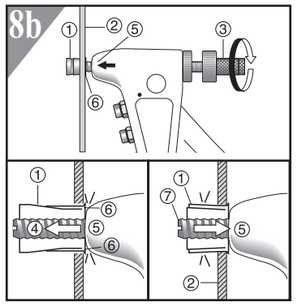
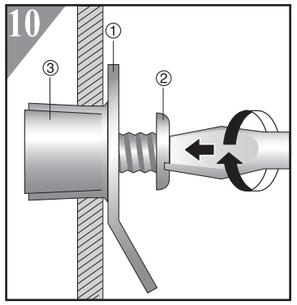
# marson® RN-1 *Professional* RIVET NUT SETTER™ M39300

## OPERATION INSTRUCTIONS — For Setting M8, 5/16, 3/8 Alum Rivet Nuts/Thread-Serts



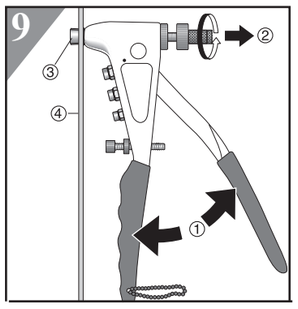

8b) If long type Rivet Nut/Thread-Sert ① is not installed firmly with Workpiece ② after the first setting, just turn Mandrel knob ③ clock-wise to enter more Mandrel Threads ④ into the non-firm Rivet Nut/Thread-Sert ① until Tool Working Nose ⑤ touches the Head ⑥ of Rivet Nut/Thread-Sert. Slowly squeeze again Tool Handles to drive Mandrel ⑦ into Working Nose ⑤ until hand force can not move and Rivet Nut/Thread-Sert ① is firmly fastened with Workpiece ②.

**NOTE**
If more than one squeeze to install Rivet Nut/Thread-Sert, it is not necessary to set the Stroke Bolt, just keep Stroke Bolt to the lowest position.




10) Fasten an Object ① by screwing a Bolt or a Screw ② to the installed Rivet Nut/Thread-Sert ③.

**NOTE**
If the next fasteing Rivet Nut/Thread-Sert is same size as previous one, Do Not Need Any Adjustment! Just repeat above 7) to screw Rivet Nut/Thread-Sert onto Mandrel and follow 8a)~8b) to fasten Rivet Nut/Thread-Sert, finally follow above 9) to unscrew Mandrel from the installed Rivet Nut/Thread-Sert.




9) Release Tool Handles ① fully and rotate Mandrel Knob ② to unscrew Mandrel from the installed Rivet Nut/Thread-Sert ③. Now the threads of Rivet Nut/Thread-Sert are built up securely in the Workpiece ④.

## RECOMMENDED CAPACITY CHART OF MARSON RN-1 TOOL:

| Klik® Rivet-Nuts/Thread-Serts (x) | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| Thread Size | Poly-Nuts | | Rivet-Nuts | | Thread-Serts | | Ribbed Rivet-Nuts | |
| | Aluminum | Steel | Aluminum | Steel | Aluminum | Steel | Aluminum | Steel |
| 6-32 | x | x | x | x | x | x | x | x |
| 8-32 | x | x | x | x | x | x | x | x |
| 10-24 | x | x | x | x | x | x | x | x |
| 10-32 | x | x | x | x | x | x | x | x |
| 1/4-20 | x | x | x | x | x | x | x | x |
| 5/16-18 | x | | x | | x | x | x | |
| 3/8-16 | | | | | x | x | | |
| 4MM | x | x | x | x | x | x | x | x |
| 5MM | x | x | x | x | x | x | x | x |
| 6MM | x | x | x | x | x | x | x | x |
| 8MM | x | | x | | x | x | x | |


marson®
1925 N. MacArthur Drive, Tracy, CA 95376
Tel: (800) 826-2884 • Fax: (800) 573-2645
For more info visit our website www.hfsindustrial.com



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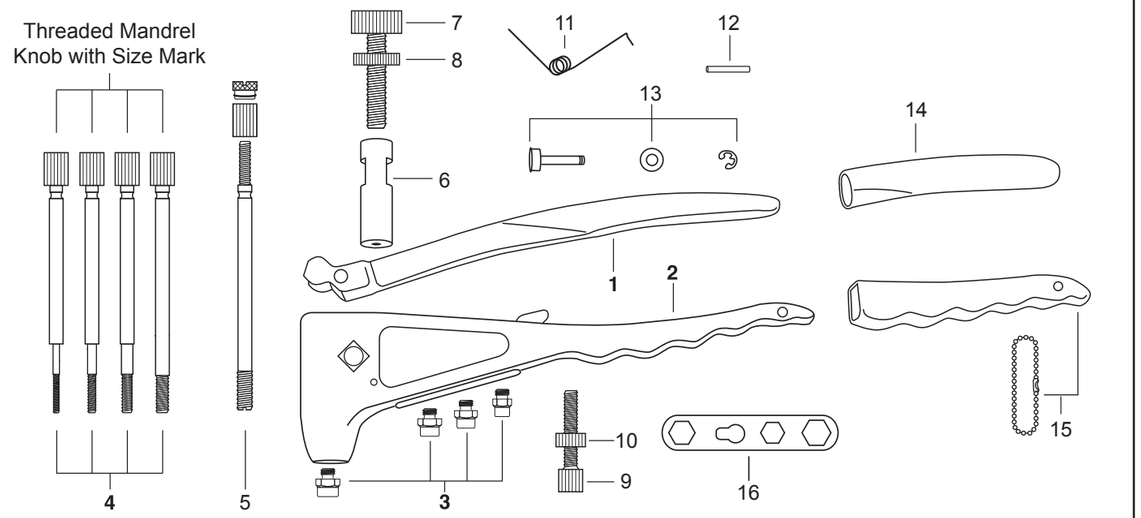
## PARTS LIST

U.S. PATENTS 5,729,880 & 8,468,668



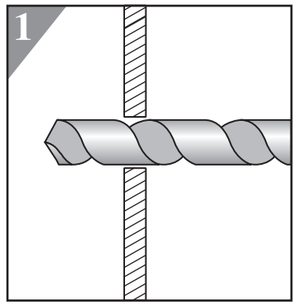

| No. | Part No. | Part Name |
|---|---|---|
| 1 | M39190 | Upper Handle |
| 2 | M39350 | Aluminum Body |
| 3-6 | M39361 | Nosepiece, for #6 Rivet Nut |
| 3-8 | M39362 | Nosepiece, for #8 Rivet Nut |
| 3-10 | M39363 | Nosepiece, for #10 Rivet Nut |
| 3-14 | M39379 | Nosepiece, for 1/4" Rivet Nut |
| 3-M4 | M39374 | Nosepiece, for M4 Rivet Nut |
| 3-M5 | M39373 | Nosepiece, for M5 Rivet Nut |
| 3-M6 | M39375 | Nosepiece, for M6 Rivet Nut |
| 4-632 | M39354 | Threaded Mandrel, for 6-32 Rivet Nut |
| 4-832 | M39355 | Threaded Mandrel, for 8-32 Rivet Nut |
| 4-1024 | M39356 | Threaded Mandrel, for 10-24 Rivet Nut |
| 4-1032 | M39357 | Threaded Mandrel, for 10-32 Rivet Nut |
| 4-1420 | M39358 | Threaded Mandrel, for 1/4-20 Rivet Nut |
| 4-1428 | M39371 | Threaded Mandrel, for 1/4-28 Rivet Nut |
| 5-51618 | M39359 | Threaded Mandrel, 3-PC Type, for 5/16-18 Thread-Sert/Rivet Nut |
| 5-51624 | M39372 | Threaded Mandrel, 3-PC Type, for 5/16-24 Thread-Sert/Rivet Nut |
| 5-3816 | M39360 | Threaded Mandrel, 3-PC Type, for 3/8-16 Thread-Sert/Rivet Nut |
| 4-M407 | M39366 | Threaded Mandrel, for M4x0.7 Rivet Nut |
| 4-M508 | M39367 | Threaded Mandrel, for M5x0.8 Rivet Nut |
| 4-M610 | M39368 | Threaded Mandrel, for M6x1.0 Rivet Nut |
| 5-M8125 | M39369 | Threaded Mandrel, 3-PC Type, for M8x1.25 Thread-Sert/Rivet Nut |
| 6 | M39264 | Collet Case |
| 7 | M39352 | Adjusting Knob |
| 8 | M39365 | Lock Nut |
| 9 | M39376 | Stroke Bolt |
| 10 | M39378 | Stroke Nut |
| 11 | M39132 | Torsion Spring |
| 12 | M39133 | Torsion Spring Pin |
| 13 | M39195 | Fulcrum Pin + Fulcrum Pin Bearing + Snap Ring |
| 14 | M39192 | Upper Grip |
| 15 | M39334 | Lower Grip + Bead Chain Lock |
| 16 | M39349 | Wrench |

**OPERATION INSTRUCTIONS ON REVERSE SIDE**

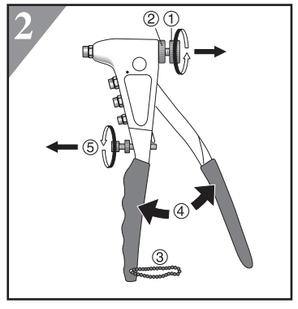
# marson® RN-1 *Professional* RIVET NUT SETTER™ M39300

## ■ OPERATION INSTRUCTIONS

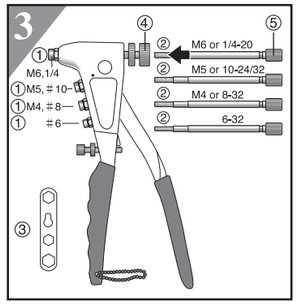
**For Setting M4 ~ M6 and 6-32 ~ 1/4-20 Rivet Nuts**



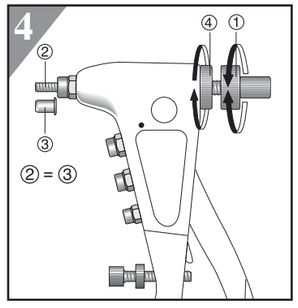

1) Drill the suppliers recommended hole size for the Rivet Nut/Thread-Sert selected into the workpiece as shown in fig. 1



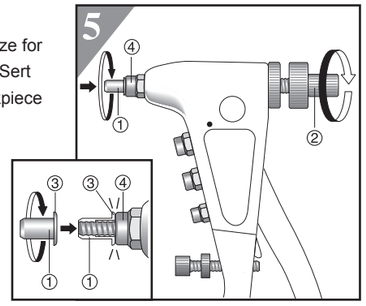

2) Still lock Tool Handles, turn up Adjusting Knob ① and Lock Nut ②, then loose Bead Chain Lock ③ to open Tool Handles fully ④, and turn down the Stroke Bolt and Stroke Nut ⑤ to the lowest position.



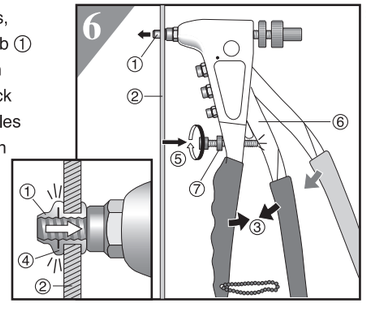

3) Select Nosepiece ① and Threaded Mandrel ② to be same size as Rivet Nut threaded size, exchange Nosepieces ① by Wrench ③, and insert Threaded Mandrel ② into Adjusting Knob ④. The Threaded Mandrel Knob ⑤ should touch Adjusting Knob ④.




4) Rotate Adjusting Knob ① to adjust thread length ② of Threaded Mandrel to be same as Rivet Nut length ③, then turn down the Lock Nut ④ to lock Adjusting Knob ① position firmly.



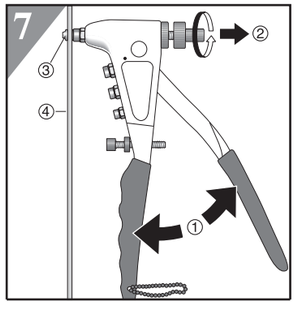

5) Screw the Rivet Nut ① onto Threaded Mandrel by turning either Rivet Nut ① or Threaded Mandrel Knob ② until Rivet Nut Head ③ touches Nosepiece ④. The Rivet Nut End should be flush with the Threaded Mandrel End.



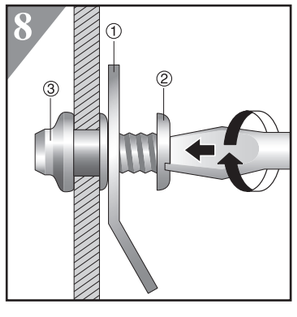

6) Insert the screwed Rivet Nut ① into the drilled Hole of Workpiece ②, squeeze Tool Handles ③ until Rivet Nut is installed firmly by forming a bulge ④ against the back of Workpiece ②; still hold Tool Handles ③ and adjust Stroke Bolt ⑤ up to touch Upper Handle ⑥, then turn up Stroke Nut ⑦ to lock Stroke Bolt ⑤ position. Now the proper Stroke is built up to protect the Rivet Nut threads and this Rivet Nut Tool as well.

**NOTE**

A proper Stroke ensures Rivet Nut threads to be installed securely, SO THE PILOT TEST IS ALWAYS RECOMMENDED BEFORE INSTALLING DIFFERENT SIZES OF RIVET NUT.




7) Release Tool Handles ① fully and rotate Threaded Mandrel Knob ② to unscrew Threaded Mandrel from the installed Rivet Nut ③. Now the Rivet Nut threads are built up securely in the Workpiece ④.




8) Fasten an Object ① by screwing a Bolt or a Screw ② to the installed Rivet Nut ③.

**NOTE**

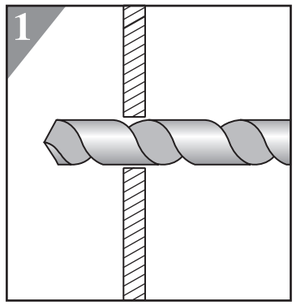
If the next fastening Rivet Nut is same size as previous one, Do Not Need Any Adjustment!
Just repeat above 5) to screw Rivet Nut onto Threaded Mandrel, then squeeze Tool Handles to fasten Rivet Nut until Upper Handle touches Stroke Bolt, finally follow above 7) to unscrew Threaded Mandrel from the installed Rivet Nut.



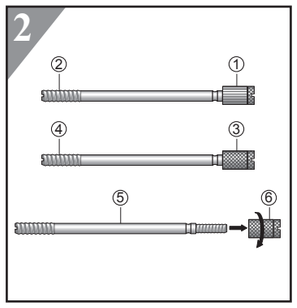
# marson® RN-1 *Professional* RIVET NUT SETTER™ M39300

## ■ OPERATION INSTRUCTIONS

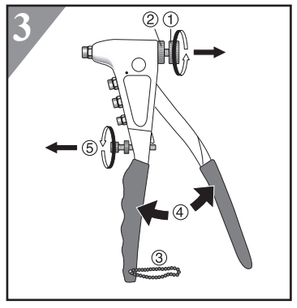
**For Setting M8, 5/16, 3/8 Alum Rivet Nuts/Thread-Serts**



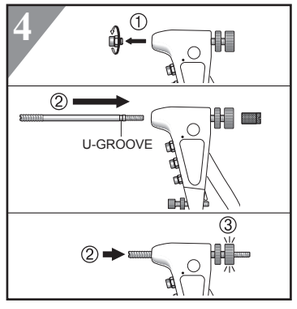

1) Drill the suppliers recommended hole size for the Thread-Sert/Rivet Nut selected into the workpiece as shown in fig. 1




2) The Mandrel and Knob Assembly of the delivered M8, 5/16, 3/8 Mandrel are already assembled. The Knob with straight lines ① is Metric size M8 Mandrel ② , while the Knob with cross ③ lines is Inch size 5/16 and 3/8 Mandrels ④. Unscrew Mandrel ⑤ from the Knob Assembly ⑥.




3) Still lock Tool Handles, turn up Adjusting Knob ① and Lock Nut , then loose Bead Chain Lock ③ to open Tool Handles fully ④, and turn down the Stroke Bolt and Stroke Nut ⑤ to the lowest position.

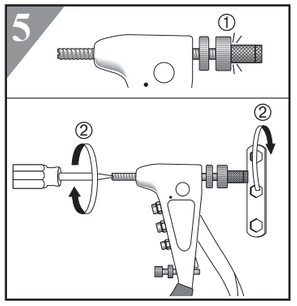



4) Unscrew to remove Nosepiece from Working Nose ①.

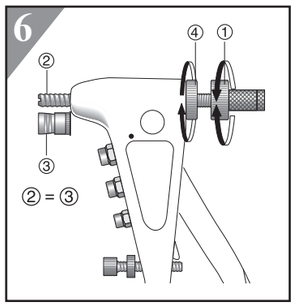
**NOTE**

The M8, 5/16, 3/8 Mandrels Do Not Need Any Nosepiece to set Thread-Serts/Rivet Nuts.

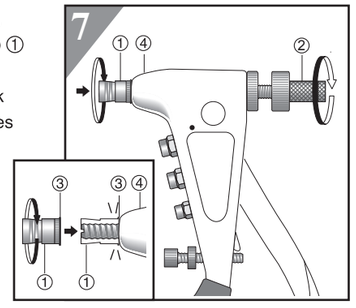
Insert the U-Groove End of separated Mandrel into Working Nose ② until the U-Groove is stuck in the Adjusting Knob ③.



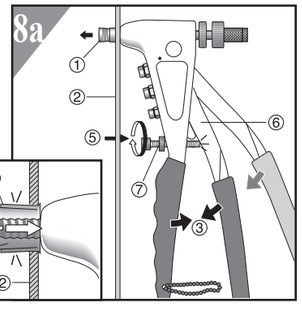

5) Screw the separated Mandrel into Knob Assembly until Knob Assembly touches Adjusting Knob ①. By using the slot, turn the Nosepiece Wrench and Screw Driver clockwise to fasten the separated Mandrel and Knob Assembly together firmly ②.




6) Rotate Adjusting Knob ① to adjust thread length of Mandrel ② to be same as length of Rivet Nut/ Thread-Sert ③, then turn down the Lock Nut ④ to lock Adjusting Knob ① position firmly.




7) Screw the Rivet Nut/Thread-Sert ① onto Mandrel by turning either Rivet Nut/Thread-Sert ①or Mandrel Knob ② until Rivet Nut/Thread-Sert Head ③ touches Working Nose ④. The Rivet Nut/Thread-Sert End should be flush with the Mandrel End.




8a) Insert the screwed Rivet Nut/ Thread-Sert ① into the drilled Hole of Workpiece ②, squeeze Tool Handles ③ until Rivet Nut/Thread-Sert is installed firmly by forming a bulge ④ against the back of Workpiece ② ; still hold Tool Handles ③ and adjust Stroke Bolt ⑤ up to touch Upper Handle ⑥, then turn up Stroke Nut ⑦ to lock Stroke Bolt ⑤ position. Now the proper Stroke is built up to protect the the threads of Rivet Nut/ Thread-Sert and this Tool as well.

**NOTE**

A proper Stroke ensures threads of Rivet Nut/Thread-Sert to be installed securely, SO THE PILOT TEST IS ALWAYS RECOMMENDED BEFORE INSTALLING DIFFERENT SIZES OF RIVET NUT/THREAD-SERT.

**MORE INSTRUCTIONS ON PAGE 4**