

Fastening Technology / Installation Tools

## Tools

for Lockbolt Systems





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## Overview - tools for lockbolts

Tool	Article No.	Technology	Standard lockbolt ø [mm]				DeltaBolt® lockbolt ø [mm]				Multigrip lockbolt ø [mm]				Hucktainer® Plus ø [mm]
			4.8	6.4	8.0	9.6	4.8	6.4	8.0	9.6	4.8	6.4	7.8	9.5	9.5
TIOS® EL18	352 300 001	Battery	•	•			•	•			•	•			•
RL 75N	385 060 300	hydropneum.	•	•			•	•			•	•			•
Huck 2025LB	370 120 000	hydropneum.	•	•			•	•			•	•			•
Huck 254	375 200 000	hydropneum.	•	•	•	• (Al)	•	•	•	•	•	•	•	• (Al)	•
Huck 256	375 490 000	hydropneum.	•	•	•	•	•	•	•	•	•	•	•	•	•
Huck 2481	370 445 000	hydraulic	•	•			•	•			•	•			•
Huck 2581	371 180 000	hydraulic	•	•	•	•	•	•	•	•	•	•	•	•	•
Huck 2583	370 830 000	hydraulic	•	•	•	•	•	•	•	•	•	•	•	•	

## Overview - tools for high-strength lockbolts

Tool	Article No.	Technology	HuckBolt® C50L® lockbolt ø [mm]				
			12.7	16.0	19.1	22.2	25.4
Huck 2620-PT	370 550 000	hydraulic	•				
Huck 3585	370 322 000	hydraulic		•	•		
Huck 2630	373 190 000	hydraulic				•	
Huck 507	373 240 000	hydraulic					•

## Overview - tools for high-strength blind rivets\*

Tool	Article No.	Technology	TIBULB blind rivet ø [mm]			M-LOCK blind rivet ø [mm]			MAGNA-BULB® blind rivet ø [mm]			BOM® blind rivet ø [mm]			
			4.8	6.4	7.8	4.8	6.4	9.5	4.8	6.4	7.8	4.8	6.4	7.8	9.5
TIOS® EL18	352 300 001	battery	•	•		•	•		•	•					
RL 75N	385 060 300	hydropneum.	•	•	• (St)	•	•		•	•		•			
Huck 2025LB	370 120 000	hydropneum.	•	•		•	•		•	•					
Huck 254	375 200 000	hydropneum.			•			•			•	•	•		
Huck 256	375 490 000	hydropneum.						•			•	•	•		
Huck 2481	370 445 000	hydraulic	•	•		•	•		•	•		•	•		
Huck 2581	371 180 000	hydraulic						•			•	•	•	•	•
Huck 2583	370 830 000	hydraulic						•			•	•	•	•	•

\* The matching pulling heads can be found on the corresponding page in our tools catalogue.

• = All materials can be installed. Should restrictions apply, please consult the table for the correct installation material.

## TIOS® EL18

Battery-operated rivet installation tool for installing lockbolts and high-strength blind rivets

### Benefits at a glance

- Intelligent battery management
- Powerful 18V lithium-ion rechargeable battery
- Brushless DC motor (BLDC)
- Low running and tooling costs compared to pneumatic and hydraulic tools
- Rapid change system for pulling unit

### Technical specifications

Stroke: 25.0 mm  
Insertion force: 18.0 kN  
Motor: 18.0 Volt brushless DC motor  
Weight: 2.3 kg with battery (2.5 Ah)

### Scope of delivery

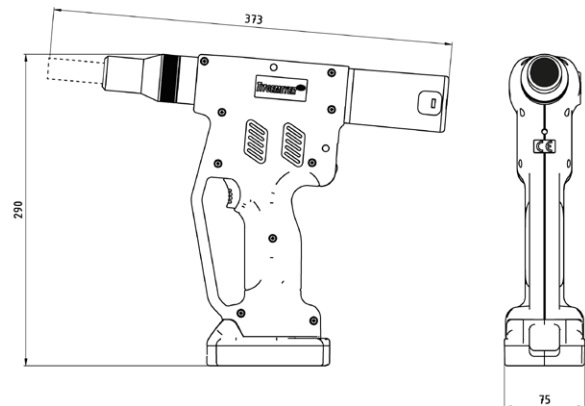
TIOS EL18 battery-operated rivet installation tool  
TIOS LI02830 18.0 V single charger  
TIOS LI01825 18.0 V / 2.5 Ah insertable battery  
Storage case  
Operating instructions  
Article No. 352 300 001

### Note

Pulling heads sold separately  
See table for product selection

### Optional extras

TIOS-CONTROL process control (load-displacement monitoring)  
Radio module (WIFI)  
Barcode reader (for program settings and parts recognition)



## Working range - lockbolts

Fastener	Standard lockbolt ø [mm]				DeltaBolt® lockbolt ø [mm]				Multigrip lockbolt ø [mm]				Hucktainer® Plus ø [mm]
	4.8	6.4	8.0	9.6	4.8	6.4	8.0	9.6	4.8	6.4	7.8	9.6	9.5
Aluminium	•	•							•	•			
Steel	•	•			•	•			•	•			•
Stainless steel	•	•							•	•			

## Working range - high-strength blind rivets

Fastener	TIBULB blind rivet ø [mm]			M-LOCK blind rivet ø [mm]			MAGNA-BULB® blind rivet ø [mm]			BOM® blind rivet ø [mm]			
	4.8	6.4	7.8	4.8	6.4	9.5	4.8	6.4	7.8	4.8	6.4	7.8	9.5
Aluminium	•	•		•	•								
Steel	•	•		•	•		•	•					
Stainless steel	•	•		•	•								

## Pulling heads for TIOS® EL18

Fastener	Nominal bolt ø [mm]	Pulling head type	Article No.
Standard lockbolts	4.8	HUCK® 99-3003	371 680 000
	6.4	HUCK® 99-3006	371 705 000
	8.0		
	9.6		
DeltaBolt® lockbolts	4.8	HUCK® 99-3003	371 680 000
	6.4	HUCK® 99-3006	371 705 000
	8.0		
	9.6		
Multigrip lockbolts	4.8	HUCK® 99-1456	372 985 000
	6.4	HUCK® 99-1477UK	371 980 000
	7.8		
	9.6		
Hucktainer® Plus TIBULB blind rivets	9.5	HUCK® 99-3465	371 730 000
	4.8	HUCK® 99-3303	371 805 000
	6.4	HUCK® 99-3305	371 815 000
	7.8		
M-LOCK blind rivets	4.8	HUCK® 99-3303	371 805 000
	6.4	HUCK® 99-3305	371 815 000
	9.5		
MAGNA-BULB® blind rivets	4.8	HUCK® 99-3303	371 805 000
	6.4	HUCK® 99-3305	371 815 000
	7.8		
BOM® blind rivets	4.8	HUCK® 99-994	372 780 000
	6.4		
	7.8		
	9.5		

For technical specifications on pulling heads, see table on pages 24/25.

## Batteries and chargers

Description	Article No.
TIOS LI01825 insertable battery, 2.5 Ah	352 200 905
TIOS LI01850 insertable battery, 5.0 Ah	352 200 904
TIOS LI02830 single charger	352 200 910
TIOS LI02830-4 multi-charger, 4 charging points	352 200 911
TIOS LI02830-8 multi-charger, 8 charging points	352 200 912

## RL 75N

Hydropneumatic rivet installation tool for installing lockbolts and high-strength blind rivets

### Benefits at a glance

- High performance
- New valve control for faster installation speeds
- Quick-release mandrel container
- Low-noise
- Easy to use; requires little maintenance
- Air supply fittable on left or right
- Fixing point for balancer
- Safety valve prevents operating pressure overload
- Reliable and tried-and-tested

### Technical specifications

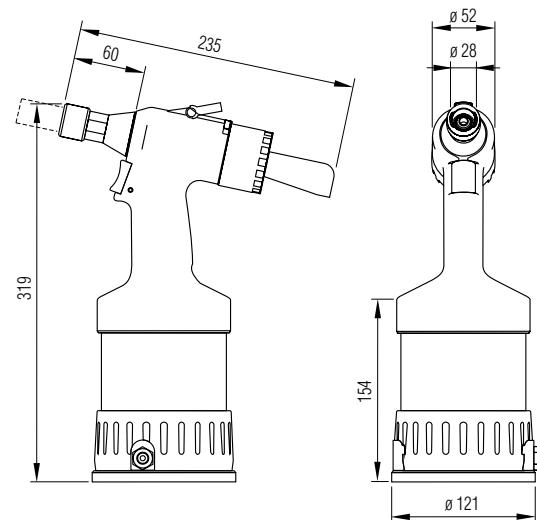
Stroke:	15.0 mm
Insertion force:	22 kN at 6 bar
Installation force/Weight ratio:	10 kN/kg
Air consumption:	2.8 l/rivet
Connection pressure:	5 - 7 bar
Air supply:	ø 6 mm (G1/4")
Weight:	2.2 kg

### Scope of delivery

RL 75N rivet installation tool  
 Oil refill set  
 Angled air supply  
 Mandrel collector  
 Operating instructions  
**Article No. 385 060 300**

### Note

Pulling heads sold separately  
 See table for product selection





## Working range - lockbolts

Fastener	Standard lockbolt ø [mm]				DeltaBolt® lockbolt ø [mm]				Multigrip lockbolt ø [mm]				Hucktainer® Plus ø [mm]
	4.8	6.4	8.0	9.6	4.8	6.4	8.0	9.6	4.8	6.4	7.8	9.6	9.5
Aluminium	•	•							•	•			
Steel	•	•			•	•			•	•			•
Stainless steel	•	•							•	•			

## Working range - high-strength blind rivets

Fastener	TIBULB blind rivet ø [mm]			M-LOCK blind rivet ø [mm]			MAGNA-BULB® blind rivet ø [mm]			BOM® blind rivet ø [mm]			
	4.8	6.4	7.8	4.8	6.4	9.5	4.8	6.4	7.8	4.8	6.4	7.8	9.5
Aluminium	•	•		•	•								
Steel	•	•	•	•	•		•	•		•			
Stainless steel	•	•		•	•								

## Pulling heads for RL 75N

Fastener	Nominal bolt ø [mm]	Pulling head type	Article No.
Standard lockbolts	4.8	HUCK® 99-3003	371 680 000
	6.4	HUCK® 99-3006	371 705 000
	8.0		
	9.6		
DeltaBolt® lockbolts	4.8	HUCK® 99-3003	371 680 000
	6.4	HUCK® 99-3006	371 705 000
	8.0		
	9.6		
Multigrip lockbolts	4.8	HUCK® 99-1456	372 985 000
	6.4	HUCK® 99-1477UK	371 980 000
	7.8		
	9.6		
Hucktainer® Plus TIBULB blind rivets	9.5	HUCK® 99-3465	371 730 000
	4.8	HUCK® 99-3303	371 805 000
	6.4	HUCK® 99-3305	371 815 000
	7.8	20-0353	385 150 000
M-LOCK blind rivets	4.8	HUCK® 99-3303	371 805 000
	6.4	HUCK® 99-3305	371 815 000
	9.5		
MAGNA-BULB® blind rivets	4.8	HUCK® 99-3303	371 805 000
	6.4	HUCK® 99-3305	371 815 000
	7.8		
BOM® blind rivets	4.8	HUCK® 99-994	372 780 000
	6.4		
	7.8		
	9.5		

For technical specifications on pulling heads, see table on pages 24/25.

## Optional accessories

Description	Article No.
Reinforced mandrel container	385 717 870
Inductive ring sensor	431 784 000
Hydraulic oil 1 l	460 299 870

## HUCK® 2025LB

Hydropneumatic rivet installation tool for installing lockbolts and high-strength blind rivets

### Benefits at a glance

- Ergonomic handle
- Chrome-plated piston rod
- In-line plunger
- Low-weight

### Technical specifications

Stroke:	17.0 mm
Insertion force:	23.5 kN at 6 bar
Length:	213 mm (without pulling head)
Height:	319 mm
Weight:	2.6 kg

### Scope of delivery

HUCK® 2025LB rivet installation tool  
Oil fill accessory kit  
Operating instructions  
Article No. 370 120 000

### Note

Pulling heads sold separately  
See table for product selection



## Working range - lockbolts

Fastener	Standard lockbolt ø [mm]				DeltaBolt® lockbolt ø [mm]				Multigrip lockbolt ø [mm]				Hucktainer® Plus ø [mm]
	4.8	6.4	8.0	9.6	4.8	6.4	8.0	9.6	4.8	6.4	7.8	9.6	9.5
Aluminium	•	•							•	•			
Steel	•	•			•	•			•	•			•
Stainless steel	•	•							•	•			

## Working range - high-strength blind rivets

Fastener	TIBULB blind rivet ø [mm]			M-LOCK blind rivet ø [mm]			MAGNA-BULB® blind rivet ø [mm]			BOM® blind rivet ø [mm]			
	4.8	6.4	7.8	4.8	6.4	9.5	4.8	6.4	7.8	4.8	6.4	7.8	9.5
Aluminium	•	•		•	•								
Steel	•	•		•	•		•	•					
Stainless steel	•	•		•	•								

## Pulling heads for HUCK® 2025LB

Fastener	Nominal bolt ø [mm]	Pulling head type	Article No.
Standard lockbolts	4.8	HUCK® 99-30031	371 680 000
	6.4	HUCK® 99-30061	371 705 000
	8.0		
	9.6		
DeltaBolt® lockbolts	4.8	HUCK® 99-30031	371 680 000
	6.4	HUCK® 99-30061	371 705 000
	8.0		
	9.6		
Multigrip lockbolts	4.8	HUCK® 99-14561	372 985 000
	6.4	HUCK® 99-1477UK	371 980 000
	7.8		
	9.6		
Hucktainer® Plus TIBULB blind rivets	9.5	HUCK® 99-3464L	on request
	4.8	HUCK® 99-33031	371 805 000
	6.4	HUCK® 99-33051	371 815 000
	7.8		
M-LOCK blind rivets	4.8	HUCK® 99-33031	371 805 000
	6.4	HUCK® 99-33051	371 815 000
	9.5		
MAGNA-BULB® blind rivets	4.8	HUCK® 99-33031	371 805 000
	6.4	HUCK® 99-33051	371 815 000
	7.8		
BOM® blind rivets	4.8		
	6.4		
	7.8		
	9.5		

For technical specifications on pulling heads, see table on pages 24/25.

## HUCK® 254

Hydropneumatic rivet installation tool for installing lockbolts and high-strength blind rivets

### Benefits at a glance

- Ergonomic two-finger trigger
- One-piece reinforced piston
- Low-throttle safeguard for added protection from dirt entering the throttle valve
- High insertion force at less than 4.0 kg weight

### Technical specifications

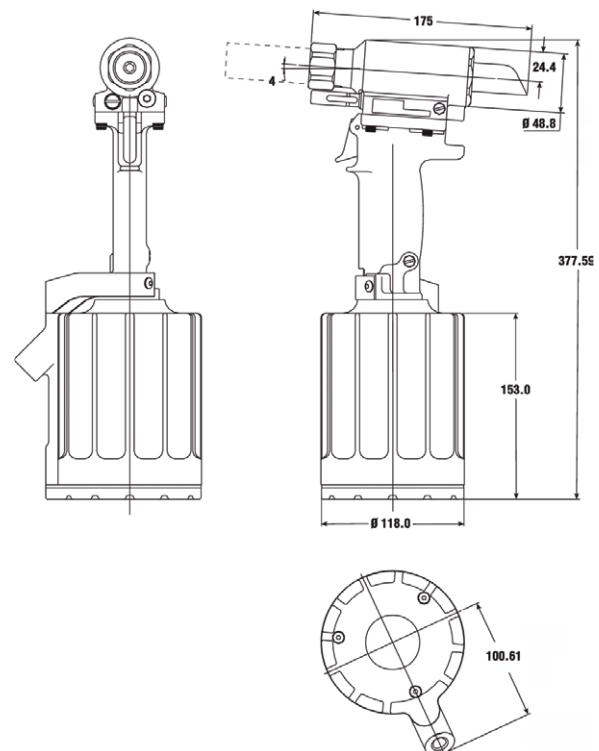
Stroke: 14.3 mm  
Insertion force: 38.3 kN at 6.2 bar  
Weight: 3.9 kg

### Scope of delivery

HUCK® 254 rivet installation tool  
Oil fill accessory kit  
Operating instructions  
Article No. 375 200 000

### Note

Pulling heads sold separately  
See table for product selection



## Working range - lockbolts

Fastener	Standard lockbolt ø [mm]				DeltaBolt® lockbolt ø [mm]				Multigrip lockbolt ø [mm]				Hucktainer® Plus ø [mm]
	4.8	6.4	8.0	9.6	4.8	6.4	8.0	9.6	4.8	6.4	7.8	9.6	9.5
Aluminium	•	•	•	•					•	•	•	•	
Steel	•	•	•	•	•	•	•	•	•	•	•	•	•
Stainless steel	•	•	•						•	•	•		

## Working range - high-strength blind rivets

Fastener	TIBULB blind rivet ø [mm]			M-LOCK blind rivet ø [mm]			MAGNA-BULB® blind rivet ø [mm]			BOM® blind rivet ø [mm]			
	4.8	6.4	7.8	4.8	6.4	9.5	4.8	6.4	7.8	4.8	6.4	7.8	9.5
Aluminium			•			•							
Steel			•			•			•	•	•		
Stainless steel			•			•							

## Pulling heads for HUCK® 254

Fastener	Nominal bolt ø [mm]	Pulling head type	Article No.
Standard lockbolts	4.8	HUCK® 99-2558	on request
	6.4	HUCK® 99-2564	375 845 000
	8.0	HUCK® 99-99-245	375 885 000
	9.6	HUCK® 99-100-245	375 945 000
DeltaBolt® lockbolts	4.8	HUCK® 99-2558	on request
	6.4	HUCK® 99-2564	375 845 000
	8.0	HUCK® 99-99-245	375 885 000
	9.6	HUCK® 99-100-245	375 945 000
Multigrip lockbolts	4.8	HUCK® 99-1456 <sup>2</sup>	372 985 000
	6.4	HUCK® 99-1477UK <sup>2</sup>	371 980 000
	7.8	HUCK® 99-1439	371 965 000
	9.6	HUCK® 99-1440	371 970 000
Hucktainer® Plus TIBULB blind rivets	9.5	HUCK® 99-3438	on request
	4.8		
	6.4		
	7.8	HUCK® 99-3307	385 159 000
M-LOCK blind rivets	4.8		
	6.4		
	9.5	HUCK® 99-3318	371 904 000
MAGNA-BULB® blind rivets	4.8		
	6.4		
	7.8	HUCK® 99-3307	385 159 000
BOM® blind rivets	4.8	HUCK® 99-1053	on request
	6.4	HUCK® 99-830-1	372 550 000
	7.8		
	9.5		

<sup>2</sup> Only to be fitted using a connector Article No. 375 870 000

For technical specifications on pulling heads, see table on pages 24/25.

## HUCK® 256

Hydropneumatic rivet installation tool for installing lockbolts and high-strength blind rivets

### Benefits at a glance

- Ergonomic handle
- Chrome-plated piston rod
- In-line plunger
- High insertion force
- For fast installation times in production

### Technical specifications

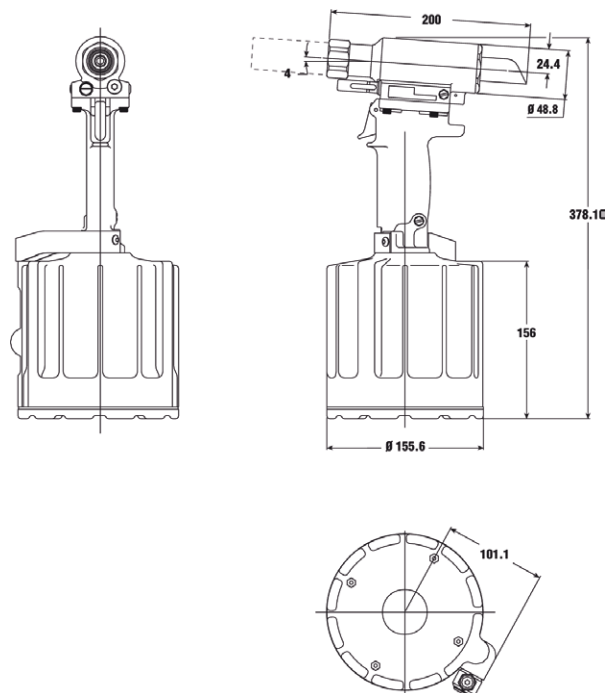
Stroke: 22.2 mm  
Insertion force: 44.4 kN at 6.2 bar  
Weight: 5.0 kg

### Scope of delivery

HUCK® 256 rivet installation tool  
Oil fill accessory kit  
Operating instructions  
Article No. 375 490 000

### Note

Pulling heads sold separately  
See table for product selection



## Working range - lockbolts

Fastener	Standard lockbolt ø [mm]				DeltaBolt® lockbolt ø [mm]				Multigrip lockbolt ø [mm]				Hucktainer® Plus ø [mm]
	4.8	6.4	8.0	9.6	4.8	6.4	8.0	9.6	4.8	6.4	7.8	9.6	9.5
Aluminium	•	•	•	•					•	•	•	•	
Steel	•	•	•	•	•	•	•	•	•	•	•	•	•
Stainless steel	•	•	•	•					•	•	•	•	

## Working range - high-strength blind rivets

Fastener	TIBULB blind rivet ø [mm]			M-LOCK blind rivet ø [mm]			MAGNA-BULB® blind rivet ø [mm]			BOM® blind rivet ø [mm]			
	4.8	6.4	7.8	4.8	6.4	9.5	4.8	6.4	7.8	4.8	6.4	7.8	9.5
Aluminium													
Steel						•			•	•	•		
Stainless steel													

## Pulling heads for HUCK® 256

Fastener	Nominal bolt ø [mm]	Pulling head type	Article No.
Standard lockbolts	4.8	HUCK® 99-2558	on request
	6.4	HUCK® 99-2564	375 845 000
	8.0	HUCK® 99-99-245	375 885 000
	9.6	HUCK® 99-100-245	375 945 000
DeltaBolt® lockbolts	4.8	HUCK® 99-2558	on request
	6.4	HUCK® 99-2564	375 845 000
	8.0	HUCK® 99-99-245	375 885 000
	9.6	HUCK® 99-100-245	375 945 000
Multigrip lockbolts	4.8	HUCK® 99-1456 <sup>2</sup>	372 985 000
	6.4	HUCK® 99-1477UK <sup>2</sup>	371 980 000
	7.8	HUCK® 99-1439	371 965 000
	9.6	HUCK® 99-1440	371 970 000
Hucktainer® Plus TIBULB blind rivets	9.5	HUCK® 99-3438	on request
	4.8		
	6.4		
M-LOCK blind rivets	7.8		
	4.8		
	6.4		
MAGNA-BULB® blind rivets	9.5	HUCK® 99-3318	371 904 000
	4.8		
	6.4		
BOM® blind rivets	7.8	HUCK® 99-3307	385 159 000
	4.8	HUCK® 99-1053	on request
	6.4	HUCK® 99-830-1	372 550 000
	7.8		
	9.5		

<sup>2</sup> Only to be fitted using a connector Article No. 375 870 000

For technical specifications on pulling heads, see table on pages 24/25.

## HUCK® 2481

Hydraulic rivet installation tool for installing lockbolts and high-strength blind rivets

### Benefits at a glance

- With set of 3.5 m hoses
- Super-light tool
- Low maintenance, as only one moving part

### Technical specifications

Stroke: 22.2 mm  
Insertion force: 25.4 kN at 579 bar  
Weight: 1.0 kg (without hose set)

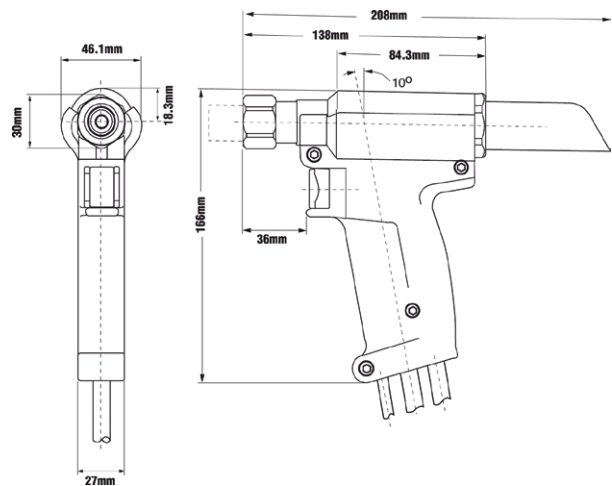
### Scope of delivery

HUCK® 2480 rivet installation tool with set of 3.5 m hoses  
Operating instructions  
Article No. 370 445 000

Required power unit:  
HUCK® KA28-001; HUCK® KA32-002; model HUCK® HV 703

### Note

Pulling heads sold separately  
See table for product selection





## Working range - lockbolts

Fastener	Standard lockbolt ø [mm]				DeltaBolt® lockbolt ø [mm]				Multigrip lockbolt ø [mm]				Hucktainer® Plus ø [mm]
	4.8	6.4	8.0	9.6	4.8	6.4	8.0	9.6	4.8	6.4	7.8	9.6	9.5
Aluminium	•	•							•	•			
Steel	•	•			•	•			•	•			•
Stainless steel	•	•							•	•			

## Working range - high-strength blind rivets

Fastener	TIBULB blind rivet ø [mm]			M-LOCK blind rivet ø [mm]			MAGNA-BULB® blind rivet ø [mm]			BOM® blind rivet ø [mm]			
	4.8	6.4	7.8	4.8	6.4	9.5	4.8	6.4	7.8	4.8	6.4	7.8	9.5
Aluminium	•	•		•	•								
Steel	•	•		•	•		•	•		•			
Stainless steel	•	•		•	•								

## Pulling heads for HUCK® 2480

Fastener	Nominal bolt ø [mm]	Pulling head type	Article No.
Standard lockbolts	4.8	HUCK® 99-3003	371 680 000
	6.4	HUCK® 99-3006	371 705 000
	8.0		
	9.6		
DeltaBolt® lockbolts	4.8	HUCK® 99-3003	371 680 000
	6.4	HUCK® 99-3006	371 705 000
	8.0		
	9.6		
Multigrip lockbolts	4.8	HUCK® 99-1456	372 985 000
	6.4	HUCK® 99-1477UK	371 980 000
	7.8		
	9.6		
Hucktainer® Plus TIBULB blind rivets	9.5	HUCK® 99-3464	
	4.8	HUCK® 99-3303	371 805 000
	6.4	HUCK® 99-3305	371 815 000
	7.8		
M-LOCK blind rivets	4.8	HUCK® 99-3303	371 805 000
	6.4	HUCK® 99-3305	371 815 000
	9.5		
MAGNA-BULB® blind rivets	4.8	HUCK® 99-3303	371 805 000
	6.4	HUCK® 99-3305	371 815 000
	7.8		
BOM® blind rivets	4.8	HUCK® 99-994	372 780 000
	6.4		
	7.8		
	9.5		

For technical specifications on pulling heads, see table on pages 24/25.

## HUCK® 2581

Hydraulic rivet installation tool for installing lockbolts and high-strength blind rivets, ideal for confined spaces.

### Benefits at a glance

- With 0.5 m hose
- Low maintenance, as only one moving part

### Technical specifications

Stroke: 24.0 mm  
Insertion force: 47.6 kN at 510 bar  
Weight: 2.5 kg (without hose set)

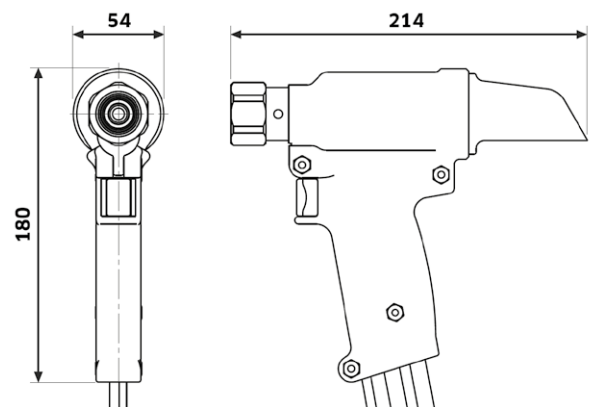
### Scope of delivery

HUCK® 2581 rivet installation tool with set of 0.5 m hoses  
Oil fill accessory kit  
Operating instructions  
Article No. 371 180 000

Required power unit:  
HUCK® KA28-001; HUCK® KA32-002; model HUCK® HV 703

### Note

Pulling heads sold separately  
See table for product selection



## Working range - lockbolts

Fastener	Standard lockbolt ø [mm]				DeltaBolt® lockbolt ø [mm]				Multigrip lockbolt ø [mm]				Hucktainer® Plus ø [mm]
	4.8	6.4	8.0	9.6	4.8	6.4	8.0	9.6	4.8	6.4	7.8	9.6	9.5
Aluminium	•	•	•	•					•	•	•	•	
Steel	•	•	•	•	•	•	•	•	•	•	•	•	•
Stainless steel	•	•	•	•					•	•	•	•	

## Working range - high-strength blind rivets

Fastener	TIBULB blind rivets ø [mm]			M-LOCK blind rivets ø [mm]			MAGNA-BULB® blind rivets ø [mm]			BOM® blind rivets ø [mm]			
	4.8	6.4	7.8	4.8	6.4	9.5	4.8	6.4	7.8	4.8	6.4	7.8	9.5
Aluminium													
Steel						•			•	•	•	•	•
Stainless steel													

## Pulling heads for HUCK 2581

Fastener	Nominal bolt ø [mm]	Pulling head type	Article No.
Standard lockbolts	4.8	HUCK® 99-2558	on request
	6.4	HUCK® 99-2564	375 845 000
	8.0	HUCK® 99-99-245	375 885 000
	9.6	HUCK® 99-100-245	375 945 000
DeltaBolt® lockbolts	4.8	HUCK® 99-2558	on request
	6.4	HUCK® 99-2564	375 845 000
	8.0	HUCK® 99-99-245	375 885 000
	9.6	HUCK® 99-100-245	375 945 000
Multigrip lockbolts	4.8	HUCK® 99-1456 <sup>2</sup>	372 985 000
	6.4	HUCK® 99-1477UK <sup>2</sup>	371 980 000
	7.8	HUCK® 99-1439	371 965 000
	9.6	HUCK® 99-1440	371 970 000
Hucktainer® Plus TIBULB blind rivets	9.5	HUCK® 99-3438	on request
	4.8		
	6.4		
M-LOCK blind rivets	7.8		
	4.8		
	6.4		
MAGNA-BULB® blind rivets	9.5	HUCK® 99-3318	371 904 000
	4.8		
	6.4		
BOM® blind rivets	7.8	HUCK® 99-3307	385 159 000
	4.8		
	6.4		
BOM® blind rivets	7.8	HUCK® 99-1053	on request
	6.4	HUCK® 99-830-1	372 550 000
	7.8	HUCK® 99-769	372 705 000
	9.5	HUCK® 99-1272	372 995 000

<sup>2</sup> Only to be fitted using a connector Article No. 375 870 000

For technical specifications on pulling heads, see table on pages 24/25.

## HUCK® 2583

Hydraulic rivet installation tool for installing lockbolts and high-strength blind rivets, high-speed stroke

### Benefits at a glance

- With 3.5 m hose
- Super-light tool
- Low maintenance, as only one moving part

### Technical specifications

Stroke: 38.1 mm  
Insertion force: 48.3 kN at 579 bar  
Weight: 2.1 kg (without hose set)

### Scope of delivery

HUCK® 2583 rivet installation tool with set of 3.5 m hoses  
Operating instructions  
Article No. 370 830 000

Required power unit:  
HUCK® KA28-001; HUCK® HK32-002; model HUCK® HV 703

### Note

Pulling heads sold separately  
See table for product selection



## Working range - lockbolts

Fastener	Standard lockbolt ø [mm]				DeltaBolt® lockbolt ø [mm]				Multigrip lockbolt ø [mm]				Hucktainer® Plus ø [mm]
	4.8	6.4	8.0	9.6	4.8	6.4	8.0	9.6	4.8	6.4	7.8	9.6	9.5
Aluminium	•	•	•	•					•	•	•	•	
Steel	•	•	•	•	•	•	•	•	•	•	•	•	•
Stainless steel	•	•	•	•					•	•	•	•	

## Working range - high-strength blind rivets

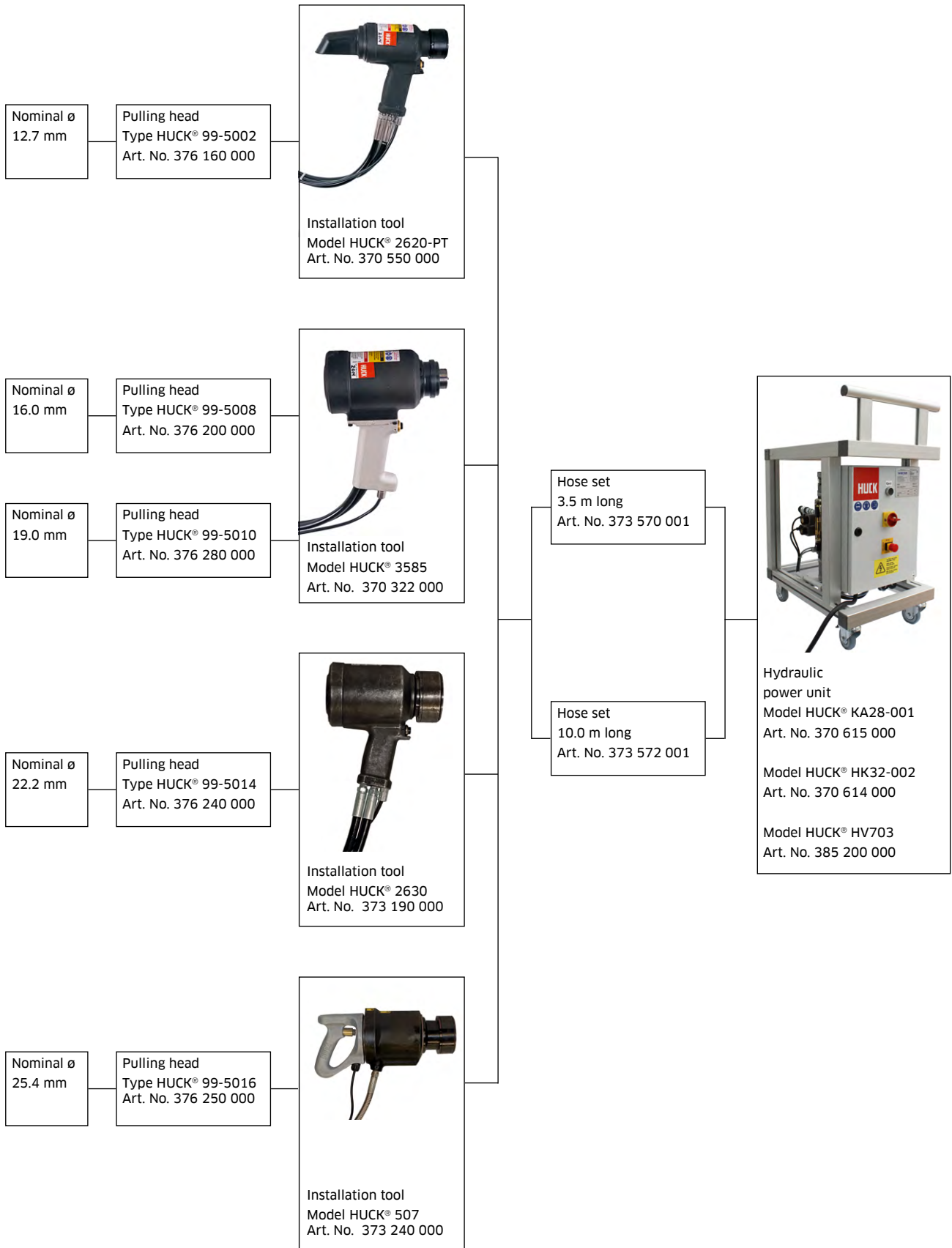
Fastener	TIBULB blind rivet ø [mm]			M-LOCK blind rivet ø [mm]			MAGNA-BULB® blind rivet ø [mm]			BOM® blind rivet ø [mm]			
	4.8	6.4	7.8	4.8	6.4	9.5	4.8	6.4	7.8	4.8	6.4	7.8	9.5
Aluminium													
Steel						•			•	•	•	•	•
Stainless steel													

## Pulling heads for HUCK® 2583

Fastener	Nominal bolt ø [mm]	Pulling head type	Article No.
Standard lockbolts	4.8	HUCK® 99-2558	on request
	6.4	HUCK® 99-2564	375 845 000
	8.0	HUCK® 99-99-245	375 885 000
	9.6	HUCK® 99-100-245	375 945 000
DeltaBolt® lockbolts	4.8	HUCK® 99-2558	on request
	6.4	HUCK® 99-2564	375 845 000
	8.0	HUCK® 99-99-245	375 885 000
	9.6	HUCK® 99-100-245	375 945 000
Multigrip lockbolts	4.8	HUCK® 99-3206	on request
	6.4	HUCK® 99-1290	on request
	7.8	HUCK® 99-1439	371 965 000
	9.6	HUCK® 99-1440	371 970 000
Hucktainer® Plus TIBULB blind rivets	9.5	HUCK® 99-3438	
	4.8		
	6.4		
M-LOCK blind rivets	7.8		
	4.8		
	6.4		
MAGNA-BULB® blind rivets	9.5	HUCK® 99-3318	371 904 000
	4.8		
	6.4		
BOM® blind rivets	7.8	HUCK® 99-3307	385 159 000
	4.8	HUCK® 99-1053	on request
	6.4	HUCK® 99-830-1	372 550 000
	7.8	HUCK® 99-769	372 705 000
	9.5	HUCK® 99-1272	372 995 000

For technical specifications on pulling heads, see table on pages 24/25.

# Rivet installation tools for high-strength lockbolts HuckBolt® C50L®

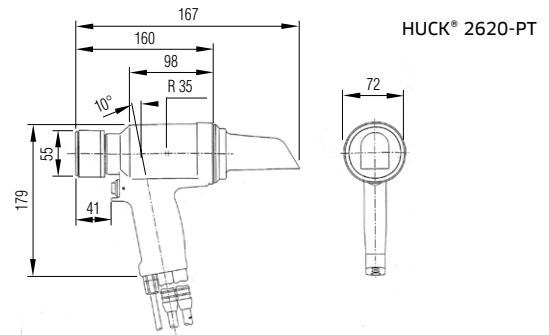


# Technical specifications - hydraulic rivet installation tools for HuckBolt® C50L®

## HUCK® 2620-PT

### Technical specifications

Working range:	ø 12.7 mm
Performance:	88.2 KN at 510 bar
Stroke:	36.5 mm
Weight without pulling head:	4.5 kg
Article No.	370 550 000



## HUCK® 3585

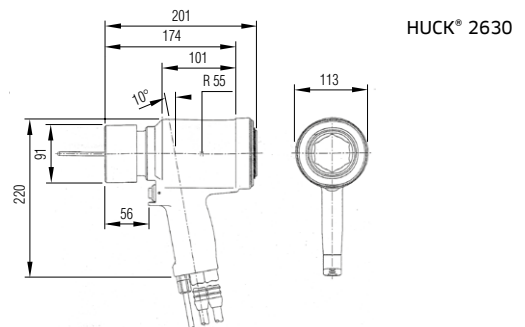
### Technical specifications

Working range:	ø 15.9 - 19.1 mm
Performance:	203 KN at 510 bar
Stroke:	46 mm
Weight without pulling head:	8.7 kg
Article No.	370 322 000

## HUCK® 2630

### Technical specifications

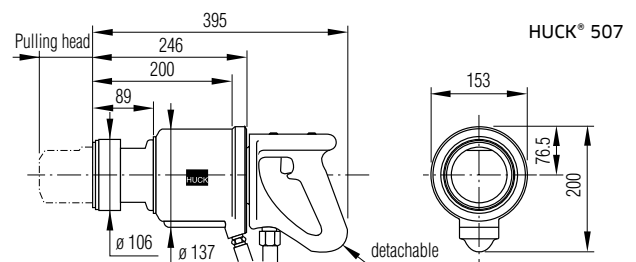
Working range:	ø 22.2 mm
Performance:	216 kN at 448 bar
Stroke:	48.4 mm
Weight without pulling head:	9.8 kg
Article No.	373 190 000



## HUCK® 507

### Technical specifications

Working range:	ø 25.4 mm
Performance:	336.73 KN at 393 bar
Stroke:	63.5 mm
Weight without pulling head:	19.5 kg
Article No.	373 240 000



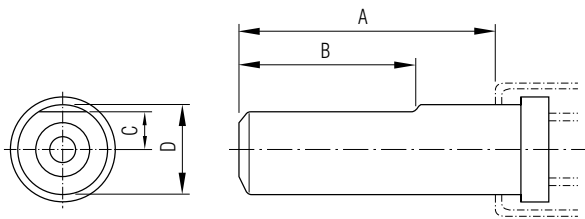
All hydraulic installation tools must be connected to a hydraulic power unit using the set of hoses

Special versions of installation tools available on request

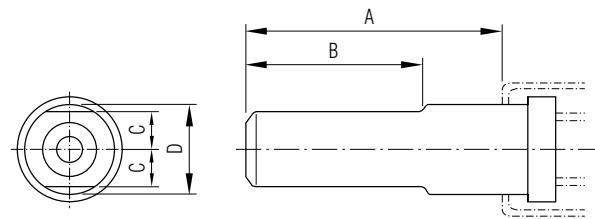
### Note

Pulling heads sold separately  
See table for product selection

## Standard/HV pulling heads



One-sided bevel



Double-sided bevel

### Pulling heads for standard TIFAS® LockBolt and DeltaBolt® lockbolt systems

Nominal bolt ø [mm]	For tools Model	Dimensions				Bevel	Pulling head type	Article No.
		A [mm]	B [mm]	C [mm]	D [mm]			
4.8	RL 75N / EL18 / 2025LB / 2480	51.0			19.1		HUCK® 99-3003 <sup>1</sup>	371 680 000
	254 / 256 / 2503 / 2580	58.0	43.9	8.1	17.8	1-sided	HUCK® 99-2558	on request
6.4	RL 75N / EL18 / 2025LB / 2480	51.0			19.1		HUCK® 99-3006 <sup>1</sup>	371 705 000
	254 / 256 / 2503 / 2580	58.0	43.7	8.7	19.4	1-sided	HUCK® 99-2564	375 845 000
8.0	254 / 256 / 2503 / 2580	71.0	53.4	12.2	27.0	1-sided	HUCK® 99-99-245	375 885 000
9.6	254 / 256 / 2503 / 2580	70.0	53.4	12.2	27.0	1-sided	HUCK® 99-100-245 <sup>2</sup>	375 945 000

<sup>1</sup> If used on the 2025LB, these pulling heads must be fitted without the supplied connector.

<sup>2</sup> Only aluminium studs may be installed if using the 255 model.

### Pulling heads for HuckBolt® C50L® lockbolt system > 10 mm

Nominal bolt ø [mm]	For tools Model	Dimensions				Bevel	Pulling head type	Article No.
		A [mm]	B [mm]	C [mm]	D [mm]			
12.7	2620 PT	106.0	58.5	19.7	44.5	1-sided	HUCK® 99-5002	376 160 000
15.9	3585	106.0	58.5	22.9	52.6	1-sided	HUCK® 99-5008	376 200 000
19.0	3585	119.0	58.0	24.7	55.5	1-sided	HUCK® 99-5010	376 280 000
22.2	2630	83.0	54.2	30.4	69.9	1-sided	HUCK® 99-5014	376 240 000
25.4	507	100.0	69.9	38.1	82.6	2-sided	HUCK® 99-5016	376 250 000

Extended pulling head versions available on request.



## Pulling heads for TIFAS® LockBolt Multigrip lockbolt system with extended grip range

Nominal bolt ø [mm]	For tools Model	Dimensions				Bevel	Pulling head type	Article No.
		A [mm]	B [mm]	C [mm]	D [mm]			
4.8	RL 75N / EL18 / 2025LB / 2480 /	49.0	39.9	8.9	19.1	2-sided	HUCK® 99-1456 <sup>1,2</sup>	372 985 000
	254 / 256 / 2580						HUCK® 99-3206	on request
	2503 / 2580							
6.4	RL 75N / EL18 / 2025LB / 254 /	54.0	38.9	9.3	19.7	2-sided	HUCK® 99-1477UK <sup>1</sup>	371 980 000
	256 / 2480 / 2580	91.0	47.8	8.9	27.0	2-sided	HUCK® 99-1290	371 960 000
	2503 / 2580							

<sup>1</sup> These pulling heads can only be fitted to the 255/256 and 2503/2580 models by means of the connector (adapter), model 102 463, Article No. 375 870 000.

<sup>2</sup> If used on the 2025LB, these pulling heads must be fitted without the supplied connector.

## Pulling heads for lockbolt system for HUCKTAINER® PLUS composite materials

Nominal bolt ø [mm]	For tools Model	Dimensions				Bevel	Pulling head type	Article No.
		A [mm]	B [mm]	C [mm]	D [mm]			
9.5	RL 75N	59.3			28.2		HUCK® 99-3465 <sup>1</sup>	371 730 000
	254 / 256	68.9			27.7		HUCK® 99-3438	on request
	2025LB	59.5			28.2		HUCK® 99-3464L	on request

<sup>1</sup> A special sleeve (Article No. 385 081 00) is required for installation. Please order separately.

## Hydraulic power unit Model HUCK® KA28-001 (without hose set)

To operate hydraulic installation tools

### Technical specifications

Length:	580 mm
Width:	400 mm
Height:	800 mm (incl. handle)
Tank capacity:	approx. 5 l
Pump:	2.8 l/min
Elec. connection:	380 V three-phase current (other supply voltages on request)
Required oil pressure:	525 bar (factory default setting)
Motor output:	1 kW
Weight (incl. oil):	approx. 54.0 kg
Article No.	370 615 000



## Hydraulic power unit Model HUCK® HK32-002 (without hose set)

To operate hydraulic installation tools

### Technical specifications

Length:	720 mm
Width:	500 mm
Height:	800 mm
Tank capacity:	6.9 l
Pump:	3.2 l/min
Elec. connection:	380 V three-phase current
Required oil pressure:	600 bar
Motor output:	2.2 kW
Weight:	approx. 97 kg
Article No.	370 614 000



### Note

All hydraulic power units supplied without set of hoses.

# Hydraulic power unit

## Model HUCK® HV703 (without hose set)

To operate hydraulic installation tools

### Technical specifications

Length:	740 mm
Width:	450 mm
Height:	630 mm
Tank capacity:	5.0 l
Pump:	3.2 l/min
Elec. connection:	400 V / 50 Hz
Required oil pressure:	650 bar
Motor output:	2.2 kW
Weight:	approx. 80 kg
Article No.	385 200 000



Version for 500 V power supply available on request.

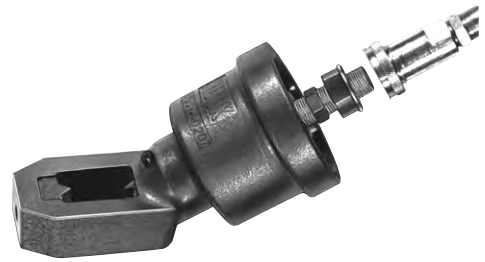
### Note

All hydraulic power units supplied without set of hoses.

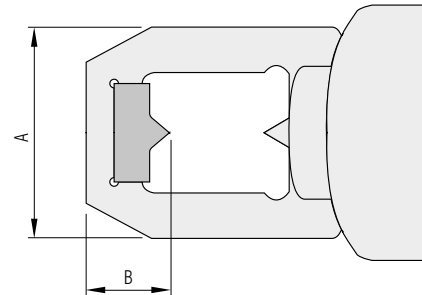
## Hydraulic lockbolt collar cutter

To remove installed HV lockbolts

For HV lockbolt ø in [mm]	A [mm]	B [mm]	Weight [kg]	Model	Article No.
12.7	39.7	28.6	2.7	HUCK® 516	373 600 000
16.0	49.2	28.6	2.7	HUCK® 520	373 630 000
19.0	57.2	31.8	3.2	HUCK® 524	373 660 000
22.2	63.5	31.8	3.6	HUCK® 528	373 690 000
25.4	66.6	38.1	7.2	HUCK® 532	



Hydraulic lockbolt collar cutters must be fitted to the pressure line using a quick-release coupling.



## Set of hoses (complete set)

Comprising quick-release couplings; to connect installation tools or lockbolt collar cutters to hydraulic power units

Length [m]	Cross-section [mm]	Pressure max [bar]	Article No.
3.5	6.4	690	373 570 001
10.0	6.4	690	373 572 001



## Tools and accessories for BobTail™ lockbolts



Pulling head



Lockbolt collar cutter



HUCK® Tool BTT25, BTT35, BTT57



HUCK® Tool BTT20SF, BTT25, BTT57



Set of hoses



Hydraulic power unit HUCK® HK432BT

BobTail™ tools and accessories available on request.



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