



# HuckLok<sup>®</sup>

Double-Locking,  
Wide-Grip Fasteners



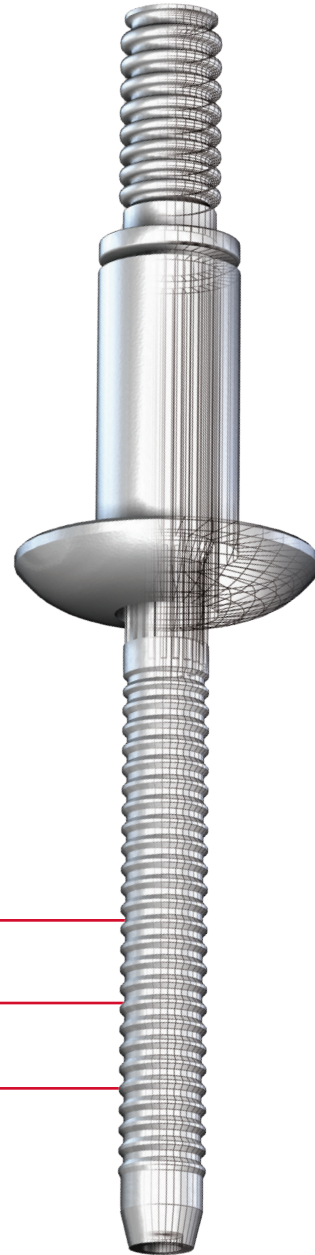
# HuckLok®

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

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

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

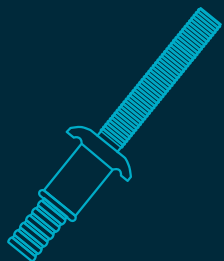
These structural blind rivets add efficiency to the production line by quickly installing in just seconds. A quick visual check that the core pin is flush on the head of the sleeve is proof of successful installation.



**Available Sizes** 3/16", 1/4"

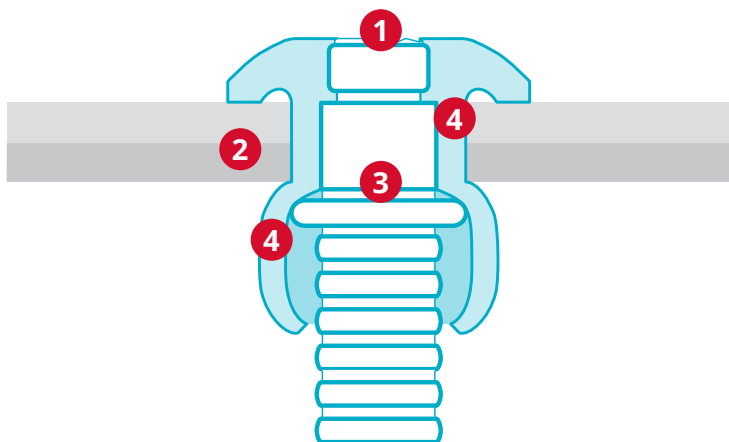
**Materials** Steel

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

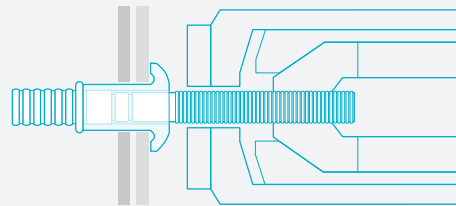


- ✓ Unique bulbing system for superior blind side strength
- ✓ Wide grip-range and unique double-locking action
- ✓ Positive mechanical pin retention ensures structural integrity
- ✓ Large, blind-side footprint prevents pull-through
- ✓ Annular grooves keep pressure on the back side

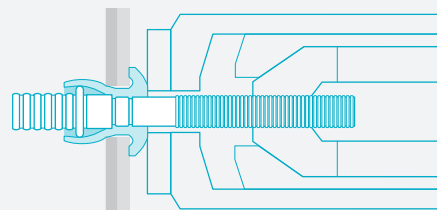
## Secure, Fast Installation



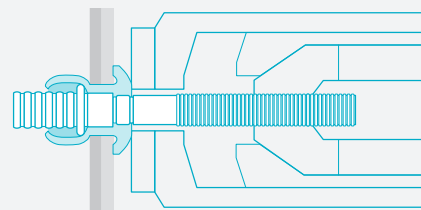
- 1 Breaking flush throughout its grip range, HuckLock allows at-a-glance verification of installation accuracy.
- 2 Undercut fillet allows seating in burred holes.
- 3 Solid pin provides exceptionally high strength in the shear plane.
- 4 Lock groove on pin engages shoulder on rivet head, while the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



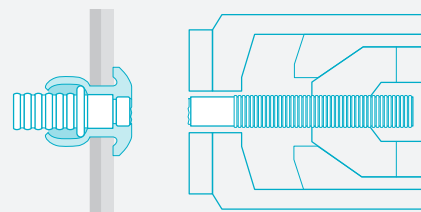
- 1 Insert the fastener into the hole and slip the installation tool over the pintail.



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

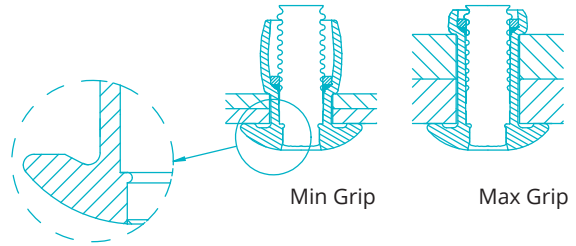
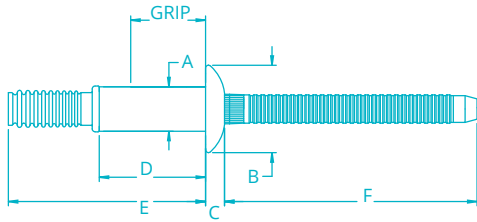


- 3 Continued pulling on the pintail expands the sleeve to maximum allowable diameter. As the shear ring reaches the backside of the work piece it breaks and catches on the tapered annular grooves, keeping high pressure on the blind side of the work pieces as the pin continues to draw down inside the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



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

# Data and Dimensions

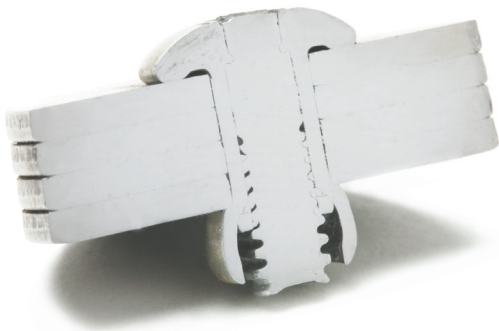


## HuckLok Dimensions

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

## Installed Values - Ibf (Minimum)

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



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

# Ordering Information

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

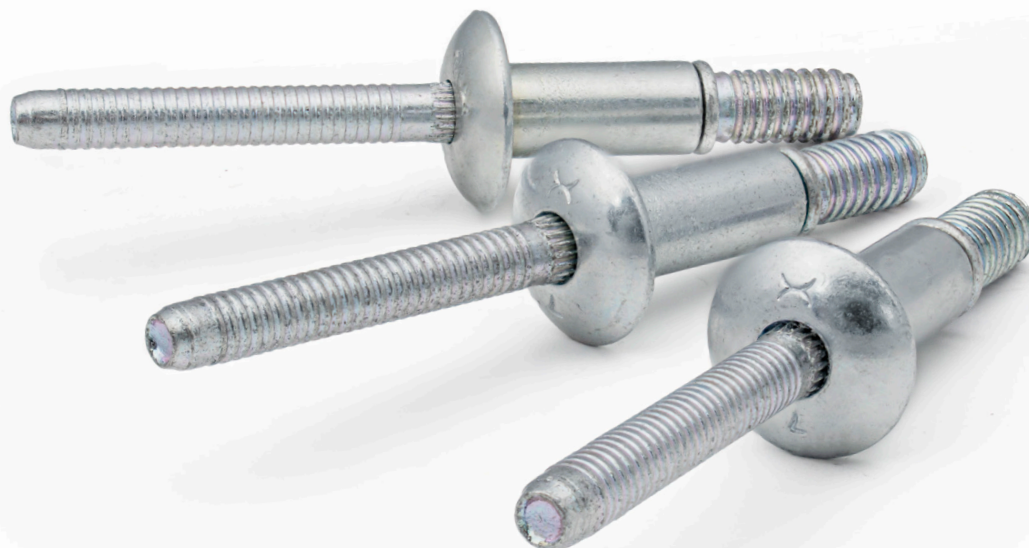
HKL(HEAD STYLE) - (MATERIAL) (DIAMETER) — (GRIP NUMBER)

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

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

## Materials and Finishes

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



# Installation Tooling

## Tooling Weight and Dimensions

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

## Nose Assembly

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

\* Recommended \*\* Not recommended for high volume production



## Huck Pneudraulic Tooling



### 256

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



### 2024

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

## Huck Hydraulic Tooling



### 2480

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



### 2581

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

## Huck Battery Tooling



### BV4500-118

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



**HOWMET  
AEROSPACE**

# Howmet Fastening Systems

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