

## Magna-Lok® Blind Fastener

A blind high strength fastener with the unique "Huck Solid Circle Locking System". High resistance to vibration and loosening available in diameters 3/16" and 1/4" with a range of head styles to suit. This product is T.I.R. approved.

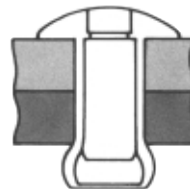
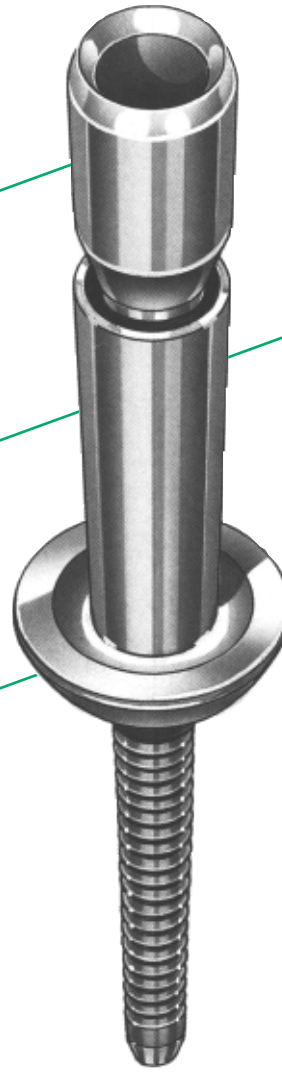
**Solid Circle Lock Design**  
Ensures high strength joint is positively locked against vibration every time.

**Watertight**  
No moisture penetration into workpiece. Better life of your product.

**Fast And Easy To Install**  
Easily placed from one side of workpiece. Takes 1.1/2 seconds to install, no skilled labour required.

**Versatility**  
Choice of materials, wide grip range (1.63 to 15.8mm) and head styles to choose from.

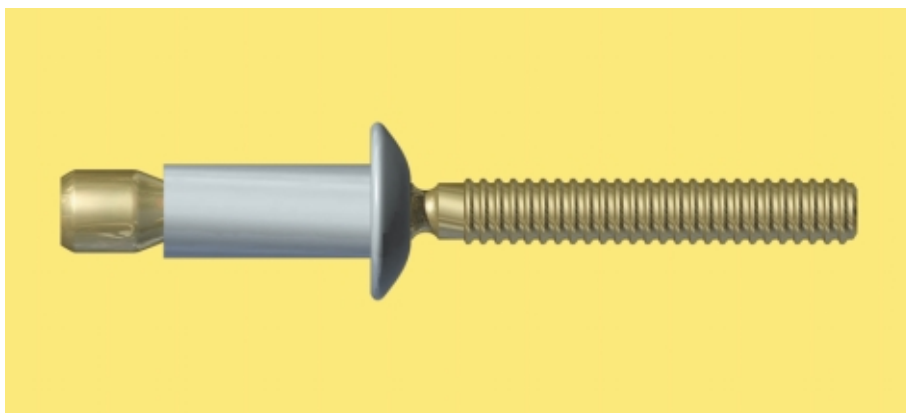
**Quick And Easy Inspection**  
No need for torque gauges or x-ray equipment. A simple visual check is all that is required.



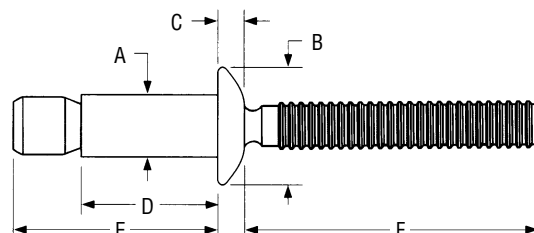
### APPLICATIONS

- Commercial vehicle body building ■ buses ■ trains
- automotive ■ sheet metal fabrication ■ containers
- electrical cabinets and anything that needs more than just a rivet

# Magna-Lok® Blind Fastener

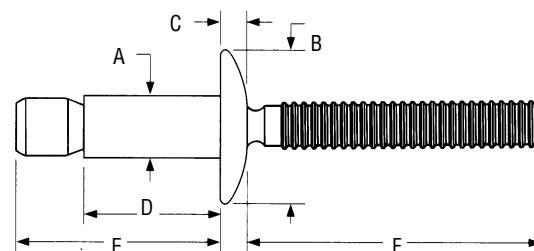


## Fastener Specifications and Grip Data



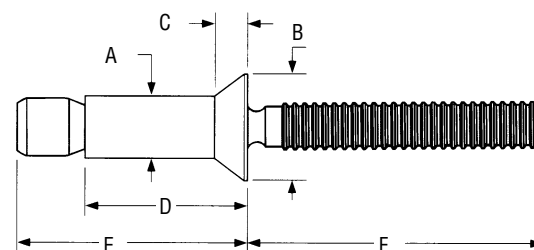
### Protruding Head

Dia.	Steel	Aluminium	Stainless	Grip Range	Hole Size	A	B	C	D	E	F
4.8mm (3/16")	MGLP-R6-4	MGLP-B6-4	MGLP-U6-4	1.57 - 6.86	4.85 - 5.11	4.78	9.78	2.16	10.54	17.15	25.40
	MGLP-R6-7	MGLP-B6-7	MGLP-U6-7	5.44 - 11.10	4.85 - 5.11	4.78	9.78	2.16	14.53	20.96	25.40
	MGLP-R6-E	MGLP-B6-E		1.57 - 11.10	4.85 - 5.11	4.78	9.78	2.16	14.53	24.13	25.40
6.4mm (1/4")	MGLP-R8-6	MGLP-B8-6	MGLP-U8-6	2.03 - 9.53	6.63 - 6.91	6.43	13.34	2.97	14.22	24.64	25.40
	MGLP-R8-10	MGLP-B8-10	MGLP-U8-10	8.89 - 15.88	6.63 - 6.91	6.43	13.34	2.97	20.57	30.99	25.40
	MGLP-R8-E	MGLP-B8-E		2.03 - 15.88	6.63 - 6.91	6.43	13.34	2.97	20.57	35.69	25.40
9.5mm (3/8")	MGLP-R12-12	MGLP-B12-12		3.05 - 14.22	9.96 - 10.36	9.80	19.99	4.45	21.34	41.91	39.24



### Truss Head

Dia.	Steel	Aluminium	Grip Range	Hole Size	A	B	C	D	E	F
4.8mm (3/16")	MGLT-R6-4	MGLT-B6-4	1.57 - 6.86	4.85 - 5.11	4.75	12.70	2.16	10.54	17.15	25.40
	MGLT-R6-7*	MGLT-B6-7*	5.44 - 11.10	4.85 - 5.11	4.75	12.70	2.16	14.53	20.96	25.40
	MGLT-R6-E	MGLT-B6-E*	1.57 - 11.10	4.85 - 5.11	4.75	12.70	2.16	14.53	24.13	25.40
6.4mm (1/4")	MGLT-R8-6*	MGLT-B8-6*	2.03 - 9.53	6.63 - 6.91	6.43	14.94	2.97	14.22	24.64	25.40
	MGLT-R8-10*	MGLT-B8-10*	8.89 - 15.88	6.63 - 6.91	6.43	14.94	2.97	20.57	30.99	25.40
	MGLT-R8-E*	MGLT-B8-E*	2.03 - 15.88	6.63 - 6.91	6.43	14.94	2.97	20.57	35.69	25.40



### 100° Countersunk Head

Dia.	Steel	Aluminium	Stainless	Grip Range	Hole Size	A	B	C	D	E	F
4.8mm (3/16")	MGL100-R6-6	MGL100-B6-6	MGL100-U6-6*	3.18 - 8.41	4.85 - 5.11	4.78	8.76	1.78	12.34	19.35	25.40
	MGL100-R6-9	MGL100-B6-9	MGL100-U6-9*	7.75 - 12.70	4.85 - 5.11	4.78	8.76	1.78	16.59	23.60	25.40
6.4mm (1/4")	MGL100-R8-8	MGL100-B8-8	MGL100-U8-8*	4.06 - 12.07	6.63 - 6.91	6.53	10.29	2.01	16.76	26.90	25.40
	MGL100-R8-12	MGL100-B8-12	MGL100-U8-12*	10.54 - 18.42	6.63 - 6.91	6.53	10.29	2.01	23.11	33.25	25.40

\*Consult factory for availability. Note: Add a "U" prefix for parts that are compatible with Monobolt, tooling and nose assemblies (eg. UMGLP-R8-6).

## Typical Installed Values in Nominal Grip (N)

Material	Diameter	Shear	Tensile	Pin Retention
Steel	4.8 (3/16")	5783	4448	667
	6.4 (1/4")	11121	8229	1334
	9.5 (3/8")	26689	17793	2669
Aluminium	4.8 (3/16")	2669	2224	334
	6.4 (1/4")	5783	3959	445
	9.5 (3/8")	13122	8452	1112
Stainless	4.8 (3/16")	5783	4226	445
	6.4 (1/4")	10453	8006	890

## Materials and Finishes

Material	Sleeve	Pin	Sleeve Finish	Pin Finish
Steel	Low	Medium	Zinc Plated	Zinc Plated
	Carbon Steel	Carbon Steel	Clear Chromate	Gold Chromate
Aluminium	5056	7075	Clear Chromate	Gold Chromate
Stainless	302	305/304	Passivated	Dry Lubricated

## How to Order

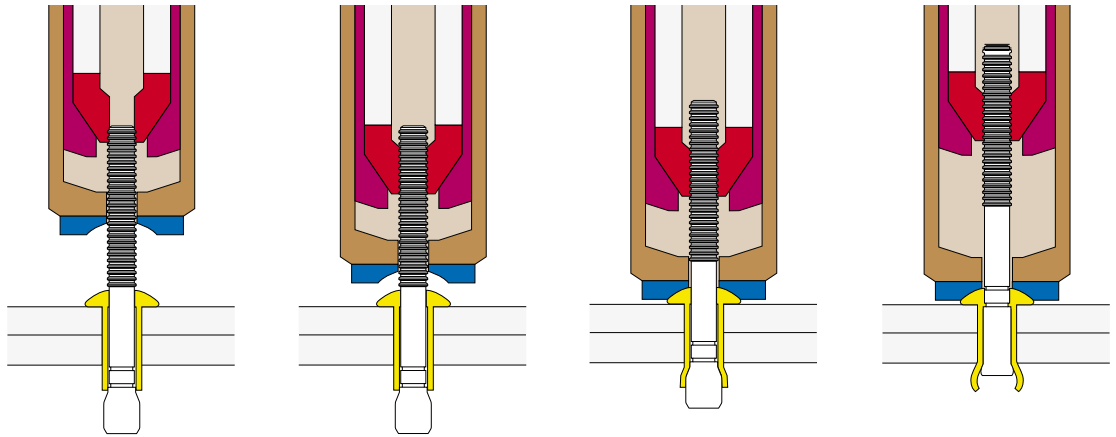
Follow the form below to construct a part number for ordering Magna-Lok blind fasteners. Refer to the Grip Data chart for grip numbers.

### MGL (STYLE) - (MATERIAL) (DIAMETER) - (GRIP NUMBER)

Example: **MGLP-R6-4** is a Magna-Lok blind fastener, Protruding Head, Steel, 4.8mm (3/16") Diameter, Grip 4

Style	Material	Diameter	Grip
Protruding Head	<b>P</b> Steel	<b>R</b> 4.8 (3/16")	<b>6</b>
Truss Head	<b>T</b> Aluminium	<b>B</b> 6.4 (1/4")	<b>8</b>
100° Countersunk Head	<b>100</b> Stainless Steel	<b>U</b> 9.5 (3/8")	<b>12</b>

## Installation Sequence



[Click Here to view animation of installation sequence](#)

## Magna-Lok® Installation Tooling

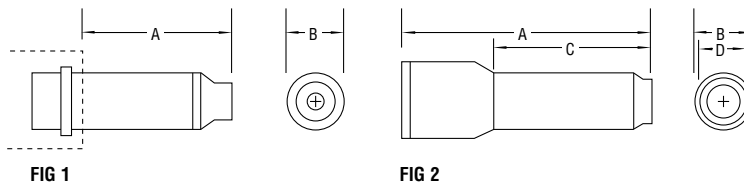
### Huck Installation Tools

Huck installation tools consist of a nose assembly and a tool. The choice of tool and nose assembly is determined by the fastener diameter and application.

Tools and nose assemblies are easily changed as installation requirements demand. Huck offers pneumatic and hydraulic installation tools.

Pneumatic tools operate on 6.2-6.9 bar (90-100 psi) air pressure.

The lighter weight hydraulic tools operate on hydraulic power supplied by a Huck POWERIG® Hydraulic Unit.



Code	Diameter	Nose Ass.	Fig.	A mm	B mm	C mm	D mm	Pneumatic Tooling	Hydraulic Tooling
6	4.8 mm (3/16")	99-3300	1	49.3	19.1	-	-	2025 / 2025V / LH-224	2480
		<b>99-3303</b>	1	55.9	19.1	-	-	2025 / 2025V / LH-224	2480
		<b>99-3303L</b>	1	55.9	19.1	-	-	<b>2025L</b>	<b>2480L</b>
		99-3304	1	157.5	19.1	-	-	2025 / 2025V / LH-224	2480
		Nose Assembly integral with Tool							<b>241E</b>
8	6.4 mm (1/4")	99-3301	1	49.3	19.1	-	-	2025 / 2025V / LH-224	2480
		<b>99-3305</b>	1	50.1	19.1	-	-	2025 / 2025V / LH-224	2480
		<b>99-3305L</b>	1	50.1	19.1	-	-	<b>2025L</b>	<b>2480L</b>
		99-3306	1	157.5	19.1	-	-	2025 / 2025V / LH-224	2480
		Nose Assembly integral with Tool							<b>241E</b>
12	9.5 mm (3/8")	<b>99-3318</b>	1	47.6	26.9	-	-	245 / 246 / 255 / 256	<b>2503</b>

Items in **bold** are part of our FOCUS Tooling Range

Note: Other tool and nose assembly combinations may be available for specific applications. Please contact Huck for details.