



## 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)

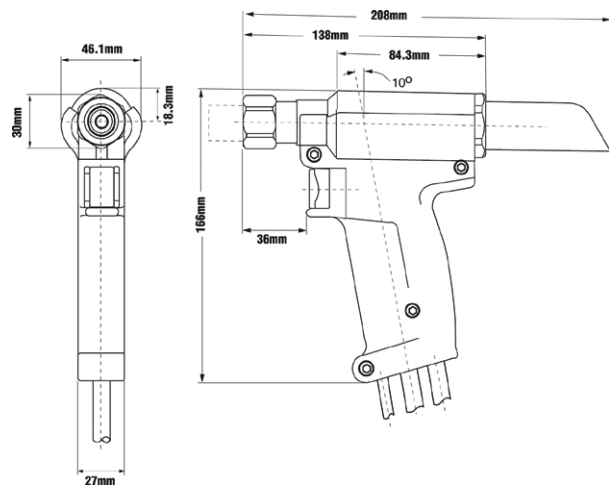
### Scope of delivery

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 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	99-3003	371 680 000
	6.4	99-3006	371 705 000
	8.0		
	9.6		
DeltaBolt® lockbolts	4.8	99-3003	371 680 000
	6.4	99-3006	371 705 000
	8.0		
	9.6		
Multigrip lockbolts	4.8	99-1456	372 985 000
	6.4	99-1477UK	371 980 000
	7.8		
	9.6		
Hucktainer® Plus TIBULB blind rivets	9.5	99-3464	
	4.8	99-3303	371 805 000
	6.4	99-3305	371 815 000
	7.8		
M-LOCK blind rivets	4.8	99-3303	371 805 000
	6.4	99-3305	371 815 000
	9.5		
MAGNA-BULB blind rivets	4.8	99-3303	371 805 000
	6.4	99-3305	371 815 000
	7.8		
BOM blind rivets	4.8	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)

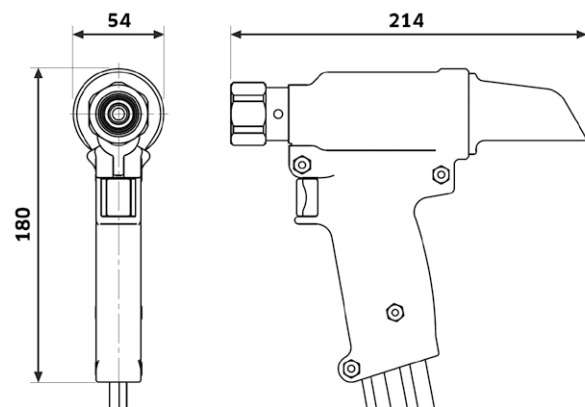
### Scope of delivery

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 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	99-2558	on request
	6.4	99-2564	375 845 000
	8.0	99-99-245	375 885 000
	9.6	99-100-245	375 945 000
DeltaBolt® lockbolts	4.8	99-2558	on request
	6.4	99-2564	375 845 000
	8.0	99-99-245	375 885 000
	9.6	99-100-245	375 945 000
Multigrip lockbolts	4.8	99-1456 <sup>2</sup>	372 985 000
	6.4	99-1477UK <sup>2</sup>	371 980 000
	7.8	99-1439	371 965 000
	9.6	99-1440	371 970 000
Hucktainer® Plus TIBULB blind rivets	9.5	99-3438	on request
	4.8		
	6.4		
M-LOCK blind rivets	7.8		
	4.8		
	6.4		
MAGNA-BULB blind rivets	9.5	99-3318	371 904 000
	4.8		
	6.4		
BOM blind rivets	7.8	99-3307	385 159 000
	4.8	99-1053	on request
	6.4	99-830-1	372 550 000
	7.8	99-769	372 705 000
	9.5	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 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

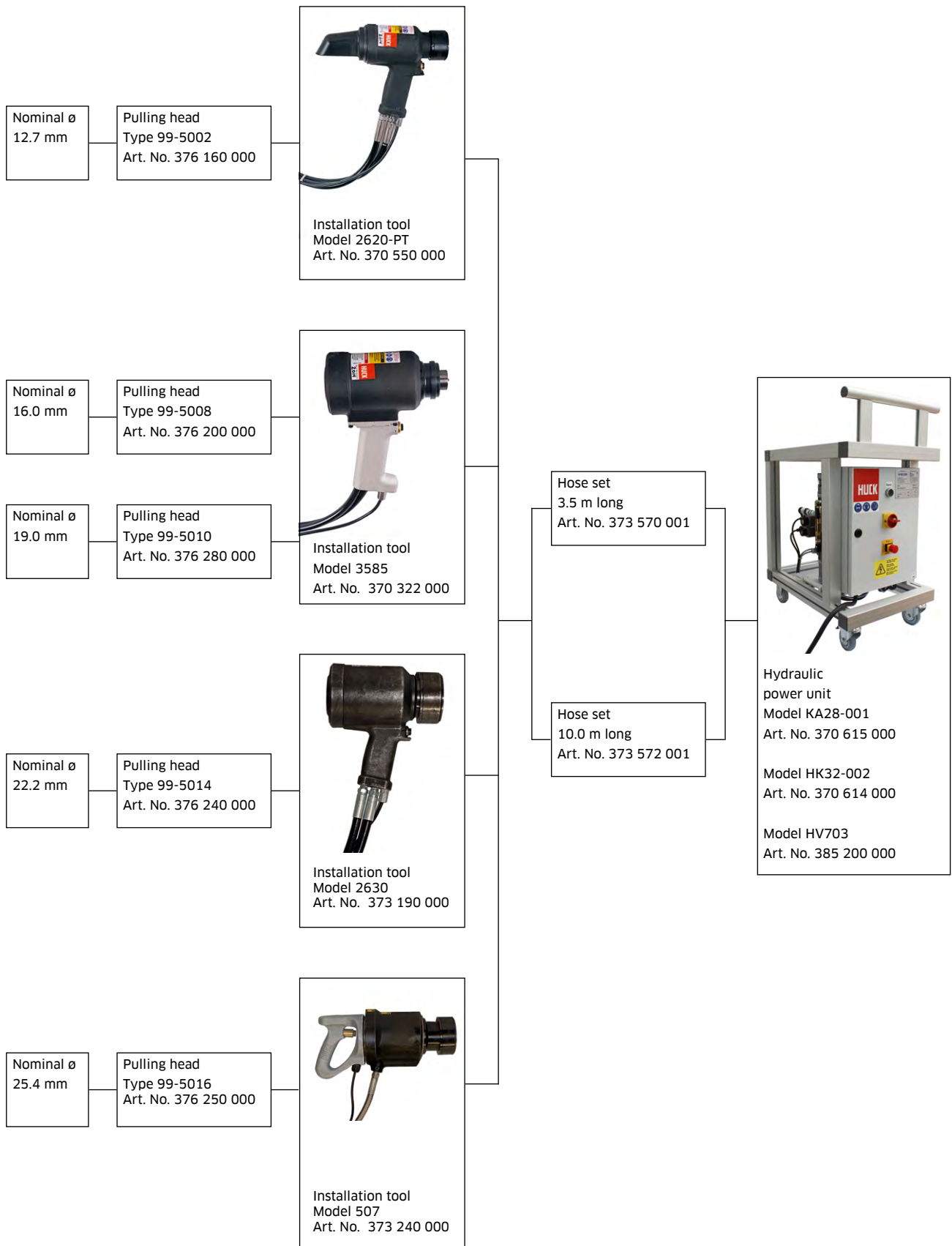
Fastener	TIBULB blind rivet ø [mm]			M-LOCK blind rivet ø [mm]			MAGNA-BULB blind rivet ø [mm]			BOM blind rivet ø [mm]			
	4.8	6.4	7.8	4.8	6.4	9.5	4.8	6.4	7.8	4.8	6.4	7.8	9.5
Aluminium	•	•	•	•	•	•	•	•	•	•	•	•	•
Steel	•	•	•	•	•	•	•	•	•	•	•	•	•
Stainless steel	•	•	•	•	•	•	•	•	•	•	•	•	•

## Pulling heads for HUCK 2583

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

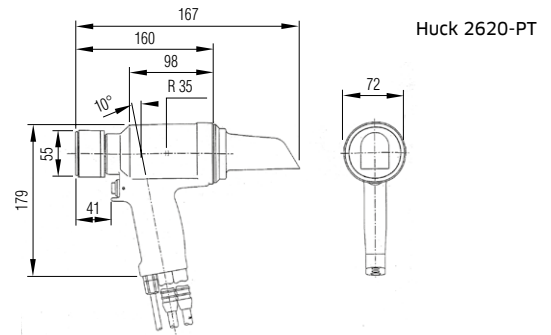


# Technical specifications - hydraulic rivet installation tools for HuckBolt® C50L®

## 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

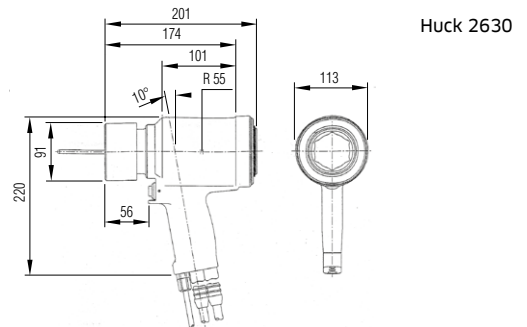
### Technical specifications

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

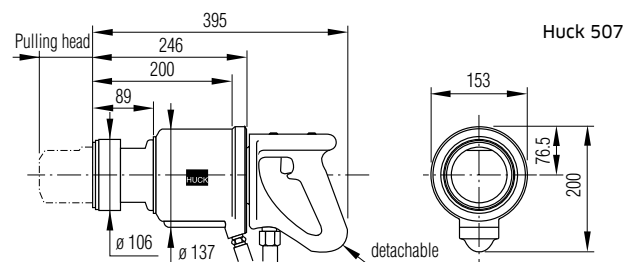
Working range:	ø 22.2 mm
Performance:	216 kN at 448 bar
Stroke:	48.4 mm
Weight without pulling head:	9.8 kg
Article No.	373 190 000



## 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

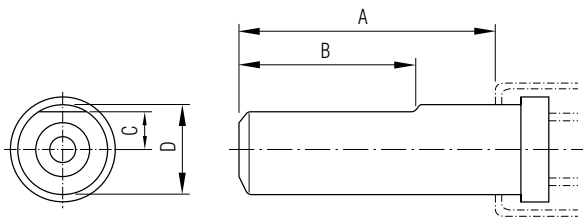
Special versions of installation tools available on request

### Note

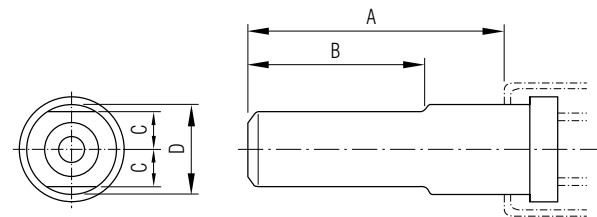
Pulling heads sold separately  
See table for product selection



## Standard/HV pulling heads



One-sided bevel



Double-sided bevel

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

Nominal bolt $\phi$ [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		99-3003 <sup>1</sup>	371 680 000
	254 / 256 / 2503 / 2580	58.0	43.9	8.1	17.8	1-sided	99-2558	on request
6.4	RL 75N / EL18 / 2025LB / 2480	51.0			19.1		99-3006 <sup>1</sup>	371 705 000
	254 / 256 / 2503 / 2580	58.0	43.7	8.7	19.4	1-sided	99-2564	375 845 000
8.0	254 / 256 / 2503 / 2580	71.0	53.4	12.2	27.0	1-sided	99-99-245	375 885 000
9.6	254 / 256 / 2503 / 2580	70.0	53.4	12.2	27.0	1-sided	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 TIFAS® LockBolt HV lockbolt system > 10 mm

Nominal bolt $\phi$ [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	99-5002	376 160 000
15.9	3585	106.0	58.5	22.9	52.6	1-sided	99-5008	376 200 000
19.0	3585	119.0	58.0	24.7	55.5	1-sided	99-5010	376 280 000
22.2	2630	83.0	54.2	30.4	69.9	1-sided	99-5014	376 240 000
25.4	507	100.0	69.9	38.1	82.6	2-sided	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	99-1456 <sup>1,2</sup>	372 985 000
	254 / 256 / 2580						99-3206	on request
	2503 / 2580							
6.4	RL 75N / EL18 / 2025LB / 254 /	54.0	38.9	9.3	19.7	2-sided	99-1477UK <sup>1</sup>	371 980 000
	256 / 2480 / 2580	91.0	47.8	8.9	27.0	2-sided	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		99-3465 <sup>1</sup>	371 730 000
	254 / 256	68.9			27.7		99-3438	on request
	2025LB	59.5			28.2		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 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 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 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

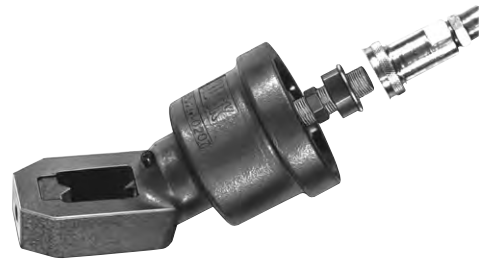
All hydraulic power units supplied without set of hoses.



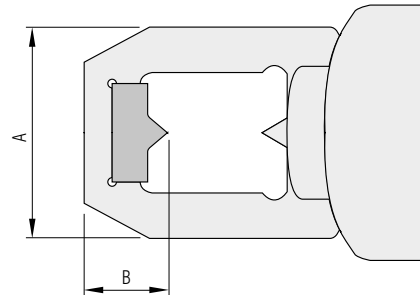
## Hydraulic lockbolt collar cutter

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	516	373 600 000
16.0	49.2	28.6	2.7	520	373 630 000
19.0	57.2	31.8	3.2	524	373 660 000
22.2	63.5	31.8	3.6	528	373 690 000
25.4	66.6	38.1	7.2	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



Tool BTT25, BTT35, BTT57



Tool BTT20SF, BTT25, BTT57



Set of hoses



Hydraulic power unit HK432BT

BobTail™ tools and accessories available on request.