

Marson® Rivets and Rivet Nut Installation Tools



Marson® Manual Rivet Tools

HP-2® Professional Hand Rivet Tool (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.

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



HP-3 Professional Hand Rivet Tool (M39002)

This multi-functional hand rivet tool offers long, ergonomically designed handles to increase leverage, and to secure the rivet in the nosepiece while the tool is in use, in any position. The HP-3 offers powerful riveting capacity with 4 standard nosepieces to set 3/32", 1/8", 5/32" and 3/16" blind rivets in all alloys. 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.



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.



Marson® Manual Rivet Tools

Big Daddy® Rivet Tool (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. 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.



Big Daddy Rivet Tool (M39010)*

This is the same tool as 39031, but comes with 3/16", 1/4" and special 1/4" Klik-Split rivet nosepieces.

Big Daddy II Rivet Tool (M39032)*

It's the Big Daddy rivet tool you've always counted on for tough quality and professional design, but with an added measure of safety. This hard-working tool is designed to feature a built-in mandrel collection receptacle; simply remove the end cap on the bottom handle to discard the spent mandrels. Reduce mandrels on the floor, increase productivity and boost safety.



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

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

Marson Next Generation Automatic Rivet Tools

These next-generation, professional-series air / hydraulic riveters are designed to be lightweight and well-balanced. Both are engineered to maximize stroke and pull force with a 3-jaw set. For added convenience, you can direct connect or use the attached swivel. Each tool is supplied with nosepieces to set rivets in all alloys, and comes complete with adjustment service wrenches, hydraulic fluid, fluid applicator, spare jaws and a removable swivel air connection line with an air OFF/ON valve built in. An adjustable vacuum system switch located inside the mandrel collection bottle 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.



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" in all alloys, including structural rivets
 Also included are 3/16" and 1/4" Monobolt® and Magna-lok® assemblies
 Weight: 5.5 lbs.

With the BT-2A battery-powered rivet tool, you'll enjoy all the reliability that Marson is known for. Includes superior features and industry-leading performance for manufacturing applications in construction, furniture assembly, lighting fixtures, signs, trailers and more. Also pulls 3/16" structural blind rivets.

* Includes nose tips for 3/32", 1/8", 5/32" and 3/16" rivet sizes. Optional nose tip for 3/16" Monobolts are available.

BT-2A / M39480

Stroke: 0.83" (21mm)
Pulling Force: 2,248 lbs. (10,000n)
Capacity: 3/32" (2.4mm) to 3/16" (4.8mm)*
Weight (with Li-ion battery pack): 4 lbs. (1.8 kg)



The BT-3 battery-powered tool offers 4,600 lbs (20,000n) of pulling force, and it only weighs 4.4 lbs. The BT-3 features a built-in mandrel collection box and a high-capacity 20 V Li-ion / 2.0 Ah battery pack. Recharge time is approximately 30 minutes. A soft grip handle reduces vibration and fatigue. The BT-3 Kit includes one tool with battery, battery charger and carrying case, along with nose tips for 5/32", 3/16" and 1/4" rivets.** Also pulls 3/16" and 1/4" structural blind rivets.

**Optional nose tips for 3/16" and 1/4" Monobolts available.

BT-3 / M38980

Stroke: 1.18" (30mm)
Pulling Force: 4,600 lbs. (20,000n)
Capacity: 5/32" to 1/4" diameter
Weight: 4.4 lbs. (with battery pack)
Battery Pack: 20V / Li-ion / 2.0 Ah
Recharge Time: approx. 30 minutes



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: 3/16" to 1/4"
Weight: 4.8 lbs. (2.177kg)



Marson Rivet Nut Tools

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. Available in a variety of kit forms.



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 6-32, 8-32, 10-24, 10-32 and 1/4-20 mandrels and nosepieces.



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

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.



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.



140-SP (M39223)

The 140-SP features Spin/Pull action, along with 3,057 lbs. of pulling force, in a smaller tool. Just hold the Rivet Nut onto the mandrel end and engage. The tool will automatically spin the nut on. Insert the Rivet Nut in the hole and pull the trigger to set the fastener. Then toggle to the bottom trigger and reverse spin the mandrel off. Easy installation in seconds. Comes supplied with inch mandrels and nosepieces 6-32" through 1/4-20" conveniently stored in a durable carry case. Mandrels and nosepieces for 4mm through 6mm can be purchased separately. The 140-SP can set thread sizes from 6-32 through 1/4"-20 and 4mm through 6mm in aluminum or steel.



Spin/Pull Rivet-Nut Setting Tool (M39225)

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

This advanced tool features an adjustable stroke knob in the base of the tool to fully adjust stroke length to suit any grip range. Included is a swivel air inlet for increased mobility. For added convenience, adjustments and changes are performed outside the tool, with no required tear down to adjust the stroke or change thread sizes. The 160-SP can set thread sizes 4-40 through 1/2-20 and 3,5mm through 10mm in aluminum or steel.



Spin/Spin Pneumatic Rivet Nut Tool (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 supplied with two nosepieces of your choice (4-40 through 3/8"-24 and M3 through M10).



SPIN TOOL MODEL	RPM	THREAD SIZES
SST-1/M39801	3000RPM	4-40, 6-32, 8-32, 3MM, 4MM
SST-2/M39802	1500RPM	10-24, 10-32, 5MM
SST-3/M39803	600RPM	1/4-20, 1/4-28, 6MM
SST-4/M39804	400RPM	5/16-18, 5/16-24, 3/8-16, 3/8-24, 8MM, 10MM



**HOWMET
AEROSPACE**

Howmet Fastening Systems

Industrial Division Brands



Huck, Marson, Recoil, Keysert, Camloc, Simmonds and Snep are trademarks of Howmet Aerospace Inc. and/or its subsidiaries.

North America

Waco Operations

PO Box 8117
8001 Imperial Drive
Waco, TX 76714-8117
Tel: +1 800-388-4825
Fax: +1 800-798-4825
hfs.sales.waco@howmet.com

Kingston Operations

1 Corporate Drive
Kingston, NY 12401
Tel: +1 800-278-4825
Fax: +1 845-334-7333
hfs.sales.kingston@howmet.com

Tracy Operations

1925 North MacArthur Drive
Tracy, CA 95376
Tel: +1 800-826-2884
Fax: +1 800-573-2645
hfs.sales.idg@howmet.com

Global

Telford Operations

Unit C, Stafford Park 7
Telford, Shropshire
England TF3 3BQ
Tel: +44 (0) 1952-290011
Fax: +44 (0) 1952-290459
thisales@howmet.com

Suzhou Operations

58 Yinsheng Road,
SIP Suzhou, Jiangsu
215126 China
Tel: +86-512-62863800-8888

Melbourne Operations

1508 Centre Road
Clayton, Victoria
Australia 3168
Tel: +613-8545-3333
Fax: +613-8545-3390
hfs.sales@howmet.com

Tokyo Operations (Japan & Korea)

1013 Hibiya U-1 Bldg.
Uchisaiwai-cho 1-1-7
Chiyoda-ku, Tokyo
100-0011 Japan
Tel: +81-3-3539-6594
Fax: +81-3-3539-6585

hfsindustrial.com

[YouTube.com/HFSIndustrial](https://www.youtube.com/HFSIndustrial)

The information contained in this publication is only for general guidance, and is not intended to create any warranty, express, implied, or statutory; all warranties are contained only in Howmet Fastening Systems' written quotations, acknowledgments, and/or purchase orders. It is recommended that the user secure specific, up-to-date data and information regarding each application and/or use of such products.

© 2020 Howmet Aerospace Inc. All rights reserved. HFS5643 0120
IntegraFuse, Magna-Lok, BOM HP-2, Big Daddy, Kilik-Turn, Klik-Fast, Klik-Lock and Klik-Split
are trademarks of Howmet Aerospace Inc. and/or its subsidiaries.