

**Alcoa  
Fastening  
Systems**



Industrial Distribution Group



**Marson™**  
Rivets, rivet nuts and  
installation tools



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Alcoa Fastening Systems-Industrial Distribution Group (AFS-IDG) offers the broadest line of blind fasteners for industrial applications in the industry. The breadth of the line is supported by a nationwide network of independent stocking warehouses, maintaining inventories that can deliver product to customers within hours if necessary. In short, the company's responsiveness to its customers and the needs of industry is second to none.

In an ongoing effort to be the best, AFS-IDG offers custom services such as painting, plating, anodizing, packaging, bar-coding and labeling. Add to this a strong commitment to research, design and development and you have an unbeatable combination.

## Quality Policy

Alcoa Fastening Systems (AFS) 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. AFS Acuna Operations is committed to the highest quality products and operating systems and employs Quality Management Systems certified to ISO 9001:2000.

### We will achieve business excellence by:

- Encouraging and expecting the creative involvement of every employee.
- Listening to our customers and meeting their needs.
- Continuously improving our processes, products and services.

# General Information – Blind Rivets

## Rivet Styles

### Open End



- For blind fastening where there is no access to opposite side of work
- Simple to install
- Wide variety of head styles and lengths available from 3/32" to 1/4" diameters

### Closed End



- Moisture-resistant due to closed end
- Greater shear and tensile strength
- Mandrel is retained 100% of time
- 1/8" to 1/4" diameters

### Multi-Grip



- Extended grip range capacity
- Reduces inventory (fewer sizes required)
- Use as a standard open end rivet
- 1/8" to 3/16" diameters

### Tri-Bulb



- Large footprint on blind side
- Multi-grip capability
- Oversized hole tolerant
- Great for soft or brittle materials
- Available in 5/32" to 3/16" diameters

### Q-Lok



- Retained mandrel increases shear and tensile strength
- Use in high vibration applications
- Mandrel breaks flush when used in mid-grip range
- Moisture-resistant due to tight seal
- 3/16" diameter

### Klik-Lock



- Permanently retained mandrel provides increased shear and tensile values
- Use in high vibration applications
- Provides weather-resistant joint
- Available in 3/16" and 1/4" diameters

### T-Rivets



- High clamp up
- High shear strength
- Creates a wide bearing surface
- 1/4" diameter

### Special Application Rivets



- Small flange rivet used primarily for fastening decorative materials on boats, automobiles, trucks & other motor vehicles
- Best suited to applications where a discreet, secure installation of non-critical components is needed.

### Plastic



- Precision-molded, all-nylon
- Secure lock prevents pull-out
- Fasten plastic to plastic, plastic to metal or plastic to fiberglass

## Materials Available

Steel/steel, Aluminum/aluminum  
Aluminum/steel, Stainless/stainless  
Stainless/steel, Copper/brass, Copper/steel

Aluminum/steel, Aluminum/aluminum,  
Stainless/stainless

Aluminum/steel, Steel/steel

Aluminum/aluminum

Steel/steel

Steel/steel, Aluminum/aluminum,  
Stainless/stainless

Aluminum/steel

Stainless/steel, Aluminum/aluminum

Nylon body, Delrin 500 Mandrel

## Head Styles

### Buttonhead



- Low profile head diameter is twice the rivet body diameter, providing adequate bearing surface for nearly all applications
- Open-end buttonhead rivets offer the broadest selection of sizes available.

### Large Flange



- Provides greater bearing surface for fastening soft and brittle facing materials and oversize facing holes
- Works well with soft materials, where the increased flange diameter protects the integrity of the application

### Countersunk



- 120° countersunk rivets for applications where flush appearance is required

Alcoa Fastening Systems offers a full line of Marson brand rivets for general consumer and industrial applications. These easy-to-use rivets are used to fasten together two or more pieces of material of varying thickness.

# Design Information

## AFS Code Descriptions

Example: **A** – First Letter.....Rivet material (A = Aluminum, S = Steel, C = Copper, SS = Stainless Steel)  
**ABL6-6A** **B** – Second Letter.....Style of Head (B = Buttonhead, C = Countersunk)  
**L** – Third Letter (if any).....Large Flange Head  
**6** – First Number.....Body Diameter in 32nds  
**6** – Second Number.....Maximum Grip Length in 16th's  
**A** – Final Letter.....A = Aluminum Mandrel, S = Stainless Steel Mandrel, B = Brass Mandrel,  
 C = Copper-plated Steel Mandrel, CLD = Closed-End  
 MG = Multi-Grip, QL = Q-Lok, KL = Klik-Lock  
 ATB = All Aluminum Tri-Bulb rivet. No letter indicates steel mandrel.

## Design Information

- 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 16 of this catalog. Testing is recommended before final selection and use in product.
- 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. AFS can paint colors to match, as well as anodize or plate to your specifications.
- 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 16. 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.
- Use recommended hole sizes for each rivet as shown on pages 5-16. An undersize hole will not allow insertion of rivet body. An oversize hole may cause rivet failure, joint failure and could adversely affect rivet shear and tensile strengths.
- The various head styles (illustrated 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.
- Please visit us at [afsindustrial.com](http://afsindustrial.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.

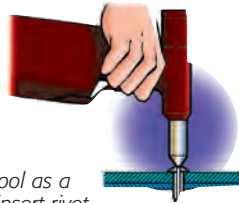


### To install

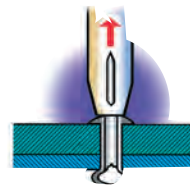
1 Insert rivet mandrel in rivet setting tool.



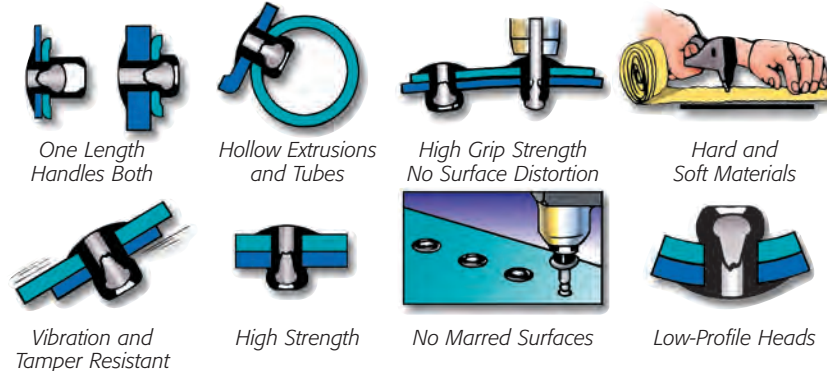
2 Using tool as a guide, insert rivet into prepared hole.

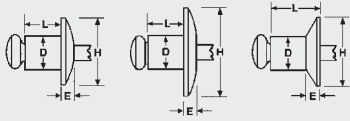


3 Or insert rivet into prepared hole and then engage the mandrel with rivet-setting tool. Squeeze trigger or handles to set rivet. Mandrel ejects after rivet is set.



### Blind rivet benefits





# Steel Rivets

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

### Buttonhead

| AFS Description | Bulk Part No.** | Grip Range |           | D Rivet Dia. Nom. Inch (mm) | Drill No. & Hole Size (mm) | H Head Dia. Nom. Inch (mm) | E Head Height Max. Inch (mm) | L Rivet Length Max. |      | Typical Ultimate Strength (lbs.) (newtons) |         |
|-----------------|-----------------|------------|-----------|-----------------------------|----------------------------|----------------------------|------------------------------|---------------------|------|--|---------|
|                 |                 | Inch       | (mm)      |                             |                            |                            |                              | Inch                | (mm) | Shear                                      | Tensile |
| SB3-2           | M50100          | .020-.125  | 5-3.2     | 3/32" (.094)                | #41 (.097-.100)            | .188                       | .032                         | .250                | 6.4  | 160  | 200     |
| SB3-4           | M50102          | .126-.250  | 3.3-6.4   | 2.4                         | (2.46-2.54)                | 4.78                       | .810                         | .375                | 9.5  | 711  | 889     |
| SB4-1           | M50111          | .020-.062  | 5-1.6     | 1/8" (.125)                 | #30 (.129-.133)            | .250                       | .040                         | .212                | 5.4  | 305  | 410     |
| SB4-2           | M50112          | .063-.125  | 1.7-3.2   | 3.2                         | (3.28-3.38)                | 6.35                       | 1.02                         | .275                | 7.0  | 1356                                       | 1823    |
| 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 |  |         |
| SB5-2           | M50132          | .020-.125  | 5-3.2     | 5/32" (.156)                | #20 (.160-.164)            | .312                       | .050                         | .300                | 7.6  | 420  | 600     |
| SB5-3           | M50134          | .126-.187  | 3.3-4.8   | 4.0                         | (4.06-4.16)                | 7.92                       | 1.27                         | .362                | 9.2  | 1868                                       | 2668    |
| 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 |  |         |
| SB6-2           | M50145          | .020-.125  | 5-3.2     | 3/16" (.187)                | #11 (.192-.196)            | .375                       | .060                         | .325                | 8.3  | 610  | 870     |
| SB6-4           | M50147          | .126-.250  | 3.3-6.4   | 4.8                         | (4.88-4.98)                | 9.53                       | 1.52                         | .450                | 11.5 | 2713                                       | 3889    |
| 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 |  |         |
| SB8-2           | M50179          | .020-.125  | 5-3.2     | 1/4" (.250)                 | F (.257-.261)              | .500                       | .080                         | .375                | 9.4  | 1270                                       | 1550    |
| SB8-4           | M50181          | .126-.250  | 3.3-6.4   | 6.4                         | (6.53-6.63)                | 12.70                      | 2.03                         | .500                | 12.7 | 5649                                       | 6894    |
| 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

|         |        |            |           |              |                 |       |      |       |      |      |      |
|---------|--------|------------|-----------|--------------|-----------------|-------|------|-------|------|------|------|
| SBL4-2  | M50114 | .063-.125  | 1.7-3.2   | 1/8" (.125)  | #30 (.129-.133) | .375  | .065 | .275  | 7.0  | 305  | 410  |
| SBL4-3  | M50124 | .126-.187  | 3.3-4.8   | 3.2          | (3.28-3.38)     | 9.53  | 1.65 | .337  | 8.6  | 1356 | 1823 |
| 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 |      |      |
| SBL5-4  | M50138 | .188-.250  | 4.9-6.4   | 5/32" (.156) | #20 (.160-.164) | .468  | .070 | .425  | 10.8 | 420  | 600  |
| SBL5-6  | M50139 | .251-.375  | 6.5-9.5   | 4.0          | (4.06-4.16)     | 11.90 | 1.77 | .550  | 14.0 | 1868 | 2668 |
| SBL5-8  | M50110 | .376-.500  | 9.6-12.7  |              |                 |       |      | .675  | 17.2 |      |      |
| SBL6-4  | M50148 | .126-.250  | 3.3-6.4   | 3/16" (.187) | #11 (.192-.196) | .615  | .090 | .450  | 11.5 | 610  | 870  |
| SBL6-6  | M50150 | .251-.375  | 6.5-9.5   | 4.8          | (4.88-4.98)     | 15.88 | 2.28 | .575  | 14.6 | 2713 | 3869 |
| 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

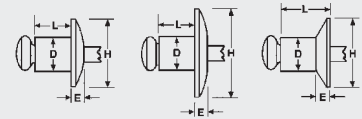
|       |        |           |          |              |                 |      |      |      |      |      |      |
|-------|--------|-----------|----------|--------------|-----------------|------|------|------|------|------|------|
| SC4-2 | M50113 | .092-.125 | 2.3-3.2  | 1/8" (.125)  | #30 (.129-.133) | .220 | .031 | .275 | 7.0  | 305  | 410  |
| SC4-3 | M50116 | .126-.187 | 3.3-4.8  | 3.2          | (3.28-3.38)     | 5.59 | 1.14 | .337 | 8.6  | 1356 | 1823 |
| 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 |      |      |
| SC5-4 | M50140 | .188-.250 | 4.9-6.4  | 5/32" (.156) | #20 (.160-.164) | .281 | .040 | .425 | 10.8 | 420  | 600  |
|       |        |           |          | 4.0          | (4.06-4.16)     | 7.20 | 1.20 |      |      | 1868 | 2668 |
| SC6-4 | M50151 | .151-.250 | 3.8-6.4  | 3/16" (.187) | #11 (.192-.196) | .350 | .050 | .450 | 11.4 | 610  | 870  |
| SC6-6 | M50129 | .251-.375 | 6.5-9.5  | 4.8          | (4.88-4.98)     | 8.89 | 1.27 | .575 | 14.6 | 2713 | 3869 |

KLICK-FAST RIVETS conform to IFI-114 (inch) and IFI-505 (metric). Millimeters (mm) and newtons (N) are in green.

\*\* Also available in various packaged quantities.



# Aluminum Rivets



## 5052 Aluminum Rivet • Aluminum Mandrel • IFI Grade 11

### Buttonhead

| AFS Description | Bulk Part No.** | Grip Range |           | D Rivet Dia. Nom. Inch | Drill No. & Hole Size | H Head Dia. Nom. Inch | E Head Height Max. Inch | L Rivet Length Max. |      | Typical Ultimate Strength (newtons) |         |
|-----------------|-----------------|------------|-----------|------------------------|-----------------------|-----------------------|-------------------------|---------------------|------|-------------------------------------|---------|
|                 |                 | Inch       | (mm)      |                        |                       |                       |                         | Inch                | (mm) | Shear                               | Tensile |
| AB3-2A          | M50200          | .020-.125  | .5-3.2    | <b>3/32" (.094)</b>    | #41 (.097-.100)       | .188                  | .032                    | .250                | 6.4  | 80                                  | 120     |
| AB3-4A          | M50202          | .126-.250  | 3.3-6.4   | 2.4                    | (2.46-2.54)           | 4.78                  | .810                    | .375                | 9.5  | 355                                 | 533     |
| AB4-1A          | M50211          | .020-.062  | .5-1.6    | <b>1/8" (.125)</b>     | #30 (.129-.133)       | .250                  | .040                    | .212                | 5.4  | 155                                 | 240     |
| AB4-2A          | M50212          | .063-.125  | 1.7-3.2   | 3.2                    | (3.28-3.38)           | 6.35                  | 1.02                    | .275                | 7.0  | 689                                 | 1067    |
| AB4-3A          | M50215          | .126-.187  | 3.3-4.8   |                        |                       |                       |                         | .337                | 8.6  |                                     |         |
| AB4-4A          | M50217          | .188-.250  | 4.9-6.4   |                        |                       |                       |                         | .400                | 10.2 |                                     |         |
| AB4-5A          | M50220          | .251-.312  | 6.5-7.9   |                        |                       |                       |                         | .462                | 11.7 |                                     |         |
| AB4-6A          | M50221          | .313-.375  | 8.0-9.5   |                        |                       |                       |                         | .525                | 13.4 |                                     |         |
| AB4-8A          | M50222          | .376-.500  | 9.6-12.7  |                        |                       |                       |                         | .650                | 16.5 |                                     |         |
| AB4-10A         | M50225          | .501-.625  | 12.8-15.9 |                        |                       |                       |                         | .775                | 19.7 |                                     |         |
| AB5-2A          | M50232          | .020-.125  | .5-3.2    | <b>5/32" (.156)</b>    | #20 (.160-.164)       | .312                  | .050                    | .300                | 7.6  | 230                                 | 340     |
| AB5-3A          | M50234          | .126-.187  | 3.3-4.8   | 4.0                    | (4.06-4.16)           | 7.92                  | 1.27                    | .362                | 9.2  | 1023                                | 1512    |
| AB5-4A          | M50235          | .188-.250  | 4.9-6.4   |                        |                       |                       |                         | .425                | 10.8 |                                     |         |
| AB5-6A          | M50236          | .251-.375  | 6.5-9.5   |                        |                       |                       |                         | .550                | 14.0 |                                     |         |
| AB5-8A          | M50237          | .376-.500  | 9.6-12.7  |                        |                       |                       |                         | .675                | 17.2 |                                     |         |
| AB5-10A         | M50238          | .501-.625  | 12.8-17.1 |                        |                       |                       |                         | .800                | 20.3 |                                     |         |
| AB5-12A         | M50239          | .626-.750  | 17.2-19.1 |                        |                       |                       |                         | .925                | 23.5 |                                     |         |
| AB6-2A          | M50245          | .020-.125  | .5-3.2    | <b>3/16" (.187)</b>    | #11 (.192-.196)       | .375                  | .060                    | .325                | 8.3  | 330                                 | 515     |
| AB6-4A          | M50247          | .126-.250  | 3.3-6.4   | 4.8                    | (4.88-4.98)           | 9.53                  | 1.52                    | .450                | 11.5 | 1467                                | 2290    |
| AB6-6A          | M50249          | .251-.375  | 6.5-9.5   |                        |                       |                       |                         | .575                | 14.6 |                                     |         |
| AB6-8A          | M50252          | .376-.500  | 9.6-12.7  |                        |                       |                       |                         | .700                | 17.8 |                                     |         |
| AB6-10A         | M50255          | .501-.625  | 12.8-15.9 |                        |                       |                       |                         | .825                | 21.0 |                                     |         |
| AB6-12A         | M50259          | .626-.750  | 16.0-19.1 |                        |                       |                       |                         | .950                | 24.2 |                                     |         |
| AB6-14A         | M50263          | .751-.875  | 19.2-22.2 |                        |                       |                       |                         | 1.075               | 27.3 |                                     |         |
| AB6-16A         | M50266          | .876-1.000 | 22.3-25.4 |                        |                       |                       |                         | 1.200               | 30.5 |                                     |         |
| AB8-4A          | M50281          | .126-.250  | 3.3-6.4   | <b>1/4" (.250)</b>     | F (.257-.261)         | .500                  | .080                    | .500                | 12.7 | 600                                 | 800     |
| AB8-6A          | M50283          | .251-.375  | 6.5-9.5   | 6.4                    | (6.53-6.63)           | 12.70                 | 1.88                    | .625                | 15.9 | 2668                                | 3558    |
| AB8-8A          | M50285          | .376-.500  | 9.6-12.7  |                        |                       |                       |                         | .750                | 19.1 |                                     |         |
| AB8-10A         | M50287          | .501-.625  | 12.8-15.9 |                        |                       |                       |                         | .875                | 21.0 |                                     |         |
| AB8-12A         | M50289          | .626-.750  | 16.0-19.1 |                        |                       |                       |                         | 1.000               | 25.4 |                                     |         |
| AB8-14A         | M50288          | .751-.875  | 19.2-22.2 |                        |                       |                       |                         | 1.125               | 28.6 |                                     |         |

### Large Flange

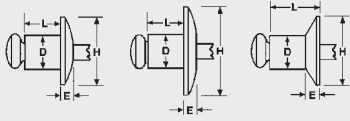
|          |        |           |           |                     |                 |       |      |       |      |      |      |
|----------|--------|-----------|-----------|---------------------|-----------------|-------|------|-------|------|------|------|
| ABL4-2A  | M50214 | .063-.125 | 1.7-3.2   | <b>1/8" (.125)</b>  | #30 (.129-.133) | .375  | .065 | .275  | 7.0  | 155  | 240  |
| ABL4-3A  | M50224 | .126-.187 | 3.3-4.8   | 3.2                 | (3.28-3.38)     | 9.53  | 1.14 | .337  | 8.6  | 689  | 1067 |
| ABL4-4A  | M50219 | .188-.250 | 4.9-6.4   |                     |                 |       |      | .400  | 10.2 |      |      |
| ABL4-6A  | M50226 | .313-.375 | 8.0-9.5   |                     |                 |       |      | .525  | 13.3 |      |      |
| ABL4-8A  | M50227 | .376-.500 | 9.6-12.7  |                     |                 |       |      | .650  | 16.5 |      |      |
| ABL5-4A  | M50244 | .188-.250 | 4.9-6.4   | <b>5/32" (.156)</b> | #20 (.160-.164) | .468  | .070 | .425  | 10.8 | 230  | 340  |
|          |        |           |           | 4.0                 | (4.06-4.16)     | 11.90 | 1.20 |       |      | 1023 | 1512 |
| ABL6-4A  | M50248 | .126-.250 | 3.3-6.4   | <b>3/16" (.187)</b> | #11 (.192-.196) | .615  | .090 | .450  | 11.5 | 330  | 515  |
| ABL6-6A  | M50250 | .251-.375 | 6.5-9.5   | 4.8                 | (4.88-4.98)     | 15.88 | 2.28 | .575  | 14.6 | 1467 | 2290 |
| ABL6-8A  | M50253 | .376-.500 | 9.6-12.7  |                     |                 |       |      | .700  | 17.8 |      |      |
| ABL6-10A | M50256 | .501-.625 | 12.8-15.9 |                     |                 |       |      | .825  | 21.0 |      |      |
| ABL6-12A | M50260 | .626-.750 | 16.0-19.1 |                     |                 |       |      | .950  | 24.2 |      |      |
| ABL6-16A | M50267 | .875-1.00 | 22.2-25.4 |                     |                 |       |      | 1.200 | 30.5 |      |      |

### 120° Countersunk

|        |        |           |          |                     |                 |      |      |      |      |      |      |
|--------|--------|-----------|----------|---------------------|-----------------|------|------|------|------|------|------|
| AC4-2A | M50213 | .092-.125 | 2.3-3.2  | <b>1/8" (.125)</b>  | #30 (.129-.133) | .220 | .031 | .275 | 7.0  | 155  | 240  |
| AC4-3A | M50216 | .126-.187 | 3.3-4.8  | 3.2                 | (3.28-3.38)     | 5.59 | 1.14 | .337 | 8.6  | 689  | 1050 |
| AC4-4A | M50218 | .188-.250 | 4.9-6.4  |                     |                 |      |      | .400 | 10.2 |      |      |
| AC4-6A | M50241 | .313-.375 | 8.0-9.5  |                     |                 |      |      | .525 | 13.3 |      |      |
| AC5-4A | M50240 | .188-.250 | 4.9-6.4  | <b>5/32" (.156)</b> | #20 (.160-.164) | .281 | .040 | .425 | 10.8 | 230  | 340  |
| AC5-6A | M50242 | .313-.375 | 8.0-9.5  | 4.0                 | (4.06-4.16)     | 7.20 | 1.20 | .550 | 14.0 | 1020 | 1512 |
| AC6-4A | M50251 | .151-.250 | 3.8-6.4  | <b>3/16" (.187)</b> | #11 (.192-.196) | .350 | .050 | .407 | 10.3 | 330  | 515  |
| AC6-6A | M50229 | .251-.375 | 6.5-9.5  | 4.8                 | (4.88-4.98)     | 8.89 | 1.27 | .575 | 14.6 | 1467 | 2290 |
| AC6-8A | M50246 | .376-.500 | 9.6-12.7 |                     |                 |      |      | .700 | 17.8 |      |      |

KLIK-FAST RIVETS conform to IFI-114 (inch) and IFI-505 (metric). Millimeters (mm) and newtons (N) are in green.

\*\* Also available in various packaged quantities.



# Aluminum/Steel Rivets

## 5056 Aluminum Rivet • Coated Steel Mandrel • IFI Grade 19

### Buttonhead

| AFS Description | Bulk Part No.** | Grip Range |           | D Rivet Dia. Nom. Inch | Drill No. & Hole Size | H Head Dia. Nom. Inch | E Head Height Max. Inch | L Rivet Length Max. |      | Typical Ultimate Strength (lbs.) (newtons) |         |
|-----------------|-----------------|------------|-----------|------------------------|-----------------------|-----------------------|-------------------------|---------------------|------|--|---------|
|                 |                 | Inch       | (mm)      |                        |                       |                       |                         | Inch                | (mm) | Shear                                      | Tensile |
| AB3-2           | M50300          | .020-.125  | .5-3.2    | 3/32" (.094)           | #41 (.097-.100)       | .188                  | .032                    | .250                | 6.4  | 120  | 160     |
| AB3-4           | M50302          | .126-.250  | 3.3-6.4   | 2.4                    | (2.46-2.54)           | 4.78                  | .810                    | .375                | 9.5  | 534  | 711     |
| AB4-1           | M50311          | .020-.062  | .5-1.6    | 1/8" (.125)            | #30 (.129-.133)       | .250                  | .040                    | .212                | 5.4  | 225  | 315     |
| AB4-2           | M50312          | .063-.125  | 1.7-3.2   | 3.2                    | (3.28-3.38)           | 6.35                  | 1.02                    | .275                | 7.0  | 1000                                       | 1401    |
| AB4-3           | M50315          | .126-.187  | 3.3-4.8   |                        |                       |                       |                         | .337                | 8.6  |  |         |
| AB4-4           | M50317          | .188-.250  | 4.9-6.4   |                        |                       |                       |                         | .400                | 10.2 |  |         |
| AB4-5           | M50320          | .251-.312  | 6.5-7.9   |                        |                       |                       |                         | .462                | 11.7 |  |         |
| AB4-6           | M50321          | .313-.375  | 8.0-9.5   |                        |                       |                       |                         | .525                | 13.4 |  |         |
| AB4-8           | M50322          | .376-.500  | 9.6-12.7  |                        |                       |                       |                         | .650                | 16.5 |  |         |
| AB4-10          | M50325          | .501-.625  | 12.8-15.9 |                        |                       |                       |                         | .775                | 19.7 |  |         |
| AB5-2           | M50332          | .020-.125  | .5-3.2    | 5/32" (.156)           | #20 (.160-.164)       | .312                  | .050                    | .300                | 7.6  | 300  | 470     |
| AB5-3           | M50334          | .126-.187  | 3.3-4.8   | 4.0                    | (4.06-4.16)           | 7.92                  | 1.27                    | .362                | 9.2  | 1334                                       | 2090    |
| AB5-4           | M50335          | .188-.250  | 4.9-6.4   |                        |                       |                       |                         | .425                | 10.8 |  |         |
| AB5-6           | M50336          | .251-.375  | 6.5-9.5   |                        |                       |                       |                         | .550                | 14.0 |  |         |
| AB5-8           | M50337          | .376-.500  | 9.6-12.7  |                        |                       |                       |                         | .675                | 17.2 |  |         |
| AB6-2           | M50345          | .020-.125  | .5-3.2    | 3/16" (.187)           | #11 (.192-.196)       | .375                  | .060                    | .325                | 8.3  | 465  | 700     |
| AB6-4           | M50347          | .126-.250  | 3.3-6.4   | 4.8                    | (4.88-4.98)           | 9.53                  | 1.52                    | .450                | 11.5 | 2068                                       | 3113    |
| AB6-6           | M50349          | .251-.375  | 6.5-9.5   |                        |                       |                       |                         | .575                | 14.6 |  |         |
| AB6-8           | M50352          | .376-.500  | 9.6-12.7  |                        |                       |                       |                         | .700                | 17.8 |  |         |
| AB6-10          | M50355          | .501-.625  | 12.8-15.9 |                        |                       |                       |                         | .825                | 21.0 |  |         |
| AB6-12          | M50359          | .626-.750  | 16.0-19.1 |                        |                       |                       |                         | .950                | 24.2 |  |         |
| AB6-16          | M50366          | .751-1.00  | 19.2-25.4 |                        |                       |                       |                         | 1.200               | 30.5 |  |         |
| AB8-4           | M50381          | .126-.250  | 3.3-6.4   | 1/4" (.250)            | F (.257-.261)         | .500                  | .080                    | .500                | 12.7 | 990  | 1195    |
| AB8-6           | M50383          | .251-.375  | 6.5-9.5   | 6.4                    | (6.53-6.63)           | 12.70                 | 1.88                    | .625                | 15.9 | 4403                                       | 5315    |
| AB8-8           | M50385          | .376-.500  | 9.6-12.7  |                        |                       |                       |                         | .750                | 19.1 |  |         |
| AB8-10          | M50387          | .501-.625  | 12.8-15.9 |                        |                       |                       |                         | .875                | 21.0 |  |         |
| AB8-12          | M50389          | .626-.750  | 16.0-19.1 |                        |                       |                       |                         | 1.000               | 25.4 |  |         |
| AB8-14          | M50388          | .751-.875  | 19.2-22.2 |                        |                       |                       |                         | 1.125               | 28.6 |  |         |
| AB8-16          | M50390          | .876-1.000 | 22.3-25.4 |                        |                       |                       |                         | 1.250               | 31.8 |  |         |

### Large Flange

|         |        |            |           |              |                 |       |      |       |      |      |      |
|---------|--------|------------|-----------|--------------|-----------------|-------|------|-------|------|------|------|
| ABL4-2  | M50314 | .063-.125  | 1.7-3.2   | 1/8" (.125)  | #30 (.129-.133) | .375  | .065 | .275  | 7.0  | 225  | 315  |
| ABL4-3  | M50324 | .126-.187  | 3.3-4.8   | 3.2          | (3.28-3.38)     | 9.53  | 1.65 | .337  | 8.6  | 1000 | 1401 |
| ABL4-4  | M50319 | .188-.250  | 4.9-6.4   |              |                 |       |      | .400  | 10.2 |      |      |
| ABL4-6  | M50326 | .313-.375  | 8.0-9.5   |              |                 |       |      | .525  | 13.3 |      |      |
| ABL5-4  | M50338 | .126-.250  | 3.2-6.4   | 5/32" (.156) | #20 (.160-.164) | .468  | .070 | .425  | 10.8 | 300  | 470  |
|         |        |            |           | 4.0          | (4.06-4.16)     | 11.9  | 1.78 |       |      | 1334 | 2090 |
| ABL6-4  | M50348 | .126-.250  | 3.3-6.4   | 3/16" (.187) | #11 (.192-.196) | .615  | .090 | .450  | 11.5 | 465  | 700  |
| ABL6-6  | M50350 | .251-.375  | 6.5-9.5   | 4.8          | (4.88-4.98)     | 15.88 | 2.08 | .575  | 14.6 | 2068 | 3113 |
| ABL6-8  | M50353 | .376-.500  | 9.6-12.7  |              |                 |       |      | .700  | 17.8 |      |      |
| ABL6-10 | M50356 | .501-.625  | 12.8-15.9 |              |                 |       |      | .825  | 21.0 |      |      |
| ABL6-12 | M50360 | .626-.750  | 16.0-19.1 |              |                 |       |      | .950  | 24.2 |      |      |
| ABL6-14 | M50365 | .751-.875  | 19.2-22.2 |              |                 |       |      | 1.075 | 27.3 |      |      |
| ABL6-16 | M50367 | .876-1.000 | 22.3-25.4 |              |                 |       |      | 1.200 | 30.5 |      |      |

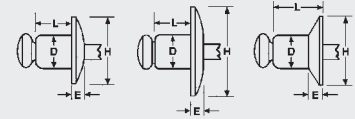
### 120° Countersunk

|       |        |           |          |              |                 |      |      |      |      |      |      |
|-------|--------|-----------|----------|--------------|-----------------|------|------|------|------|------|------|
| AC4-2 | M50313 | .092-.125 | 2.3-3.2  | 1/8" (.125)  | #30 (.129-.133) | .220 | .031 | .275 | 7.0  | 225  | 315  |
| AC4-3 | M50316 | .126-.187 | 3.3-4.8  | 3.2          | (3.28-3.38)     | 5.59 | 1.14 | .337 | 8.6  | 1000 | 1401 |
| AC4-4 | M50318 | .188-.250 | 4.9-6.4  |              |                 |      |      | .400 | 10.2 |      |      |
| AC4-5 | M50323 | .251-.312 | 6.5-9.5  |              |                 |      |      | .525 | 11.7 |      |      |
| AC5-4 | M50340 | .188-.250 | 4.9-6.4  | 5/32" (.156) | #20 (.160-.164) | .281 | .040 | .425 | 10.8 | 300  | 470  |
| AC5-6 | M50342 | .251-.375 | 6.5-9.5  | 4.0          | (4.06-4.16)     | 7.2  | 1.20 | .550 | 14.0 | 1334 | 2090 |
| AC5-8 | M50343 | .376-.500 | 9.6-12.7 |              |                 |      |      | .675 | 17.2 |      |      |
| AC6-4 | M50346 | .151-.250 | 3.8-6.4  | 3/16" (.187) | #11 (.192-.196) | .350 | .050 | .407 | 10.3 | 465  | 700  |
| AC6-6 | M50329 | .251-.375 | 6.5-9.5  | 4.8          | (4.88-4.98)     | 8.89 | 1.27 | .575 | 14.6 | 2068 | 3113 |
| AC6-8 | M50306 | .376-.500 | 9.6-12.7 |              |                 |      |      | .700 | 17.8 |      |      |

KLIIK-FAST RIVETS conform to IFI-114 (inch) and IFI-505 (metric). Millimeters (mm) and newtons (N) are in green.

\*\* Also available in various packaged quantities.

# Stainless Rivets



## Stainless Rivet • Stainless Mandrel • IFI Grade 51 Buttonhead

| AFS Description | Bulk Part No.** | Grip Range |           | D Rivet Dia. Nom. Inch (mm) | Drill No. & Hole Size (mm) | H Head Dia. Nom. Inch (mm) | E Head Height Max. Inch (mm) | L Rivet Length Max. |      | Typical Ultimate Strength (lbs.) (newtons) |         |
|-----------------|-----------------|------------|-----------|-----------------------------|----------------------------|----------------------------|------------------------------|---------------------|------|--|---------|
|                 |                 | Inch       | (mm)      |                             |                            |                            |                              | Inch                | (mm) | Shear                                      | Tensile |
| SSB4-1S         | M50411          | .020-.062  | .5-1.6    | 1/8" (.125)                 | #30 (.129-.133)            | .250                       | .040                         | .212                | 5.4  | 520  | 600     |
| SSB4-2S         | M50412          | .063-.125  | 1.7-3.2   | 3.2                         | (3.28-3.38)                | 6.35                       | 1.02                         | .275                | 7.0  | 2310                                       | 2660    |
| 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 |  |         |
| SSB5-2S         | M50432          | .020-.125  | .5-3.2    | 5/32" (.156)                | #20 (.160-.164)            | .312                       | .045                         | .300                | 7.6  | 785  | 1040    |
| SSB5-3S         | M50434          | .126-.187  | 3.3-4.8   | 4.0                         | (4.06-4.16)                | 7.92                       | 1.14                         | .338                | 8.0  | 3490                                       | 4620    |
| 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 |  |         |
| SSB6-2S         | M50445          | .020-.125  | .5-3.2    | 3/16" (.187)                | #11 (.192-.196)            | .375                       | .066                         | .325                | 8.3  | 1150                                       | 1300    |
| SSB6-4S         | M50447          | .126-.250  | 3.3-6.4   | 4.8                         | (4.88-4.98)                | 9.53                       | 1.40                         | .450                | 11.5 | 5110                                       | 5780    |
| 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 |  |         |
| SSB8-4S         | M50481          | .126-.250  | 3.3-6.4   | 1/4" (.250)                 | F (.257-.261)              | .500                       | .074                         | .500                | 12.7 | 1700                                       | 2100    |
| SSB8-6S         | M50483          | .251-.375  | 6.5-9.5   | 6.4                         | (6.53-6.63)                | 12.70                      | 1.88                         | .625                | 15.9 | 7560                                       | 9340    |
| 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

|           |        |           |           |              |                 |       |      |      |      |      |      |
|-----------|--------|-----------|-----------|--------------|-----------------|-------|------|------|------|------|------|
| SSBL4-2S  | M50409 | .063-.125 | 1.7-3.2   | 1/8" (.125)  | #30 (.129-.133) | .375  | .045 | .275 | 7.0  | 520  | 600  |
| SSBL4-3S  | M50416 | .126-.187 | 3.3-4.8   | 3.2          | (3.28-3.38)     | 9.53  | 1.14 | .337 | 8.6  | 2310 | 2660 |
| SSBL4-4S  | M50418 | .188-.250 | 4.9-6.4   |              |                 |       |      | .400 | 10.2 |      |      |
| SSBL6-4S  | M50452 | .126-.250 | 3.3-6.4   | 3/16" (.187) | #11 (.192-.196) | .615  | .082 | .450 | 11.5 | 1150 | 1300 |
| SSBL6-6S  | M50453 | .251-.375 | 6.5-9.5   | 4.8          | (4.88-4.98)     | 15.88 | 2.08 | .575 | 14.6 | 5110 | 5780 |
| 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 |      |      |

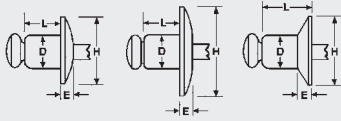
## 120° Countersunk

|         |        |           |         |              |                 |      |      |      |      |      |      |
|---------|--------|-----------|---------|--------------|-----------------|------|------|------|------|------|------|
| SSC4-2S | M50423 | .063-.125 | 2.3-3.2 | 1/8" (.125)  | #30 (.129-.133) | .220 | .031 | .275 | 7.0  | 520  | 600  |
| SSC4-3S | M50424 | .126-.187 | 3.3-4.8 | 3.2          | (3.28-3.38)     | 5.59 | 1.14 | .337 | 8.6  | 2310 | 2660 |
| SSC4-4S | M50425 | .188-.250 | 4.9-6.4 |              |                 |      |      | .400 | 10.2 |      |      |
| SSC4-5S | M50426 | .251-.312 | 6.5-7.9 |              |                 |      |      | .462 | 11.7 |      |      |
| SSC6-4S | M50429 | .151-.250 | 3.8-6.4 | 3/16" (.187) | #11 (.192-.196) | .350 | .050 | .407 | 10.3 | 1150 | 1300 |
|         |        |           |         | 4.8          | (4.88-4.98)     | 8.89 | 1.27 |      |      | 5110 | 5780 |

KLICK-FAST RIVETS conform to IFI-114 (inch) and IFI-505 (metric). Millimeters (mm) and newtons (N) are in green.

\*\* Also available in various packaged quantities.





# Stainless/Steel Rivets

## Stainless Rivet • Coated Steel Mandrel • IFI Grade 50

### Buttonhead

| AFS Description | Bulk Part No.** | Grip Range |           | D Rivet Dia. Nom. Inch | Drill No. & Hole Size | H Head Dia. Nom. Inch | E Head Height Max. Inch | L Rivet Length Max. |      | Typical Ultimate Strength (lbs.) (newtons) |         |
|-----------------|-----------------|------------|-----------|------------------------|-----------------------|-----------------------|-------------------------|---------------------|------|--|---------|
|                 |                 | Inch       | (mm)      |                        |                       |                       |                         | Inch                | (mm) | Shear                                      | Tensile |
| SSB4-1          | M50511          | .020-.062  | .5-1.6    | 1/8" (.125)            | #30 (.129-.133)       | .250                  | .040                    | .212                | 5.4  | 520  | 600     |
| SSB4-2          | M50512          | .063-.125  | 1.7-3.2   | 3.2                    | (3.28-3.38)           | 6.35                  | 1.02                    | .275                | 7.0  | 2310                                       | 2660    |
| 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 |  |         |
| SSB4-8          | M50522          | .376-.500  | 9.6-12.7  |                        |                       |                       |                         | .650                | 16.5 |  |         |
| SSB5-2          | M50532          | .020-.125  | .5-3.2    | 5/32" (.156)           | #20 (.160-.164)       | .312                  | .045                    | .300                | 7.6  | 785  | 1040    |
| SSB5-4          | M50535          | .188-.250  | 4.7-6.4   | 4.0                    | (4.06-4.16)           | 7.92                  | 1.14                    | .425                | 8.0  | 3490                                       | 4620    |
| SSB5-6          | M50536          | .251-.375  | 6.5-9.5   |                        |                       |                       |                         | .550                | 14.0 |  |         |
| SSB6-2          | M50545          | .020-.125  | .5-3.2    | 3/16" (.187)           | #11 (.192-.196)       | .375                  | .055                    | .325                | 8.3  | 1150                                       | 1300    |
| SSB6-4          | M50547          | .126-.250  | 3.3-6.4   | 4.8                    | (4.88-4.98)           | 9.53                  | 1.40                    | .450                | 11.5 | 5110                                       | 5780    |
| 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 |  |         |
| SSB6-16         | M50566          | .751-1.000 | 19.2-25.4 |                        |                       |                       |                         | 1.120               | 30.5 |  |         |

### Large Flange

|          |        |           |           |              |                 |       |      |      |      |      |      |
|----------|--------|-----------|-----------|--------------|-----------------|-------|------|------|------|------|------|
| SSBL4-2  | M50513 | .063-.125 | 1.7-3.2   | 1/8" (.125)  | #30 (.129-.133) | .375  | .045 | .275 | 7.0  | 520  | 600  |
| SSBL4-3  | M50518 | .126-.187 | 3.3-4.8   | 3.2          | (3.28-3.38)     | 9.53  | 1.14 | .337 | 8.6  | 2310 | 2660 |
| SSBL4-4  | M50519 | .188-.250 | 4.9-6.4   |              |                 |       |      | .400 | 10.2 |      |      |
| SSBL6-4  | M50548 | .126-.250 | 3.3-6.4   | 3/16" (.187) | #11 (.192-.196) | .615  | .082 | .450 | 11.5 | 1150 | 1300 |
| SSBL6-6  | M50553 | .251-.375 | 6.5-9.5   | 4.8          | (4.88-4.98)     | 15.88 | 2.08 | .575 | 14.6 | 5110 | 5780 |
| 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 |      |      |

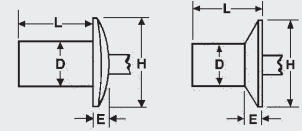
### 120° Countersunk

|        |        |           |         |              |                 |      |      |      |      |      |      |
|--------|--------|-----------|---------|--------------|-----------------|------|------|------|------|------|------|
| SSC4-2 | M50523 | .092-.125 | 2.3-3.2 | 1/8" (.125)  | #30 (.129-.133) | .220 | .031 | .275 | 7.0  | 520  | 600  |
| SSC4-3 | M50524 | .126-.187 | 3.3-4.8 | 3.2          | (3.28-3.38)     | 5.59 | 1.14 | .337 | 8.6  | 2310 | 2660 |
| SSC4-4 | M50525 | .188-.250 | 4.9-6.4 |              |                 |      |      | .400 | 10.2 |      |      |
| SSC4-5 | M50528 | .251-.312 | 6.5-7.9 |              |                 |      |      | .462 | 11.7 |      |      |
| SSC6-4 | M50529 | .151-.250 | 3.8-6.4 | 3/16" (.187) | #11 (.192-.196) | .350 | .050 | .407 | 10.3 | 1150 | 1300 |
|        |        |           |         | 4.8          | (4.88-4.98)     | 8.89 | 1.27 |      |      | 5110 | 5780 |

KLIK-FAST RIVETS conform to IFI-114 (inch) and IFI-505 (metric). Millimeters (mm) and newtons (N) are in green.

\*\* Also available in various packaged quantities.

# Closed-End Rivets



## 5056 Aluminum/Steel • IFI Grade 19 Buttonhead

| AFS Description | Bulk Part No.** | Grip Range |           | D Rivet Dia. Nom. Inch | Drill No. & Hole Size | H Head Dia. Nom. Inch | E Head Height Max. Inch | L Rivet Length Max. |       | Typical Ultimate Strength (lbs.) (newtons) |         |
|-----------------|-----------------|------------|-----------|------------------------|-----------------------|-----------------------|-------------------------|---------------------|-------|--|---------|
|                 |                 | Inch       | (mm)      |                        |                       |                       |                         | Inch                | (mm)  | Shear                                      | Tensile |
| AB4-1C          | M56000          | .020-.062  | .5-1.6    | 1/8"(.125)             | #30                   | .236                  | .050                    | .297                | 7.54  | 240  | 280     |
| AB4-2C          | M56001          | .063-.125  | 1.7-3.2   | 3.2                    | (.129-.133)           | 5.99                  | 1.27                    | .360                | 9.14  | 1060                                       | 1240    |
| 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 |  |         |
| AB5-2C          | M56005          | .020-.125  | .51-3.2   | 5/32"(.157)            | #20                   | .315                  | .065                    | .375                | 9.53  | 350  | 480     |
| AB5-3C          | M56006          | .126-.187  | 3.3-4.8   | 4.0                    | (.160-.164)           | 8.00                  | 1.65                    | .437                | 11.10 | 1550                                       | 2130    |
| AB5-5C          | M56007          | .188-.312  | 4.9-6.35  |                        |                       |                       |                         | .562                | 12.70 |  |         |
| AB6-2C          | M56008          | .020-.125  | .51-3.2   | 3/16"(.188)            | #11                   | .374                  | .080                    | .406                | 10.31 | 500  | 690     |
| AB6-4C          | M56009          | .126-.250  | 3.3-4.75  | 4.8                    | (.192-.196)           | 9.50                  | 2.03                    | .531                | 11.89 | 2230                                       | 3070    |
| 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 |  |         |
| AB8-4C          | M56013          | .126-.250  | 3.2-6.4   | 1/4"(.252)             | F                     | .512                  | .090                    | .570                | 14.48 | 900  | 1100    |
| AB8-6C          | M56014          | .251-.375  | 6.5-9.5   | 6.4                    | (.257-.261)           | 13.0                  | 2.29                    | .695                | 17.65 | 3950                                       | 5000    |

## 120° Countersunk

|        |        |           |          |             |             |      |       |      |       |      |      |
|--------|--------|-----------|----------|-------------|-------------|------|-------|------|-------|------|------|
| AC4-2C | M56016 | .063-.125 | 1.7-3.2  | 1/8"(.125)  | #30         | .236 | .050  | .395 | 10.03 | 240  | 280  |
| AC4-3C | M56017 | .126-.187 | 3.3-4.8  | 3.2         | (.129-.133) | 5.99 | 1.27  | .457 | 11.61 | 1060 | 1240 |
| AC4-4C | M56018 | .188-.250 | 4.9-6.4  |             |             |      |       | .520 | 13.21 |      |      |
| AC6-4C | M56019 | .126-.250 | 3.3-4.75 | 3/16"(.188) | #11         | .374 | .540  | .601 | 13.67 | 500  | 690  |
|        |        |           |          | 4.8         | (.192-.196) | 9.50 | 13.72 |      |       | 2230 | 3070 |

## All Aluminum Buttonhead • IFI Grade 15

|          |        |           |           |             |             |      |      |      |       |      |      |
|----------|--------|-----------|-----------|-------------|-------------|------|------|------|-------|------|------|
| AB4-2AC  | M56201 | .063-.125 | 1.7-3.2   | 1/8"(.125)  | #30         | .236 | .050 | .360 | 9.14  | 99   | 108  |
| AB4-3AC  | M56202 | .126-.187 | 3.3-4.8   | 3.2         | (.129-.133) | 5.99 | 1.27 | .422 | 10.72 | 450  | 490  |
| AB4-4AC  | M56203 | .188-.250 | 4.9-6.4   |             |             |      |      | .485 | 12.32 |      |      |
| AB5-4AC  | M56207 | .126-.250 | 3.3-4.75  | 5/32"(.157) | #20         | .315 | .065 |      | 11.10 | 127  | 180  |
|          |        |           |           | 4.0         | (.160-.164) | 8.00 | 1.65 | .500 | 12.70 | 198  | 246  |
| AB6-2AC  | M56208 | .020-.125 | .51-3.2   | 3/16"(.188) | #11         | .374 | .080 | .406 | 10.31 | 900  | 1120 |
| AB6-4AC  | M56209 | .126-.250 | 3.3-4.75  | 4.8         | (.192-.196) | 9.50 | 2.03 | .531 | 11.89 | 3950 | 5090 |
| 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 |      |      |

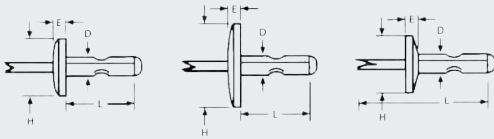
## All Stainless Buttonhead

|           |        |           |           |             |             |      |      |      |       |      |      |
|-----------|--------|-----------|-----------|-------------|-------------|------|------|------|-------|------|------|
| SSB4-2SC  | M56403 | .020-.125 | .51-3.2   | 1/8"(.125)  | #30         | .236 | .039 | .360 | 9.14  | 441  | 551  |
| SSB4-3SC  | M56405 | .126-.187 | 3.3-4.8   | 3.2         | (.129-.133) | 5.99 | .990 | .422 | 10.72 | 2000 | 2500 |
| SSB4-4SC  | M56406 | .188-.250 | 4.9-6.4   |             |             |      |      | .485 | 12.32 |      |      |
| SSB6-2SC  | M56408 | .020-.125 | .51-3.2   | 3/16"(.188) | #11         | .374 | .070 | .406 | 10.31 | 991  | 1210 |
| SSB6-4SC  | M56409 | .126-.250 | 3.3-4.75  | 4.8         | (.192-.196) | 9.49 | 1.77 | .531 | 11.89 | 4500 | 5500 |
| 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-126 (inch). Millimeters (mm) and newtons (N) are in green.

\*\*Also available in packaged quantities.



Buttonhead

Large Flange

Countersunk

# Multi-Grip Rivets

## Plated Steel Rivet • Steel Mandrel

### Steel Buttonhead

| AFS Description | Bulk Part No.** | Grip Range |         | D Rivet Dia. Nom. Inch | Drill No. & Hole Size | H Head Dia. Nom. Inch | E Head Height Max. Inch | L Rivet Length Max. |      | Typical Ultimate Strength (lbs.) (newtons) |         |
|-----------------|-----------------|------------|---------|------------------------|-----------------------|-----------------------|-------------------------|---------------------|------|--|---------|
|                 |                 | Inch       | (mm)    |                        |                       |                       |                         | Inch                | (mm) | Shear                                      | Tensile |
| SB41-42MG       | M56112          | .043-.156  | 1.1-4.0 | 1/8"(.125)             | #30(.129-.133)        | .283                  | .033                    | .355                | 9.0  | 340  | 385     |
|                 |                 |            |         | 3.2                    | (3.28-3.38)           | 7.20                  | .850                    |                     |      | 1510                                       | 1710    |
| SB52-53MG       | M56134          | .056-.196  | 1.4-5.0 | 5/32"(.156)            | #20(.160-.164)        | .319                  | .047                    | .433                | 11.0 | 440  | 530     |
|                 |                 |            |         | 4.0                    | (4.06-4.16)           | 8.10                  | 1.20                    |                     |      | 1960                                       | 2360    |
| SB62-63MG       | M56146          | .047-.187  | 1.2-4.8 | 3/16"(.187)            | #11(.192-.196)        | .386                  | .069                    | .405                | 10.3 | 810  | 750     |
|                 |                 |            |         | 4.8                    | (4.88-4.98)           | 9.80                  | 1.75                    |                     |      | 3605                                       | 3335    |
| SB63-64MG       | M56147          | .156-.250  | 4.0-6.3 |                        |                       |                       |                         | .500                | 12.7 | 1025                                       | 780     |
|                 |                 |            |         |                        |                       |                       |                         |                     |      | 4560                                       | 3470    |

### Aluminum/Steel Buttonhead†

|             |        |           |           |             |                |      |      |      |      |      |      |
|-------------|--------|-----------|-----------|-------------|----------------|------|------|------|------|------|------|
| AB41-43MG   | M56315 | .031-.187 | .8-4.8    | 1/8"(.125)  | #30(.129-.133) | .250 | .037 | .315 | 8.0  | 165  | 230  |
| AB42-44MG   | M56317 | .046-.250 | 1.2-6.4   | 3.2         | (3.28-3.38)    | 6.35 | .95  | .375 | 9.5  | 735  | 1025 |
| AB44-45MG   | M56320 | .156-.312 | 4.0-7.9   |             |                |      |      | .438 | 11.1 |      |      |
| AB45-46MG   | M56321 | .216-.375 | 5.5-9.5   |             |                |      |      | .500 | 12.7 |      |      |
| AB52-54MG   | M56335 | .046-.250 | 1.2-6.4   | 5/32"(.156) | #20(.160-.164) | .312 | .047 | .375 | 9.5  | 255  | 375  |
| AB54-56MG   | M56336 | .156-.375 | 4.0-9.5   | 4.0         | (4.06-4.16)    | 7.92 | 1.20 | .500 | 12.7 | 1135 | 1670 |
| AB56-58MG   | M56337 | .250-.500 | 6.4-12.7  |             |                |      |      | .666 | 16.9 |      |      |
| AB62-64MG   | M56347 | .062-.250 | 1.6-6.4   | 3/16"(.187) | #11(.192-.196) | .386 | .057 | .406 | 10.3 | 350  | 530  |
| AB63-67MG   | M56351 | .187-4.37 | 4.8-11.1  | 4.8         | (4.88-4.98)    | 9.80 | 1.45 | .595 | 15.1 | 1560 | 2360 |
| AB66-68MG   | M56352 | .250-.500 | 6.4-12.7  |             |                |      |      | .666 | 16.9 |      |      |
| AB610-612MG | M56359 | .500-.781 | 12.7-19.8 |             |                |      |      | .978 | 24.8 |      |      |

### Aluminum/Steel Large Flange

|              |        |           |           |             |                |       |      |      |      |      |      |
|--------------|--------|-----------|-----------|-------------|----------------|-------|------|------|------|------|------|
| ABL42-43MG   | M56314 | .031-.187 | .8-4.8    | 1/8"(.125)  | #30(.129-.133) | .325  | .039 | .315 | 8.0  | 165  | 230  |
| ABL42-44MG   | M56319 | .046-.250 | 1.2-6.4   | 3.2         | (3.28-3.38)    | 8.25  | 1.00 | .375 | 9.5  | 735  | 1025 |
| ABL44-45MG   | M56322 | .156-.312 | 4.0-7.9   |             |                |       |      | .438 | 11.1 |      |      |
| ABL52-54MG   | M56241 | .062-.250 | 1.6-6.4   | 5/32"(.156) | #20(.160-.164) | .374  | .051 | .375 | 9.5  | 255  | 375  |
| ABL53-55MG   | M56340 | .125-.312 | 3.2-7.9   | 4.0         | (4.06-4.16)    | 9.50  | 1.30 | .438 | 11.1 | 1135 | 1670 |
| ABL55-58MG   | M56342 | .251-.500 | 6.4-12.7  |             |                |       |      | .690 | 17.5 |      |      |
| ABL62-64MG   | M56350 | .062-.250 | 1.6-6.4   | 3/16"(.187) | #11(.192-.196) | .625  | .069 | .406 | 10.3 | 350  | 530  |
| ABL66-68MG   | M56353 | .250-.500 | 6.4-12.7  | 4.8         | (4.88-4.98)    | 15.85 | 1.75 | .666 | 16.9 | 1560 | 2360 |
| ABL610-612MG | M56360 | .500-.781 | 12.7-19.8 |             |                |       |      | .978 | 24.8 |      |      |

### Aluminum/Steel 120° Countersunk

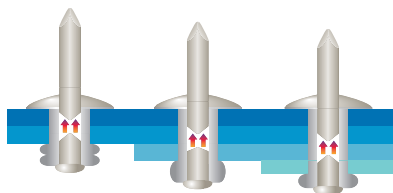
|           |        |           |          |             |                |      |      |      |      |      |      |
|-----------|--------|-----------|----------|-------------|----------------|------|------|------|------|------|------|
| AC43-44MG | M56318 | .093-.250 | 2.4-6.4  | 1/8"(.125)  | #30(.129-.133) | .209 | .029 | .383 | 9.7  | 155  | 206  |
|           |        |           |          | 3.2         | (3.28-3.38)    | 5.30 | .75  |      |      | 690  | 912  |
| AC53-55MG | M56357 | .109-.312 | 2.7-7.9  | 5/32"(.156) | #20(.160-.164) | .252 | .049 | .470 | 11.9 | 255  | 300  |
|           |        |           |          | 4.0         | (4.06-4.16)    | 6.40 | 1.24 |      |      | 1135 | 1670 |
| AC62-65MG | M56361 | .062-.312 | 1.6-7.9  | 3/16"(.187) | #11(.192-.196) | .345 | .051 | .500 | 12.7 | 350  | 530  |
| AC66-68MG | M56362 | .250-.500 | 6.4-12.7 | 4.8         | (4.88-4.98)    | 8.75 | 1.30 | .690 | 17.5 | 1560 | 2360 |

‡ Countersunk—Total Length (L) including head

Millimeters (mm) and newtons (N) are in green.

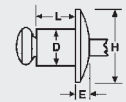
\*\*Also available in packaged quantities.

\*Klik-Fast multi-grip rivets conform to IFI-116.



Multi-grip rivets provide an effective and economical alternative to other, more costly methods of fastening, because one size handles the grip range capacity of up to 3 standard open end rivets. Multi-grip rivets can be used in any application requiring open end rivets, while reducing inventory requirements. Use multi-grip rivets as a standard open-end rivet . . . no special tool is needed.

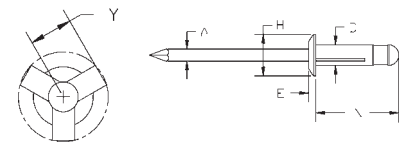
# Specialty Rivets



## #110 Copper/Brass & #110 Copper/Steel (copper-plated mandrel)

| AFS Description | Bulk Part No.** | Grip Range |         | D Rivet Dia. Nom. Inch (mm) | Drill No. & Hole Size (mm) | H Head Dia. Nom. Inch (mm) | E Head Height Max. Inch (mm) | L Rivet Length Max. |      | Typical Ultimate Strength (lbs.) (newtons) |         |
|-----------------|-----------------|------------|---------|-----------------------------|----------------------------|----------------------------|------------------------------|---------------------|------|--|---------|
|                 |                 | Inch       | (mm)    |                             |                            |                            |                              | Inch                | (mm) | Shear                                      | Tensile |
| CB4-2B          | M58600          | .063-.125  | 1.7-3.2 | 1/8" (.125)                 | #30 (.129-.133)            | .250                       | .040                         | .275                | 7.0  | 215  | 300     |
| CB4-4B          | M58602          | .188-.250  | 4.9-6.4 | 3/2                         | 3.3 (3.28-3.38)            | 6.35                       | 1.02                         | .400                | 10.2 | 950  | 1330    |
| CB4-2C          | M56600          | .063-.125  | 1.7-3.2 | 1/8" (.125)                 | #30 (.129-.133)            | .250                       | .040                         | .275                | 7.0  | 215  | 300     |
| CB4-4C          | M56602          | .188-.250  | 4.9-6.4 | 3/2                         | 3.3 (3.28-3.38)            | 6.35                       | 1.02                         | .400                | 10.2 | 950  | 1330    |

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



## Tri-Bulb Rivets

| AFS Description | D            | Grip Range  | Drill No. & Hole Size | A    | E    | H    | N     | Y    | Shear |         | Tensile |         |
|-----------------|--------------|-------------|-----------------------|------|------|------|-------|------|-------|---------|---------|---------|
|                 |              |             |                       |      |      |      |       |      | lbs.  | newtons | lbs.    | newtons |
| A0516ATB        | 5/32" (.156) | .039 - .118 | #20 (.160-.164)       | .091 | .055 | .315 | .630  | .236 | 134   | 600     | 224     | 1000    |
| A0523ATB        |              | .039 - .276 |                       | .091 | .055 | .315 | .835  | .335 | 134   | 600     | 224     | 1000    |
| A0619ATB        | 3/16" (.187) | .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.

## Painted Rivets\*

W=White BR=Brown BL=Black

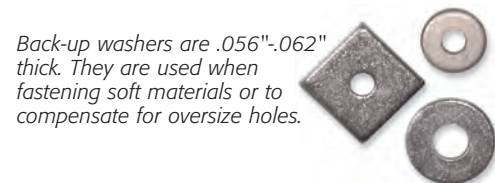
| AFS Description | Bulk Part No.** | Rivet Color | Grip Range |         | D Rivet Dia. Nom. Inch (mm) | Drill No. & Hole Size (mm) | H Head Dia. Nom. Inch (mm) | E Head Height Max. Inch (mm) | L Rivet Length Max. |      | Typical Ultimate Strength (lbs.) (newtons) |         |
|-----------------|-----------------|-------------|------------|---------|-----------------------------|----------------------------|----------------------------|------------------------------|---------------------|------|--|---------|
|                 |                 |             | Inch       | (mm)    |                             |                            |                            |                              | Inch                | (mm) | Shear                                      | Tensile |
| AB4-2AW         | M53032          | W           | .062-.125  | 1.7-3.2 | .125                        | #30 (.129-.133)            | .250                       | .040                         | .275                | 7.0  | 155  | 240     |
| AB4-3AW         | M53007          | W           | .126-.187  | 3.2-4.8 | 3.2                         | (3.28-3.38)                | 6.35                       | 1.02                         | .337                | 8.6  | 689  | 1067    |
| AB4-4AW         | M53009          | W           | .188-.250  | 4.9-6.4 |                             |                            |                            |                              | .400                | 10.2 |  |         |
| AB4-2ABR        | M53097          | BR          | .062-.125  | 1.7-3.2 | .125                        | #30 (.129-.133)            | .275                       | .040                         | .275                | 7.0  | 155  | 240     |
| AB4-3ABR        | M53081          | BR          | .126-.187  | 3.2-4.8 | 3.2                         | (3.28-3.38)                | .337                       | 1.02                         | .337                | 8.6  | 689  | 1067    |
| AB4-4ABR        | M53099          | BR          | .188-.250  | 4.9-6.4 |                             |                            |                            |                              | .400                | 10.2 |  |         |
| AB4-2ABL        | M53098          | BL          | .062-.125  | 1.7-3.2 | .125                        | #30 (.129-.133)            | .275                       | .040                         | .275                | 7.0  | 155  | 240     |
| AB4-3ABL        | M53102          | BL          | .126-.187  | 3.2-4.8 | 3.2                         | (3.28-3.38)                | .337                       | 1.02                         | .337                | 8.6  | 689  | 1067    |
| AB4-4ABL        | M53100          | BL          | .188-.250  | 4.9-6.4 |                             |                            |                            |                              | .400                | 10.2 |  |         |
| SB4-2W          | M53033          | W           | .062-.125  | 1.7-3.2 | .125                        | #30 (.129-.133)            | .275                       | .040                         | .275                | 7.0  | 305  | 410     |
| SB4-3W          | M53034          | W           | .126-.187  | 3.2-4.8 | 3.2                         | (3.28-3.38)                | .337                       | 1.02                         | .337                | 8.6  | 1356                                       | 1823    |
| SB4-4W          | M53036          | W           | .188-.250  | 4.9-6.4 |                             |                            |                            |                              | .400                | 10.2 |  |         |
| SB4-2BR         | M53003          | BR          | .062-.125  | 1.7-3.2 | .125                        | #30 (.129-.133)            | .275                       | .040                         | .275                | 7.0  | 305  | 410     |
| SB4-3BR         | M53011          | BR          | .126-.187  | 3.2-4.8 | 3.2                         | (3.28-3.38)                | .337                       | 1.02                         | .337                | 8.6  | 1356                                       | 1823    |
| SB4-4BR         | M53012          | BR          | .188-.250  | 4.9-6.4 |                             |                            |                            |                              | .400                | 10.2 |  |         |
| SB4-2BL         | M53060          | BL          | .062-.125  | 1.7-3.2 | .125                        | #30 (.129-.133)            | .275                       | .040                         | .275                | 7.0  | 330  | 515     |
| SB4-4BL         | M53051          | BL          | .188-.250  | 3.2-4.8 | 3.2                         | (3.28-3.38)                |                            | 1.02                         | .400                | 10.2 | 1467                                       | 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.

## Back-Up Washers

| AFS 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.

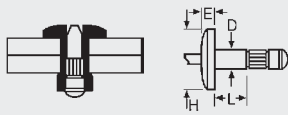


Back-up washers are .056"-.062" thick. They are used when fastening soft materials or to compensate for oversized holes.

## 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.



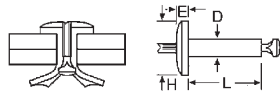


# Specialty Rivets

## Steel Q-Lok™ Rivets

### Plated Steel Body Plated Steel Mandrel

| AFS Description | Bulk Part No.** | Grip Range |          | D Rivet Dia. Nom. Inch (mm) | Drill No. & Hole Size (mm) | H Head Dia. Nom. Inch (mm) | E Head Height Max. Inch (mm) | L Rivet Length Max. |      | Typical Ultimate Strength (lbs.) (newtons) |         |
|-----------------|-----------------|------------|----------|-----------------------------|----------------------------|----------------------------|------------------------------|---------------------|------|--|---------|
|                 |                 | Inch       | (mm)     |                             |                            |                            |                              | Inch                | (mm) | Shear                                      | Tensile |
| SB6-2QL         | M55145          | .062-.125  | 2.3-3.2  | 3/16"(.187)                 | #11(.192-.196)             | .375                       | .065                         | .350                | 8.9  | 1050                                       | 825     |
| SB6-4QL         | M55147          | .126-.250  | 3.3-6.4  | 4.8                         | (4.88-4.98)                | 9.5                        | 1.65                         | .475                | 12.0 | 4670                                       | 3670    |
| SB6-6QL         | M55149          | .251-.375  | 6.5-9.5  |                             |                            |                            |                              | .600                | 15.2 |  |         |
| SB6-8QL         | M55152          | .376-.500  | 9.6-12.7 |                             |                            |                            |                              | .725                | 18.4 |  |         |



### Aluminum/Steel†

## T-Rivets/Klik-Split®

|   |        |           |             |            |              |      |      |      |       |      |      |
|---|--------|-----------|-------------|------------|--------------|------|------|------|-------|------|------|
| — | M52372 | .062-.125 | 1.58-3.18   | 1/4"(.250) | F(.257-.261) | .500 | .120 | .520 | 13.22 | 1500 | 1000 |
| — | M52371 | .032-.140 | .81-3.56    | 6.4        | (.653-6.63)  | 12.7 | 3.00 | .520 | 13.22 | 6670 | 4445 |
| — | 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 |      |      |

† Requires nosepiece No. M96028 when using the Marson brand Big Daddy® or Big Daddy II hand tool.  
KLIK-FAST RIVETS conform to IFI-130 (inch) and IFI-505 (metric). Millimeters (mm) and newtons (N) are in green.

\*\*Also available in packaged quantities.

## Automotive/Special Application Rivets

### Trim Rivets

| AFS Description | Bulk Part No.** | Grip Range | Description                   | Materials Body/Mandrel | Rivet Dia. Nom | Flange Dia. Nom. | Hole Dia. Range | 500 Pack No. |
|-----------------|-----------------|------------|-------------------------------|------------------------|----------------|------------------|-----------------|--------------|
| 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       |

\*Use 39112 Trim Clip Rivet Nosepieces with HP-2 or HP-3 to form trim clip studs with 50261; 50262; 50516 rivets.

### Klik-Split® Window & Door Rivets†

|   |        |           |  |            |      |      |           | 50 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 | Blk. Anodized Door Handle Rivet                              | Alum/Steel | .250 | .500 | .257-.261 | M42375      |
| — | M50376 | .520-.620 | Glass Stop Rivet   | Alum/Steel | .250 | .500 | .257-.261 | M42376      |

† Requires nosepiece No. M96028 when using the Marson brand Big Daddy® or Big Daddy® II hand tool.

### 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      |

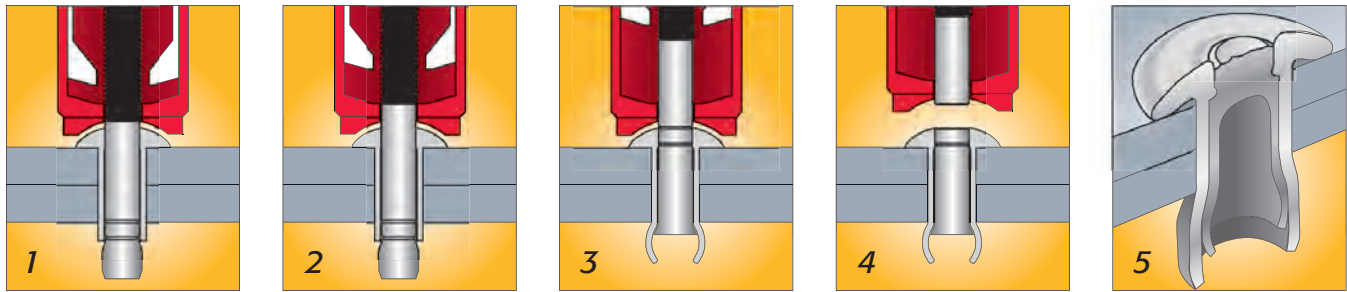
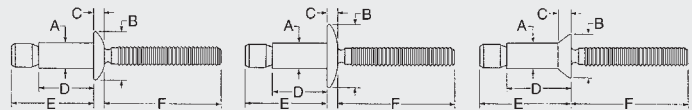
  

|   |        |           |  |             |      |      |           | 100 Pack No. |
|---|--------|-----------|--|-------------|------|------|-----------|--------------|
| — | M53295 | .125-.187 | Rear Window Gasket Rivet                         | Alum/Steel  | .125 | .325 | .129-.130 | M43295       |
| — | M53181 | .125-.250 | Bumper Fascia Rivet w/yellow zinc coated mandrel | Steel/Steel | .250 | .500 | .257-.261 | M43181       |

\*\*Also available in packaged quantities.



# Klik-Lock™ Rivets



**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** A 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.

**5** The expansion of the body tightly fills the hole creating a weather-resistant joint.

| AFS Description | Bulk Part No.** | Grip Range<br>Inch (mm) | A Rivet Dia. Inch (mm) | Required Hole Size Inch (mm) | B Head Dia. Inch (mm) | C Head Height Max. Inch (mm) | D Body Length Max. Inch (mm) | E Overall Length Max. (mm) | F Length Min. Inch (mm) | Average Shear Strength lbs. (newtons) | Average Tensile Strength lbs. (newtons) |
|-----------------|-----------------|-------------------------|------------------------|------------------------------|-----------------------|------------------------------|------------------------------|----------------------------|-------------------------|---------------------------------------|---|
|-----------------|-----------------|-------------------------|------------------------|------------------------------|-----------------------|------------------------------|------------------------------|----------------------------|-------------------------|---------------------------------------|---|

## Steel Rivet • Steel Mandrel • Buttonhead

|          |        |            |      |           |      |      |      |       |          |       |      |
|----------|--------|------------|------|-----------|------|------|------|-------|----------|-------|------|
| SB6-4KL  | M50807 | .062-.270  | .187 | .191-.201 | .385 | .085 | .415 | .733  | .980     | 1450  | 1200 |
|          |        | 1.57-6.85  |      |           |      |      |      | 4.8   | 4.9-5.10 |       |      |
| SB6-7KL  | M50808 | .214-.437  |      |           |      |      |      | .582  | .968     |       |      |
|          |        | 5.43-11.09 |      |           |      |      |      | 14.78 | 22.66    | 24.39 |      |
| SB6-EKL  | M50809 | .062-.437  |      |           |      |      |      | .582  | .991     |       |      |
|          |        | 1.57-11.09 |      |           |      |      |      | 14.78 | 26.19    | 25.17 |      |
| SB8-6KL  | M50810 | .080-.375  | .253 | .261-.272 | .530 | .120 | .560 | .984  | 1.043    | 2750  | 2200 |
|          |        | 2.03-9.52  |      |           |      |      |      | 6.5   | 6.6-6.9  |       |      |
| SB8-10KL | M50811 | .350-.625  |      |           |      |      |      | .810  | 1.043    |       |      |
|          |        | 8.89-15.75 |      |           |      |      |      | 20.57 | 31.34    | 26.49 |      |
| SB8-EKL  | M50812 | .080-.625  |      |           |      |      |      | .810  | 1.043    |       |      |
|          |        | 2.03-15.87 |      |           |      |      |      | 20.57 | 36.04    | 26.49 |      |

## Large Flange

|          |        |            |      |           |      |      |      |       |         |       |      |
|----------|--------|------------|------|-----------|------|------|------|-------|---------|-------|------|
| SBL6-4KL | M50813 | .062-.270  | .187 | .191-.201 | .530 | .095 | .415 | .733  | .973    | 1450  | 1200 |
|          |        | 1.57-6.85  |      |           |      |      |      | 4.8   | 4.9-5.1 |       |      |
| SBL6-EKL | M50814 | .062-.437  |      |           |      |      |      | .582  | .984    |       |      |
|          |        | 1.57-11.09 |      |           |      |      |      | 14.78 | 26.19   | 24.99 |      |
| SBL8-6KL | M50815 | .80-.375   | .253 | .261-.272 | .592 | .120 | .560 | .984  | 1.043   | 2750  | 2200 |
|          |        | 2.03-9.52  |      |           |      |      |      | 6.4   | 6.6-6.9 |       |      |

## 100° Countersunk

|          |        |             |      |           |      |      |      |       |         |       |      |
|----------|--------|-------------|------|-----------|------|------|------|-------|---------|-------|------|
| SC6-6KL  | M50816 | .125-.331   | .187 | .191-.201 | .350 | .080 | .490 | .809  | .987    | 1450  | 1200 |
|          |        | 3.17-8.40   |      |           |      |      |      | 4.8   | 4.9-5.1 |       |      |
| SC6-9KL  | M50818 | .305-.500   |      |           |      |      |      | .660  | .975    |       |      |
|          |        | 7.74-12.70  |      |           |      |      |      | 16.76 | 24.59   | 24.77 |      |
| SC8-8KL  | M50819 | .160-.475   | .253 | .261-.272 | .410 | .090 | .665 | 1.089 | 1.055   | 2750  | 2200 |
|          |        | 4.06-12.06  |      |           |      |      |      | 6.4   | 6.6-6.9 |       |      |
| SC8-12KL | M50820 | .415-.725   |      |           |      |      |      | .915  | 1.055   |       |      |
|          |        | 10.54-18.41 |      |           |      |      |      | 23.24 | 34.01   | 26.80 |      |

\*\*Also available in packaged quantities.

| AFS Description | Bulk Part No.** | Grip Range<br>Inch (mm) | A Rivet Dia. Inch (mm) | Required Hole Size Inch (mm) | B Head Dia. Inch (mm) | C Head Height Max. Inch (mm) | D Body Length Max. Inch (mm) | E Overall Length Max. (mm) | F Length Min. Inch (mm) | Average Shear Strength lbs. (newtons) | Average Tensile Strength lbs. (newtons) |
|-----------------|-----------------|-------------------------|------------------------|------------------------------|-----------------------|------------------------------|------------------------------|----------------------------|-------------------------|---------------------------------------|---|
|-----------------|-----------------|-------------------------|------------------------|------------------------------|-----------------------|------------------------------|------------------------------|----------------------------|-------------------------|---------------------------------------|---|

## Stainless Rivet • Stainless Mandrel • Buttonhead

|            |        |                         |             |                      |               |              |               |                |                |               |              |
|------------|--------|-------------------------|-------------|----------------------|---------------|--------------|---------------|----------------|----------------|---------------|--------------|
| SSB6-4SKL  | M50833 | .062-.270<br>1.57-6.85  | .187<br>4.8 | .191-.201<br>4.9-5.1 | .385<br>9.8   | .085<br>2.15 | .415<br>10.54 | .773<br>15.87  | .980<br>23.06  | 1400<br>6228  | 1100<br>4893 |
| SSB6-7SKL  | M50834 | .214-.437<br>5.43-11.09 |             |                      |               |              | .582<br>14.78 | .892<br>22.66  | .968<br>24.39  |               |              |
| SSB6-ESKL  | M50835 | .062-.437<br>1.57-11.09 |             |                      |               |              | .582<br>14.78 | 1.031<br>26.19 | .991<br>25.17  |               |              |
| SSB8-6SKL  | M50836 | .080-.375<br>2.03-9.52  | .253<br>6.5 | .261-.272<br>6.6-6.9 | .530<br>13.46 | .120<br>3.05 | .560<br>14.62 | .984<br>24.99  | 1.043<br>26.49 | 2500<br>11121 | 2000<br>8896 |
| SSB8-10SKL | M50837 | .350-.625<br>8.89-15.87 |             |                      |               |              | .810<br>20.57 | 1.234<br>31.34 | 1.043<br>26.49 |               |              |

## 100° Countersunk

|           |        |                         |             |                      |              |              |               |                |                |               |               |
|-----------|--------|-------------------------|-------------|----------------------|--------------|--------------|---------------|----------------|----------------|---------------|---------------|
| SSC6-6SKL | M50838 | .125-.331<br>3.17-8.40  | .187<br>4.8 | .191-.201<br>4.9-5.1 | .350<br>8.8  | .080<br>1.8  | .490<br>12.45 | .809<br>20.55  | .987<br>25.07  | 1400<br>6228  | 1100<br>4893  |
| SSC8-8SKL | M50839 | .160-.475<br>4.06-12.06 | .253<br>6.5 | .261-.272<br>6.6-6.9 | .410<br>10.4 | .090<br>2.29 | .665<br>14.62 | 1.089<br>27.66 | 1.055<br>26.80 | 2750<br>12233 | 2200<br>12233 |

## Aluminum Rivet • Aluminum Mandrel • Buttonhead

|           |        |                         |             |                      |               |              |               |                |                |              |             |
|-----------|--------|-------------------------|-------------|----------------------|---------------|--------------|---------------|----------------|----------------|--------------|-------------|
| AB6-4AKL  | M50821 | .062-.270<br>1.57-6.85  | .187<br>4.8 | .191-.201<br>4.9-5.1 | .385<br>9.8   | .085<br>2.15 | .415<br>10.54 | .733<br>15.87  | .980<br>23.06  | 700<br>3114  | 580<br>2580 |
| AB6-7AKL  | M50822 | .214-.437<br>5.43-11.09 |             |                      |               |              | .582<br>14.78 | .892<br>22.66  | .968<br>24.39  |              |             |
| AB6-AEKL  | M50823 | .062-.437<br>1.57-11.09 |             |                      |               |              | .582<br>14.78 | 1.031<br>26.19 | .991<br>25.17  |              |             |
| AB8-6AKL  | M50824 | .080-.375<br>2.03-9.52  | .253<br>6.4 | .261-.272<br>6.6-6.9 | .530<br>13.46 | .120<br>3.05 | .560<br>14.62 | .984<br>24.99  | 1.043<br>26.49 | 1300<br>5783 | 950<br>4226 |
| AB8-10AKL | M50825 | .350-.625<br>8.89-15.87 |             |                      |               |              | .810<br>20.57 | 1.234<br>31.34 | 1.013<br>26.49 |              |             |
| AB8-AEKL  | M50826 | .080-.625<br>2.03-15.87 |             |                      |               |              | .810<br>20.57 | 1.419<br>36.04 | 1.043<br>26.49 |              |             |

## Aluminum/Large Flange

|           |        |                         |             |                      |               |              |               |               |               |             |             |
|-----------|--------|-------------------------|-------------|----------------------|---------------|--------------|---------------|---------------|---------------|-------------|-------------|
| ABL6-4AKL | M50827 | .062-.270<br>1.57-6.85  | .187<br>4.8 | .191-.201<br>4.9-5.1 | .530<br>13.46 | .085<br>2.15 | .415<br>10.45 | .733<br>15.87 | .973<br>24.71 | 700<br>3114 | 580<br>2580 |
| ABL6-7AKL | M50828 | .214-.437<br>5.43-11.09 |             |                      |               |              | .572<br>14.52 | .892<br>22.66 | .984<br>24.99 |             |             |

## Aluminum/100° Countersunk

|           |        |                          |             |                      |              |              |               |                |                |              |             |
|-----------|--------|--------------------------|-------------|----------------------|--------------|--------------|---------------|----------------|----------------|--------------|-------------|
| AC6-6AKL  | M50829 | .125-.331<br>3.17-8.40   | .187<br>4.8 | .191-.201<br>4.9-5.1 | .350<br>8.9  | .080<br>1.8  | .490<br>12.45 | .809<br>20.55  | .987<br>25.07  | 700<br>3114  | 580<br>2580 |
| AC6-9AKL  | M50830 | .305-.500<br>7.74-12.70  |             |                      |              |              | .660<br>16.76 | .968<br>24.09  | .975<br>24.77  |              |             |
| AC8-8AKL  | M50831 | .160-.475<br>4.06-12.06  | .253<br>6.4 | .261-.272<br>6.6-6.9 | .410<br>10.4 | .090<br>2.29 | .665<br>16.89 | 1.089<br>27.66 | 1.055<br>26.80 | 1300<br>5783 | 950<br>4226 |
| AC8-12AKL | M50832 | .415-.725<br>10.54-18.41 |             |                      |              |              | .915<br>23.24 | 1.339<br>34.01 | 1.055<br>26.80 |              |             |

## Pin Retention Values

|       |               | Steel lbs. | Aluminum lbs. | Stainless Steel lbs. |
|-------|---------------|------------|---------------|----------------------|
| 3/16" | Pin Retention | 300        | 50            | 125                  |
| 1/4"  | Pin Retention | 500        | 100           | 250                  |



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

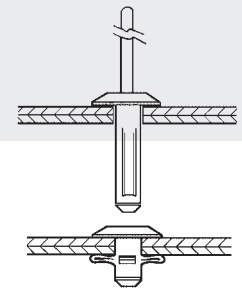
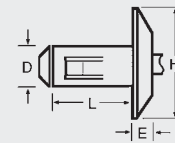
## Material and Finish

| 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                       |

Millimeters (mm) and newtons (N) are in green.

\*\*Also available in packaged quantities.

# Plastic Rivets



Plastic rivet before and after set.

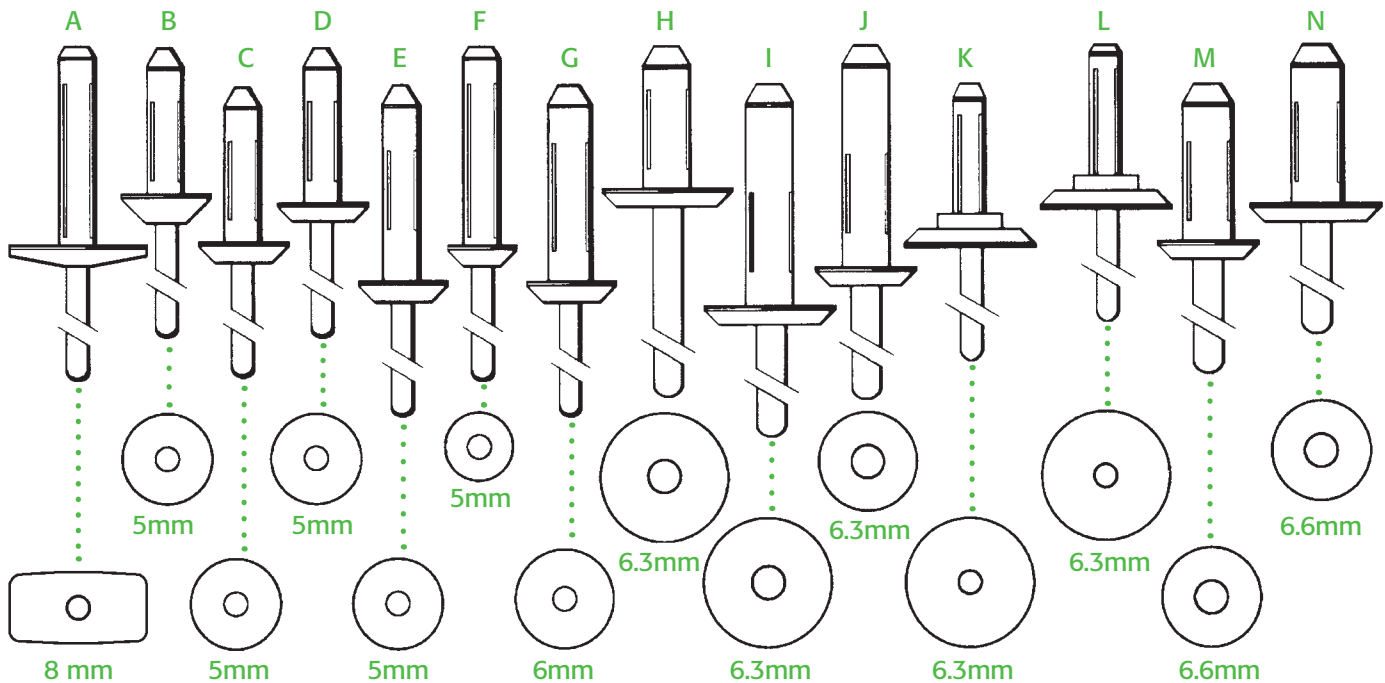
## Klik-Lok™ Plastic Rivets • Nylon Body ST801HS • Delrin 500 Mandrel

Marson brand Klik-Lok 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-Lok Plastic Rivets are ideal for non-conductive and non-corrosive environments. Klik-Lok 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.

| Diagram Reference | 100-Pack Part No.* | Grip Range  |            | D         |           | H         |           | E         |                | Rivet Length |             | Typical Ultimate Strength (lbs.) |     |     |     |     |
|-------------------|--------------------|-------------|------------|-----------|-----------|-----------|-----------|-----------|----------------|--------------|-------------|----------------------------------|-----|-----|-----|-----|
|                   |                    | Inch        | (mm)       | Nom. Inch | Inch (mm) | Inch (mm) | Inch (mm) | Inch (mm) | Max. Inch (mm) | Shear (N)    | Tensile (N) | Tensile (N)                      |     |     |     |     |
| 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                 | M48353             | .028 - .193 | .7 - 5.0   | .246      | .250      | 6.3       | .670      | 17        | .098           | 2.5          | .682        | 17.3                             | 121 | 538 | 194 | 863 |
| L                 | M48354             | .028 - .178 | .7 - 4.5   | .246      | .250      | 6.3       | .670      | 17        | .098           | 2.5          | .682        | 17.3                             | 121 | 538 | 194 | 863 |
| M                 | M48385             | .098 - .197 | 2.5 - 5.0  | .258      | .260      | 6.6       | .512      | 13        | .098           | 2.5          | .787        | 20                               | 137 | 609 | 219 | 974 |
| N                 | 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.



## Klik-Lok™ Plastic Rivet Setter/M48000

This plastic rivet setter delivers the extra-long pulling stroke needed to set plastic rivets. Its all-steel construction and full-size handles make for smooth easy operation. The tool is packaged in a reusable, heavy-duty vinyl pouch. Weight: .6 lb.



## Klik-Lok™ Plastic Rivet Kit/M48001

You'll be all set for the next job that requires plastic rivet fastening with this kit. The kit includes the M48000 Plastic Rivet Setter and a 20-pack each of our four most popular rivet sizes: No. M58106, M58108, M58149 and M58150. A reclosable carton provides storage for rivets and tool. Weight: 1.5 lbs.

## Klik-Lok™ 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: No. M58106, M58108, M58149 and M58150. A reclosable carton provides storage for rivets and tool. Weight: 1.5 lbs.



# Hand Rivet Tools



## 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 Riveter Capacity Chart on page 19 for specific capabilities. Weight: 1.2 lbs.

## HP-3®/M39002

Our newest 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-3 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 new 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.



## 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. And 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 II/M39032

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 Conversion Kit 3 Jaw Set Up/M96050

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



## 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 Chart

|                 | 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-3/M39002     | •     | •    | •     | •     |      | •            | •    | •     | •     |      | •              | •    | •     | •     |      | •         | •    | •     | •     |      |             |      |            |      |   |
| SP-1/M39005     | •     | •    | •     | •     |      | •            | •    | •     | •     |      | •              | •    | •     | •     |      | •         | •    | •     | •     |      |             |      |            |      |   |
| BIG DADDY (All) |       | •    | •     | •     | •    | •            | •    | •     | •     | •    | •              | •    | •     | •     | •    | •         | •    | •     | •     | •    | •           | •    | •          | •    | • |

## Hand Rivet Tools – Standard & Special Nosepieces

|                 | Sizes  |        |        |        | 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-3/M39002     | M39131 | M39128 | M39130 | M39129 |            |        |               |        |        |
| SP-1/M39005     | M39160 | M39161 | M39163 | M39162 |            |        |               |        |        |
| BIG DADDY (All) |        | M96024 | M96025 | M96026 | M96027     | M96031 | M96030        | M96029 | M96028 |

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

# Automatic Tools

These next-generation, professional-series air/hydraulic riveters are designed to be light weight 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 control 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.



### MP-3V/M39045

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



### 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.

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.



### 302-E/M39062

**Stroke:** .812"  
**Pulling Force:** 2,000 lbs.  
**Capacity:** 3/32" – 3/16" diameter in all alloys and up to 1/4" in aluminum/steel combinations.  
**Weight:** 4 lbs.

### 304-E/M39064

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



**Extended head Accessory for 302-E and 304-E**  
 171 New Style

| Tool         | Description       | Part Number |
|--------------|-------------------|-------------|
| 302-E/M39062 | 5" Extension Head | M88082      |
| 302-E/M39062 | 8" Extension Head | M88086      |
| 304-E/M39064 | 5" Extension Head | M88220-39   |
| 304-E/M39064 | 5" Extension Head | M723358     |

**NEW**

Cordless, battery-powered tool features built-in mandrel collection box and high-capacity 14.4 V Li-ion / 3.9 A.h battery pack. Charge time is approximately 60 minutes. Also comes with replaceable carbon brushes, and storage for other nosepieces. Soft grip handle reduces vibration and fatigue.



### BT-1/M39020

**Stroke:** .79" (20mm)

**Pulling Force:** 1,870 lbs.

**Capacity:** 3/32" to 3/16" diameter in all alloys.

**Weight:** 4.6 lbs. (with battery pack).

**NEW**

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.*

### IntegraFuse IF-1/M39075

**Stroke:** 1.125" (28.575mm)

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

**Capacity:** 3/6" – 1/4"

**Weight:** 4.8 lbs. (2.177kg)



## Automatic Rivet Tools – Standard & Special Nosepieces

|              | Standard |         | Standard |          |           | T-Rivets /<br>Klik-Split® | Monobolt®** |           |
|--------------|----------|---------|----------|----------|-----------|---------------------------|-------------|-----------|
|              | 3/32"    | 1/8"    | 5/32"    | 3/16"    | 1/4"      | 1/4"                      | 3/16"       | 1/4"      |
| MP-3V/M39045 | M95200   | M95201  | M95202   | M95203   |           |                           |             |           |
| MP-4V/M39048 |          |         | M95300   | M95301   | M95302    |                           | M95299      | M95303    |
| 302-E/M39062 | M717006  | M717001 | M717002  | M717003  | M717005   |                           |             |           |
| 304-E/M39064 |          |         |          | M88220-1 | M88220-79 | M88220-83                 | M88220-85   | M88220-84 |
| IF-1/M39075  |          |         |          | M95137-2 | M95137    |                           |             |           |

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

## Automatic Rivet Tools – Capacity Chart

|              | Steel |      |       |       |      | All Aluminum |      |       |       |      | Aluminum Steel |      |       |       |      | Stainless |      |       |       |      | Structural* |      | "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" |   |
| MP-3V/M39045 | •     | •    | •     | •     |      | •            | •    | •     | •     |      | •              | •    | •     | •     |      | •         | •    | •     | •     |      |             |      |            |      |   |
| MP-4V/M39048 |       |      | •     | •     | •    |              |      | •     | •     | •    |                |      | •     | •     | •    |           |      | •     | •     | •    | •           | •    |            |      |   |
| 302-E/M39062 | •     | •    | •     | •     |      | •            | •    | •     | •     |      | •              | •    | •     | •     |      | •         | •    | •     | •     |      |             |      |            |      |   |
| 304-E/M39064 |       |      |       | •     | •    |              |      |       | •     | •    |                |      |       | •     | •    |           |      |       | •     | •    | •           | •    | •          | •    | • |
| BT-1/M39020  | •     | •    | •     | •     |      | •            | •    | •     | •     |      | •              | •    | •     | •     |      | •         | •    | •     | •     |      |             |      |            |      |   |
| IF-1/M39075  |       |      |       | •     | •    |              |      |       | •     | •    |                |      |       | •     | •    |           |      |       | •     | •    |             |      |            |      |   |

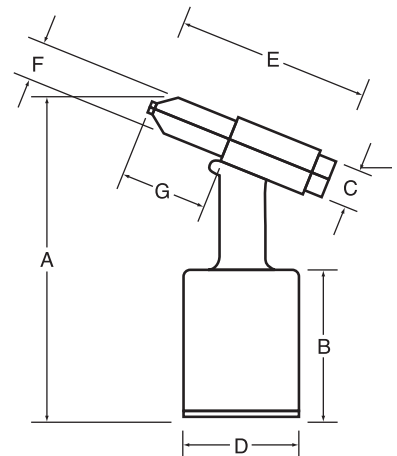
\*For Monobolt® structural rivets, the noted special nosepiece is required. For Marson brand Klik-Lock® structural rivets, no special insert is required.

## Automatic Rivet Tools – Dimensions

| Tool         | A       | B      | C      | D      | E       | F       | G      | WT       |
|--------------|---------|--------|--------|--------|---------|---------|--------|----------|
| MP-3V/M39045 | 10.000" | 3.500" | 1.500" | 3.500" | 6.500"  | .925"   | 2.750" | 2.9 lbs. |
| MP-4V/M39048 | 12.000" | 5.500" | 2.000" | 4.500" | 7.000"  | .925"   | 3.500" | 3.7 lbs. |
| 302-E/M39062 | 11.125" | 5.000" | 2.375" | 4.500" | 13.000" | .828"   | 2.500" | 4 lbs.   |
| 304-E/M39064 | 13.125" | 6.000" | 2.375" | 5.250" | 13.000" | .938"   | 2.500" | 5.5 lbs. |
| BT-1/M39020  | 8.750"  | 2.760" | 2.465" | 4.214" | 10.500" | .950"   | 7.500" | 4.6 lbs. |
| IF-1/M39075  | 12.000" | 5.560" | 1.575" | 4.990" | 9.180"  | 12.790" | 4.155" | 4.8 lbs. |

## Automatic Rivet Tools – Specifications

| Tool         | Work Force                       | Stroke              |
|--------------|----------------------------------|---------------------|
| MP-3V/M39045 | 70-95 psi<br>1,800 lbs./8007 n   | .750<br>19 mm       |
| MP-4V/M39048 | 70-95 psi<br>3,420 lbs./15,213 n | 1.000<br>25.4 mm    |
| 302-E/M39062 | 85-95 psi<br>2,000 lbs./8,896 n  | .812"<br>21 mm      |
| 304-E/M39064 | 85-95 psi<br>4,200 lbs./18,682 n | 1.000"<br>25.4 mm   |
| BT-1/39020   | 1,870 lbs./8,318 n               | .79"<br>20 mm       |
| IF-1/M39075  | 4,600 lbs./20,500 n              | 1.125"<br>28.575 mm |

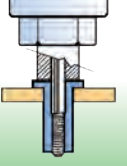
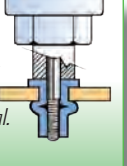
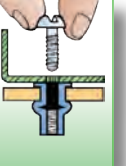
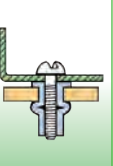


# Marson Rivet Nuts

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. Blind side 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.

## 4 Easy Steps to Complete Installation and Application

- 1** Thread rivet nut onto tool mandrel and insert into hole. 
- 2** Actuate tool to properly set fastener into material. 
- 3** Complete your fastening operation with a bolt or screw with the proper thread. 
- 4** The positive riveting action of the Klik Rivet Nut will provide a permanent thread. As threads are tightened, so are rivet nut and application. 

Rivet Nuts can be used to fasten multiple sheets as well as single sheets





# General Information – Rivet Nuts

## Rivet Styles

## Features/Benefits

## Materials Available

MRN Series  
(p. 24)



Rivet Nut, Flathead Flange (thick wall) for applications that require heavy push out loads (recommend spin-pull tool)

Steel, Aluminum

MPN Series  
(p. 25)



Poly-Nut Rivet Nut has very small flange, lowest profile for near counter sink applications

Steel, Aluminum

MTS Series  
(p. 25)



Thread-Sert has small flange, 360 degree swaging action in the hole and no maximum grip range

Steel, Aluminum

MLR Series  
(p. 26)



Large Flange Ribbed Rivet Nut provides increased turn-out resistance vs conventional rivet nut and large flange for improved push out performance

Steel, Aluminum

MLC Series  
(p. 27)



Large Flange Ribbed Rivet Nut with Closed End for thread seal

Steel, Aluminum

MSR Series  
(p. 28)



Small Flange low profile Ribbed Rivet Nut virtually flush install with increased turn-out resistance vs conventional low profile Ply-Nut

Steel, Aluminum

MSC Series  
(p. 29)



Small Flange low profile Ribbed Rivet Nut with Closed End for thread seal

Steel, Aluminum

MHN Series  
(p. 30)



Large Flange Half Hex Rivet Nut for hex hole to provide exceptional turn-out resistance

Steel

MQN Series  
(p. 31)



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  
(p. 31)



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  
(p. 32)



External Thread Stud Rivet Nut allows for component mounting and mate nut

Steel

MNN Series  
(p. 33)



Neoprene Insert with pre-molded brass nut for quick fastening in vibration and moisture resistant applications

Neoprene

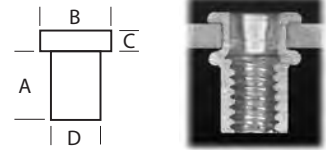
All finishes are RoHS compliant.

# MRN Series Flathead Rivet Nuts

Available in Steel-Zinc Plated or Aluminum

## MRN Series Flathead Rivet Nut (Thick Wall)

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.



## MRN Series Flathead Rivet Nut

| Thread Size | Grip Range |      | Steel *Bulk Part # | Aluminum *Bulk Part # | A<br>Body Length<br>±.015" | B<br>Head Dia.<br>±.015" | C<br>Head Height<br>(nom.) | D<br>Body Dia.<br>Max. | Hole Size |      | Drill Size |
|-------------|------------|------|--------------------|-----------------------|----------------------------|--------------------------|----------------------------|------------------------|-----------|------|------------|
|             | Min.       | 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        |

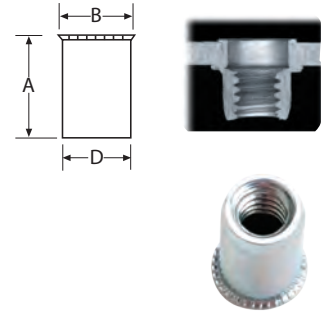
\* Also available in small packaged quantities.  
Inch sizes are class 2B thread.

# MPN Series Poly-Rivet Nut

Available in Steel-Zinc Plated or Aluminum

## MPN Series Lowest Profile Poly-Rivet Nut

MPN – Poly-Rivet Nut has very small flange, 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.



## MPN Series Poly-Rivet Nut

| Thread Size | Grip Range<br>Min. - Max. | Steel<br>*Bulk Part # | Aluminum<br>*Bulk Part # | A                                 | B                                | C                                   | D   | Hole Size<br>Min. - Max. | Drill Size |
|-------------|---------------------------|-----------------------|--------------------------|-----------------------------------|----------------------------------|-------------------------------------|---|--------------------------|------------|
|             |                           |                       |                          | Body Length<br>±.015<br>± 0.38 mm | Head Dia.<br>± .015<br>± 0.38 mm | Head Height<br>± .005<br>± .0127 mm | Body Dia.<br>+0<br>-0.005<br>to -0.127 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.

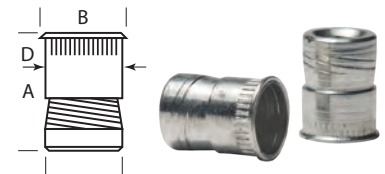
\*\* Limited availability, minimums may apply.

Inch sizes are class 2B thread. Metric sizes are class 6H thread.

# MTS Series Thread-Sert®

Available in Steel-Zinc Plated or Aluminum

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.



## MTS Series Thread-Sert®

| Thread Size | Steel<br>*Bulk Part # | Aluminum<br>*Bulk Part # | A**                   | B                   | D**                 | Material Thickness<br>.0937-.1562 |            | Material Thickness<br>.1562- Infinity |            |
|-------------|-----------------------|--------------------------|-----------------------|---------------------|---------------------|-----------------------------------|------------|---------------------------------------|------------|
|             |                       |                          | Body Length<br>±.005" | Head Dia.<br>±.005" | Body Dia.<br>±.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      |

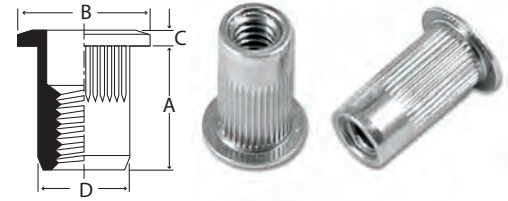
\* Also available in small packaged quantities. \*\* A and D dimensions are prior to setting

Inch sizes are class 2B thread.

# MLR Series Large Flange Ribbed Low-Profile Rivet Nuts

## Available in Steel-Zinc Plated or Aluminum

MLR – Large Flange Ribbed Rivet Nut feature ribbed external body for increased torque out resistance vs conventional rivet nut. Large flange offers improved push out performance. Overall MLR offers the best/highest strength levels. May install with all pneumatic and manual Rivet Nut tools.



## MLR Series Large Flange Ribbed Low-Profile Rivet Nut

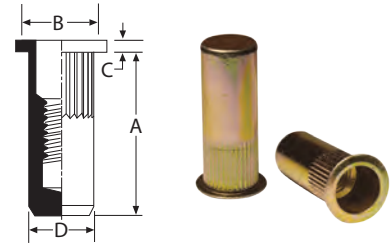
| Thread Size | Grip Range<br>Min-Max | Steel<br>*Bulk Part # | Aluminum<br>*Bulk Part # | A                                  | B                                 | C                                  | D                | Hole Size<br>Min-Max | Drill Size |
|-------------|-----------------------|-----------------------|--------------------------|------------------------------------|-----------------------------------|------------------------------------|------------------|----------------------|------------|
|             |                       |                       |                          | Body Length<br>±.015"<br>± 0.38 mm | Head Dia.<br>±.010"<br>± 0.254 mm | Head Height<br>±.003"<br>± 0.76 mm | Body Dia.<br>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                | M57620                   | .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                               | .865                              | .035                               | .530             | .530 - .536          | 17/32      |
| 3/8-16      | .150 - .312           | M57382                | M57682                   | .805                               | .865                              | .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      |
| M4x07       | .5 - 2.0              | M57360                | M57660                   | 10.67                              | 9.91                              | .76                                | 6.73             | 6.75 + .15           | 6.75       |
| M4x07       | 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       |

Dimensions in green indicate millimeters (mm) \* Also available in small packaged quantities.  
Inch sizes are class 2B thread.  
Metric sizes are class 6H thread.

# MLC Series Large Flange Closed End Ribbed Rivet Nuts

## Available in Steel-Zinc Plated or Aluminum

MLC – Large Flange Ribbed Rivet Nut 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.



## MLC Series Large Flange Closed End Ribbed Rivet Nut

| Thread Size | Grip Range<br>Min-Max | Steel<br>*Bulk Part # | Aluminum<br>*Bulk Part # | A                                  | B                                 | C                                  | D                | Hole Size<br>Min-Max | Drill Size |
|-------------|-----------------------|-----------------------|--------------------------|------------------------------------|-----------------------------------|------------------------------------|------------------|----------------------|------------|
|             |                       |                       |                          | Body Length<br>±.015"<br>± 0.38 mm | Head Dia.<br>±.010"<br>± 0.254 mm | Head Height<br>±.003"<br>± 0.76 mm | Body Dia.<br>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      |

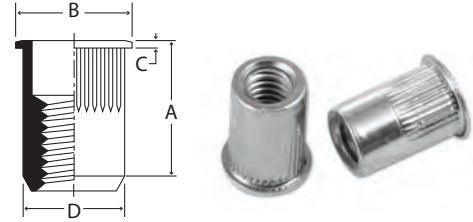
Dimensions in green indicate millimeters (mm) \* Also available in small packaged quantities.  
 Inch sizes are class 2B thread. \*\* Limited availability, minimums may apply.  
 Metric sizes are class 6H thread.



# MSR Series Small Flange Low Profile Ribbed Rivet Nuts

## Available in Steel-Zinc Plated or Aluminum

MSR – Small Flange low profile Ribbed Rivet Nut virtually flush installation with ribbed external body for increased torque-out resistance vs conventional low profile Poly-Nut. May install with all pneumatic and manual Rivet Nut tools.



## MSR Series Small Flange Low Profile Ribbed Rivet Nut

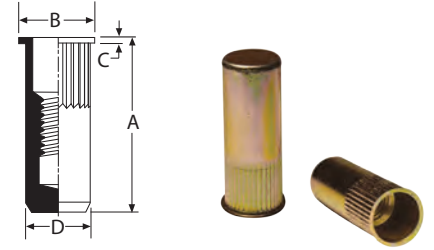
| Thread Size | Grip Range<br>Min-Max | Steel<br>*Bulk Part # | Aluminum<br>*Bulk Part # | A                                  | B                                 | C                                  | D                | Hole Size<br>Min-Max | Drill Size<br>Min-Max |
|-------------|-----------------------|-----------------------|--------------------------|------------------------------------|-----------------------------------|------------------------------------|------------------|----------------------|-----------------------|
|             |                       |                       |                          | Body Length<br>±.015"<br>± 0.38 mm | Head Dia.<br>±.010"<br>± 0.254 mm | Head Height<br>±.003"<br>± 0.76 mm | Body Dia.<br>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                 |

Dimensions in green indicate millimeters (mm) \* Also available in small packaged quantities.  
 Inch sizes are class 2B thread.  
 Metric sizes are class 6H thread.

# MSC Series Small Flange Closed End Ribbed Rivet Nuts

## Available in Steel-Zinc Plated or Aluminum

MSC — Small Flange Ribbed Rivet Nut 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.



## MSC Series Small Flange Closed End Ribbed Rivet Nut

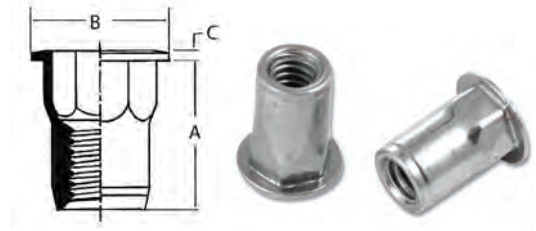
| Thread Size | Grip Range<br>Min-Max | Steel<br>*Bulk Part # | Aluminum<br>*Bulk Part # | A<br>Body Length<br>±.015"<br>± 0.38 mm | B<br>Head Dia.<br>±.010"<br>± 0.254 mm | C<br>Head Height<br>±.003"<br>± 0.76 mm | D<br>Body Dia.<br>Max | Hole Size<br>Min-Max | Drill Size<br>Min-Max |
|-------------|-----------------------|-----------------------|--------------------------|---|--|---|-----------------------|----------------------|-----------------------|
| 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                 |

Dimensions in green indicate millimeters (mm) \* Also available in small packaged quantities.  
 Inch sizes are class 2B thread. \*\* Limited availability, minimums may apply.  
 Metric sizes are class 6H thread.

# MHN Series Large Flange Half Hex Rivet Nuts

## Available in Steel-Zinc Plated Threads

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.



## MHN Series Large Flange Half Hex Rivet Nut

| Thread Size | Grip Range<br>Min-Max | Steel<br>*Bulk Part # | A                                  | B                                 | C                                  | D                | Hex Hole<br>Across Flats<br>+.004"-.000" |
|-------------|-----------------------|-----------------------|------------------------------------|-----------------------------------|------------------------------------|------------------|--|
|             |                       |                       | Body Length<br>±.015"<br>± 0.38 mm | Head Dia.<br>±.010"<br>± 0.254 mm | Head Height<br>±.003"<br>± 0.76 mm | Body Dia.<br>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                                     |

Dimensions in green indicate millimeters (mm) \* Also available in small packaged quantities.  
Inch sizes are class 2B thread.  
Metric sizes are class 6H thread.

# MQN Series Quad-Leg Rivet Nuts

## Available in Steel-Zinc Plated Threads

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



## MQN Series Quad-Leg Rivet Nut

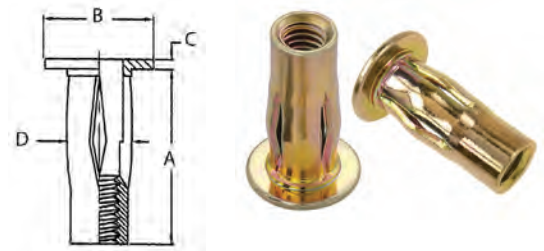
| Thread Size | Grip Range Min-Max | Steel *Bulk Part # | A Overall Length | B Head Dia Ref | E Head Height (nom.) | D Body Dia. Max | Hole Size Min-Max | Drill Size |
|-------------|--------------------|--------------------|------------------|----------------|----------------------|-----------------|-------------------|------------|
| 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      |

Dimensions in green indicate millimeters (mm) \* Also available in small packaged quantities. Inch sizes are class 2B thread. Metric sizes are class 6H thread.

# MXN Series Large Flange Cross Bulb Rivet Nuts

## Available in Steel-Zinc Plated Threads

MXN – Large Flange Cross Bulb Rivet Nut has 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.



## MXN Series Large Flange Cross Bulb Rivet Nut

| Thread Size | Grip Range Min-Max | Steel *Bulk Part # | A Body Length Min-Max | B Head Dia.   | C Head Height | D Body Dia. Max | Hole Size Min-Max | Drill Size |
|-------------|--------------------|--------------------|-----------------------|---------------|---------------|-----------------|-------------------|------------|
| 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        |

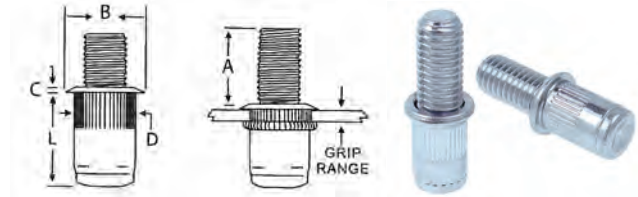
Dimensions in green indicate millimeters (mm) Inch sizes are class 2B thread. Metric sizes are class 6H thread.

\* Also available in small packaged quantities. \*\* Limited availability, minimums may apply.

# MET Series External Thread Stud Rivet Nuts

## Available in Steel-Zinc Plated Threads

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.



## MET Series External Thread Stud Rivet Nut

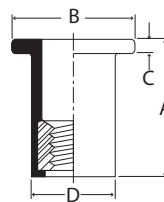
| Thread Size | Grip Range<br>Min-Max | *Steel<br>Bulk Part # | A**<br>Exposed<br>Thread | B<br>Head Dia.<br>±.010"<br>± .25 mm | L<br>Body Length<br>±.020"<br>± .50 mm | C<br>Head Height<br>±.003"<br>± .08 mm | D<br>Body Dia.<br>Max | Hole Size<br>Min-Max | Drill Size |
|-------------|-----------------------|-----------------------|--------------------------|--------------------------------------|--|--|-----------------------|----------------------|------------|
| 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       |

Dimensions in green indicate millimeters (mm) \*Also available in small packaged quantities.  
 \*\* Dimensions at maximum grip range. \*\* Limited availability, minimums may apply.  
 Inch sizes are class 2B thread.  
 Metric sizes are class 6H thread.



# MNN Series Neoprene Inserts

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 blind side with conventional wrench. Just insert the proper thread screw or bolt and tighten.



## MNN Series Neoprene Insert

| Thread Size | Grip Range<br>Min-Max | Bulk Part # | A                                  | B                                 | C                                  | D                | Hole Size<br>Min-Max | Drill Size<br>Min-Max |
|-------------|-----------------------|-------------|------------------------------------|-----------------------------------|------------------------------------|------------------|----------------------|-----------------------|
|             |                       |             | Body Length<br>±.015"<br>± 0.38 mm | Head Dia.<br>±.010"<br>± 0.254 mm | Head Height<br>±.003"<br>± 0.76 mm | Body Dia.<br>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                  |

Dimensions in green indicate millimeters (mm)  
Inch sizes are class 2B thread. Metric sizes are class 6H thread.

\* Also available in small packaged quantities.  
\*\* Limited availability, minimums may apply.

# Rivet Nut Tools & Kits

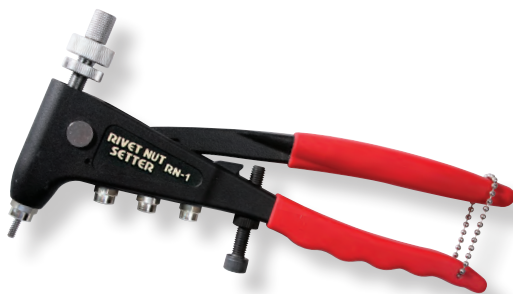


## Klik-Turn™ SRN-2/M39400

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. A new 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 8-32, 10-24 and 10-32 mandrel nosepieces.

## Mandrel/Nosepiece Chart

| Thread Size | Mandrel No. | Nosepiece No. |
|-------------|-------------|---------------|
| 6-32        | M39354      | M39361        |
| 8-32        | M39355      | M39362        |
| 10-24       | M39356      | M39363        |
| 10-32       | M39357      | M39363        |
| 1/4-20      | M39358      | M39379        |



## Rivet Nut Setter™ RN-1/M39300

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

## Mandrel/Nosepiece Chart

| 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 Tools & 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

## 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 & 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)

New from Marson, the 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 – 1/4-20 and M4 – M6. It works by threading the bolt to the quad leg nut, then dropping the component in the slot of the tool, inserting it into the pre-drilled hole, and squeezing until set. Tightening the exposed bolt completes the installation.

Jack Nut® is a registered trademark of Stanley Engineered Fastening.



## 325RN/M34604

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

## 325RNK Kit/M34606

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



## 425RN/M34607

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

## 425RNK Kit/M34608

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



## Mandrel/Nosepiece Chart for M34604 and M34607

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

## Mandrel/Nosepiece Chart for M34610

| Thread Size | Mandrel No. | Nosepiece No. | Mandrel/Nosepiece Combo No. | MET External Thread |
|-------------|-------------|---------------|-----------------------------|---------------------|
| 10-24       | M95635      | M95645        | M34615                      | M34635              |
| 10-32       | M95636      | M95645        | M34616                      | M34636              |
| 1/4-20      | M95637      | M95647        | M34617                      | M34637              |
| 5/16-18     | M95638      | M95648        | M34618                      | M34638              |
| 3/8-16      | M95639      | M95649        | M34619                      | —                   |

## Mandrel/Nosepiece Chart for M34613

| Thread Size | Mandrel No. | Nosepiece No. | Mandrel/Nosepiece Combo No. | MET External Thread |
|-------------|-------------|---------------|-----------------------------|---------------------|
| 5mm         | M95630      | M95640        | M34625                      | M34645              |
| 6mm         | M95631      | M95641        | M34626                      | M34647              |
| 8mm         | M95632      | M95642        | M34627                      | M34648              |
| 10mm        | M95633      | M95643        | M34628                      | —                   |

# Rivet Nut Tools & Kits



## 140-SP/M39223

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

## 160-SP/M39225

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

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

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



## Mandrel Nosepiece Chart for 140-SP/M39223

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

## Mandrel Nosepiece Chart for 160-SP/M39225

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

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

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



## Spin/Pull Tool Stroke Adjustment

Follow these easy steps for correct tool stroke adjustment:

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

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

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

## Pull-up Factor Chart per Thread Size

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

## SST Series

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



Additional nosepiece and mandrel sizes are available:

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

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

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

Purchasing the Optional Front End Assemblies are at the Owner's discretion. Care must be taken to optimize the tools Rivet Nut setting ability. 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. Available retrofit for MET external thread, contact customer service.

# Rivet Nut Tools & Kits

## Spin/Spin Front End Assembly Table

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

Contact customer service for MET series front ends.

| 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                 |

| 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                 |

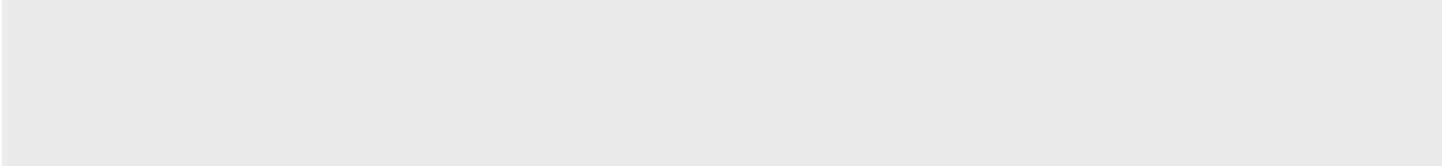
## Inch-Metric Conversion Table

| Inches   |          |        | Inches   |           |        |
|----------|----------|--------|----------|-----------|--------|
| Fraction | Decimal  | mm     | Fraction | Decimal   | mm     |
| 1/64     | .015 625 | .397   | 33/64    | .515 625  | 13.097 |
| 1/32     | .031 250 | .794   | 17/32    | .531 250  | 13.494 |
| 3/64     | .046 875 | 1.191  | 35/64    | .546 875  | 13.891 |
| 1/16     | .062 500 | 1.588  | 9/16     | .562 500  | 14.288 |
| 5/64     | .078 125 | 1.984  | 37/64    | .578 125  | 14.684 |
| 3/32     | .093 750 | 2.381  | 19/32    | .593 750  | 15.081 |
| 7/64     | .109 375 | 2.778  | 39/64    | .609 375  | 15.478 |
| 1/8      | .125 000 | 3.175  | 5/8      | .625 000  | 15.875 |
| 9/64     | .140 625 | 3.572  | 41/64    | .640 625  | 16.272 |
| 5/32     | .156 250 | 3.969  | 21/32    | .656 250  | 16.669 |
| 11/64    | .171 875 | 4.366  | 43/64    | .671 875  | 17.066 |
| 3/16     | .187 500 | 4.763  | 11/16    | .687 500  | 17.463 |
| 13/64    | .203 125 | 5.159  | 45/64    | .703 125  | 17.860 |
| 7/32     | .218 750 | 5.556  | 23/32    | .718 750  | 18.256 |
| 15/64    | .234 375 | 5.953  | 47/64    | .734 375  | 18.653 |
| 1/4      | .250 000 | 6.350  | 3/4      | .750 000  | 19.050 |
| 17/64    | .265 625 | 6.747  | 49/64    | .765 625  | 19.447 |
| 9/32     | .281 250 | 7.144  | 25/32    | .781 250  | 19.844 |
| 19/64    | .296 875 | 7.541  | 51/64    | .796 875  | 20.241 |
| 5/16     | .312 500 | 7.938  | 13/16    | .812 500  | 20.638 |
| 21/64    | .328 125 | 8.334  | 53/64    | .828 125  | 21.034 |
| 11/32    | .343 750 | 8.731  | 27/32    | .843 750  | 21.431 |
| 23/64    | .359 375 | 9.128  | 55/64    | .859 375  | 21.828 |
| 3/8      | .375 000 | 9.525  | 7/8      | .875 000  | 22.225 |
| 25/64    | .390 625 | 9.922  | 57/64    | .890 625  | 22.622 |
| 13/32    | .406 250 | 10.319 | 29/32    | .906 250  | 23.019 |
| 27/64    | .421 875 | 10.716 | 59/64    | .921 875  | 23.416 |
| 7/16     | .437 500 | 11.113 | 15/16    | .937 500  | 23.813 |
| 29/64    | .453 125 | 11.510 | 61/64    | .953 125  | 24.209 |
| 15/32    | .468 750 | 11.906 | 31/32    | .968 750  | 24.606 |
| 31/64    | .484 375 | 12.303 | 63/64    | .984 375  | 25.003 |
| 1/2      | .500 000 | 12.700 | 1        | 1.000 000 | 25.400 |

## Decimal Equivalents of Standard Sheet Gauges

| Inches<br>No. of Gauge | Thickness in Thousandths |                   |
|------------------------|--------------------------|-------------------|
|                        | Aluminum (B & S)         | Steel (U.S. Std.) |
| 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                     | .0123                    | .015              |
| 29                     | .011                     | .014              |
| 30                     | .010                     | .012              |







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Tel: 800 826 2884  
Fax: 800 573 2645

Latin America Sales  
Avenida Parque Lira  
79-402 Tacubaya  
Mexico C P 11850  
Tel: +52 55 5515 1776  
Fax: +52 55 5277 7564

Brazil Sales  
Av. Nações Unidas, 12.901  
Torre Oeste, 3º andar  
São Paulo – SP – Brasil  
04578-000  
Tel: 0800 015 9888  
Fax: +55 11 5509 0200

## International Locations

India Operations  
Unit no. 28, Chowringhee Court  
55/1, Chowringhee Road  
Kolkata – 700071  
India  
Tel: +91 33 4069 9170/80  
Fax: +91 33 4069 9184

Japan/Korea Sales  
Alcoa Japan Ltd.  
#1013 NBF Hibiyi Bldg.  
Uchisaiwai-cho, Chiyoda-ku  
Tokyo 100-1011  
Japan  
Tel: +81 3 3539 6577  
Fax: +81 3 3539 6585

Melbourne Operations  
1508 Centre Road  
Clayton, Victoria, 3168  
Australia  
Tel: +61 3 8545 3333  
Fax: +61 3 8545 3390

Suzhou Sales  
58 Yinsheng Road, Shengpu  
Suzhou Industrial Park  
Suzhou Jiangsu 215126  
China  
Tel: 0512 62823800-8888  
Fax: 0512 62863810

Telford Operations  
Unit C, Stafford Park 7  
Telford, Shropshire TF3, 3BQ  
United Kingdom  
Tel: +44 1952 2900 11  
Fax: +44 1952 2904 59

Alcoa Fastening Systems  
St Cosme Operations  
9 rue de Cressonnieres  
72110 Saint Cosme en Varais  
France  
Tel: +33 0 2.43.31.41.00  
Fax: +33 0 2.43.31.41.41

Alcoa Fastening Systems  
Kelkheim Operations  
Industriestr. 6  
65779 Kelkheim  
Germany  
Tel: +49 [0] 6195 8050  
Fax: +49 [0] 6195 2001

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