/8"	12			

Collars (Grade 2 Steel, Aluminum, Stainless Steel)

(TYPE) – (MATERIAL) (DIAMETER) (FINISH)

Example: 2LC-R8G is a Standard C6L HuckBolt Collar, Carbon Steel, 1/4" Diameter, Zinc Finish

Head Style	Prefix	Material	Code	Diameter	Code	Finish	Suffix
Standard	2LC	Carbon Steel	2R/R	3/16"	6	Zinc	G
Flange	3LC	6061 Alum Alloy Heat Treated	I	1/4"	8		
Wide Flange	3LCW	6061 Alum Alloy	F	5/16"	10		
		Stainless Steel	2CU	3/8"	12		

Collars (Grade 5)

(TYPE) – (MATERIAL) (DIAMETER) (FINISH)

Example: 2LC120-R8G is a Standard C120L HuckBolt Collar, Carbon Steel, 1/4" Diameter, Zinc Finish

Grade 5	Prefix	Material	Code	Diameter	Code	Finish	Suffix
Standard	2LC120	Carbon Steel	2R/R	3/16"	6	Zinc	G
Flange	3LC120			1/4"	8		
				5/16"	10		
				3/8"	12		

Magna-Grip®

Offering a wide grip range and uniform installed values.

In applications where a wide grip range is required and a flush pin break to the collar is beneficial, Huck Magna-Grip® is the ideal fastener for the job. In fact, Magna-Grip's wide grip range can replace up to 4 traditional HuckBolts.

Like all Huck engineered fasteners, Magna-Grip offers the highest level of vibration resistance possible. Magna-Grip installs reliably, and consistently provides high, uniform installed values.

Available Sizes:

3/16", 1/4", 5/16", 3/8"

Materials:

Steel, Aluminum

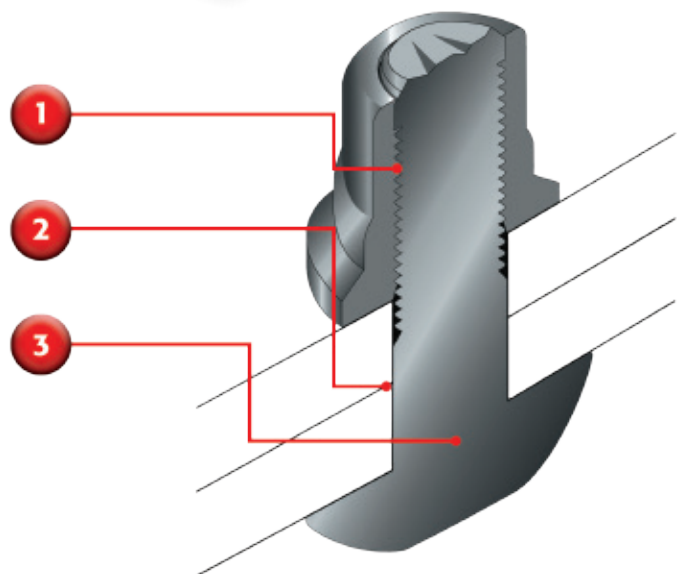
Headstyles:

Button, Truss, Broad Truss, 90° Flush, 98T



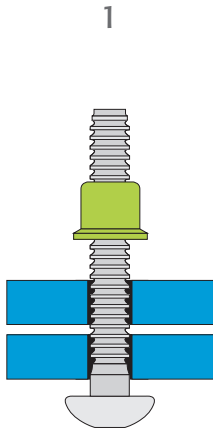
Secure, Fast Installation

1. Flush-breaking, lock-groove design provides a wide grip range to reduce inventory requirements.
2. Collar material swaged into the annular pin grooves forms a permanent, vibration-proof connection that promotes increased customer satisfaction and reduced warranty claims.
3. Hole preparation isn't critical. Built-in system values yield high, consistent clamp loads, and gap removal.

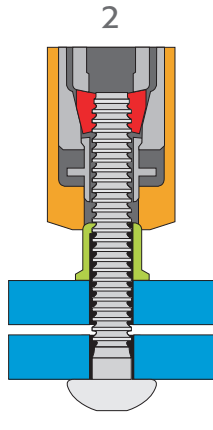


Installation Sequence

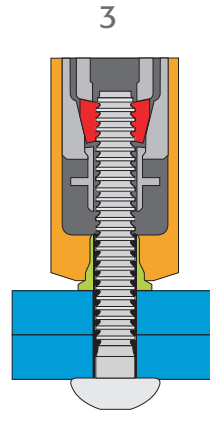
Perfect installations do not depend upon worker skill or a precisely calibrated impact wrench — and can be achieved with just a few minutes training.



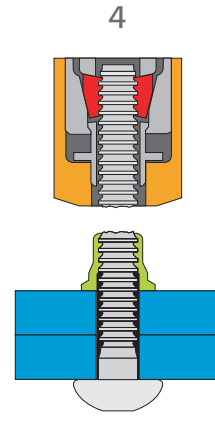
The fastener pin is inserted through a prepared hole. The precision collar is placed over the other end.



The Huck installation tool is applied and engages the pin. When the tool is activated, it pulls the pin in a straight line while pushing down on the collar.

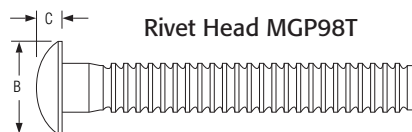
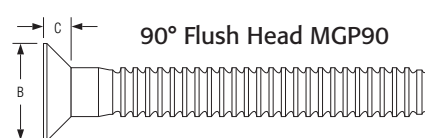
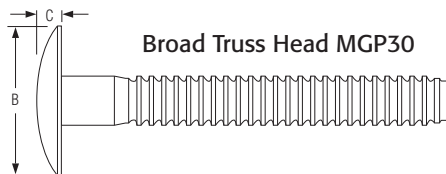
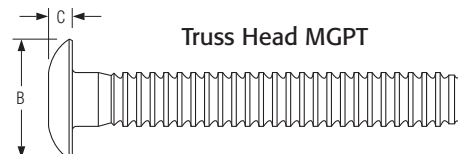
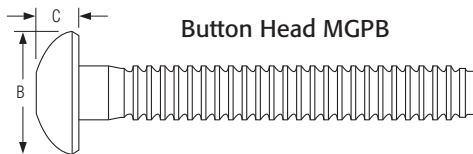


The tool moves forward over the collar, molding the collar material into the grooves of the pin. This process, called "swaging," causes a precise stretching of the pin and collar, developing the fastener's clamping force.



When swaging is complete the pintail is automatically tensioned off, flush with the end of the collar. The tool then pushes off from the collar. The result is a permanent, mechanically locked fastener.

Magna-Grip Head Style Options



Steel Pin - Zinc Plated

Diameter	Part No.	Grip Range	Max Hole Size	[B] Head Dia (max)	[C] Head Height (max)	Typical Shear (lbs)	Typical Clamp (lbf)	Typical Tensile (lbs)
Button Head								
3/16"	MGPB-R6-10G	.062-.625	.219	.395	.129	2000	1500	2700
	MGPB-R6-20G	.312-1.250	.219	.395	.129	2000	1500	2700
1/4"	MGPB-R8-10G	.062-.625	.281	.520	.154	2700	2000	4000
	MGPB-R8-20G	.312-1.250	.281	.520	.154	2700	2000	4000
5/16"	MGPB-R10-12G	.125-.750	.359	.655	.206	3900	2900	6200
	MGPB-R10-22G	.625-1.375	.359	.655	.206	3900	2900	6200
3/8"	MGPB-R12-14G	.125-.875	.422	.780	.250	6000	4000	9000
	MGPB-R12-26G	.750-1.625	.422	.780	.250	6000	4000	9000
98T Head								
3/16"	MGP98T-R6-10G	.062-.625	.219	.488	.105	2000	1500	2700
	MGP98T-R6-10GP	.062-.625	.219	.488	.105	2000	1500	2700
	MGP98T-R6-20G	.312-1.250	.219	.488	.105	2000	1500	2700
Truss Head								
1/4"	MGPT-R8-10G	.062-.625	.281	.582	.120	2700	2000	4000
	MGPT-R8-10GP	.062-.625	.281	.582	.120	2700	2000	4000
	MGPT-R8-20G	.312-1.250	.281	.582	.120	2700	2000	4000
5/16"	MGPT-R10-12G	.125-.750	.359	.802	.149	3900	2900	6200
3/8"	MGPT-R12-14G	.125-.875	.422	.905	.175	6000	4000	9000
Broad Truss Head								
1/4"	MGP30-R8-10G	.062-.625	.281	.978	.165	2700	2000	4000
	MGP30-R8-24G	.062-1.500	.281	.978	.165	2700	2000	4000
3/8"	MGP30-R12-24G	.625-1.500	.422	1.259	.215	6000	4000	9000
	MGP30-R12-32G	1.125-2.000	.422	1.259	.215	6000	4000	9000
90° Flush Head								
3/16"	MGP90-R6-10G	.062-.625	.219	.361	.105	2000	1500	2700
1/4"	MGP90-R8-10G	.062-.625	.281	.475	.130	2700	2000	4000

NOTE: Part number listings reflect typical stock. Items not listed require a minimum order.

Steel Pin - Zinc Plated - Stainless Steel Cap

Diameter	Part No.	Grip Range	Max Hole Size	[B] Head Dia (max)	[C] Head Height (max)	Typical Shear (lbs)	Typical Clamp (lbf)	Typical Tensile (lbs)
Truss Head								
1/4"	MGPTC-R8-10G	.062-.625	.281	.582	.120	2700	2000	4000
3/8"	MGPTC-R12-14G	.125-.875	.422	.905	.210	6000	4000	9000



Aluminum Pins

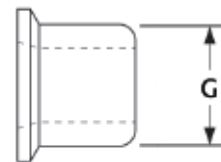
Diameter	Part No.	Grip Range	Max Hole Size	[B] Head Dia (max)	[C] Head Height (max)	Typical Shear (lbs)	Typical Clamp (lbf)	Typical Tensile (lbs)
Button Head								
3/16"	MGPB-E6-10	.062-.625	.219	.395	.129	1000	800	1300
1/4"	MGPB-E8-10	.062-.625	.281	.520	.154	1600	1400	2500
	MGPB-E8-20	.312-1.250	.281	.520	.154	1600	1400	2500
5/16"	MGPB-E10-12	.125-.750	.359	.655	.206	2700	2200	4100
3/8"	MGPB-E12-14	.125-.875	.422	.780	.250	3900	3200	5500
98T Head								
3/16"	MGP98T-E6-10	.062-.625	.219	.488	.108	1000	800	1300
	MGP98T-E6-20	.312-1.250	.219	.488	.108	1000	800	1300
Truss Head								
1/4"	MGPT-E8-10	.062-.625	.281	.582	.120	1600	1400	2500
Broad Truss Head								
3/8"	MGP30-E12-24	.625-1.500	.422	1.259	.215	3900	3200	5500
90° Flush Head								
3/16"	MGP90-E6-10	.062-.625	.219	.361	.105	1000	800	1300
1/4"	MGP90-E8-10	.062-.625	.281	.475	.130	1600	1400	2500

NOTE: Part number listings reflect typical stock. Items not listed require a minimum order.

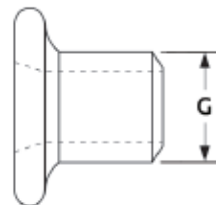
Magna-Grip Lockbolt Collars



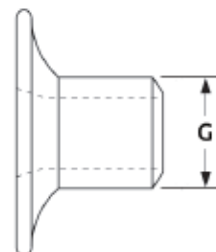
	Diameter	Part No.	Width(G)
Steel - Zinc Plated			
Flanged	3/16"	MGC-R6U	.305-.315
	1/4"	MGC-R8U	.395-.405
	5/16"	MGC-R10U	.500-.510
	3/8"	MGC-R12U	.602-.612
Medium Flange	3/16"	MGCS-R6U	.305-.315
Wide Flange	3/16"	MGCW-R6U	.305-.315
	1/4"	MGCW-R8U	.395-.405
Aluminum			
Flanged	3/16"	MGC-F6	.305-.315
	1/4"	MGC-F8	.395-.405
	5/16"	MGC-F10	.500-.510
	3/8"	MGC-F12	.602-.612
Wide Flange	3/16"	MGCW-F6	.305-.315



Standard-Flanged MGC



Medium-Flanged MGCS



Wide-Flanged MGCW

Ordering Information - Magna Grip

Follow the tables below to construct part numbers for ordering Magna-Grip pins and collars.
Refer to the Grip Data chart for grip numbers.

Pins

MGP (HEAD STYLE) - (MATERIAL) (DIAMETER) - (GRIP NUMBER) (FINISH)

Example: MGPB-R8-10G is a Magna-Grip fastener, Button Head, Steel, 1/4" Diameter, Grip 10 with a Zinc Finish

Head Style	Prefix
Button Head	B
Truss Head	T
Broad Truss Head	30
Rivet Head	98T
90° Flush Head	90

Material	Code
Steel	R
Aluminum	E

Diameter	Code
3/16"	6
1/4"	8
5/16"	10
3/8"	12

Grip Number
Please refer to the dimensional data chart.

Finish	Code
Zinc	G

* Additional coatings are available upon request

Collars

(FLANGE STYLE) - (MATERIAL) (DIAMETER) (FINISH) (OPTIONS)

Example: MGCW-R8U is a wide Flange Magna-Grip Collar, Steel, 1/4" Diameter, with a Zinc Finish

Flange Style	Prefix
Standard	MGC
Medium	MGCS
Wide	MGCW

Material	Code
Steel	R
Aluminum	F

Diameter	Code
3/16"	6
1/4"	8
5/16"	10
3/8"	12

Finish	Code
Zinc Chromate Gold	U

* Additional coatings are available upon request

Options	Code
Tab Lock	L

Magna-Grip Installation Tooling

Diameter	Installation Tool	Nose Assembly	Type
3/16"	LH-224	99-3201	Pneudraulic
	255	99-3206	Pneudraulic
	256	99-3206	Pneudraulic
	2480	99-3201	Hydraulic
	2581	99-3206	Hydraulic
1/4"	LH-224	99-3204	Pneudraulic
	255	99-3207	Pneudraulic
	256	99-3207	Pneudraulic
	2480	99-3204	Hydraulic
	2581	99-3207	Hydraulic
5/16"	255	99-1439	Pneudraulic
	256	99-1439	Pneudraulic
	2581	99-1439	Pneudraulic
	2600	99-3217	Pneudraulic
	255*	99-1440	Pneudraulic
3/8"	256	99-1440	Pneudraulic
	2581	99-1440	Hydraulic
	2600	99-3220	Hydraulic
	2620PT	H99-1492	Hydraulic

* Aluminum Only



Hucktainer®

Two-piece specialty fastener for fiberglass reinforced plywood panels.

The Hucktainer® specialty fastener installs with a consistent pressure, reducing the potential for crushing or crazing FRP panels and metal-clad applications. Each features a heavy zinc plating that resists corrosion, and an integral seal that helps keep the elements and other contaminants from invading the joint. Unlike threaded fasteners, Hucktainer is never over-torqued or under-torqued. Consistent clamp and fast, foolproof installation is what you'll get every time with Hucktainer.

Designed specifically for truck trailers, truck bodies, cargo containers, and other structures fabricated from fiberglass reinforced plywood, Hucktainer fasteners provide the consistent clamp and fast, foolproof installation required for maximum product quality and productivity.

Available Sizes:

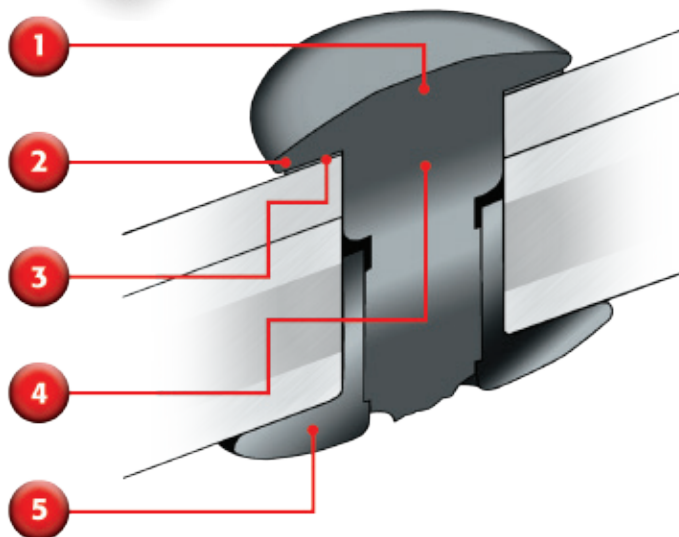
3/8"

Materials:

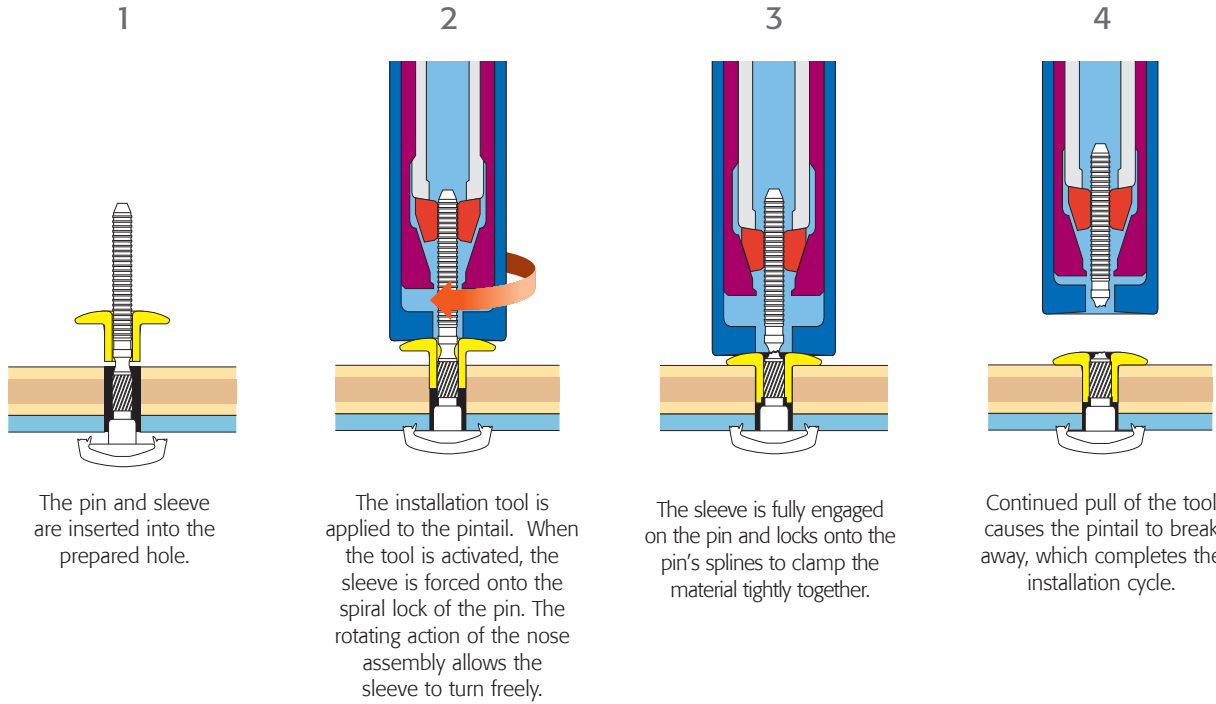
Steel

Weather-Resistant Seal

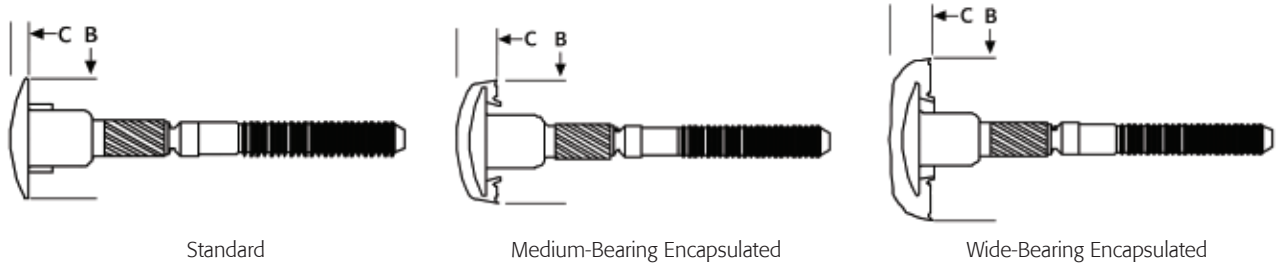
1. Lower profile head design saves cargo space.
2. Heads may be plastic-encapsulated for maximum corrosion-resistance; UV-resistant head capsules are colorfast and won't fade.
3. Integral weather-resistant seal provides protection from the elements.
4. Heavy-zinc plating protects against corrosion and preserves good looks.
5. One sleeve fits all pins; no need to mix and match.



Installation Sequence



Hucktainer Data & Dimensions



Steel Pin - Zinc Plated

Diameter	Part No.	Grip Range	Max Hole Size	[B] Head Dia (max)	[C] Head Height (max)	Typical Clamp (lbf)	Typical Tensile (lbs)		
							Min Grip	Mid Grip	Max Grip
Standard Head									
3/8"	HLPP-R12-10PL	.562-.687	.421	.830	.160	700	800	1200	1800
	HLPP-R12-11PL	.625-.750	.421	.830	.160	700	800	1200	1800
	HLPP-R12-12PL	.687-.812	.421	.830	.160	700	800	1200	1800
	HLPP-R12-13PL	.750-.875	.421	.830	.160	700	800	1200	1800
	HLPP-R12-14PL	.812-.937	.421	.830	.160	700	800	1200	1800
	HLPP-R12-15PL	.875-1.000	.421	.830	.160	700	800	1200	1800
	HLPP-R12-16PL	.937-1.062	.421	.830	.160	700	800	1200	1800
	HLPP-R12-17PL	1.000-1.125	.421	.830	.160	700	800	1200	1800
	HLPP-R12-18PL	1.062-1.187	.421	.830	.160	700	800	1200	1800
	HLPP-R12-19PL	1.125-1.250	.421	.830	.160	700	800	1200	1800
HLPP-R12-20PL	1.187-1.312	.421	.830	.160	700	800	1200	1800	

NOTE: Part number listings reflect typical stock. Items not listed require a minimum order.

Steel Pin - Zinc Plated

Diameter	Part No.	Grip Range	Max Hole Size	[B] Head Dia (max)	[C] Head Height (max)	Typical Clamp (lbf)	Typical Tensile (lbs)		
							Min Grip	Mid Grip	Max Grip
Medium Bearing Encapsulated Head - Gray									
3/8"	HLPMG-R12-9PL	.500-.625	.421	.950	.300	700	800	1200	1800
	HLPMG-R12-10PL	.562-.687	.421	.950	.300	700	800	1200	1800
	HLPMG-R12-11PL	.625-.750	.421	.950	.300	700	800	1200	1800
	HLPMG-R12-12PL	.687-.812	.421	.950	.300	700	800	1200	1800
	HLPMG-R12-13PL	.750-.875	.421	.950	.300	700	800	1200	1800
	HLPMG-R12-14PL	.812-.937	.421	.950	.300	700	800	1200	1800
	HLPMG-R12-15PL	.875-1.000	.421	.950	.300	700	800	1200	1800
	HLPMG-R12-16PL	.937-1.062	.421	.950	.300	700	800	1200	1800
	HLPMG-R12-17PL	1.000-1.125	.421	.950	.300	700	800	1200	1800
	HLPMG-R12-18PL	1.062-1.187	.421	.950	.300	700	800	1200	1800
HLPMG-R12-19PL	1.125-1.250	.421	.950	.300	700	800	1200	1800	
Medium Bearing Encapsulated Head - White									
3/8"	HLPMW-R12-9PL	.500-.625	.421	.950	.300	700	800	1200	1800
	HLPMW-R12-10PL	.562-.687	.421	.950	.300	700	800	1200	1800
	HLPMW-R12-11PL	.625-.750	.421	.950	.300	700	800	1200	1800
	HLPMW-R12-12PL	.687-.812	.421	.950	.300	700	800	1200	1800
	HLPMW-R12-13PL	.750-.875	.421	.950	.300	700	800	1200	1800
	HLPMW-R12-14PL	.812-.937	.421	.950	.300	700	800	1200	1800
	HLPMW-R12-15PL	.875-1.000	.421	.950	.300	700	800	1200	1800
	HLPMW-R12-16PL	.937-1.062	.421	.950	.300	700	800	1200	1800
	HLPMW-R12-17PL	1.000-1.125	.421	.950	.300	700	800	1200	1800
	HLPMW-R12-18PL	1.062-1.187	.421	.950	.300	700	800	1200	1800
Medium Bearing Encapsulated Head - Hertz Yellow									
3/8"	HLPMHY-R12-9PL	.500-.625	.421	.950	.300	700	800	1200	1800
	HLPMHY-R12-10PL	.562-.687	.421	.950	.300	700	800	1200	1800
	HLPMHY-R12-11PL	.625-.750	.421	.950	.300	700	800	1200	1800
	HLPMHY-R12-12PL	.687-.812	.421	.950	.300	700	800	1200	1800
	HLPMHY-R12-13PL	.750-.875	.421	.950	.300	700	800	1200	1800
	HLPMHY-R12-14PL	.812-.937	.421	.950	.300	700	800	1200	1800
	HLPMHY-R12-15PL	.875-1.000	.421	.950	.300	700	800	1200	1800
	HLPMHY-R12-16PL	.937-1.062	.421	.950	.300	700	800	1200	1800
	HLPMHY-R12-17PL	1.000-1.125	.421	.950	.300	700	800	1200	1800
	HLPMHY-R12-18PL	1.062-1.187	.421	.950	.300	700	800	1200	1800
HLPMHY-R12-19PL	1.125-1.250	.421	.950	.300	700	800	1200	1800	
Medium Bearing Encapsulated Head - Ryder Yellow									
3/8"	HLPMPRY-R12-9PL	.500-.625	.421	.950	.300	700	800	1200	1800
	HLPMPRY-R12-10PL	.562-.687	.421	.950	.300	700	800	1200	1800
	HLPMPRY-R12-11PL	.625-.750	.421	.950	.300	700	800	1200	1800
	HLPMPRY-R12-12PL	.687-.812	.421	.950	.300	700	800	1200	1800
	HLPMPRY-R12-13PL	.750-.875	.421	.950	.300	700	800	1200	1800
	HLPMPRY-R12-14PL	.812-.937	.421	.950	.300	700	800	1200	1800
	HLPMPRY-R12-15PL	.875-1.000	.421	.950	.300	700	800	1200	1800
	HLPMPRY-R12-16PL	.937-1.062	.421	.950	.300	700	800	1200	1800
	HLPMPRY-R12-17PL	1.000-1.125	.421	.950	.300	700	800	1200	1800
	HLPMPRY-R12-18PL	1.062-1.187	.421	.950	.300	700	800	1200	1800
HLPMPRY-R12-19PL	1.125-1.250	.421	.950	.300	700	800	1200	1800	
Wide Bearing Encapsulated Head - Gray									
3/8"	HLPEG-R12-9PL	.500-.625	.421	1.210	.325	700	800	1200	1800
	HLPEG-R12-10PL	.562-.687	.421	1.210	.325	700	800	1200	1800
	HLPEG-R12-11PL	.625-.750	.421	1.210	.325	700	800	1200	1800
	HLPEG-R12-12PL	.687-.812	.421	1.210	.325	700	800	1200	1800
	HLPEG-R12-13PL	.750-.875	.421	1.210	.325	700	800	1200	1800
	HLPEG-R12-14PL	.812-.937	.421	1.210	.325	700	800	1200	1800
	HLPEG-R12-15PL	.875-1.000	.421	1.210	.325	700	800	1200	1800

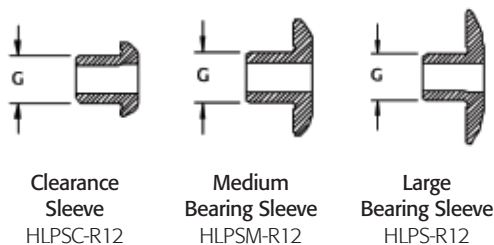
NOTE: Part number listings reflect typical stock. Items not listed require a minimum order.

Steel Pin - Zinc Plated

Diameter	Part No.	Grip Range	Max Hole Size	[B] Head Dia (max)	[C] Head Height (max)	Typical Clamp (lbf)	Typical Tensile (lbs)		
							Min Grip	Mid Grip	Max Grip
Wide Bearing Encapsulated Head - Gray									
3/8"	HLPEG-R12-16PL	.937-1.062	.421	1.210	.325	700	800	1200	1800
	HLPEG-R12-17PL	1.000-1.125	.421	1.210	.325	700	800	1200	1800
	HLPEG-R12-18PL	1.062-1.187	.421	1.210	.325	700	800	1200	1800
	HLPEG-R12-19PL	1.125-1.250	.421	1.210	.325	700	800	1200	1800
Wide Bearing Encapsulated Head - White									
3/8"	HLPEW-R12-9PL	.500-.625	.421	1.210	.325	700	800	1200	1800
	HLPEW-R12-10PL	.562-.687	.421	1.210	.325	700	800	1200	1800
	HLPEW-R12-11PL	.625-.750	.421	1.210	.325	700	800	1200	1800
	HLPEW-R12-12PL	.687-.812	.421	1.210	.325	700	800	1200	1800
	HLPEW-R12-13PL	.750-.875	.421	1.210	.325	700	800	1200	1800
	HLPEW-R12-14PL	.812-.937	.421	1.210	.325	700	800	1200	1800
	HLPEW-R12-15PL	.875-1.000	.421	1.210	.325	700	800	1200	1800
	HLPEW-R12-16PL	.937-1.062	.421	1.210	.325	700	800	1200	1800
	HLPEW-R12-17PL	1.000-1.125	.421	1.210	.325	700	800	1200	1800
	HLPEW-R12-18PL	1.062-1.187	.421	1.210	.325	700	800	1200	1800
HLPEW-R12-19PL	1.125-1.250	.421	1.210	.325	700	800	1200	1800	
Wide Bearing Encapsulated Head - Hertz Yellow									
3/8"	HLPEHY-R12-9PL	.500-.625	.421	1.210	.325	700	800	1200	1800
	HLPEHY-R12-10PL	.562-.687	.421	1.210	.325	700	800	1200	1800
	HLPEHY-R12-11PL	.625-.750	.421	1.210	.325	700	800	1200	1800
	HLPEHY-R12-12PL	.687-.812	.421	1.210	.325	700	800	1200	1800
	HLPEHY-R12-13PL	.750-.875	.421	1.210	.325	700	800	1200	1800
	HLPEHY-R12-14PL	.812-.937	.421	1.210	.325	700	800	1200	1800
	HLPEHY-R12-15PL	.875-1.000	.421	1.210	.325	700	800	1200	1800
	HLPEHY-R12-16PL	.937-1.062	.421	1.210	.325	700	800	1200	1800
	HLPEHY-R12-17PL	1.000-1.125	.421	1.210	.325	700	800	1200	1800
	HLPEHY-R12-18PL	1.062-1.187	.421	1.210	.325	700	800	1200	1800
HLPEHY-R12-19PL	1.125-1.250	.421	1.210	.325	700	800	1200	1800	
Wide Bearing Encapsulated Head - Ryder Yellow									
3/8"	HLPERY-R12-9PL	.500-.625	.421	1.210	.325	700	800	1200	1800
	HLPERY-R12-10PL	.562-.687	.421	1.210	.325	700	800	1200	1800
	HLPERY-R12-11PL	.625-.750	.421	1.210	.325	700	800	1200	1800
	HLPERY-R12-12PL	.687-.812	.421	1.210	.325	700	800	1200	1800
	HLPERY-R12-13PL	.750-.875	.421	1.210	.325	700	800	1200	1800
	HLPERY-R12-14PL	.812-.937	.421	1.210	.325	700	800	1200	1800
	HLPERY-R12-15PL	.875-1.000	.421	1.210	.325	700	800	1200	1800
	HLPERY-R12-16PL	.937-1.062	.421	1.210	.325	700	800	1200	1800
	HLPERY-R12-17PL	1.000-1.125	.421	1.210	.325	700	800	1200	1800
	HLPERY-R12-18PL	1.062-1.187	.421	1.210	.325	700	800	1200	1800
HLPERY-R12-19PL	1.125-1.250	.421	1.210	.325	700	800	1200	1800	

Minimum orders may apply

Hucktainer Sleeves - Zinc Plated



Installation Tooling

Diameter	Installation Tool	Nose Assembly	Type
3/8"	LH-224	99-3465	Pneudraulic
	256	99-3438	Pneudraulic
	2480	99-3464	Hydraulic
	2581	99-3438	Hydraulic

NOTE: Part number listings reflect typical stock. Items not listed require a minimum order.

Huck 360®

The engineered nut-and-bolt fastening system from the leader in vibration-resistant fastening, Huck.

The goal was simple: to design a high-strength bolting system that resists vibration loosening, no matter how extreme the environment. This system should offer quick installation and removal with conventional tools, deliver superior fatigue strength, and hold tight under high spike loads.

The result is the Huck 360®, the most advanced nut-and-bolt fastening system you'll find on the market today. Easy-to-install, the Huck 360 is engineered to be virtually maintenance-free and resistant to vibration, even under extreme conditions.

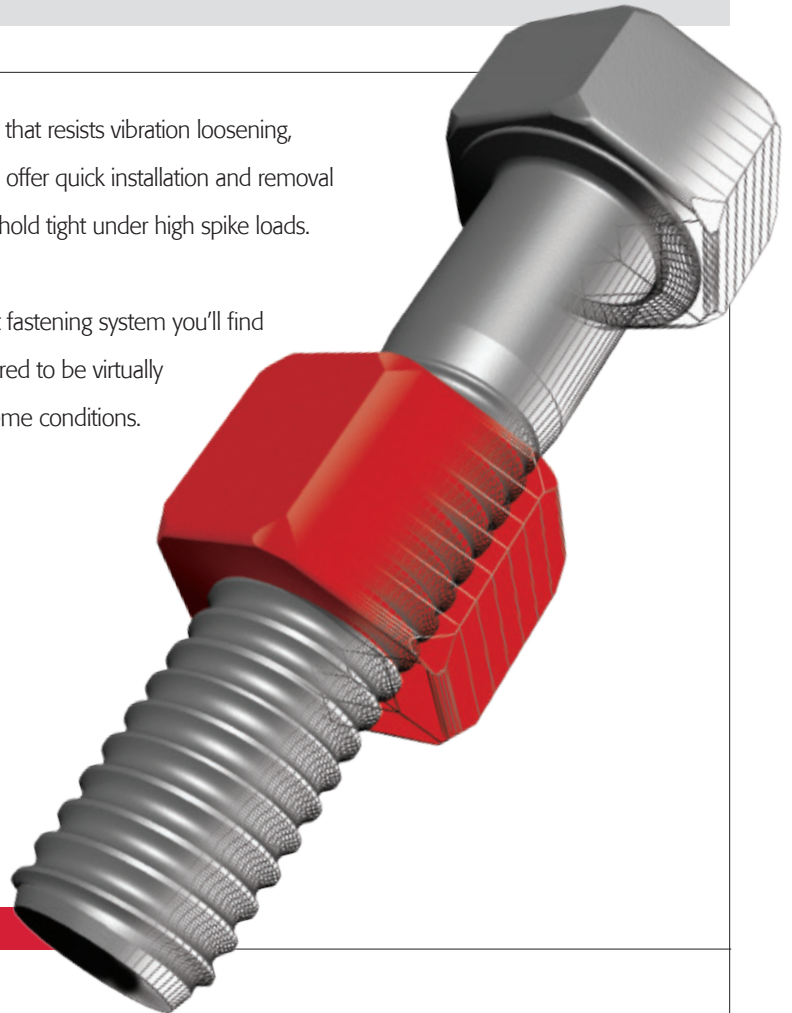
Available Sizes:

3/8", 1/2", 5/8", 3/4", 7/8", 1", 1-1/8", 1-3/8"
10mm, 12mm, 16mm, 20mm, and 36mm

Materials:

Steel

Contact Alcoa Fastening Systems & Rings for availability.

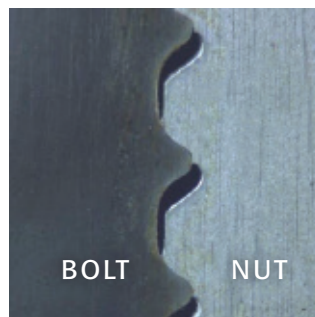


The Difference is in the Design



Huck 360® stays tight under severe vibration loading by eliminating the "gap" around the crest of the bolt. When tightened, the Huck 360 fills this gap, which prevents transverse motion between the 360 nut and bolt, keeping the assembly in place.

Huck 360®



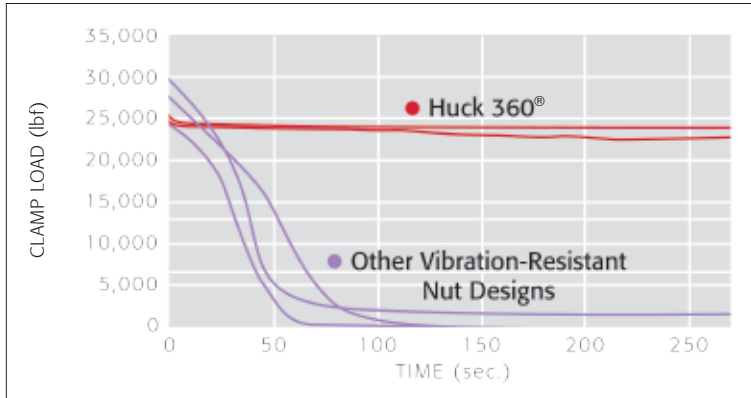
Thread flanks are locked.
Nut cannot move relative to bolt.

Conventional thread



Thread flanks can slide.
Nut can move relative to bolt.

Transverse Vibration Comparison



This chart shows that once vibration begins, clamp load quickly decays with conventional nuts and bolts, while it holds constant with Huck 360®.

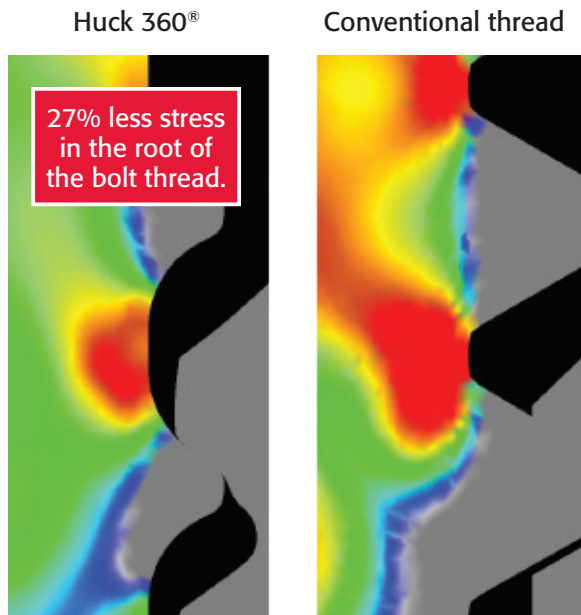
Increased Life

Because the Huck 360® was designed with shallow, low-notch factor bolt threads (the grooves aren't rolled as deep as a conventional bolt), the effective area of the fastener itself is widened by as much as 20%, increasing tensile and fatigue strength. In fact, the Huck 360 thread delivers 5 times the fatigue life of a standard thread bolt.



Improved Fatigue Performance

Finite Element Analysis (FEA) reveals that the shallow thread form of the Huck 360® results in 27% less axial stress in the root than conventional bolt threads. Stress concentration is the primary contributing factor leading to fatigue failures.



Reduce Maintenance, Save Time

The Huck 360® installs faster and more easily than the nuts and bolts you're accustomed to using, and maintenance intervals can be extended. The Huck 360's superior fatigue strength has proven to increase equipment uptime and productivity.

Huck 360® Benefits

- Resists vibration loosening.
- Withstands high spike loads.
- Increases equipment uptime.
- Installs 300% faster than conventional locknuts.
- Can be installed and removed with conventional tools.

* For more information visit www.afsrhuck.net or contact your nearest distributor, listed on the back of the catalogue.

Huck Structural Blind Rivets



When High Performance and Holding Power are Critical

Huck Structural Blind Rivets are Alcoa Fastening Systems & Rings' answer to loosening and vibration challenges. And it's the reason they are the world's strongest, most reliable, most consistent blind fastening solution available.

In fact, in fatigue tests, Huck Structural Blind Rivets outlasted the competition by almost 20-to-1. Engineered with a unique locking design, many of the Huck Structural Blind Rivets create an internal lock during installation that virtually eliminates pin pushout by mechanically locking the pin to the sleeve. Each locks permanently, reliably into place, with little effort.

Always accurate and easy to install, Huck Structural Blind Rivets offer quick one-worker installation. Inspections are simple to perform; no need for torque inspections or x-rays.

In applications where vibration resistance, reliability, and strong hold are critical, Huck Structural Blind Rivets offer the strength and durability needed. No fastening system is more dependable.

Sheet-Line Bulb Comparison

Even in minimum-grip applications, Huck fasteners outperform the competition. They're engineered to form a bulb directly on the sheet line, precisely where it's needed, to prevent pull-through.



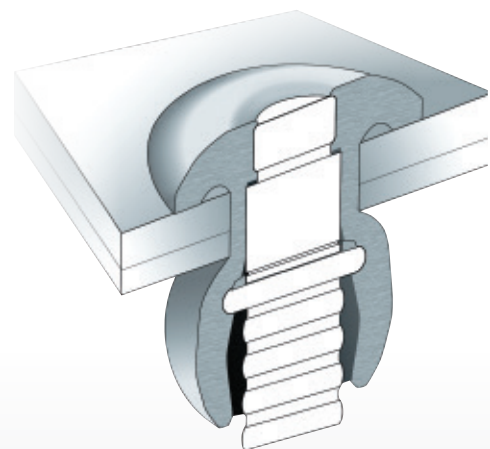
Auto-Bulb™

Bulb forms directly on sheet line.



The Competition

Bulb forms irregularly above sheet line resulting in lower installed values.



HuckLok's proprietary solid circle lock ensures maximum strength and vibration resistance. Shear ring at sheet line provides consistent clamp.

Types



Magna-Lok®

Hole-filling fastener with excellent gap pull-out and moisture resistance. Solid circle lock creates internal lock that virtually eliminates pin push-out.



Magna-Bulb®

Wide grip range fastener that forms a bulb directly on the sheet line. Offers a broader bearing surface.

HuckLok®

Wide 1/4" grip range, double-locking action clamps assembly from both sides for maximum joint integrity.



Auto-Bulb™

Features a tapered lead-in point for automated, high-speed assemblies. Forms a bulb directly on the sheet line, preventing pull-through. Available in stainless steel.



Magna-Tite®

Has water-resistant sealant for oversized holes and repairs. Large blind-side footprint for use in thin or low-strength materials.



BOM®

Blind, Oversize, Mechanically locked fasteners. Unique push-and-pull installation design for ultimate locking strength from blind-side install.

FloorTight®

Self-countersinking design for consistent installations in plywood and plymetal vehicle floor applications.



Magna-Lok®

The hole-filling fastener with mechanical circle lock and wide grip range.

The 360° solid-circle lock. It's Alcoa Fastening Systems and Rings' answer to loosening and vibration challenges. And it's the reason Magna-Lok® is the world's strongest, most reliable, most consistent blind fastening solution available. The unique locking design creates an internal lock during installation that virtually eliminates pin pushout by mechanically locking the pin to the sleeve. So Magna-Lok fasteners lock flush into place reliably. Permanently.

In lab shear fatigue tests, steel Magna-Lok fasteners outlasted the nearest competitor nearly 20 to 1. Ours lasted 2 million cycles, while theirs lasted only 100,000. In addition, this strength extends to the solid-circle lock design. The expanding sleeve creates a tough, long-lasting joint with a tight, weather-resistant seal. This shield blocks out water and salt, further ensuring the fastener's long, reliable life.

Available Sizes:

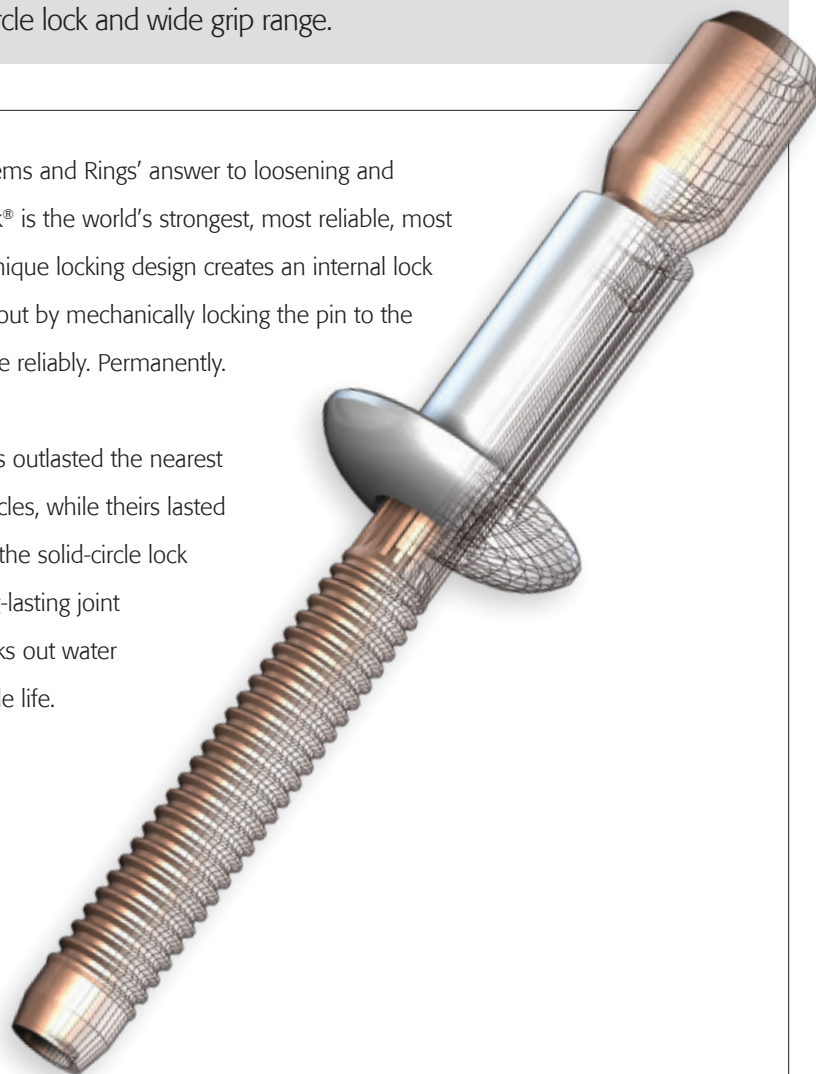
3/16", 1/4", 3/8", 1/2"

Materials:

Steel, Aluminum, Stainless Steel

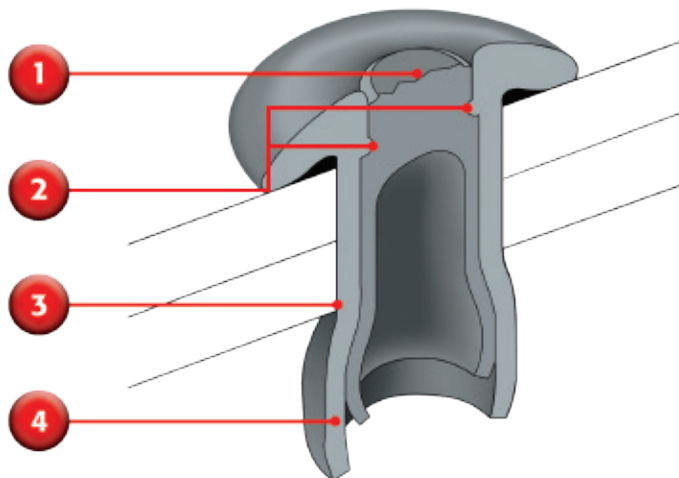
Headstyles:

Protruding, Truss, 100° Flush

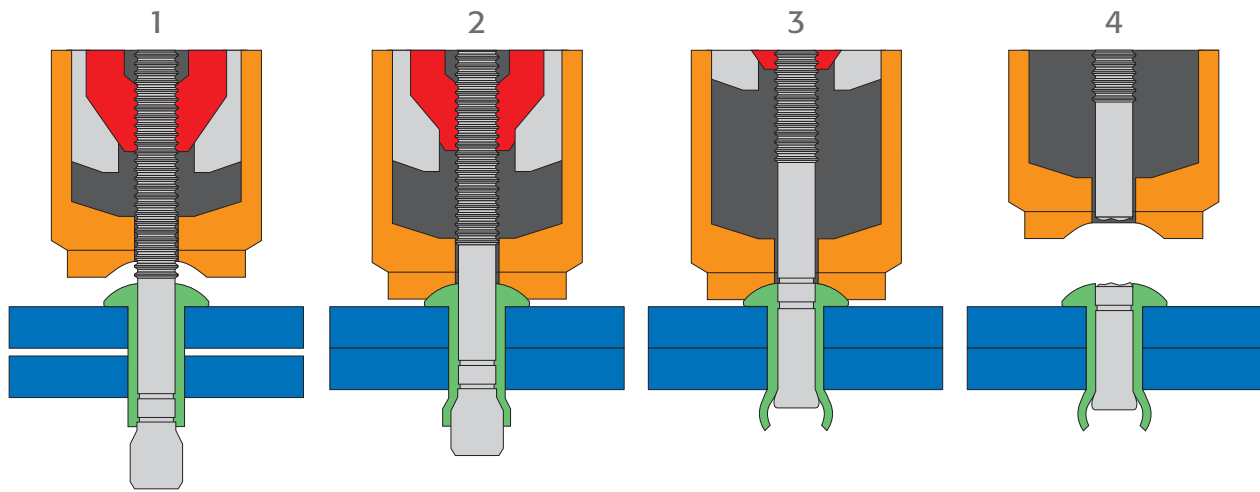


Secure, Fast Installation

1. Flush pin break eliminates grinding and filling, leaving an even surface.
2. Unique, solid-circle lock ensures maximum strength and vibration resistance. The potential for pin push-out is virtually eliminated.
3. Excellent gap pull-out and high retained clamp.
4. Sleeve expands during installation to fill the hole and create a moisture-resistant joint.



Installation Sequence



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

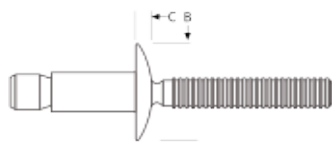
2
Press the trigger to initiate pulling action. As the tool pulls on the pintail, the pin (mandrel) expands the sleeve and begins drawing the work pieces together.

3
Continued pulling on the pintail draws the hollow pin head inside sleeve. The pin expands inside the sleeve and the work pieces, to completely fill the hole of the work pieces.

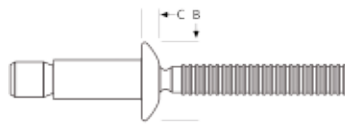
4
A solid circle lock between the pin and sleeve is formed just prior to the pin breaking flush with the sleeve head, completing the installation.



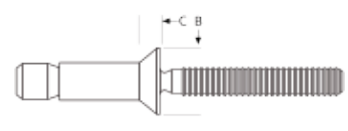
Magna-Lok Data & Dimensions



Truss Head



Protruding Head



100° Flush Head

Steel Rivet/Steel Mandrel

Diameter	Part No.	Grip Range	Max Hole Size	[B] Head Dia (max)	[C] Head Height (max)	Typical Shear (lbs)	Typical Tensile (lbs)
Protruding Head							
3/16"	MGLP-R6-4	.062-.270	.201	.392	.101	1450	1200
	MGLP-R6-7	.214-.437	.201	.392	.101	1450	1200
	MGLP-R6-10	.455-.665	.201	.392	.101	1450	1200
	MGLP-R6-E	.062-.437	.201	.392	.101	1450	1200
1/4"	MGLP-R8-6	.080-.375	.272	.530	.120	2750	2200
	MGLP-R8-7	.080-.437	.272	.530	.120	2750	2200
	MGLP-R8-10	.350-.625	.272	.530	.120	2750	2200
	MGLP-R8-14	.580-.875	.272	.530	.120	2750	2200
	MGLP-R8-22	1.080-1.375	.272	.530	.120	2570	2200
	MGLP-R8-E	.080-.625	.272	.530	.120	2750	2200
	MGLP-R8-E12.6*	.245-.790	.272	.530	.120	2750	2200
3/8"	MGLP-R12-12	.120-.625	.408	.793	.175	6300	5000
1/2"	MGLP-R16-12	.160-.750	.563	1.060	.240	11200	9400
Truss Head							
3/16"	MGLT-R6-4	.062-.270	.201	.530	.104	1450	1200
	MGLT-R6-E	.062-.437	.201	.530	.104	1450	1200
1/4"	MGLT-R8-6	.080-.375	.272	.592	.120	2750	2200
100° Flush Head							
3/16"	MGL100-R6-6	.125-.331	.201	.350	.080	1450	1200
	MGL100-R6-9	.305-.500	.201	.350	.080	1450	1200
1/4"	MGL100-R8-8	.160-.475	.272	.410	.090	2750	2200
	MGL100-R8-12	.415-.725	.272	.410	.090	2750	2200

* Also available in 400 Stainless Steel

Aluminum Rivet/Aluminum Mandrel

Diameter	Part No.	Grip Range	Max Hole Size	[B] Head Dia (max)	[C] Head Height (max)	Typical Shear (lbs)	Typical Tensile (lbs)
Protruding Head							
3/16"	MGLP-B6-4	.062-.270	.201	.392	.101	700	580
	MGLP-B6-7	.214-.437	.201	.392	.101	700	580
	MGLP-B6-E	.062-.437	.201	.392	.101	700	580
1/4"	MGLP-B8-6	.080-.375	.272	.530	.120	1300	950
	MGLP-B8-10	.350-.625	.272	.530	.120	1300	950
	MGLP-B8-E	.080-.625	.272	.530	.120	1300	950
3/8"	MGLP-B12-12	.120-.625	.408	.793	.175	3000	2100
1/2"	MGLP-B16-12	.160-.750	.563	1.060	.240	5400	4100
Truss Head							
3/16"	MGLT-B6-4	.062-.270	.201	.530	.104	700	580
	MGLT-B6-7	.214-.437	.201	.530	.104	700	580
	MGLT-B6-E	.062-.437	.201	.530	.104	700	580
100° Flush Head							
3/16"	MGL100-B6-6	.125-.331	.201	.350	.080	700	580
	MGL100-B6-9	.305-.500	.201	.350	.080	700	580
	MGL100-B6-12	.080-.375	.201	.350	.080	700	580
	MGL100-B6-14	.080-.375	.201	.350	.080	700	580
1/4"	MGL100-B8-8	.160-.475	.272	.410	.090	1300	950
	MGL100-B8-12	.415-.725	.272	.410	.090	1300	950

NOTE: Part number listings reflect typical stock. Items not listed require a minimum order.

Stainless Sleeve/Stainless Mandrel

Diameter	Part No.	Grip Range	Max Hole Size	[B] Head Dia (max)	[C] Head Height (max)	Typical Shear (lbs)	Typical Tensile (lbs)
Protruding Head							
3/16"	MGLP-U6-4	.062-.270	.201	.392	.101	1400	1100
	MGLP-U6-7	.214-.437	.201	.392	.101	1400	1100
	MGLP-U6-E	.062-.437	.201	.392	.101	1400	1100
1/4"	MGLP-U8-6	.080-.375	.272	.530	.120	2500	1800
	MGLP-U8-7	.080-.375	.272	.530	.120	2500	1800
	MGLP-U8-10	.350-.625	.272	.530	.120	2500	1800
	MGLP-U8-E	.080-.625	.272	.530	.120	2500	1800
Flush Head							
3/16"	MGL100-U6-6	.125-.331	.201	.350	.080	1400	1100
	MGL100-U6-9	.305-.500	.201	.350	.080	1400	1100
1/4"	MGL100-U8-8	.160-.475	.272	.410	.090	2500	1800
	MGL100-U8-12	.415-.725	.272	.410	.090	2500	1800

NOTE: Part number listings reflect typical stock. Items not listed require a minimum order.



Installation Tooling

Diameter	Installation Tool	Nose Assembly		Type
3/16"	LH-224	99-3300	99-3303	Pneudraulic
	2480	99-3300	99-3303	Hydraulic
1/4"	LH-224	99-3301	99-3305	Pneudraulic
	2480	99-3301	99-3305	Hydraulic
3/8"	256	99-3318		Pneudraulic
	2581	99-3318		Hydraulic
1/2"	2620PT	99-3330		Hydraulic - Aluminium
	2620PT	99-3331		Hydraulic - Steel Only



Model
2480



Model
LH-224

Ordering Information - Magna-Lok

Follow the form below to construct a part number for ordering Huck Magna-Lok blind fasteners. Refer to the Grip Data chart for grip numbers.

Ordering Information

MGL (HEAD STYLE) - (MATERIAL) (DIAMETER) - (GRIP NUMBER)

Example: MGLP-R6-4 is a Protruding Head Magna-Lok, Steel, 3/16" Diameter.

Head Style	Prefix	Material	Code	Diameter	Code
Protruding Head	P	Steel	R	3/16"	6
Truss Head	T	Aluminum	B	1/4"	8
100° Flush Head	100	Stainless Steel	U	3/8"	12
		430 Stainless Steel	4U	1/2"	16

Materials and Finishes

Material	Sleeve	Pin	Sleeve Finish*	Pin Finish*	Code
Steel	Low Carbon Steel	Medium Carbon Steel	Zinc Plated Clear Chromate	Zinc Plated Clear Chromate	R
Aluminum	5000 Series	7000 Series	Clear Chromate	Clear Chromate	B
Stainless Steel	300 Series	300 Series	Passivated	Dry Lubricated	U
400 Series Stainless Steel	430 Series	300 Series	Passivated	Dry Lubricated	430U
400 Series Stainless Steel	430 Series	410 Series	Passivated	Dry Lubricated	4U

Contact Manufacturer for other available/possible finishes.

Magna-Bulb®

A unique bulbing fastener with high shear strength.

Huck Magna-Bulb® is a unique, clamp-type fastener offering high shear strength in specific applications. Its bulbing action during installation spreads the load over more surface area, supplying a stronger, longer-lasting connection, while offering superior blind side strength. This increased bearing area makes Magna-Bulb ideal for pull-out resistance in thin materials, and oversized or misaligned holes. Positive, mechanical pin-retention ensures structural integrity no matter what the application.

Available Sizes:

3/16", 1/4", 5/16"

Materials:

Steel

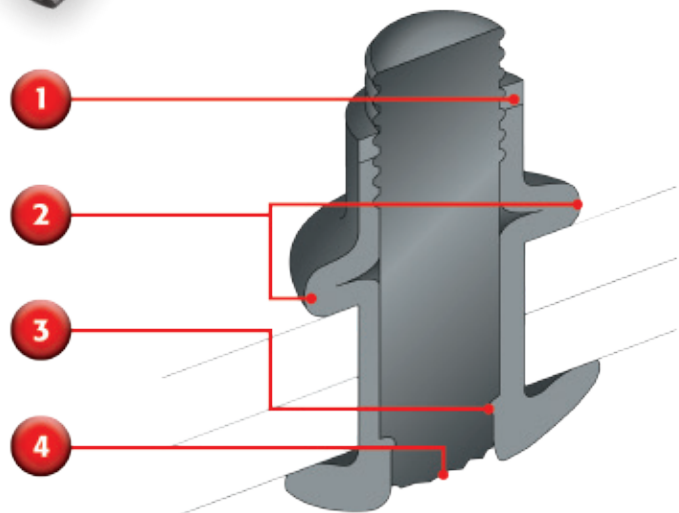
Headstyles:

Protruding, Truss, 100° Oval Flush

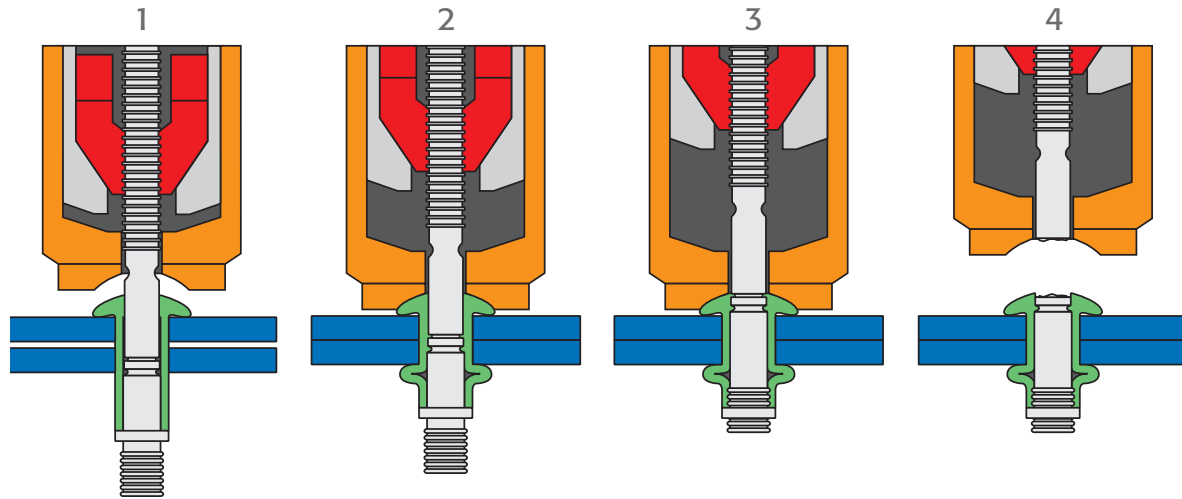


Secure, Fast Installation

1. Shear ring design promotes bulb formation and grip adjustment for flush break throughout the grip range.
2. The wide blind footprint (bulb) gives the fastener a broader bearing surface, spreading the load out for greater strength and high pull out resistance.
3. Unique solid circle lock ensures maximum strength and resistance to vibration.
4. Breaking flush throughout the entire grip range, the Magna-Bulb fastener eliminates costly cosmetic finish work and ensures "visually" that the fastener has been installed correctly.



Installation Sequence



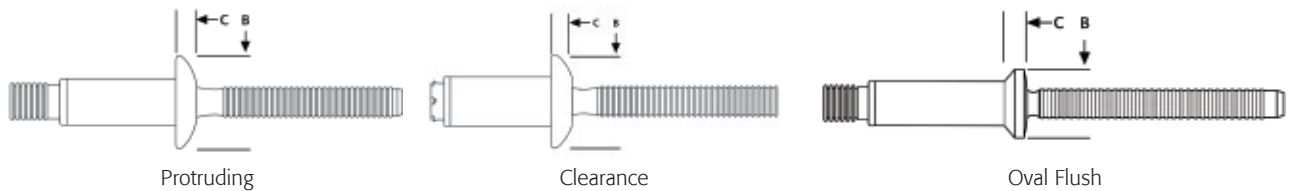
Insert the fastener into the hole and slip the installation tool over the pintail.

Press the trigger to initiate pulling action. As the tool pulls on the pintail, the pin (mandrel) expands the sleeve and begins drawing the work pieces together.

Continued pulling on the pintail expands the bulb to maximum allowable diameter. The shear ring then breaks and catches on the annular grooves as the pin continues to draw down inside the sleeve.

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.

Magna-Bulb Data & Dimensions



Steel Rivet/Steel Mandrel

Diameter	Part No.	Grip Range	Max Hole Size	[B] Head Dia (max)	[C] Head Height (max)	Typical Shear (lbs)	Typical Tensile (lbs)
Protruding Head							
3/16"	MBP-R6-M3	.087-.150	.201	.395	.101	1900	1050
	MBP-R6-M4	.126-.189	.201	.395	.101	1900	1050
	MBP-R6-M5	.165-.228	.201	.395	.101	1900	1050
	MBP-R6-M6	.205-.268	.201	.395	.101	1900	1050
	MBP-R6-M7	.244-.307	.201	.395	.101	1900	1050
	MBP-R6-M8	.283-.347	.201	.395	.101	1900	1050
	MBP-R6-M10	.362-.425	.201	.395	.101	1900	1050
1/4"	MBP-R8-M3	.110-.189	.272	.530	.125	2700	2000
	MBP-R8-M4	.150-.229	.272	.530	.125	2760	2000
	MBP-R8-M5	.189-.268	.272	.530	.125	3000	2000
	MBP-R8-M6	.229-.308	.272	.530	.125	3200	2000
	MBP-R8-M7	.268-.346	.272	.530	.125	3600	2000
	MBP-R8-M8	.308-.387	.272	.530	.125	3600	2000
	MBP-R8-M9	.346-.425	.272	.530	.125	3600	2000
	MBP-R8-M10	.387-.466	.272	.530	.125	3600	2000
	MBP-R8-M11	.425-.504	.272	.530	.125	3600	2000
	MBP-R8-M12	.466-.545	.272	.530	.125	3600	2000
	MBP-R8-M13	.504-.583	.272	.530	.125	3600	2000

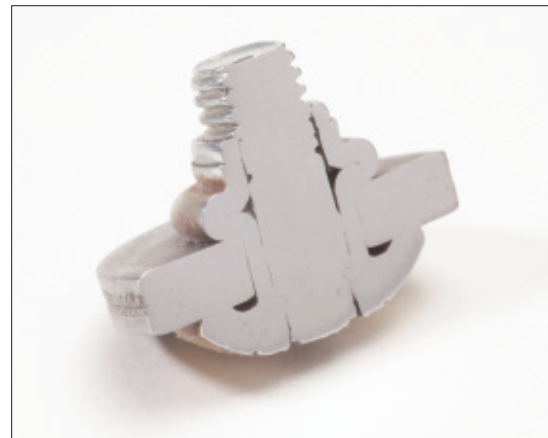
Steel Rivet/Steel Mandrel

Diameter	Part No.	Grip Range	Max Hole Size	[B] Head Dia (max)	[C] Head Height (max)	Typical Shear (lbs)	Typical Tensile (lbs)
Protruding Head							
5/16"	MBP-R10-3	.150-.250	.340	.655	.152	5000	3000
	MBP-R10-4	.200-.300	.340	.655	.152	5000	3000
	MBP-R10-5	.250-.350	.340	.655	.152	5000	3000
	MBP-R10-6	.300-.400	.340	.655	.152	5000	3000
	MBP-R10-7	.350-.450	.340	.655	.152	5000	3000
	MBP-R10-8	.400-.500	.340	.655	.152	5000	3000
	MBP-R10-10	.500-.600	.340	.655	.152	5000	3000
Clearance Version*							
1/4"	MBCP-R8-M3	.110-.189	.272	.525	.122	3000	3000
	MBCP-R8-M4	.189-.268	.272	.525	.122	3000	3000
	MBCP-R8-M5	.268-.346	.272	.525	.122	3000	3000
	MBCP-R8-M6	.229-.308	.272	.525	.122	3000	3000
	MBCP-R8-M7	.268-.346	.272	.525	.122	3000	3000
	MBCP-R8-M8	.308-.387	.272	.525	.122	3000	3000
	MBCP-R8-M9	.346-.425	.272	.525	.122	3000	3000
	MBCP-R8-M11	.425-.504	.272	.525	.122	3000	3000
	MBCP-R8-M13	.504-.583	.272	.525	.122	3000	3000
	MBCP-R8-M16	.622-.701	.272	.530	.125	3000	3000

* MBCP: Please refer to coordination drawings for specifications. NOTE: Part number listings reflect typical stock. Items not listed require a minimum order.

Installation Tooling

Diameter	Installation Tool	Nose Assembly		Type
3/16"	LH-224	99-3300	99-3303	Pneudraulic
	2480	99-3300	99-3303	Hydraulic
1/4"	LH-224	99-3301	99-3305	Pneudraulic
	2480	99-3301	99-3305	Hydraulic
5/16"	256	99-3307	-	Pneudraulic



Wide bulb provides broader bearing surface

Model
LH-224



Model
2480



Ordering Information

Follow the form below to construct a part number for ordering Huck Magna-Bulb blind fasteners. Refer to the data and dimensions chart for grip numbers.

Ordering Information

STANDARD VERSION

MB (HEAD STYLE) - (MATERIAL) (DIAMETER) - (GRIP NUMBER)

Example: MBP-R6-M4 is a Protruding Head Magna-Bulb, Steel, 3/16" Diameter, M4 Grip.

CLEARANCE VERSION

MBC (HEAD STYLE) - (MATERIAL) (DIAMETER) - (GRIP NUMBER)

Example: MBCP-R8-M3 is a Protruding Head Clearance Magna-Bulb, Steel, 1/4" Diameter, M3 Grip.

Head Style	Prefix	Material	Code	Diameter	Code
Protruding Head	P	Steel	R	3/16"	6
Oval Head	V			1/4"	8
				5/16"	10

Materials and Finishes

Material	Sleeve	Pin	Sleeve Finish	Pin Finish
Steel	Low Carbon Steel	Medium Carbon Steel	Zinc Plate/ Chromate/Gold Dye	Zinc Plated Clear Chromate

HuckLok®

Wide grip-range and double-locking action for a secure hold.

Featuring a wide grip range and unique double-locking action, the HuckLok® blind rivet combines high shear strength and high pull-up force. Its double-locking action consistently secures the assembly from both sides, resulting in maximum hold and joint integrity. Its large, blind-side footprint prevents pull-through, especially when joining thin or lightweight materials, such as plastics, composites, or any kind of pliable material. Positive mechanical pin retention ensures structural integrity, while annular grooves keep pressure on the back side.

Available Sizes:

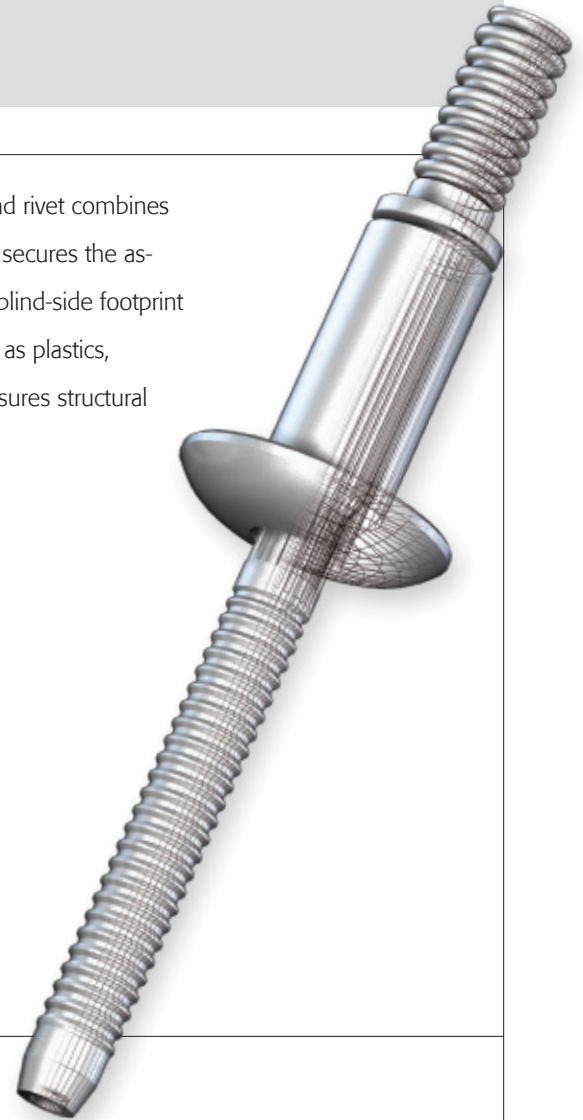
3/16", 1/4"

Materials:

Steel

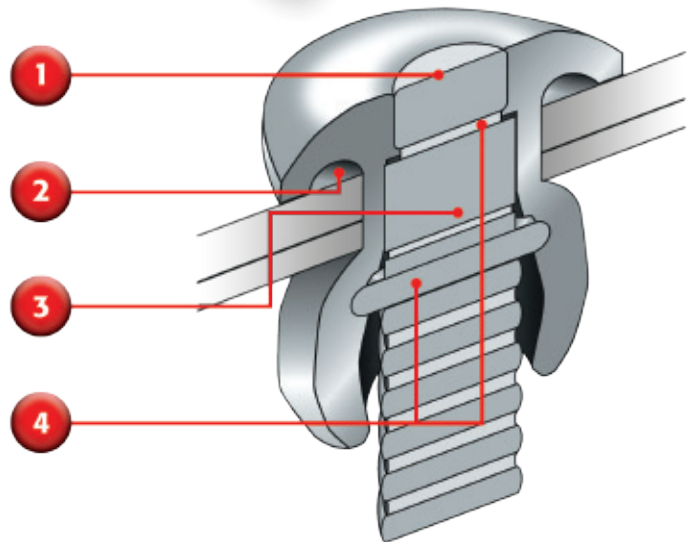
Headstyles:

Protruding, Truss, 100° Oval Flush

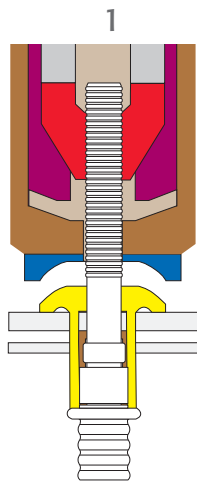


Secure, Fast Installation

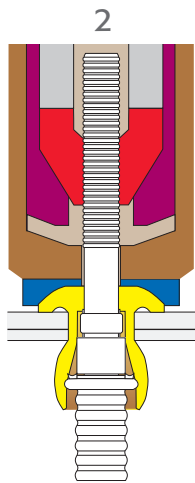
1. Breaking flush throughout its grip range, HuckLok allows at-a-glance verification of installation accuracy.
2. Undercut fillet allows seating in burred holes.
3. Solid pin provides exceptionally high strength in the shear plane.
4. Lock groove on pin engages shoulder on rivet head, while the extruded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



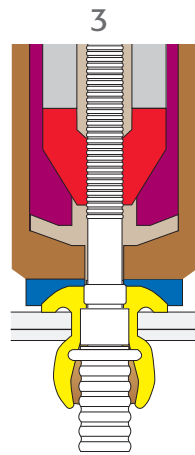
Installation Sequence



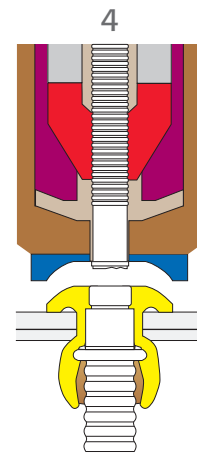
Insert the fastener into the hole and slip the installation tool over the pintail.



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.

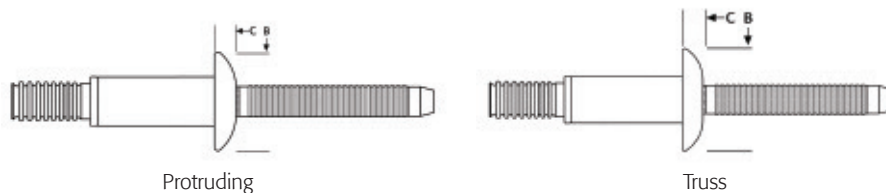


Continued pulling on the pintail expands the sleeve to maximum allowable diameter. As the shear ring reaches the backside of the work piece it breaks and catches on the tapered annular grooves, keeping high pressure on the blind side of the work pieces as the pin continues to draw down inside the sleeve.



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.

Huck-Lok Data & Dimensions



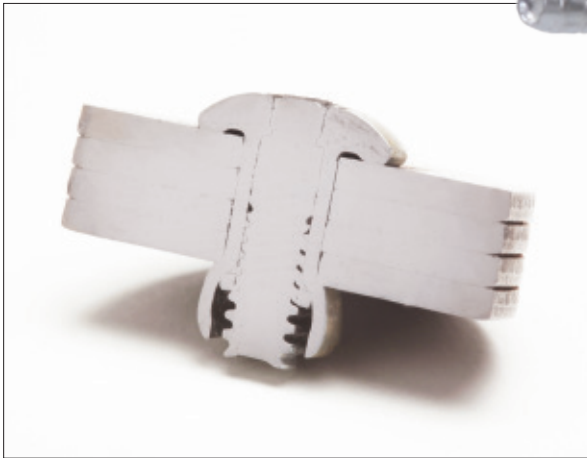
Steel Rivet - Steel Mandrel

Diameter	Part No.	Finish	Grip Range	Max Hole Size	[B] Head Dia (max)	[C] Head Height (max)	Typical Shear	Minimum Tensile
Protruding Head								
3/16"	HKLP-R6-5	zinc plate clear chromate	.062-.312	.201	.388	.101	1900	1000
	HKLP-R6-5U	zinc plate yellow chromate	.062-.312	.201	.388	.101	1900	1000
	HKLP-R6-5GAT	zinc plate clear chromate plus sealer	.062-.312	.201	.388	.101	1900	1000
1/4"	HKLP-R8-6	zinc plate clear chromate	.080-.375	.272	.530	.125	3500	1900
	HKLP-R8-6U	zinc plate yellow chromate	.080-.375	.272	.530	.125	3500	1900
	HKLP-R8-6S	PVC sealant	.080-.375	.272	.530	.125	3500	1900
	HKLP-R8-7	zinc plate clear chromate	.187-.437	.272	.530	.125	3500	1900
	HKLP-R8-7U	zinc plate yellow chromate	.187-.437	.272	.530	.125	3500	1900
	HKLP-R8-7BL	zinc plate black chromate	.187-.437	.272	.530	.125	3500	1900
	HKLP-R8-7A3	zinc plate clear chromate with glass seal	.187-.437	.272	.530	.125	3500	1900
	HKLP-R8-10	zinc plate clear chromate	.375-.625	.272	.530	.125	3500	1900
	HKLP-R8-10U	zinc plate yellow chromate	.375-.625	.272	.530	.125	3500	1900
	HKLP-R8-12	zinc plate clear chromate	.500-.750	.272	.530	.125	3500	1900
	HKLP-R8-14	zinc plate clear chromate	.625-.875	.272	.530	.125	3500	1900
	HKLP-R8-18	zinc plate clear chromate	.875-1.125	.272	.530	.125	3500	1900
Truss Head								
1/4"	HKLT-R8-6	zinc plate clear chromate	.080-.375	.272	.592	.125	3500	1900

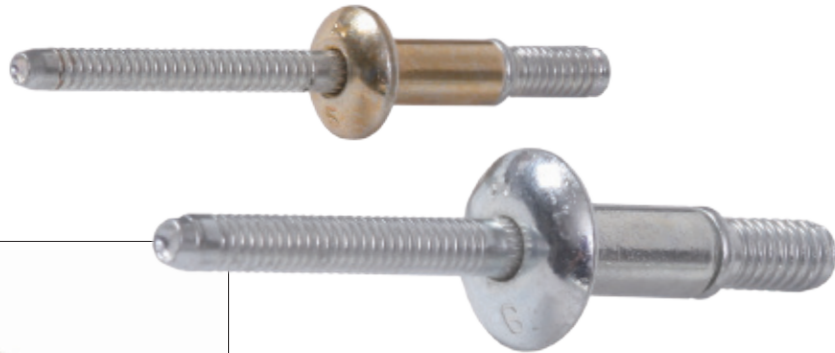
NOTE: Part number listings reflect typical stock. Items not listed require a minimum order.

Installation Tooling

Diameter	Installation Tool	Nose Assembly		Type
3/16"	LH-224	99-3300	99-3303	Pneudraulic
	2480	99-3300	99-3303	Hydraulic
1/4"	LH-224	99-3301	99-3305	Pneudraulic
	2480	99-3301	99-3305	Hydraulic



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



Model
2480



Model
LH-224

Auto-Bulb™

A high-strength bulbing fastener available in stainless steel.

For automated, high-speed assemblies, the Huck Auto-Bulb™ is the perfect solution. Unique to the structural blind rivet offering from Huck, Auto-Bulb is available in both steel and 400 stainless steel for ultimate corrosion-resistance.

Auto-Bulb is designed with an easy-to-use lead-in point, which means fast, reliable installation. It works by clamping the joint with a broad, blind side bulb, which makes it a good choice for use within thin materials, and within oversized, misaligned, or slotted holes. Auto-Bulb's positive mechanical pin retention ensures structural integrity, while its unique bulbing system creates superior blind side bearing strength.

Available Sizes:

3/16", 1/4"

Materials:

Steel, Stainless Steel

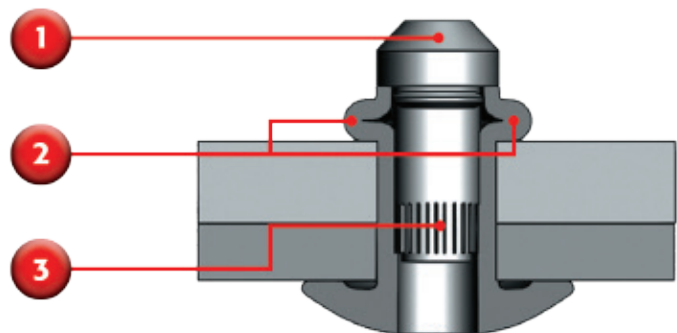
Headstyles:

Protruding, Flush

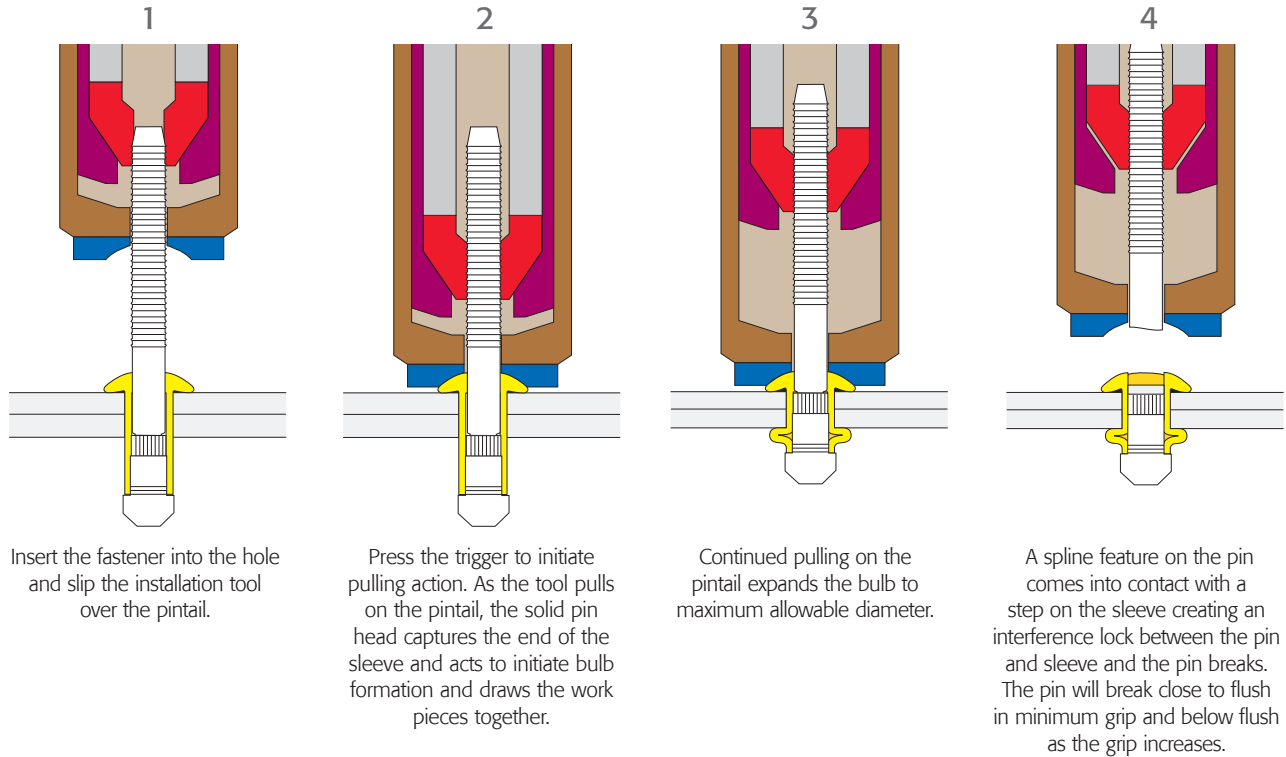


Secure, Fast Installation

1. Tapered hole seeking tip for quick and easy installation.
2. Unique band annealed bulbing system for superior blind side strength.
3. Positive mechanical pin retention ensures structural integrity.



Installation Sequence



Auto-Bulb Data & Dimensions



430 Stainless Steel

Diameter	Part No.	Grip Range	Max Hole Size	[B] Head Dia (max)	[C] Head Height (max)	Typical Shear (lbs)	Typical Tensile (lbs)
Protruding Head							
1/4"	ABP-4U8-M3	.110-.189	.272	.512	.130	2600	1600
	ABP-4U8-M4	.150-.299	.272	.512	.130	2600	1600
	ABP-4U8-M5	.189-.268	.272	.512	.130	2600	1600
	ABP-4U8-M6	.299-.308	.272	.512	.130	2600	1600
	ABP-4U8-M7	.268-.346	.272	.512	.130	2600	1600
	ABP-4U8-M8	.308-.387	.272	.512	.130	2600	1600
	ABP-4U8-M9	.346-.425	.272	.512	.130	2600	1600
	ABP-4U8-M10	.387-.466	.272	.512	.130	2600	1600
	ABP-4U8-M11	.425-.504	.272	.512	.130	2600	1600
	ABP-4U8-M13	.504-.583	.272	.512	.130	2600	1600

NOTE: Part number listings reflect typical stock. Items not listed require a minimum order.

Ordering Information

Follow the form below to construct a part number for ordering Huck Auto-Bulb blind fasteners. Refer to the Grip Data chart for grip numbers.

Ordering Information

AB (HEAD STYLE) - (MATERIAL) (DIAMETER) - (GRIP NUMBER)

Example: ABP-R8-M4 is a Protruding Head Auto-Bulb, Steel, 1/4" Diameter, M4 Grip.

Head Style	Code
Protruding	P
Countersunk Oval Head	V

Material	Code
Steel	R
400 Series Stainless Steel	4U

Diameter	Code
3/16"	6
1/4"	8
3/8"	12

Materials and Finishes

Material	Sleeve	Pin	Sleeve Finish	Pin Finish
Steel	Low Carbon Steel	Medium Carbon Steel	Zinc Plated Clear Chromate	Zinc Plated Clear Chromate
400 Series Stainless Steel	400 Series	400 Series	Passivated/Clear Sealer	Zinc Plated Clear Chromate/ Clear Sealer

Installation Tooling

Diameter	Installation Tool	Nose Assembly	Type
3/16"	LH-224	99-3300 99-3303	Pneudraulic
1/4"	LH-224	99-3301 99-3305	Pneudraulic



Bulb forms directly on the sheet line



Model
LH-224



Magna-Tite®

All-aluminum fastener ideal for thin or low-strength materials.

The Huck Magna-Tite® is a specialized aluminum structural rivet fastener well-suited for use within oversized holes and repair applications. Its wide, blind-side bulb makes it ideal for installation in thin or low-strength materials such as aluminum, fiberglass, and plastic. Unlike other bulbing blind fasteners, the Huck Magna-Tite has a unique embedded sealant applied between the pin and sleeve.

Available Sizes:

3/16", 1/4"

Materials:

Aluminum

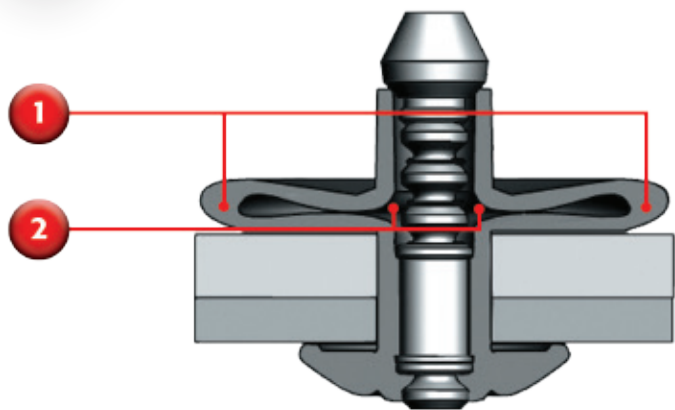
Headstyles:

Protruding, Shavable, Low Profile, 100° Oval Flush

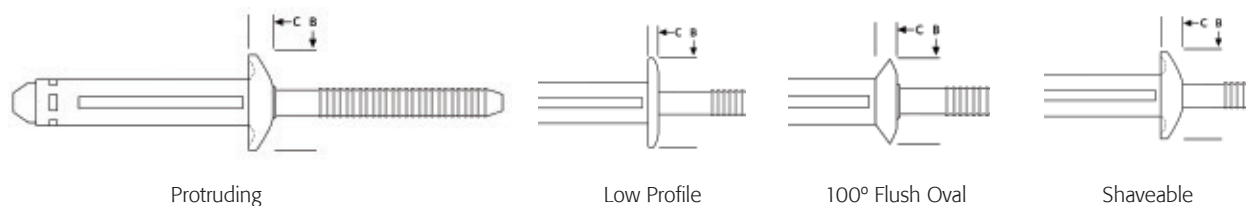


Secure, Fast Installation

1. Large blind-side footprint for installation in thin or compressible materials where controlled strength is required.
2. Unique embedded sealant applied between the pin and sleeve.



Magna-Tite Data & Dimensions



Aluminum Rivet/Aluminum Mandrel

Diameter	Part No.	Sealant	Grip Range	Max Hole Size	[B] Head Dia (max)	[C] Head Height (max)	Typical Shear (lbs)	Typical Tensile (lbs)
Protruding Head								
3/16"	MTP-B6-5S	PVC	.050-.312	.221	.453	.117	630	450
	MTP-B6-6		.100-.375	.221	.453	.117	630	450
	MTP-B6-6S	PVC	.100-.375	.221	.453	.117	630	450
	MTP-B6-8S	PVC	.250-.500	.221	.453	.117	630	450
	MTP-B6-10S	PVC	.375-.625	.221	.453	.117	630	450
	MTP-B6-12S	PVC	.500-.750	.221	.453	.117	630	450
1/4"	MTP-B8-4		.040-.250	.263	.530	.120	1100	650
	MTP-B8-4S	PVC	.040-.250	.263	.530	.120	1100	650
	MTP-B8-6		.125-.375	.263	.530	.120	1100	650
	MTP-B8-6S	PVC	.125-.375	.263	.530	.120	1100	650
	MTP-B8-8S	PVC	.250-.500	.263	.530	.120	1100	650
	MTP-B8-10S	PVC	.375-.625	.263	.530	.120	1100	650
	MTP-B8-12S	PVC	.500-.750	.263	.530	.120	1100	650
Oval Head								
3/16"	MTV-B6-5S	PVC	.070-.312	.221	.355	.117	630	450
	MTV-B6-7S	PVC	.160-.410	.221	.355	.117	630	450
	MTV-B6-8S	PVC	.250-.500	.221	.355	.117	630	450
	MTV-B6-10S	PVC	.375-.625	.221	.355	.117	630	450
	MTV-B6-12S	PVC	.500-.750	.221	.355	.117	630	450
Low Profile Head								
3/16"	MTLP-B6-4		.050-.250	.221	.453	.052	630*	450
	MTLP-B6-8		.187-.500	.221	.453	.052	630*	450
	MTLP-B6-12		.375-.750	.221	.453	.052	630*	450
	MTLP-B6-12X		.050-.750	.221	.453	.052	630*	450
Shaveable Head								
3/16"	MTS-B6-8		.050-.500	.221	.453	.117	630	450
	MTS-B6-8S	PVC	.050-.500	.221	.453	.117	630	450
	MTS-B6-12S	PVC	.050-.750	.221	.453	.117	630	450

* In Minimum Grip. 350 lb. shear strength over minimum grip. NOTE: Part number listings reflect typical stock. Items not listed require a minimum order.

Installation Tooling

Diameter	Installation Tool	Nose Assembly	Type
3/16"	LH-224	99-3310F/P 99-3311F/P	Pneudraulic
	2480	99-3310F/P 99-3311F/P	Hydraulic
1/4"	LH-224	99-3312F/P	Pneudraulic
	2480	99-3312F/P	Hydraulic

Note: For Nose Assembly selection, F is for Countersunk Flush Head and P is for Protruding Head



BOM®

The highest strength blind oversized fastener available.

Often used as a replacement for welding, Huck BOM® is so strong, one 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 military vehicles, auto suspensions, rail car assembly, and much more. BOM's high fatigue thread form extends the life of any structure. Offering accurate, easy, quick installation, BOM requires no special training or skills for operators.

Available Sizes:

3/16", 1/4", 5/16", 3/8", 1/2", 5/8", 3/4"

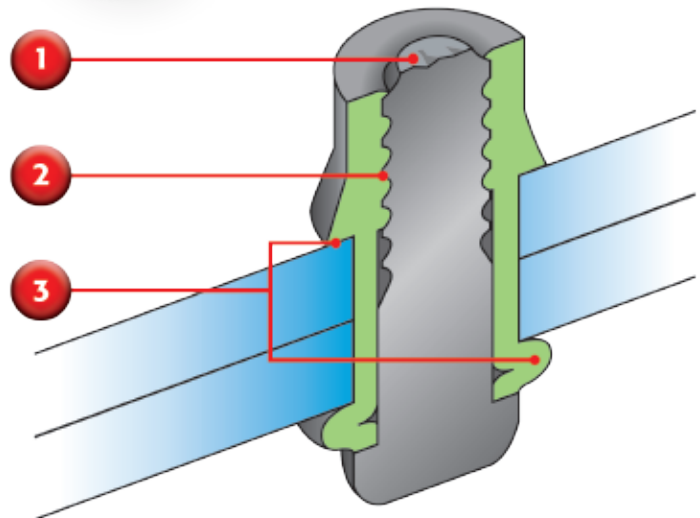
Materials:

Steel

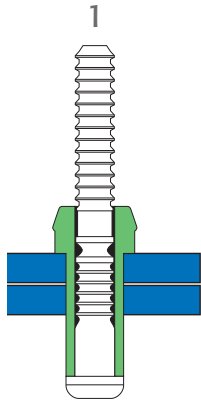


Secure, Fast Installation

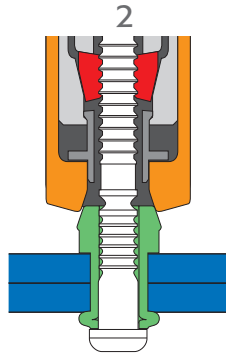
1. When the pin separates near flush, the BOM fastener is installed correctly. The BOM fastener does not require surface preparation, grinding or filling after installation.
2. The collar is locked to the pin through the "swaging" process, creating a high vibration resistant connection and the highest strength of any blind fastener.
3. Large bearing area on both sides of the work piece ensures a permanently held, tamper resistant joint.



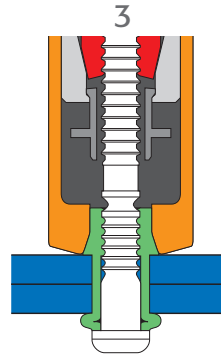
Installation Sequence



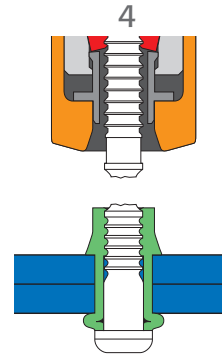
Insert the fastener into the hole and slip the installation tool over the pintail.



Press the trigger to initiate pulling action. As the tool pulls on the pintail, the unique collar design "stands off" the swaging action until the maximum allowable bulb is formed on the backside.

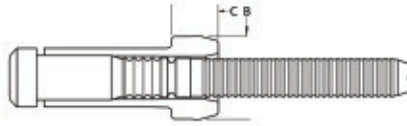


Continued pulling on the pintail draws the work pieces together and the swaging anvil overcomes the standoff and moves down the length of the collar, securely locking the collar to the pin.



Once the collar is swaged, the pin breaks leaving a high strength, vibration resistant secured joint.

BOM Data & Dimensions



Steel Pin - Zinc Plated

Diameter	Part No.	Grip Range	Max Hole Size	[B] Head Dia (max)	[C] Head Height (max)	Typical Shear (lbs)	Typical Tensile (lbs)
1/4"	BOM-R8-3	.157-.219	.292	.225	.020	5100	3250
	BOM-R8-4	.220-.281	.292	.225	.020	5100	3250
	BOM-R8-5	.282-.344	.292	.225	.020	5100	3250
	BOM-R8-6	.345-.406	.292	.225	.020	5100	3250
	BOM-R8-7	.407-.469	.292	.225	.020	5100	3250
	BOM-R8-8	.470-.531	.292	.225	.020	5100	3250
	BOM-R8-9	.532-.594	.292	.225	.020	5100	3250
	BOM-R8-10	.595-.656	.292	.225	.020	5100	3250
	BOM-R8-11	.657-.719	.292	.225	.020	5100	3250
5/16"	BOM-R8-12	.720-.781	.292	.225	.020	5100	3250
	BOM-R10-4	.188-.312	.368	.278	.025	8050	5200
	BOM-R10-6	.313-.437	.368	.278	.025	8050	5200
	BOM-R10-8	.438-.562	.368	.278	.025	8050	5200
	BOM-R10-10	.563-.687	.368	.278	.025	8050	5200
	BOM-R10-12	.688-.812	.368	.278	.025	8050	5200
3/8"	BOM-R10-14	.813-.937	.368	.278	.025	8050	5200
	BOM-R12-4	.188-.312	.435	.327	.030	11100	7250
	BOM-R12-6	.313-.437	.435	.327	.030	11100	7250
	BOM-R12-8	.438-.562	.435	.327	.030	11100	7250
	BOM-R12-10	.563-.687	.435	.327	.030	11100	7250
	BOM-R12-12	.688-.812	.435	.327	.030	11100	7250
1/2"	BOM-R12-14	.813-.937	.435	.327	.030	11100	7250
	BOM-R16-10	.626-.750	.581	.458	.035	20150	13000
5/8"	BOM-R16-12	.751-.875	.581	.458	.035	20150	13000
	BOM-R20-4GA	.251-.500	.728	.545	.040	28500	20500
	BOM-R20-8GA	.501-.750	.728	.545	.040	28500	20500
	BOM-R20-12GA	.751-1.000	.728	.545	.040	28500	20500
	BOM-R20-16GA	1.001-1.250	.728	.545	.040	28500	20500
3/4"	BOM-R20-20GA	1.251-1.500	.728	.545	.040	28500	20500
	BOM-R24-4GAG	.251-.500	.873	.654	.050	45100	29100
	BOM-R24-8GAG	.501-.750	.873	1.130	.050	45100	29100
	BOM-R24-12GAG	.751-1.000	.873	1.130	.050	45100	29100
	BOM-R24-16GAG	1.001-1.250	.873	1.130	.050	45100	29100

NOTE: Part number listings reflect typical stock. Items not listed require a minimum order.

Grip Data									
	Grip No.	Grip Range	M Nom	N Max		Grip No.	Grip Range	M Nom	N Max
6 (3/16")	2	.093 -.156	.376	.500	12 (3/8")	4	.188 -.312	.766	.975
	3	.157 -.219	.439	.562		6	.313 -.437	.891	1.100
	4	.220 -.281	.501	.625		8	.438 -.562	1.016	1.225
	5	.282 -.344	.564	.687		10	.563 -.687	1.141	1.350
	6	.345 -.406	.626	.750		12	.688 -.812	1.266	1.475
	7	.407 -.469	.689	.812		14	.813 -.937	1.391	1.600
	8	.470 -.531	.751	.875		16	.938 - 1.062	1.516	1.725
	9	.532 -.594	.814	.937		18	1.063 - 1.187	1.641	1.850
	10	.595 -.656	.876	1.000		20	1.188 - 1.312	1.766	1.975
	11	.657 -.719	.939	1.062					
	12	.720 -.781	1.001	1.125					
	8 (1/4")	2	.093 -.156	.460		.625	16 (1/2")	4	.251 -.375
3		.157 -.219	.523	.688	6	.376 -.500		1.125	1.391
4		.220 -.281	.585	.750	8	.501 -.625		1.250	1.516
5		.282 -.344	.648	.813	10	.626 -.750		1.375	1.641
6		.345 -.406	.710	.875	12	.751 -.875		1.500	1.766
7		.407 -.469	.773	.938	14	.876 -1.000		1.625	1.891
8		.470 -.531	.835	1.000	16	1.001 -1.125		1.750	2.016
9		.532 -.594	.898	1.063	18	1.126 -1.250		1.875	2.141
10		.595 -.656	.960	1.125	20	1.251 -1.375		2.000	2.266
11		.657 -.719	1.023	1.188	22	1.376 -1.500		2.125	2.391
12		.720 -.781	1.085	1.250	24	1.501 -1.625		2.250	2.516
13		.782 -.843	1.147	1.313					
14		.844 -.905	1.209	1.375					
10 (5/16")		4	.188 -.312	.695	.875	20 (5/8")	4	.251 -.500	1.213
	5	.250 -.375	.758	.938	8		.501 -.750	1.463	1.781
	6	.313 -.437	.820	1.000	12		.751 -1.000	1.713	2.031
	8	.438 -.562	.945	1.125	16		1.001 -1.250	1.963	2.281
	10	.563 -.687	1.070	1.250	20		1.251 -1.500	2.213	2.531
	12	.688 -.812	1.195	1.375	24 (3/4")	4	.251 -.500	1.380	1.750
	14	.813 -.937	1.320	1.500		8	.501 -.750	1.630	2.000
	16	.938 -1.062	1.445	1.625		12	.751 -1.000	1.880	2.250
					16	1.001 -1.250	2.130	2.500	
Installed Values in Nominal Grip (lbs.)									
Diameter	Shear		Tensile		Note: These are minimum ultimate shear and tensile strengths, in pounds, of installed fastener, when tested in a grip equal to or greater than one and one half the fastener diameter.				
3/16"	2800		1800						
1/4"	5100		3250						
5/16"	8050		5200						
3/8"	11100		7250						
1/2"	20150		13000						
5/8"	28500		20500						
3/4"	45100		29100						

Ordering Information

Follow the form below to construct a part number for ordering Huck BOM blind fasteners.
Refer to the Grip Data chart for grip numbers.

Ordering Information

BOM-R (DIAMETER) - (GRIP NUMBER)

Example: BOM-R8-6 is a BOM blind rivet,
Steel, 1/4" Diameter, Grip 6.

Material	Code
Steel	R

Diameter	Code
3/16"	6
1/4"	8
5/16"	10
3/8"	12
1/2"	16
5/8"	20
3/4"	24

Materials and Finishes

Material	Sleeve	Pin	Sleeve Finish	Pin Finish
Steel	Low Carbon Steel	Medium Carbon Steel	Zinc Plated Clear Chromate	None (Std)

Additional coatings are available upon request.

Installation Tooling

Diameter	Installation Tool	Nose Assembly	Type
3/16"	LH-224	99-994	Pneudraulic
	255	99-1053 (heavy duty)	Pneudraulic
	256	99-1053 (heavy duty)	Pneudraulic
	2480	99-994	Hydraulic
	2581	99-1053 (heavy duty)	Hydraulic
1/4"	255	99-830-1	Pneudraulic
	256	99-830-1	Pneudraulic
	2581	99-830-1	Hydraulic
5/16"	256	99-769	Pneudraulic
	2581	99-769	Hydraulic
	2600	99-3119	Hydraulic
3/8"	256	99-1272	Pneudraulic
	2581	99-1272	Hydraulic
1/2"	2620	99-5100	Hydraulic
	2620PT	99-5101	Hydraulic
5/8"	2624	99-5102	Hydraulic
	3585	99-5102	Hydraulic
3/4"	3585	99-5103	Hydraulic



FloorTight®

The only controlled, self-countersinking blind fastener commercially available.

Originally designed for large vehicle flooring installations, Huck FloorTight® is ideal for all wood-to-metal applications, especially plywood and plymetal. FloorTight's self-countersinking head eliminates the secondary counterboring process in plywood, and eliminates dimpling in metals. Unlike screws that can be over-torqued or under-torqued, FloorTight ensures consistent, reliable installation every time.

Available Sizes:

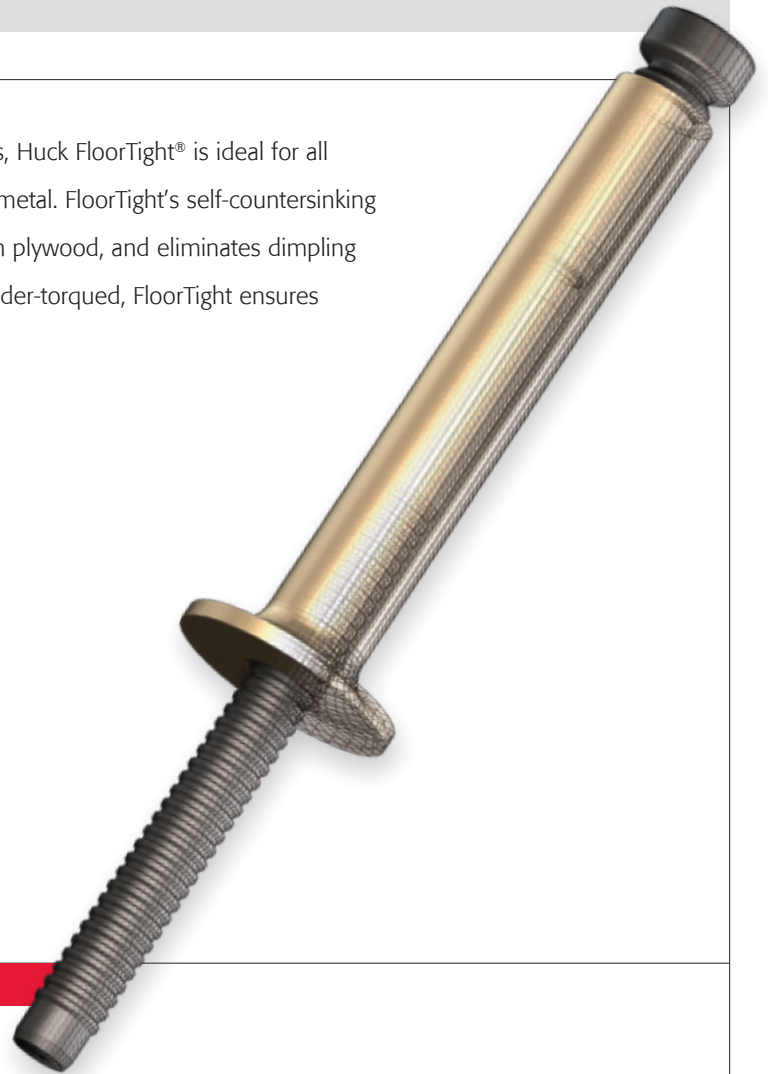
1/4", 5/16"

Materials:

Steel

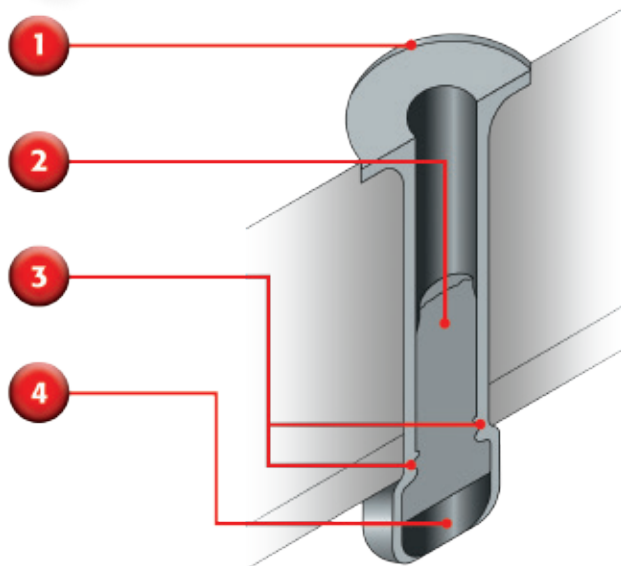
Headstyles:

Standard, Wide Flange, Plymetal, 90° Flush

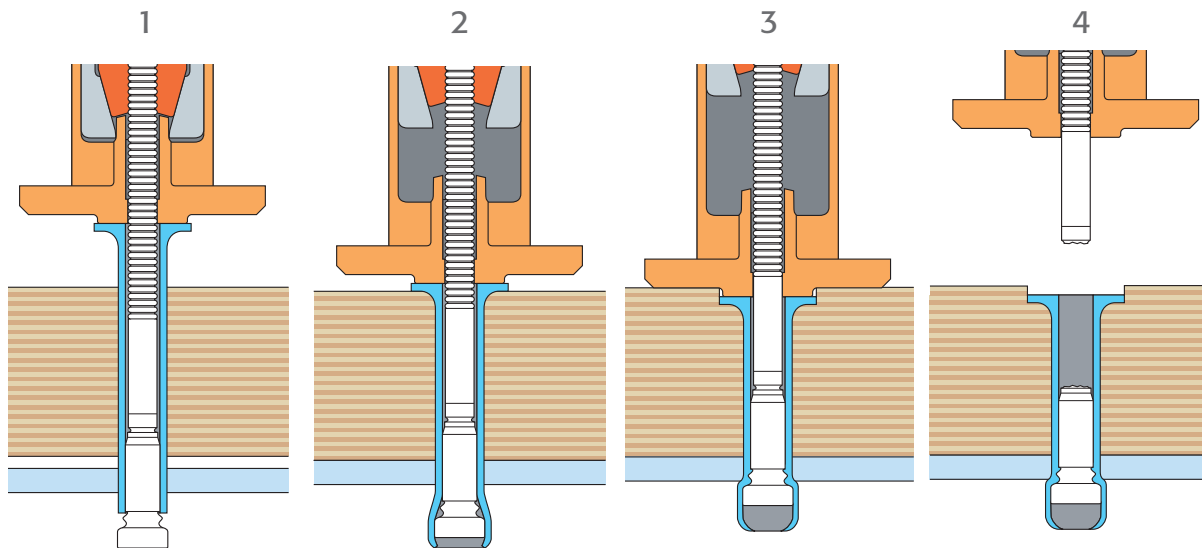


Secure, Fast Installation

1. Self-countersinking head eliminates the counter-boring process in plywood, as well as dimpling in plymetal floors.
2. A high-strength pin locks in place within the shear plane for added holding power and durability.
3. 360° internal locking feature creates a solid mechanical lock to prevent loosening.
4. Expansion within the weather-side stringer, coupled with the 360° internal lock provides excellent moisture resistance on the weather side.



Installation Sequence



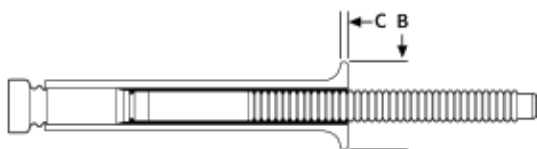
Insert fastener in hole.
Apply installation tool.

The Huck installation tool is placed over the pintail. When the trigger is pressed, the nose assembly jaws pull on the pintail, drawing the pin through the sleeve, causing the blind side sleeve to expand, partially setting the sleeve in the top sheet and pulling out all the sheet gap.

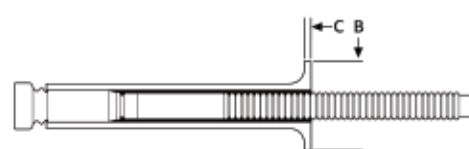
Continued pulling on the pintail forms a mechanical lock between the pin and sleeve end. The anvil on the installation tool then countersinks the fastener head into the top of the material to a preset depth set by the anvil. The anvil's large bearing face then prevents further travel of the sleeve head into the top material.

The pin is then separated in tension at the break neck groove.

FloorTight Data & Dimensions



Plywood



Plymetal

Steel Sleeves - Steel Mandrel

Diameter	Part No.	Grip Range	Max Hole Size	[B] Head Dia (max)	[C] Head Height (max)	Typical Shear (lbs)	Typical Tensile (lbs)
Plywood Floor							
5/16"	PWF-R10-20	.750-1.375	.339	.325	.650	4300	3000
	PWFMC-R10-20A3	.750-1.375	.339	.675	.050	4300	3000
Plymetal Floor							
5/16"	PMF-R10-20	.750-1.375	.339	.325	.590	4300	3000
	PMFMC-R10-20	.750-1.375	.339	.325	.590	4300	3000

Installation Tooling

Diameter	Installation Tool	Nose Assembly	Type
1/4"	256	99-3441	Pneudraulic
	2581	99-3441	Hydraulic
5/16"	255	99-3452-AUS	Pneudraulic
	256	99-3452-AUS	Pneudraulic
	2581	99-3452-AUS	Hydraulic



NOTE: Part number listings reflect typical stock. Items not listed require a minimum order.

Huck Tools

The industry's best installation tooling.



Model 507

Designed to offer the highest levels of ergonomics, productivity, and long life, the Huck line of installation tooling reflects the same level of innovation and quality as its advanced fasteners. Whether it's a Huck hydraulic tool employed in high-volume installation of large diameter HuckBolts, or a smaller pneumatic model used to install blind rivets and small diameter HuckBolts, you can count on these tools to deliver the industry's best value.

A Wide Selection of Tooling Options

Huck offers a broad selection of hydraulic and pneumatic tools, in addition to Powerig® hydraulic power sources. Huck hydraulic installation tools are available to install a wide range of fasteners, from structural blind rivets to the largest HuckBolts. The Huck line of pneumatic tools, designed for use in repair work or in lower volume production applications, can effectively pull fasteners ranging from 3/32" blind rivets to 3/8" HuckBolts.



SF20
Swageforward®



LH-224



256BT



SFBTT8-12

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 2581 to easily fit in limited clearance applications.



2620

2620 tool (shown with Nose assembly) is a light weight hydraulic tool specifically designed to provide the installation force for 1/2" Huck fasteners of all types.



3585

Offering durable construction, advanced hydraulics, and safe, ergonomic design, the 3585 installation tool is easy to hold and efficient to use. An improved piston and cylinder design promote longer life. In addition, the nose adapter can be removed through the back of the tool for ease of repair. Stroke: 1.900"; Weight: 19 lbs.



2630

is a heavy duty Hydraulic tool designed specifically for 7/8" Dia Huck Fasteners



507

The 507 tool is a high production tool that will install 1" and 1-1/8" Huck Fasteners when fitted with the correct nose assembly

Huck Hydraulic Tooling



5304, 6304, 7304, 8304 and 9304

This family of tools are designed as limited access tools.

Pistons and Swaging areas are offset to the centreline of the tool allowing the tool to access tighter corners, additionally the nose assembly is built into the body of the tool making it shorter and reducing the envelope necessary to allow the tool to operate.

NOTE these tools are designed to supplement normal production tooling only in situations where the standard tooling is inappropriate.



SFBTT8-12

Huck's proprietary, advanced swage forward tooling for BobTail fasteners, the SFBTT series makes the installation process quicker and easier by reducing the force required to install each fastener. More compact and lighter weight than previous Huck lockbolt production tooling, BobTail installation tools also offer greater operator flexibility as well as extended reach into difficult areas. For tight, space-constrained applications, swageforward BobTail tools allow the operator to position his or her hand at a safe distance from the working structure during installation.



SF20

Huck's proprietary, advanced swage forward tooling for BobTail fasteners, the SF series makes the installation process quicker and easier by reducing the force required to install each fastener. More compact and lighter weight than previous Huck lockbolt production tooling, BobTail installation tools also offer greater operator flexibility as well as extended reach into difficult areas. For tight, space-constrained applications, swageforward BobTail tools allow the operator to position his or her hand at a safe distance from the working structure during installation.



SF46

More compact and lighter weight than previous Huck lockbolt production tooling, Huck's proprietary SF series Swageforward™ tooling for BobTail fasteners offers greater operator flexibility as well as extended reach into difficult areas. By reducing the force required to install each fastener, the SF series tooling makes the installation process much faster and easier. For tight, space-constrained applications, Swageforward BobTail tools allow the operator to position his or her hand at a safe distance from the working structure during installation.

NOTE: For additional tool details, refer to the specific fastener brochure or visit AFSRhuck.net.

Huck Pneudraulic Tooling



244BT

The 244BT Tool is designed for rapid installation of Huck BobTail 4.8mm and 6.4mm diameters. This lightweight tool provides for fast, uniform installations, and delivers optimum stroke for one-cycle installation of fasteners. Minimal moving parts.



256BT

Designed for quick installation of Huck BobTail fasteners, the 256BT 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.



LH-224

This lightweight ergonomically designed tool is intended for fast efficient installation of all Huck fasteners up to and including 1/4" Diameter, when coupled with the correct Nose assembly.



245 & 246

The 245 (up to 5/16"Dia) and 246 (up to 3/8"Dia) are designed to provide consistent power and reliability, required to install fasteners larger than 1/4"Diameter, when coupled with the correct Nose assembly.



256

The 256 (up to 3/8"Dia) has a slightly larger centre to edge distance than the 246. This has the benefit of using a concentric piston to provide more direct force to install the fastener. All nose assemblies are fully interchangeable with the 246 and 2581 tools.

NOTE: For additional tool details, refer to the specific fastener brochure or visit AFSRhuck.net.

Huck Powerig® Power Sources

Combining advanced design and quality manufacturing, Huck Powerigs offer both best-in-class performance and long product life. Whether for mobile or factory use, there is a Huck Powerig hydraulic power source for the job, from electric and gasoline powered portable units to larger rigs that can individually power up to three tools.



940-220AUS

The Model 940 Powerig® is a portable unit sized for moderate production and repair applications. This unit features rugged construction for durability in the field, and the choice of 115 or 220 Volt AC power. The Model 940 includes a handle for easy transport, simple adjustable hydraulic outputs and quick-connect couplers for connecting installation tool hoses.

SPECIFICATIONS

Width: 409mm
Length: 354mm
Height: 470mm
Weight: 74.5 lbs. operational,
30kg. w/o hydraulic fluid
Power: electric, 115 or 220 volts,
single phase

Flow Rate: 70 cu. in./min. @
5,000 psi
Reservoir Capacity: 1.5 gallons
Options: 220V, 60/50 hertz single
phase, 250VDC, direct current



940AB

The 940AB is an "AIR" powered unit for use in areas where mains supply would be unsafe. It has similar performance characteristics as the 940-220AUS, but its motive force is pneumatic. Air pressure of 70 – 100 PSI and a flow rate of 6CFM is required to power this unit. The control circuit incorporates a 12DC battery allowing standard Huck Hydraulic tools and switches to be used without

modification. Long battery life between charges is achieved through the use of isolation relays ensuring batteries are only in use during installation cycles.

913H

913H is a Petrol Powered Hydraulic Powerig for use in areas where there is no provision for electrical or Pneumatic supply. Pull start and 12DC control circuit without battery ensures the 913H is totally self contained and can operate standard Huck tools without modification.



918 & 918-5

The Model 918 Powerig® is the largest hydraulic unit offered by Huck. Sized for high production applications, the unit can operate up to three tools independently. This electrically powered model also delivers sufficient power to operate the tools up to 100 feet away. A 22-gallon reservoir stores hydraulic fluid, with a filter-strainer in the suction line to assure clean, filtered fluid.



NOTES:

NOTES:

This image shows a single sheet of white paper with horizontal ruling lines. The lines are evenly spaced and run across the width of the page. There are no margins, text, or other markings on the paper.

Alcoa Fastening Systems & Rings



For more than 120 years, the name Alcoa has been recognized worldwide as a strong leader in product quality and customer support. These strengths are found in every product manufactured for Alcoa Fastening Systems & Rings, offering the greatest breadth and depth of fastening system solutions in the industry.

Alcoa Fastening Systems & Rings (AFSR) maintains company offices in the United States and in many other countries. AFSR fastener distributors are also located in many of the world's industrial centers, where they provide a ready source of AFSR fasteners, installation tools, tool parts, and application assistance.

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