

# Rivet Nut Tools & Kits



## Rivet Nut Setter™ RN-1/M39300

Capable of installing all sizes of rivet nuts and threaded inserts up to 1/4-20 and 6mm threads in steel, the next-generation Rivet Nut Setter features a quick-change mandrel and longer handles for improved leverage and an adjustable stroke, positive-stop locking feature. Rivet Nut Setter is ergonomically designed, with a forged, heat-treated steel upper handle, precision die-cast body of high-strength aluminum alloy, patented fulcrum pin design, and comfortable hand grips. Supplied with 8-32, 10-24 and 10-32 mandrels and nosepieces. Available in a variety of kit forms. Weight: 1.2 lbs.



## Rivet Nut Kit/M39301

Model M39301 Rivet Nut Kit contains the M39300 Rivet Nut tool in a molded plastic case; mandrels and nosepieces for 6-32, 8-32, 10-24 and 1/4-20, instructions and wrench. The kit also includes 103 assorted Klik Rivet Nuts and Klik Poly-Nuts: 25 each M57210, M57425, M57130; 20 each M57250; 8 each M57445. Weight: 2.75 lbs.

## Poly-Nut Kit/M39302

Model M39302 Poly-Nut Kit contains the M39300 Rivet Nut tool in a molded plastic case with 8-32, 10-32 and 1/4-20 mandrels and nosepieces, wrench and instructions. The kit contains 52 assorted Klik Poly-Nuts: 12 each M57425, M57435, M57445; 16 each M57455. Weight: 3 lbs.

## Metric Poly-Nut Kit/M39303

Model M39303 Metric Poly-Nut Kit contains the M39300 Rivet Nut tool in a molded plastic case with 4mm, 5mm, 6mm and 8mm mandrels and nosepieces, wrench and instructions. The kit contains 75 assorted Klik Poly-Nuts: 25 each M57407, M57409; 15 each M57411; 10 each M57413. Weight: 3.25

## Mandrel/Nosepiece Chart

Thread Size	Mandrel No.	Nosepiece No.	Kit No.
6-32	M39354	M39361	M39380
8-32	M39355	M39362	M39381
10-24	M39356	M39363	M39382
10-32	M39357	M39363	M39383
1/4-20	M39358	M39379	M39384
1/4-28	M39371	M39379	
5/16-18*	M39359	Not Needed	
5/16-24*	M39372	Not Needed	
3/8-16*	M39360	Not Needed	
4mm	M39366	M39374	M39385
5mm	M39367	M39373	M39386
6mm	M39368	M39375	M39387
8mm	M39369	Not Needed	

For tool RN-1 M39300

\*Not recommended for steel rivet nut.

## Ribbed Rivet Nut Kit/M39315

Model M39215 Ribbed Rivet Nut kit contains the M39300 Rivet Nut tool in a molded plastic case; mandrels, nosepieces, wrench & instructions for setting 8-32, 10-24, 10-32 and 1/4-20 Rivet Nuts. The kit also includes 50 assorted Ribbed style Rivet Nuts: 12 each M57320, M57330, M57340; 8 each M57350; 6 each M57354. Weight: 2.75 lbs.

## Metric Ribbed Rivet Nut Kit/M39316

Model M39316 Ribbed Rivet Nut kit contains the M39300 Rivet Nut tool in a molded plastic case with 4mm, 5mm, 6mm and 8mm mandrels and nosepieces, wrench and instructions. The kit also includes 50 assorted Ribbed style Rivet Nuts: 12 each M57360, M57385, M57384; 8 each M57386; 6 each M57387. Weight: 2.75 lbs.

## Steel Klik Thread-sert Kit/M39314

Model M39314 Thread-sert Kit contains the M39300 Rivet Nut tool in a plastic case with 6-32, 8-32, 10-24, 10-32, 1/4-20, 5/16-18 and 3/8-16 mandrels and nosepieces, wrench and instructions. The kit contains 62 assorted Steel Klik Thread-serfs: 10 each M57810, M57820, M57830, M57840, M57850; 6 each M57871, M57881. Weight: 3.25 lbs.

## Aluminum Klik Thread-sert Kit/M39313

Model M39313 Thread-sert Kit contains the M39300 Rivet Nut tool in a molded plastic case with 6-32, 8-32, 10-24, 10-32, 1/4-20, 5/16-18 and 3/8-16 mandrels and nosepieces, wrench and instructions. The kit contains 62 assorted Aluminum Klik Thread-serfs: 10 each M57910, M57920, M57930, M57940, M57950; 6 each M57971, M57981. Weight: 3 lbs.

## Quad Leg Nut Installation Tool (MJN-1/M39042)

New from Marson, the MJN-1 hand-held Quad Leg Nut Installation tool is designed to effortlessly set quad leg nuts and Jack Nuts® in sizes ranging from 6-32 – 1/4-20, and M4 – M6. It works by threading the bolt to the quad leg nut, then dropping the component in the slot of the tool, inserting it into the pre-drilled hole, and squeezing until set. Pressing the release lever releases the tool. Then tightening the exposed bolt completes the installation.

Jack Nut® is a registered trademark of The Black & Decker Corporation.



**NEW**



## 325RN/M34604

Choose the M34604 for installing larger size Rivet Nuts. Model M34604 is a heavy-duty tool that will install 10-24 through 3/8"-16, and 5mm through 10mm threaded inserts in aluminum or steel. Quick-change mandrels, easily adjustable stroke. Supplied with 1/4"-20 mandrel and nosepiece only. Weight: 4.25 lbs.

## 325RNK Kit/M34606

The M34606 / 325RNK kit comes complete with the heavy-duty 325RN Rivet Nut tool, mandrels and nosepieces to set 10-24",10-32", 1/4-20", 5/16-18" and 3/8-16" Rivet-Nuts, and service/adjustment tools all contained within a sturdy carrying case. Optional external thread adapters available.



**NEW**



**NEW**

## 425RN/M34607

Like the 325RN, the 425RN will install the full range of Rivet Nuts. It offers quick-change mandrels, easy adjust stroke, and a fast-action Push/Pull plunger that can be used to spin on and spin off rivet nuts for more speed. Supplied with 1/4-20 mandrel and nosepiece only. Weight 4.5 lbs.

## 425RNK Kit/M34008

The M34008 / 425RNK kit comes complete with the heavy-duty 425RN Rivet Nut tool, mandrels and nosepieces to set 10-24",10-32", 1/4-20", 5/16-18" and 3/8-16" Rivet-Nuts, and service/adjustment tools all contained within a sturdy carrying case. Optional external thread adapters available.



**NEW**

## Mandrel/Nosepiece Chart for M34604 and M34607

Thread Size	Mandrel No.	Nosepiece No.	Mandrel/Nosepiece Combo No.	MET External Thread
10-24	M95635	M95645	M34615	M34635
10-32	M95636	M95645	M34616	M34636
1/4-20	M95637	M95647	M34617	M34637
5/16-18	M95638	M95648	M34618	M34638
3/8-16	M95639	M95649	M34619	—
5mm	M95630	M95640	M34625	M34645
6mm	M95631	M95641	M34626	M34647
8mm	M95632	M95642	M34627	M34648
10mm	M95633	M95643	M34628	—

# Rivet Nut Tools & Kits



## 140-SP/M39223

The 140-SP features Spin/Pull action in a smaller tool. Just hold the Rivet Nut onto the mandrel end and engage. The tool will automatically spin the nut on. Insert the Rivet Nut in the hole and pull the trigger to set the fastener. Then toggle to the bottom trigger and reverse spin the mandrel off. Easy installation in seconds. Comes supplied with inch mandrels and nosepieces 6-32" through 1/4-20" conveniently stored in a durable carry case. Weight 4.9 lbs. Mandrels and nosepieces for 4mm through 6mm can be purchased separately.

## Mandrel Nosepiece Chart for 140-SP/M39223

Thread Size	Mandrel No.	Nosepiece No.
6-32	M88708	M88701
8-32	M88709	M88702
10-24	M88710	M88703
10-32	M88711	M88703
1/4-20	M88712	M88704
4mm	M88651	M88646
5mm	M88652	M88647
6mm	M88653	M88648

## 160-SP/M39225

The new Marson 160-SP Spin/Pull rivet nut setting tool is our most powerful air/hydraulic rivet nut tool yet. Engage the rivet nut onto the mandrel, and the 160-SP automatically threads the fastener on the tool. Pressing and holding the trigger in position will set the rivet nut and reverse itself out automatically, all in one operation.

This advanced tool features an adjustable stroke knob in the base of the tool to fully adjust stroke length to suit any grip range. Included is a swivel air inlet for increased mobility. For added convenience, adjustments and changes are performed outside the tool, with no required tear down to adjust the stroke or change thread sizes.

Comes supplied with either all inch (M39225) or all metric (M39226) mandrels and nosepieces conveniently stored in a durable carry case. Weight 6 lbs.



## Mandrel Nosepiece Chart for 160-SP/M39225

Thread Size	Mandrel No.	Nosepiece No.
6-32	M71345403	M71345396
8-32	M71345404	M71345397
10-24	M71345405	M71345398
10-32	M71345406	M71345398
1/4-20	M71345407	M71345399
5/16-18	M71345408	M71345400
3/8-16	M71345409	M71345401
1/2-13	M71345410	M71345402

## Metric Mandrel Nosepiece Chart for 160-SP/M39226

Thread Size	Mandrel No.	Nosepiece No.
4mm	M71C00277	M713287
5mm	M71C00278	M713288
6mm	M71C00279	M713289
8mm	M71C00514	M713290
10mm	M71C00281	M713291
12mm	M713177	M713292

## Spin/Pull Tool Stroke Adjustment

Follow these easy steps for correct tool stroke adjustment:

1. Measure and write down the overall length of Rivet Nut.
2. Write down the Maximum Grip Range of the Rivet Nut (reference catalog).
3. Subtract Material Thickness from Maximum Grip range.
4. Add the Pull-up Factor from chart at right for your existing thread size.
5. This will give you the correct stroke required to properly set the Rivet Nut.
6. To double check, set a Rivet Nut, measure length and subtract from length of a non-set Rivet Nut (#1). Adjust tool stroke accordingly.

Example: M57150 (1/4-20) Rivet Nut  
 Max Grip of Rivet Nut: (.080)  
 Subtract Material Thickness: - (.060)  
 Difference: (.020)  
 Add Pull-up Factor for 1/4": + (.095)  
 Equals required tool stroke: = (.115)

*Refer to page 39 for fractional breakdown of decimal.*

## Pull-up Factor Chart per Thread Size

Inch	Metric
4 - .055	M3 - .055
6 - .065	M4 - .075
8 - .065	M5 - .095
10 - .080	M6 - .115
1/4 - .095	M7 - .115
5/16 - .120	M8 - .125
3/8 - .155	M10 - .155
1/2 - .185	M12 - .180

## SST Series

The versatile, low cost, Spin/Spin pneumatic rivet nut production tool now comes with a quick-change nosepiece assembly and standard socket head cap screw for convenient replacement and change over. For added ease of operation, the Spin/Spin offers a superior ergonomic design, lightweight body, and operates without stroke adjustment. Available models come with 2 front assemblies of your choice (refer to table below).



Additional nosepiece and mandrel sizes are available:

- SST-1/M39801 - 3000 RPM
- SST-2/M39802 - 1500 RPM
- SST-3/M39803 - 600 RPM
- SST-4/M39804 - 400 RPM

**NEW**

Marson Spin/ Tool Model Thread Size	3000 RPM SST-1 Recommended	1500 RPM SST-2		600 RPM SST-3		400 RPM SST-4 Recommended
		Recommended	Optional	Recommended	Optional	
4-40	✓					
6-32	✓					
8-32	✓		✓			
10-24		✓			✓	
10-32		✓			✓	
1/4-20			✓	✓		
1/4-28			✓	✓		
5/16-18					✓	✓
5/16-24					✓	✓
3/8-16						✓
3/8-24						✓
M3	✓					
M4	✓		✓			
M5		✓			✓	
M6			✓	✓		
M8					✓	✓
M10						✓

**OPERATOR IS LIABLE FOR CORRECT AIR PRESSURE. DO NOT EXCEED 100 PSI.**

Purchasing the Optional Front End Assemblies are at the Owner's discretion. Care must be taken to optimize the tools Rivet Nut setting ability. Adjustment of the air pressure will be necessary in order for the tool to function in both minimum and maximum capacity on ALL optional thread sizes per tool. Available retrofit for MET external thread, contact customer service.

# Rivet Nut Tools & Kits

## Spin/Spin Front End Assembly Table

Recommended Tool	Inch Size	Front End Assembly FEA #
M39801	4-40	M95500
M39801	6-32	M95501
M39801	8-32	M95502
M39802	10-24	M95503
M39802	10-32	M95504
M39803	1/4-20	M95505
M39803	1/4-28	M95506
M39804	5/16-18	M95507
M39804	5/16-24	M95508
M39804	3/8-16	M95509
M39804	3/8-24	M95510

Contact customer service for MET series front ends.

Recommended Tool	Metric Size	Front End Assembly FEA #
M39801	M3	M95515
M39801	M4	M95516
M39802	M5	M95517
M39803	M6	M95518
M39804	M8	M95519
M39804	M10	M95520

FEA Parts			
Anvil / Nosepiece	3 Bearing Set	Hex-drive	Mandrel / Screw Thread
M95399	M95525	M95535	M95424
M95400	M95526	M95536	M95425
M95401	M95527	M95537	M95426
M95402	M95528	M95538	M95427
M95402	M95528	M95538	M95428
M95404	M95529	M95539	M95429
M95404	M95529	M95539	M95430
M95406	M95530	M95540	M95431
M95406	M95530	M95540	M95432
M95408	M95531	M95541	M95433
M95408	M95531	M95541	M95434

FEA Parts			
Anvil / Nosepiece	3 Bearing Set	Hex-drive	Mandrel / Screw Thread
M95400	M95526	M95545	M95440
M95401	M95527	M95546	M95441
M95402	M95528	M95547	M95442
M95404	M95529	M95548	M95443
M95406	M95530	M95549	M95444
M95408	M95531	M95550	M95445

## Inch-Metric Conversion Table

Inches			Inches		
Fraction	Decimal	mm	Fraction	Decimal	mm
1/64	.015 625	.3969	33/64	.515 625	13.0969
1/32	.031 250	.7938	17/32	.531 250	13.4938
3/64	.046 875	1.1906	35/64	.546 875	13.8906
1/16	.062 500	1.5875	9/16	.562 500	14.2875
5/64	.078 125	1.9844	37/64	.578 125	14.6844
3/32	.093 750	2.3812	19/32	.593 750	15.0812
7/64	.109 375	2.7781	39/64	.609 375	15.4781
1/8	.125 000	3.1750	5/8	.625 000	15.8750
9/64	.140 625	3.5719	41/64	.640 625	16.2719
5/32	.156 250	3.9688	21/32	.656 250	16.6688
11/64	.171 875	4.3656	43/64	.671 875	17.0656
3/16	.187 500	4.7625	11/16	.687 500	17.4625
13/64	.203 125	5.1594	45/64	.703 125	17.8594
7/32	.218 750	5.5562	23/32	.718 750	18.2562
15/64	.234 375	5.9531	47/64	.734 375	18.6531
1/4	.250 000	6.3500	3/4	.750 000	19.0500
17/64	.265 625	6.7469	49/64	.765 625	19.4469
9/32	.281 250	7.1438	25/32	.781 250	19.8437
19/64	.296 875	7.5406	51/64	.796 875	20.2406
5/16	.312 500	7.9375	13/16	.812 500	20.6375
21/64	.328 125	8.3344	53/64	.828 125	21.0344
11/32	.343 750	8.7312	27/32	.843 750	21.4312
23/64	.359 375	9.1281	55/64	.859 375	21.8281
3/8	.375 000	9.5250	7/8	.875 000	22.2250
25/64	.390 625	9.9219	57/64	.890 625	22.6219
13/32	.406 250	10.3188	29/32	.906 250	23.0188
27/64	.421 875	10.7156	59/64	.921 875	23.4156
7/16	.437 500	11.1125	15/16	.937 500	23.8125
29/64	.453 125	11.5094	61/64	.953 125	24.2094
15/32	.468 750	11.9062	31/32	.968 750	24.6062
31/64	.484 375	12.3031	63/64	.984 375	25.0031
1/2	.500 000	12.7000	1	1.000 000	25.4000

## Decimal Equivalents of Standard Sheet Gauges

Inches No. of Gauge	Thickness in Thousandths	
	Aluminum (B & S)	Steel (U.S. Std.)
10	.1019	.1345
11	.0907	.1196
12	.0808	.1046
13	.0720	.0897
14	.0641	.0747
15	.0571	.0673
16	.0508	.0598
17	.0453	.0538
18	.0403	.0478
19	.0359	.0418
20	.0320	.0359
21	.0285	.0329
22	.0253	.0299
23	.0226	.0269
24	.0201	.0239
25	.0179	.0209
26	.0159	.0179
27	.0142	.0164
28	.0126	.0149
29	.0113	.0135
30	.0100	.0120

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