OPERATION MANUAL

marson 325-RN Heavy Duty & Professional
HAND RIVET NUT & *RIVET BOLT/STUD TOOL
with Easy-Turn Unit

Arconic
Fastening Systems & Rings

- This Illustrated Operation Manual includes the FEATURES, SPECIFICATIONS, PARTS LIST, OPERATION INSTRUCTIONS, MAINTENANCE and TROUBLESHOOTING.
- Before operating this TOOL, please MUST read this Illustrated OPERATION MANUAL carefully to ensure Safe, Correct and Satisfactory Operation.
- 325-RN can be also served as the RIVET BOLT/STUD TOOL with the Optional THREADED SOCKETS on request.

PATENTS U.S.A. 5,771,738 WORLDWIDE PATENT PENDING

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A. FEATURES

- **325-RN RIVET NUT TOOL** is designed to fasten RIVET NUTS with the THREADED MANDRELS, from 10-24/10-32 UP TO 1/2-13 or from M5x0.8 UP TO M12x1.75, firmly and to build up enough Female Threads securely in the thin base metals and pipes with weldless, tapping-free and one-side work in order to fasten with Bolts.

- **325-RN** is also designed to set RIVET BOLTS/STUDS with the optional THREADED SOCKETS, from 10-24/10-32 up to 5/16-18 or from M5x0.8 UP TO M8x1.25, firmly and to build up enough Male Threads securely on the thin base metals and pipes with weldless and one-side work in order to fasten with Nuts.

- **325-RN** is equipped with an EASY TURN UNIT, just turn the ROTATING KNOB to drive the THREADED MANDREL or THREADED SOCKET to engage with and release from RIVET NUT or RIVET BOLT/STUD easily.

- **325-RN** is equipped with a worldwide patented FIXING-HOLES DEVICE, simply inserts the FIXING-HOLE PIN not only to solve the headache problem of RIVET NUT stuck on the working THREADED MANDREL or RIVET BOLT/STUD stuck in the working THREADED SOCKET that might happen when engaging with or fastening RIVET NUT or RIVET BOLT/STUD, but also to assist THREADED MANDREL or THREADED SOCKET to mount to or dismount from the TOOL easily just with a single SERVICE WRENCH.

B. SPECIFICATIONS

- **325-RN Tool Dimensions and Net Weight:**
  Dimensions (Closed type): L530 x W130 mm. Net Weight: 1.83 kgs.

- **325-RN Working Capacity:**
  1) RIVET NUTS/THREADED INSERTS Materials: Aluminum, Steel, Stainless Steel/Inox
     UN Inch Thread Size: 8-32, 10-24, 10-32, 1/4-20, 5/16-18, 3/8-16. Or ISO Metric Thread Size: M4x0.7, M5x0.8, M6x1.0, M8x1.25, M10x1.5.
  2) RIVET NUTS/THREADED INSERTS Materials: Aluminum, Steel
     UN Inch Thread Size: 1/2-13. Or ISO Metric Thread Size: M12x1.75.
  3) RIVET BOLTS/STUDS Materials: Aluminum, Steel, Stainless Steel/Inox
     UN Inch Thread Size: 10-24, 10-32, 1/4-20, 5/16-18. Or ISO Metric Thread Size: M5x0.8, M6x1.0, M8x1.25.

- **325-RN can fasten RIVET BOLTS/STUDS with the optional THREADED SOCKETS on request.**

- **Standard Parts for 325-RN Single Tool:**
  1) THREADED MANDRELS:
     UN Inch Thread Size 1/4-20 1 pc. Or ISO Metric Thread Size M6x1.0 1 pc.
  2) NOSEPIECES: UN Inch Size 1/4 1 pc. Or ISO Metric Size M6 1 pc.
  3) NOSEPIECES LOCK NUT, SERVICE WRENCH, SMALL RULE, FIXING-HOLE PIN, PIN RETAINER, PARTS PLASTIC BOX, OPERATION MANUAL: 1 pc of each.

- **Optional Parts for 325-RN Single Tool:**
  1) THREADED MANDRELS:
     UN Inch Thread Size: 8-32, 10-24, 10-32, 1/4-28, 5/16-18, 3/8-16, 1/2-13. Or ISO Metric Thread Size: M4x0.7, M5x0.8, M8x1.25, M10x1.5, M12x1.75.
  2) NOSEPIECES: UN Inch Size: #8, #10, 5/16, 3/8, 1/2. Or ISO Metric Size: M4, M5, M8, M10, M12.
  3) THREADED SOCKETS (to fasten RIVET BOLTS/STUDS):
     UN Inch Thread Size: 10-24, 10-32, 1/4-20, 5/16-18. Or ISO Metric Thread Size: M5x0.8, M6x1.0, M8x1.25.

- **Standard Parts for 325-RNK Kit:**
  1) THREADED MANDRELS:
     UN Inch Thread Size: 10-24, 10-32, 1/4-20, 5/16-18, 3/8-16: 1 pc of each. Or ISO Metric Thread Size: M5x0.8, M6x1.0, M8x1.25, M10x1.5: 1 pc of each.
  2) NOSEPIECES:
     UN Inch Size: #10, 1/4, 5/16, 3/8: 1 pc of each. Or ISO Metric Size: M5, M6, M8, M10: 1 pc of each.
  3) NOSEPIECES LOCK NUT, SERVICE WRENCH, SMALL RULE, FIXING-HOLE PIN, PIN RETAINER, PARTS PLASTIC BOX, OPERATION MANUAL: 1 pc of each.

- **Optional Parts for 325-RNK Kit:**
  1) THREADED MANDRELS:
     UN Inch Thread Size: 8-32, 1/4-28, 1/2-13 Or ISO Metric Thread Size: M4x0.7, M12x1.75
  2) NOSEPIECES: UN Inch Size: #8, 1/2. Or ISO Metric Size: M4, M12.
  3) THREADED SOCKETS (to fasten RIVET BOLTS/STUDS):
     UN Inch Thread Size: 10-24, 10-32, 1/4-20, 5/16-18. Or ISO Metric Thread Size: M5x0.8, M6x1.0, M8x1.25.
# C. PARTS LIST

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<td>M95629</td>
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<td>Mandrel/Nosspiece Plastic Container</td>
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Not Shown:

- M34610: Complete set UN inch Mandrels & Nosspieces
- M34613: Complete set Metric Mandrels & Nosspieces
- M34615: 10-24 Mandrel and Nosspiece
- M34616: 10-32 Mandrel and Nosspiece
- M34617: 1/4-20 Mandrel and Nosspiece
- M34618: 1/4-28 Mandrel and Nosspiece
- M34619: 3/8-16 Mandrel and Nosspiece
- M34620: 5mm Mandrel and Nosspiece
- M34621: 6mm Mandrel and Nosspiece
- M34622: 8mm Mandrel and Nosspiece
- M34623: 10mm Mandrel and Nosspiece
- M34624: Steel Carrying Case
- M34625: Plastic Carrying Case
D. MAIN PARTS NAME

- NOSEPICE
- NOSEPICE LOCK NUT
- HEAD
- FIXING-HOLES OF HEAD
- THREAD MANDREL
- MANDREL SEAT, LEFT-HANDED FEMALE THREADS
- LONG FIXING-HOLE OF MANDREL SEAT
- FRONT BODY
- THREAD MANDREL
- NOSEPICE LOCK NUT
- HEAD
- FIXING-HOLES OF HEAD
- FRONT BODY
- STROKE ADJUSTMENT
- STROKE INDICATOR
- ROTATING KNOB
- HANDLE
- GRIP
- PIN RETAINER
E. HOW TO CHANGE THREADED MANDREL AND NOSEPIECE

PRECAUTION:
Check the Thread Size of Fastening BOLT and WORKPIECE Thickness to determine the Thread Size, Grip Range, Material and Type of RIVET NUT, then drill or punch the correct size of Hole in the WORKPIECE to fasten RIVET NUT. The Working Size of THREADED MANDREL and NOSEPIECE should be same as the Thread Size of RIVET NUT.

1. Close 2 HANDLES completely ①.  
   Use SERVICE WRENCH to loose NOSEPIECE LOCK NUT by turning Counter-Clockwise ②.

2. Use Hand to unscrew NOSEPIECE and NOSEPIECE LOCK NUT from HEAD ①, then dismount NOSEPIECE LOCK NUT from NOSEPIECE ②.

3. Use Hand to rotate THREADED MANDREL to align 2 FIXING-HOLES of HEAD with inside LONG FIXING-HOLE of MANDREL SEAT ③, then insert FIXING-HOLE PIN through the FIXING-HOLES and put PIN RETAINER onto FIXING-HOLE PIN End ④. The free rotation of MANDREL SEAT is locked.

4. Use SERVICE WRENCH and Hand to loose and dismount THREADED MANDREL from MANDREL SEAT by turning Clockwise. (NOTE: MANDREL SEAT has Left-Handed Female Threads.)

5. Now the TOOL is ready for changing another Size of THREADED MANDREL and NOSEPIECE.

6. Use Hand and SERVICE WRENCH to assemble the working size of THREADED MANDREL into MANDREL SEAT firmly by turning Counter-Clockwise. (NOTE: MANDREL SEAT has Left-Handed Female Threads.)

7. Use Hand to screw NOSEPIECE into HEAD by turning Clockwise.

8. Finally, take off PIN RETAINER and pull FIXING-HOLE PIN from the FIXING-HOLES.
F. HOW TO ADJUST STROKE DISTANCE

[ WARNING ]

The proper Stroke Distance is decided as per the WORKPIECE Thickness and the Grip Range of RIVET NUT. Each RIVET NUT has its own Grip Range, the Maximum Grip and Minimum Grip.

The WORKPIECE Thickness must be WITHIN the Grip Range of RIVET NUT or BETWEEN the Maximum Grip and Minimum Grip of RIVET NUT for safe and firm fastening.

If the Maximum Grip of RIVET NUT is SMALLER than the WORKPIECE Thickness, this TOOL and RIVET NUT Threads might be damaged.

If the Minimum Grip of RIVET NUT is LARGER than the WORKPIECE Thickness, this RIVET NUT can not be gripped firmly in the WORKPIECE.

Adjusting TOO LONG Stroke Distance might damage this TOOL and RIVET NUT Threads, while TOO SHORT Stroke Distance can not fasten RIVET NUT firmly in the WORKPIECE.

1

Close 2 HANDLES completely ①, rotate STROKE ADJUSTER ② to adjust the proper Stroke Distance in 2 popular ways.

2

First Way: Rotate STROKE ADJUSTER to find out the Figure on the STROKE INDICATOR parallel with the Bottom Edge of the STROKE ADJUSTER:

Figure on STROKE INDICATOR = Stroke Distance

3

Second Way: Rotate STROKE ADJUSTER to find out the Total Exposed Black Lines of the STROKE INDICATING LINES:

1 Black Line = 1 mm or 0.04" Stroke Distance
Total Exposed Black Lines = Stroke Distance

NOTE

HOLE IN WORKPIECE

4 mm

WORKPIECE THICKNESS

4 mm

NOTE: The SMALL RULE is specially designed to measure the WORKPIECE Thickness.
G. HOW TO ADJUST THE PROTRUDING LENGTH (L) OF THREADED MANDREL

1

Open 2 HANDLES fully ①, use SERVICE WRENCH to loose NOSEPIECE LOCK NUT by turning Counter-Clockwise②.

2

Use Hand to rotate NOSEPIECE to adjust the Protruding Length (L) of THREADED MANDREL to be same as the RIVET NUT Height (H), \( L = H \).

3

Finally use SERVICE WRENCH to fasten NOSEPIECE LOCK NUT by turning Clockwise.

NOTE

NOTE: After adjusting the Protruding Length (L) of THREADED MANDREL, the Screwed RIVET NUT should be flush with the THREADED MANDREL.
H. HOW TO OPERATE THIS TOOL TO SET RIVET NUT

PRECAUTION:
Before operating this TOOL, it is strongly requested to follow the above "E" to install the correct size of THREADED MANDREL and NOSEPICE, the above "F" to adjust the proper Stroke Distance, and the above "G" to adjust the suitable Protruding Length (L) of THREADED MANDREL for engaging with RIVET NUT.

1. Open 2 HANDLES fully.
2. Turn ROTATING KNOB Clockwise to screw RIVET NUT onto THREADED MANDREL until RIVET NUT touches NOSEPICE. It is strongly suggested the RIVET NUT to touch the NOSEPICE Slightly, NOT HEAVILY! The Screwed RIVET NUT should be flush with the THREADED MANDREL.

3. Insert the Screwed RIVET NUT into the Prepared Hole of WORKPIECE to touch WORKPIECE ①. Squeeze 2 HANDLES to touch REAR BODY ②, that drives THREADED MANDREL downwards to deform RIVET NUT a Bulge against the back of WORKPIECE to fasten RIVET NUT in the WORKPIECE ③.

NOTE:
It is always suggested to SQUEEZE 2 HANDLES WITH BALANCED HAND FORCE to deform RIVET NUT a Normal Bulge against the back of WORKPIECE.

[ WARNING ]
If hand force CAN NOT squeeze 2 HANDLES to touch REAR BODY, DO NOT CONTINUE TO SQUEEZE 2 HANDLES, it may be caused by TOO LONG Stroke Distance. REDUCE The Stroke Distance immediately to protect this precious TOOL and RIVET NUT Threads from damage. See TROUBLESHOOTING K-2).
H. HOW TO OPERATE THIS TOOL TO SET RIVET NUT

Open 2 HANDLES fully ③, turn ROTATING KNOB Counter-Clockwise ② to unscrew THREADED MANDREL from the Gripped RIVET NUT completely ③.

5

The RIVET NUT is therefore gripped in the WORKPIECE firmly and the RIVET NUT Threads are built up securely.

NOTES:
IF THE RIVET NUT IS NOT FASTENED FIRMLY, please refer to the TROUBLESHOOTING K-1.
IF 2 HANDLES CAN NOT BE SQUEEZED TO TOUCH REAR BODY, please refer to the TROUBLESHOOTING K-2).

6

Complete the fastening work with a Bolt screwed to the Gripped RIVET NUT.

I. HOW TO FASTEN THE SAME SIZE OF RIVET NUT

If the next gripping RIVET NUT is same size as previous one, just repeat the above "H" steps.
Don't Need Any Adjustment!

NOTE:
The PILOT TEST is always recommended before setting different sizes of RIVET NUT for proper fastening and protecting this precious TOOL and RIVET NUT Threads from damage.

J. MAINTENANCE

This TOOL is a very sturdy and reliable tool, it only requires occasional Light Oil applied to the Threads of the THREADED MANDREL ①, NOSEPICE ② and STROKE ADJUSTER ③.

WARNING
FOR SAFETY WORK,
ALWAYS WEAR
SAFETY GOGGLES.
K. TROUBLESHOOTING

K-1) IF THE RIVET NUT IS NOT SET FIRMLY AT THE FIRST FASTENING OPERATION, HOW TO RE-SET THE RIVET NUT FIRMLY:

1. NON-GRIPPED RIVET NUT

2. NON-GRIPPED RIVET NUT

3. GRIPPED RIVET NUT

Still hold to squeeze 2 HANDLES to touch REAR BODY, adjust the STROKE ADJUSTER upward to increase the Stroke Distance 1.0mm or 0.04" step by step to try ②.

Open 2 HANDLES fully ①, turn ROTATING KNOB Clockwise until RIVET NUT touches NOSEPICE Slightly ②.

Squeeze 2 HANDLES ① to grip again RIVET NUT until 2 HANDLES touch REAR BODY ②. If RIVET NUT is still not fastened firmly, repeat the above steps until RIVET NUT is fastened firmly.

4. GRIPPED RIVET NUT + WORK PIECE

5. GRIPPED RIVET NUT + WORK PIECE

NOTE: If the THREADED MANDREL still can not unscrew from the Gripped RIVET NUT and WORK PIECE, turn whole TOOL Counter-Clockwise to unscrew THREADED MANDREL completely.

As the Stroke Distance has been re-adjusted, the Protruding Length (L) of THREADED MANDREL needs to be adjusted again to be same as RIVET NUT Height (H). L = H, as per the above "G" instruction.

NOTE: If the THREADED MANDREL still can not unscrew from the Gripped RIVET NUT and WORK PIECE, turn whole TOOL Counter-Clockwise to unscrew THREADED MANDREL completely.
K. TROUBLESHOOTING

K-2) IF HAND FORCE CAN NOT SQUEEZE 2 HANDLES TO TOUCH REAR BODY, HOW TO RE-ADJUST THE CORRECT STROKE DISTANCE TO PROTECT THIS TOOL AND RIVET NUT THREADS FROM DAMAGE:

1. ACTUAL FIGURE ON STROKE INDICATOR
   GRIPPED RIVET NUT + WORKPIECE
   REAR BODY
   HANDLE

2. THREADED MANDREL
   GRIpped RIVet NUt + WORKPIECE
   HANDLE

WARNING
DO NOT CONTINUE TO SQUEEZE 2 HANDLES!
DO NOT CONTINUE TO SQUEEZE 2 HANDLES, still hold 2 HANDLES and find out the Actual Figure on STROKE INDICATOR and remember that.

3. ADJUST DOWNWARD STROKE ADJUSTER
   OPEN HANDLES fully, turn ROTATING KNOB Counter-Clockwise ② to unscrew THREADED MANDREL from the Gripped RIVET NUT and WORKPIECE ③.

4. PROTRUDING LENGTH (L) OF THREADED MANDREL
   RIVET NUT HEIGHT (H)
   L = H
   Rotate NOSEPIECE

Close 2 HANDLES completely ① to touch REAR BODY, and adjust the STROKE ADJUSTER downward to let Bottom Edge of STROKE ADJUSTER parallel with the Actual Figure on STROKE INDICATOR ②. Now the correct Stroke Distance has been re-adjusted.

As the Stroke Distance has been re-adjusted, the Protruding Length (L) of THREADED MANDREL needs to be adjusted again to be same as RIVET NUT Height (H). L = H, as per the above "G" instruction.
K. TROUBLESHOOTING

K-3) HOW TO SOLVE THE PROBLEM OF RIVET NUT STUCK ON THE THREADED MANDREL WHEN RIVET NUT SCREWS ONTO THREADED MANDREL'S THREADS BY TURNING THE ROTATING KNOB:

1. **STUCK RIVER NUT**
   - **HEAD**
   - **PIN RETAINER**
   - **FIXING-HOLES OF HEAD**
   - **ROTATING KNOB**

2. **STUCK RIVER NUT**
   - **APR OF PLIERS**
   - **THREADED MANDREL**
   - **FIXING-HOLES**

Rotate **ROTATING KNOB** to align the **FIXING-HOLES** of **HEAD** with the inside **LONG FIXING-HOLES** of **MANDREL SEAT**①, then plug the **FIXING-HOLE PIN** into these **FIXING-HOLES** and put the **PIN RETAINER** onto **FIXING-HOLE PIN End**③, the free rotation of **THREADED MANDREL** is therefore stopped.

One person uses **A Pair of Pliers** to clamp the **Stuck RIVET NUT**①, and another person turns whole **TOOL Counter-Clockwise** to unscrew the **THREADED MANDREL** from the **Stuck RIVET NUT**②. Finally, take off **PIN RETAINER** and pull **FIXING-HOLE PIN** from the **FIXING-HOLES**③.

K-4) HOW TO RESOLVE THE PROBLEM OF RIVET NUT STUCK ON THE THREADED MANDREL WHEN SQUEEZES 2 HANDLES AND DEFORMS RIVET NUT IN THE WORKPIECE ABNORMALLY:

1. **ABNORMALLY DEFORMED (STUCK) RIVET NUT**
   - **WORKPIECE**
   - **HEAD**
   - **PIN RETAINER**
   - **FIXING-HOLES OF HEAD**
   - **FIXING-HOLE PIN**

2. **ABNORMALLY DEFORMED (STUCK) RIVET NUT**
   - **WORKPIECE**
   - **THREADED MANDREL**

Open **2 HANDLES** a little bit ③, rotate whole **TOOL** to align the **FIXING-HOLES** of **HEAD** with the inside **LONG FIXING-HOLE** of **MANDREL SEAT**②, then plug the **FIXING-HOLE PIN** into these **FIXING-HOLES** and put the **PIN RETAINER** onto **FIXING-HOLE PIN End**③, the free rotation of **THREADED MANDREL** is therefore stopped.

Turn whole **TOOL Counter-Clockwise** to unscrew **THREADED MANDREL** from the **Stuck RIVET NUT**①. Finally, take off **PIN RETAINER** and pull **FIXING-HOLE PIN** from the **FIXING-HOLES**③.

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