



# Magna-Grip<sup>®</sup>

The Original Wide  
Grip Range Fastener

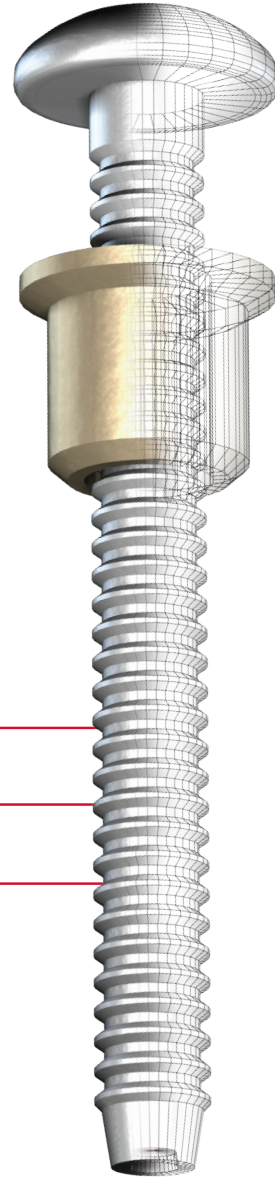


# Huck® Magna-Grip®

## Offering a Wide Grip Range and Uniform Installed Values

In applications where a wide grip range is required and a flush pin break to the collar is beneficial, Huck® Magna-Grip® is the ideal fastener for the job. In fact, Magna-Grip's wide grip range can replace up to 4 traditional HuckBolts.

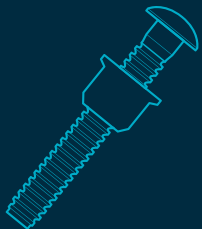
Like all Huck engineered fasteners, Magna-Grip offers the highest level of vibration resistance possible. Magna-Grip installs reliably and consistently provides high, uniform installed values.



**Available Sizes** 3/16", 1/4", 5/16", 3/8"

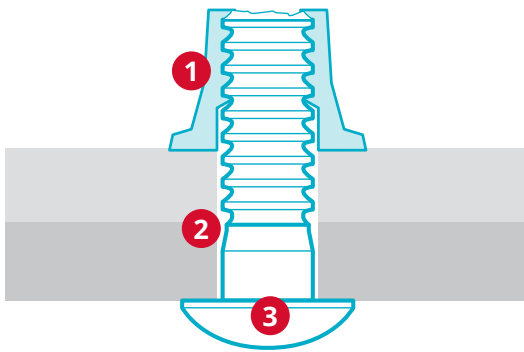
**Materials** Steel, Aluminum

**Headstyles** Button, Truss, Broad Truss, 90° Flush, 98T

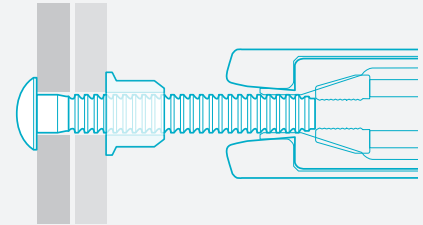


- ✓ Unmatched installation speed
- ✓ Low overall installed cost
- ✓ Vibration resistance
- ✓ Flush-breaking pin
- ✓ Eliminates need for secondary operations
- ✓ No special training or skills required for operators

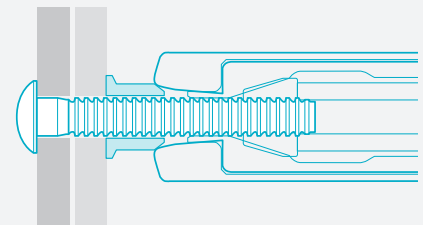
## Secure, Fast Installation



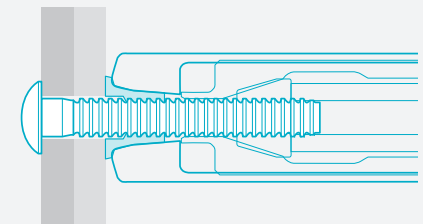
- 1 Flush-breaking, lock-groove design provides a wide grip range to reduce inventory requirements.
- 2 Collar material swaged into the annular pin grooves forms a permanent, vibration-proof connection that promotes increased customer satisfaction and reduced warranty claims.
- 3 Hole preparation isn't critical. Built-in system values yield high, consistent clamp loads and gap removal.



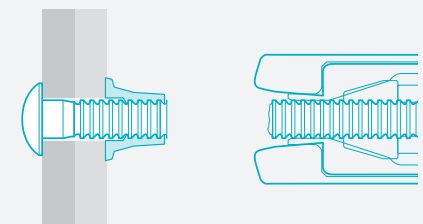
- 1 Insert fastener through a prepared hole. The precision collar is placed over the other end.



- 2 The Huck installation tool is applied and engages the pin. When the tool is activated, it pulls the pin in a straight line while pushing down on the collar.

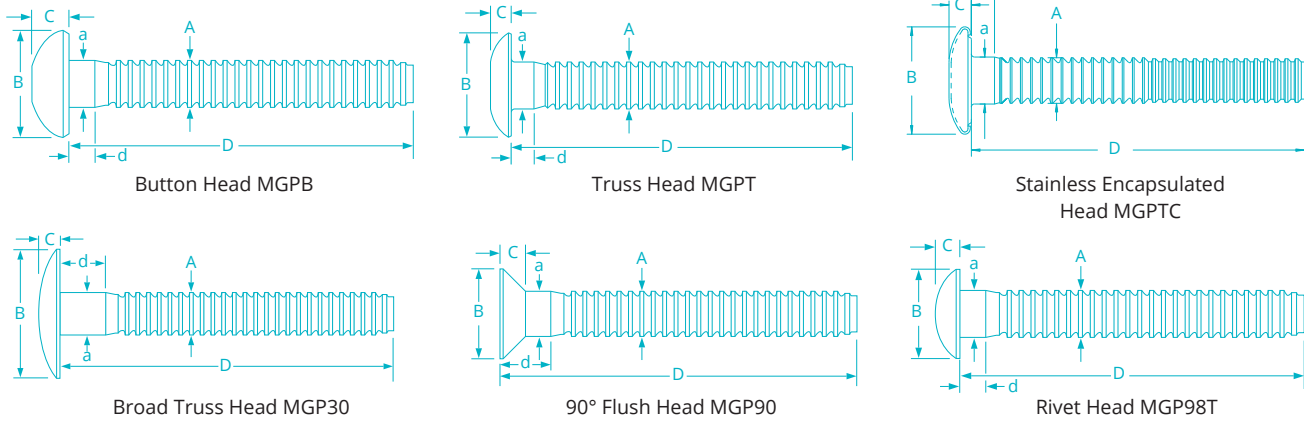


- 3 The tool moves forward over the collar, molding the collar material into the grooves of the pin. This process, called swaging, causes a precise stretching of the pin and collar, developing the fastener's clamping force.



- 4 When swaging is complete the pintail is automatically tensioned off, flush with the end of the collar. The tool then pushes off from the collar. The result is a permanent, mechanically locked fastener.

# Data and Dimensions

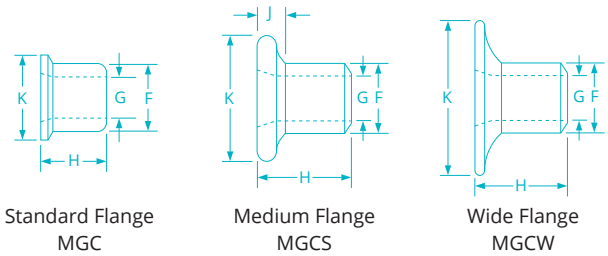


## Magna-Grip Dimensions

DIA.	GRIP NUMBER	GRIP RANGE	HOLE SIZE MAX	A MAX	B	C	D	a MAX	d REF
<b>Button Head</b>									
6 (3/16")	10	.062-.625	0.219	0.186	.360-.390	.111-.127	1.771-1.831	.192	.087
	20	.312-1.250	0.219	0.186	.360-.390	.111-.127	2.353-2.413	.192	.312
8 (1/4")	10	.125-.625	0.281	0.250	.480-.520	.135-.155	1.965-2.040	.259	.125
	20	.312-1.250	0.281	0.250	.480-.520	.135-.155	2.560-2.635	.259	.312
10 (5/16")	12	.125-.750	0.359	0.312	.600-.650	.180-.205	2.340-2.390	.322	.100
	22	.625-1.375	0.359	0.312	.600-.650	.180-.205	2.840-2.890	.322	.550
12 (3/8")	14	.188-.875	0.422	0.375	.720-.780	.220-.250	2.875-2.925	.385	.188
	26	.812-1.625	0.422	0.375	.720-.780	.220-.250	3.500-3.550	.385	.810
<b>Truss Head Dimensions</b>									
8 (1/4")	10	.125-.625	.281	.250	.530-.595	.115-.135	1.965-2.040	.259	.125
	20	.312-1.250	.281	.250	.530-.595	.115-.135	2.560-2.635	.259	.312
10 (5/16")	12	.125-.750	.359	.312	.700-.795	.125-.175	2.340-2.390	.322	.100
	22	.625-1.375	.359	.312	.700-.795	.125-.175	2.840-2.890	.322	.550
12 (3/8")	14	.188-.875	.422	.375	.830-.920	.150-.215	2.875-2.925	.385	.188
	26	.812-1.625	.422	.375	.830-.920	.150-.215	3.500-3.550	.385	.810
<b>Broad Truss Head Dimensions</b>									
8 (1/4")	10	.125-.625	.281	.250	.900-.970	.135-.165	1.965-2.040	.259	.125
	24	.562-1.500	.281	.250	.900-.970	.135-.165	2.810-2.885	.259	.562
12 (3/8")	14	.188-.875	.422	.375	1.175-1.255	.185-.215	2.875-2.925	.385	.188
	24	.688-1.500	.422	.375	1.175-1.255	.185-.215	3.375-3.425	.385	.680
<b>90° Flush Head Dimensions</b>									
6 (3/16")	10	.062-.625	.219	.186	.325-.360	.075-.090	1.771-1.831	.192	-
	20	.312-1.250	.219	.186	.325-.360	.075-.090	2.353-2.413	.192	.312
8 (1/4")	10	.125-.625	.281	.250	.435-.475	.115-.130	1.965-2.040	.259	-
	20	.312-1.250	.281	.250	.435-.475	.115-.130	2.560-2.635	.259	.312
12 (3/8")	14	.250-.875	.422	.375	.650-.715	.175-.195	2.875-2.925	.385	-
	26	.812-1.625	.422	.375	.650-.715	.175-.195	3.500-3.550	.385	.810
<b>Stainless Encapsulated Head Dimensions</b>									
8 (1/4")	10	.125-.625	.281	.250	.620	.165	1.965-2.040	.259	.125
	20	.312-1.250	.281	.250	.620	.165	2.560-2.635	.259	.312
	32	1.062-2.000	.281	.250	.620	.165	3.310-3.385	.259	1.062
10 (5/16")	12	.125-.750	.359	.311	.810	.175	2.340-2.390	.322	.100
12 (3/8")	14	.188-.875	.422	.375	.860	.210	2.875-2.925	.385	.188
	26	.812-1.625	.422	.375	.860	.210	3.500-3.550	.385	.810
	32	1.188-2.000	.422	.375	.860	.210	3.875-3.925	.385	1.185
<b>Rivet Head Dimensions</b>									
6 (3/16")	10	.062-.625	.219	.186	.467-.488	.098-.110	1.771-1.831	.192	.087
	20	.312-1.250	.219	.186	.467-.488	.098-.110	2.353-2.413	.192	.312

### Collar Dimensions

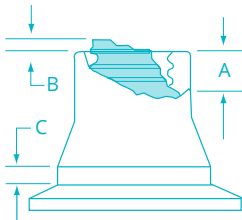
COLLAR	DIA.	F	G	H	K
MGC	3/16"	.305-.315	.188-.204	.267-.283	.360-.390
	1/4"	.395-.405	.250-.260	.365-.385	.485-.515
	5/16"	.500-.510	.310-.320	.430-.450	.605-.645
	3/8"	.600-.612	.375-.385	.495-.515	.735-.765
MGCS	3/16"	.305-.315	.186-.196	.295-.315	.495-.535
	1/4"	.395-.405	.247-.260	.432-.462	.665-.715
MGCW	3/16"	.305-.315	.188-.204	.295-.335	.640-.755
	1/4"	.395-.405	.250-.260	.435-.460	.855-1.005



### Installed Values in Nominal Grip (lbf)

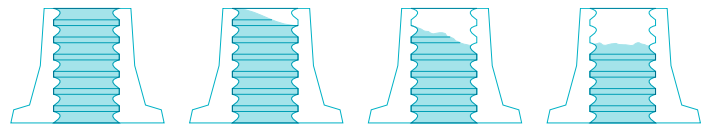
DIA.		ALUMINUM		STEEL	
		MIN.	TYPICAL	MIN.	TYPICAL
3/16"	Shear	750	1000	1725	2000
	Tensile	900	1300	1650	2700
	Clamp	550	800	1025	1500
1/4"	Shear	1200	1600	2200	2700
	Tensile	1620	2500	2950	4000
	Clamp	950	1400	1350	2000

DIA.		ALUMINUM		STEEL	
		MIN.	TYPICAL	MIN.	TYPICAL
5/16"	Shear	2200	2700	3000	3900
	Tensile	2500	4100	4400	6200
	Clamp	1600	2200	2300	2900
3/8"	Shear	3000	3900	4200	6000
	Tensile	4000	5500	6000	9000
	Clamp	2400	3200	3200	4000

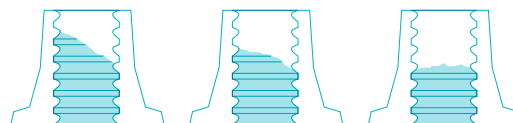


### Inspection Data

DIA.	A MAX	B MAX	C MAX
6 (3/16")	.062	.031	.050
8 (1/4")	.125	.093	.100
10 (5/16")	.187	.140	.100
12 (3/8")	.250	.171	.100



Acceptable Features- Substantially flush with end of collar up to a maximum of two lock witness marks within collar.



Unacceptable Features- Three witness marks within collar.

# Ordering Information

Follow the tables below to construct part numbers for ordering Magna-Grip pins and collars. Refer to the Grip Data chart for grip numbers.

## Pins

MGP (HEAD STYLE) - (MATERIAL) (DIAMETER) - (GRIP NUMBER) (FINISH)

Example: MGPB-R8-10G is a Magna-Grip fastener, Button Head, Steel, 1/4" Diameter, Grip 10 with a Zinc Finish

HEAD STYLE	PREFIX	MATERIAL	CODE	DIA.	CODE	GRIP NUMBER	FINISH	CODE
Button Head	B	Steel	R	3/16"	6	Please refer to the dimensional data chart.	Zinc	G
Truss Head	T	Aluminum	E	1/4"	8		Zinc Plating with Zinc Phosphate	GP
Broad Truss Head	30			5/16"	10		Zinc Electroplate, Black Dyed Trivalent Chromate	BL
Rivet Head	98T			3/8"	12			
90° Flush Head	90							

## Collars

(FLANGE STYLE) - (MATERIAL) (DIAMETER) (FINISH) (OPTIONS)

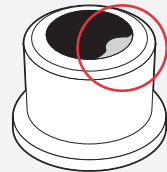
Example: MGCW-R8UL is a wide Flange Magna-Grip Collar, Steel, 1/4" Diameter, Zinc Finish with Tab-Lok

FLANGE STYLE	PREFIX	MATERIAL	CODE	DIA.	CODE	FINISH	GRADE	CODE	OPTIONS	CODE
Standard	MGC	Steel	R	3/16"	6	Zinc Electroplate, Trivalent Chromate	2	G	Tab-Lok	L
Medium	MGCS	Aluminum	F	1/4"	8					
Wide	MGCW			5/16"	10	Zinc Electroplate, Yellow Dyed Trivalent Chromate	2	U		
				3/8"	12					

Additional coating options available.

### Tab-Lok™

The optional Tab-Lok feature makes sure the collar stays on the pin, before installation, in overhead and down slanted pin placements.



# Installation Tooling

## Installation Tools

NOSE ASSEMBLY	SIZE	BATTERY	HYDRAULIC <sup>1</sup>				PNEUDRAULIC	
		TOOL MODEL						
		BV4500-118	2480	2581	2600	256	2025	
3/16"	99-3201	99-3201	99-3206	-	99-3206	99-3201		
1/4"	99-3204	99-3204	99-3207	-	99-3207	99-3204		
5/16"	-	-	99-1439	99-3217	99-1439	-		
3/8"	-	-	99-1440	99-3220	99-1440	-		

<sup>1</sup>Requires a PowerRig to operate. PowerRigs that may be used: 918, 940, 968 and 913H (gas powered).



Model BV4500-118



Model 2480



Model 2581



Model 256



Model 2025

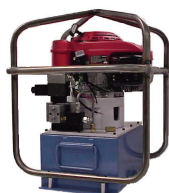
## Tooling Weight and Dimensions

MODEL	TYPE	WEIGHT	LENGTH	HEIGHT	WIDTH
BV4500-118	Battery	5 lbs	14.25"	10.63"	3.75"
2480	hydraulic	2.2 lbs	8.6"	6.5"	1.9"
2581	hydraulic	5.5 lbs	8.4"	7.1"	2.1"
2600	hydraulic	7.3 lbs	9.4"	6.9"	2.65"
256	pneudraulic	11.1 lbs	7.8"	14.9"	6.1"
2025	pneudraulic	5.75 lbs	8.4"	12.5"	4.4"

## Huck POWERIG<sup>®</sup> Hydraulic Units

MODEL 918	MODEL 940	MODEL 913H	MODEL 968 (NOT SHOWN) <sup>2</sup>
High-production applications	Portable; production and repair	Portable; production and repair	Portable; production and repair
Operates up to 2 tools; 2 gpm flow rate	70 in3/min flow rate	139 in3/min flow rate	50 in3/min flow rate
Electrically powered; 220, 440, or 550 volts, 3 phase	Electrically powered; 115 or 220 volts, single phase	Gasoline powered	Compressed Air minimum 50 CPM
Weighs 708 lbs, operational	Weighs 75 lbs	Weighs 175 lbs	Weighs 93 lbs, operational
44"L x 25"W x 30"H	12.5"L x 10.5"W x 18"H	24"L x 21"W x 27"H	10.5"L x 16.3"W x 15.7"H

<sup>2</sup>Requires air-triggered tools



Model 913H



Model 918



Model 940



**HOWMET  
AEROSPACE**

# Howmet Fastening Systems

## Industrial Division Brands



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### North America

#### Waco Operations

PO Box 8117  
8001 Imperial Drive  
Waco, TX 76714-8117  
Tel: +1 800-388-4825  
Fax: +1 800-798-4825  
[sales.waco@howmet.com](mailto:sales.waco@howmet.com)

#### Tracy Operations

1925 North MacArthur Drive  
Tracy, CA 95376  
Tel: +1 800-826-2884  
Fax: +1 800-573-2645  
[sales.idg@howmet.com](mailto:sales.idg@howmet.com)

#### Kingston Operations

1 Corporate Drive  
Kingston, NY 12401  
Tel: +1 800-278-4825  
Fax: +1 845-334-7333  
[sales.kingston@howmet.com](mailto:sales.kingston@howmet.com)

### Global

#### Telford Operations

Unit C, Stafford Park 7  
Telford, Shropshire  
England TF3 3BQ  
Tel: +44 (0) 1952-290011  
Fax: +44 (0) 1952-290459  
[sales.telford@howmet.com](mailto:sales.telford@howmet.com)

#### Melbourne Operations

1508 Centre Road  
Clayton, Victoria  
Australia 3168  
Tel: +613-8545-3333  
Fax: +613-8545-3390  
[sales.melbourne@howmet.com](mailto:sales.melbourne@howmet.com)

#### Tokyo Operations (Japan & Korea)

8F CIRCLES Nihonbashi-  
Bakurocho Bldg  
1-5-12 Nihonbashi-Bakurocho  
103-0002 Tokyo Japan  
Tel: +81-3-5642-8360  
Tel: +81-3-5642-8361 x8365  
Fax: +81-3-5644-5772

#### Suzhou Operations

58 Yinsheng Road,  
SIP Suzhou, Jiangsu  
215126 China  
Tel: +86-512-62863800-8888

[hfsindustrial.com](http://hfsindustrial.com)

[YouTube.com/HFSIndustrial](https://www.youtube.com/HFSIndustrial)

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