

HOWMET FASTENING SYSTEMS

Blind Rivets
Marson

Open End
For blind fastening where there is no access to opposite side of work.



Sizes	Materials
3/32" to 1/4"	Steel/steel Aluminum/aluminum Aluminum/steel Stainless/stainless Stainless/steel Copper/brass Copper/steel

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Closed End
Moisture-resistant due to closed end, greater shear and tensile strength.



Sizes	Materials
1/8", 1/4"	Aluminum/steel Aluminum/aluminum Stainless/stainless

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Multi-Grip
Extended grip range capacity, reduces inventory (fewer sizes required).



Sizes	Materials
1/8", 3/16"	Aluminum/steel Steel/steel

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Tri-Bulb
Large footprint on blind side, great for soft or brittle materials.



Sizes	Materials
5/32", 3/16"	Aluminum/aluminum

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Q-Lok
Retained mandrel increases shear and tensile strength, use in high vibration applications.



Sizes	Materials
3/16"	Steel/steel

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T-Rivets
High clamp up, high shear strength, creates a wide bearing surface.



Sizes	Materials
1/4"	Aluminum/steel

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Special Application
Small flange rivet used primarily for fastening decorative materials on boats, automobiles and other motor vehicles.



Sizes	Materials
1/8"	Stainless/steel Aluminum/aluminum

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Klik-Lock
Hole-filling fastener with excellent gap pull-out. Solid circle lock creates internal lock during installation that virtually eliminates pin push-out.



Sizes	Materials
3/16", 1/4"	Steel/steel Aluminum/aluminum Stainless/stainless

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Plastic

Secure lock prevents pull-out, fasten plastic to plastic, plastic to metal or plastic to fiberglass.



Sizes	Materials
5mm - 8mm	Nylon body, Delrin 500 Mandrel

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Cordless Rivet Tool

Marson

Marson is making installation more efficient with the BT-1 battery-powered cordless rivet tool. It features all the reliability and performance you would expect from Marson, along with superior features and specifications:



- Capacity: 3/32" (2.4 mm) - 3/16" (4.8 mm)
- Stroke length: 0.79" (20 mm)
- Traction power: 1,870 lbs. (850 kg)
- Weight (with Li-ion battery pack): 4.6 lbs. (2.1 kg)
- Battery pack: 14.4 V / Li-ion / 3.0 A.h
- Recharge time: approximately 60 minutes
- Tool accepted: Ni-cad / Ni-MH / Li-ion

The Marson BT-1 is ideal for applications ranging from construction, furniture assembly, lighting fixtures, signs, trailers, and many more.

Mfg Part #
BT-1

HOWMET FASTENING SYSTEMS

Hand Rivet Tool

Marson

The HP-2 is the number one selling hand rivet in the industry. Know 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. 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.



Mfg Part #
HP-2/39000

HOWMET FASTENING SYSTEMS

Air/Hydraulic Rivet Tool

Marson

This next-generation, professional-series air/hydraulic riveter is designed to be light weight and well-balanced. It is engineered to maximize stroke and pull force with a 3-jaw set. For added convenience, you can direct connect or use the attached swivel. The 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.



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

Mfg Part #
MP-3V/39045

HOWMET FASTENING SYSTEMS

Hand Rivet Tool

Marson

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.



Mfg Part #
Big Daddy II/39031

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Rivet Nuts

Marson

MRN Series

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



Sizes	Materials
6/32 to 3/8-16	Steel, Aluminum

HOWMET FASTENING SYSTEMS

Rivet Nuts
Marson

MPN Series

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



Sizes	Materials
6/32 to 3/8-16	Steel, Aluminum

HOWMET FASTENING SYSTEMS

Rivet Nuts
Marson

MTS Series

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



Sizes	Materials
6/32 to 3/8-16	Steel, Aluminum

HOWMET FASTENING SYSTEMS

Rivet Nuts
Marson

MLR/MSR Series

Ribbed Rivet Nut with increased turn-out resistance versus conventional rivet nut; large and small flange available.



Sizes	Materials
6/32 to 3/8-24	Steel, Aluminum
M4x.07 to M10x1.5	

HOWMET FASTENING SYSTEMS

Rivet Nuts
Marson

MLC/MSC Series

Ribbed Rivet Nut with closed end for thread seal; large and small flange available.



Sizes	Materials
6/32 to 3/8-24	Steel
M4x.07 to M10x1.5	

HOWMET FASTENING SYSTEMS

Rivet Nuts
Marson

MHN Series

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



Sizes	Materials
6/32 to 3/8-16	Steel
M4x.07 to M10x1.5	

HOWMET FASTENING SYSTEMS

Rivet Nuts
Marson

MQN Series

Quad-Leg Rivet Nut for light duty thin or soft/brittle material – will accommodate slightly oversized hole with large back side footprint.



Sizes	Materials
6/32 to 1/4-20	Steel
M4x.07 to M6x1.0	

HOWMET FASTENING SYSTEMS

Rivet Nuts
Marson

MXN Series

Large Flange Cross Bulb, large grip range with pre-bulb and 4 slots, provides large blindside footprint for greater pull-out strength in thin sheet metal and plastics.



Sizes	Materials
1/4-20 to 3/8-16	Steel
6mm to 10mm	

HOWMET FASTENING SYSTEMS

Rivet Nuts
Marson

MET Series

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



Sizes	Materials
6-32 to 3/8-16	Steel
4mm to 10mm	

HOWMET FASTENING SYSTEMS

Rivet Nuts
Marson

MNN Series

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



Sizes	Materials
6-32 to 1/2-13	Neoprene
M3-0.5 to M12-1.75	

HOWMET FASTENING SYSTEMS

Rivet Nut Installation Tool

Marson

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.



Mfg Part #
RN-1/M39300

HOWMET FASTENING SYSTEMS

Spin/Spin Pneumatic Rivet Nut Tool (SST)

Marson

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 and mandrels accommodating installation of rivet nuts ranging in size from 4mm and 8-32" to 8mm and 5/16-18".



Mfg Part #	RPM	Standard Nosepiece and Mandrel Sizes	Optional Nosepiece and Mandrel Sizes
39801	3000	4mm and 8/32	3mm and 6/32
39802	1500	6mm and 1/4-20	5mm, 10-24, 10-32, 1/4-28
39804	400	8mm and 5/16-18	10mm, 5/16-24, 3/8-16, 3/8-24

HOWMET FASTENING SYSTEMS

Taps and Gauges

Recoil

Optimum results can be achieved with Recoil taps and gauges to suit hand-tapping through to volume production requirements. Using the "Go - NoGo" gauge, tapped holes can be gauged to enable a precision fit.



Taps	Gauges
Taper	Close and medium tolerance gauges are used to check the pitch diameter of the tapped hole. Gauge handle and all gauge nibs are marked with the extreme product limits for particular size and class of fit.
Intermediate	
Bottoming	
Pilot Nose	
Spiral Flute	
Spiral Point	

HOWMET FASTENING SYSTEMS

Spin/Pull Rivet-Nut Setting Tool (160-SP)

Marson

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.



Mfg Part #	Rivet Nut Thread Sizes	Weight
39225	6-32 through 1/2-13	6 lbs
39226	4mm through 12mm	6 lbs

HOWMET FASTENING SYSTEMS

Free-Running Inserts

Recoil

Recoil helically wound wire thread inserts can be used to strengthen threads, giving applications a longer life. Each insert sharing the load over the entire bolt and hole, improving holding or pull out resistance. With a Recoil insert installed, a more even distribution of load and stress can be achieved. Recoil inserts are generally made of type 304(18-8) stainless steel wire rolled into a diamond shape cross-section.



Recoil inserts can be supplied in other materials such as Inconel, Nimonic 90, Nitronic 60, Phosphor Bronze and type 316 Stainless Steel.

Standard inserts are free-running, but screw-locking inserts are also available. Both free-running and screw-locking inserts are available on plastic strips for automated tooling systems.

Benefits:

- Lightweight yet robust design gives superior holding power
- Quick and simple installation process
- Extensive stock of METRIC, BSW, UNC, UNF, BSC, BA, BSP and NPT inserts
- Large variety of materials and coating options
- Special lengths and diameter pitch combinations available to order
- A wide range of tooling options available

Available Materials	Available Coatings
Stainless Steel	Silver Plating
Phosphor Bronze	Coloured Dye
Inconel X750 (AS7246)	Dry Film Lubricants
Nimonic 90 (HR 503)	
Nitronic 60 (UNS S21800)	
Austenitic Anti-galling Alloy	

HOWMET FASTENING SYSTEMS

Screw-Locking Inserts

Recoil

The Recoil screw-locking insert is designed to provide a screw-locking feature which will retain screws or bolts under the most severe vibration or varying temperature conditions. The insert locking configuration comprises a series of uniquely designed locking chords which, upon the engagement of a screw or bolt, deflect radially to permit the installation of the bolt. Upon bolt entry, these straight segments are flexed outwardly, creating pressure on the bolt. This pressure is applied between the flanks of the bolt thread so that contact area is maximized.



Locking inserts retain locking torque over numerous assembly cycles. Refer to relevant specifications for insert life. Each Recoil screw-locking insert type has a specifically designed locking configuration. This ensures that the insert meets its design specification requirements. Therefore the shape, depth, and number of locking chords will inevitably vary for differing thread types and sizes.

NOTE: Recoil locking inserts are supplied coloured in a red surface dye as standard for differentiation from standard inserts.

Both screw-locking and free-running inserts are available on plastic strips for automated tooling systems.

Benefits:

- Increased bolt retention in vibrating applications
- Consistent performance against temperature variations
- Available in Metric, UNC and UNF thread forms. Others on request.

Available Materials	Available Coatings
Stainless Steel	Silver Plating
Phosphor Bronze	Coloured Dye
Inconel X750 (AS7246) Nickel Alloy	Dry Film Lubricants
Nimonic 90 (HR 503)	
Nitronic 60 (UNS S21800) Austenitic	
Anti-galling Alloy	

HOWMET FASTENING SYSTEMS

Installation Tooling

Recoil

HOWMET Fastening Systems offers a selection of work arms and power tooling, including high efficiency pneumatic and electric installation tools for in-line production or repetitive maintenance situations. A range of associated tooling is available to facilitate insert installation, including manual installation tooling and manual, spring, and pneumatic operated tang breakoff tools.



Available Types
Manual hand tool
Prewinder tool with handle
Electric powered tool
Pneumatic powered tool
Tang break tool

HOWMET FASTENING SYSTEMS

Tangless® Designs

Recoil

Recoil Tangless inserts are designed to offer the same reliable thread strengthening whilst minimizing the risk of losing a 'tang' associated with tanged inserts. Generally, wire thread inserts use a small, piece of material at the bottom of the insert to provide a catching point for the installation tooling, making installation possible. The tang is broken off and removed after installation.



Tangless inserts, however, can be installed without the use of a tang using specialized tooling and an installation notch on the bottom coil of the insert. The absence of a tang eliminates the risk of the metal tang falling into safety critical applications such as engines or electronic equipment.

Available in free-running, screw-locking and strip-feed varieties.

Benefits:

- No tangs to break, retrieve or lose – eliminating risk of a lost tang
- Significantly decreased installation and inspection time
- Approved for use on military programs by NASM8846 and NAS1130
- Bi-directional design eliminates insert orientation requirement
- Quick, non-destructive removal prevents damage to castings

Available Materials	Available Coatings
Stainless Steel	Silver Plating
Phosphor Bronze	Coloured Dye
Inconel X750 (AS7246) Nickel Alloy	Dry Film Lubricants
Nimonic 90 (HR 503)	
Nitronic 60 (UNS S21800) Austenitic	
Anti-galling Alloy	

HOWMET FASTENING SYSTEMS

Thread Repair Kits

Recoil

Containing everything you need to complete thread repair projects, Recoil's innovative and cost effective thread repair kits are utilised worldwide in industrial, automotive & aerospace maintenance solutions.



Recoil currently offer a range of different kits:

- 1 Recoil Pro XL kit is our most advanced kit to date, with a complete rework on the kit box and the contents for optimum usability.
- 2 Original Recoil kit provides you with the basis for the thread repair. Large or unusual size will normally be supplied as a specialist kit.
- 3 Recoil workshop kit contains a selection of kits in the most popular sizes so you always have the kit you need close at hand.

Benefits:

- The largest ex stock range available, including METRIC, BSF, BSW, UNC, UNF, BSC, BA, BSP and NPT in single or multiple size formats.
- Outstanding quality components that won't let you down.
- Pro XL kits include everything to repair a thread; tools, drill and tap.
- Easy to use, with detailed instructions in a range of languages.
- Practical design - sleek, durable case for easy storage and carriage.

Typical Applications:

- Can be used to repair any damaged thread.
- Widely used in automotive applications across car, motorcycle, and commercial vehicle repair.