Lockbolt Collar Cutter

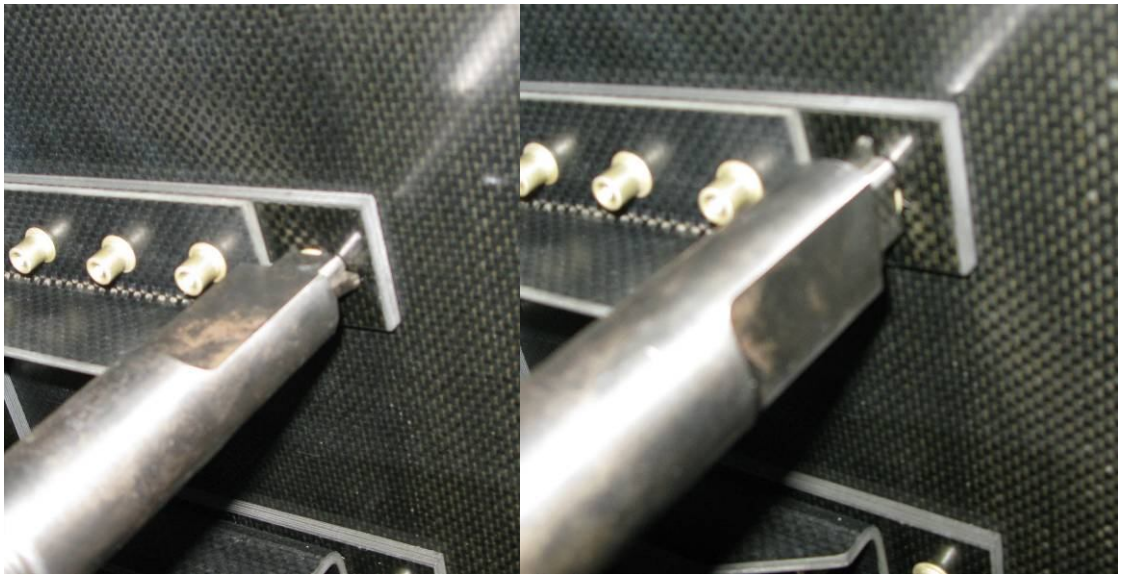
These collar cutters are available in sizes 5/32, 3/16, 1/4, 5/16 & 3/8 and are for use on lockbolt collars.

Tool Order Code: CS-1-X
Replacement Blades: BL-X
(X is the size of collar to be cut)

X Dash Number	Collar Size
-5	5/32
-6	3/16
-8	1/4
-10	5/16
-12	3/8

Tool Use

The tool functions by cutting the collar in two passes, 90 degrees apart to relieve the locking tension of the collar.



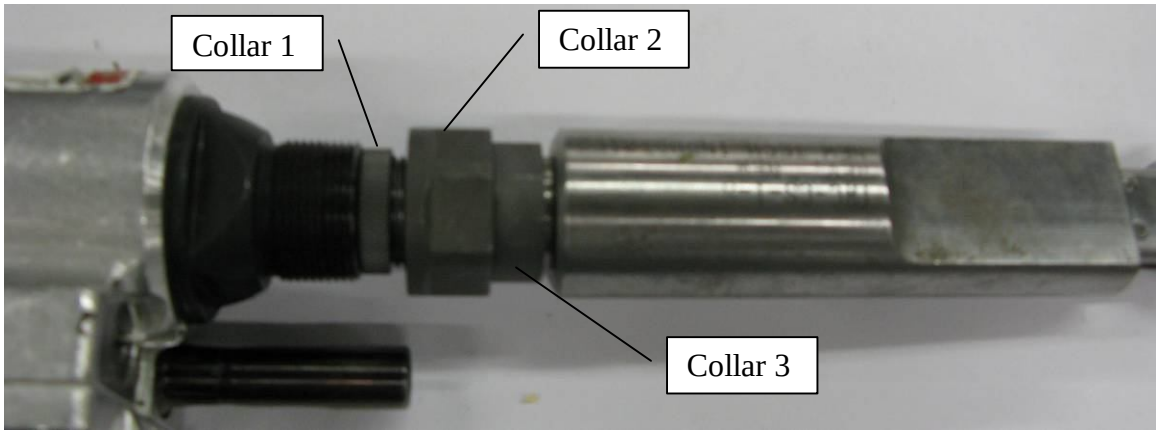
Ensure there is sufficient clearance of the outer body to surrounding parts to prevent damage to structure during the cutting process.

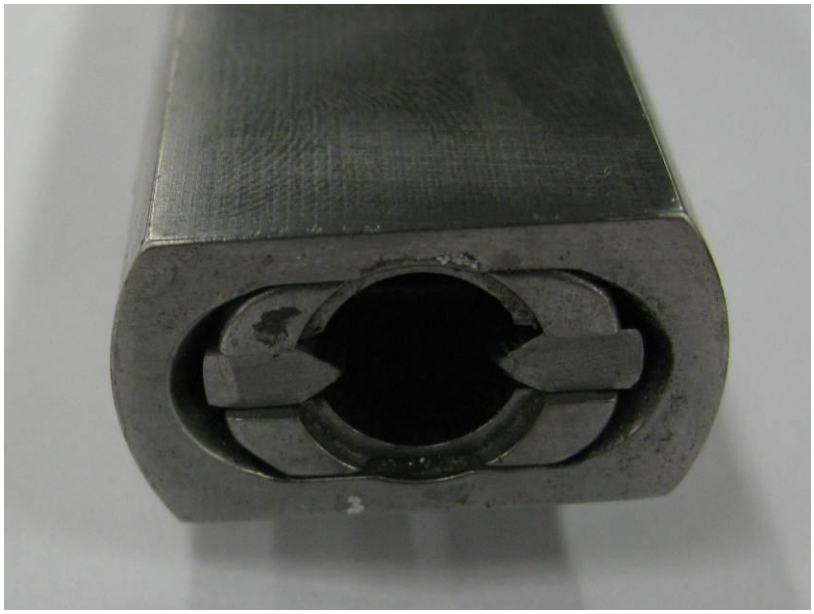
The collar will be cut and broken as shown.

The collar can be removed with standard Hi-lok pliers. Take care not to grip to the collar too tightly with the pliers, as this will potentially make the collar more difficult to remove. Once the collar is broken free with the pliers the collar can typically be unthreaded by hand.

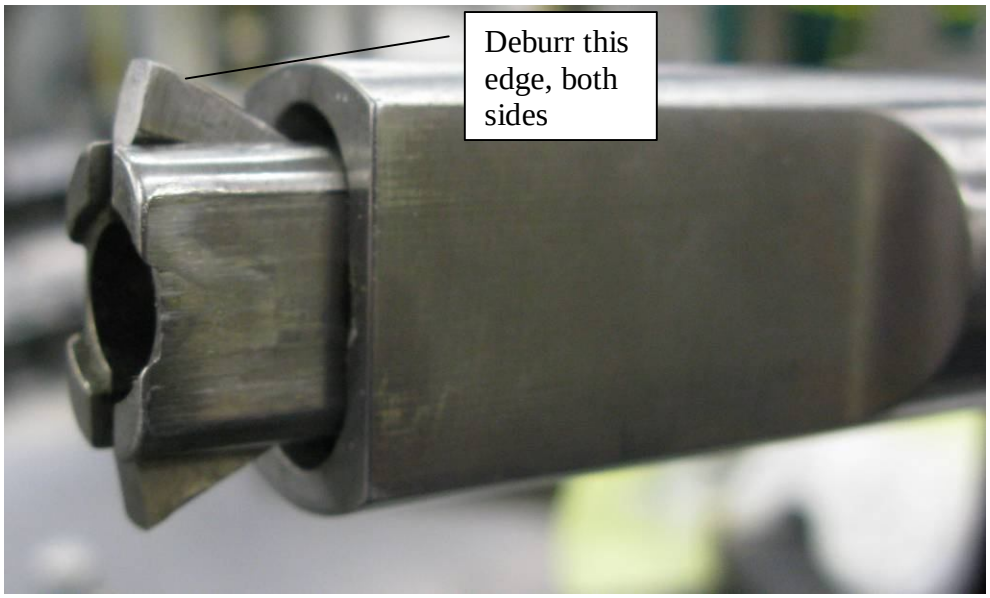
Set Up and Maintenance

The collar cutter will come pre-adjusted from the factory and need only be threaded onto a standard Huck gun to function properly. The collar cutter has three threaded collars. The thin knurled threaded collar (1) on the internal threaded shaft is the stop adjustment for adjusting the depth of cut. The large collar (2) is used to hold the collar cutter to the Huck gun. The round collar with 2 flats (3) is to prevent the collar cutter from rotating and changing the depth of cut when in use. Once the desired depth of cut is achieved collar 3 should be tightened against collar 2.



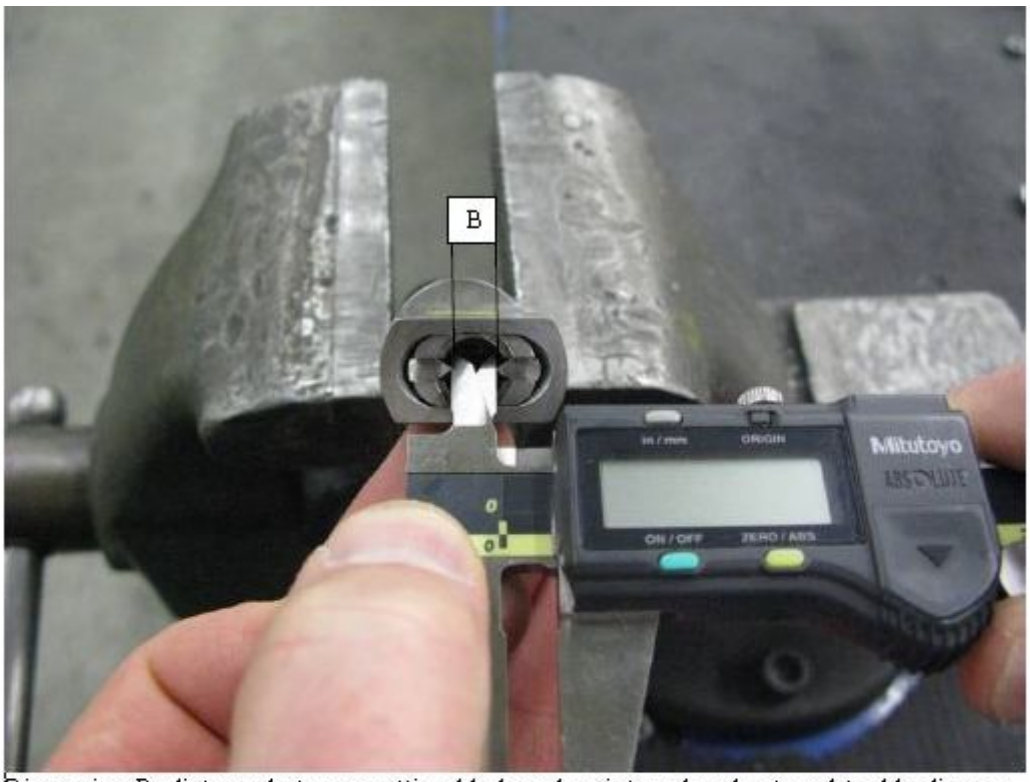


When properly adjusted the cutting jaws should be flush with the external tool body at full depth of cut. Thread the cutter body all the way onto the Huck gun until stop collar 1 is contacting the Huck gun body. Cycle and hold the Huck gun trigger to check for proper depth of cut. Be very careful when adjusting and checking for proper adjustment with the tool connected to an air supply to prevent injury to fingers. Adjust the depth of cut by repositioning stop collar 1 and/or unthreading the cutter body from the Huck gun. When proper adjustment is obtained tighten stop collars 2 and 3.



As the cutting blades wear they may begin to stick in the blade slots. The blades should be deburred on the backside that contacts the outer housing to restore original functionality. The cutting surfaces of the blades should be inspected frequently and replaced when dull. The cutting blades should also be replaced when multiple cuts are required to relieve the tension of the collar, providing the tool is in proper adjustment.

When the tool is set up correctly the backside end of the cutting blade does not contact the external tool body. If the internal tool body is set too deep inside the external tool body wear as depicted in the above picture will occur. The raised material shown in the picture must be removed with a stone or by sanding to prevent damage to the aircraft structure during use. Take care not to remove material near the cutting surface of the blades.



Dimension B, distance between cutting blades when internal and external tool bodies are flush. If dimension B is below the recommended values in the table readjust tool bodies. If dimension B is beyond the recommended values in the table replace the cutting blades. Do not adjust internal body below flush to the external body to achieve proper setting of dimension B except in extreme emergency cases. *Improper setting of this tool can result in damage to the aircraft structure.*

Tool Size	Dimension A +/- 0.005"	Dimension B
3/16 (-6)	0.303"	0.190" – 0.215"
1/4 (-8)	0.272"	0.250" – 0.275"
5/16 (-10)	0.359"	0.312" – 0.337"
3/8 (-12)	0.328"	0.375" – 0.400"