



**HOWMET
AEROSPACE**



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Rivets, Rivet Nuts and Installation Tools



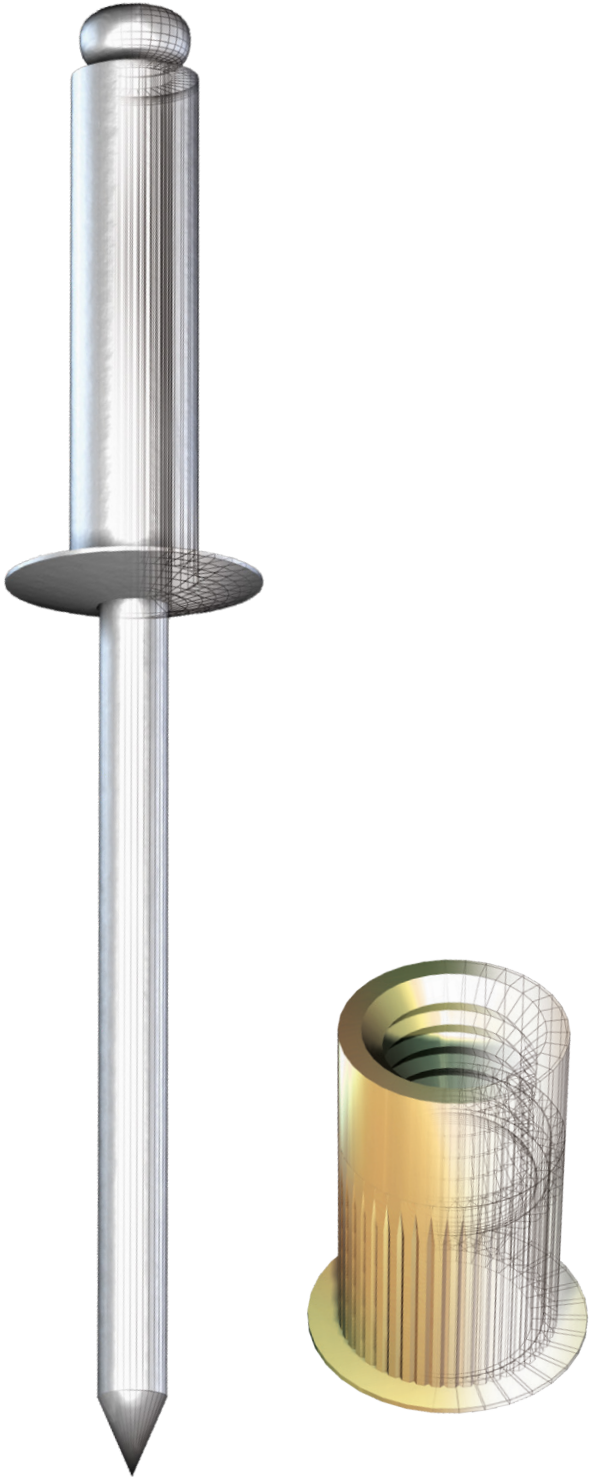


The Marson® brand is synonymous with leading technologies that automate the manufacture and installation of a wide variety of blind rivets and rivet nuts used on assembly lines and in repair facilities around the world.

Ace Rivet is a Tier One Supplier of all Marson and Huck Products

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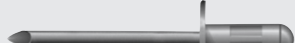



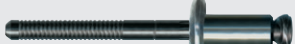


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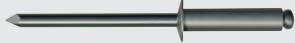
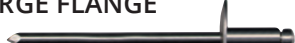



Quality Policy

Howmet Fastening Systems is committed to satisfying our customers by delivering safe and reliable products and services. Marson® brand rivets are engineered in accordance with and governed by the Industrial Fastener Institute quality standards.

Blind Rivets

Rivet Styles	Features/Benefits	Materials
OPEN END 	<ul style="list-style-type: none"> Simple to install 3/32" to 1/4" diameters 	Steel/steel, Aluminum/aluminum Aluminum/steel, Stainless/stainless, Stainless/steel, Copper/brass, Copper/steel
CLOSED END 	<ul style="list-style-type: none"> Moisture-resistant High shear and tensile strength 1/8" to 1/4" diameters 	Aluminum/steel, Aluminum/aluminum, Stainless/stainless
MULTI-GRIP 	<ul style="list-style-type: none"> Extended grip range capacity Reduces inventory (fewer sizes required) Use as a standard open end rivet 1/8" to 3/16" diameters 	Aluminum/steel, Steel/steel
TRI-BULB 	<ul style="list-style-type: none"> Large blind-side footprint Multi-grip capability Oversized hole tolerant Great for soft or brittle materials 5/32" to 3/16" diameters 	Aluminum/aluminum
Q-LOK 	<ul style="list-style-type: none"> High shear and tensile strength Vibration resistant Mandrel breaks flush with mid-grip range Moisture-resistant due to tight seal 3/16" diameter 	Steel/steel
KLIK-LOCK® 	<ul style="list-style-type: none"> High shear and tensile strength Vibration resistant Weather-resistant joint 3/16" and 1/4" diameters 	Steel/steel, Aluminum/aluminum, Stainless/stainless
T-RIVETS 	<ul style="list-style-type: none"> High clamp up High shear strength Large blind-side footprint 1/4" diameter 	Aluminum/steel
SPECIAL APPLICATION RIVETS 	<ul style="list-style-type: none"> For fastening decorative materials on boats and motor vehicles For installation of non-critical components 	Stainless/steel, Aluminum/aluminum
PLASTIC 	<ul style="list-style-type: none"> Precision-molded, all-nylon Secure lock prevents pull-out Multi-material joining 	Nylon body, Delrin 500 Mandrel

Head Styles	Features/Benefits
BUTTONHEAD 	<ul style="list-style-type: none"> Low profile head diameter provides high bearing surface for nearly all applications Open-end buttonhead rivets offer the broadest selection of sizes available
LARGE FLANGE 	<ul style="list-style-type: none"> For fastening soft and brittle facing materials and oversize facing holes Works with soft materials, increased flange diameter protects the integrity of the application
COUNTERSUNK 	<ul style="list-style-type: none"> 120° countersunk rivets for flush appearance applications

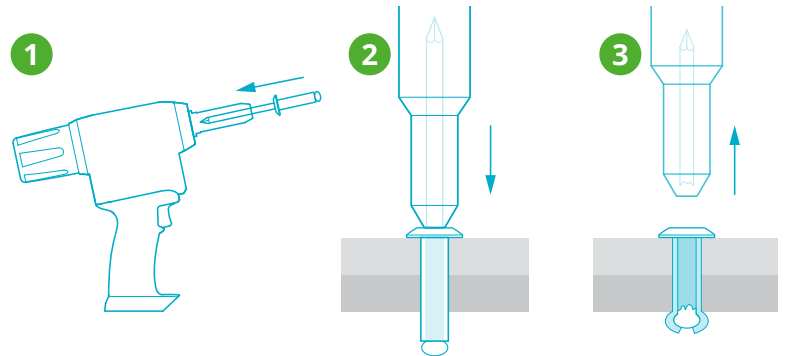
Design Information

1. The shear and tensile strength of the rivet selected and the number of rivets used in the application should equal or exceed the joint strength requirements. Typical ultimate shear and tensile strengths are listed by diameter and material on pages 5 through 17 of this catalog. Testing is recommended before final selection and use in product.
2. The rivet body material should be compatible with the materials to be joined to resist galvanic corrosion which may result in reduction of joint strength. If dissimilar materials are widely separated on the galvanic chart, it is advisable to separate them with a dielectric material such as paint or other coating. HFS can paint colors to match, as well as anodize or plate to your specifications.
3. After determination of strengths required by diameter and material, the total thickness of materials to be joined must be considered. The grip range for each rivet is listed on pages 5 through 17. Select the rivet grip range which includes the total thickness of materials to be joined. Please note that the rivet barrel length (Column L) is not the grip range.
4. Use recommended hole sizes for each rivet as shown on pages 5 through 17. An undersize hole will not allow insertion of rivet body. An oversize hole may cause rivet or joint failure and could adversely affect rivet shear and tensile strengths.
5. The various head styles (illustrated on page 3) are offered to accommodate different assembly needs. The most popular Klik-Fast rivet is the buttonhead, whose lower-profile head is twice the diameter of the rivet body. This provides adequate bearing surface for nearly all applications. The large flange Klik-Fast rivet provides greater bearing surface for fastening soft or brittle facing materials. The countersunk Klik-Fast rivet is available for applications where a flush appearance is required.
6. Please visit us at hfsindustrial.com and e-mail your questions. We will follow up with evaluations, recommendations and testing if required.
 - Samples are available upon request
 - Special packaging available

HFS Code Descriptions

Example: ABL6-6A	A	Rivet Material (A = Aluminum, S = Steel, C = Copper, SS = Stainless Steel)
	B	Style of Head (B = Buttonhead, C = Countersunk)
	L	Large Flange Head (if any)
	6	Body Diameter in 32nds
	6	Maximum Grip Length in 16ths
	A	A = Aluminum Mandrel, S = Stainless Steel Mandrel, B = Brass Mandrel, C = Copper-Plated Steel Mandrel, CLD = Closed-End Mandrel, MG = Multi-Grip, QL = Q-Lok, KL = Klik-Lock, ATB = All Aluminum Tri-Bulb Rivet, No letter indicates steel mandrel.

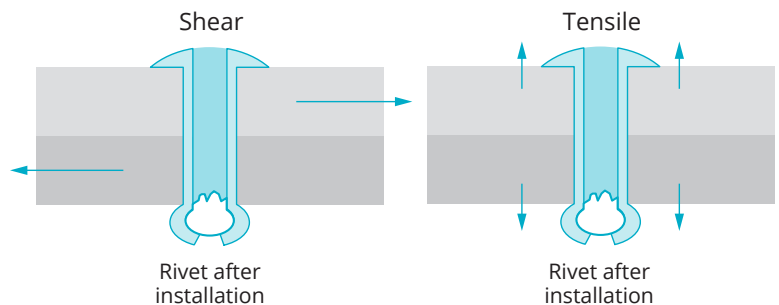
Installation



1 Insert rivet mandrel in rivet setting tool.

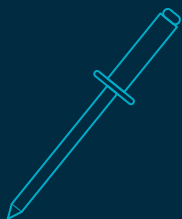
2 Using tool as a guide, insert rivet into prepared hole. Engage the mandrel with rivet-setting tool.

3 Squeeze trigger or handles to set rivet. Mandrel ejects after rivet is set.



Rivet after installation

Rivet after installation

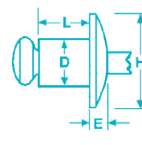


- ✓ Hollow Extrusions and Tubes
- ✓ High Grip Strength No Surface Distortion
- ✓ Hard and Soft Materials

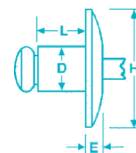
- ✓ Vibration and Tamper Resistant
- ✓ High Strength
- ✓ No Marred Surfaces
- ✓ Low-Profile Heads

Steel

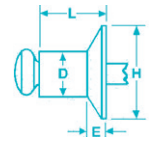
Buttonhead



Large Flange



Countersunk

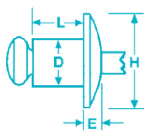


Plated-Steel Rivet • Coated Steel Mandrel • IFI Grade 30

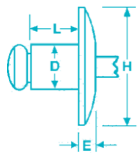
DIA.		HFS DESCRIPTION	BULK PART NO.**	GRIP RANGE		DRILL NO. & HOLE SIZE		H HEAD DIA. NOM		E HEAD HEIGHT MAX		L RIVET LENGTH MAX		TYPICAL ULTIMATE STRENGTH			
IN	MM			IN	MM	IN	MM	IN	MM	IN	MM	IN	MM	SHEAR		TENSILE	
				IN	MM			LBS	N	LBS	N						
Buttonhead																	
1/8" (.125)	3.2	SB4-1	M50111	.020-.062	.5-1.6	#30	#30	.250	6.35	.040	1.02	.212	5.4	305	1356	410	1823
		SB4-2	M50112	.063-.125	1.7-3.2							.275	7.0				
		SB4-3	M50115	.126-.187	3.3-4.8							.337	8.6				
		SB4-4	M50117	.188-.250	4.9-6.4							.400	10.2				
		SB4-5	M50120	.251-.312	6.5-7.9							.462	11.7				
		SB4-6	M50121	.313-.375	8.0-9.5							.525	13.4				
		SB4-8	M50122	.376-.500	9.6-12.7							.650	16.5				
		SB4-10	M50125	.501-.625	12.8-15.9							.775	19.7				
5/32" (.156)	4.0	SB5-2	M50132	.020-.125	.5-3.2	#20	#20	.312	7.92	.050	1.27	.300	7.6	420	1868	600	2668
		SB5-3	M50134	.126-.187	3.3-4.8							.362	9.2				
		SB5-4	M50135	.188-.250	4.9-6.4							.425	10.8				
		SB5-6	M50136	.251-.375	6.5-9.5							.550	14.0				
		SB5-8	M50137	.376-.500	9.6-12.7							.675	17.2				
		SB5-10	M50131	.501-.675	12.8-17.1							.800	20.3				
		SB5-12	M50133	.676-.750	17.2-19.1							.925	23.5				
		3/16" (.187)	4.8	SB6-2	M50145							.020-.125	.5-3.2				
SB6-4	M50147			.126-.250	3.3-6.4	.450	11.5										
SB6-6	M50149			.251-.375	6.5-9.5	.575	14.6										
SB6-8	M50152			.376-.500	9.6-12.7	.700	17.8										
SB6-10	M50155			.501-.625	12.8-15.9	.825	21.0										
SB6-12	M50159			.626-.750	16.0-19.1	.950	24.2										
SB6-14	M50163			.751-.875	19.2-22.2	1.075	27.3										
SB6-16	M50170			.876-1.000	22.3-25.4	1.200	30.5										
1/4" (.250)	6.4	SB8-2	M50179	.020-.125	.5-3.2	F	F	.500	12.70	.080	2.03	.375	9.4	1270	5649	1550	6894
		SB8-4	M50181	.126-.250	3.3-6.4							.500	12.7				
		SB8-6	M50183	.251-.375	6.5-9.5							.625	15.9				
		SB8-8	M50185	.376-.500	9.6-12.7							.750	19.1				
		SB8-10	M50187	.501-.625	12.8-15.9							.875	21.0				
		SB8-12	M50189	.626-.750	16.0-19.1							1.000	25.4				
		SB8-14	M50188	.751-.875	19.2-22.2							1.125	28.6				
		SB8-16	M50190	.876-1.000	22.3-25.4							1.250	31.8				
Large Flange																	
1/8" (.125)	3.2	SBL4-2	M50114	.063-.125	1.7-3.2	#30	#30	.375	9.53	.065	1.65	.275	7.0	305	1356	410	1823
		SBL4-3	M50124	.126-.187	3.3-4.8							.337	8.6				
		SBL4-4	M50119	.188-.250	4.9-6.4							.400	10.2				
		SBL4-6	M50108	.313-.375	8.0-9.5							.525	13.3				
		SBL4-8	M50109	.376-.500	9.6-12.7							.650	16.5				
5/32" (.156)	4.0	SBL5-4	M50138	.188-.250	4.9-6.4	#20	#20	.468	11.90	.070	1.77	.425	10.8	420	1868	600	2668
		SBL5-6	M50139	.251-.375	6.5-9.5							.550	14.0				
		SBL5-8	M50110	.376-.500	9.6-12.7							.675	17.2				
3/16" (.187)	4.8	SBL6-4	M50148	.126-.250	3.3-6.4	#11	#11	.615	15.88	.090	2.28	.450	11.5	610	2713	870	3869
		SBL6-6	M50150	.251-.375	6.5-9.5							.575	14.6				
		SBL6-8	M50153	.376-.500	9.6-12.7							.700	17.8				
		SBL6-10	M50156	.501-.625	12.8-15.9							.825	21.0				
		SBL6-12	M50160	.626-.750	16.0-19.1							.950	24.2				
		SBL6-14	M50165	.751-.875	19.2-22.2							1.075	27.3				
		SBL6-16	M50167	.876-1.000	22.3-25.4							1.200	30.5				
120° Countersunk																	
1/8" (.125)	3.2	SC4-2	M50113	.092-.125	2.3-3.2	#30	#30	.220	5.59	.031	1.14	.275	7.0	305	1356	410	1823
		SC4-3	M50116	.126-.187	3.3-4.8							.337	8.6				
		SC4-4	M50118	.188-.250	4.9-6.4							.400	10.2				
		SC4-6	M50126	.313-.375	6.5-9.5							.525	13.3				
		SC4-8	M50127	.376-.500	9.6-12.7							.650	16.5				
5/32" (.156)	4.0	SC5-4	M50140	.188-.250	4.9-6.4	#20	#20	.281	7.20	.040	1.20	.425	10.8	420	1868	600	2668
3/16" (.187)	4.8	SC6-4	M50151	.151-.250	3.8-6.4	#11	#11	.350	8.89	.050	1.27	.450	11.4	610	2713	870	3869
		SC6-6	M50129	.251-.375	6.5-9.5							.575	14.6				

KLIK-FAST RIVETS conform to IFI-114 (inch) and IFI-505 (metric). ** Also available in various packaged quantities.

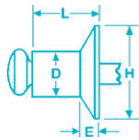
Buttonhead



Large Flange



Countersunk



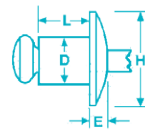
Aluminum

5052 Aluminum Rivet • Aluminum Mandrel • IFI Grade 11

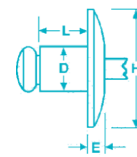
DIA.		HFS DESCRIPTION	BULK PART NO.**	GRIP RANGE		DRILL NO. & HOLE SIZE		H HEAD DIA. NOM		E HEAD HEIGHT MAX		L RIVET LENGTH MAX		TYPICAL ULTIMATE STRENGTH			
IN	MM			IN	MM	IN	MM	IN	MM	IN	MM	IN	MM	SHEAR		TENSILE	
				IN	MM	LBS	N	LBS	N								
Buttonhead																	
3/32"	2.4	AB3-2A AB3-4A	M50200 M50202	.020-.125 .126-.250	.5-3.2 3.3-6.4	#41 .097-.100	#41 2.46-2.54	.188	4.78	.032	.810	.250 .375	6.4 9.5	80	355	120	533
1/8"	3.2	AB4-1A AB4-2A AB4-3A AB4-4A AB4-5A AB4-6A AB4-8A AB4-10A	M50211 M50212 M50215 M50217 M50220 M50221 M50222 M50225	.020-.062 .063-.125 .126-.187 .188-.250 .251-.312 .313-.375 .376-.500 .501-.625	.5-1.6 1.7-3.2 3.3-4.8 4.9-6.4 6.5-7.9 8.0-9.5 9.6-12.7 12.8-15.9	#30 .129-.133	#30 3.28-3.38	.250	6.35	.040	1.02	.212 .275 .337 .400 .462 .525 .650 .775	5.4 7.0 8.6 10.2 11.7 13.4 16.5 19.7	155	689	240	1067
5/32"	4.0	AB5-2A AB5-3A AB5-4A AB5-6A AB5-8A AB5-10A AB5-12A	M50232 M50234 M50235 M50236 M50237 M50238 M50239	.020-.125 .126-.187 .188-.250 .251-.375 .376-.500 .501-.625 .626-.750	.5-3.2 3.3-4.8 4.9-6.4 6.5-9.5 9.6-12.7 12.8-17.1 17.2-19.1	#20 .160-.164	#20 4.06-4.16	.312	7.92	.050	1.27	.300 .362 .425 .550 .675 .800 .925	7.6 9.2 10.8 14.0 17.2 20.3 23.5	230	1023	340	1512
3/16"	4.8	AB6-2A AB6-4A AB6-6A AB6-8A AB6-10A AB6-12A AB6-14A AB6-16A	M50245 M50247 M50249 M50252 M50255 M50259 M50263 M50266	.020-.125 .126-.250 .251-.375 .376-.500 .501-.625 .626-.750 .751-.875 .876-1.000	.5-3.2 3.3-6.4 6.5-9.5 9.6-12.7 12.8-15.9 16.0-19.1 19.2-22.2 22.3-25.4	#11 .192-.196	#11 4.88-4.98	.375	9.53	.060	1.52	.325 .450 .575 .700 .825 .950 1.075 1.200	8.3 11.5 14.6 17.8 21.0 24.2 27.3 30.5	330	1467	515	2290
1/4"	6.4	AB8-4A AB8-6A AB8-8A AB8-10A AB8-12A AB8-14A	M50281 M50283 M50285 M50287 M50289 M50288	.126-.250 .251-.375 .376-.500 .501-.625 .626-.750 .751-.875	3.3-6.4 6.5-9.5 9.6-12.7 12.8-15.9 16.0-19.1 19.2-22.2	F.257-.261	F 6.53-6.63	.500	12.70	.080	2.03	.500 .625 .750 .875 1.000 1.125	12.7 15.9 19.1 21.0 25.4 28.6	600	2668	800	3558
Large Flange																	
1/8"	3.2	ABL4-2A ABL4-3A ABL4-4A ABL4-6A ABL4-8A	M50214 M50224 M50219 M50226 M50227	.063-.125 .126-.187 .188-.250 .313-.375 .376-.500	1.7-3.2 3.3-4.8 4.9-6.4 8.0-9.5 9.6-12.7	#30 .129-.133	#30 3.28-3.38	.375	9.53	.065	1.65	.275 .337 .400 .525 .650	7.0 8.6 10.2 13.3 16.5	155	689	240	1067
5/32"	4.0	ABL5-4A	M50244	.188-.250	4.9-6.4	#20 .160-.164	#20 4.06-4.16	.468	11.90	.070	1.20	.425	10.8	230	1023	340	1512
3/16"	4.8	ABL6-4A ABL6-6A ABL6-8A ABL6-10A ABL6-12A ABL6-16A	M50248 M50250 M50253 M50256 M50260 M50267	.126-.250 .251-.375 .376-.500 .501-.625 .626-.750 .875-1.00	3.3-6.4 6.5-9.5 9.6-12.7 12.8-15.9 16.0-19.1 22.2-25.4	#11 .192-.196	#11 4.88-4.98	.615	15.88	.090	2.28	.450 .575 .700 .825 .950 1.200	11.5 14.6 17.8 21.0 24.2 30.5	330	1467	515	2290
120° Countersunk																	
1/8"	3.2	AC4-2A AC4-3A AC4-4A AC4-6A	M50213 M50216 M50218 M50241	.092-.125 .126-.187 .188-.250 .313-.375	2.3-3.2 3.3-4.8 4.9-6.4 8.0-9.5	#30 .129-.133	#30 3.28-3.38	.220	5.59	.031	1.14	.275 .337 .400 .525	7.0 8.6 10.2 13.3	155	689	240	1050
5/32"	4.0	AC5-4A AC5-6A	M50240 M50242	.188-.250 .313-.375	4.9-6.4 8.0-9.5	#20 .160-.164	#20 4.06-4.16	.281	7.20	.040	1.20	.425 .550	10.8 14.0	230	1020	340	1512
3/16"	4.8	AC6-4A AC6-6A AC6-8A	M50251 M50229 M50246	.151-.250 .251-.375 .376-.500	3.8-6.4 6.5-9.5 9.6-12.7	#11 .192-.196	#11 4.88-4.98	.350	8.89	.050	1.27	.407 .575 .700	10.3 14.6 17.8	330	1467	515	2290

KLICK-FAST RIVETS conform to IFI-114 (inch) and IFI-505 (metric). ** Also available in various packaged quantities.

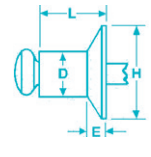
Buttonhead



Large Flange



Countersunk



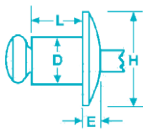
Aluminum / Steel

5056 Aluminum Rivet • Coated Steel Mandrel • IFI Grade 19

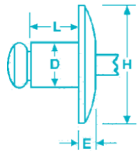
DIA.		HFS DESCRIPTION	BULK PART NO.**	GRIP RANGE		DRILL NO. & HOLE SIZE		H HEAD DIA. NOM		E HEAD HEIGHT MAX		L RIVET LENGTH MAX		TYPICAL ULTIMATE STRENGTH			
IN	MM			IN	MM	IN	MM	IN	MM	IN	MM	IN	MM	SHEAR		TENSILE	
														LBS	N	LBS	N
Buttonhead																	
3/32" (.094)	2.4	AB3-2 AB3-4	M50300 M50302	.020-.125 .126-.250	.5-3.2 3.3-6.4	#41 .097- .100	#41 2.46- 2.54	.188	4.78	.032	.810	.250 .375	6.4 9.5	120	534	160	711
1/8" (.125)	3.2	AB4-1 AB4-2 AB4-3 AB4-4 AB4-5 AB4-6 AB4-8 AB4-10	M50311 M50312 M50315 M50317 M50320 M50321 M50322 M50325	.020-.062 .063-.125 .126-.187 .188-.250 .251-.312 .313-.375 .376-.500 .501-.625	.5-1.6 1.7-3.2 3.3-4.8 4.9-6.4 6.5-7.9 8.0-9.5 9.6-12.7 12.8-15.9	#30 .129- .133	#30 3.28- 3.38	.250	6.35	.040	1.02	.212 .275 .337 .400 .462 .525 .650 .775	5.4 7.0 8.6 10.2 11.7 13.4 16.5 19.7	225	1000	315	1401
5/32" (.156)	4.0	AB5-2 AB5-3 AB5-4 AB5-6 AB5-8	M50332 M50334 M50335 M50336 M50337	.020-.125 .126-.187 .188-.250 .251-.375 .376-.500	.5-3.2 3.3-4.8 4.9-6.4 6.5-9.5 9.6-12.7	#20 .160- .164	#20 4.06- 4.16	.312	7.92	.050	1.27	.300 .362 .425 .550 .675	7.6 9.2 10.8 14.0 17.2	300	1334	470	2090
3/16" (.187)	4.8	AB6-2 AB6-4 AB6-6 AB6-8 AB6-10 AB6-12 AB6-16	M50345 M50347 M50349 M50352 M50355 M50359 M50366	.020-.125 .126-.250 .251-.375 .376-.500 .501-.625 .626-.750 .751-1.00	.5-3.2 3.3-6.4 6.5-9.5 9.6-12.7 12.8-15.9 16.0-19.1 19.2-25.4	#11 .192- .196	#11 4.88- 4.98	.375	9.53	.060	1.52	.325 .450 .575 .700 .825 .950 1.200	8.3 11.5 14.6 17.8 21.0 24.2 30.5	465	2068	700	3113
1/4" (.250)	6.4	AB8-4 AB8-6 AB8-8 AB8-10 AB8-12 AB8-14 AB8-16	M50381 M50383 M50385 M50387 M50389 M50388 M50390	.126-.250 .251-.375 .376-.500 .501-.625 .626-.750 .751-.875 .876-1.000	3.3-6.4 6.5-9.5 9.6-12.7 12.8-15.9 16.0-19.1 19.2-22.2 22.3-25.4	F .257- .261	F 6.53- 6.63	.500	12.70	.080	1.88	.500 .625 .750 .875 1.000 1.125 1.250	12.7 15.9 19.1 21.0 25.4 28.6 31.8	990	4403	1195	5315
Large Flange																	
1/8" (.125)	3.2	ABL4-2 ABL4-3 ABL4-4 ABL4-6	M50314 M50324 M50319 M50326	.063-.125 .126-.187 .188-.250 .313-.375	1.7-3.2 3.3-4.8 4.9-6.4 8.0-9.5	#30 .129- .133	#30 3.28- 3.38	.375	9.53	.065	1.65	.275 .337 .400 .525	7.0 8.6 10.2 13.3	225	1000	315	1401
5/32" (.156)	4.0	ABL5-4	M50338	.126-.250	3.2-6.4	#20 .160- .164	#20 4.06- 4.16	.468	11.9	.070	1.78	.425	10.8	300	1334	470	2090
3/16" (.187)	4.8	ABL6-4 ABL6-6 ABL6-8 ABL6-10 ABL6-12 ABL6-14 ABL6-16	M50348 M50350 M50353 M50356 M50360 M50365 M50367	.126-.250 .251-.375 .376-.500 .501-.625 .626-.750 .751-.875 .876-1.000	3.3-6.4 6.5-9.5 9.6-12.7 12.8-15.9 16.0-19.1 19.2-22.2 22.3-25.4	#11 .192- .196	#11 4.88- 4.98	.615	15.88	.090	2.08	.450 .575 .700 .825 .950 1.075 1.200	11.5 14.6 17.8 21.0 24.2 27.3 30.5	465	2068	700	3113
120° Countersunk																	
1/8" (.125)	3.2	AC4-2 AC4-3 AC4-4 AC4-5	M50313 M50316 M50318 M50323	.092-.125 .126-.187 .188-.250 .251-.312	2.3-3.2 3.3-4.8 4.9-6.4 6.5-9.5	#30 .129- .133	#30 3.28- 3.38	.220	5.59	.031	1.14	.275 .337 .400 .525	7.0 8.6 10.2 11.7	225	1000	315	1401
5/32" (.156)	4.0	AC5-4 AC5-6 AC5-8	M50340 M50342 M50343	.188-.250 .251-.375 .376-.500	4.9-6.4 6.5-9.5 9.6-12.7	#20 .160- .164	#20 4.06- 4.16	.281	7.2	.040	1.20	.425 .550 .675	10.8 14.0 17.2	300	1334	470	2090
3/16" (.187)	4.8	AC6-4 AC6-6 AC6-8	M50346 M50329 M50306	.151-.250 .251-.375 .376-.500	3.8-6.4 6.5-9.5 9.6-12.7	#11 .192- .196	#11 4.88- 4.98	.350	8.89	.050	1.27	.407 .575 .700	10.3 14.6 17.8	465	2068	700	3113

KLIK-FAST RIVETS conform to IFI-114 (inch) and IFI-505 (metric). ** Also available in various packaged quantities.

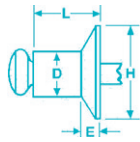
Buttonhead



Large Flange



Countersunk



Stainless

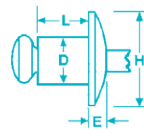
Stainless Rivet • Stainless Mandrel • IFI Grade 51

DIA.		HFS DESCRIPTION	BULK PART NO.**	GRIP RANGE		DRILL NO. & HOLE SIZE		H HEAD DIA. NOM		E HEAD HEIGHT MAX		L RIVET LENGTH MAX		TYPICAL ULTIMATE STRENGTH			
IN	MM			IN	MM	IN	MM	IN	MM	IN	MM	IN	MM	SHEAR		TENSILE	
				IN	N	LBS	N										
Buttonhead																	
1/8" (.125)	3.2	SSB4-1S	M50411	.020-.062	.5-1.6	#30	#30	.250	6.35	.040	1.02	.212	5.4	520	2310	600	2660
		SSB4-2S	M50412	.063-.125	1.7-3.2							.275	7.0				
		SSB4-3S	M50415	.126-.187	3.3-4.8							.337	8.6				
		SSB4-4S	M50417	.188-.250	4.9-6.4							.400	10.2				
		SSB4-5S	M50420	.251-.312	6.5-7.9							.462	11.7				
		SSB4-6S	M50421	.313-.375	8.0-9.5							.525	13.4				
		SSB4-8S	M50422	.376-.500	9.6-12.7							.650	16.5				
5/32" (.156)	4.0	SSB5-2S	M50432	.020-.125	.5-3.2	#20	#20	.312	7.92	.045	1.14	.300	7.6	785	3490	1040	4620
		SSB5-3S	M50434	.126-.187	3.3-4.8							.338	8.0				
		SSB5-4S	M50435	.188-.250	4.7-6.4							.425	10.8				
		SSB5-6S	M50436	.251-.375	6.5-9.5							.550	14.0				
		SSB5-8S	M50437	.376-.500	9.6-12.7							.675	17.2				
		SSB5-10S	M50427	.501-.625	12.8-15.9							.800	20.3				
3/16" (.187)	4.8	SSB6-2S	M50445	.020-.125	.5-3.2	#11	#11	.375	9.53	.066	1.40	.325	8.3	1150	5110	1300	5780
		SSB6-4S	M50447	.126-.250	3.3-6.4							.450	11.5				
		SSB6-6S	M50449	.251-.375	6.5-9.5							.575	14.6				
		SSB6-8S	M50450	.376-.500	9.6-12.7							.700	17.8				
		SSB6-10S	M50457	.501-.625	12.8-15.9							.825	21.0				
		SSB6-12S	M50458	.626-.750	16.0-19.1							.950	24.2				
		SSB6-16S	M50466	.751-1.000	19.2-25.4							1.200	30.5				
1/4" (.250)	6.4	SSB8-4S	M50481	.126-.250	3.3-6.4	F	F	.500	12.70	.074	1.88	.500	12.7	1700	7560	2100	9340
		SSB8-6S	M50483	.251-.375	6.5-9.5							.625	15.9				
		SSB8-8S	M50485	.376-.500	9.6-12.7							.750	19.1				
		SSB8-10S	M50487	.501-.625	12.8-15.9							.875	21.0				
		SSB8-12S	M50489	.626-.750	16.0-19.1							1.000	25.4				
Large Flange																	
1/8" (.125)	3.2	SSBL4-2S	M50409	.063-.125	1.7-3.2	#30	#30	.375	9.53	.045	1.14	.275	7.0	520	2310	600	2660
		SSBL4-3S	M50416	.126-.187	3.3-4.8							.337	8.6				
		SSBL4-4S	M50418	.188-.250	4.9-6.4							.400	10.2				
3/16" (.187)	4.8	SSBL6-4S	M50452	.126-.250	3.3-6.4	#11	#11	.615	15.88	.082	2.08	.450	11.5	1150	5110	1300	5780
		SSBL6-6S	M50453	.251-.375	6.5-9.5							.575	14.6				
		SSBL6-8S	M50456	.376-.500	9.6-12.7							.700	17.8				
		SSBL6-10S	M50451	.501-.625	12.8-15.9							.825	21.0				
		SSBL6-12S	M50455	.626-.750	16.0-19.1							.950	24.2				
120° Countersunk																	
1/8" (.125)	3.2	SSC4-2S	M50423	.063-.125	2.3-3.2	#30	#30	.220	5.59	.031	1.14	.275	7.0	520	2310	600	2660
		SSC4-3S	M50424	.126-.187	3.3-4.8							.337	8.6				
		SSC4-4S	M50425	.188-.250	4.9-6.4							.400	10.2				
		SSC4-5S	M50426	.251-.312	6.5-7.9							.462	11.7				
3/16" (.187)	4.8	SSC6-4S	M50429	.151-.250	3.8-6.4	#11	#11	.350	8.89	.050	1.27	.407	10.3	1150	5110	1300	5780

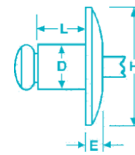
KLIK-FAST RIVETS conform to IFI-114 (inch) and IFI-505 (metric). ** Also available in various packaged quantities.

Stainless / Steel

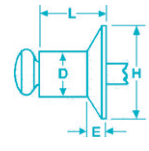
Buttonhead



Large Flange



Countersunk

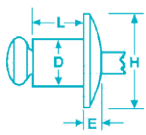


Stainless Rivet • Coated Steel Mandrel • IFI Grade 50

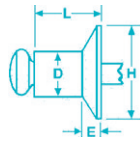
DIA.		HFS DESCRIPTION	BULK PART NO.**	GRIP RANGE		DRILL NO. & HOLE SIZE		H HEAD DIA. NOM		E HEAD HEIGHT MAX		L RIVET LENGTH MAX		TYPICAL ULTIMATE STRENGTH			
IN	MM			IN	MM	IN	MM	IN	MM	IN	MM	IN	MM	SHEAR		TENSILE	
				IN	N	LBS	N										
Buttonhead																	
1/8" (.125)	3.2	SSB4-1	M50511	.020-.062	.5-1.6	#30	#30	.250	6.35	.040	1.02	.212	5.4	520	2310	600	2660
		SSB4-2	M50512	.063-.125	1.7-3.2							.275	7.0				
		SSB4-3	M50515	.126-.187	3.3-4.8							.337	8.6				
		SSB4-4	M50517	.188-.250	4.9-6.4							.400	10.2				
		SSB4-5	M50526	.251-.312	6.5-7.9							.462	11.7				
		SSB4-6	M50521	.313-.375	8.0-9.5							.525	13.4				
		SSB4-7	M50522	.376-.500	9.6-12.7							.650	16.5				
		SSB4-8	M50522	.376-.500	9.6-12.7							.650	16.5				
5/32" (.156)	4.0	SSB5-2	M50532	.020-.125	.5-3.2	#20	#20	.312	7.92	.045	1.14	.300	7.6	785	3490	1040	4620
		SSB5-4	M50535	.188-.250	4.7-6.4							.425	8.0				
		SSB5-6	M50536	.251-.375	6.5-9.5							.550	14.0				
3/16" (.187)	4.8	SSB6-2	M50545	.020-.125	.5-3.2	#11	#11	.375	9.53	.055	1.40	.325	8.3	1150	5110	1300	5780
		SSB6-4	M50547	.126-.250	3.3-6.4							.450	11.5				
		SSB6-6	M50549	.251-.375	6.5-9.5							.575	14.6				
		SSB6-8	M50550	.376-.500	9.6-12.7							.700	17.8				
		SSB6-10	M50557	.501-.625	12.8-15.9							.825	21.0				
		SSB6-12	M50558	.626-.750	16.0-19.1							.950	24.2				
		SSB6-14	M50559	.751-1.000	19.2-25.4							1.120	30.5				
		SSB6-16	M50566	.751-1.000	19.2-25.4							1.120	30.5				
Large Flange																	
1/8" (.125)	3.2	SSBL4-2	M50513	.063-.125	1.7-3.2	#30	#30	.375	9.53	.045	1.14	.275	7.0	520	2310	600	2660
		SSBL4-3	M50518	.126-.187	3.3-4.8							.337	8.6				
		SSBL4-4	M50519	.188-.250	4.9-6.4							.400	10.2				
3/16" (.187)	4.8	SSBL6-4	M50548	.126-.250	3.3-6.4	#11	#11	.615	15.88	.082	2.08	.450	11.5	1150	5110	1300	5780
		SSBL6-6	M50553	.251-.375	6.5-9.5							.575	14.6				
		SSBL6-8	M50556	.376-.500	9.6-12.7							.700	17.8				
		SSBL6-10	M50551	.501-.625	12.8-15.9							.825	21.0				
		SSBL6-12	M50555	.626-.750	16.0-19.1							.950	24.2				
120° Countersunk																	
1/8" (.125)	3.2	SSC4-2	M50523	.092-.125	2.3-3.2	#30	#30	.220	5.59	.031	1.14	.275	7.0	520	2310	600	2660
		SSC4-3	M50524	.126-.187	3.3-4.8							.337	8.6				
		SSC4-4	M50525	.188-.250	4.9-6.4							.400	10.2				
		SSC4-5	M50528	.251-.312	6.5-7.9							.462	11.7				
3/16" (.187)	4.8	SSC6-4	M50529	.151-.250	3.8-6.4	#11	#11	.350	8.89	.050	1.27	.407	10.3	1150	5110	1300	5780

KLIK-FAST RIVETS conform to IFI-114 (inch) and IFI-505 (metric). ** Also available in various packaged quantities.

Buttonhead



Countersunk



Closed-End

5056 Aluminum

DIA.		HFS DESCRIPTION	BULK PART NO.**	GRIP RANGE		DRILL NO. & HOLE SIZE	H HEAD DIA. NOM		E HEAD HEIGHT MAX		L RIVET LENGTH MAX		TYPICAL ULTIMATE STRENGTH			
IN	MM			IN	MM		MM	IN	MM	IN	MM	IN	MM	SHEAR		TENSILE
				IN	N	LBS	N									
Buttonhead																
1/8" (.125)	3.2	AB4-1C	M56000	.020-.062	.5-1.6	#30 .129-.133	.236	5.99	.050	1.27	.297	7.54	240	1060	280	1240
		AB4-2C	M56001	.063-.125	1.7-3.2						.360	9.14				
		AB4-3C	M56002	.126-.187	3.3-4.8						.422	10.72				
		AB4-4C	M56003	.188-.250	4.9-6.4						.485	12.32				
		AB4-5C	M56004	.251-.312	6.5-7.9						.547	13.89				
AB4-6C	M56015	.313-.375	8.0-9.5	.610	15.50											
5/32" (.156)	4.0	AB5-2C	M56005	.020-.125	.51-3.2	#20 .160-.164	.315	8.00	.065	1.65	.375	9.53	350	1550	480	2130
		AB5-3C	M56006	.126-.187	3.3-4.8						.437	11.10				
		AB5-5C	M56007	.188-.312	4.9-6.35						.562	12.70				
3/16" (.187)	4.8	AB6-2C	M56008	.020-.125	.51-3.2	#11 .192-.196	.374	9.50	.080	2.03	.406	10.31	500	2230	690	3070
		AB6-4C	M56009	.126-.250	3.3-4.75						.531	11.89				
		AB6-6C	M56010	.251-.375	6.5-9.5						.656	16.66				
		AB6-8C	M56011	.376-.500	9.6-12.7						.781	19.84				
		AB6-10C	M56012	.501-.625	12.8-15.9						.906	23.01				
1/4" (.250)	6.4	AB8-4C	M56013	.126-.250	3.2-6.4	F .257-.261	.512	13.0	.090	2.29	.570	14.48	900	3950	1100	5000
		AB8-6C	M56014	.251-.375	6.5-9.5						.695	17.65				
120° Countersunk																
1/8" (.125)	3.2	AC4-2C	M56016	.063-.125	1.7-3.2	#30 .129-.133	.236	5.99	.050	1.27	.395	10.03	240	1067	280	1245
		AC4-3C	M56017	.126-.187	3.3-4.8						.457	11.61				
		AC4-4C	M56018	.188-.250	4.9-6.4						.520	13.21				
3/16" (.187)	4.8	AC6-4C	M56019	.126-.250	3.3-4.75	#11 .192-.196	.374	9.50	.540	13.72	.601	13.67	500	2224	690	3070
All Aluminum Buttonhead - IFI Grade 9																
1/8" (.125)	3.2	AB4-2AC	M56201	.063-.125	1.7-3.2	#30 .129-.133	.236	5.99	.050	1.27	.360	9.14	100	445	110	489
		AB4-3AC	M56202	.126-.187	3.3-4.8						.422	10.72				
		AB4-4AC	M56203	.188-.250	4.9-6.4						.485	12.32				
5/32" (.156)	4.0	AB5-4AC	M56207	.126-.250	3.3-4.75	#20 .160-.164	.315	8.00	.065	1.65	.500	11.10	130	578	160	712
3/16" (.187)	4.8	AB6-2AC	M56208	.020-.125	.51-3.2	#11 .192-.196	.374	9.50	.080	2.03	.406	10.31	210	934	250	1112
		AB6-4AC	M56209	.126-.250	3.3-4.75						.531	11.89				
		AB6-6AC	M56210	.251-.375	6.5-9.5						.656	16.66				
		AB6-8AC	M56211	.376-.500	9.6-12.7						.781	19.84				
		AB6-10AC	M56022	.501-.625	12.8-15.9						.906	23.01				

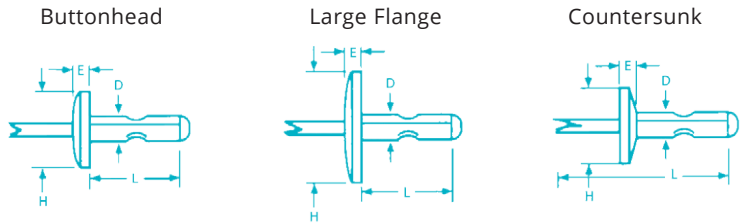
Stainless Rivet • Stainless Mandrel • IFI Grade 51 • Buttonhead

1/8" (.125)	3.2	SSB4-2SC	M56403	.020-.125	.51-3.2	#30 .129-.133	.236	5.99	.039	.990	.360	9.14	400	1779	450	2002
		SSB4-3SC	M56405	.126-.187	3.3-4.8						.422	10.72				
		SSB4-4SC	M56406	.188-.250	4.9-6.4						.485	12.32				
3/16" (.187)	4.8	SSB6-2SC	M56408	.020-.125	.51-3.2	#11 .192-.196	.374	9.49	.070	1.77	.406	10.31	850	3781	900	4003
		SSB6-4SC	M56409	.126-.250	3.3-4.75						.531	11.89				
		SSB6-6SC	M56410	.251-.375	6.5-9.5						.656	16.66				
		SSB6-8SC	M56411	.376-.500	9.6-12.7						.781	19.84				
		SSB6-10SC	M56412	.501-.625	12.8-15.9						.906	23.01				

Note: A slightly smaller mandrel diameter is required for closed-end rivets; therefore when setting closed-end rivets using Marson brand rivet setting tools, we recommend you use one size smaller nosepiece when possible (i.e., to set 1/8" rivets, use 3/32" nosepiece).

KLIK-FAST RIVETS conform to IFI-114 (inch) and IFI-505 (metric). ** Also available in various packaged quantities.

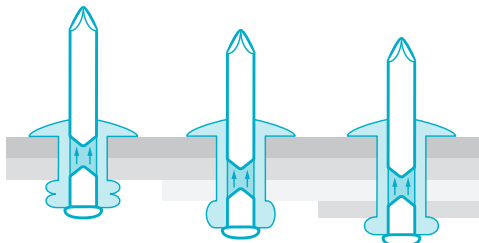
Multi-Grip



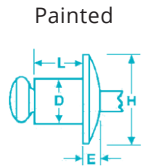
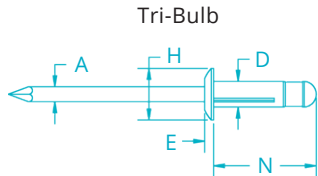
Aluminum Rivet • Plated Steel Mandrel

DIA.		HFS DESCRIPTION	BULK PART NO.**	GRIP RANGE		DRILL NO. & HOLE SIZE		H HEAD DIA. NOM		E HEAD HEIGHT MAX		L RIVET LENGTH MAX		TYPICAL ULTIMATE STRENGTH			
IN	MM			IN	MM	IN	MM	IN	MM	IN	MM	IN	MM	SHEAR		TENSILE	
														LBS	N	LBS	N
Steel Buttonhead																	
1/8" (.125)	3.2	SB41-42MG	M56112	.043-.156	1.1-4.0	#30 .129-.133	#30 3.28-3.38	.283	7.20	.033	.850	.355	9.0	340	1510	385	1710
5/32" (.156)	4.0	SB52-53MG	M56134	.056-.196	1.4-5.0	#20 .160-.164	#20 4.06-4.16	.319	8.10	.047	1.20	.433	11.0	440	1960	530	2360
3/16" (.187)	4.8	SB62-63MG SB63-64MG	M56146 M56147	.047-.187 .156-.250	1.2-4.8 4.0-6.3	#11 .192-.196	#11 4.88-4.98	.386	9.80	.069	1.75	.405 .500	10.3 12.7	810 1025	3605 4560	750 780	3335 3470
Aluminum / Steel Buttonhead																	
1/8" (.125)	3.2	AB41-43MG AB42-44MG AB44-45MG AB45-46MG	M56315 M56317 M56320 M56321	.031-.187 .046-.250 .156-.312 .216-.375	.8-4.8 1.2-6.4 4.0-7.9 5.5-9.5	#30 .129-.133	#30 3.28-3.38	.250	6.35	.037	.95	.315 .375 .438 .500	8.0 9.5 11.1 12.7	165	735	230	1025
5/32" (.156)	4.0	AB52-54MG AB54-56MG AB56-58MG	M56335 M56336 M56337	.046-.250 .156-.375 .250-.500	1.2-6.4 4.0-9.5 6.4-12.7	#20 .160-.164	#20 4.06-4.16	.312	7.92	.047	1.20	.375 .500 .666	9.5 12.7 16.9	255	1135	375	1670
3/16" (.187)	4.8	AB62-64MG AB63-67MG AB66-68MG AB610-612MG	M56347 M56351 M56352 M56359	.062-.250 .187-.437 .250-.500 .500-.781	1.6-6.4 4.8-11.1 6.4-12.7 12.7-19.8	#11 .192-.196	#11 4.88-4.98	.386	9.80	.057	1.45	.406 .595 .666 .978	10.3 15.1 16.9 24.8	350	1560	530	2360
Aluminum / Steel Large Flange																	
1/8" (.125)	3.2	ABL42-43MG ABL42-44MG ABL44-45MG	M56314 M56319 M56322	.031-.187 .046-.250 .156-.312	.8-4.8 1.2-6.4 4.0-7.9	#30 .129-.133	#30 3.28-3.38	.325	8.25	.039	1.00	.315 .375 .438	8.0 9.5 11.1	165	735	230	1025
5/32" (.156)	4.0	ABL52-54MG ABL53-55MG ABL55-58MG	M56341 M56340 M56342	.062-.250 .125-.312 .251-.500	1.6-6.4 3.2-7.9 6.4-12.7	#20 .160-.164	#20 4.06-4.16	.374	9.50	.051	1.30	.375 .438 .690	9.5 11.1 17.5	255	1135	375	1670
3/16" (.187)	4.8	ABL62-64MG ABL66-68MG ABL610-612MG	M56350 M56353 M56360	.062-.250 .250-.500 .500-.781	1.6-6.4 6.4-12.7 12.7-19.8	#11 .192-.196	#11 4.88-4.98	.625	15.85	.069	1.75	.406 .666 .978	10.3 16.9 24.8	350	1560	530	2360
Aluminum / Steel 120° Countersunk†																	
1/8" (.125)	3.2	AC43-44MG	M56318	.093-.250	2.4-6.4	#30 .129-.133	#30 3.28-3.38	.209	5.30	.029	.75	.383	9.7	155	690	206	912
5/32" (.156)	4.0	AC53-55MG	M56357	.109-.312	2.7-7.9	#20 .160-.164	#20 4.06-4.16	.252	6.40	.049	1.24	.470	11.9	255	1135	300	1670
3/16" (.187)	4.8	AC62-65MG AC66-68MG	M56361 M56362	.062-.312 .250-.500	1.6-7.9 6.4-12.7	#11 .192-.196	#11 4.88-4.98	.345	8.75	.051	1.30	.500 .690	12.7 17.5	350	1560	530	2360

†Countersunk-Total Length (L) including head. **Also available in packaged quantities.



A single multi-grip rivet provides the grip range capacity of up to three standard open-end rivets without requiring special tools. This allows you to reduce inventory while maintaining a full range fasteners for any application that uses open-end rivets.



Specialty

#110 Copper / Brass and #110 Copper / Steel

DIA.		HFS DESCRIPTION	BULK PART NO.**	GRIP RANGE		DRILL NO. & HOLE SIZE		H HEAD DIA. NOM		E HEAD HEIGHT MAX		L RIVET LENGTH MAX		TYPICAL ULTIMATE STRENGTH			
IN	MM			IN	MM	IN	MM	IN	MM	IN	MM	IN	MM	SHEAR		TENSILE	
														LBS	N	LBS	N
Plated Mandrel																	
1/8" (.125)	3.2	CB4-2B CB4-4B CB4-2C CB4-4C	M58600 M58602	.063-.125 .188-.250	1.7-3.2 4.9-6.4	#30 .129-.133	#30 3.28-3.38	.250	6.35	.040	1.02	.275 .400	7.0 10.2	215	950	300	1330

B - Copper / Brass; C - Copper / Steel plated mandrel) **Also available in packaged quantities.

DIA.		HFS DESCRIPTION	BULK PART NO.**	COLOR	GRIP RANGE		DRILL NO. & HOLE SIZE		H HEAD DIA. NOM		E HEAD HEIGHT MAX		L RIVET LENGTH MAX		TYPICAL ULTIMATE STRENGTH			
IN	MM				IN	MM	IN	MM	IN	MM	IN	MM	IN	MM	SHEAR		TENSILE	
														LBS	N	LBS	N	
Painted Rivets*																		
1/8" (.125)	3.2	AB4-2AW AB4-3AW AB4-4AW	M53032 M53007 M53009	W W W	.062-.125 .126-.187 .188-.250	1.7-3.2 3.2-4.8 4.9-6.4	#30 .129-.133	#30 3.28-3.38	.250	6.35	.040	1.02	.275 .337 .400	7.0 8.6 10.2	155	689	240	1067
		AB4-2ABR AB4-3ABR AB4-4ABR	M53097 M53081 M53099	BR BR BR	.062-.125 .126-.187 .188-.250	1.7-3.2 3.2-4.8 4.9-6.4	#30 .129-.133	#30 3.28-3.38	.275	.337	.040	1.02	.275 .337 .400	7.0 8.6 10.2	155	689	240	1067
		AB4-2ABL AB4-3ABL AB4-4ABL	M53098 M53102 M53100	BL BL BL	.062-.125 .126-.187 .188-.250	1.7-3.2 3.2-4.8 4.9-6.4	#30 .129-.133	#30 3.28-3.38	.275	.337	.040	1.02	.275 .337 .400	7.0 8.6 10.2	155	689	240	1067
		SB4-2W SB4-3W SB4-4W	M53033 M53034 M53036	W W W	.062-.125 .126-.187 .188-.250	1.7-3.2 3.2-4.8 4.9-6.4	#30 .129-.133	#30 3.28-3.38	.275	.337	.040	1.02	.275 .337 .400	7.0 8.6 10.2	305	1356	410	1823
		SB4-2BR SB4-3BR SB4-4BR	M53003 M53011 M53012	BR BR BR	.062-.125 .126-.187 .188-.250	1.7-3.2 3.2-4.8 4.9-6.4	#30 .129-.133	#30 3.28-3.38	.275	.337	.040	1.02	.275 .337 .400	7.0 8.6 10.2	305	1356	410	1823
		SB4-2BL SB4-4BL	M53060 M53051	BL BL	.062-.125 .188-.250	1.7-3.2 3.2-4.8	#30 .129-.133	#30 3.28-3.38	.275	.337	.040	1.02	.275 .400	7.0 10.2	330	1467	515	2290

*Custom colors available; contact factory for additional information. Painted rivets work best when hole size is at the high end of tolerance to allow for paint.

**Also available in packaged quantities.

Tri-Bulb Rivets														
DIA.	HFS DESCRIPTION	GRIP RANGE	DRILL NO. AND HOLE SIZE	A	E	H	N	Y	SHEAR		TENSILE			
									LBS	N	LBS	N		
5/32" (.156)	A0516ATB	.039 - .118	#20	.091	.055	.315	.630	.236	134	600	224	1000		
	A0523ATB	.039 - .276	.160-.164	.091	.055	.315	.835	.335	134	600	224	1000		
3/16" (.187)	A0619ATB	.039 - .157	#11 .192-.196	.115	.071	.386	.720	.276	202	900	269	1200		
	A0622ATB	.039 - .248		.115	.071	.386	.807	.335	202	900	269	1200		
	A0625ATB	.039 - .354		.115	.071	.386	.925	.374	202	900	269	1200		
	A0630ATB	.157 - .472		.115	.071	.386	1.063	.433	202	900	269	1200		
	AL0625ATB			.039 - .354		.115	.079	.551	.925	.374	202	900	269	1200

For black rivets add BL to the part number. White available as special order item. Refer to price list for bulk part number.

Back-Up Washers						
HFS DESCRIPTION	STANDARD CARTON QTY.	BULK PART NO.**	500 PACK NO.	MATERIAL	FOR HOLE SIZE	SIZE / SHAPE
SS-3	5M	M50653	M40653	STEEL	3/32"	1/2" SQ
SS-4	5M	M50654	M40654	STEEL	1/8"	1/2" SQ
SS-6	5M	M50656	M40656	STEEL	3/16"	1/2" SQ
SS-8	10M	M50658	M40658	STEEL	1/8"	3/8" RD
SS-9	10M	M50655	M40655	STEEL	5/32"	7/16" RD
SS-10	10M	M50661	M40661	STEEL	3/16"	1/2" RD
SS-12	10M	M50662	M40662	STEEL	1/4"	1/2" RD
AS-8	10M	M50657	M40657	ALUMINUM	1/8"	3/8" RD
AS-9	10M	M50659	M40659	ALUMINUM	5/32"	7/16" RD
AS-10	10M	M50660	M40660	ALUMINUM	3/16"	1/2" RD
AS-12	10M	M50665	M40665	ALUMINUM	1/4"	1/2" RD

**Also available in packaged quantities.



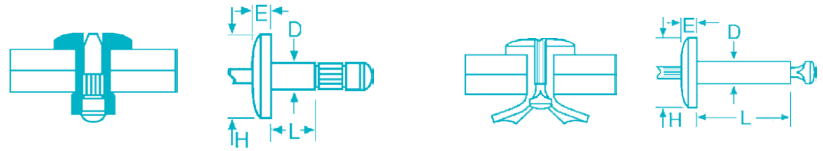
Back-up washers are .056"-.062" thick. They are used when fastening soft materials or to compensate for oversize holes.

Double-Ended Drill Bit / M39100

This double-ended drill bit provides the correct size hole and angle for 1/8" diameter countersink rivets, drilling and countersinking in one operation.



Specialty



Steel Q-LOK® Rivets

DIA.		HFS DESCRIPTION	BULK PART NO.**	GRIP RANGE		DRILL NO. & HOLE SIZE		H HEAD DIA. NOM		E HEAD HEIGHT MAX		L RIVET LENGTH MAX		TYPICAL ULTIMATE STRENGTH			
IN	MM			IN	MM	IN	MM	IN	MM	IN	MM	IN	MM	SHEAR		TENSILE	
														LBS	N	LBS	N
Plated Steel Body Plated Steel Mandrel																	
3/16" (.187)	4.8	SB6-2QL	M55145	.062-.125	2.3-3.2	#11	#11	.375	9.5	.065	1.65	.520	13.22	1050	4670	825	3670
		SB6-4QL	M55147	.126-.250	3.3-6.4	.192	4.88-4.98					.520	13.22				
		SB6-6QL	M55149	.251-.375	6.5-9.5	.196						.707	17.79				
		SB6-8QL	M55152	.376-.500	9.6-12.7							.770	19.56				
												.832	21.13				
												.960	24.38				

T-Rivets / Klik-Split™

Plated Steel Body Plated Steel Mandrel																	
1/4" (.250)	6.4	—	M52372	.062-.125	1.58-3.18	F	F	.500	12.7	.120	3.00	.520	13.22	1500	6670	1000	4445
			M52371	.032-.140	.81-3.56							.520	13.22				
			M52368	.251-.312	6.38-7.93							.707	17.79				
			M52369	.312-.375	7.95-9.53							.770	19.56				
			M52370	.376-.437	9.55-11.10							.832	21.13				
			M50376	.520-.620	13.21-15.97							.960	24.38				

Automotive / Special Application Rivets

HFS DESCRIPTION	BULK PART NO.*	GRIP RANGE	DESCRIPTION	MATERIALS BODY / MANDREL	RIVET DIA. NOM	FLANGE DIA. NOM	HOLE DIA. RANGE	500 PACK NO.
Trim Rivets								
ABN4-3A	M50261***	.126-.187	Trim Moulding Rivet	Alum / Alum	.125	.208	.129-.133	M40261
ABN4-4A	M50262***	.188-.250	Long Trim Moulding Rivet	Alum / Alum	.125	.208	.129-.133	M40262
SSBN4-3	M50516***	.126-.187	Trim Moulding Rivet w / SS Body	SS / Steel	.125	.208	.129-.133	M40516

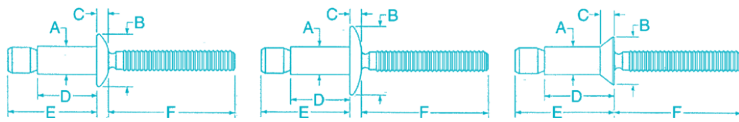
Klik-Split™ Window and Door Rivets*

Aluminum / Steel**								500 Pack No.
—	M52371	.032 -.140	Window Regulator Rivet	Alum / Steel	.250	.500	.257-.261	M42371
—	M52372	.090 -.115	Outside Door Handle Rivet with recessed head	Alum / Steel	.250	.500	.257-.261	M42372
—	M52373	.110 -.177	Door Handle Rivet with recessed head and zinc coated mandrel	Alum / Steel	.250	.500	.257-.261	M42373
—	M52374	.140 -.187	Window Regulator Rivet with yellow zinc coated mandrel	Alum / Steel	.250	.500	.257-.261	M42374
—	M52375	.090 -.115	Black Anodized Door Handle Rivet	Alum / Steel	.250	.500	.257-.261	M42375
—	M50376	.520 -.620	Glass Stop Rivet	Alum / Steel	.250	.500	.257-.261	M42376

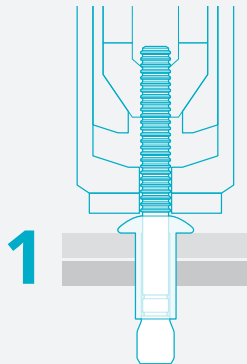
Miscellaneous Rivets

								50 PACK NO.
—	M53150	.250 -.375	Bumper Fascia Rivet large flange black	Steel / Steel	.187	.625	.192-.196	M43150
—	M53353	.125 -.187	Trunk Lock Swivel Emblem Rivet sealed end, countersunk head	Alum / Steel	.156	.312	.160-.164	M43353
								100 PACK NO.
—	M53295	.125 -.187	Rear Window Gasket Rivet	Alum / Steel	.125	.325	.129-.130	M43295
—	M53181	.125 -.250	Bumper Fascia Rivet w / yellow zinc coated mandrel	Steel / Steel	.250	.500	.257-.261	M43181

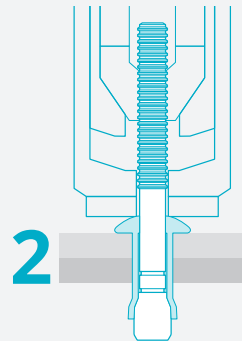
*Also available in packaged quantities. **Requires nosepiece No. M96028 when using the Marson brand Big Daddy® or Big Daddy II hand tool. ***Use 39112 Trim Clip Rivet Nosepieces with HP-2 or HP-5 to form trim clip studs with 50261, 50262 and 50516 rivets.



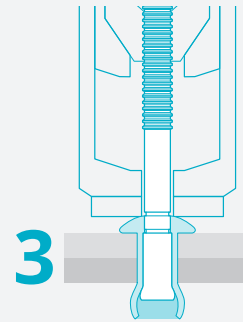
Klik-Lock®



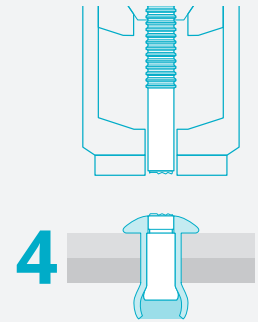
1 After drilling hole to proper diameter, rivet is placed into hole and rivet setting tool is placed over mandrel.



2 Actuating tool starts mandrel into rivet body, pulling work material together and expanding body on the blind side.



3 Solid circle lock is created between the body and mandrel, creating a weather-resistant assembly that virtually eliminates pin pushout.



4 After the mandrel is broken, the mandrel is flush with the rivet body, removing the need for grinding. The expansion of the body tightly fills the hole, creating a weather-resistant joint.

Steel • IFI Grade 19

HFS DESCRIPTION	BULK PART NO.**	GRIP RANGE		A RIVET DIA. INCH		REQUIRED HOLE SIZE		B HEAD DIA.		C HEAD HEIGHT MAX		D BODY LENGTH MAX		E OVERALL LENGTH MAX		F LENGTH MIN		AVERAGE STRENGTH		AVERAGE STRENGTH	
		IN	MM	IN	MM	IN	MM	IN	MM	IN	MM	IN	MM	IN	MM	IN	MM	SHEAR LBS	TENSILE LBS	N	N
		SHEAR LBS		TENSILE LBS		N		N													
Steel Rivet • Steel Mandrel • Buttonhead																					
SB6-4KL	M50807	.062-.270	1.57-6.85	.187	4.8	.191-.201	4.9-5.10	.385	9.77	.085	2.15	.415	10.45	.733	15.87	.980	23.06	1450	6499	1200	5338
SB6-7KL	M50808	.214-.437	5.43-11.09									.582	14.78	.892	22.66	.968	24.39				
SB6-EKL	M50809	.062-.437	1.57-11.09									.582	14.78	1.031	26.19	.991	25.17				
SB8-6KL	M50810	.080-.375	2.03-9.52	.253	6.5	.261-.272	6.6-6.9	.530	13.46	.120	3.05	.560	14.62	.984	24.99	1.043	26.49	2750	12233	2200	9786
SB8-10KL	M50811	.350-.625	8.89-15.75									.810	20.57	1.234	31.34	1.043	26.49				
SB8-EKL	M50812	.080-.625	2.03-15.87									.810	20.57	1.419	36.04	1.043	26.49				
Large Flange																					
SBL6-4KL	M50813	.062-.270	1.57-6.85	.187	4.8	.191-.201	4.9-5.1	.530	13.46	.095	2.41	.415	10.45	.733	18.62	.973	24.71	1450	6499	1200	5338
SBL6-EKL	M50814	.062-.437	1.57-11.09									.582	14.78	1.031	26.19	.984	24.99				
SBL8-6KL	M50815	.80-.375	2.03-9.52	.253	6.4	.261-.272	6.6-6.9	.592	15.04	.120	3.05	.560	14.62	.984	24.99	1.043	26.49	2750	12233	2200	9786
100° Countersunk																					
SC6-6KL	M50816	.125-.331	3.17-8.40	.187	4.8	.191-.201	4.9-5.1	.350	8.9	.080	2.03	.490	12.45	.809	20.55	.987	25.07	1450	6499	1200	5338
SC6-9KL	M50818	.305-.500	7.74-12.70									.660	16.76	.968	24.59	.975	24.77				
SC8-8KL	M50819	.160-.475	4.06-12.06	.253	6.4	.261-.272	6.6-6.9	.410	10.4	.090	2.29	.665	16.89	1.089	27.66	1.055	26.80	2750	12233	2200	9786
SC8-12KL	M50820	.415-.725	10.54-18.41									.915	23.24	1.339	34.01	1.055	26.80				

Klik-Lock®

Stainless Steel • IFI Grade 19

HFS DESCRIPTION	BULK PART NO.**	GRIP RANGE		A RIVET DIA. INCH		REQUIRED HOLE SIZE		B HEAD DIA.		C HEAD HEIGHT MAX		D BODY LENGTH MAX		E OVERALL LENGTH MAX		F LENGTH MIN		AVERAGE STRENGTH		AVERAGE STRENGTH	
		IN	MM	IN	MM	IN	MM	IN	MM	IN	MM	IN	MM	IN	MM	IN	MM	SHEAR		TENSILE	
																		LBS	N	LBS	N
Stainless Rivet • Stainless Mandrel • Buttonhead																					
SSB6-4SKL	M50833	.062-.270	1.57-6.85	.187	4.8	.191-.201	4.9-5.1	.385	9.8	.085	2.15	.415	10.54	.773	15.87	.980	23.06	1400	6228	1100	4893
SSB6-7SKL	M50834	.214-.437	5.43-11.09									.582	14.78	.892	22.66	.968	24.39				
SSB6-ESKL	M50835	.062-.437	1.57-11.09									.582	14.78	1.031	26.19	.991	25.17				
SSB8-6SKL	M50836	.080-.375	2.03-9.52	.253	6.5	.261-.272	6.6-6.9	.530	13.46	.120	3.05	.560	14.62	.984	24.99	1.043	26.49	2500	11121	2000	8896
SSB8-10SKL	M50837	.350-.625	8.89-15.87									.810	20.57	1.234	31.34	1.043	26.49				
100° Countersunk																					
SSC6-6SKL	M50838	.125-.331	3.17-8.40	.187	4.8	.191-.201	4.9-5.1	.350	8.8	.080	1.8	.490	12.45	.809	20.55	.987	25.07	1400	6228	1100	4893
SSC8-8SKL	M50839	.160-.475	4.06-12.06	.253	6.5	.261-.272	6.6-6.9	.410	10.4	.090	2.29	.665	14.62	1.089	27.66	1.055	26.80				

5056 Aluminum • IFI Grade 19

Aluminum Rivet • Aluminum Mandrel • Buttonhead																					
AB6-4AKL	M50821	.062-.270	1.57-6.85	.187	4.8	.191-.201	4.9-5.1	.385	9.8	.085	2.15	.415	10.54	.733	15.87	.980	23.06	700	3114	580	2580
AB6-7AKL	M50822	.214-.437	5.43-11.09									.582	14.78	.892	22.66	.968	24.39				
AB6-AEKL	M50823	.062-.437	1.57-11.09									.582	14.78	1.031	26.19	.991	25.17				
AB8-6AKL	M50824	.080-.375	2.03-9.52	.253	6.4	.261-.272	6.6-6.9	.530	13.46	.120	3.05	.560	14.62	.984	24.99	1.043	26.49	1300	5783	950	4226
AB8-10AKL	M50825	.350-.625	8.89-15.87									.810	20.57	1.234	31.34	1.013	26.49				
AB8-AEKL	M50826	.080-.625	2.03-15.87									.810	20.57	1.419	36.04	1.043	26.49				
Aluminum / Large Flange																					
ABL6-4AKL	M50827	.062-.270	1.57-6.85	.187	4.8	.191-.201	4.9-5.1	.530	13.46	.085	2.15	.415	10.45	.733	15.87	.973	24.71	700	3114	580	2580
ABL6-7AKL	M50828	.214-.437	5.43-11.09									.572	14.52	.892	22.66	.984	24.99				
Aluminum / 100° Countersunk																					
AC6-6AKL	M50829	.125-.331	3.17-8.40	.187	4.8	.191-.201	4.9-5.1	.350	8.9	.080	1.8	.490	12.45	.809	20.55	.987	25.07	700	3114	580	2580
AC6-9AKL	M50830	.305-.500	7.74-12.70									.660	16.76	.968	24.09	.975	24.77				
AC8-8AKL	M50831	.160-.475	4.06-12.06	.253	6.4	.261-.272	6.6-6.9	.410	10.4	.090		.665	16.89	1.089	27.66	1.055	26.80	1300	5783	950	4226
AC8-12AKL	M50832	.415-.725	10.54-18.41									.915	23.24	1.339	34.01	1.055	26.80				

Pin Retention Values

SIZE	STEEL LBS.	ALUMINUM LBS.	STAINLESS STEEL LBS.
3/16"	300	50	125
1/4"	500	100	250



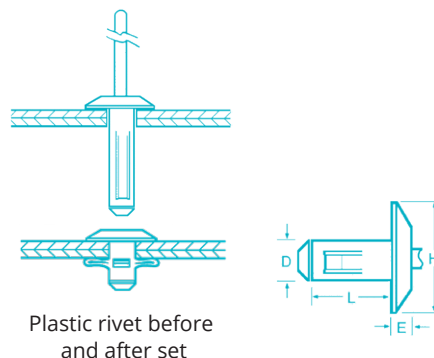
Material and Finish

MATERIAL	SLEEVE	PIN	SLEEVE FINISH	PIN FINISH
Steel	Low	Medium	Zinc Plated	Zinc Plated Clear Trivalent Chromate
	Carbon Steel	Carbon Steel	Clear Chromate	Zinc Plated Clear Trivalent Chromate
Aluminum	5056	7075	Clear Chromate	Clear Trivalent Chromate
Stainless	302	305 / 304	Passivated	Dry Lubricated

**Also available in packaged quantities.

Plastic

Marson brand Klik-Lock Plastic Rivets are the same precision-molded all-nylon rivets used by domestic auto manufacturers, both for original equipment and replacement parts. In addition, Klik-Lock Plastic Rivets are ideal for non-conductive and non-corrosive environments. Klik-Lock Plastic Rivets fasten plastic to plastic, plastic to metal and plastic to fiberglass. As they set, three "legs" form to securely lock the components in place and prevent pullout.

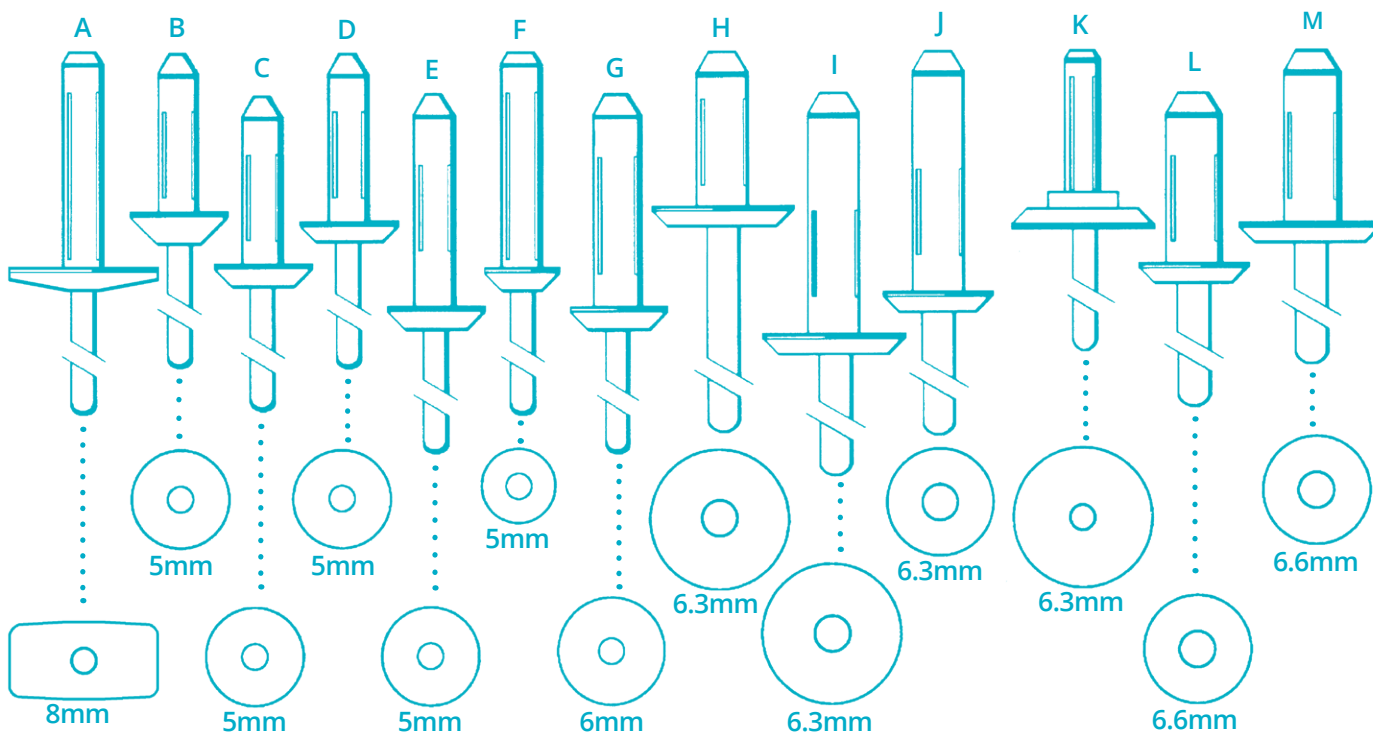


Klik-Lock® Plastic Rivets • Nylon Body ST801HS • Delrin 500 Mandrel

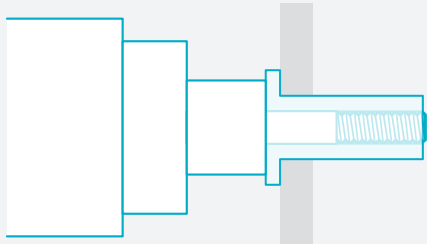
DIAGRAM REFERENCE	100-PACK PART NO.*	GRIP RANGE		D RIVET DIA. NOM INCH	HOLE SIZE		H HEAD DIA.		E HEAD HEIGHT		RIVET LENGTH		TYPICAL ULTIMATE STRENGTH			
		IN	MM		IN	MM	IN	MM	IN	MM	IN (MAX)	MM	SHEAR		TENSILE	
														LBS	N	LBS
A	M48286	.236 - .413	6.0 - 10.5	.154	.156	4	.315	8	.098	2.5	1.024	20	40	178	82	365
B	M48305	.059 - .177	1.5 - 4.5	.195	.197	5	.472	12	.130	3.3	.728	18.5	68	302	120	534
C	M48306	.118 - .236	3.0 - 6.0	.195	.197	5	.472	12	.071	1.8	.787	20	68	302	120	534
D	M48307	.118 - .177	3.0 - 4.5	.195	.197	5	.472	12	.071	1.8	.787	20	68	302	120	534
E	M48308	.236 - .394	6.0 - 10.0	.195	.197	5	.472	12	.071	1.8	.984	25	68	302	120	534
F	M48309	.118 - .157	3.0 - 4.0	.195	.197	5	.354	9	.071	1.8	.650	16.5	68	302	120	534
G	M48330	.157 - .335	4.0 - 8.5	.234	.236	6.0	.512	13	.098	2.5	1.102	28	110	489	181	805
H	M48349	.157 - .236	4.0 - 6.0	.246	.250	6.3	.669	17	.098	2.5	.709	18	121	538	194	863
I	M48350	.157 - .394	4.0 - 10.0	.246	.250	6.3	.669	17	.098	2.5	1.102	28	121	538	194	863
J	M48351	.157 - .394	4.0 - 10.0	.246	.250	6.3	.512	13	.098	2.5	1.102	28	121	538	194	863
K	M48354	.028 - .178	.7 - 4.5	.246	.250	6.3	.670	17	.098	2.5	.682	17.3	121	538	194	863
L	M48385	.098 - .197	2.5 - 5.0	.258	.260	6.6	.512	13	.098	2.5	.787	20	137	609	219	974
M	M48386	.098 - .197	2.5 - 5.0	.258	.260	6.6	.709	18	.098	2.5	.787	20	137	609	219	974

* Also available in bulk 2,000/ctn and visual boxes, 20/pkg.

Actual Size Rivets / Flanges When ordering, match diagram reference letter with those in above chart.

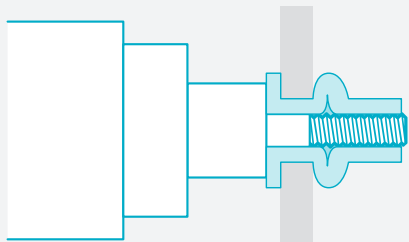


Rivet Nuts



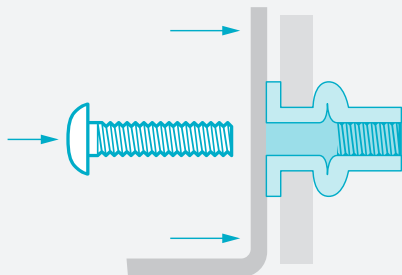
Thread Rivet Nut onto tool mandrel and insert into hole.

1



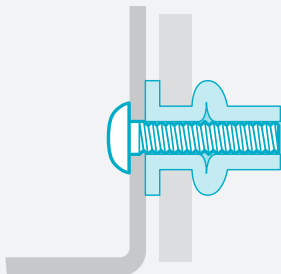
Actuate tool to properly set fastener into material.

2



Complete your fastening operation with a bolt or screw with the proper thread.

3



The positive riveting action of the Klik Rivet Nut will provide a permanent thread. As threads are tightened, so are Rivet Nut and application.

4

More Styles, Sizes and Tools to Fit Your Application Needs

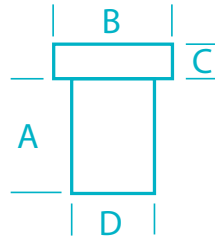
Marson Rivet Nuts deliver low cost, permanent thread placement in thin material while providing at least six full thread turns per application install. Easy installation can be completed by one operator with minimum training. Blindside access is not required when installing Marson Rivet Nuts. Ideal for painted surfaces, Marson Rivet Nuts help increase production and reduce rework by eliminating the surface damage that can occur with other fastening methods. Rivet Nuts can be used to fasten multiple sheets as well as single sheets.



Styles	Features / Benefits	Materials Available
MRN Series 	Rivet Nut, Flathead Flange (thick wall) for applications that require heavy push out loads (recommend spin-pull tool)	Steel, Aluminum
MPN Series 	Poly-Nut Rivet Nut has very small flange, lowest profile for near countersink applications	Steel, Aluminum
MTS Series 	Thread-Sert has small flange, 360 degree swaging action in the hole and no maximum grip range	Steel, Aluminum
MLR Series 	Large Flange Ribbed Rivet Nut provides increased turn-out resistance versus conventional rivet nut and large flange for improved push out performance	Steel, Aluminum
MLC Series 	Large Flange Ribbed Rivet Nut with Closed End for thread seal	Steel, Aluminum
MSR Series 	Small Flange low profile Ribbed Rivet Nut for virtually flush install with increased turn-out resistance versus conventional low profile Poly-Nut	Steel, Aluminum
MSC Series 	Small Flange low profile Ribbed Rivet Nut with Closed End for thread seal	Steel, Aluminum
MHN Series 	Large Flange Half Hex Rivet Nut for hex hole to provide exceptional turn-out resistance	Steel
MQN Series 	Quad-Leg Rivet Nut used for light duty thin or soft / brittle material – will accommodate slightly oversized hole with large back side footprint	Steel
MXN Series 	Large Flange Cross Bulb Rivet Nut large grip range with pre-bulb and 4 slots cut to provide large blindside footprint for greater pull out strength in thin sheet metal and plastics	Steel
MET Series 	External Thread Stud Rivet Nut allows for component mounting and mate nut	Steel
MNN Series 	Neoprene Insert with pre-molded brass nut for quick fastening in vibration and moisture resistant applications	Neoprene

MRN Series

MRN — Rivet Nut, Flathead Flange provides the most bearing surface for applications that require heavy push out loads and high torque for use in metal, fiberglass and rigid plastics too thin for tapped holes. Spin/Pull tool is recommended although smaller thread sizes can utilize a manual tool. Available in Steel-Zinc Plated or Aluminum.



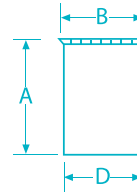
MRN Series Flathead Rivet Nut (Thick Wall)

THREAD SIZE	GRIP RANGE		STEEL BULK PART #*	ALUMINUM BULK PART #*	A	B	C	D	HOLE SIZE		DRILL SIZE
	MIN	MAX			BODY LENGTH ±.015"	HEAD DIA. ±.015"	HEAD HEIGHT (NOM)	BODY DIA. MAX	MIN	MAX	
6-32	.010	.075	M57110	M57210	.438	.325	.032	.189	.189	.193	#12
8-32	.010	.075	M57120	M57220	.438	.357	.032	.221	.221	.226	#2
8-32	.075	.120	M57121	M57221	.500	.357	.032	.221	.221	.226	#2
10-24	.010	.080	M57130	M57230	.531	.406	.038	.250	.250	.254	1/4
10-24	.080	.130	M57132	M57232	.594	.406	.038	.250	.250	.254	1/4
10-32	.010	.080	M57140	M57240	.531	.406	.038	.250	.250	.254	1/4
10-32	.080	.130	M57142	M57242	.594	.406	.038	.250	.250	.254	1/4
1/4-20	.020	.080	M57150	M57250	.625	.475	.058	.332	.332	.338	Q (.332)
1/4-20	.080	.140	M57152	M57252	.687	.475	.058	.332	.332	.338	Q (.332)
1/4-20	.140	.200	M57154	M57254	.750	.475	.058	.332	.332	.338	Q (.332)
5/16-18	.030	.125	M57171	M57271	.750	.665	.062	.413	.413	.423	Z (.423)
5/16-18	.125	.200	M57174	M57274	.875	.665	.062	.413	.413	.423	Z (.423)
3/8-16	.030	.115	M57181	M57281	.844	.781	.088	.490	.490	.500	1/2
3/8-16	.115	.200	M57184	M57284	.938	.781	.088	.490	.490	.500	1/2

* Also available in small packaged quantities.
Inch sizes are class 2B thread.

MPN and MTS Series

MPN — Poly-Rivet Nut has very small flange and the lowest profile for near flush installation. Eliminates additional operations of countersinking or dimpling of the parent material. May install with all pneumatic and manual Rivet Nut tools. Available in Steel-Zinc Plated or Aluminum.

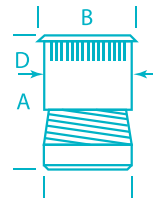


MPN Series Poly-Rivet Nut

THREAD SIZE	GRIP RANGE MIN - MAX	STEEL BULK PART #*	ALUMINUM BULK PART #*	A	B	C	D	HOLE SIZE MIN - MAX	DRILL SIZE
				BODY LENGTH ±.015 ± 0.38 MM	HEAD DIA. ± .015 ± 0.38 MM	HEAD HEIGHT ± .005 ± .0127 MM	BODY DIA. +0 -.005 TO -.0127 MM		
6-32	.020-.080	M57415	M57510	.410	.287	.017	.249	.250-.254	1/4
8-32	.020-.080	M57425	M57520	.410	.287	.017	.249	.250-.254	1/4
10-24	.020-.130	M57435	M57530	.465	.320	.020	.280	.281-.285	9/32
10-32	.020-.130	M57445	M57540	.465	.320	.020	.280	.281-.285	9/32
1/4-20	.030-.165	M57455	M57550	.591	.415	.020	.374	.375-.379	3/8
5/16-18	.030-.165	M57475	M57575	.720	.540	.024	.499	.500-.504	1/2
3/8-16	.030-.165	M57485	M57585	.720	.540	.024	.499	.500-.504	1/2
4 mm	.50-2.03	M57407	N/A	10.41	7.29	0.43	6.32	6.35 -6.45	6.35
5 mm	.50-3.30	M57409	N/A	11.81	8.13	.61	7.11	7.14-7.23	7.14
6 mm	.76-4.19	M57411	N/A	15.01	10.54	.61	9.50	9.52-9.62	9.52
8 mm	.76-4.19	M57413	N/A	18.29	13.72	.61	12.67	12.7-12.8	12.7
10 mm**	.76-4.19	M57414	N/A	18.29	13.72	.61	12.67	12.7-12.8	12.7

* Also available in small packaged quantities. ** Limited availability, minimums may apply. Inch sizes are class 2B thread. Metric sizes are class 6H thread.

MTS — Thread-Sert® fasteners have a small flange and 360 degree swaging action as the Rivet Nut expands inside the hole. Provides high resistance to torque-out with minimal backside protrusion. Can be installed in blind hole with unlimited maximum grip range. May install with all pneumatic and manual Rivet Nut tools. Available in Steel-Zinc Plated or Aluminum.



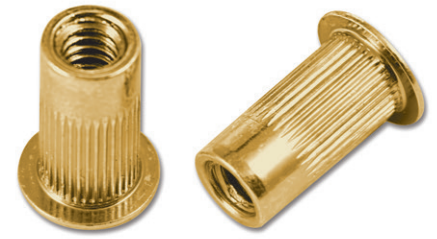
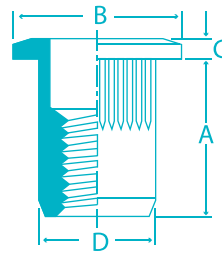
MTS Series Thread-Sert®

THREAD SIZE	STEEL BULK PART #*	ALUMINUM BULK PART #*	A**	B	D**	MATERIAL THICKNESS .0937-.1562		MATERIAL THICKNESS .1562- INFINITY	
			BODY LENGTH ±.005"	HEAD DIA. ±.005"	BODY DIA. ±.002"	HOLE SIZE	DRILL SIZE	HOLE SIZE	DRILL SIZE
6-32	M57810	M57910	.375	.250	.215	.221	# 2	.234	A (.234)
8-32	M57820	M57920	.375	.282	.246	.250	1/4	.261	G (.261)
10-24	M57830	M57930	.375	.314	.277	.281	9/32	.290	L (.290)
10-32	M57840	M57940	.375	.314	.277	.281	9/32	.290	L (.290)
1/4-20	M57850	M57950	.510	.408	.372	.391	3/8	.376	25/64
5/16-18	M57871	M57971	.615	.537	.496	.500	1/2	.516	33/64
3/8-16	M57881	M57981	.740	.600	.559	.562	9/16	.578	37/64

* Also available in small packaged quantities. ** A and D dimensions are prior to setting. Inch sizes are class 2B thread.

MLR Series

MLR — Large Flange Ribbed Rivet Nuts feature ribbed external body for increased torque-out resistance versus conventional Rivet Nut. Large flange offers improved push out performance. Overall MLR offers the best and highest strength levels. May install with all pneumatic and manual Rivet Nut tools. Available in Steel-Zinc Plated or Aluminum.



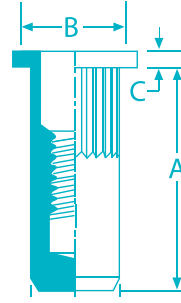
MLR Series Large Flange Ribbed Low-Profile Rivet Nut

THREAD SIZE	GRIP RANGE MIN-MAX	STEEL BULK PART #*	ALUMINUM BULK PART #*	A	B	C	D	HOLE SIZE MIN-MAX	DRILL SIZE
				BODY LENGTH ±.015" ± 0.38 MM	HEAD DIA. ±.010" ± 0.254 MM	HEAD HEIGHT ±.003" ± 0.76 MM	BODY DIA. MAX		
6-32	.020 - .080	M57310	M57610	.420	.390	.030	.265	.265 - .271	17/64
6-32	.080 - .130	M57312	M57612	.470	.390	.030	.265	.265 - .271	17/64
8-32	.020 - .080	M57320	M57618	.420	.390	.030	.265	.265 - .271	17/64
8-32	.080 - .130	M57321	M57621	.470	.390	.030	.265	.296 - .302	17/64
10-24	.020 - .130	M57330	M57630	.475	.415	.030	.296	.296 - .302	19/64
10-24	.130 - .225	M57332	M57632	.585	.415	.030	.296	.296 - .302	19/64
10-32	.020 - .130	M57340	M57640	.475	.415	.030	.296	.296 - .302	19/64
10-32	.130 - .225	M57342	M57642	.585	.415	.030	.296	.296 - .302	19/64
1/4-20	.027 - .165	M57350	M57650	.580	.500	.030	.390	.390 - .396	25/64
1/4-20	.165 - .260	M57354	M57654	.680	.500	.030	.390	.390 - .396	25/64
1/4-28	.027 - .165	M57358	M57658	.580	.500	.030	.390	.390 - .396	25/64
1/4-28	.165 - .260	M57359	M57659	.680	.500	.030	.390	.390 - .396	25/64
5/16-18	.027 - .150	M57371	M57671	.690	.685	.035	.530	.530 - .536	17/32
5/16-18	.150 - .312	M57374	M57674	.805	.685	.035	.530	.530 - .536	17/32
5/16-24	.027 - .150	M57378	M57678	.690	.685	.035	.530	.530 - .536	17/32
5/16-24	.150 - .312	M57379	M57679	.805	.685	.035	.530	.530 - .536	17/32
3/8-16	.027 - .150	M57381	M57681	.690	.685	.035	.530	.530 - .536	17/32
3/8-16	.150 - .312	M57382	M57682	.805	.685	.035	.530	.530 - .536	17/32
3/8-24	.027 - .150	M57395	M57695	.690	.685	.035	.530	.530 - .536	17/32
3/8-24	.150 - .312	M57396	M57696	.805	.685	.035	.530	.530 - .536	17/32
M4x.07	.5 - 2.0	M57360	M57660	10.67	9.91	.76	6.73	6.75 + .15	6.75
M4x.07	2.0 - 3.3	M57365	M57665	11.94	9.91	.76	6.73	6.75 + .15	6.75
M5x0.8	.5 - 3.3	M57385	M57684	12.07	10.54	.76	7.52	7.6 + .15	7.6
M5x0.8	3.3 - 5.7	M57384	M57685	14.86	10.54	.76	7.52	7.6 + .15	7.6
M6x1.0	.7 - 4.2	M57386	M57686	14.73	12.7	.76	9.91	10.0 + .15	10.0
M6x1.0	4.2 - 6.6	M57387	M57687	17.27	12.7	.76	9.91	10.0 + .15	10.0
M8x1.25	.7 - 3.8	M57388	M57688	17.53	17.4	.89	13.46	13.5 + .15	13.5
M8x1.25	3.8 - 7.9	M57389	M57689	20.45	17.4	.89	13.46	13.5 + .15	13.5
M10x1.5	.7 - 3.8	M57390	M57690	17.53	17.4	.89	13.46	13.5 + .15	13.5
M10x1.5	3.8 - 7.9	M57391	M57691	20.45	17.4	.89	13.46	13.5 + .15	13.5

* Also available in small packaged quantities. Inch sizes are class 2B thread. Metric sizes are class 6H thread.

MLC Series

MLC — Large Flange Ribbed Rivet Nuts are the same as MLR with Closed End for complete thread seal. Use in moisture resistant applications. May install with all pneumatic and manual Rivet Nut tools. Available in Steel-Zinc Plated or Aluminum.



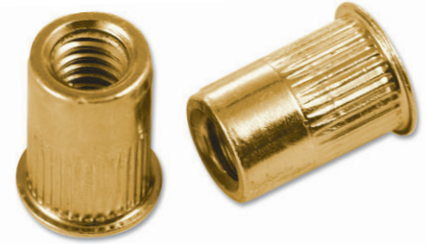
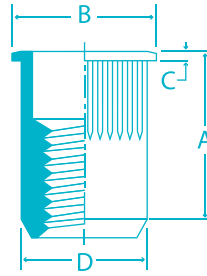
MLC Series Large Flange Closed End Ribbed Rivet Nut

THREAD SIZE	GRIP RANGE MIN-MAX	STEEL BULK PART #*	ALUMINUM BULK PART #*	A	B	C	D	HOLE SIZE MIN-MAX	DRILL SIZE
				BODY LENGTH ±.015" ± 0.38 MM	HEAD DIA. ±.010" ± 0.254 MM	HEAD HEIGHT ±.003" ± 0.76 MM	BODY DIA. MAX		
6-32"	.020 - .080	M27310	M37310	.740	.390	.030	.265	.265 - .271	17/64
6-32"	.080 - .130	M27312	M37312	.740	.390	.030	.265	.265 - .271	17/64
8-32"	.020 - .080	M27320	M37320	.740	.390	.030	.265	.265 - .271	17/64
8-32"	.080 - .130	M27321	M37321	.740	.390	.030	.265	.296 - .302	17/64
10-24"	.020 - .130	M27330	M37330	.990	.415	.030	.296	.296 - .302	19/64
10-24"	.130 - .225	M27332	M37332	.990	.415	.030	.296	.296 - .302	19/64
10-32"	.020 - .130	M27340	M37340	.990	.415	.030	.296	.296 - .302	19/64
10-32"	.130 - .225	M27342	M37342	.990	.415	.030	.296	.296 - .302	19/64
1/4-20"	.027 - .165	M27350	M37350	1.190	.500	.030	.390	.390 - .396	25/64
1/4-20"	.165 - .260	M27354	M37354	1.190	.500	.030	.390	.390 - .396	25/64
1/4-28"	.027 - .165	M27358	M37358	1.190	.500	.030	.390	.390 - .396	25/64
1/4-28"	.165 - .260	M27359	M37359	1.190	.500	.030	.390	.390 - .396	25/64
5/16-18"	.027 - .150	M27371	M37371	1.390	.685	.035	.530	.530 - .536	17/32
5/16-18"	.150 - .312	M27374	M37374	1.390	.685	.035	.530	.530 - .536	17/32
5/16-24"	.027 - .150	M27378	M37378	1.390	.685	.035	.530	.530 - .536	17/32
5/16-24"	.150 - .312	M27379	M37379	1.390	.685	.035	.530	.530 - .536	17/32
3/8-16"	.027 - .150	M27381	M37381	1.390	.685	.035	.530	.530 - .536	11/16
3/8-16"	.150 - .312	M27382	M37382	1.390	.685	.035	.530	.530 - .536	11/16
3/8-24"	.027 - .150	M27395	M37395	1.390	.685	.035	.530	.530 - .536	11/16
3/8-24"	.150 - .312	M27396	M37396	1.390	.685	.035	.530	.530 - .536	11/16
M4x.07"	.5 - 2.0	M27360	M37360	18.8	9.91	.76	6.73	6.75 + .15	6.75
M4x.07"	2.0 - 3.3	M27365	M37365	18.8	9.91	.76	6.73	6.75 + .15	6.75
M5x0.8"	.5 - 3.3	M27385	M37385	25.15	10.54	.76	7.52	7.6 + .15	7.60
M5x0.8"	3.3 - 5.7	M27384	M37384	25.15	10.54	.76	7.52	7.6 + .15	7.60
M6x1.0"	.7 - 4.2	M27386	M37386	30.23	12.7	.76	9.91	10.0 + .15	10.00
M6x1.0"	4.2 - 6.6	M27387	M37387	30.23	12.7	.76	9.91	10.0 + .15	10.00
M8x1.25"	.7 - 3.8	M27388	M37388	35.31	17.4	.89	13.46	13.5 + .15	13.50
M8x1.25"	3.8 - 7.9	M27389	M37389	35.31	17.4	.89	13.46	13.5 + .15	13.50
M10x1.5"	.7 - 3.8	M27390	M37390	35.31	17.4	.89	13.46	13.5 + .15	13.50
M10x1.5"	3.8 - 7.9	M27391	M37391	35.31	17.4	.89	13.46	13.5 + .15	13.50

* Also available in small packaged quantities. ** Limited availability, minimums may apply. Inch sizes are class 2B thread. Metric sizes are class 6H thread.

MSR Series

MSR — Small Flange low profile Ribbed Rivet Nut for virtually flush installation with ribbed external body for increased torque-out resistance versus conventional low profile Poly-Nut. May install with all pneumatic and manual Rivet Nut tools. Available in Steel-Zinc Plated, Aluminum, or Stainless Steel.



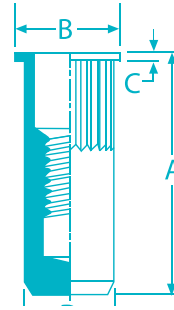
MSR Series Small Flange Low Profile Ribbed Rivet Nut

THREAD SIZE	GRIP RANGE MIN-MAX	STEEL BULK PART #*	ALUMINUM BULK PART #*	A	B	C	D	HOLE SIZE MIN-MAX	DRILL SIZE
				BODY LENGTH ±.015" ± 0.38 MM	HEAD DIA. ±.010" ± 0.254 MM	HEAD HEIGHT ±.003" ± 0.76 MM	BODY DIA. MAX		
6-32	.020 - .080	M56810	M56910	.420	.310	.019	.265	.265 - .271	17/64
6-32	.080 - .130	M56812	M56912	.470	.310	.019	.265	.265 - .271	17/64
8-32	.020 - .080	M56820	M56920	.420	.310	.019	.265	.265 - .271	17/64
8-32	.080 - .130	M56821	M56921	.470	.310	.019	.265	.296 - .302	17/64
10-24	.020 - .130	M56830	M56930	.475	.340	.019	.296	.296 - .302	19/64
10-24	.130 - .225	M56832	M56932	.585	.340	.019	.296	.296 - .302	19/64
10-32	.020 - .130	M56840	M56940	.475	.340	.019	.296	.296 - .302	19/64
10-32	.130 - .225	M56842	M56942	.585	.340	.019	.296	.296 - .302	19/64
1/4-20	.027 - .165	M56850	M56950	.580	.455	.022	.390	.390 - .396	25/64
1/4-20	.165 - .260	M56854	M56954	.680	.455	.022	.390	.390 - .396	25/64
1/4-28	.027 - .165	M56858	M56958	.580	.455	.022	.390	.390 - .396	25/64
1/4-28	.165 - .260	M56859	M56959	.680	.455	.022	.390	.390 - .396	25/64
5/16-18	.027 - .150	M56871	M56971	.690	.595	.022	.530	.530 - .536	17/32
5/16-18	.150 - .312	M56874	M56974	.805	.595	.022	.530	.530 - .536	17/32
5/16-24	.027 - .150	M56878	M56978	.690	.595	.022	.530	.530 - .536	17/32
5/16-24	.150 - .312	M56879	M56979	.805	.595	.022	.530	.530 - .536	17/32
3/8-16	.027 - .150	M56881	M56981	.690	.595	.022	.530	.530 - .536	17/32
3/8-16	.150 - .312	M56882	M56982	.805	.595	.022	.530	.530 - .536	17/32
3/8-24	.027 - .150	M56895	M56995	.690	.595	.022	.530	.530 - .536	17/32
3/8-24	.150 - .312	M56896	M56996	.805	.595	.022	.530	.530 - .536	17/32
M4x.07	.5 - 2.0	M56860	M56960	10.67	7.87	.48	6.73	6.75 + .15	6.75
M4x.07	2.0 - 3.3	M56865	M56965	11.94	7.87	.48	6.73	6.75 + .15	6.75
M5x0.8	.5 - 3.3	M56884	M56984	12.07	8.64	.48	7.52	7.6 + .15	7.60
M5x0.8	3.3 - 5.7	M56885	M56985	14.86	8.64	.48	7.52	7.6 + .15	7.60
M6x1.0	.7 - 4.2	M56886	M56986	14.73	11.56	.55	9.91	10.0 + .15	10.00
M6x1.0	4.2 - 6.6	M56887	M56987	17.27	11.56	.55	9.91	10.0 + .15	10.00
M8x1.25	.7 - 3.8	M56888	M56988	17.53	15.11	.55	13.46	13.5 + .15	13.50
M8x1.25	3.8 - 7.9	M56889	M56989	20.45	15.11	.55	13.46	13.5 + .15	13.50
M10x1.5	.7 - 3.8	M56890	M56990	17.53	15.11	.55	13.46	13.5 + .15	13.50
M10x1.5	3.8 - 7.9	M56891	M56991	20.45	15.11	.55	13.46	13.5 + .15	13.50

* Also available in small packaged quantities. Inch sizes are class 2B thread. Metric sizes are class 6H thread.

MSC Series

MSC — Small Flange Ribbed Rivet Nut is the same as MSR with Closed End for complete thread seal. For use in moisture resistant applications. May install with all pneumatic and manual Rivet Nut tools. Available in Steel-Zinc Plated or Aluminum.



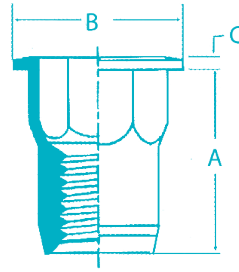
MSC Series Small Flange Closed End Ribbed Rivet Nut (Built to order, minimums required)

THREAD SIZE	GRIP RANGE MIN-MAX	STEEL BULK PART #*	ALUMINUM BULK PART #*	A	B	C	D	HOLE SIZE MIN-MAX	DRILL SIZE
				BODY LENGTH ±.015" ± 0.38 MM	HEAD DIA. ±.010" ± 0.254 MM	HEAD HEIGHT ±.003" ± 0.76 MM	BODY DIA. MAX		
6-32	.020 - .080	M26810	M36910	.740	.310	.019	.265	.265 - .271	17/64
6-32	.080 - .130	M26812	M36912	.740	.310	.019	.265	.265 - .271	17/64
8-32	.020 - .080	M26820	M36920	.740	.310	.019	.265	.265 - .271	17/64
8-32	.080 - .130	M26821	M36921	.740	.310	.019	.265	.296 - .302	17/64
10-24	.020 - .130	M26830	M36930	.990	.340	.019	.296	.296 - .302	19/64
10-24	.130 - .225	M26832	M36932	.990	.340	.019	.296	.296 - .302	19/64
10-32	.020 - .130	M26840	M36940	.990	.340	.019	.296	.296 - .302	19/64
10-32	.130 - .225	M26842	M36942	.990	.340	.019	.296	.296 - .302	19/64
1/4-20	.027 - .165	M26850	M36950	1.190	.455	.022	.390	.390 - .396	25/64
1/4-20	.165 - .260	M26854	M36954	1.190	.455	.022	.390	.390 - .396	25/64
1/4-28	.027 - .165	M26858	M36958	1.190	.455	.022	.390	.390 - .396	25/64
1/4-28	.165 - .260	M26859	M36959	1.190	.455	.022	.390	.390 - .396	25/64
5/16-18	.027 - .150	M26871	M36971	1.390	.595	.022	.530	.530 - .536	17/32
5/16-18	.150 - .312	M26874	M36974	1.390	.595	.022	.530	.530 - .536	17/32
5/16-24	.027 - .150	M26878	M36978	1.390	.595	.022	.530	.530 - .536	17/32
5/16-24	.150 - .312	M26879	M36979	1.390	.595	.022	.530	.530 - .536	17/32
3/8-16	.027 - .150	M26881	M36981	1.390	.595	.022	.530	.530 - .536	17/32
3/8-16	.150 - .312	M26882	M36982	1.390	.595	.022	.530	.530 - .536	17/32
3/8-24	.027 - .150	M26895	M36995	1.390	.595	.022	.530	.530 - .536	17/32
3/8-24	.150 - .312	M26896	M36996	1.390	.595	.022	.530	.530 - .536	17/32
M4x.07	.5 - 2.0	M26860	M36960	18.8	7.87	.48	6.73	6.75 + .15	6.75
M4x.07	2.0 - 3.3	M26865	M36965	18.8	7.87	.48	6.73	6.75 + .15	6.75
M5x0.8	.5 - 3.3	M26884	M36984	25.15	8.64	.48	7.52	7.6 + .15	7.60
M5x0.8	3.3 - 5.7	M26885	M36985	25.15	8.64	.48	7.52	7.6 + .15	7.60
M6x1.0	.7 - 4.2	M26886	M36986	30.23	11.56	.55	9.91	10.0 + .15	10.00
M6x1.0	4.2 - 6.6	M26887	M36987	30.23	11.56	.55	9.91	10.0 + .15	10.00
M8x1.25	.7 - 3.8	M26888	M36988	35.31	15.11	.55	13.46	13.5 + .15	13.50
M8x1.25	3.8 - 7.9	M26889	M36989	35.31	15.11	.55	13.46	13.5 + .15	13.50
M10x1.5	.7 - 3.8	M26890	M36990	35.31	15.11	.55	13.46	13.5 + .15	13.50
M10x1.5	3.8 - 7.9	M26891	M36991	35.31	15.11	.55	13.46	13.5 + .15	13.50

*Also available in small packaged quantities. Inch sizes are class 2B thread. Metric sizes are class 6H thread.

MHN Series

MHN — Large Flange Half Hex Rivet Nut provides exceptional torque-out strength and superior vibration resistance as the Rivet Nut external flat sides engage the hex cut opening. May be installed with all pneumatic and manual Rivet Nut tools. Available in Steel-Zinc Plated Threads.



MHN Series Large Flange Half Hex Rivet Nut

THREAD SIZE	GRIP RANGE MIN-MAX	STEEL BULK PART #*	A	B	C	D	HEX HOLE ACROSS FLATS +.004"-.000"
			BODY LENGTH ±.015" ± 0.38 MM	HEAD DIA. ±.010" ± 0.254 MM	HEAD HEIGHT ±.003" ± 0.76 MM	BODY DIA. MAX	
6-32	.020 - .080	M52610	.385	.375	.027	.249	.250
6-32	.080 - .130	M52612	.435	.375	.027	.249	.250
8-32	.020 - .080	M52620	.385	.375	.027	.249	.250
8-32	.080 - .130	M52621	.435	.375	.027	.249	.250
10-24	.020 - .130	M52630	.435	.390	.027	.280	.281
10-24	.130 - .225	M52632	.535	.390	.027	.280	.281
10-32	.020 - .130	M52640	.435	.390	.027	.280	.281
10-32	.130 - .225	M52642	.535	.390	.027	.280	.281
1/4-20	.027 - .165	M52650	.585	.510	.030	.374	.375
1/4-20	.165 - .260	M52654	.685	.510	.030	.374	.375
5/16-18	.027 - .165	M52671	.685	.655	.035	.499	.500
5/16-18	.165 - .260	M52674	.845	.655	.035	.499	.500
3/8-16	.027 - .150	M52681	.685	.655	.035	.499	.500
3/8-16	.150 - .312	M52682	.845	.655	.035	.499	.500
M4x0.7	.5 - 2.0	M52660	9.78	9.53	.68	6.35	6.35
M4x0.7	2.0 - 3.3	M52665	11.05	9.53	.68	6.35	6.35
M5x0.8	.5 - 3.3	M52684	11.05	9.91	.68	7.1	7.14
M5x0.8	3.3 - 5.7	M52685	13.59	9.91	.68	7.1	7.14
M6x1.0	.7 - 4.2	M52686	14.86	12.96	.76	9.5	9.53
M6x1.0	4.2 - 6.6	M52687	17.40	12.96	.76	9.5	9.53
M8x1.25	.7 - 3.8	M52688	17.40	16.64	.89	12.7	12.7
M8x1.25	3.8 - 7.9	M52689	21.46	16.64	.89	12.7	12.7
M10x1.5	.7 - 3.8	M52690	17.40	16.64	.89	12.7	12.7
M10x1.5	3.8 - 7.9	M52691	21.46	16.64	.89	12.7	12.7

*Also available in small packaged quantities. Inch sizes are class 2B thread. Metric sizes are class 6H thread.

MQN and MXN Series

MQN — Quad-Leg Rivet Nut is used for light duty, thin or soft / brittle material. It will accommodate slightly oversized hole with large back side footprint similar to a wall anchor. Utilizes dedicated manual tool for proper installation. Available in Steel-Zinc Plated Threads.

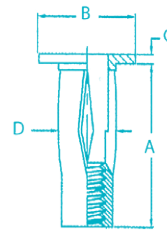


MQN Series Quad-Leg Rivet Nuts

THREAD SIZE	GRIP RANGE MIN-MAX	STEEL BULK PART #*	A	B	E	D	HOLE SIZE MIN-MAX	DRILL SIZE
			OVERALL LENGTH	HEAD DIA. REF	HEAD HEIGHT (NOM)	BODY DIA. MAX		
6-32	.000 - .197	M52510	.670	.472	.063	.315	.318 - .330	P (.323)
6-32	.197 - .394	M52511	.866	.472	.063	.315	.318 - .330	P (.323)
10-24	.000 - .197	M52530	.709	.547	.063	.394	.397 - .406	X (.397)
10-24	.197 - .394	M52532	.906	.547	.063	.394	.397 - .406	X (.397)
1/4-20	.000 - .197	M52550	.709	.630	.063	.472	.475 - .487	31/64
1/4-20	.197 - .394	M52554	.906	.630	.063	.472	.475 - .487	31/64
M4x0.7	.0 - 5.0	M52560	17.0	12.0	1.60	8.0	8.08 - 8.38	P (.323)
M4x0.7	5.0 - 10.0	M52565	22.0	12.0	1.60	8.0	8.08 - 8.38	P (.323)
M5x0.8	.0 - 5.0	M52584	18.0	13.9	1.60	10.0	10.08 - 10.31	X (.397)
M5x0.8	5.0 - 10.0	M52585	23.0	13.9	1.60	10.0	10.08 - 10.31	X (.397)
M6x1.0	.0 - 5.0	M52586	18.0	16.0	1.60	12.0	12.06 - 12.37	31/64
M6x1.0	.0 - 5.0	M52587	23.0	16.0	1.60	12.0	11.13 - 11.43	31/64

* Also available in small packaged quantities. Inch sizes are class 2B thread. Metric sizes are class 6H thread.

MXN — Large Flange Cross Bulb Rivet Nut has a large grip range with pre-bulb shank made up of 4 slots cut to Rivet Nut body providing large blindside footprint for greater pull out strength. Recommended for thin sheet metal and plastics, and works well in oversized hole. May be installed with all pneumatic and manual Rivet Nut tools. Available in Steel-Zinc Plated Threads.



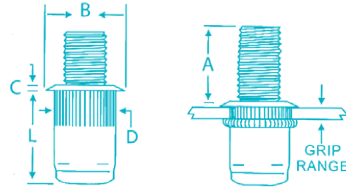
MXN Series Large Flange Cross Bulb Rivet Nuts

THREAD SIZE	GRIP RANGE MIN-MAX	STEEL BULK PART #*	A	B	C	D	HOLE SIZE MIN-MAX	DRILL SIZE
			BODY LENGTH MIN-MAX	HEAD DIA.	HEAD HEIGHT	BODY DIA. MAX		
1/4-20	.020-.280	M27150	.985 - 1.014	.610 - .645	.053 - .063	.382	.390-.396	25/64
1/4-20	.280-.500	M27155	1.218 - 1.248	.610 - .645	.053 - .063	.382	.390-.396	25/64
5/16-18	.020-.280	M27160	1.113 - 1.166	.740 - .770	.057 - .067	.495	.500-.506	1/2
5/16-18	.280 -.500	M27161	1.359 - 1.390	.740 - .770	.057-.067	.495	.500-.506	1/2
3/8-16**	.020-.280	M27162	1.205 - 1.233	.865 - .895	.083 - .093	.587	.594 - .600	#53
6MM	.5 - 7.1	M27151	25.02 - 25.78	15.49 - 16.38	1.35 - 1.60	9.7	10.0 - 10.15	X (.397)
6MM**	7.1 - 12.7	M27156	30.96 - 31.72	15.49 - 16.38	1.35 - 1.60	9.7	10.0 - 10.15	X (.397)
8MM	.5 - 7.1	M27157	28.29 - 29.63	18.80 - 19.56	1.45 - 1.70	12.57	12.70 - 12.85	1/2
8MM**	7.1 - 12.7	M27163	34.54 - 35.31	18.80 - 19.56	1.45 - 1.70	12.57	12.70 - 12.85	1/2
10MM**	.5 - 7.1	M27164	30.61 - 31.32	21.97 - 22.73	2.11 - 2.36	14.91	15.09 - 15.24	#53

* Also available in small packaged quantities. Inch sizes are class 2B thread. Metric sizes are class 6H thread. ** Limited availability, minimums may apply.

MET Series

MET — External Thread Stud Rivet Nut provides a strong external thread in blind applications. Allows for component mounting and mating nut. Easy to install with Spin/Spin and manual tools using the proper external thread front end assembly. Available in Steel-Zinc Plated Threads.



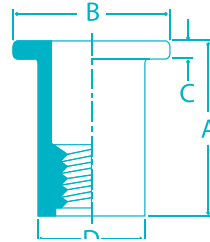
MET Series External Thread Stud Rivet Nut (Built to order, minimums required)

THREAD SIZE	GRIP RANGE MIN-MAX	STEEL BULK PART #*	A**	B	L	C	D	HOLE SIZE MIN-MAX	DRILL SIZE
			EXPOSED THREAD	HEAD DIA. $\pm .010"$ $\pm .25$ MM	BODY LENGTH $\pm .020"$ $\pm .50$ MM	HEAD HEIGHT $\pm .003"$ $\pm .08$ MM	BODY DIA. MAX		
6-32	.020-.080	M28310	.500	.390	.485	.030	.265	.265 - .271	17/64
6-32	.080-.130	M28312	.450	.390	.535	.030	.265	.265 - .271	17/64
8-32	.020-.080	M28320	.500	.390	.485	.030	.265	.296 - .302	17/64
8-32	.080-.130	M28321	.450	.390	.535	.030	.265	.296 - .302	17/64
10-24	.020-.130	M28330	.500	.415	.545	.030	.296	.296 - .302	19/64
10-24	.130-.225	M28332	.405	.415	.655	.030	.296	.296 - .302	19/64
10-32	.020-.130	M28340	.500	.415	.545	.030	.296	.296 - .302	19/64
10-32	.130-.225	M28342	.405	.415	.655	.030	.296	.296 - .302	19/64
1/4-20	.027-.165	M28350	.625	.500	.670	.030	.390	.390 - .396	25/64
1/4-20	.165-.260	M28354	.530	.500	.770	.030	.390	.390 - .396	25/64
5/16-18	.027-.150	M28371	.625	.685	.810	.035	.530	.530 - .536	17/32
5/16-18	.150-.312	M28374	.463	.685	.925	.035	.530	.530 - .536	17/32
3/8-16	.027-.150	M28381	.750	.685	.810	.035	.530	.530 - .536	17/32
3/8-16	.150-.312	M28382	.588	.685	.925	.035	.530	.530 - .536	17/32
4mm	.50-2.00	M28360	12.0	9.91	12.32	.76	6.73	6.75 + .15	6.75
4mm	2.00-3.30	M28365	10.7	9.91	13.59	.76	6.73	6.75 + .15	6.75
5mm	.50-3.30	M28385	12.0	10.54	13.84	.76	7.52	7.6 + .15	7.6
5mm	3.30-5.70	M28384	9.6	10.54	16.64	.76	7.52	7.6 + .15	7.6
6mm	.70-4.20	M28386	15.0	12.7	17.02	.76	9.91	10.0 + .15	10.0
6mm	4.20-6.60	M28387	12.6	12.7	19.56	.76	9.91	10.0 + .15	10.0
8mm	.70-3.8	M28388	16.0	17.4	20.57	.89	13.46	13.5 + .15	13.5
8mm	3.8-7.90	M28389	11.9	17.4	23.5	.89	13.46	13.5 + .15	13.5
10mm	.70-3.8	M28390	20.0	17.4	20.57	.89	13.46	13.5 + .15	13.5
10mm	3.8-7.90	M28391	15.9	17.4	23.5	.89	13.46	13.5 + .15	13.5

* Also available in small packaged quantities. ** Dimensions at maximum grip range. Inch sizes are class 2B thread. Metric sizes are class 6H thread.

MNN Series

MNN — Neoprene Insert contains pre-molded brass nut for quick fastening in vibration, moisture protection, shock dampening and even electrical insulation applications. Easy installation from blindside with conventional wrench; just insert the proper thread screw or bolt and tighten.



MNN Series Neoprene Insert

THREAD SIZE	GRIP RANGE MIN-MAX	BULK PART #	A	B	C	D	HOLE SIZE MIN-MAX	DRILL SIZE
			BODY LENGTH ±.015" ± 0.38 MM	HEAD DIA. ±.010" ± 0.254 MM	HEAD HEIGHT ±.003" ± 0.76 MM	BODY DIA. MAX		
6-32	.015-.157	M52710	.496	.433	.055	.312	.312 - .323	5/16
8-32	.015-.157	M52720	.496	.433	.055	.312	.312 - .323	5/16
10-32	.015-.193	M52730	.555	.500	.035	.378	.378 - .386	W (.386)
10-32	.033-.232	M52731	.669	.551	.039	.378	.378 - .386	W (.386)
10-32	.031-.228	M52732	.709	.748	.079	.378	.378 - .386	W (.386)
10-32	.031-.228	M52733	.825	.746	.185	.378	.378 - .386	W (.386)
10-32	.311-.630	M52734	.846	.551	.035	.378	.378 - .386	W (.386)
10-32	.311-.449	M52735	1.030	.551	.051	.378	.378 - .386	W (.386)
10-32	.984-1.256	M52736	1.732	.551	.035	.378	.378 - .386	W (.386)
1/4-20	.015-.110	M52750	.630	.630	.051	.500	.500 - .508	1/2
1/4-20	.031-.185	M52751	.831	.750	.187	.500	.500 - .508	1/2
1/4-20	.252-.453	M52752	1.051	.642	.079	.500	.500 - .508	1/2
1/4-20	.453-.906	M52753	1.377	.630	.051	.512	.512 - .520	33/64
5/16-18	.015-.157	M52771	.720	.847	.126	.626	.626 - .634	41/64
5/16-18	.156-.374	M52772	1.099	.847	.225	.626	.626 - .634	41/64
5/16-18	.079-.709	M52773	1.970	.787	.063	.750	.750 - .758	3/4
3/8-16	.748-1.570	M52781	2.165	.886	.051	.750	.750 - .758	3/4
1/2-13**	1.470-1.575	M52791	3.070	1.060	.051	.945	.945 - .953	61/64
M3-0.5	.4-4.0	M52810	12.6	11.0	1.4	7.9	7.90 - 8.20	7.9
M4-0.7	.4-4.0	M52820	12.6	11.0	1.4	7.9	7.90 - 8.20	7.9
M5-0.8	.4-4.9	M52830	14.1	12.7	.9	9.6	9.60 - 9.80	9.6
M5-0.8	.85-5.9	M52831	17.0	14.0	1.0	9.6	9.60 - 9.80	9.6
M5-0.8	.8-5.8	M52832	18.0	19.0	2.0	9.6	9.60 - 9.80	9.6
M5-0.8	.8-5.8	M52833	20.95	18.95	4.7	9.6	9.60 - 9.80	9.6
M5-0.8	7.9-16	M52834	26.1	14.0	1.3	9.6	9.60 - 9.80	9.6
M5-0.8	7.9-11.4	M52835	21.5	14.0	.9	9.6	9.60 - 9.80	9.6
M5-0.8	20.5-30	M52836	39.8	14.0	1.3	9.6	9.60 - 9.80	9.6
M6-1.0	.4-2.8	M52850	16.0	16.0	1.3	12.7	12.7 - 12.9	1/2
M6-1.0	.8-4.7	M52851	21.1	19.05	4.75	12.7	12.7 - 12.9	1/2
M6-1.0	6.4-11.5	M52852	26.7	16.3	2.0	12.7	12.7 - 12.9	1/2
M6-1.0	11.5-23	M52853	35.0	16.0	1.3	13.0	13.0 - 13.20	13.0
M8-1.25	.4-4.0	M52871	18.3	21.5	3.2	15.9	15.9 - 16.1	16.0
M8-1.25	3.95-9.5	M52872	27.93	21.5	5.72	15.9	15.9 - 16.1	16.0
M8-1.25	2.0-18.0	M52873	50.0	20.0	1.6	18.0	18.0 - 18.2	18.0
M10-1.5	19.0-40.0	M52881	55.0	22.5	1.3	15.9	20.0 - 20.2	20.0
M12-1.75	36.0-64.0	M52891	78.0	27.0	1.3	15.9	24.0 - 24.2	24.0

* Also available in small packaged quantities. Inch sizes are class 2B thread. Metric sizes are class 6H thread. ** Built to order, minimums required.

Hand Rivet Tooling



HP-2® / M39000*

The HP-2 is the number one selling hand rivet tool in the industry. Known and trusted for durability, quality and performance, the HP-2 is often copied but never duplicated. Its square shoulder fulcrum pin of cold-formed heat-treated steel prevents pin rotation that can elongate the engaging holes and cause premature tool failure in imitation tools. Other quality features include: precision die-cast, high-strength aluminum alloy body; drop-forged carbon steel upper handle; and thick, cushion-molded vinyl grips for comfort. The HP-2 sets up to 3/16" steel rivets and comes with four mounted nosepieces (3/32", 1/8", 5/32" and 3/16") and a service wrench. Refer to the Hand Rivet Tool Capacity Chart on page 19 for specific capabilities

Weight: 1.2 lbs.



HP-5™ / M39011

This hand rivet tool offers long, ergonomically designed handles to increase leverage. The tool is spring-loaded to secure the rivet in the nosepiece while the tool is in any position. The HP-5 offers powerful riveting capacity with 4 standard nosepieces to set 3/32", 1/8" and 5/32" in all alloys and up to 3/16" in steel. It features a drop-forged steel handle with heat-treated aluminum body with steel insert, high quality powder coated finish, special alloy steel fulcrum pin with anti-wearing design and durable jaws and jaw case.

Weight: 1.2 lbs.



Klik-Turn® SP-1 / M39005

The SP-1 swivel head hand-held rivet tool features a patented positive-ratchet locking feature which will allow the swivel head section of the tool to turn 360° and hold in place in any of the forty-plus positions. The high-strength steel body and cast aluminum head complement this innovative design in a swivel head riveting tool. The SP-1 also includes built-in threaded nosepiece storage holes and a service wrench. The SP-1 sets up to 3/16" steel rivets.

Weight: 1.2 lbs.



HP-4x4™ Multiplex Kit / M39410

The Marson HP-4x4 Multiplex Hand Tool features innovative design that allows a single tool to set blind rivets, rivet nuts, Jack rivets and rivet nut studs. This inch size kit includes 5 Threaded Mandrels (6-32, 8-32, 10-24, 10-32, 1/4-20), 3 Threaded Sockets (8-32, 10-24, 10-32) and 4 Nosepieces (#6, #8, #10, 1/4).

Contact Howmet sales for spare parts or metric nosepieces and mandrels from M3 - M6.

200 Kit / M39001*

The deluxe hand riveter kit includes the HP-2 and 200 assorted Klik-Fast rivets: 50 each SB4-2, SB4-4, AB4-2A; 25 each SC4-4, AB6-2. The molded plastic case houses and protects the tool and rivets.

Weight: 4 lbs.

Stainless Steel Kit / M39003*

This kit is the same as our M39001, but contains 200 assorted Klik-Fast stainless steel rivets: 40 each SSB4-2S, SSB4-3S, SSB4-4S, SSBL4-2S, SSBL4-4S.

Weight: 4 lbs.

Big Daddy® / M39031*

The Big Daddy is the most versatile and powerful Marson brand hand riveter, taking the hard work out of setting large diameter blind rivets. Its extra long handles provide excellent leverage and permit working a foot beyond natural reach. Other features include a patented bearing design, self-adjusting two-piece jaws and single-unit body construction with a steel insert to provide stronger threads for the nosepieces included. In addition, the Big Daddy features a double-gear reduction system which easily sets from 1/8" to 1/4" diameter Klik-Fast rivets in all alloys, including 1/4" Klik-Split™ and 3/16" and 1/4" Klik-Lock™** rivets. Additionally, a one-piece collet case eliminates the need to adjust the tool when changing rivet diameters. The Big Daddy model #M39031 comes with 5/32", 3/16" and 1/4" nosepieces, which are stored in the body.

Weight: 3.75 lbs



Big Daddy / M39035*

This is the same tool as M39010, but comes with M39009 attached, extending the tool's reach by an additional 2 1/2".

Weight: 4 lbs.

Big Daddy / M39010*

This is the same tool as M39031, but comes with 3/16", 1/4" and special 1/4" Klik-Split rivet nosepieces.

Weight: 3.75 lbs.



Big Daddy Conversion Kit 3 Jaw Set Up / M96050

Converting to a three-jaw set adds additional gripping power and extends jaw life.

Big Daddy II / M3903*

With all the features of the Big Daddy, Big Daddy II includes a built-in mandrel collection receptacle; just remove the end cap on the bottom handle to discard the spent mandrels.

Big Daddy Extended Nosepiece Kit / M39009

Install kit to add an additional 2-1/2" to any Big Daddy tool.

Weight: .25 lb.



Hand Rivet Tool Capacity

	STEEL					ALL ALUMINUM					ALUMINUM STEEL					STAINLESS					MONO-BOLT®**		"T" RIVETS			
	3/32"	1/8"	5/32"	3/16"	1/4"	3/32"	1/8"	5/32"	3/16"	1/4"	3/32"	1/8"	5/32"	3/16"	1/4"	3/32"	1/8"	5/32"	3/16"	1/4"	3/16"	1/4"	3/16"	1/4"		
HP-2 / M39000	•	•	•	•		•	•	•	•		•	•	•	•		•	•	•								
HP-5 / M39011	•	•	•	•		•	•	•	•		•	•	•	•		•	•	•								
SP-1 / M39005	•	•	•	•		•	•	•	•		•	•	•	•		•	•	•								
BIG DADDY (All)		•	•	•	•		•	•	•	•		•	•	•	•		•	•	•	•		•	•	•	•	•

Hand Rivet Tools — Standard and Special Nosepieces

	STANDARD					MONOBOLT®**		T-RIVET SIZES	
	3/32"	1/8"	5/32"	3/16"	1/4"	3/16"	1/4"	3/16"	1/4"
HP-2 / M39000	M39131	M39128	M39130	M39129					
HP-5 / M39011	M39131	M39128	M39130	M39129					
SP-1 / M39005	M39160	M39165	M39164	M39162					
BIG DADDY (All)		M96024	M96025	M96026	M96027	M96031	M96030	M96029	M96028

*Warning: This product contains phthalates that are chemicals known to the State of California to cause cancer, or birth defects, or other reproductive harm.

** When setting Marson band Klik-Lock rivets, no special nosepiece is required.

Hand Rivet Tooling Kits



For truck cabs and trailers, Howmet Fastening Systems offers a broad range of industry-leading blind fasteners and structural rivets to attach or repair panels, doors, floor structures, shelving, storage compartments and much more. Each of our fasteners delivers the industry's best combination of clamp, tensile strength and zero-maintenance performance.

Marson Big Daddy® Huck Tool Kits

KIT PART NO.	MAGNA-GRIP® SIZE RANGE	NOSEPIECE
M39500	3/16" and 1/4"	Included
M39502	3/16"	Included
M39504	1/4"	Included

Marson Big Daddy® Huck Tool Nose Assemblies

KIT PART NO.	MAGNA-GRIP® SIZE RANGE
M96070	3/16"
M96072	1/4"

* Also works with 3/16" and 1/4" Huck Magna-Lok and Magna-Tite nose assemblies.



Huck Aftermarket Starter Kit — TCR-KIT

REFILL PACK QTY.	DESCRIPTION CODE	DESCRIPTION AND GRIP RANGE
Huck Magna-Lok / Klik-Lock Blind Rivet		
25	MGLP-R6-4-PKT	3/16" Steel Locking .062-.270
25	MGLP-R6-E-PKT	3/16" Steel Locking .62-.437
25	MGLP-R8-6-PKT	1/4" Steel Locking .080-.375
25	MGLP-R8-10-PKT	1/4" Steel Locking .350-.625
25	MGLP-B6-4-PKT	3/16" Aluminum Locking .62-.270
25	MGLP-B6-E-PKT	3/16" Aluminum Locking .062-.437
25	MGLP-B8-E-PKT	1/4" Aluminum Locking .080-.625
Huck Magna-Tite Blind Rivet		
25	MTP-B6-8S-PKT	3/16" Aluminum (sealant) .050-.500
25	MTP-B8-10S-PKT	1/4" Aluminum (sealant) .375-.625
Huck Magna-Grip Pins		
10	MGP98T-E6-10-PKT	3/16" Alum Button head .062-.625
10	MGP98T-R6-10G-PKT	3/16" Steel Button head .062-.625
10	MGPB-R8-10G-PKT	1/4" Steel Button head .062-.625
10	MGPB-R8-20G-PKT	1/4" Steel Button head .312-1.250
10	MGPT-R8-10G-PKT	1/4" Steel Truss-head .062-.625
10	MGC-R6U-PKT	3/16" Steel Standard Flange Collar
10	MGC-R8U-PKT	1/4" Steel Standard Flange Collar
10	MGCW-R6U-PKT	3/16" Steel Large Flange Collar
10	MGCW-F6-PKT	3/16" Aluminum Large Flange Collar



Available in new tool kits with nose assemblies that fit Huck Magna-Lok®, Magna-Tite® and Magna-Grip® 3/16" or 1/4" fasteners or both sizes. Order the kit that's right for you.

Huck Rivet Shaver

PART NO.	DESCRIPTION
105-MT	Huck Rivet Shaver Tool + Bit+ Holder
124351	Huck Rivet Shaver Tool Bit
124486	Huck Rivet Shaver Tool Holder

Fits any standard size drill and burnishes 5/32", 3/16", and 1/4" shavable rivet heads to leave a clean, solid appearance that closely matches solid or brazier head rivets. Shavable head rivets can be installed in a blind hole where the blind side or back side does not allow you access.

Power Rivet Tooling

These next generation, professional series air / hydraulic riveters are designed to be lightweight and well-balanced. Both are engineered to maximize stroke and pull force with a 3-jaw set. For added convenience, you can direct connect or use the attached swivel. Each tool is supplied with nosepieces to set rivets in all alloys and comes complete with adjustment service wrenches, hydraulic fluid, fluid applicator, spare jaws and a removable swivel air connection line with an air OFF / ON valve built in. An adjustable vacuum system allows you to control the force of air needed to hold the rivet in place, or you may operate with the vacuum system turned off. Recommended air pressure is 70-95 psi.

Each of these proven, professional tools features a one-piece molded frame and front swivel air inlet for maximum operator comfort and durability. An external vacuum adjustment offers convenient air flow control for rivet placement and mandrel disposal. This allows the operator to install rivets in any orientation using one hand, and freeing up the other for assembly. Spent mandrels are conveniently collected in the bottle for disposal, encouraging a safer, clean work environment. Tools come complete with oil, replacement jaws and nosepieces. Recommended air pressure: 85-95 psi.

MP-3V / M39045

Stroke: 3/4"
Pulling Force: 1,800 lbs.
Capacity: 3/32" - 3/16", all alloys
Weight: 2.9 lbs.



301-E / M39061

Stroke: 0.807"
Pulling Force: 2,360 lbs
Capacity: 3/32" - 3/16" diameter in all alloys and up to 1/4" in aluminum
Weight: 3.5 lbs.
Automatic Air-Stop: cuts vacuum draw when idle



MP-4V / M39048

Stroke: 1"
Pulling Force: 3,420 lbs.
Capacity: 5/32" - 1/4", all alloys, 1/4" Monobolt® nosepiece included
Weight: 3.7 lbs.



304-E / M39064

Stroke: 1"
Pulling Force: 4,200 lbs.
Capacity: 3/16" to 1/4" in all alloys, including structural rivets Also included are 3/16" and 1/4" Monobolt® and Magna-Lok® assemblies
Weight: 5.5 lbs.



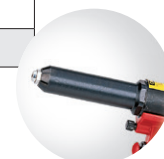
AH-250 / M39510

Stroke: 0.728"
Pulling Force: 5,280 lbs.
Capacity: Lockbolts 3/16" - 1/4"
 Structural rivets 3/16" - 1/4"
 High Strength Structural rivets 5/32" - 5/16"
 Standard rivets 3/16" - 1/4"
Weight: 5.58 lbs.



Extended Head Accessory for 301-E and 304-E

TOOL	DESCRIPTION	PART #
301-E / M39061	5" Extension Head	M88082
301-E / M39061	8" Extension Head	M88086
304-E / M39064	5" Extension Head	M723358



Monobolt® is a registered trademark of Avdel®

Power Rivet Tooling

BT-5 / M38990

Stroke: 0.866" (22 mm)

Pulling Force: 2,248 lbs. (10,000 n)

Capacity: 3/32" (2.4mm) to 3/16" (4.8 mm)

Weight (with Li-ion battery pack): 4.21 lbs. (1.91 kg)

Battery Pack: 18 V / Li-ion / 2.0 Ah

Recharge Time: approx. 45 minutes

The Marson® BT-5 is among the best values you'll find anywhere for industrial-strength, battery-powered riveters. Engineered for dependability on the factory floor or at the job site, BT-5 delivers reliable performance at a fraction of the cost of other high-performance riveters.

The Marson BT-5 Kit includes nose tips for 1/8", 5/32" and 3/16" rivet diameters. An optional nosepiece allows you to install 3/32" rivets, as well.



BT-6 / M38996

Stroke: 1.1024" (26 mm)

Pulling Force: 4,496 lbs. (20,000 n)

Capacity: 3/16" (4.8 mm) to 1/4" (6.2mm)

Weight (with Li-ion battery pack): 4.28 lbs. (1.91 kg)

Battery Pack: 18 V / Li-ion / 2.0 Ah

Recharge Time: approx. 45 minutes

The Marson® BT-6 is a battery-powered riveter designed to deliver reliable pull-force for high-volume assembly applications. Engineered for versatility and extensive use on factory floors and job sites, this portable powerhouse offers a durable value.

The Marson BT-6 kit includes nose tips for 3/16" and 1/4" rivet sizes.



IntegraFuse IF-1 / M39075

Stroke: 1.125" (28.575mm)

Pulling Force: 4,600 lbs. (20.5kn)

Capacity: 3/16" (4.8 mm) to 1/4" (6.2mm)

Weight: 4.8 lbs. (2.177kg)

The IF-1 is the one-and-only tool needed for single-pull installations of all blind rivets and structural blind fasteners from 3/16" to 1/4"*. Single integral front end eliminates the need for nosepiece change out during installation. The secret to the IF-1's unique versatility is its stroke — the longest in the industry.

*Does not include HUCK® BOM® structural blind fasteners.



M-Series

These proven, heavy duty air / hydraulic riveters are designed with an aluminum forged head to hold up under demanding continuous use. The aluminum forged head allows for continuous full operating power and less internal wear. Tools come complete with nosepieces, service tools, swivel inlet air coupler and a mandrel collection bottle. Recommended air pressure: 85-95 psi.

M-3 M39054

Stroke: .551" (14mm)

Pulling Force: 1,983 lbs. (8,820n)

Capacity: 1/8" (3.2mm) to 3/16" (4.8 mm) in all alloys including some structural rivets

Weight: 4.2 lbs.



M-4 M39058

Stroke: .748" (19mm)

Pulling Force: 3,500 lbs. (13,784n)

Capacity: 3/32" (2.4mm) to 1/4" (6.2mm) in all alloys including structural rivets

Weight: 6.6 lbs.



Power Rivet Tools — Standard and Special Nosepieces

	STANDARD					MONOBOLT®*	
	³ / ₃₂ "	¹ / ₈ "	⁵ / ₃₂ "	³ / ₁₆ "	¹ / ₄ "	³ / ₁₆ "	¹ / ₄ "
M-3 / M39054		M95715	M95716	M95717			
MP-3V / M39045	M95200	M95201	M95202	M95203			
M4 / M39050	M95897	M95898	M95899	M95900		M95904	M95906
MP-4V / M39048			M95300	M95301	M95302	M95299	M95303
301-E / M39061	M717006	M717001	M717002	M717003	M717005		
304-E / M39064				M88220-1	M88220-79	M88220-85	M88220-84
BT-5 / M38990	M96208	M96209	M96210	M96211			
BT-6 / M38996			M96310	M96311	M96322		
IF-1 / M39075				M95137-2	M95137		

Power Rivet Tools — Capacity

	STEEL					ALL ALUMINUM					ALUMINUM STEEL					STAINLESS					STRUCTURAL*	
	³ / ₃₂ "	¹ / ₈ "	⁵ / ₃₂ "	³ / ₁₆ "	¹ / ₄ "	³ / ₃₂ "	¹ / ₈ "	⁵ / ₃₂ "	³ / ₁₆ "	¹ / ₄ "	³ / ₃₂ "	¹ / ₈ "	⁵ / ₃₂ "	³ / ₁₆ "	¹ / ₄ "	³ / ₃₂ "	¹ / ₈ "	⁵ / ₃₂ "	³ / ₁₆ "	¹ / ₄ "	³ / ₁₆ "	¹ / ₄ "
M-3 / M39054		•	•	•			•	•	•			•	•	•			•	•	•			
MP-3V / M39045	•	•	•	•		•	•	•	•		•	•	•	•		•	•	•	•			
M-4 / M39058	•	•	•	•		•	•	•	•		•	•	•	•		•	•	•	•		•	•
MP-4V / M39048			•	•	•			•	•	•			•	•	•			•	•	•	•	•
301-E / M39061	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
304-E / M39064				•	•				•	•				•	•				•	•	•	•
BT-5 / M38990	•	•	•	•		•	•	•	•		•	•	•	•		•	•	•	•			
BT-6 / M38996				•	•				•	•				•	•				•	•	•	•
IF-1 / M39075				•	•				•	•				•	•				•	•		

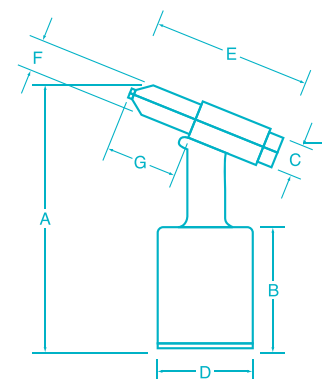
*For Monobolt® structural rivets, the noted special nosepiece is required. For Marson brand Klik-Lock® structural rivets, no special insert is required.

Power Rivet Tools — Dimensions

TOOL	A	B	C	D	E	F	G	WT
M-3 / M39054	12"	6"	1.25"	3"	6"	1"	2"	4.2 lbs.
MP-3V / M39045	10"	3.5"	1.5"	3.5"	6.5"	.925"	2.75"	2.9 lbs.
M-4 / M39058	12"	4.5"	1.5"	3.5"	7"	.987"	4.5"	6.6 lbs.
MP-4V / M39048	12"	5.5"	2"	4.5"	7"	.925"	3.5"	3.7 lbs.
301E / M39061	11"	5"	1.75"	4.5"	8"	.875"	2.375"	4.8 lbs.
304-E / M39064	13.125"	6"	2.375"	5.25"	13"	.938"	2.5"	5.5 lbs.
BT-5 / M38990	10.75"	N/A	2.11"	2.55"	11"	.89"	2.99	4.21 lbs.
BT-6 / M38996	10.75"	N/A	2.11"	2.55"	11"	.89"	2.99	4.21 lbs.
IF-1 / M39075	12"	5.56"	1.575"	4.99"	9.18"	12.79"	4.155"	4.8 lbs.
AH-250 / M39510	13.66"	6.375"	1.25"	5.10"	9.31"	1.18"	1.43"	5.58 lbs.

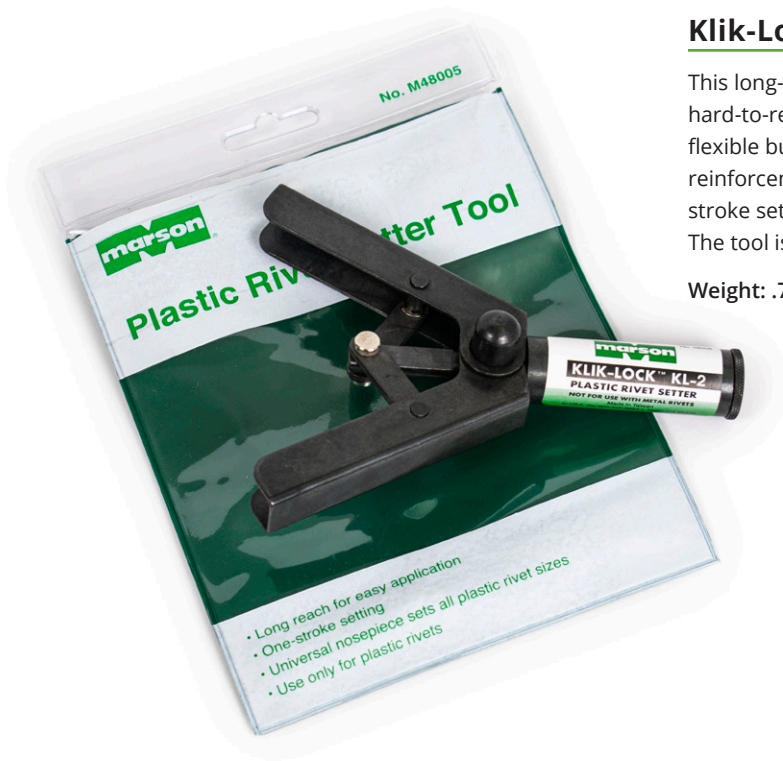
Power Rivet Tools — Specifications

TOOL	WORK FORCE	STROKE
MP-3 / M39054	85-95 psi, 2,000 lbs. / 8,896 n	.551" / 14 mm
MP-3V / M39045	70-95 psi, 1,800 lbs. / 8007 n	.75" / 19 mm
M-4 / M39058	70-95 psi, 3,500 lbs. / 15,213 n	.748" / 19 mm
MP-4V / M39048	70-95 psi, 3,420 lbs. / 15,213 n	1." / 25.4 mm
301E / M39061	85-95 psi, 2,360 lbs. / 10,498 n	.807" / 20.5 mm
304-E / M39064	85-95 psi, 4,200 lbs. / 18,682 n	1" / 25.4 mm
BT-5 / M38990	2,248 lbs. / 10,000 n	0.866" / 22 mm
BT-6 / M38996	4,496 lbs. / 20,000 n	1.1024" / 26 mm
IF-1 / M39075	4,600 lbs. / 20,500 n	1.125" / 28.575 mm
AH-250 / M39510	90 psi, 5,280 lbs. / 23,500 n	0.728" / 18.5 mm



Monobolt® is a registered trademark of Avdel®

Plastic Rivet Tooling



Klik-Lock® KL-2 Plastic Rivet Setter / M48005

This long-reach tool is just what today's professional needs for hard-to-reach spots, especially in automotive applications such as flexible bumpers, wheel wells, license plate brackets and bumper reinforcements. In addition to the tool's long reach, it offers one-stroke setting and a universal nosepiece that sets all plastic rivets. The tool is packaged in a reusable, heavy-duty vinyl pouch.

Weight: .75 lb.

Professional Plastic Rivet Kit / M48006

This kit includes the versatile KL-2 Plastic Rivet Setter, plus a 20-pack each of our four most popular rivet sizes: Nos. M58106, M58108, M58149 and M58150. A reclosable carton provides storage for rivets and tool.

Weight: 1.5 lbs.



Rivet Nut Tooling

Klik-Turn® SRN-2 / M39400

The SRN-2 swivel head, hand held Rivet Nut tool features a positive-ratchet locking feature which allows the swivel head to turn 360°. This feature helps hold in place in forty-plus positions. An innovative design, the SRN-2 features a heat treated steel upper handle and precision die-cast body of high-strength aluminum. In addition, the SRN-2 offers adjustable stroke with a positive locking feature, patented fulcrum pin design, quick-change mandrel, comfortable hand grips and longer handles to improve leverage. Included are built-in threaded nosepiece storage holes and a service wrench. The SRN-2 can set steel and aluminum Rivet Nuts up to 1/4-20" and 6mm. The tool is supplied with 6-32, 8-32, 10-24, 10-32 and 1/4-20 mandrels and nosepieces.

Mandrel / Nosepiece

THREAD SIZE	MANDREL NO.	NOSEPIECE NO.
6-32	M39454	M39361
8-32	M39455	M39362
10-24	M39456	M39363
10-32	M39457	M39363
1/4-20	M39458	M39379
1/4-28*	M39471	M39379
4mm*	M39466	M39374
5mm*	M39467	M39373
6mm*	M39468	M39375

*Sold separately



Rivet Nut Setter RN-1 / M39300

The RN-1 features a quick-change mandrel, long handles for improved leverage, and a locking adjustable-stroke. 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. This kit includes 8-32, 10-24 and 10-32 mandrels and nosepieces, but installs all sizes of Rivet Nuts and threaded inserts up to 1/4-20 and 6mm threads in steel. Available in a variety of other kits. Weight: 1.2 lbs.

Rivet Nut Setter RN-1 Inch Kit in Clamshell Blister Package / 39304

RN-1 tool packaged with 5 threaded mandrels 6-32, 8-32, 10-24, 10-32, 1/4-20 and 4 nosepieces #6, #8, #10, 1/4.

Rivet Nut Setter RN-1 Metric Kit in Clamshell Blister Package / 39306

RN-1 tool packaged with 3 Threaded Mandrels M4, M5, M6 and 3 Nosepieces M4, M5, M6.



Mandrel / Nosepiece

THREAD SIZE	MANDREL NO.	NOSEPIECE NO.	COMPLETE SET 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.

Rivet Nut Tooling and Kits

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 lbs.

Ribbed Rivet Nut Kit / M39315

Model M39315 Ribbed Rivet Nut kit contains the M39300 Rivet Nut tool in a molded plastic case; mandrels, nosepieces, wrench and 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 and 6mm 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-Serts: 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-Serts: 10 each M57910, M57920, M57930, M57940, M57950; 6 each M57971, M57981.

Weight: 3 lbs.



Quad Leg Nut Installation Tool (MJN-2 / M39043)

Marson's MJN-2 hand-held Quad Leg Nut Installation tool is designed to effortlessly set quad leg nuts and Jack Nuts® in sizes ranging from #6-32 to 1/4-20 and M4 to 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. Tightening the exposed bolt completes the installation.



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. It features quick-change mandrels with an easily adjustable stroke. Supplied with 1/4"-20 mandrel and nosepiece only.

Weight: 4.25 lbs.



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.

Mandrel / Nosepiece — M34604 & M34607

THREAD SIZE	MANDREL NO.	NOSEPIECE NO.	MANDREL / NOSEPIECE COMBO NO.
10-24	M95635	M95645	M34615
10-32	M95636	M95645	M34616
1/4-20	M95637	M95647	M34617
5/16-18	M95638	M95648	M34618
3/8-16	M95639	M95649	M34619
5mm	M95630	M95640	M34625
6mm	M95631	M95641	M34626
8mm	M95632	M95642	M34627
10mm	M95633	M95643	M34628

Mandrel/Nosepiece (Inch) — M34610 Kit

THREAD SIZE	MANDREL NO.	NOSEPIECE NO.	MANDREL / NOSEPIECE COMBO NO.
10-24	M95635	M95645	M34615
10-32	M95636	M95645	M34616
1/4-20	M95637	M95647	M34617
5/16-18	M95638	M95648	M34618
3/8-16	M95639	M95649	M34619



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.

425RNK Kit / M34608

The M34608 / 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.

Mandrel/Nosepiece (Metric) — M34613 Kit

THREAD SIZE	MANDREL NO.	NOSEPIECE NO.	MANDREL / NOSEPIECE COMBO NO.
5mm	M95630	M95640	M34625
6mm	M95631	M95641	M34626
8mm	M95632	M95642	M34627
10mm	M95633	M95643	M34628

MET Series External Thread Stud Rivet Nut Adapter

THREAD SIZE	MANDREL NO.
10-24	M34635
10-32	M34636
1/4-20	M34637
5/16-18	M34638
3/8-16	N/A
5mm	M34645
6mm	M34647
8mm	M34648
10mm	N/A

Rivet Nut Tooling and Kits

140-SP / M39223

The 140-SP features advanced Spin/Pull action, along with 3,057 lbs. of pull force, 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. Mandrels and nosepieces for 4mm through 6mm can be purchased separately.

Weight: 4.9 lbs.

Mandrel / Nosepiece

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

Featuring 6,159 lbs. of pull force, the 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

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

Mandrel Nosepiece (Metric)

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 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 changeover. For added ease of operation, the Spin/Spin offers a superior ergonomic design, lightweight body and operates without stroke adjustment. Available models come with two 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

MARSON SPIN/ TOOL MODEL	3000 RPM SST-1	1500 RPM SST-2		600 RPM SST-3		400 RPM SST-4
THREAD SIZE	RECOMMENDED	RECOMMENDED	OPTIONAL	RECOMMENDED	OPTIONAL	RECOMMENDED
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 tool's Rivet Nut setting ability. Recommended for thin wall Rivet Nuts only. 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. Contact customer service for available retrofit for MET external thread.

Conversion Tables

Spin / Spin Front End Assembly

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

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

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
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

INCHES		MM
FRACTION	DECIMAL	
1/64	.015 625	.397
1/32	.031 250	.794
3/64	.046 875	1.191
1/16	.062 500	1.588
5/64	.078 125	1.984
3/32	.093 750	2.381
7/64	.109 375	2.778
1/8	.125 000	3.175
9/64	.140 625	3.572
5/32	.156 250	3.969
11/64	.171 875	4.366
3/16	.187 500	4.763
13/64	.203 125	5.159
7/32	.218 750	5.556
15/64	.234 375	5.953
1/4	.250 000	6.350
17/64	.265 625	6.747
9/32	.281 250	7.144
19/64	.296 875	7.541
5/16	.312 500	7.938
21/64	.328 125	8.334
11/32	.343 750	8.731
23/64	.359 375	9.128
3/8	.375 000	9.525
25/64	.390 625	9.922
13/32	.406 250	10.319
27/64	.421 875	10.716
7/16	.437 500	11.113
29/64	.453 125	11.510
15/32	.468 750	11.906
31/64	.484 375	12.303
1/2	.500 000	12.700

INCHES		MM
FRACTION	DECIMAL	
33/64	.515 625	13.097
17/32	.531 250	13.494
35/64	.546 875	13.891
9/16	.562 500	14.288
37/64	.578 125	14.684
19/32	.593 750	15.081
39/64	.609 375	15.478
5/8	.625 000	15.875
41/64	.640 625	16.272
21/32	.656 250	16.669
43/64	.671 875	17.066
11/16	.687 500	17.463
45/64	.703 125	17.860
23/32	.718 750	18.256
47/64	.734 375	18.653
3/4	.750 000	19.050
49/64	.765 625	19.447
25/32	.781 250	19.844
51/64	.796 875	20.241
13/16	.812 500	20.638
53/64	.828 125	21.034
27/32	.843 750	21.431
55/64	.859 375	21.828
7/8	.875 000	22.225
57/64	.890 625	22.622
29/32	.906 250	23.019
59/64	.921 875	23.416
15/16	.937 500	23.813
61/64	.953 125	24.209
31/32	.968 750	24.606
63/64	.984 375	25.003
1	1.000 000	25.400

Decimal Equivalents of Standard Sheet Gauges

INCHES	THICKNESS (THOUSANDTHS)	
	ALUMINUM (B&S)	STEEL (U.S. STD.)
NO. OF GAUGE		
10	.102	.135
11	.091	.120
12	.081	.105
13	.072	.090
14	.064	.075
15	.057	.067
16	.051	.060
17	.045	.054
18	.040	.048
19	.036	.042
20	.032	.036
21	.029	.033
22	.025	.030
23	.023	.027
24	.020	.024
25	.018	.021
26	.016	.018
27	.014	.016
28	.012	.015
29	.011	.014
30	.010	.012



Howmet Fastening Systems

Industrial Division Brands



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