



# Spin Spin Rivet-Nut Tool Instructions

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



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

## 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 essential for reliable operation 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**

**Note: The average setting is 80 PSI**

The models SST-1, SST-2 and SST-4 pneumatic Rivet-Nut setting tools are designed to provide a user friendly, light weight, quiet, fast and powerful Rivet-Nut insert installation tool that provides long life & trouble free service.

**Weight: 2.5 lbs. 1/4 NPT air fitting required**

**Alcoa  
Fastening  
Systems**



Alcoa Fastening Systems  
1925 N MacArthur Dr  
Suite 200  
Tracy, CA 95376

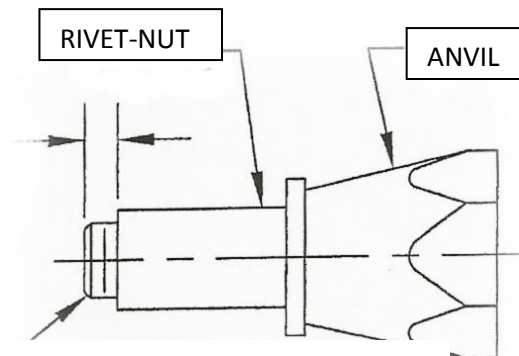


LA-530

**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" 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 actuate and hold position "F" of the trigger (c) in and start engagement of the Rivet-Nut and let the socket head cap screw (mandrel) drive through the fastener and clinch it securely into the application and allow the tool to stall.

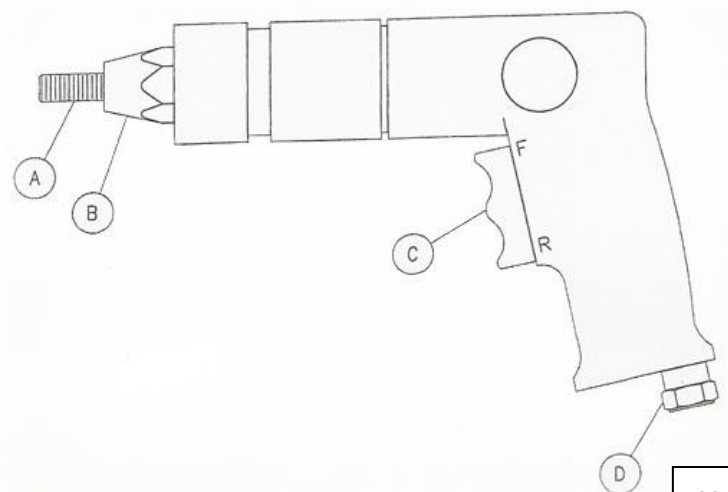
**STEP 3.** After tool stalls actuate and hold position "R" on the trigger (c) and disengage the socket head cap screw (mandrel) from the installed Rivet-Nut. Release trigger

**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 REDUCE WEAR.**

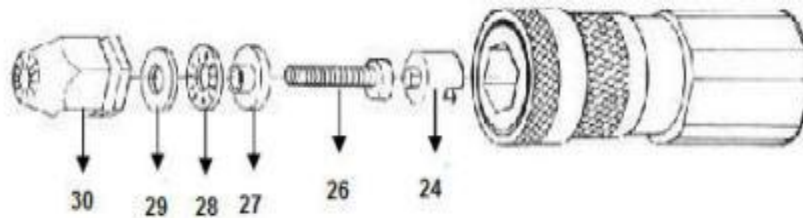
ALL AIR TOOLS CONATIN GEARS THAT SHOULD BE LUBRICATED WEEKLY WITH STANDARD GEAR GREASE. (CAUTION: EXCESSIVE LUBRICATION WILL AFFECT THE TOOLS SPEED AND POWER)

TO PREVENT DAMAGE REMEMBER THAT PNEUMATIC TOOLS HAVE SENSITIVE INTERNAL COMPONENTS AND THEY SHOULD NOT BE DROPPED OR DRAGGED



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

### Changing Mandrel and Nosepiece procedure



(1.) First assembly parts 30, 29, 28, 27 and 26 as shown in figure



2. Insert Part 24 into the gun body. Rotate part 24 until the slot connects with the gun body.



3. Install the pre-assembled bearing set into part 24



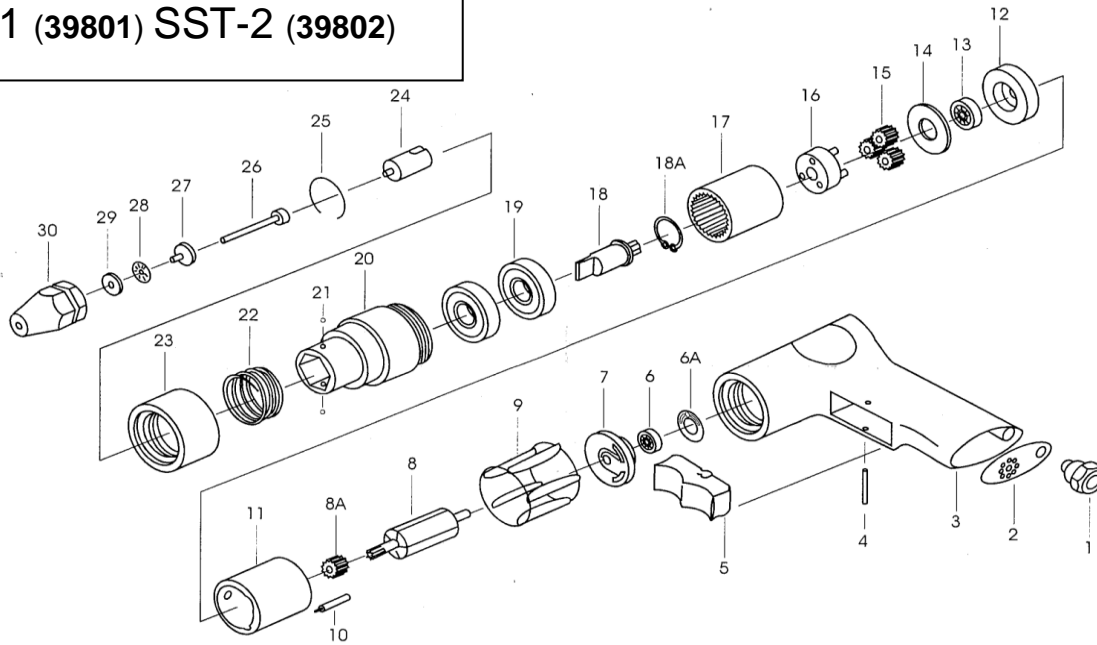
4. Insert part 30 into gun body's hexagon slot



5. Push gun body's quick releasing ring backward and push part 30 into the gun body. Completely release the quick releasing ring to complete the tool assembly.

# PARTS LIST BREAKDOWN

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

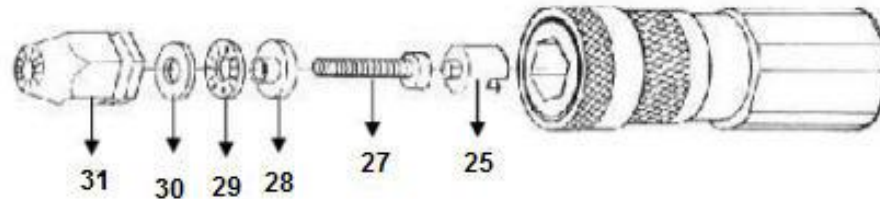


Part #	AFS #	Description	Qty	Part #	AFS #	Description	Qty
1	M95446	Air Inlet	1	26	M95425	Screw 6/32"	1
2	M95447	Difuser-Exhaust	1	26	M95426	Screw 8/32" (supplied w/39801)	1
3	M95448	Handle assembly	1	*26	M95427	Screw 10-24"	1
4	M95449	Pin	1	*26	M95428	Screw 10-32"	1
5	M95450	Trigger	1	26	M95429	Screw 1/4-20" (supplied w/38902)	1
6	M95452	Ball Bearing	1	26	M95430	Screw 1/4-28"	1
6A	M95451	Gasket	1	*26	M95440	Screw M3	1
7	M95453	Rear Plate	1	*26	M95441	Screw M4 (supplied w/39801)	1
8	M95454	Sun Gear (12T)	1	*26	M95442	Screw M5	1
9	M95455	Rotor Blade	5	*26	M95443	Screw M-6 (supplied w/38902)	1
10	M95456	Roll Pin (02.5X10)	2	27	M95474	Rear Thrust Plate	1
11	M95457	Cylinder	1	28	M95475	Roller Bearing	1
12	M95458	Front End Plate	1	29	M95476	Washer	1
13	M95459	Ball Bearing (626zz)	1	*30	M95400	Nosepiece 6/32"	1
14	M95460	Washer	1	30	M95401	Nosepiece 8/32" (supplied w/39801)	1
15	M95461	Planet Gear (15T)	3	*30	M95403	Nosepiece 10-32"	1
16	M95462	Gear Cage	1	*30	M95403	Nosepiece10-24"	1
16	M95463	GearCage	1	30	M95404	Nosepiece 1/4-20" (supplied w/38902)	1
17	M95464	Internal Gear	1	30	M95404	Nosepiece 1/4-28"	1
18	M95465	Drive Spindle	1	30	M95415	Nosepiece M3	1
18A	M95466	Retaining Ring	1	*30	M95416	Nosepiece M4 (supplied w/39801)	1
19	M95467	Ball Bearing (6200z0)	2	*30	M95417	Nosepiece M-5	1
20	M95468	Nose Housing	1	*30	M95418	Nosepiece M6 (supplied w/38902)	1
21	M95469	Locking Balls	2				
22	M95470	Change Valve Spring	1				
23	M95471	Quick Change Sleeve	1				
24	M95472	Draw Bolt Driver	1				
25	M95473	Circlip	1				

\* Sold Separately

## SST-4 (39804)

### Changing Mandrel and Nosepiece procedure



(1.) First assemble parts 31, 30, 29, 28, and 27 as shown



2. Insert Part 25 into the gun body. Rotate part until the slot connects with the gun body.



3. Install pre-assembly into part 25

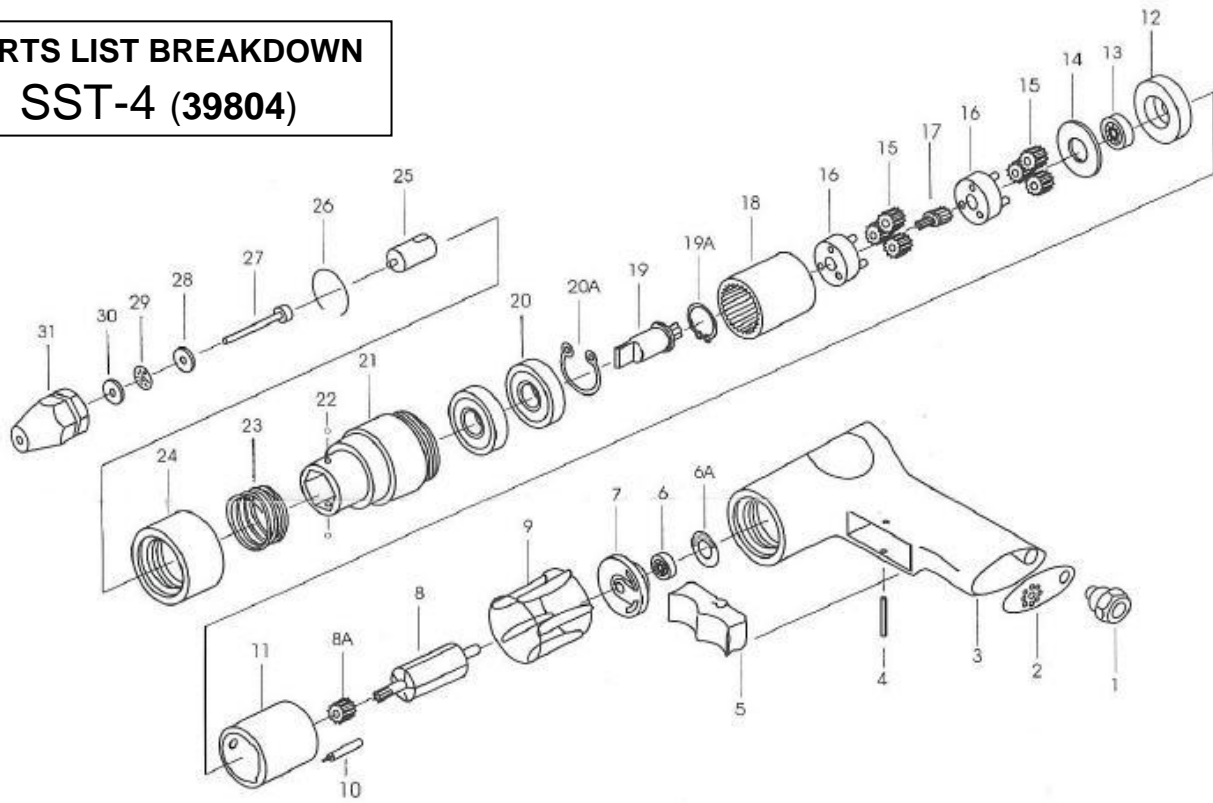


4. Insert part 31 into gun body's hexagon slot



5. Push gun body's quick releasing ring backward and push part 31 into the gun body. Completely release the quick releasing ring to complete the tool assembly.

# PARTS LIST BREAKDOWN SST-4 (39804)



Part #	AFS #	Description	Qty	Part #	AFS #	Description	Qty
1	M95446	Air Inlet	1	20A	M95488	Retaining Ring	1
2	M95447	Difuser-Exhaust	1	21	M95489	Nose Housing	2
3	M95448	Handle assembly	1	22	M95490	Locking Balls	1
4	M95449	Pin (03x28)	1	23	M95491	Spring	1
5	M95450	Trigger	1	24	M95492	Quick Change Sleeve	1
6	M95452	Ball Bearing (696zz)	1	25	M95493	Draw Bolt Driver	1
6A	M95451	Gasket	1	26	M95494	Circlip	1
7	M95453	Rear Plate	1	*27	M95433	Screw 3/8-16"	1
8	M95477	Rotor (6T)	1	*27	M95434	Screw 3/8-24"	1
8A	M95478	Rotor (9T)	1	27	M95431	Screw 5/16-18" <b>(supplied)</b>	1
9	M95455	Rotor Blade	5	*27	M95432	Screw 5/16-24"	1
10	M95456	Roll Pin (03.5X10)	2	*27	M95445	Screw M10	1
11	M95457	Cylinder	1	27	M95444	Screw M8 <b>(supplied)</b>	1
12	M95479	Front End Plate 034x06	1	28	M95495	Washer	1
13	M95480	Ball Bearing (698zz)	1	29	M95496	Roller Bearings	1
14	M95460	Washer	1	30	M95497	Washer	1
15	M95481	Planet Gear (16T)	6	31	M95419	Nose Piece M8 <b>(supplied)</b>	1
16	M95482	GearCage	2	*31	M95408	Nosepiece 3/8-16"	1
17	M95483	Sun Gear (9T)	1	*31	M95408	Nosepiece 3/8-24"	1
18	M95484	Internal Gear	1	31	M95406	Nosepiece 5/16-18" <b>(supplied)</b>	1
19	M95485	Drive Spindle	1	*31	M95406	Nosepiece 5/16-24"	1
19A	M95486	Retaining Ring	1	*31	M95420	Nosepiece M10	1
20	M95487	Ball Bearing (6200z)	2				

\* Sold Separately

IF further maintenance is 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 for further information.

## **LIMITED TOOL WARRANTY**

Alcoa Fastening Systems - Marson division warrants that this tool will be free from defects in material and workmanship under normal service and 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 division 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 division 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.