



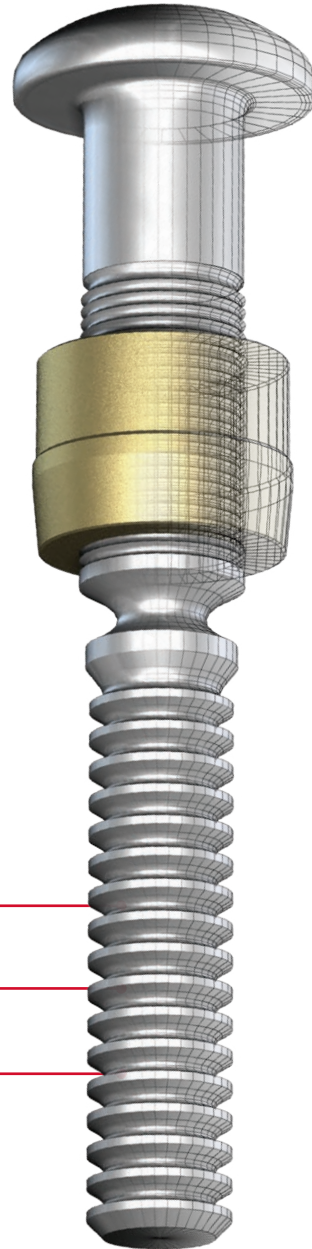
Lockbolts, Structural Blind Fasteners and Tooling



C50L®

The Fastener That Has Defined HuckBolts for More Than 50 years

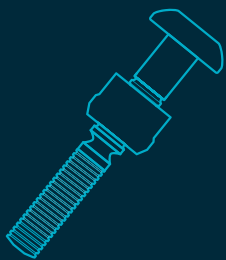
The C50L® offers superior vibration resistance and overall durability for heavy-duty fastening jobs, and is ideal for use within applications where consistent, uniform high clamp force is required. Testing has proven that C50L fasteners meet, or exceed the performance of torqued bolts in both shear and tensile strength, as well as fatigue life. For heavy-duty applications ranging from railcar to mining equipment manufacturing, the C50L delivers superior vibration resistance and overall durability.



Available Sizes 1/2", 5/8", 3/4", 7/8", 1", 1-1/8", 1-3/8"

Materials Steel, Aluminum

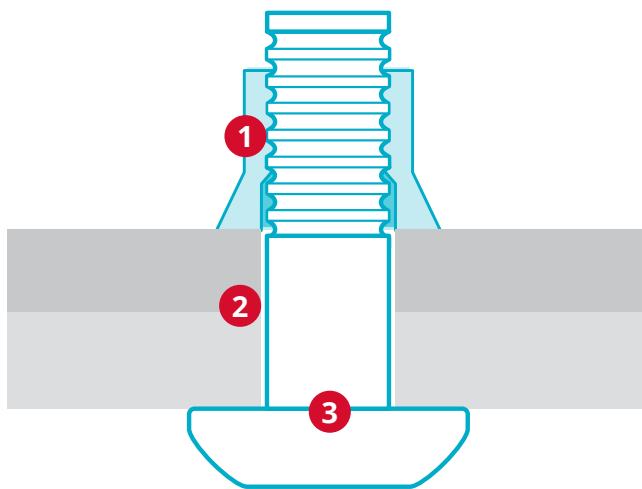
Headstyles Round, Truss, Large Truss, 90° Flush, Thread Head



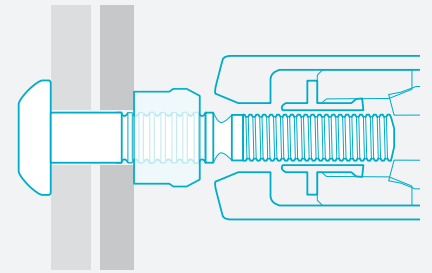
- ✓ Superior vibration resistance
- ✓ Overall durability for heavy-duty applications
- ✓ High shear and tensile strength
- ✓ High fatigue life
- ✓ Consistent, uniform clamp force

Secure, Fast Installation

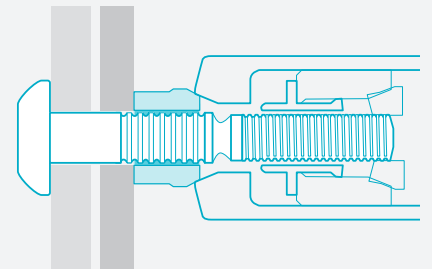
Unlike threaded fasteners, the C50L HuckBolt delivers consistent installation results. High costs of calibrating, maintaining, and replacing tools are eliminated. Also, installation does not require expensive, highly experienced workers.



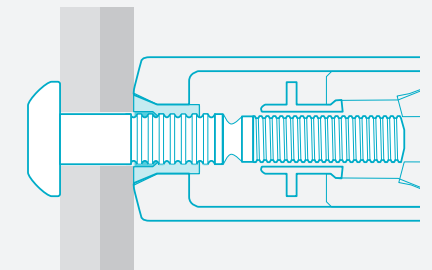
- 1 Swaged-on collar forms a permanent, vibration-proof connection.
- 2 Initial long length of fastener enables pull-out of large gaps.
- 3 Consistent, repeatable pre-load.



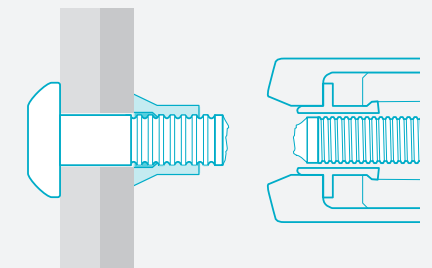
- 1 Insert pin into the prepared hole and the smooth bore collar is placed on the pin.



- 2 The installation tool is applied to the pintail. When the tool is activated, the jaws in the nose assembly pull on the pintail and the nose anvil pushes on the collar to remove any gap.

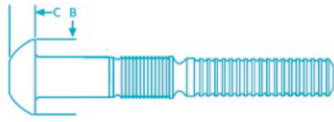


- 3 The nose anvil starts to swage the collar into the lockgrooves on the pin. Continued swaging causes the collar to lengthen and develop clamp.

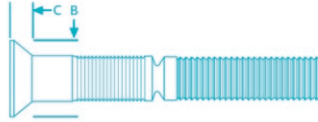


- 4 When swaging of the collar into the lockgrooves is complete, the tool ejects the fastener and releases the puller to complete the sequence.

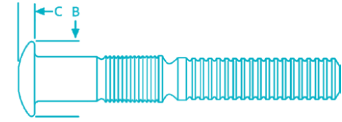
C50L® Data and Dimensions



Round



90 Degree Flush



Truss Head

Steel Pin - Black

DIAMETER	PART NO.	GRIP RANGE**	MAX HOLE SIZE**	[B] HEAD DIA	[C] HEAD HEIGHT	MINIMUM SHEAR (LBF)	MINIMUM CLAMP (LBF)	MINIMUM TENSILE (LBF)
Round Head								
1/2"	C50LR-BR16-4	.250-.500	.563	.870-.940	.310-.320	14400	12050	17050
	C50LR-BR16-8	.500-.750	.563	.870-.940	.310-.320	14400	12050	17050
	C50LR-BR16-12	.750-1.000	.563	.870-.940	.310-.320	14400	12050	17050
	C50LR-BR16-16	1.000-1.250	.563	.870-.940	.310-.320	14400	12050	17050
	C50LR-BR16-20	1.250-1.500	.563	.870-.940	.310-.320	14400	12050	17050
	C50LR-BR16-24	1.500-1.750	.563	.870-.940	.310-.320	14400	12050	17050
	C50LR-BR16-28	1.750-2.000	.563	.870-.940	.310-.320	14400	12050	17050
	C50LR-BR16-32	2.000-2.250	.563	.870-.940	.310-.320	14400	12050	17050
5/8"	C50LR-BR20-4	.250-.500	.688	1.086-1.196	.367-.432	22500	19200	27100
	C50LR-BR20-8	.500-.750	.688	1.086-1.196	.367-.432	22500	19200	27100
	C50LR-BR20-12	.750-1.000	.688	1.086-1.196	.367-.432	22500	19200	27100
	C50LR-BR20-16	1.000-1.250	.688	1.086-1.196	.367-.432	22500	19200	27100
	C50LR-BR20-20	1.250-1.500	.688	1.086-1.196	.367-.432	22500	19200	27100
	C50LR-BR20-24	1.500-1.750	.688	1.086-1.196	.367-.432	22500	19200	27100
3/4"	C50LR-BR24-8	.500-.750	.813	1.328-1.438	.455-.530	32400	28400	40100
	C50LR-BR24-12	.750-1.000	.813	1.328-1.438	.455-.530	32400	28400	40100
	C50LR-BR24-16	1.000-1.250	.813	1.328-1.438	.455-.530	32400	28400	40100
	C50LR-BR24-20	1.250-1.500	.813	1.328-1.438	.455-.530	32400	28400	40100
	C50LR-BR24-24	1.500-1.750	.813	1.328-1.438	.455-.530	32400	28400	40100
	C50LR-BR24-28	1.750-2.000	.813	1.328-1.438	.455-.530	32400	28400	40100
	C50LR-BR24-32	2.000-2.250	.813	1.328-1.438	.455-.530	32400	28400	40100
	C50LR-BR24-36	2.250-2.500	.813	1.328-1.438	.455-.530	32400	28400	40100
7/8"	C50LR-BR28-16	1.000-1.250	.938	1.450-1.660	.530-.580	43400	39250	55450
	C50LR-BR28-20	1.250-1.500	.938	1.450-1.660	.530-.580	43400	39250	55450
	C50LR-BR28-24	1.500-1.750	.938	1.450-1.660	.530-.580	43400	39250	55450
	C50LR-BR28-28	1.750-2.000	.938	1.450-1.660	.530-.580	43400	39250	55450
	C50LR-BR28-32	2.000-2.250	.938	1.450-1.660	.530-.580	43400	39250	55450
	C50LR-BR28-36	2.250-2.500	.938	1.450-1.660	.530-.580	43400	39250	55450
1"	C50LR-BR32-20	1.250-1.500	1.063	1.750-2.000	.590-.650	56500	51500	72700
	C50LR-BR32-24	1.500-1.750	1.063	1.750-2.000	.590-.650	56500	51500	72700
	C50LR-BR32-28	1.750-2.000	1.063	1.750-2.000	.590-.650	56500	51500	72700
	C50LR-BR32-32	2.000-2.250	1.063	1.750-2.000	.590-.650	56500	51500	72700
	C50LR-BR32-36	2.250-2.500	1.063	1.750-2.000	.590-.650	56500	51500	72700
	C50LR-BR32-44	2.750-3.000	1.063	1.750-2.000	.590-.650	56500	51500	72700
	C50LR-BR32-48	3.000-3.250	1.063	1.750-2.000	.590-.650	56500	51500	72700
	C50LR-BR32-52	3.250-3.500	1.063	1.750-2.000	.590-.650	56500	51500	72700
	C50LR-BR32-56	3.500-3.750	1.063	1.750-2.000	.590-.650	56500	51500	72700
	C50LR-BR32-60	3.750-4.000	1.063	1.750-2.000	.590-.650	56500	51500	72700
	C50LR-BR32-64	4.000-4.250	1.063	1.750-2.000	.590-.650	56500	51500	72700
	C50LR-BR32-84	5.250-5.500	1.063	1.750-2.000	.590-.650	56500	51500	72700
C50LR-BR32-88	5.500-5.750	1.063	1.750-2.000	.590-.650	56500	51500	72700	

** Grip and max hole size calculated using LC collar from 1,000 up

NOTE: Part numbers listed reflect typical stock. Additional Head Styles, material, diameter and grips may be available. All parts may be subject to minimum order.

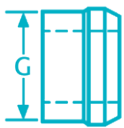
C50L[®] Data and Tooling

Steel Pin - Zinc Plated

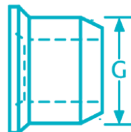
DIAMETER	PART NO.	GRIP RANGE**	MAX HOLE SIZE**	[B] HEAD DIA	[C] HEAD HEIGHT	MINIMUM SHEAR (LBF)	MINIMUM CLAMP (LBF)	MINIMUM TENSILE (LBF)
Round Head								
1/2"	C50LR-BR16-4GA	.250-.500	.563	.870-.940	.310-.320	14400	12050	17050
	C50LR-BR16-8GA	.500-.750	.563	.870-.940	.310-.320	14400	12050	17050
	C50LR-BR16-12GA	.750-1.000	.563	.870-.940	.310-.320	14400	12050	17050
	C50LR-BR16-16GA	1.000-1.250	.563	.870-.940	.310-.320	14400	12050	17050
5/8"	C50LR-BR20-4GA	.250-.500	.688	1.086-1.196	.367-.432	22500	19200	27100
	C50LR-BR20-8GA	.500-.750	.688	1.086-1.196	.367-.432	22500	19200	27100
	C50LR-BR20-12GA	.750-1.000	.688	1.086-1.196	.367-.432	22500	19200	27100
	C50LR-BR20-16GA	1.000-1.250	.688	1.086-1.196	.367-.432	22500	19200	27100
3/4"	C50LR-BR20-20GA	1.250-1.500	.688	1.086-1.196	.367-.432	22500	19200	27100
	C50LR-BR24-12GA	.750-1.000	.813	1.328-1.438	.530-.580	32400	28400	40100
90° Flush Head								
5/8"	C50L90-BR20-12	.750-1.000	.688	1.093-1.183	.284-.300	22500	19200	27100
3/4"	C50L90-BR24-12	.750-1.000	.813	1.312-1.417	.350-.380	32400	28400	40100
	C50L90-BR24-16	1.000-1.250	.813	1.312-1.417	.350-.380	32400	28400	40100
	C50L90-BR24-20	1.250-1.500	.813	1.312-1.417	.350-.380	32400	28400	40100
	C50L90-BR24-24	1.500-1.750	.813	1.312-1.417	.350-.380	32400	28400	40100
	C50L90-BR24-28	1.750-2.000	.813	1.312-1.417	.350-.380	32400	28400	40100
	C50L90-BR24-32	2.000-2.250	.813	1.312-1.417	.350-.380	32400	28400	40100
80° Flush Head								
3/4"	C50L80-BR24-16	1.000-1.250	.813	1.101-1.125	.337-.357	32400	28400	40100

** Grip and max hole size calculated using LC collar from 1,000 up

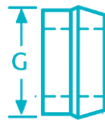
Collars



Standard



Flanged



Low Profile

Steel, Zinc Plated

DIAMETER	PART NO.	WIDTH (G)
Standard, Non-Flanged		
1/2"	LC-2R16G	.765-.800
5/8"	LC-2R20G	.970-.990
3/4"	LC-2R24G	1.165-1.180
7/8"	LC-2R28G	1.355-1.375
1"	LC-2R32G	1.535-1.575
1-1/8"	LC-2R36G	1.750-1.770
Flanged		
1/2"	3LC-2R16G	.969-1.031
5/8"	3LC-2R20G	.980-1.000
5/8" with tab	3LC-2R20GANL	.980-1.000
3/4"	3LC-2R24G	1.170-1.195
7/8"	3LC-2R28G	1.360-1.370
1"	3LC-2R32G	1.550-1.575
Low Profile		
5/8"	8LC-2R20GA	.972-.982
7/8"	8LC-2R28G	1.360-1.375

Installation Tooling

DIAMETER	INSTALLATION TOOL	NOSE ASSEMBLY	TYPE
1/2"	2620	99-5000	Hydraulic
	2620-PT	99-5002	Hydraulic
5/8"	2624	99-5008	Hydraulic
	3585	99-5008	Hydraulic
3/4"	3585	99-5010	Hydraulic
7/8"	2630	99-5014	Hydraulic
1"	507	99-5016	Hydraulic
1-1/8"	507	99-5019	Hydraulic
1-3/8"	12142	Integral	Hydraulic

