

## OPERATING & SERVICE INSTRUCTIONS

Thank you for purchasing a Thread-Setter™ tool from Marson/Corporation. Please read these instructions carefully before using your new Thread-Setter Tool. If you have any questions, let us know. Your Thread-Setter will set all of the threaded inserts found in the table below.

3. Install proper size mandrel (male threads on both ends) and if required, a nosepiece as follows:

**Installing Nosepiece (If Required):**

- a. Close handles and secure with locking chain.
- b. Screw adjusting knob (5) clockwise into tool about half way. Loosen lock screw (6).
- c. Remove nosepiece (if installed) and store in tool body or with other mandrels.
- d. Remove mandrel in tool by unscrewing (counterclockwise). Hold adjusting knob to prevent it from turning. Store with other mandrels.
- e. Insert threaded end of selected mandrel with flat end into tool and screw in until flush with top of adjusting knob.
- f. Align flat on mandrel with lock screw. Tighten lock screw.
- g. Install nosepiece if needed. Do not over-tighten.

4. Thread "head end" of Klik Poly-Nut or Klik Rivet-Nut onto mandrel with handle in open or unlocked position. Thread on until mandrel end is flush with bottom of fastener.
5. Rotate adjusting knob counterclockwise until fastener head touches nosepiece. Do not tighten.
6. Insert Klik Poly-Nut or Klik Rivet-Nut in hole in workpiece. Hold flush and square in contact with workpiece.
7. Close handles to set. NOTE: Klik Poly-Nuts and Klik Rivet-Nuts work by forming a bulge on the other side. The handles will "give" then stop. When handles will not move further with hand force, the fastener is set.
8. Release handles and rotate adjusting knob counterclockwise to unscrew Thread-Setter from Klik Poly-Nut and Klik Rivet-Nut.

Thread Size	Klik Poly-Nuts		Klik Rivet-Nuts	
	Steel	Alum.	Alum.	Steel
6-32	*	*	*	*
8-32	*	*	*	*
10-24	*	*	*	*
10-32	*	*	*	*
1/2"-20	*	*	*	*
1/2"-28	*	*	*	*
5/16-18	*	*	*	*
5/16-24	*	*	*	*
4MM	*	*	*	*
5MM	*	*	*	*
6MM	*	*	*	*
8MM	*	*	*	*

**How to Set Klik Poly-Nuts and Klik Rivet-Nuts**

Note that Klik Rivet-Nuts have larger diameter heads than Poly-Nuts of the same thread size. A larger head will cover an oversized hole or act as a spacer. Klik Rivet-Nuts assure captive load bearing threads in materials too thin to provide sufficient strength independently. Klik Rivet-Nuts are well suited for soft materials, too.

Klik Poly-Nuts provide a nearly flush installation; Klik Poly-Nuts provide extra grip range as well. With both styles of blind inserts, it is important to select the proper grip range. In addition to total material thickness, measurements must include air gaps, paint and any burrs that cannot be removed.

1. Determine thread size, material and type required.
2. Drill proper size hole in workpiece. Refer to information on fastener box or technical page in catalog for correct hole size.