

HUCK

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Product Bulletin

Model 2702 and A2702 Piston, P/N 115372, With Marks to Align Staking Holes

The new Model 2702 piston has aligning marks on deflector end of piston to align cylinder staking holes with piston staking holes.

Note:

When replacing pistons that have the marks for staking hole alignment, order piston assembly P/N 115418.

When upgrading tools with the old style pistons (those without the staking hole aligning marks), order Retrofit Kit P/N 115419.

To attach new nose assembly:

1. Cycle tool by holding tool trigger depressed for 30 seconds. Disconnect control cord or control tubing, also disconnect **RETURN** hose. **Tool piston must be completely forward.**
2. Remove old nose assembly.
3. Observe position of piston staking holes in relation to marks on piston extension—marks are in line with staking holes, see Figure 1. Insert hex key in piston extension and rotate piston to align piston staking holes with cylinder staking holes.
4. While holding piston in position with hex key, screw collet and lock collar onto tool spindle—tighten collet.
5. After tightening collet check alignment of piston marks and cylinder staking holes. Realign with hex key if necessary.
6. Connect tool to power source. Connect control cord or control tubing and return hose.

To stake lock collar:

Nose assembly lock collar must be staked to tool spindle as shown in Figure 2. Collet assembly is locked to maintain adjustment for proper function of nose assembly and tool, and to prevent damage to nose assembly or tool. For the staking operation use Staking Tool, P/N 84212, which must be purchased separately.

1. Pull anvil part-way out to provide clearance for staking tool, and to support collet assembly and spindle.
2. Place staking tool through cylinder staking hole and against lock collar.
3. Hit staking tool a light blow with hammer to stake lock collar to spindle. Reinstall anvil.

Collet assemblies with staked lock collars can be removed with a wrench. Lock collars are generally reusable a few times.

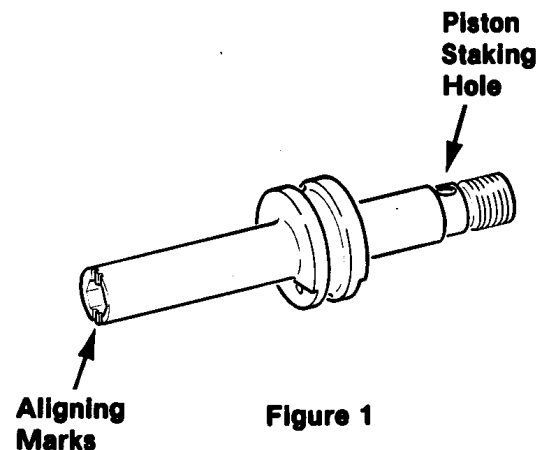


Figure 1

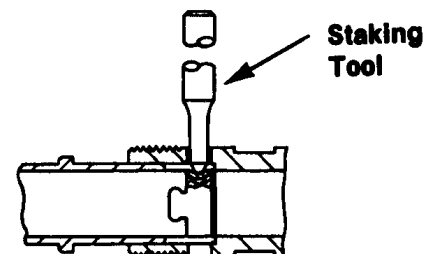


Figure 2

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