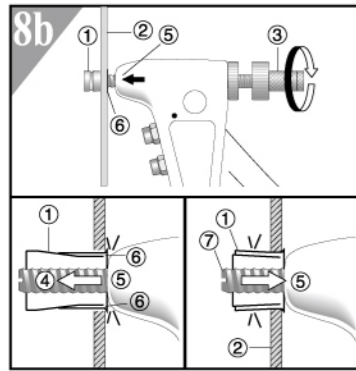
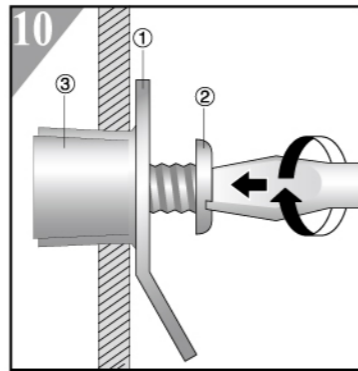


OPERATION INSTRUCTIONS For Setting M8, 5/16, 3/8 Alum Rivet Nuts/Thread-Serts



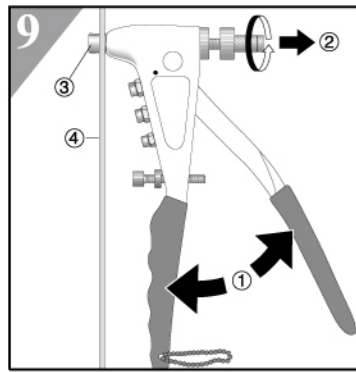
8b) If long type Rivet Nut/Thread-Sert ① is not installed firmly with Workpiece ② after the first setting, just turn Mandrel knob ③ clockwise to enter more Mandrel Threads ④ into the non-firm Rivet Nut/Thread-Sert ① until Tool Working Nose ⑤ touches the Head ⑥ of Rivet Nut/Thread-Sert. Slowly squeeze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



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

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

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



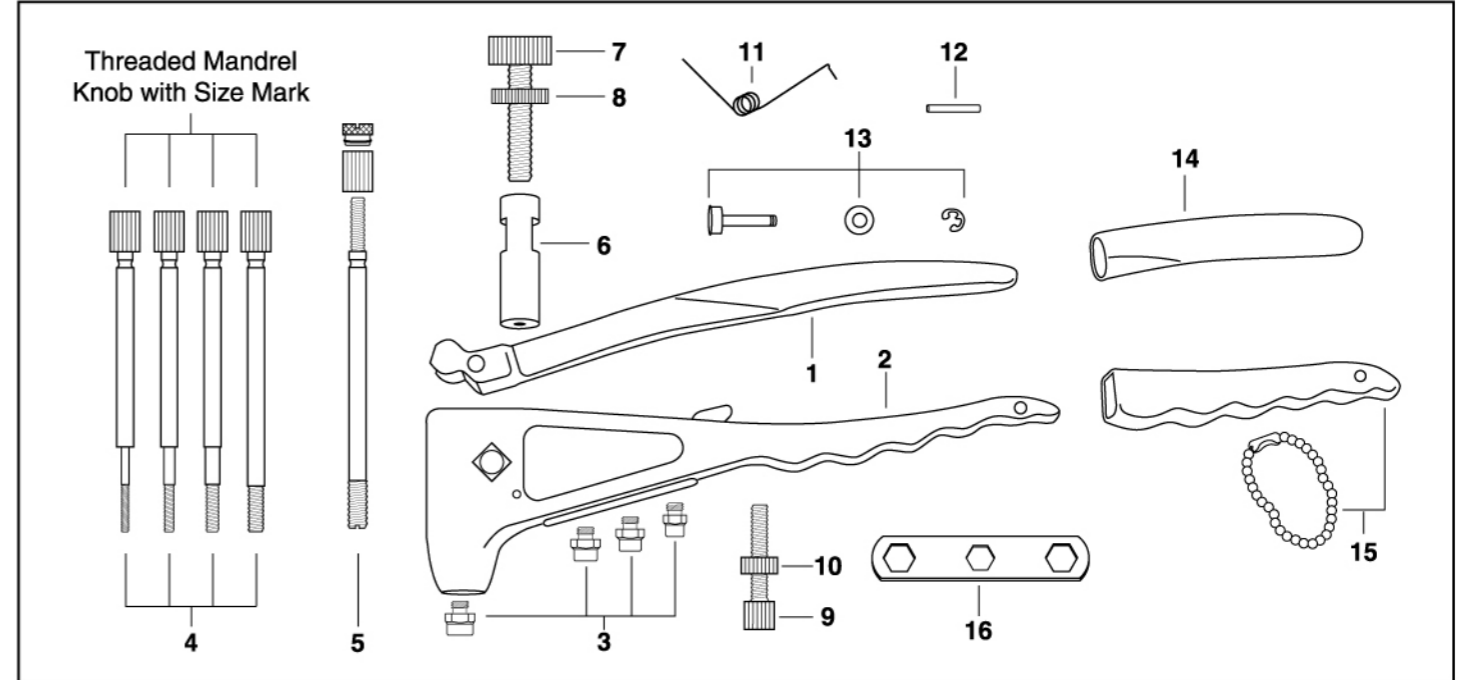
9) Release Tool Handles ① fully and rotate Mandrel Knob ② to unscrew Mandrel from the installed Rivet Nut/Thread-Sert ③. Now the threads of Rivet Nut/Thread-Sert are built up securely in the Workpiece ④.

RECOMMENDED CAPACITY CHART OF MARSON RN-1 TOOL:

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

PARTS LIST

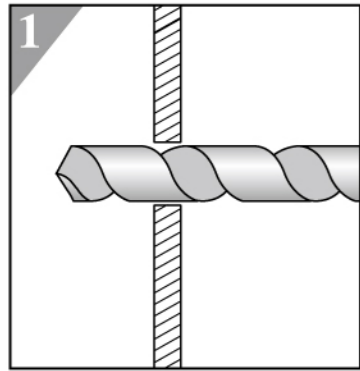
U.S. PATENT 5,729,880



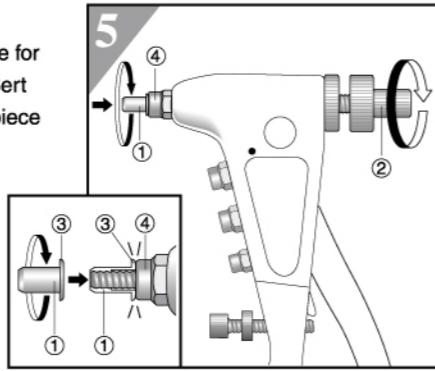
No.	Part No.	Part Name
1	M39190	Upper Handle
2	M39350	Aluminum Body
3-6	M39361	Nosepiece, for #6 Rivet Nut
3-8	M39362	Nosepiece, for #8 Rivet Nut
3-10	M39363	Nosepiece, for #10 Rivet Nut
3-14	M39379	Nosepiece, for 1/4" Rivet Nut
3-M4	M39374	Nosepiece, for M4 Rivet Nut
3-M5	M39373	Nosepiece, for M5 Rivet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

OPERATION INSTRUCTIONS ON REVERSE SIDE

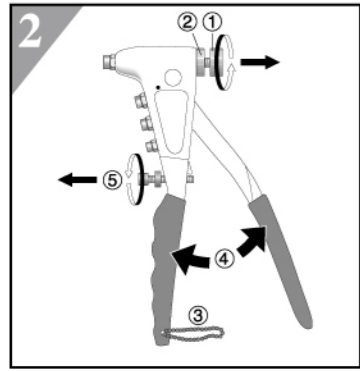
OPERATION INSTRUCTIONS For Setting M3 ~ M6 and 6-32 ~ 1/4-20 Rivet Nuts



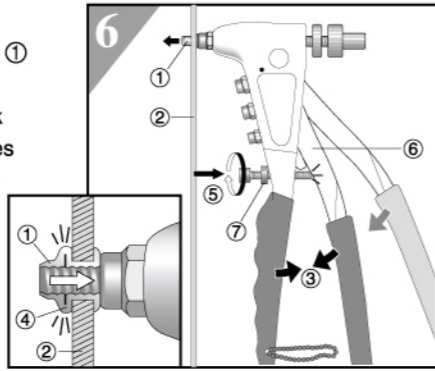
1) Drill the suppliers recommended hole size for the Rivet Nut/Thread-Sert selected into the workpiece as shown in fig. 1



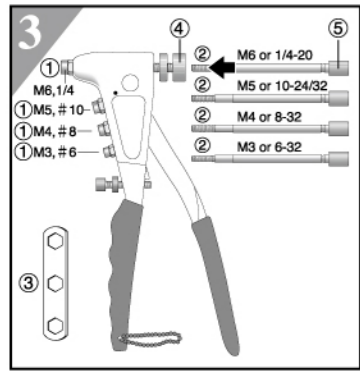
5) Screw the Rivet Nut ① onto Threaded Mandrel by turning either Rivet Nut ① or Threaded Mandrel Knob ② until Rivet Nut Head ③ touches Nosepiece ④. The Rivet Nut End should be flush with the Threaded Mandrel End.



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

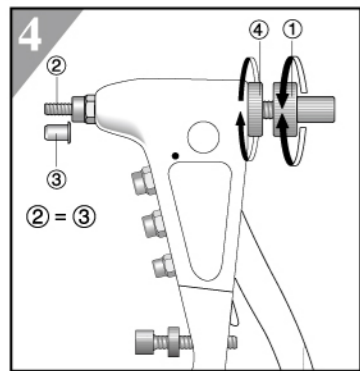


6) Insert the screwed Rivet Nut ① into the drilled Hole of Workpiece ②, squeeze Tool Handles ③ until Rivet Nut is installed firmly by forming a bulge ④ against the back of Workpiece ②; still hold Tool Handles ③ and adjust Stroke Bolt ⑤ up to touch Upper Handle ⑥, then turn up Stroke Nut ⑦ to lock Stroke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

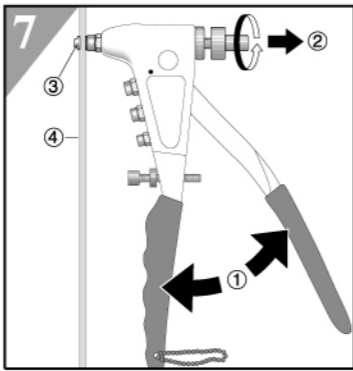


3) Select Nosepiece ① and Threaded Mandrel ② to be same size as Rivet Nut threaded size, exchange Nosepieces ① by Wrench ③, and insert Threaded Mandrel ② into Adjusting Knob ④. The Threaded Mandrel Knob ⑤ should touch Adjusting Knob ④.

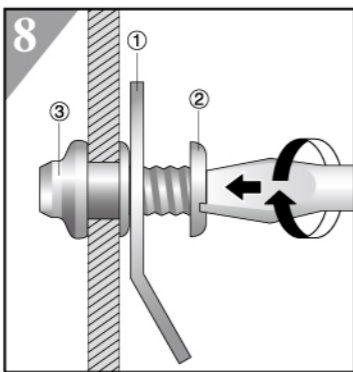
NOTE
A proper Stroke ensures Rivet Nut threads to be installed securely, SO THE PILOT TEST IS ALWAYS RECOMMENDED BEFORE INSTALLING DIFFERENT SIZES OF RIVET NUT.



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



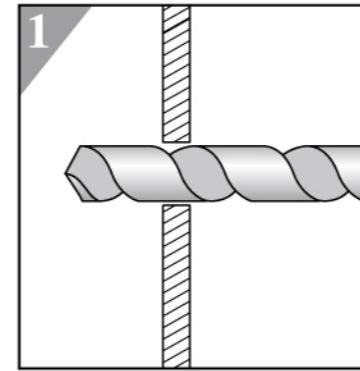
7) Release Tool Handles ① fully and rotate Threaded Mandrel Knob ② to unscrew Threaded Mandrel from the installed Rivet Nut ③. Now the Rivet Nut threads are built up securely in the Workpiece ④.



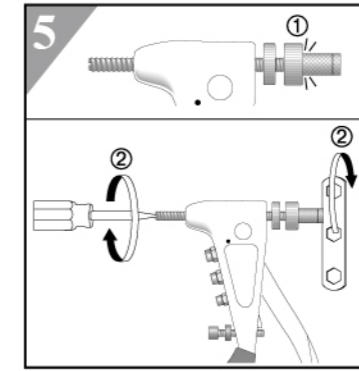
8) Fasten an Object ① by screwing a Bolt or a Screw ② to the installed Rivet Nut ③.

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

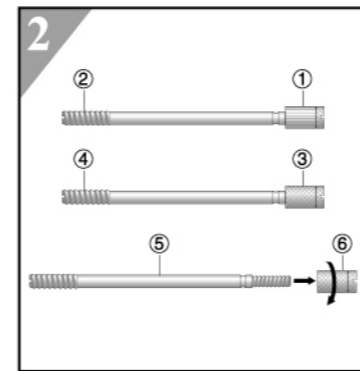
OPERATION INSTRUCTIONS For Setting M8, 5/16, 3/8 Alum Rivet Nuts/Thread-Serts



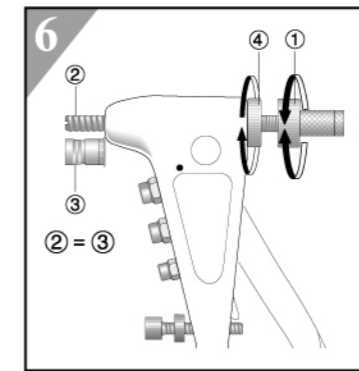
1) Drill the suppliers recommended hole size for the Thread-Sert/Rivet Nut selected into the workpiece as shown in fig. 1



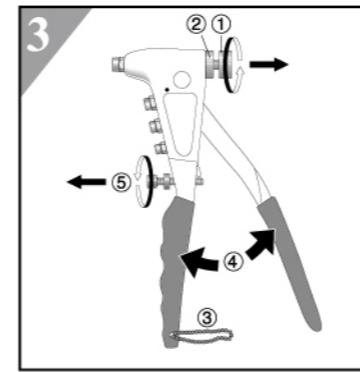
5) Screw the separated Mandrel into Knob Assembly until Knob Assembly touches Adjusting Knob ①. By using the slot, turn the Nosepiece Wrench and Screw Driver clockwise to fasten the separated Mandrel and Knob Assembly together firmly ②.



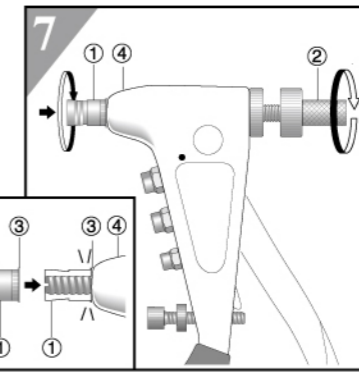
2) The Mandrel and Knob Assembly of the delivered M8, 5/16, 3/8 Mandrel are already assembled. The Knob with straight lines ① is Metric size M8 Mandrel ②, while the Knob with cross ③ lines is Inch size 5/16 and 3/8 Mandrels ④. Unscrew Mandrel ⑤ from the Knob Assembly ⑥.



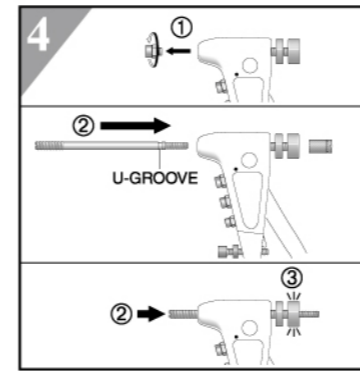
6) Rotate Adjusting Knob ① to adjust thread length of Mandrel ② to be same as length of Rivet Nut/Thread-Sert ③, then turn down the Lock Nut ④ to lock Adjusting Knob ① position firmly.



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



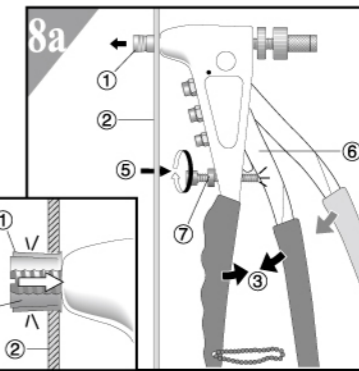
7) Screw the Rivet Nut/Thread-Sert ① onto Mandrel by turning either Rivet Nut/Thread-Sert ① or Mandrel Knob ② until Rivet Nut/Thread-Sert Head ③ touches Working Nose ④. The Rivet Nut/Thread-Sert End should be flush with the Mandrel End.



4) Unscrew to remove Nosepiece from Working Nose ①.

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

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



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

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