



Huck-Spin 2[®]

The Huck-Spin fastener,
evolved.

Improved production speed
Increased uptime
Prolonged tool life

1/2, 5/8, 3/4",
14mm, 20mm



The Huck-Spin 2®

All the vibration-resistant advantages of Huck-Spin, and much more.



It's a whole new spin on fastening for high-volume OEM applications, heavy-assembly, and aftermarket repair.

Offering the high-performance characteristics of the classic Huck-Spin fastener that you've come to rely on, the Huck-Spin 2® brings even more performance to every job.

Because of its unique engineering and design, the Huck-Spin 2 delivers higher speed of installation than Huck-Spin, saving two to three seconds per installed fastener.

Huck-Spin 2 promotes longer tool life because the thimbles last three to four times longer than original Huck-Spin thimbles in factory environments. And, Huck-Spin 2 means less tool maintenance – the lower hydraulic pressure needed leads to longer lasting seals and hoses.

While the Huck-Spin 2 is a more advanced version, it retains all the benefits of the original Huck-Spin. For instance, it features a low-impact, straight-line installation process, delivering a highly secure joint, each and every time.

Huck-Spin 2 still retains a high clamp load, delivering up to eight times greater fatigue strength than conventional nuts and bolts. In addition, the Huck-Spin 2, like the original Huck-Spin, is designed with no pintail, so you can count on improved factory safety, reduced noise levels, and less impact on your Huck tooling.

Greater productivity. Reduced maintenance. Increased installation speed. Get it all in the Huck-Spin 2.

Benefits of Huck-Spin 2® vs. Huck-Spin®

Increased Production Speed

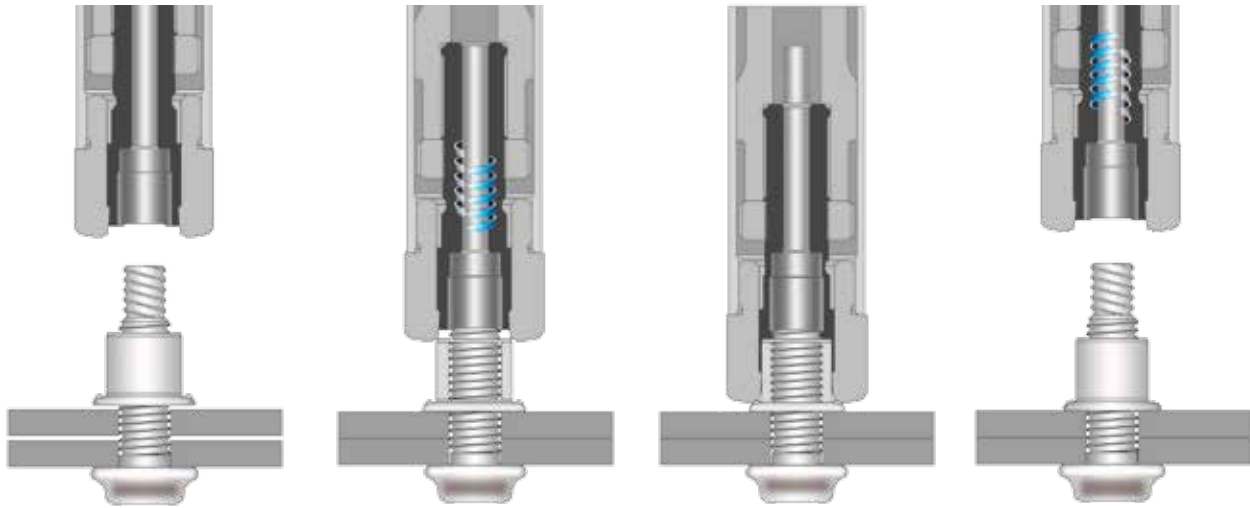
- Easier installation due to reduced diameter pilot point
- Less interference with collar tab during fit-up because of deeper bolt lock groove
- Less likely to have “spinners” due to left-handed pull threads: thimbles can be pushed up-hill onto the puller thread
- Takes less than half of the revolutions to spin-on and spin-off because of double-helix pull grooves
- Save two to three seconds installation time per installed fastener

Prolonged Tool Life

- Huck-Spin 2 thimbles last three to four times longer than Huck-Spin thimbles in factory environments
- Huck-Spin 2 requires lower hydraulic pressure compared to the Huck-Spin, so seals, hoses and tools last longer

Unmatched speed of installation

The Huck-Spin 2® System delivers a lightening-quick installation cycle time for greater productivity – as fast as two seconds*. This quick cycle is due, in part, to the short time required to apply the tool to the pin and initiate the installation cycle. Once the operator engages the trigger, the swage and eject sequence is programmed to complete the cycle without any additional worker input.



The bolt is inserted into the hole, and the collar is started onto the bolt thread by hand.

The installation tool spins onto the bolt pull threads, and removes all gap.

The tool continues to push the collar into the swaging anvil, locking the collar onto the bolt threads and developing clamp in the joint.

The tool ejects the collar and spins off of the bolt, completing the installation.

* Based on a typical installation of a 5/8" Grade 8 fastener

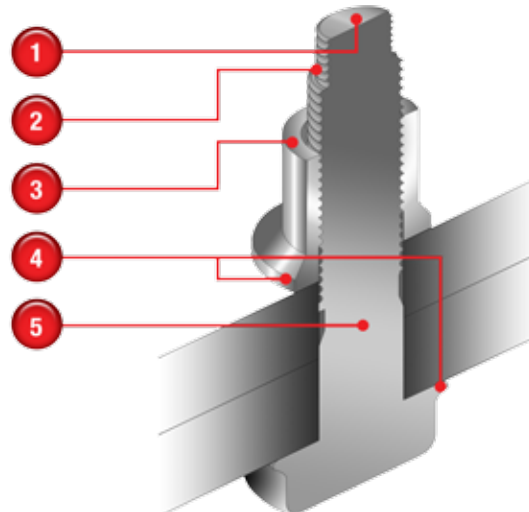
Quick visual inspection



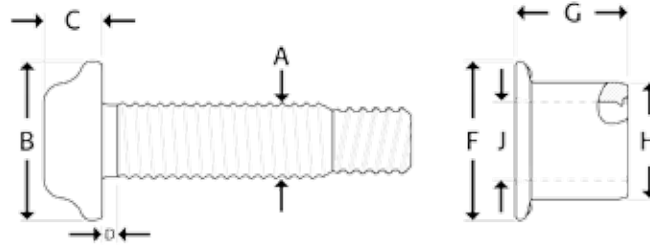
"Dots" on Huck-Spin 2 collar flange indicate a full swage when at least one is crossed by the swage anvil.

Secure, fast installation

1. Pin protrusion allows easy removal with Spincutter™ system
2. High fatigue thread form extends the life of your structure
3. Corrosion resistant coatings can be painted
4. Flanged collar and head spread load to ensure structural integrity
5. Excellent gap pull-out and high retained clamp



Inch Data and Dimensions



Fastener Dimensions

Diameter	A	B	C
1/2"	.500 max	1.010 - 1.080	.360 - .400
5/8"	.625 max	1.270 - 1.330	.448 - .499
3/4"	.750 max	1.520 - 1.600	.550 - .600

Collar Dimensions

Diameter	F	G	H	J
1/2"	1.010 - 1.080	.728 - .748	.762 - .772	.506 - .518
5/8"	1.270 - 1.330	.912 - .932	.953 - .963	.632 - .644
3/4"	1.520 - 1.600	1.095 - 1.115	1.145 - 1.155	.762 - .774

Grip Tables Inch

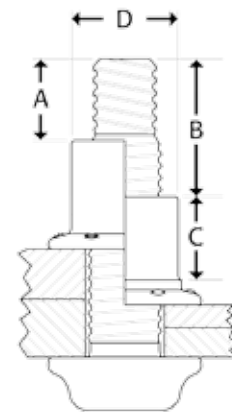
Grip	1/2"		5/8"		3/4"		
	Grip Range	D	E	D	E	D	E
4	.125 - .50	0.18	1.309	0.15	1.52	0.18	1.712
6	.188 - .63	0.18	1.434	0.15	1.65	0.18	-
8	.25 - .75	0.18	1.559	0.15	1.77	0.18	1.962
10	.375 - .88	0.18	1.684	0.15	1.89	0.18	-
12	.50 - 1.00	0.18	1.809	0.15	2.02	0.18	2.212
16	.75 - 1.25	0.18	2.059	0.15	2.15	0.18	2.462
20	1.00 - 1.50	0.18	2.309	0.15	2.27	0.18	2.712
24	1.25 - 1.75	0.18	2.559	0.15	2.52	0.18	2.962
28	1.50 - 2.00	0.18	2.809	0.15	2.77	0.18	3.212
32	1.75 - 2.25	0.18	3.059	0.15	3.02	0.18	3.462
36	2.00 - 2.50	0.18	3.309	0.15	3.27	0.18	3.712
40	2.25 - 2.75	0.18	3.559	0.15	3.52	0.38	3.962
44	2.50 - 3.00	0.18	3.809	0.38	3.77	0.38	4.212
48	2.75 - 3.25	0.38	4.059	0.38	4.02	0.38	4.462
52	3.00 - 3.50	-	-	0.38	4.27	0.38	4.712
56	3.25 - 3.75	-	-	0.38	4.52	0.38	4.962
60	3.50 - 4.00	-	-	0.38	4.77	0.38	5.212
72	4.25 - 4.75	-	-	0.38	5.02	-	-

Installed Fastener Values

Diameter	Clamp	Tensile	Shear
1/2"	15,800	21,300	16,400
5/8"	26,000	36,600	26,000
3/4"	37,200	50,100	38,000

Hole Data

Diameter	Max Hole
1/2"	9/16"
5/8"	11/16"
3/4"	13/16"

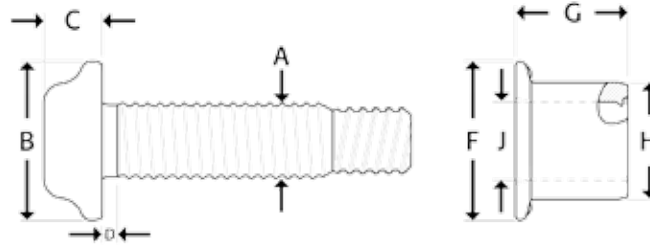


Inspection Data

Diameter	A min	B max	C min	D max
1/2"	.540	1.140	.568	.726
5/8"	.675	1.300	.710	.908
3/4"	.810	1.460	.852	1.090

Should "A" or "B" dimensions exceed the given values, the fastener is out-of-grip.
 A "C" dimension less than the given value indicates an incomplete swage. A "D" dimension greater than the given values indicates an incorrect or worn anvil on the installation tool.

Metric Data and Dimensions



Fastener Dimensions

Diameter	A	B	C
14mm	14.0 max	30.0 max	11.5 max
20mm	20.0 max	42.4 max	16.1 max

Collar Dimensions

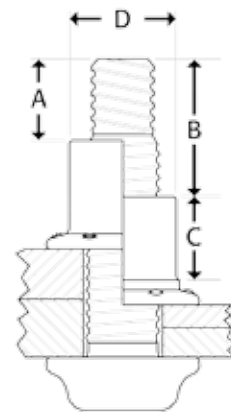
Diameter	F	G	H	J
14mm	28.2 - 29.6	20.5 - 21.0	21.1 - 21.5	14.0 - 14.4
20mm	40.2 - 42.2	29.0 - 29.6	30.2 - 30.6	20.1 - 20.5

Grip Tables Metric

Grip	14mm			20mm		
	Grip Range	D	E	Grip Range	D	E
10	4 - 19	3.8	42.4	4 - 16	4.3	48
15	9 - 24	3.8	47.4	9 - 21	4.3	53
20	14 - 29	3.8	52.4	14 - 26	4.3	58
25	19 - 34	3.8	57.4	19 - 31	4.3	63
30	24 - 39	3.8	62.4	24 - 36	4.3	68
35	29 - 44	3.8	67.4	29 - 41	4.3	73
40	34 - 49	3.8	72.4	34 - 46	4.3	78
45	39 - 54	3.8	77.4	39 - 51	4.3	83
50	44 - 59	3.8	82.4	44 - 56	4.3	88
55	49 - 64	3.8	87.4	49 - 61	4.3	93
60	54 - 69	3.8	92.4	54 - 66	4.3	98
65	59 - 74	9.5	97.4	59 - 71	9.5	103
70	64 - 79	9.5	102.4	64 - 76	9.5	108
75	69 - 84	9.5	107.4	69 - 81	9.5	113
80	-	-	-	74 - 86	9.5	118
110	101 - 119	9.5	142.4	-	-	-

Installed Fastener Values

Diameter	Clamp	Tensile	Shear
14mm	84 kN	120 kN	94kN
20mm	181kN	255kN	182kN



Hole Data

Diameter	Max Hole
14mm	15.5mm
20mm	22mm

Inspection Data

Diameter	A min	B max	C min	D max	
14mm	15.3	33.1	15.8	20.2	Should "A" or "B" dimensions exceed the given values, the fastener is out-of-grip. A "C" dimension less than the given value indicates an incomplete swage. A "D" dimension greater than the given values indicates an incorrect or worn anvil on the installation tool.
20mm	21.9	37.9	22.6	28.8	

Huck-Spin 2 Tooling

Tooling Selection (Inches)

Size	Tool	Nose	Style
1/2"	HS37	99-7362	Installation - Standard
	HS52	99-7356	Installation - Standard (HS37 Dia. Anvil)
		99-7358	Installation - Short
		99-7359	Installation - Long
		99-7363	Installation - Standard
		99-7363CC	Removal
	HSSFT-M12	99-7660	Installation - Standard
	2624HS/3585PT	99-7520	Installation - Standard
99-7520CC		Removal	
5/8"	HS52	99-7365	Installation - Standard
		99-7366	Installation - Short
		99-7367	Installation - Long
		99-7368	Installation - Extra Long
	HSSFT-M16	99-7662	Installation - Standard
		99-7662CC	Removal
		99-7662-5	Installation - Standard
	2624HS/3585PT	99-7521	Installation - Standard
		99-7521CC	Removal
	3/4"	HS52	99-7364
99-7364CC			Removal
2624HS/3585PT		99-7523	Installation - Standard
		99-7523CC	Removal

Tooling Selection (Metric)

Size	Tool	Nose	Style
14mm	HS52	99-7465	Installation - Standard
	HSSFT-M16	99-7762	Installation - Standard
		99-7762-4	Installation - Long
	2624HS/3585PT	99-7531	Installation - Standard
99-7531CC		Removal	
16mm	HSSFT-M16	99-7662	Installation - Standard
		99-7662CC	Removal
		99-7662-5	Installation - Long
	2624HS/3585PT	99-7521	Installation - Standard
		99-7521CC	Removal
20mm	HS52	call for info	Installation - Standard
	2624HS/3585PT	call for info	Installation - Standard
		call for info	Removal



Ordering Information

Follow the form below to construct a part number for ordering Huck-Spin 2 pins and their respective collars. Refer to the Grip Tables (pages 3-4) for grip numbers.

Pins: (TYPE)-(DIAMETER)-(GRIP NUMBER) (FINISH)

Example: HS2P-DT16-10 is a Huck Spin 2, 1/2" Diameter, Grip 10, oil finish

Collars: TYPE-(DIAMETER)-(FINISH)

Example: MBTC-R14BL is a Metric Huck Spin 2 collar, 14mm diameter, zinc plate black chromate finish

Pins

Type	Prefix
Inch	HS2P
Metric	MHS2P

Diameter	Code
1/2"	DT16
5/8"	DT20
3/4"	DT24
14mm	DT14
20mm	DT20

Grip
Refer to the Grip Tables on pages 3-4

Finish	Suffix
Black Chromate	-
Zinc Plate	A

Collars

Diameter	Part Number
1/2"	BTC-R16BL
5/8" (16mm)	MBTC-R16BL
3/4"	BTC-R24BL
14mm	MBTC-R14BL
20mm	MBTC-R20BL



Alcoa Fastening Systems



For more than 120 years, the name Alcoa has been recognized worldwide as a strong leader in product quality and customer support. These strengths are found in every product manufactured for Alcoa Fastening Systems, offering the greatest breadth and depth of fastening system solutions in the industry.

Alcoa Fastening Systems (AFS) maintains company offices in the United States and in many other countries. AFS fastener distributors are also located in many of the world's industrial centers, where they provide a ready source of AFS fasteners, installation tools, tool parts, and application assistance.

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Installation Tool Division
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