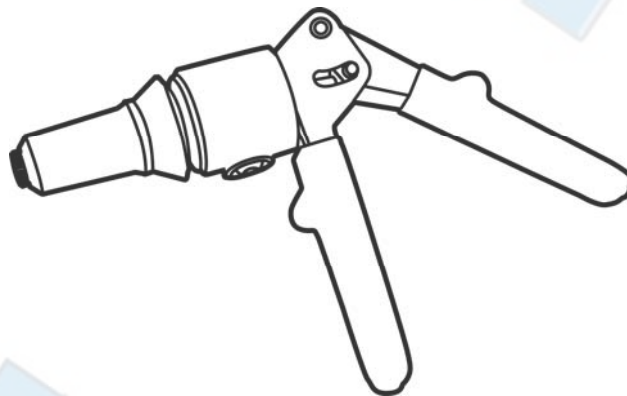


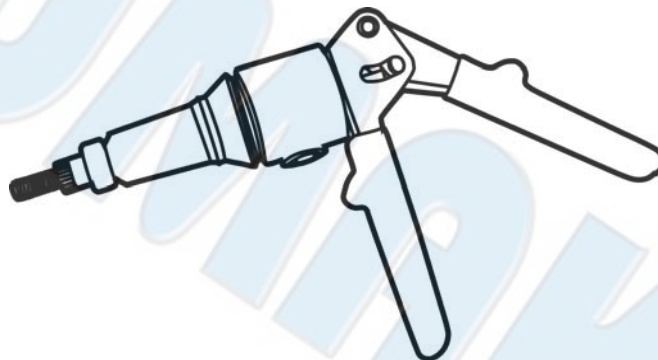
INSTRUCTION MANUAL

ITEM NO.: HT-6750
HYDRAULIC HAND RIVETER KIT

ITEM NO.: HT-6850M
HYDRAULIC HAND RIVETING NUT TOOL KIT



HT-6750



HT-6850M



CONTENTS

SAFETY	4
PRINCIPLE OF OPERATION AND TOOL SPECIFICATIONS	5
OPERATING INSTRUCTIONS	6~8
RIVET PINTAIL REMOVAL	7
THREE PIECE JAW INSTALLATION AND REMOVAL	8~9
TOOL MAINTENANCE	10
TROUBLESHOOTING	11
OPTIONAL ACCESSORIES	12
RIVETER TO NUTSETTER CONVERSION INSTRUCTIONS	13

SAFETY

This instruction manual must be read with particular attention to the following safety guide lines, by any person servicing or operating this tool.

1. Safety Glossary



— Product complies with requirements set forth by the relevant European directives.



— Read manual prior to using equipment.



— Eye protection required while using this equipment.



— Hearing protection required while using this equipment.



WARNINGS - Must be understood to avoid severe personal injury.

CAUTIONS — show *conditions* that will damage equipment and or structure.

Notes — are reminders of required procedures.

Bold. Italic type and underlining - emphasizes a specific instruction.

2. Huck equipment must be maintained in a safe working condition at all times and inspected on a regular basis for damage or wear. Any repair should be done by a qualified repairman trained on Huck procedures.
3. Repairman and Operator must read manual prior to using equipment and understand any Warning and Caution stickers/ labels supplied with equipment before connecting equipment to any primary power supply. As applicable, each of the sections in this manual have specific safety and other information.
4. See MSDS Specifications before servicing the tool. MSDS Specifications are available from your Huck representative or on-line at www.huck.com. Click on Installation Systems Division.
5. When repairing or operating Huck installation equipment, always wear approved eye protection. Where applicable, refer to ANSI Z87.1 – 1989
6. Disconnect primary power source before doing maintenance on Huck equipment.
7. If any equipment shows signs of damage, wear, or leakage, do not connect it to the primary power supply.
8. Make sure proper power source is used at all times.
9. Never remove any safety guards or pintail deflector.
10. Never install a fastener in free air. Personal injury from fastener ejecting may occur.
11. Do not abuse tool by dropping or using it as a hammer. Never use hydraulic or air lines as a handle. Reasonable care of installation tools by operators is an important factor in maintaining tool efficiency, eliminating downtime, and in preventing an accident which may cause severe personal injury.
12. Never place hands between nose assembly and work piece.

PRINCIPLE OF OPERATION AND TOOL SPECIFICATIONS

READ INSTRUCTIONS THOROUGHLY PRIOR TO OPERATING THE RIVETER. THIS RIVETER IS DESIGNED FOR INTERMITTENT DUTY AND MAINTENANCE WORK ONLY.

Manual Hydraulic Riveter

The HT-6750 is a hydraulic tool designed to set from 1/8 inch up to and including 1/4 inch diameter steel, stainless steel, aluminum and plastic rivets by changing only the nose piece. The HT-6750 has a rated pull pressure of over 3,500 lbs and one handed operation gives access to tight areas.

The hydraulic system is sealed, oil need not be added. If the HT-6850M should become damaged and leaks oil from the tool, ***it should be returned to an authorized service center.*** (Authorized Service centers may be found in the Authorized Tools Centers section.)

<u>Model</u>	<u>Stroke</u>	<u>Rivet Diameter</u>	<u>Rivet Materials</u>	<u>Pull Pressure</u>	<u>Weight</u>
HT-6850M	518"	1/8"-1/4"	Stainless Steel, Aluminum, Plastic	3,500 lbs	28 oz

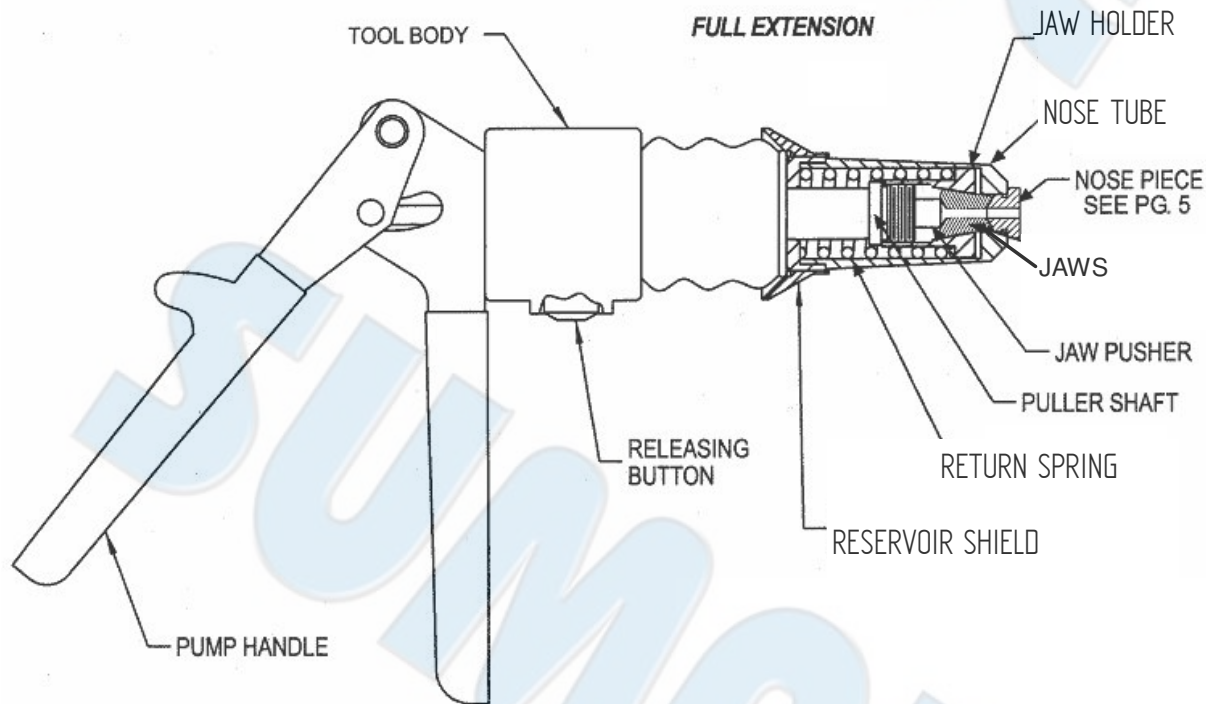
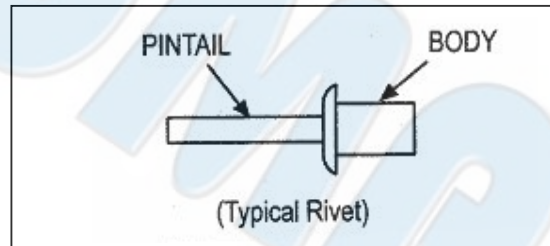


Figure 1

OPERATING INSTRUCTIONS

The HT-6750 hydraulic riveter installs fasteners by a pull and release system. Pumping the handles (see fig. 2 on the next page) will actuate the tool. The tool must be actuated when installing fasteners or changing nose pieces. After installing the fastener or changing the nose piece, the tool must be returned to its original position. This releases the pintail if a fastener was installed. To do this point the tool downward, squeeze HANDLES and push in RELEASING BUTTON (see fig. 3). The pintail should drop out. (See sections on NOSE PIECE INSTALLATION and FASTENER INSTALLATION for detailed instructions.)



Nose Piece Installation:

SELECT THE PROPER NOSE PIECE FOR THE CORRECT INSTALLATION OF FASTENER AND FUNCTION OF TOOL.

To change the Nose Piece

1. Remove the NOSE PIECE in the tool by unscrewing it in a counterclockwise direction.
2. Actuate tool until it is fully extended. (There should be gap of approximately 7/8" in between the RESERVOIR SHIELD and the TOOL BODY. (see fig. 1))
3. Hand tighten the NOSE PIECE into the NOSE TUBE and release the tool by squeezing the HANDLES and pressing the RELEASING BUT-TON at the same time.

Fastener Installation:

Install correct nose piece on tool (see NOSE PIECE installation section).

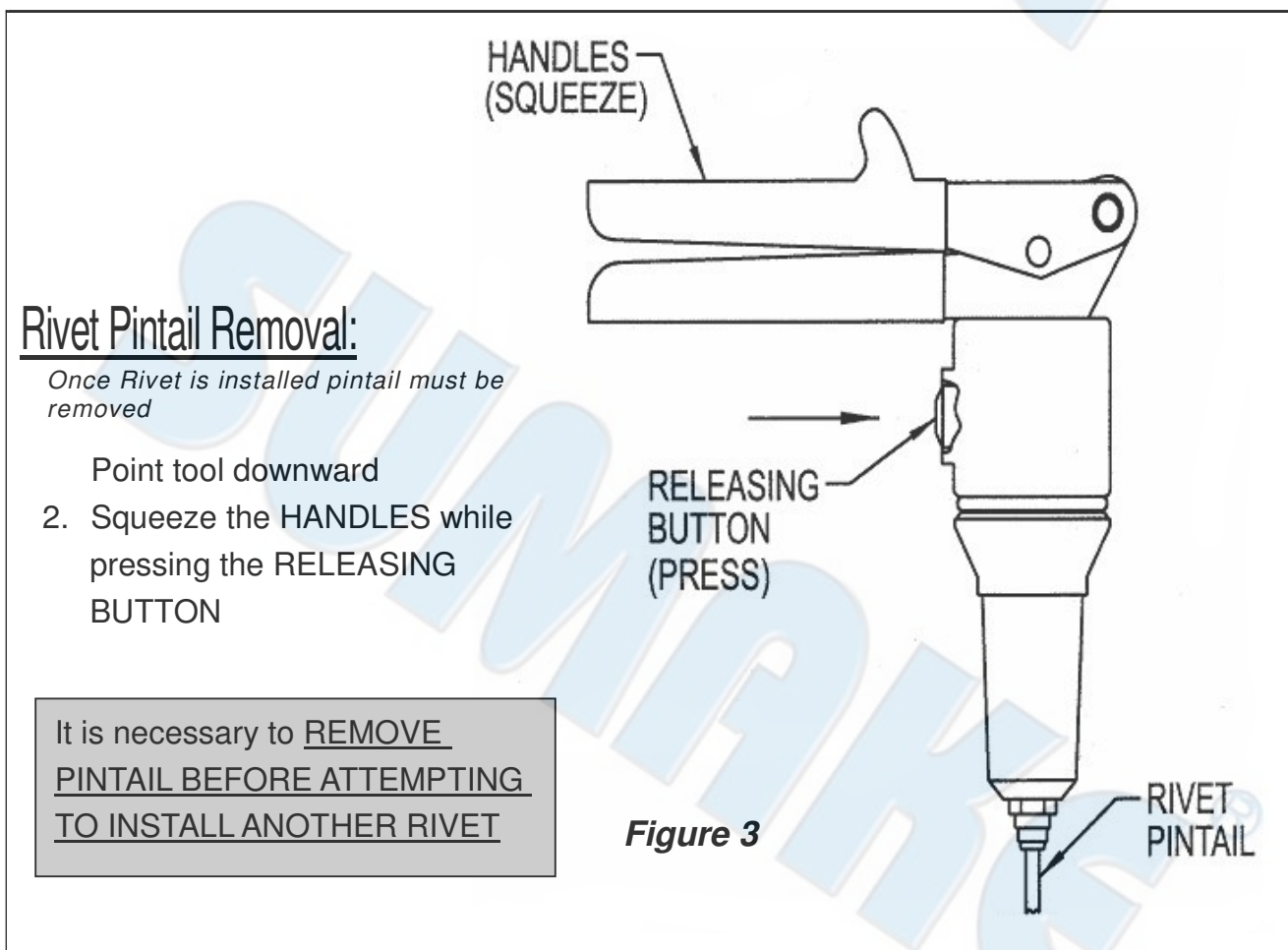
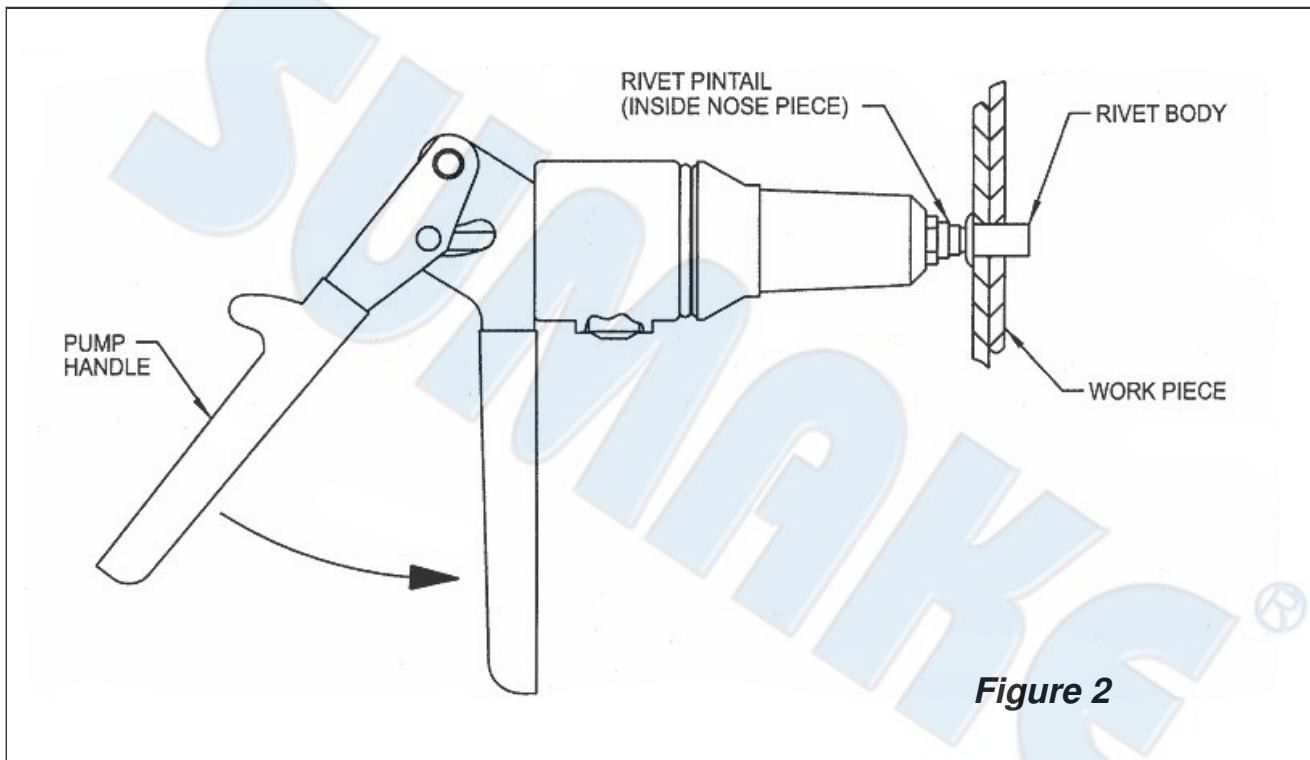
1. Insert pintail of rivet in to the NOSE PIECE.
2. Position the RIVET BODY in to WORK PIECE to be fastened.
3. Hold the tool steady against the work piece and pump HANDLES until rivet is set and pintail is broken*. See fig. 2 on the next page.

Note:

Before operating tool, make sure that all NOSE PARTS have been screwed in HAND TIGHT.

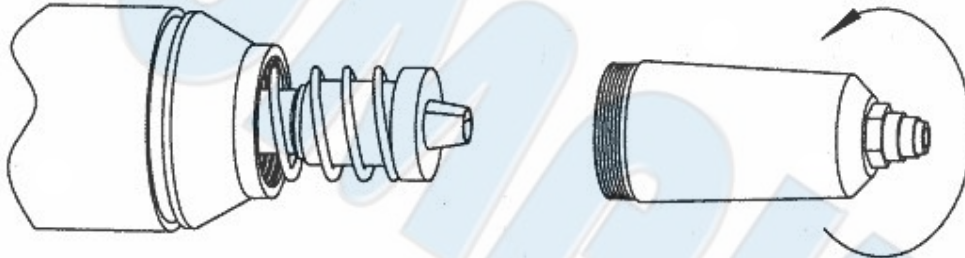
Frequently check that nose components do not vibrate loose during operation. ng

*The HT-6750 has a 5/8 inch work travel and will set most rivets in one cycle (approx. 12 pumps). If the tool reaches the end of its travel before the rivet breaks, DO NOT continue pumping the HANDLES on the tool. Release the tool by squeezing the HANDLES and pressing the RELEASING BUTTON, regrip the rivet, pump the HANDLES and finish the installation.



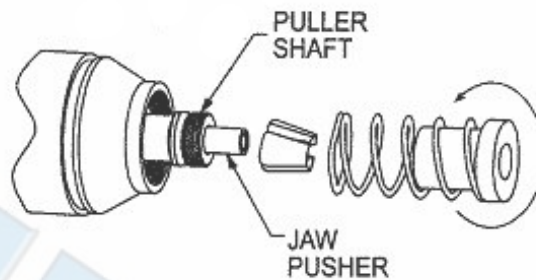
Three Piece Jaw Installation and

1. The jaws are installed at the factory and should only need to be removed for periodic inspection and cleaning. To remove the jaws unscrew the NOSE TUBE from the tool in a counterclockwise direction.



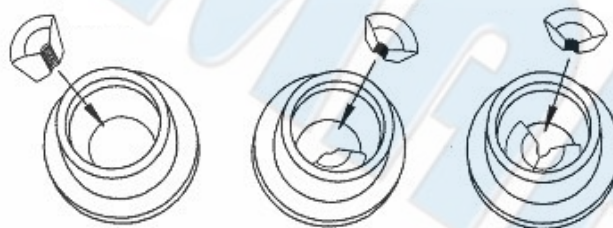
2. THREE PIECE JAW SYSTEM

Remove the JAW HOLDER by unscrewing it in a counterclockwise direction. Drop JAWS out from SPRING side. Actuate tool by squeezing the ACTUATING TRIGGER (see fig 3 above) until the jaw pusher is fully extended. Stop as soon as the JAW PUSHER is in the extended position.

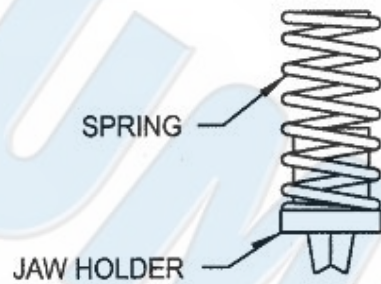


3. THREE PIECE JAW SYSTEM

To replace JAWS, hold JAW HOLDER large end down and at a slight angle. Hold finger over small opening and place jaws in one at a time. Add a small amount of jaw lubricant to jaws and jaws holder prior to assembly.

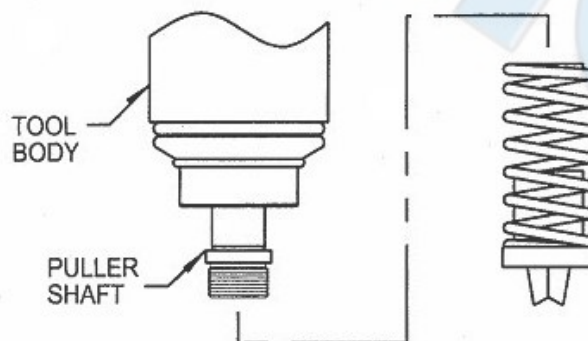


- 4.** When jaws are in place, insert jaw holder into spring, being sure to keep large end of jaw holder pointing downward.

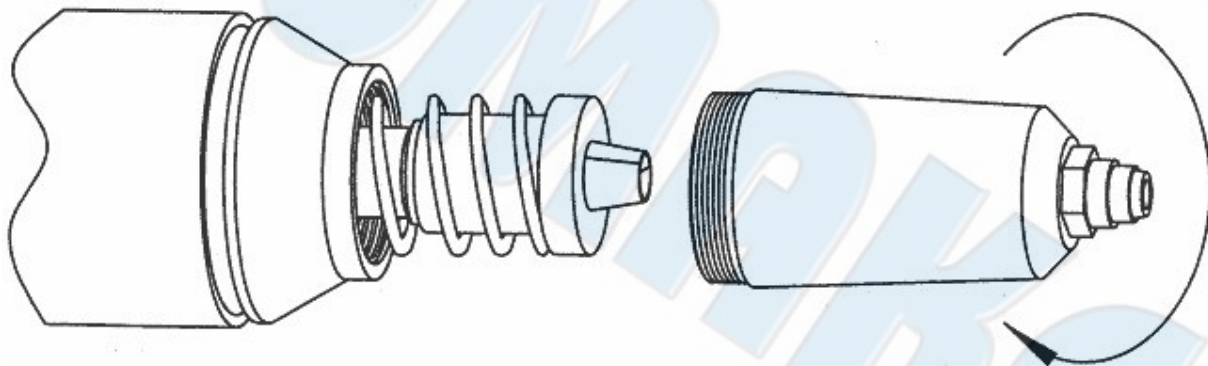


5. THREE JAW SYSTEM

Hold tool with the PULLER SHAFT pointing down and the JAW PUSHER fully extended. Screw the jaw holder on to the PULLER SHAFT. HAND TIGHTEN ONLY.

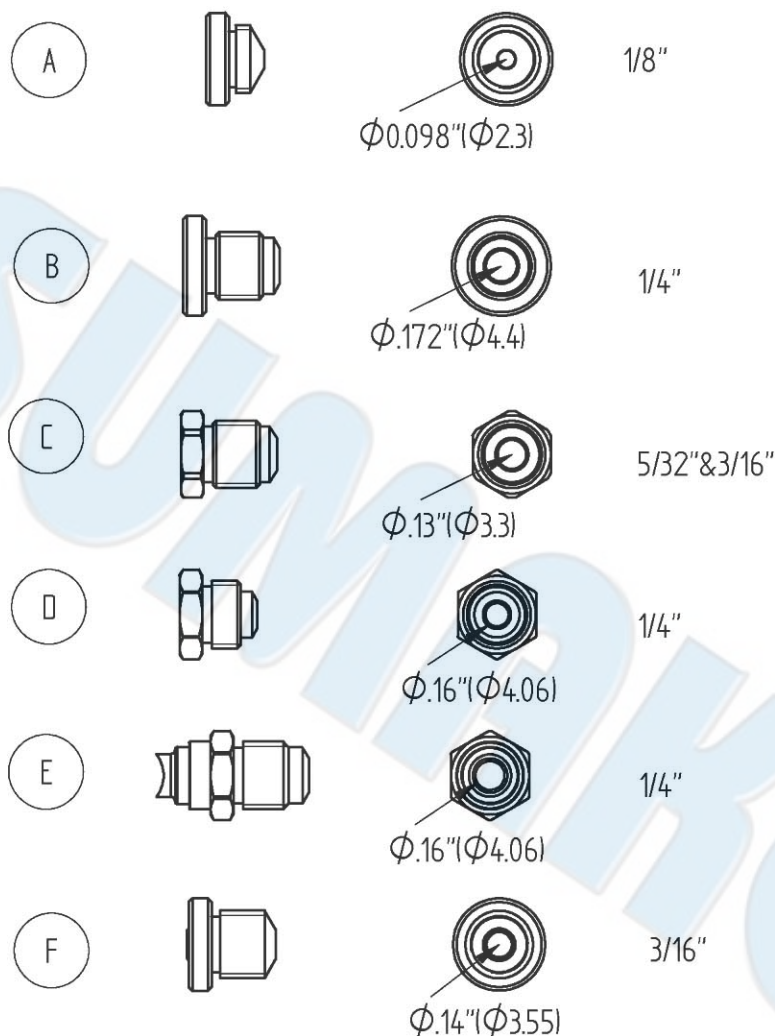


- 6.** Replace the NOSE TUBE and NOSE PIECE, HAND TIGHTEN ONLY. The tool is now ready to use.



Steps for Proper Tool Maintenance and Operation

1. Disassemble and clean NOSE components periodically or if the pintails do not drop out freely. Use a pick to clean the jaw grooves. Wash components in mineral spirits or isopropyl alcohol. Apply a small amount of lubricant to the JAWS and inside of JAW HOLDER prior to assembly.
2. To ease NOSE TUBE and NOSE PIECE installation, extend tool by pumping HANDLES.
3. **Do not use tool as a lever** if rivet pintail is jammed while regripping. Instead, squeeze HANDLES and press the RELEASING BUTTON while pushing tool nose against work piece for the jaws to get a deeper grip.
4. If rivet pintail is stuck in tool after breaking, lightly tap nose against a hard surface while squeezing HANDLES and pressing the RELEASING BUTTON with tool pointing downward. Pintail should then fall out.
5. Before operating tool, make sure that all NOSE PARTS have been screwed in HAND TIGHT.
6. The tool has a 5/8" work travel, the completion of which is indicated by a solid stop after approximately 12 pumps (one cycle). **Do not force beyond this point** to insure long life of tool.
7. The HT-6750(6850M) should not be used at temperatures below 35°F unless it is first brought to room temperature and cycled several times. Normal use of the tool after warming should keep it warm enough for proper operation.
8. If tool will not reverse, remove NOSE TUBE and inspect for any foreign matter that might have caused jamming between JAW HOLDER and inside of NOSE TUBE.
9. Frequently check that nose components do not vibrate loose during operation.
10. **Do not rock tool** when pumping it. This may cause rivets to prematurely break.
11. Large fasteners can be set one handed in tight areas by using short pump strokes.



TROUBLESHOOTING

<i>Problem</i>	<i>Solution</i>
1. Rivet pintail is stuck in tool	<p>First Step: Lightly tap nose against a hard surface while after breaking squeezing HANDLES and pressing down the RELEASING BUTTON with tool pointing downward Pintail should then fall out, see fig. 4. (If that does not work try Second Step)</p> <p>Second Step: (Use this only if first step does not work) Remove NOSE TUBE and JAW HOLDER (for help see figure 5) take out pintail and reassemble.</p>
2. Tool will not reverse	Push on the handles until you feel a slight give, then press the RELEASING BUTTON and continue pushing on the handles, the tool should then reverse. If this does not work Remove NOSE TUBE and inspect for any foreign matter that may have cause the jamming between JAW HOLDER and the inside of NOSE TUBE.
3. Fastener does not pull rivet	The JAW HOLDER is loose. Remove the NOSE TUBE and tighten the JAW HOLDER by turning it counter clockwise (see (See Three Piece Jaw Installation and Removal)).
4. The rivet does not fit into the tool	The rivet is to large, or the wrong NOSE PIECE is on the tool. To find the correct NOSE PIECE (see chart on page 11). If you do not have the needed NOSE PIECE, See next page for how to order the correct one.
5. Premature breaking	See solution for problem 4. Also verify the grip of the fastener and make sure you are not rocking the tool during installation.
6. Jamming of tool	See solution for problem 4. Also verify that you have the proper jaw engagement and that all parts are hand tight and that the jaws are cleaned and properly assembled in jaw pusher (See Three Piece Jaw Installation and Removal)
7. Rivet not installed properly	See solution for problem 4. Also verify jaw grip and that the appropriate fastener is being used.
8. Jaws breaking	See solution for problem 4. Check to see all parts are properly assembled and hand tight.
9. Damaged jaw pusher	See solution for problem 4. Check to see if all parts are properly assembled.

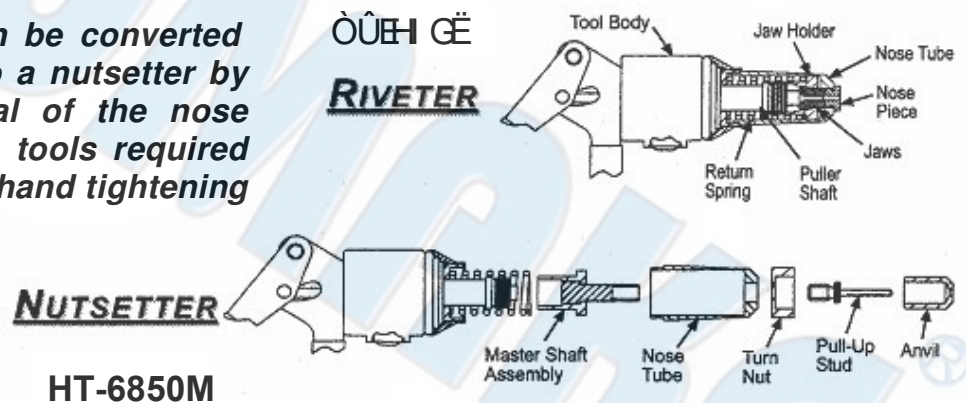
OPTIONAL ACCESSORIES

Part Number	Description
G	Nose Piece - 1/8" for Trim Molding Pop Rivets
H	Nose Piece - 1/8" Stand Off Pop Rivets
I	Nose Piece - 1/4" Monobolts
J	Nose Piece - Spec. GM Glass Stop Travel, Pop

SERVICE NOTES:

CONVERTING A RIVETER TO A NUTSETTER

The HT-6850M can be converted from a riveter to a nutsetter by changing several of the nose components. No tools required as parts require hand tightening only.



The **ØÛËÍ GËR NUTSETTER** sets 3mm through 3/8-24 threaded aluminum inserts and up to 1/4-20 steel inserts. Size changes are accomplished by changing the PULL-UP STUD and ANVIL. No tools required.

ØÛËÍ GËR Nutsetter

Installing threaded Inserts:

1. Make sure proper PULL-UP STUD and ANVIL in place.
2. Thread the insert on the PULL-UP STUD until all threads on the insert are engaged.
3. Position the INSERT into workpiece with the appropriate size hole and pump the HANDLES until the INSERT is set.

(You will feel the tool come to a definite stop when the insert is properly set. STOP PUMPING HANDLES)

Releasing the Tool: *(After INSERT has been set in the workpiece)*

1. PRESS THE RELEASING BUTTON WHILE SQUEEZING HANDLES.
2. Rotate the TURN NUT in a counter clockwise direction until the PULL-UP STUD is released from the THREAD-ED INSERT.

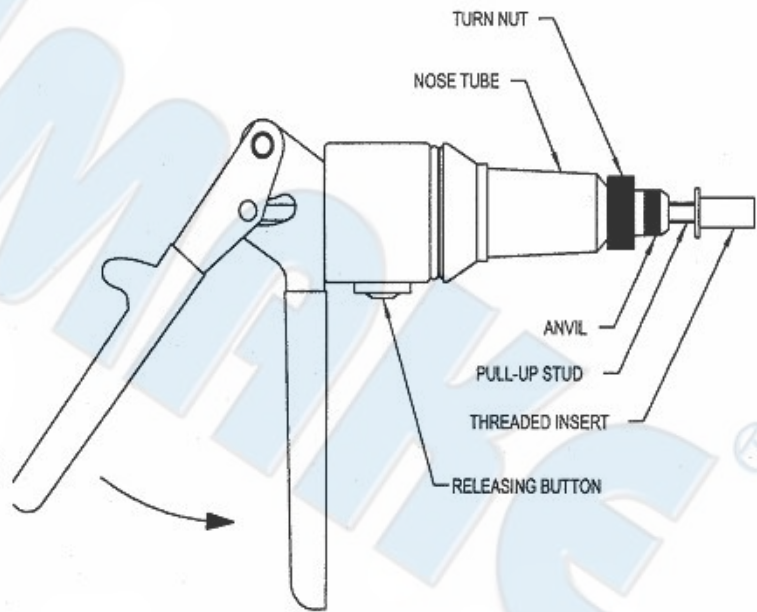
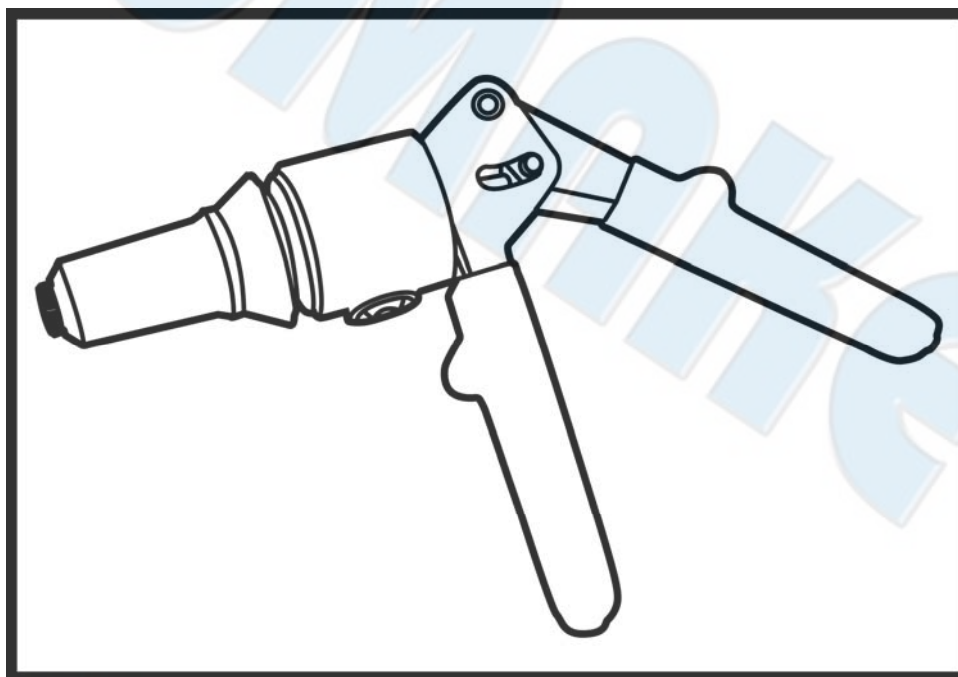


Figure 4



SUMAKE PNEUMATIC TOOLS



Hydraulic Hand Riveter HT-6750

Specification:

Riveting Capacity	1/8", 5/32", 3/16", 7/32", 1/4" (3.2mm, 4.0mm, 4.8mm, 5.6mm, 6.4 mm)
Stroke Length	5/8" (15.8 mm)
Traction Power	3500 lbs (1600 kg)
Net Weight	1.92 lbs (0.87 kg)

Noise and Vibration:

Vibration EN ISO 20643	Noise EN ISO 15744	Remark
No Load: 1.5 m/s ²	Sound Pressure Level No load: 54.8 dB(A)	Please always wear ear protector at environment noise level > 80 dB(A) due to risk of impaired hearing!
	Sound power level No load: 65.8 dB(A)	
Uncertainty K= 1.5 m/s ²	Uncertainty K= 3dB	

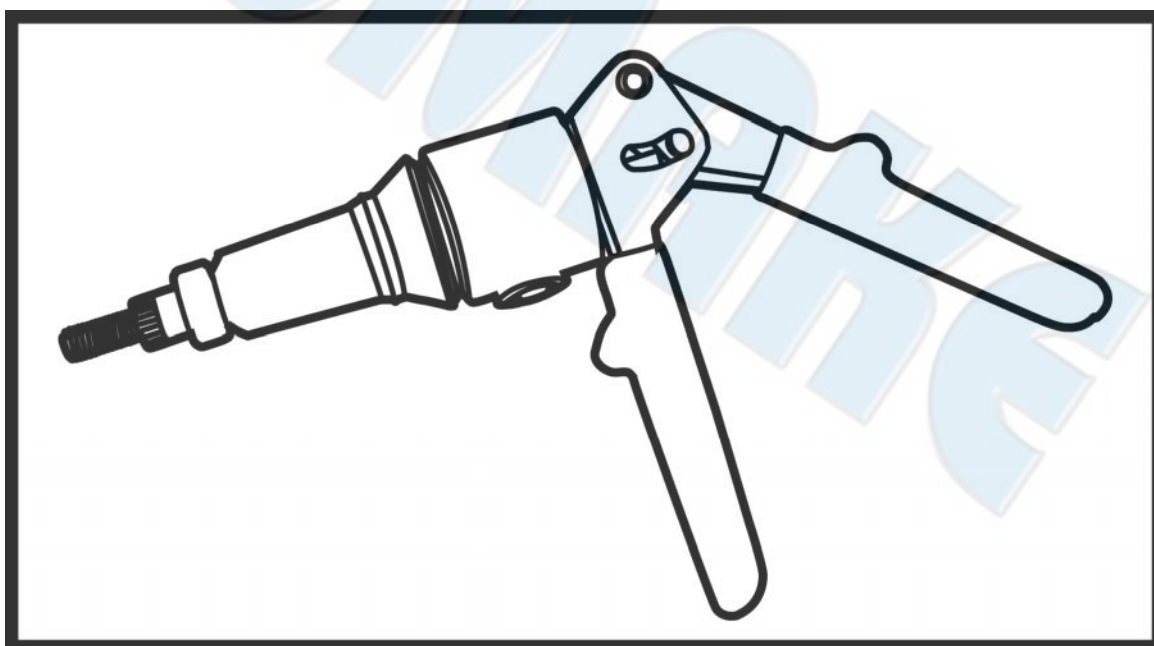
SUMAKE INDUSTRIAL CO., LTD

4F,NO.351,Yanguang St.,Neihu District TAIPEI, TAIWAN, ZIP:114-91

HT-6750-S-1403A-C1F



SUMAKE *PNEUMATIC TOOLS*



Hydraulic Hand Riveting Nut Tool HT-6850M

Specification:

Riveting Capacity	M3, M4, M5, M6, M8
Stroke Length	5/8" (15.8 mm)
Traction Power	3500 lbs (1600 kg)
Net Weight	1.92 lbs (0.87 kg)

Noise and Vibration:

Vibration EN ISO 20643	Noise EN ISO 15744	Remark
No Load: 1.44 m/s ²	Sound Pressure Level No load: 54.58 dB(A)	Please always wear ear protector at environment noise level > 80 dB(A) due to risk of impaired hearing!
	Sound power level No load: 65.58 dB(A)	
Uncertainty K= 1.5 m/s ²	Uncertainty K= 3dB	

SUMAKE INDUSTRIAL CO., LTD

4F,NO.351,Yanguang St.,Neihu District TAIPEI, TAIWAN, ZIP:114-91

HT-6850M-S-1403A-C1F



EC DECLARATION OF CONFORMITY

We: **SUMAKE INDUSTRIAL CO., LTD.**

4F, No. 351, Yangguang St., Neihu District, Taipei City, Taiwan

declare in sole responsibility that the equipment

Equipment : **HYDRAULIC HAND RIVETER**

Model/ Serial No. : **HT-6750**

to which this declaration applies, complies with these normative documents:

- Machinery Directive: 2006/42/EC

and conforms to the following EN standard,

- EN ISO 12100: 2010
- EN ISO 11148-1:2011

Name and Signature/Position

Mike Su – Managing Director

Date and Place

2014/1/24

Taipei, Taiwan

HT-6750-D-1403A-C1F



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We: **SUMAKE INDUSTRIAL CO., LTD.**

4F, No. 351, Yangguang St., Neihu District, Taipei City, Taiwan

declare in sole responsibility that the equipment

Equipment : **HYDRAULIC HAND RIVETING NUT TOOL**

Model/ Serial No. : **HT-6850M**

to which this declaration applies, complies with these normative documents:

- Machinery Directive: 2006/42/EC

and conforms to the following EN standard,

- EN ISO 12100: 2010
- EN ISO 11148-1:2011

Name and Signature/Position

Mike Su – Managing Director

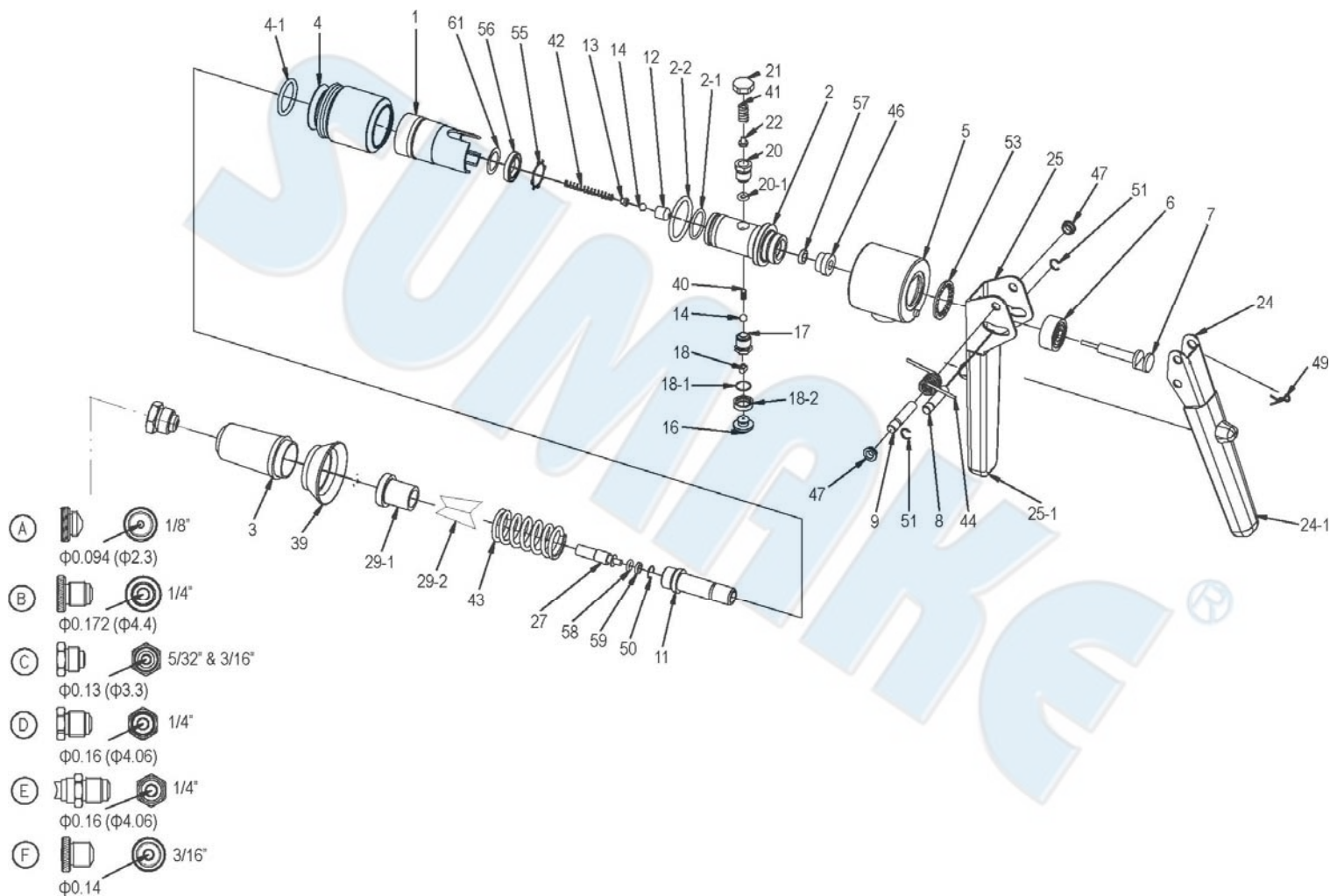
Date and Place

2014/1/24

Taipei, Taiwan

HT-6850M-D-1403A-C1F

HT-6750 HYDRAULIC HAND RIVETER KIT

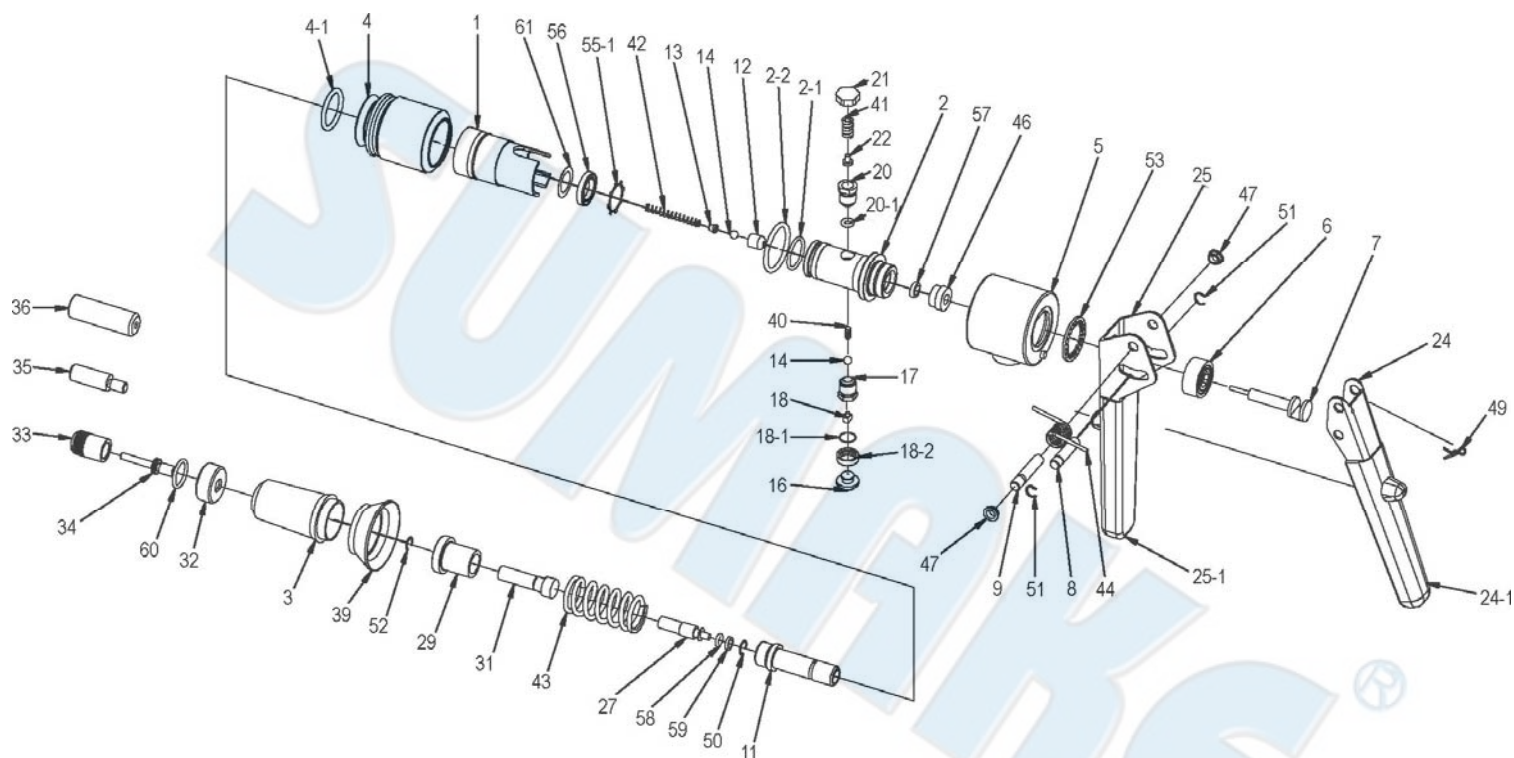


PARTS LIST

No.	Parts No.	Description	Q'ty
1	HT6750-01	Hydraulic Housing	1
2	HT6750-02	Hydraulic Piston	1
2-1	HT6750-02-1	O-Ring	1
2-2	HT6750-02-2	Wear-Ring	1
3	HT6750-03	Front Sleeve	1
4	HT6750-04	Expansion Bellows	1
4-1	HT6750-04-1	O-Ring	1
5	HT6750-05	Encase	1
6	HT6750-06	Connection	1
7	HT6750-07	Tappet	1
8	HT6750-08	Shaft For Tappet	1
9	HT6750-09	Shaft For Leg Spring	1
11	HT6750-11	Slide Piece	1
12	HT6750-12	Valve Seat	1
13	HT6750-13	Spring Guide	1
14	HT6750-14	Ball	2
16	HT6750-16	Trigger	1
17	HT6750-17	Valve Box	1
18	HT6750-18	Ball Thrust Piece	1
18-1	HT6750-18-1	Net	1
18-2	HT6750-18-2	Net Cover	1
20	HT6750-20	Valve Box	1
20-1	HT6750-20-1	O-Ring	1
21	HT6750-21	Valve Cover	1
22	HT6750-22	Spring Guide	1
24	HT6750-24	Lever Left	1
24-1	HT6750-24-1	Lever Left Skin	1
25	HT6750-25	Lever Right	1

25-1	HT6750-25-1	Lever Right Skin	1
27	HT6750-27	Guide Sleeve	1
29-1	HT6750-29-1	Guide	1
29-2	HT6750-29-2	Jaw	3
39	HT6750-39	Cover	1
40	HT6750-40	Pressure Spring	1
41	HT6750-41	Pressure Spring	1
42	HT6750-42	Pressure Spring	1
43	HT6750-43	Pressure Spring	1
44	HT6750-44	Hinge Spring	1
46	HT6750-46	Plain Bearing	1
47	HT6750-47	Plain Bearing	2
49	HT6750-49	R Pin	1
50	HT6750-50	Spring Ring	1
51	HT6750-51	Circlip	2
53	HT6750-53	Tooth Look Washer	1
55	HT6750-55	Tooth Washer	1
56	HT6750-56	Lip Seal	1
57	HT6750-57	Plain Seal	1
58	HT6750-58	O-Ring	1
59	HT6750-59	Backup Ring	1
61	HT6750-61	Washer	1
A	HT6750-A	1/8"(3.2mm) Riveting	1
B	HT6750-B	1/4"(6.4mm) Riveting	1
C	HT6750-C	5/32"(4.0mm) & 3/16"(4.8mm) Riveting	1
D	HT6750-D	1/4"(6.4mm) Riveting	1
E	HT6750-E	1/4"(6.4mm) Riveting	1
F	HT6750-F	3/16"(4.8mm) Riveting	1

HT-6850M HYDRAULIC HAND RIVETING NUT TOOL KIT



PARTS LIST

No.	Parts No.	Description	Q'ty
1	HT6850M-01	Hydraulic Housing	1
2	HT6850M-02	Hydraulic Piston	1
2-1	HT6850M-02-1	O-Ring	1
2-2	HT6850M-02-2	Wear-Ring	1
3	HT6850M-03	Front Sleeve	1
4	HT6850M-04	Expansion Bellows	1
4-1	HT6850M-04-1	O-Ring	1
5	HT6850M-05	Encase	1
6	HT6850M-06	Connection	1
7	HT6850M-07	Tappet	1
8	HT6850M-08	Shaft For Tappet	1
9	HT6850M-09	Shaft For Leg Spring	1
11	HT6850M-11	Slide Piece	1
12	HT6850M-12	Valve Seat	1
13	HT6850M-13	Spring Guide	1
14	HT6850M-14	Ball	2
16	HT6850M-16	Trigger	1
17	HT6850M-17	Valve Box	1
18	HT6850M-18	Ball Thrust Piece	1
18-1	HT6850M-18-1	Net	1
18-2	HT6850M-18-2	Net Cover	1
20	HT6850M-20	Valve Box	1
20-1	HT6850M-20-1	O-Ring	1
21	HT6850M-21	Valve Cover	1
22	HT6850M-22	Spring Guide	1
24	HT6850M-24	Lever Left	1
24-1	HT6850M-24-1	Lever Left Skin	1
25	HT6850M-25	Lever Right	1
25-1	HT6850M-25-1	Lever Right Skin	1
27	HT6850M-27	Guide Sleeve	1
29	HT6850M-29	Guide	1
31	HT6850M-31	Adapter For The Mandrel	1
32	HT6850M-32	Adapter For Nose Piece	1
33	HT6850M-33A	Nose Piece M3	1
	HT6850M-33B	Nose Piece M4	1
	HT6850M-33C	Nose Piece M5	1

33	HT6850M-33D	Nose Piece M6	1
	HT6850M-33E	Nose Piece M8	1
34	HT6850M-34A	Mandrel M3	1
	HT6850M-34B	Mandrel M4	1
	HT6850M-34C	Mandrel M5	1
	HT6850M-34D	Mandrel M6	1
	HT6850M-34E	Mandrel M8	1
35	HT6850M-35B	Mandrel Case M4	1
	HT6850M-35C	Mandrel Case M5	1
	HT6850M-35D	Mandrel Case M6	1
	HT6850M-35E	Mandrel Case M8	1
36	HT6850M-36B	Nose Piece Riv-Bolt M4	1
	HT6850M-36C	Nose Piece Riv-Bolt M5	1
	HT6850M-36D	Nose Piece Riv-Bolt M6	1
	HT6850M-36E	Nose Piece Riv-Bolt M8	1
39	HT6850M-39	Cover	1
40	HT6850M-40	Pressure Spring	1
41	HT6850M-41	Pressure Spring	1
42	HT6850M-42	Pressure Spring	1
43	HT6850M-43	Pressure Spring	1
44	HT6850M-44	Hinge Spring	1
46	HT6850M-46	Plain Bearing	1
47	HT6850M-47	Plain Bearing	2
49	HT6850M-49	R Pin	1
50	HT6850M-50	Spring Ring	1
51	HT6850M-51	Circlip	2
52	HT6850M-52	Circlip	1
53	HT6850M-53	Tooth Look Washer	1
55	HT6850M-55	Oring	1
55-1	HT6850M-55-1	Tooth Washer	1
56	HT6850M-56	Lip Seal	1
57	HT6850M-57	Plain Seal	1
58	HT6850M-58	O-Ring	1
59	HT6850M-59	Backup Ring	1
60	HT6850M-60	Oring	1
61	HT6850M-61	Washer	1

NOTE

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