

# Spin Spin Rivet-Nut Tool Instructions

SST-1 (39801), SST-2 (39802), SST-3 (39803) & SST-4 (39804)



## RPM CHART

SST-1 = 3,000 RPM  
SST-2 = 1,500 RPM  
SST-3 = 600 RPM  
SST-4 = 400 RPM

### **CAUTION:**

**ALWAYS WEAR SAFETY GLASSES WHEN OPERATING TOOL**

**Recommended air pressure: 45 to 100 PSI.\***

The air supply to the tool should be dry and free of contamination to prevent wear and tear of the internal components. It is recommended that a filter, pressure regulator and oiler system be used "in line" as close to tool as possible.

\* PSI setting depends upon material, thread size and thickness

The average air setting is 80 PSI.

**See next page (2) for Optional Front End Assemblies (FEA)  
for your tool**

**Alcoa  
Fastening  
Systems**



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**IMPORTANT! PLEASE READ! FRONT END ASSEMBLIES (FEA)**

Purchasing the Optional Front End Assemblies are at the Owner's discretion. Care must be taken to optimize the tools Rivet Nut setting ability. 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.

**OPERATOR IS LIABLE FOR CORRECT AIR PRESSURE**

**DO NOT EXCEED 100 PSI.**

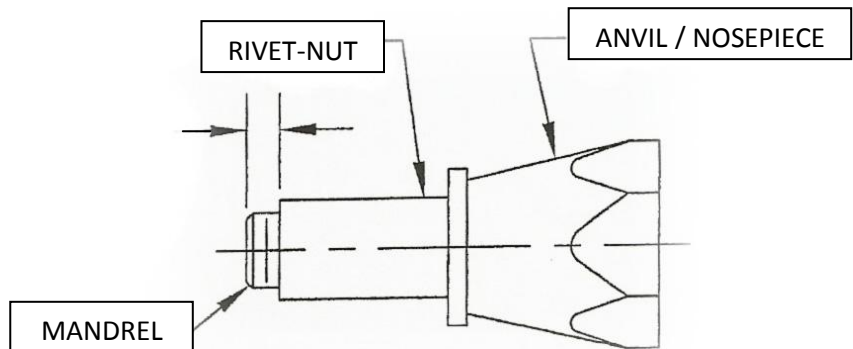
Marson Spin/Spin	3000 RPM	1500 RPM		600 RPM		400 RPM
Tool Model	SST-1	SST-2		SST-3		SST-4
Thread Size	Recommend	Recommend	Optional	Recommend	Optional	Recommend
4-40	X					
6-32	X					
8-32	X		X			
10-24		X			X	
10-32		X			X	
¼-20			X	X		
¼-28			X	X		
5/16-18					X	X
5/16-24					X	X
3/8-16						X
3/8-24						X
M3	X					
M4	X		X			
M5		X			X	
M6			X	X		
M8					X	X
M10						X

## CAUTION:

**ALWAYS WEAR SAFETY GLASSES WHEN OPERATING TOOL**

### OPERATING INSTRUCTIONS:

WITH THE TOOL DISCONNECTED FROM THE AIRLINE, CHECK TO SEE THAT THE SOCKET HEAD CAP SCREW (MANDREL) EXTENDS BEYOND THE FACE OF THE ANVIL FAR ENOUGH TO ALLOW AT LEAST ONE THREAD OF THE SCREW / MANDREL TO EXTEND BE BEYOND THE END OF THE INSERT. IF THE SCREW IS NOT LONG ENOUGH, MEASURE WHAT IS REQUIRED AND GET A SOCKET HEAD CAP SCREW (MANDREL) TO THE CORRECT SIZE THAT WILL ALLOW THE THREADS TO PROTRUDE OUT OF THE RIVET-NUT AS SHOWN.



Socket head cap screw (mandrel)

Note: If you need to purchase a socket head cap screw be sure to purchase a high quality socket head cap screw and also the correct length

**STEP 1.** Connect the airline to the tool. Hold the Rivet-nut to the tool mandrel. Actuate and hold position "F" (Forward) of the trigger (c) in and start engagement of the Rivet-Nut on to the tool screw (mandrel).

**STOP Rivet-Nut engagement just before the head of the Rivet-Nut comes in contact with the anvil face and then by hand, rotate the Rivet-Nut until it comes in contact with the anvil.**

**STEP 2.** After the above is completed, insert Rivet-Nut into the pre-drilled hole in the application. To actuate, depress trigger (C) at position "F" (Forward) and start engagement of the Rivet-Nut. The socket head cap screw (mandrel) will upset the fastener and clinch it securely into the application and allow the tool to stall.

**STEP 3.** After tool stalls, depress trigger (c) at position "R" (Reverse) and disengage the socket head cap screw (mandrel) from the installed Rivet-Nut. Release trigger (c) after disengagement.

Repeat steps 1, 2 and 3 to continue setting Rivet-Nuts.

### PREVENTIVE MAINTENANCE:

IT IS RECOMMENDED THAT YOU APPLY OR DIP THE FIRST FEW THREADS OF THE SOCKET HEAD CAP SCREW IN A LIGHT OIL EVERY SO OFTEN TO MAINTAIN LUBRICITY AND REDUCE WEAR. ALL AIR TOOLS CONTAIN GEARS THAT SHOULD BE LUBRICATED WEEKLY WITH STANDARD GEAR GREASE. (**CAUTION:** EXCESSIVE LUBRICATION WILL AFFECT THE TOOLS SPEED AND POWER). TO PREVENT DAMAGE REMEMBER THAT PNEUMATIC TOOLS HAVE SENSITIVE INTERNAL COMPONENTS AND THEY SHOULD NOT BE DROPPED OR DRAGGED.

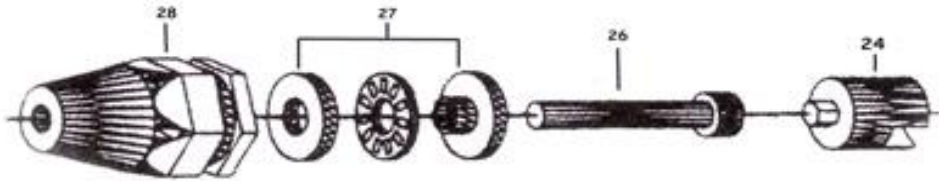


# FRONT END ASSEMBLY (FEA) COMPONENTS

Preferred Tool	Inch Size	Front End Assembly FEA #	Anvil / Nosepiece	3 Piece Bearing Set	Hex Drive	Mandrel / Screw Thread
39801	4-40	M95500	M95399	M95525	M95535	M95424
39801	6-32	M95501	M95400	M95526	M95536	M95425
39801	8-32	M95502	M95401	M95527	M95537	M95426
39802	10-24	M95503	M95402	M95528	M95538	M95427
39802	10-32	M95504	M95402	M95528	M95538	M95428
39803	1/4-20	M95505	M95404	M95529	M95539	M95429
39803	1/4-28	M95506	M95404	M95529	M95539	M95430
39804	5/16-18	M95507	M95406	M95530	M95540	M95431
39804	5/16-24	M95508	M95406	M95530	M95540	M95432
39804	3/8-16	M95509	M95408	M95531	M95541	M95433
39804	3/8-24	M95510	M95408	M95531	M95541	M95434
Preferred Tool	Metric Size	Front End Assembly FEA #	Anvil / Nosepiece	3 Piece Bearing Set	Hex Drive	Mandrel / Screw Thread
39801	M3	M95515	M95400	M95526	M95545	M95440
39801	M4	M95516	M95401	M95527	M95546	M95441
39802	M5	M95517	M95402	M95528	M95547	M95442
39803	M6	M95518	M95404	M95529	M95548	M95443
39804	M8	M95519	M95406	M95530	M95549	M95444
39804	M10	M95520	M95408	M95531	M95550	M95445

## SST-1 (39801) and SST-2 (39802)

### Changing Front End Assembly (FEA) Procedure



1. Insert part 24 into the gun body and rotate until the slot connects with the gun body.



2. Assemble parts 26 and 27 as shown above and drop the assembly into tool and rotate so that hex head in mandrel fits over the hex drive.

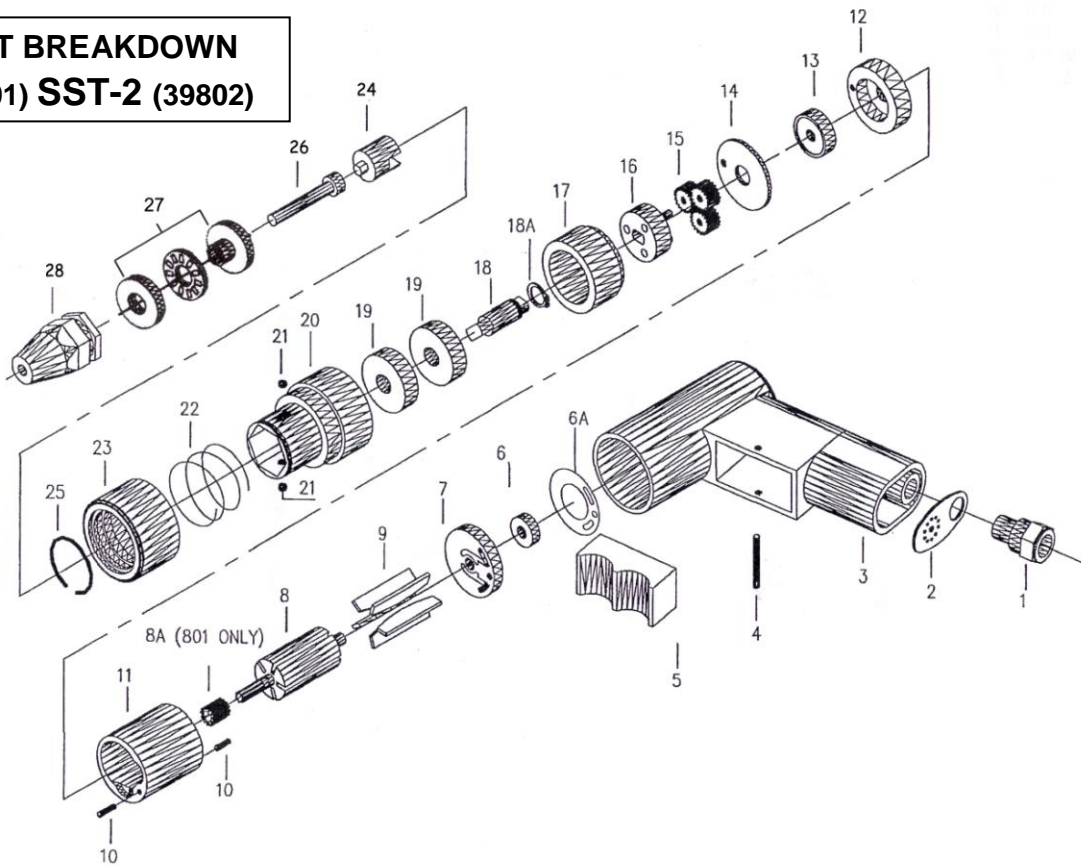


3. Place part 28 onto mandrel.



4. Pull down the quick releasing ring backward and hold while pushing part 28 into the gun body and release the quick releasing ring to complete the assembly.

**PARTS LIST BREAKDOWN  
SST-1 (39801) SST-2 (39802)**

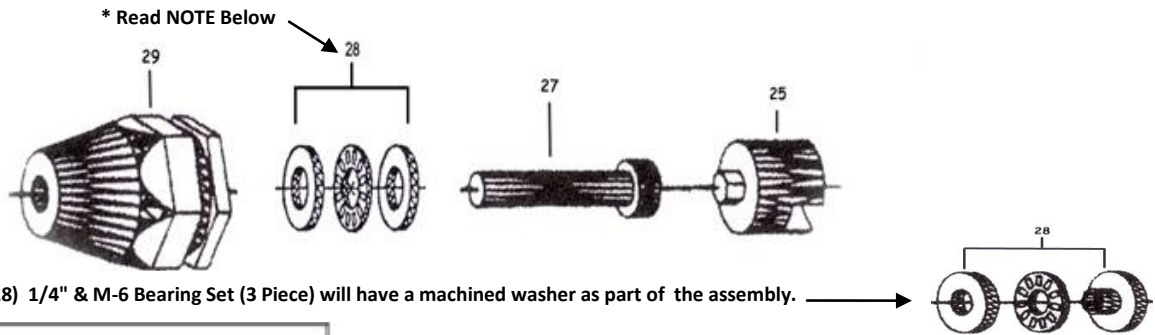


Part #	AFS #	Description	For Tool #	Qty
1	M95446	Air Inlet		1
2	M95447	Difuser-Exhaust		1
3	M95448	Handle assembly		1
4	M95449	Pin		1
5	M95450	Trigger		1
6	M95452	Ball Bearing		1
6A	M95451	Gasket		1
7	M95453	Rear Plate		1
8	M95454	Rotor (6T)		1
8A	M95410	Sun Gear (12T)	39801	1
9	M95455	Rotor Blade		5
10	M95456	Roll Pin (02.5X10)		2
11	M95457	Cylinder		1
12	M95458	Front End Plate		1
13	M95459	Ball Bearing (626zz)		1
14	M95460	Washer		1
15	M95461	Planet Gear (15T)	39801	3
15	M95411	Planet Gear (18T)	39802	3
16	M95462	Gear Cage	39801	1
16	M95463	Gear Cage	39802	1
17	M95464	Internal Gear		1
18	M95465	Drive Spindle		1
18A	M95466	Retaining Ring		1
19	M95467	Ball Bearing (6200z0)		2
21	M95469	Locking Balls		2
22	M95470	Change Valve Spring		1
23	M95471	Quick Change Sleeve		1
21	M95469	Locking Balls		2
22	M95470	Change Valve Spring		1
23	M95471	Quick Change Sleeve		1

Part #	AFS #	Description	For Tool #	Qty
24	M95535	Hex Drive 4-40"	39801	1
24	M95536	Hex Drive 6-32"	39801	1
24	M95537	Hex Drive 8-32"	39801	1
24	M95538	Hex Drive 10-24" / 10-32"	39802	1
24	M95545	Hex Drive M-3	39801	1
24	M95546	Hex Drive M-4	39801	1
24	M95547	Hex Drive M-5	39802	1
25	M95473	Circlip		1
26	M95424	Mandrel 4-40"	39801	1
26	M95425	Mandrel 6-32"	39801	1
26	M95426	Mandrel 8-32"	39801	1
26	M95427	Mandrel 10-24"	39802	1
26	M95428	Mandrel 10-32"	39802	1
26	M95440	Mandrel M-3	39801	1
26	M95441	Mandrel M-4	39801	1
26	M95442	Mandrel M-5	39802	1
27	M95525	4-40" Bearing Set	39801	1
27	M95526	6-32" Bearing Set	39801	1
27	M95527	8-32" Bearing Set	39801	1
27	M95528	10-24" / 10-32" Bearing Set	39802	1
27	M95526	Bearing Set M-3	39801	1
27	M95527	Bearing Set M-4	39801	1
27	M95528	Bearing Set M-5	39802	1
28	M95399	Anvil / Nosepiece 4-40"	39801	1
28	M95400	Anvil / Nosepiece 6-32"	39801	1
28	M95401	Anvil / Nosepiece 8-32"	39801	1
28	M95402	Anvil / Nosepiece 10-24" / 10-32"	39802	1
28	M95400	Anvil / Nosepiece M-3	39801	1
28	M95401	Anvil / Nosepiece M-4	39801	1
28	M95402	Anvil / Nosepiece M-5	39802	1

# SST-3 (39803) & SST-4 (39804)

## Changing Front End Assembly (FEA) Procedure



1. Insert part 25 into the gun body and rotate until the slot connects with the gun body.



2. Assemble parts 27 and 28 as shown above and drop the assembly into tool and rotate so that hex head in mandrel fits over the hex drive.



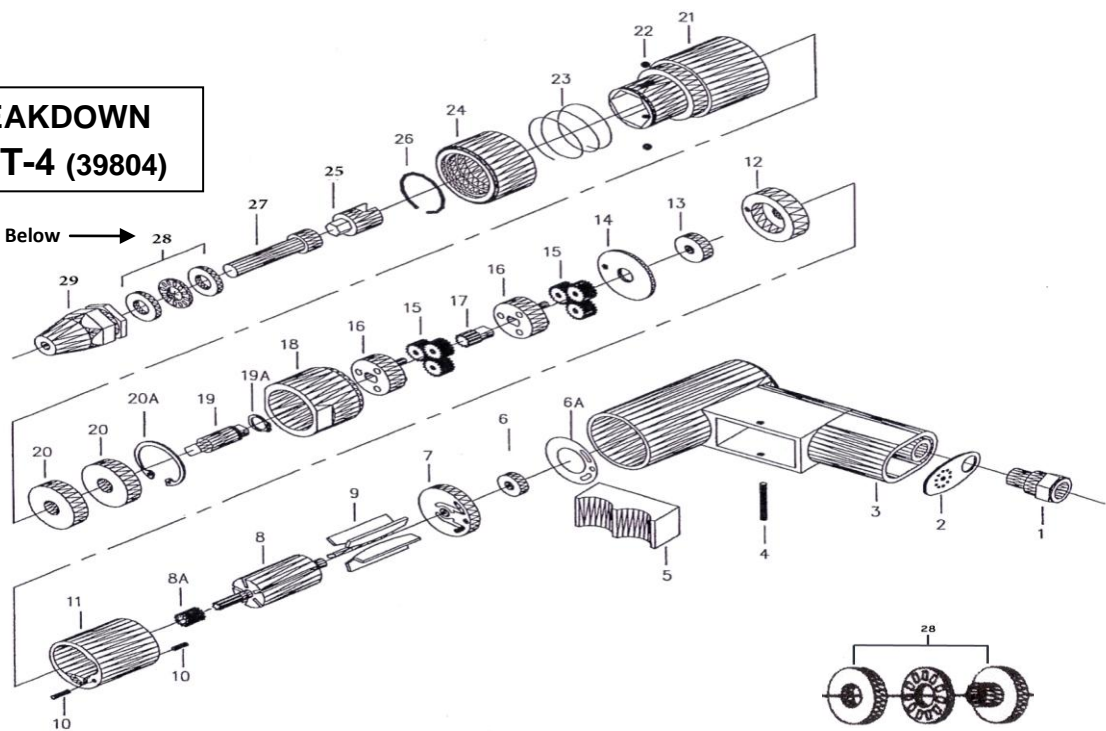
3. Place part 29 onto mandrel.



4. Pull down the quick release ring backward and hold while pushing part 29 into the gun body and release the quick releasing ring to complete the assembly.

# PARTS LIST BREAKDOWN SST-3 (39803) SST-4 (39804)

\* Read NOTE Below →



Note: The 39803 (part # 28) 1/4" & M-6 Bearing Set (3 Piece) will have a machined washer as part of the assembly.

Part #	AFS #	Description	For Tool #	Qty
1	M95446	Air Inlet		1
2	M95447	Difuser-Exhaust		1
3	M95448	Handle Assembly		1
4	M95449	Pin (03x28)		1
5	M95450	Trigger		1
6	M95452	Ball Bearing (696zz)		1
6A	M95451	Gasket		1
7	M95453	Rear Plate		1
8	M95477	Rotor (6T)	39803	1
8	M95478	Rotor (9T)	39804	1
8A	M95412	Sun Gear	39803	1
9	M95455	Rotor Blade		5
10	M95456	Roll Pin (03.5X10)		2
11	M95457	Cylinder		1
12	M95479	Front End Plate 34x6mm	39803	1
12	M95413	Front End Plate 34x8mm	39804	1
13	M95480	Ball Bearing (626zz)	39803	1
13	M95480	Ball Bearing (698zz)	39804	1
14	M95460	Washer		1
15	M95414	Planet Gear (15T)	39803	6
15	M95481	Planet Gear (16T)	39804	6
16	M95421	Gear Cage	39803	2
16	M95482	Gear Cage	39804	2
17	M95422	Sun Gear (12T)	39803	2
17	M95483	Sun Gear (9T)	39804	1
18	M95434	Internal Gear	39803	1
18	M95484	Internal Gear	39804	1
19	M95485	Drive Spindle		1
19A	M95486	Retaining Ring		1
20	M95487	Ball Bearing (6200z)		2
20A	M95488	Retaining Ring		1
21	M95489	Nose Housing		1

Part #	AFS #	Description	For Tool #	Qty
22	M95490	Locking Balls		1
23	M95491	Spring		1
24	M95492	Quick Change Sleeve		1
25	M95539	Hex Drive 1/4-20" / 1/4-28"	39803	1
25	M95540	Hex Drive 5/16-18" / 5/16-24"	39804	1
25	M95541	Hex Drive 3/8-16" / 3/8-24"	39804	1
25	M95548	Hex Drive M-6	39803	1
25	M95549	Hex Drive M-8	39804	1
25	M95550	Hex Drive M-10	39804	1
26	M95494	Circlip		1
27	M95429	Mandrel 1/4-20"	39803	1
27	M95430	Mandrel 1/4-28"	39803	1
27	M95431	Mandrel 5/16-18"	39804	1
27	M95432	Mandrel 5/16-24"	39804	1
27	M95433	Mandrel 3/8-16"	39804	1
27	M95434	Mandrel 3/8-24"	39804	1
27	M95443	Mandrel M-6	39803	1
27	M95444	Mandrel M-8	39804	1
27	M95445	Mandrel M-10	39804	1
28	M95529	1/4-20" / 1/4-28" Bearing Set	39803	1
28	M95530	5/16-18" / 5/16-24" Bearing Set	39804	1
28	M95531	3/8-16" / 3/8-24" Bearing Set	39804	1
28	M95529	M-6 Bearing Set	39803	1
28	M95530	M-8 Bearing Set	39804	1
28	M95531	M-10 Bearing Set	39804	1
29	M95404	Anvil / Nosepiece 1/4-20" / 1/4-28"	39803	1
29	M95406	Anvil / Nosepiece 5/16-18" / 5/16-24"	39804	1
29	M95408	Anvil / Nosepiece 3/8-16" / 3/8-24"	39804	1
29	M95404	Anvil / Nosepiece M-6	39803	1
29	M95406	Anvil / Nosepiece M-8	39804	1
29	M95408	Anvil / Nosepiece M-10	39804	1



## **MAINTENANCE**

If further maintenance is required beyond the scope of this direction sheet and the tool fails to function properly, contact the factory or return it to the factory for service.

Contact our Tool Repair Center at 317-704-8874 or visit our web site at [www.afs-idg.com](http://www.afs-idg.com) for further information.

## **LIMITED TOOL WARRANTY**

Alcoa Fastening Systems (Marson) warrants that this tool, will be free from defects in material and workmanship under normal service, 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 for free of charge replacement of any part or parts found by Alcoa Fastening System (Marson) to be defective due to faulty material or workmanship. This represents the sole obligation of Alcoa Fastening Systems (Marson) under this warranty. In no event shall Alcoa Fastening Systems (Marson) be liable for any consequential or special damages arising from the purchase or use of this tool. You may have other rights which vary from state to state.