

# M39075 ( IF-1)

## Integra-Fuse™ Rivet Tool



**Marson is making installation easier than ever with the new  
Marson® Integra-Fuse™ (IF-1)  
It's the one-and-only tool needed for single-pull installations of  
open-end blind and structural rivets in all alloys from 3/16" - 1/4" \***

### **Features:**

**Capacity: up to 1/4"\* (6.350mm)**

**Stroke length: 1.1250" (28.575mm)**

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

**Air Consumption: 4CFM**

**Dimensions: 12"X12.79"X4.99"**

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

\* Does not include Huck® BOM® structural blind fasteners.

AFS Industrial Distribution Group  
1925 N. MacArthur Drive  
Tracy, CA 95376

AFSIndustrial.com  
Customer Service: 800-826-2884  
Tool Repair Dept: 800-826-2884 x 3032

**Alcoa  
Fastening  
Systems**



**WARNING:**  
**ALWAYS WEAR SAFETY GLASSES**  
**WHEN OPERATING AND PERFORMING MAINTENANCE ON TOOL**

**AIR FEED**

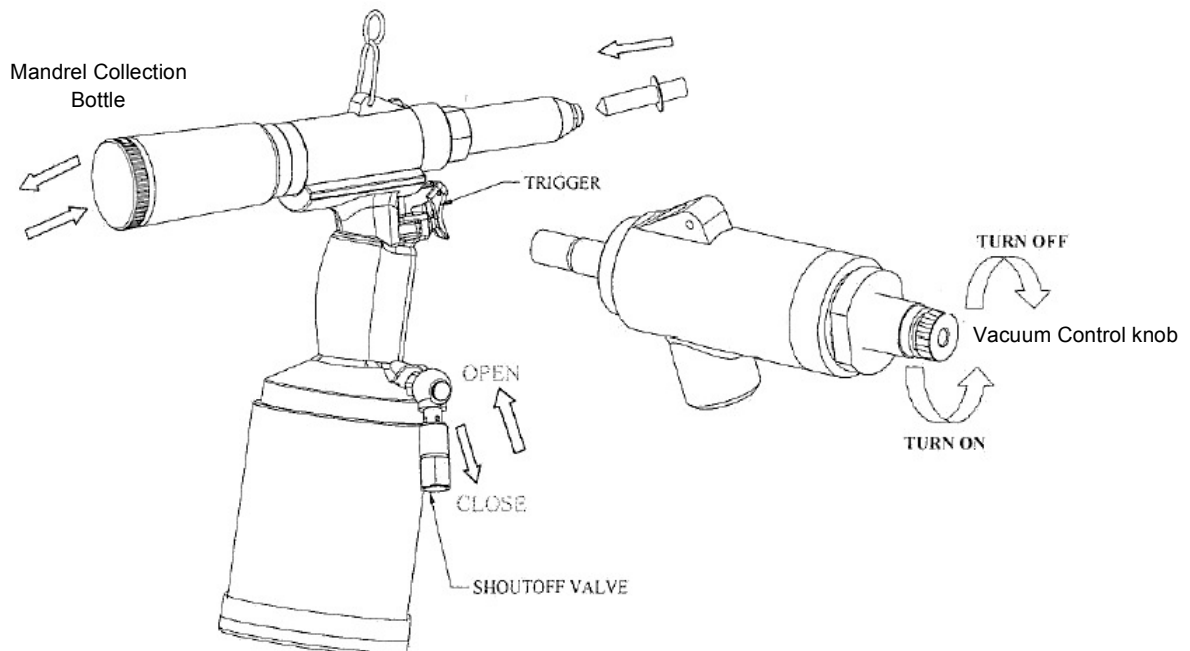
Use only compressed air. Check airline for damage from humidity & contaminants. In order to protect the tool from premature wear, we recommend the use of air regulator and moisture filter

**Recommended Air Pressure is 85 – 95 *psi***  
**Air hose connection thread size is 1/4" NPT.**

**WARNING:**  
**Do not use air supply greater than recommended or tool may be damaged or burst.**

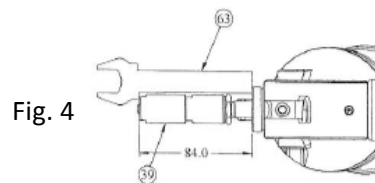
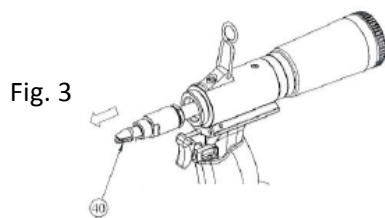
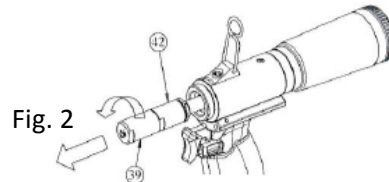
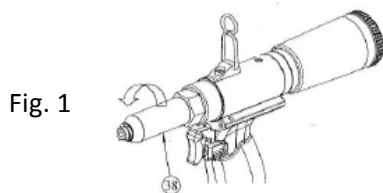
**Operation:**

1. Attach tool to air supply.
2. As shown below, OPEN the shut off valve.
3. Press and hold trigger, to change nosepiece to correct size and then release trigger.
4. If attached, remove mandrel collection bottle and turn vacuum valve assemble to the on position to start vacuum system. Reattach mandrel collection bottle.
5. Insert rivet into tool and squeeze trigger to set. Once rivet is set, release trigger and spent mandrel will be discharged into the mandrel collection bottle when vacuum system is on.



## How to change jaws

1. Remove the frame head (part #38, fig.1).
2. Using two wrenches, separate front jaw housing (part #39) from rear jaw housing (part #42, fig. 2).
3. Remove and replace part #40 (fig. 3 jaws) and re-assemble part #39 back onto tool (fig. 2).
4. Using spanner gauge (part #63), adjust position as shown in fig. 4 and tighten.
5. Reassemble frame head (part #38 fig.1) back onto tool and tighten together front jaw housing (part #39) and rear jaw housing (part #42).



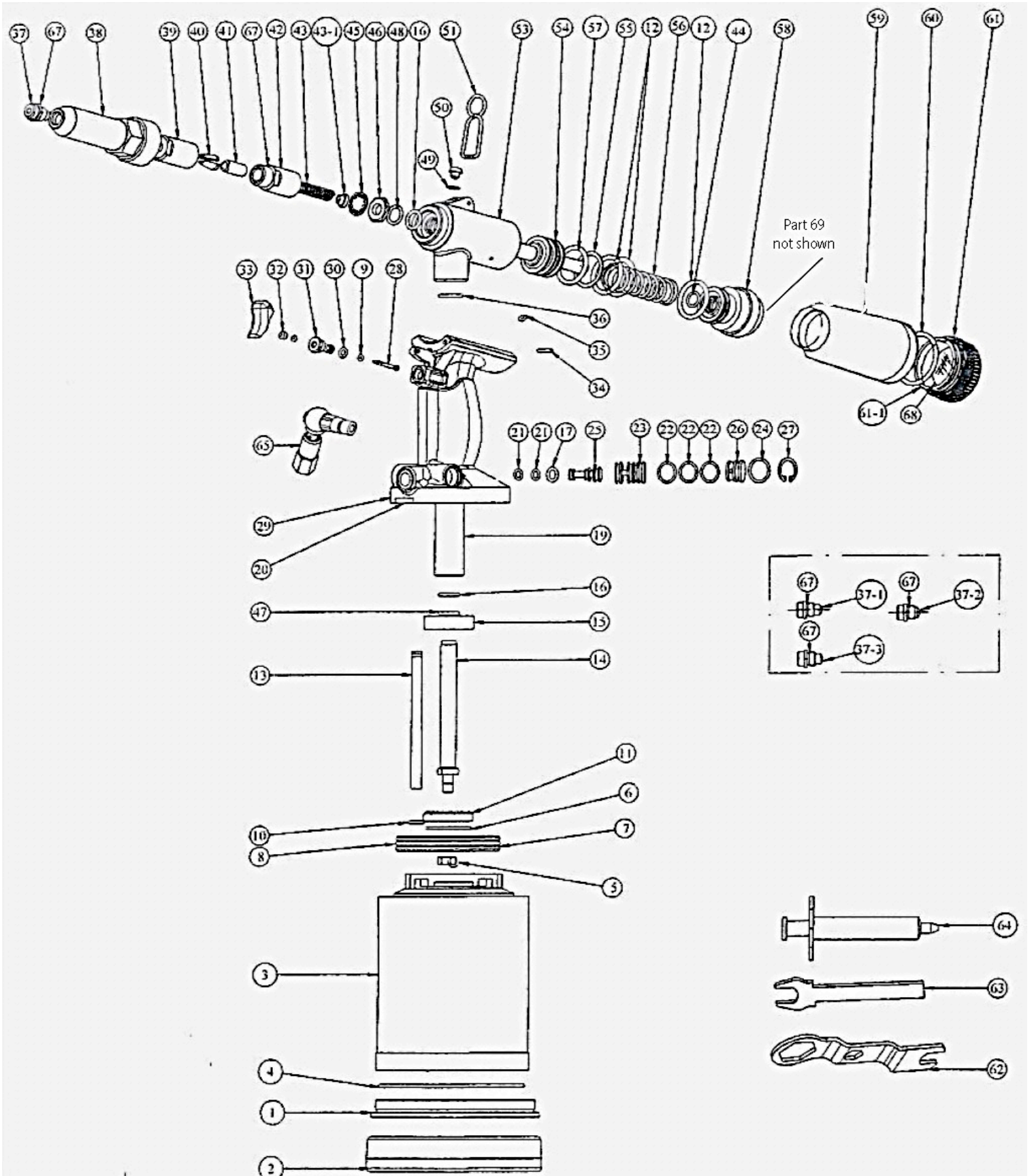
## How to change the hydraulic oil

1. Remove the oil plug (#50) from the tool.
  2. Hold tool upside down over a suitable container, apply air to the tool and squeeze the trigger 2-3 times to remove oil.
  3. Release the air from the tool.
  4. Fill the syringe that came in the tool kit with hydraulic oil. We recommend Mobil DTE 24 as our preferred hydraulic oil.  
If recommended hydraulic fluid is not available be sure to use a *non-foaming hydraulic fluid*.
  5. Screw the syringe into the top of the tool and press the top of the syringe until all of the oil has been inserted into the tool.
  7. Repeat steps 5 & 6 until the tool no longer accepts oil. \*
- \* Note – the oil capacity should not exceed 14ml.
8. Remove the syringe and reinstall the oil plug.
  9. Re-install the frame head back onto the tool.

## Returning the tool to the factory setting

1. Loosen and remove the frame head (#38) from the tool.
2. Loosen the lock nut from the rear of the assembly.
3. Using the spanner gauge (see fig. 4 above), move the assembly until the distance of the front of the collet case to the tool frame matches the distance on the spanner gauge.
4. Re-tighten the lock nut.
5. Re-install the frame head back onto tool.

# IF-1 Tool Breakdown



## IF-1 Parts List

Ref #	AFS Part #	Part Name	Qty	Ref #	AFS Part #	Part Name	Qty
1	M95101	Cylinder Cap	1	36	M95136	Upper Stem O'ring	1
2	M95102	Rubber Cushion	1	37	M95137	1/4 " Nosepiece	1
3	M95103	Air cylinder body	1	37-2	M95137-2	3/16" Nosepiece	1
4	M95104	Cylinder Cap O'ring	1	38	M95138	Frame Head	1
5	M95105	Air Piston Nut	1	39	M95139	Front Jaw Housing	1
6	M95106	Washer	1	40	M95140	Jaw	3
7	M95107	Air piston	1	41	M95141	Jaw Pusher	1
8	M95108	Air Piston O'ring	1	42	M95142	Rear Jaw Housing	1
9	M95109	Valve Piston O'ring	2	43	M95143	Jaw Pusher Spring	1
10	M95110	Vacuum Tube O'ring	1	43-1	M95143-1	Jaw Pusher Spring Collar	1
11	M95111	Air Piston Cushion	1	44	M95144	O'ring	2
12	M95112	O'ring	1	45	M95145	Case Lock Washer	1
13	M95113	Vacuum Tube	1	46	M95146	Case Lock Nut	1
14	M95114	Air Piston Stem	1	47	M95147	Wear ring	1
15	M95115	Hydraulic Rod Guide	1	48	M95148	O'ring	1
16	M95116	Seal	2	49	M95149	Oil Plug Washer	1
17	M95117	Valve Body O'ring	1	50	M95150	Oil Plug	1
18	M95118	O'ring	1	51	M95151	Balance Connector	1
19	M95119	Frame Stem	1	53	M95153	Frame Oil Cylinder Body	1
20	M95120	Silencer	1	54	M95154	Oil Piston	1
21	M95121	Valve Body O'ring	2	55	M95155	Back-Up O'ring	1
22	M95122	Cage O'ring	3	56	M95156	Return Spring	1
23	M95123	Cage	1	57	M95157	Oil Piston O'ring	1
24	M95124	Valve Cap O'ring	1	58	M95158	Frame Cap	1
25	M95125	Valve	1	59	M95159	Spent Mandrel Bottle	1
26	M95126	Valve cap	1	60	M95160	Silencer O'ring	1
27	M95127	Retaining ring	1	61	M95161	Bottle Adapter	1
28	M95128	Valve piston	1	61-1	M95161-1	Bottle Silencer	1
29	M95129	Frame Body	1	62	M95162	Spanner Wrench	1
30	M95130	Trigger Valve O'ring	1	63	M95163	Spanner Gauge	1
31	M95131	Trigger Valve Body	1	64	M95164	Priming Pump Syringe	1
32	M95132	Valve Push Button	1	65	M95165	Air Inlet Shutoff Valve	1
33	M95133	Trigger	1	67	M95167	Jaw Housing O'ring	3
34	M95134	Trigger Pin	1	68	M95168	Foam Cushion	1
35	M95135	O'ring	1	69	M95169	Vacuum Valve Ass'y	1

# Troubleshooting Tips

PROBLEM	CAUSE	SOLUTION
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Rivet jammed	Wrong size rivet	Check nosepiece size versus rivet
	Check for material in the jaw housing	Remove the frame head and clear debris from the inside
No suction	Shut off valve turned off	Remove the mandrel collector and turn the vacuum adjustment knob counterclockwise
Air leaking	Damaged O'rings	Replace damaged O'rings
Loss of power or tool runs slow	Air inlet assembly loose	Re-install and tighten air inlet
	Exhaust port blocked	Clean debris from exhaust port
	Low air pressure	Check pressure (85-95 psi)
Stroke has decreased	Loss of hydraulic oil in tool	Add hydraulic oil

## IMPORTANT WARRANTY INFORMATION

*Alcoa Fastening Systems (AFS)*, makers of Huck, Marson and Recoil brand fasteners, tools and accessories warrants that this tool will be free from defects in materials and workmanship under normal service and use for **ninety (90) days from the date of purchase**. This warranty applies to the purchaser of the tool for original use only.

All other warranties, whether expressed or implied, including any warranties of merchantability or fitness for purpose are hereby excluded. Should this tool fail during this **ninety (90) day period**, and no unauthorized repairs have been made, return the tool freight prepaid to the factory free of charge for replacement of any part or parts found to be defective due to faulty material or workmanship. This represents the sole obligation under this warranty. In no event shall Alcoa Fastening Systems be liable for any consequential or special damages arising from the purchase or use of this tool. You may have other rights which may vary from state to state.

## WARRANTY / OUT OF WARRANTY SHIPPING INSTRUCTIONS

**WARRANTY REPAIR:** Tools requiring warranty repair must be shipped to our tool repair facility with a copy of the purchasers invoice and a tool warranty / repair form.

Form can be downloaded at

[http://afsindustrial.com/distribution/wp-content/uploads/TR\\_FORM\\_112713\\_Tracy.pdf](http://afsindustrial.com/distribution/wp-content/uploads/TR_FORM_112713_Tracy.pdf)

or contact customer service to request a form at 800-826-2884

**OUT OF WARRANTY:** tools require only a completed warranty /repair form

**Note:** shipping address is located on the form