



Product Bulletin

SPINDLE LOADS AND HYDRAULIC PRESSURES AT SHIFT FOR HUCK MODEL 200 INSTALLATION TOOL

When used to install double action fasteners, the shift valve of the Model 200 H.I.T. must be adjusted to insure the proper installation of various fasteners. Two methods of checking the shift valve setting are available:

Method #1: Shift Setting Kit No. 107569 employs a Skidmore-Wilhelm Tension Tester to check the spindle load at shift, in pounds.

Method #2: Shift setting No. 101300 employs a hydraulic pressure gauge to check the hydraulic pressure at shift, in pounds per square inch (psi).

The chart below shows the "Spindle Load at Shift" and "Hydraulic Pressure at Shift" for various fasteners. It may be necessary to retrofit some older tools prior to serial number 5161 (except 5081 thru 5090 and 5120 thru 5135), using Shift Valve and Balance Valve Retrofit Kit No. 110434, to insure repeatability of the shift valve settings.

FASTENERS		POUNDS		PSI (2)
		SPINDLE LOAD AT SHIFT USING SETTING KIT #107569		HYDRAULIC PRESSURE AT SHIFT USING SETTING KIT #101300
AFS 40911-460 AFS 40911-461	CKLX4	325 (1)		425 (1)
	CKLX5	500	±25	650
	CKLX6	725	±25	950
	OCKL-4	450 (1)		575 (1)
	OCKL-5	575	±25	750
	OCKL-6	775	±25	1000
NAS1919 & 1921				
B04	MLS-B04	350 (1)		450 (1)
B05	MLS-B05	500	±25	650
B06	MLS-B06	725	±25	950
B08	MLS-B08	1275	±25	1650
C04	MLS-EU04	875	±25	1125
C05	MLS-EU05	1175	±25	1525
C06	MLS-EU06	1875	±25	2450
M04	MLS-M04	775	±25	1000
M05	MLS-M05	1125	±25	1475
M06	MLS-M06	1775	±25	2325
MS21140	B-EU5	1260	±35	1650
MS21141	B-EU6	1845	±65	2400
MS90353	B-T5	1425	±25	1850
MS90354	B-T6	2200	±50	2875
---	OB-T5	1425	±25	1850
---	OB-T6	2200	±50	2875

(1) Set as close as possible to pounds or psi shown.

(2) Plus or minus 50 psi, unless otherwise specified.

*This revised Bulletin obsoletes and supersedes Bulletin 141 dated 7-15-75

*REVISED

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