



# Alcoa Fastening Systems & Rings Products

# Alcoa Fastening Systems & Rings

Strength and reliability across the board. And across the globe.

## Five industry-leading brands. One high standard of quality.

Behind every Alcoa Fastening Systems & Rings brand is a powerful commitment to providing you the strongest, most reliable fastening solution available, regardless of industry. Our uncompromising approach to engineering, manufacturing quality, and breadth and depth of products is unmatched; resulting in a range of structurally superior fasteners and ergonomically designed installation tooling.

In addition, Alcoa Fastening Systems & Rings makes the process easy. Our knowledgeable sales and engineering support staff is available to consult with you to help discover the products that best meet your needs and application requirements.

As part of Alcoa, a global brand with a 100-year history of innovation, Alcoa Fastening Systems & Rings stands behind every product and system we provide; you can be sure we'll be there for you today and tomorrow.

For specific, detailed information about the products you see in this catalog, visit [AFSRindustrial.com](http://AFSRindustrial.com)



Precision engineered, designed and manufactured for superior performance, Huck products include lockbolts, structural blind rivets, hydraulic and pneumatic installation tools, and hydraulic power rigs.



With a wide range of products for specific applications, the Marson system includes structural blind rivets, non-structural blind rivets and rivet nuts, hand tools, and pneumatic installation tools.

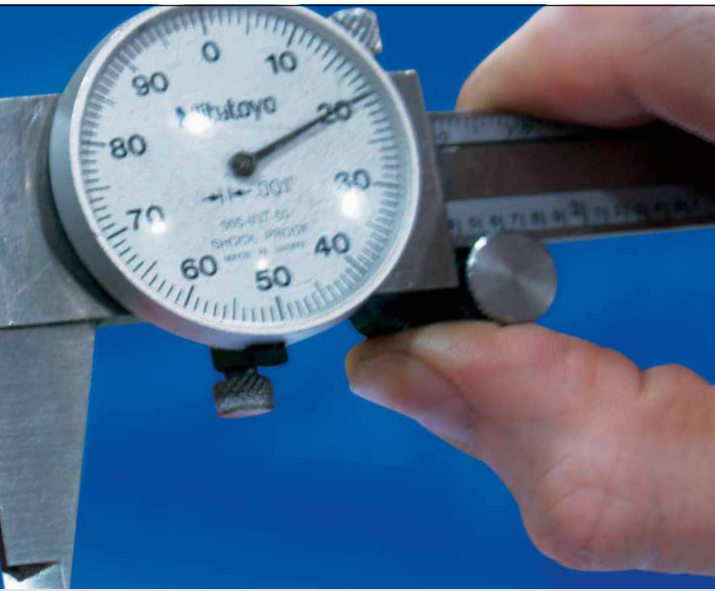


One of the world's most trusted brands of thread inserts, thread repair kits, installation tooling, taps and gauges.



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The Camloc brand encompasses a full line of 1/4-turn, quick release fasteners and tension latches in your choice of standard or highly specialized products.



Keyserts are solid, one-piece, key-locking inserts used to repair damaged threads or for use in original equipment. The Keysert locking keys provide a positive mechanical lock which prevents rotation due to vibration or torsion. Keyserts are available in carbon or stainless steel, both in inch and metric series. Thinwall, Heavy Duty, Extra Heavy Duty, and Solid insert styles are available separately or in kits containing a range of sizes.



## Durable locking performance in high vibration environments.

It's the proven reliable, vibration-resistant locking performance that made Alcoa Fastening Systems & Rings famous.

You'll find it in every HuckBolt®. Delivering uniform, consistent clamp load and high shear and tensile strength, HuckBolts are ideal for applications ranging from general manufacturing to high-vibration environments such as HVAC, trailer and container assembly, rotating equipment, shopping carts, railroad and transit cars, geodesic structures, and many others. HuckBolts also provide a high level of corrosion resistance.

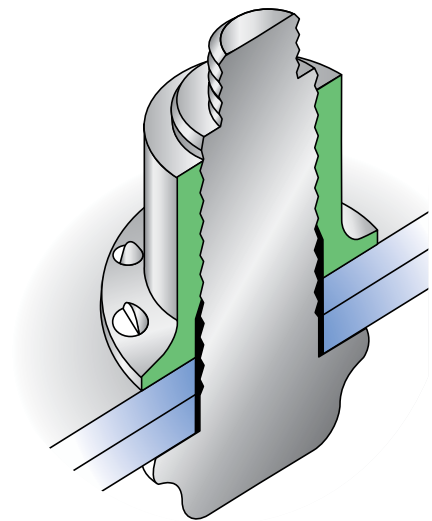
HuckBolts feature an exclusive locking groove design that ensures a tight, permanent fit. In addition to superior fastening performance regardless of which lockbolt type you require, HuckBolts have been proven to reduce labor and installation costs, along with rework and warranty expenses. Stronger, easier to install, and more durable than welding, adhesives, or conventional threaded fastening systems, HuckBolts have been the professionals' choice for decades.

## HuckBolt Tooling

Model SFBTT20  
SWAGEFORWARD®



Lightweight and technologically advanced, Huck lockbolt tooling makes the installation process quick and easy. For instance, this tool represents our most advanced installation tool yet.



The BobTail® offers a pintail-less design, easy-to-read installation indicator, and collar materials that swage into lockgrooves ensuring a permanent connection.

## Types



### BobTail®

Huck's swaged-on fastener with no break-off pintail. Corrosion resistant and installs with lightweight ergonomic tooling.

<b>Sizes</b>	3/16" - 3/8", 1/2" - 1", 12mm - 20mm		
<b>Materials</b>	Steel, Aluminum, Stainless		
<b>Grades</b>	Grade 2	Grade 5 (Class 8.8)	Grade 8 (Class 10.9)

### Huck 360®

The engineered nut-and-bolt fastening system with a unique, embedded thread design for vibration-resistance.

<b>Sizes</b>	3/8" - 1", 12mm - 36mm
<b>Materials</b>	Steel
<b>Grades</b>	Grade 8 (Class 10.9)



### C50L®

Superior vibration resistance and durability for heavy-duty applications. Meets or exceeds all ASTM A-325 standards for shear, tensile and fatigue life.

<b>Sizes</b>	1/2" - 1-3/8"	
<b>Materials</b>	Steel, Aluminum, Stainless	
<b>Grades</b>	Grade 5 (Class 8.8)	Grade 8 (Class 10.9)

### Magna-Grip®

Vibration-resistant, reliable grade 2 fasteners offering high uniform installed values with a wide grip range.

<b>Sizes</b>	3/16" - 3/8"
<b>Materials</b>	Steel, Aluminum



### C6L®/C120L/C150L

The classic 6-groove locking fastener ideal for a wide range of applications. Available in grades, 2, 5, and 8.

<b>Sizes</b>	3/16" - 3/8"		
<b>Materials</b>	Steel, Aluminum, Stainless, Steel Pin with Stainless Head		
<b>Grades</b>	Grade 2	Grade 5 (Class 8.8)	Grade 8 (Class 10.9)

### Hucktainer®

Panel fastener that installs with consistent pressure, reducing crushing or crazing.

<b>Sizes</b>	3/8"
<b>Materials</b>	Steel





## When high performance and holding power are critical.

Huck Structural Blind Rivets are Alcoa Fastening Systems & Rings' answer to loosening and vibration challenges. And it's the reason they are the world's strongest, most reliable, most consistent blind fastening solution available.

In fact, in fatigue tests, Huck Structural Blind Rivets outlasted the competition by almost 20 to 1. Engineered with a unique locking design, many of the Huck Structural Blind Rivets create an internal lock during installation that virtually eliminates pin pushout by mechanically locking the pin to the sleeve. Each locks permanently, reliably, into place, with little effort.

Always accurate and easy to install, Huck Structural Blind Rivets offer quick one-worker installation. Inspections are simple to perform; no need for torque inspections or x-rays.

In applications where vibration-resistance, reliability, and strong hold are critical, Huck Structural Blind Rivets offer the strength and durability needed. No fastening system is more dependable.

## Sheet-line bulb comparison

Even in minimum-grip applications, Huck fasteners outperform the competition. They're engineered to form a bulb directly on the sheet line, precisely where it's needed, to prevent pull-through.



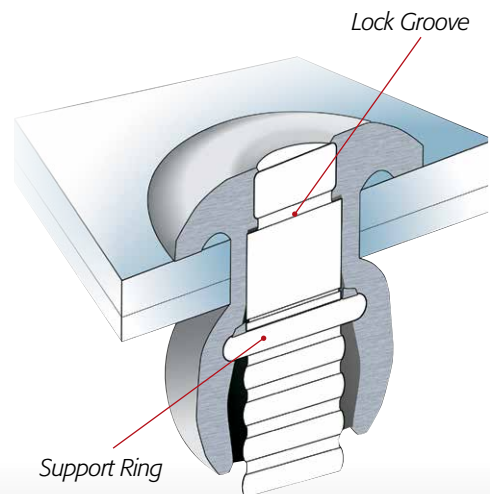
**Auto-Bulb™**

Bulb forms directly on sheet line.



**Competition**

Bulb forms irregularly above sheet line resulting in lower installed values.



HuckLok's lock groove on the pin engages the shoulder of the rivet head while the support ring double locks the pin within the bulb.

## Types



### HuckLok®

Wide 1/4" grip range, double-locking action clamps assembly from both sides for maximum joint integrity.

<b>Sizes</b>	3/16", 1/4"
<b>Materials</b>	Steel
<b>Heads</b>	Protruding, Truss, 100° Oval Countersunk

### Magna-Lok®

Hole-filling fastener with excellent gap pull-out and moisture resistance. Solid circle lock creates internal lock that virtually eliminates pin push-out.

<b>Sizes</b>	3/16", 1/4", 3/8", 1/2"
<b>Materials</b>	Steel, Aluminum, Stainless Steel
<b>Heads</b>	Protruding, Truss, 100° Flush



### Auto-Bulb™

Features a tapered lead-in point for automated, high-speed assemblies. Forms a bulb directly on the sheet line, preventing pull-through. Available in stainless steel.

<b>Sizes</b>	3/16", 1/4"
<b>Materials</b>	Steel, Stainless Steel
<b>Heads</b>	Protruding, Countersunk

### Magna-Bulb®

Wide grip range fastener that forms a bulb directly on the sheet line. Offers a broader bearing surface.

<b>Sizes</b>	3/16", 1/4", 5/16"
<b>Materials</b>	Steel
<b>Heads</b>	Protruding, Truss, 100° Oval Countersunk



### BOM®

Blind, Oversize, Mechanically locked fasteners. Unique push-&-pull installation design for ultimate locking strength from blind-side install.

<b>Sizes</b>	3/16", 1/4", 5/16", 3/8", 1/2", 5/8", 3/4"
<b>Materials</b>	Steel

### FloorTight®

Self-countersinking design for consistent installations in plywood and plymetal vehicle floor applications.

<b>Sizes</b>	1/4", 5/16"
<b>Materials</b>	Steel
<b>Heads</b>	Standard, Wide Flange, Plymetal, 90° Countersunk



### Magna-Tite®

Has water-resistant sealant, for oversize holes and repairs. Large blind-side footprint for use in thin or low-strength materials.

<b>Sizes</b>	3/16", 1/4"
<b>Materials</b>	Aluminum
<b>Heads</b>	Protruding, Shavable, Low Profile, 100° Oval Countersunk

The industry's best installation tooling

Designed to offer the highest levels of ergonomics, productivity, and long life, the Huck line of installation tooling reflects the same level of innovation and quality as its advanced fasteners. Whether it's a Huck hydraulic tool employed in high-volume installation of large diameter HuckBolts, or a smaller pneudraulic model used to install blind rivets and small diameter HuckBolts, you can count on these tools to deliver the industry's best value.



Model BTT35



SFBTT20  
SWAGEFORWARD®



SFBTT8-12



## A wide selection of tooling options

Huck offers a broad selection of hydraulic and pneumatic tools, in addition to Powerig® hydraulic power sources. Huck hydraulic installation tools are available to install a wide range of fasteners, from structural blind rivets to the largest HuckBolts. The Huck line of pneumatic tools, designed for use in repair work or in lower volume production applications, can effectively pull fasteners ranging from 3/32" blind rivets to 3/8" HuckBolts.



244BT



2025

## Powerig® Power Supplies

Combining advanced design and quality manufacturing, Huck Powerigs offer both best-in-class performance and long product life. Whether for mobile or factory use, there is a Huck Powerig hydraulic power source for the job, from electric and gasoline powered portable units, to larger rigs that can individually power up to three tools.



Powerig Model 918 Series



Powerig Model 940



## Versatile, strong, easy to install.

With nine specialty rivets and three distinct head styles, the Marson® line of blind rivets accommodates almost any application where rivets are used to join two or more pieces of material of varying thicknesses.

Available in a wide array of materials and grip ranges, Marson blind rivets are the fastener of choice for a broad range of general consumer and industrial applications. Products include standard open-end rivets, as well as specialty rivets, including closed-end, multi-grip and plastic rivets.

Benefits of Marson blind rivets include high grip strength with no surface distortion or marred surfaces, low-profile heads, high shear and tensile strength, corrosion resistance, and resistance to tampering and vibration.

In addition, Alcoa Fastening Systems & Rings can paint colors to match, as well as anodize or plate to your specifications. Strength. Performance. Variety of styles and grip ranges. All reasons why Marson is one of the most recognized and trusted brand names in fasteners, worldwide.

## Rivet Installation Tooling

Marson provides professional-grade rivet installation tooling, both manual and pneumatic models. Each is designed for maximum ease of use, high performance, and reliability.



## Head Styles



Buttonhead



Large Flange



Countersunk

Marson Rivets are available in a variety of head styles, each engineered to work in specific applications.

## Types



### Open End

For blind fastening where there is no access to opposite side of work.

<b>Sizes</b>	3/32" to 1/4"
<b>Materials</b>	Steel/steel, Aluminum/aluminum, Aluminum/steel, Stainless/stainless, Stainless/steel, Copper/brass, Copper/steel

### Closed End

Moisture-resistant due to closed end, greater shear and tensile strength.

<b>Sizes</b>	1/8", 1/4"
<b>Materials</b>	Aluminum/steel, Aluminum/aluminum, Stainless/stainless



### Multi-Grip

Extended grip range capacity, reduces inventory (fewer sizes required).

<b>Sizes</b>	1/8", 3/16"
<b>Materials</b>	Aluminum/steel, Steel/steel

### Tri-Bulb

Large footprint on blind side, great for soft or brittle materials.

<b>Sizes</b>	5/32", 3/16"
<b>Materials</b>	Aluminum/aluminum



### Q-Lok

Retained mandrel increases shear and tensile strength, use in high vibration applications.

<b>Sizes</b>	3/16"
<b>Materials</b>	Steel/steel

### T-Rivets

High clamp up, high shear strength, creates a wide bearing surface.

<b>Sizes</b>	1/4"
<b>Materials</b>	Aluminum/steel



### Special Application

Small flange rivet used primarily for fastening decorative materials on boats, automobiles & other motor vehicles.

<b>Sizes</b>	1/8"
<b>Materials</b>	Stainless/steel, Aluminum/aluminum

### Klik-Lock

Hole-filling fastener with excellent gap pull-out. Solid circle lock creates internal lock during installation that virtually eliminates pin push-out.

<b>Sizes</b>	3/16", 1/4"
<b>Materials</b>	Steel/steel, Aluminum/aluminum, Stainless/stainless



### Plastic

Secure lock prevents pull-out, fasten plastic to plastic, plastic to metal or plastic to fiberglass.

<b>Sizes</b>	5mm - 8mm
<b>Materials</b>	Nylon body, Delrin 500 Mandrel

## When high performance and strength are critical.

Marson® Rivet Nuts are designed to deliver low-cost, permanent thread placement in thin material while providing at least six full thread turns per application install. Ideal for painted surfaces, Marson Rivet Nuts help increase production and reduce rework by eliminating the surface damage that can occur with other fastening methods.

Available in a variety of sizes and materials, Marson Rivet Nuts can be used to fasten multiple sheets as well as single sheets. Styles accommodate every type of application, whether it requires heavy push-out loads, counter-sinking, large backside footprint, component mounting, or applications requiring a high level of vibration and moisture resistance. Engineered with Alcoa Fastening Systems & Rings' focus on quality, Marson Rivet Nuts are the ideal choice when high performance and strength are critical.

## Rivet Nut Installation Tools & Kits

Using manual or pneumatic Rivet Nut Tooling, Marson Rivet Nut Installation Tools and specialty kits provide the operator with the ability to install any size rivet nut or threaded insert with ease. Installation of Marson Rivet Nuts can be completed by one operator with a minimum level of training.



## Types



### MRN Series

Flathead Flange (thick wall) for applications that require heavy push-out loads (recommend spin-pull tool).

<b>Thread Sizes</b>	6-32 to 3/8-16
<b>Materials</b>	Steel, Aluminum

### MPN Series

Poly-Nut Rivet Nut, very small flange, lowest profile for near counter sink applications.

<b>Thread Sizes</b>	6-32 to 3/8-16, 4mm to 10mm
<b>Materials</b>	Steel, Aluminum



### MTS Series

Thread-Sert®, small flange, 360 degree swaging action in the hole and no maximum grip range.

<b>Thread Sizes</b>	6-32 to 3/8-16
<b>Materials</b>	Steel, Aluminum

### MLR/MSR Series

Ribbed Rivet Nut with increased turn-out resistance vs. conventional rivet nut; large and small flange available.

<b>Thread Sizes</b>	6-32 to 3/8-24, M4x.07 to M10x1.5
<b>Materials</b>	Steel, Aluminum



### MLC/MSC Series

Ribbed Rivet Nut with closed end for thread seal; large and small flange available.

<b>Thread Sizes</b>	6-32 to 3/8-24, M4x.07 to M10x1.5
<b>Materials</b>	Steel

### MHN Series

Large Flange Half Hex Rivet Nut for hex hole to provide exceptional turn-out resistance.

<b>Thread Sizes</b>	6-32 to 3/8-16, M4x.07 to M10x1.5
<b>Materials</b>	Steel



### MQN Series

Quad-Leg Rivet Nut for light duty thin or soft/brittle material – will accommodate slightly oversized hole with large back side footprint.

<b>Thread Sizes</b>	6-32 to 1/4-20, M4x.07 to M6x1.0
<b>Materials</b>	Steel

### MXN Series

Large Flange Cross Bulb, large grip range with pre-bulb and 4 slots, provides large blindside footprint for greater pull-out strength in thin sheet metal and plastics.

<b>Thread Sizes</b>	1/4-20 to 3/8-16, 6mm to 10mm
<b>Materials</b>	Steel



### MET Series

External Thread Stud Rivet Nut allows for component mounting and mate nut.

<b>Thread Sizes</b>	6-32 to 3/8-16, 4mm to 10mm
<b>Materials</b>	Steel

### MNN Series

Neoprene Insert with pre-molded brass nut for quick fastening in vibration and moisture resistant applications.

<b>Thread Sizes</b>	6-32 to 1/2-13, M3-0.5 to M12-1.75
<b>Materials</b>	Neoprene



## Delivering positive-locking performance.

The Recoil® system consists of precision inserts, quality high speed taps, and easy-to-use installation tools which are used for repairing damaged screw threads or creating strong new threads. Recoil helically wound screw-thread inserts are generally manufactured from Type 304 (18-8) stainless steel wire, cold rolled into a diamond shaped cross section. Recoil inserts can be supplied in other materials such as Inconel X750, Inconel 625, Nimonic 90, Nitronic 60, Phosphor Bronze and Type 316 stainless steel.

Recoil inserts are available in either standard free-running form or screw-lock type which provides an internal locking feature. Inserts are manufactured for every thread form including UNC, UNF, BSC, BSW, BSP, BSF, BA, NPT and ISO Metric thread sizes. Inserts are available in 5 different standard lengths. 1D, 1.5D, 2D, 2.5D and 3D. Special lengths are available on request.

## Types of Inserts



### Free-Running Inserts

The standard Recoil free-running insert provides for easy installation of a female thread, delivering the necessary holding power for most applications. Various sizes available.

### Screw-Locking

For particularly demanding or extreme high-vibration applications, Recoil offers a screw-locking design, which provides a superior locking function in the female thread. Various sizes available.



### Tangless® Designs

Ideal for a wide range of OEM applications, Recoil Tangless® inserts provide peace-of-mind by eliminating the possibility of foreign objects (the tang) being left behind in the final assembled product. Various sizes available.

## Thread Repair Kits

A full range of Recoil thread repair kits, covering the majority of sizes commonly in use today, is available from AFSR. Recoil industrial kits contain an HSS tap, installation tools, tang break tools, drills, stainless steel inserts, and instructions, in a sturdy reusable container. Recoil problem-solving repair kits are available in single or multiple size format.



## Installation Tooling

Alcoa Fastening Systems & Rings also offers a selection of work arms and power tooling, including high efficiency pneumatic and electric installation tools for in-line production or repetitive maintenance situations. A range of associated tooling is available to facilitate insert installation, including manual installation tooling and manual, spring, and pneumatic operated tang breakoff tools.



## Taps and Gauges

Optimum results can be achieved with Recoil taps and gauges to suit hand-tapping through to volume production requirements. Using the "Go-No-Go" gauge, tapped holes can be gauged to enable a precision fit.



## Ideal for heavy-wear and positive mechanical lock.

Keyserts are solid, one-piece, key-locking inserts used to repair damaged threads or for use in original equipment. The Keysert locking keys provide a positive mechanical lock which prevents rotation due to vibration or torsion. Keyserts are available in carbon or stainless steel, both in inch and metric series. Thinwall, Heavy Duty, Extra Heavy Duty, and Solid insert styles are available separately or in kits containing a range of sizes. Installation tools are also available separately or in a range kit.

### Features

- Installed with standard drills and taps
- Easy installation
- May be used in many materials; aluminum, magnesium, and cold rolled steel
- Easy to remove



Keysert tools are available in inch and metric sizes for all Keysert inserts.

Kits are available with an assortment of Keysert insert sizes with matching tools.



## Types of Key-Locking Inserts

### Thin Wall

Ideal for repairing damaged threads. Different material thicknesses are available depending on application (see other types below).

<b>Sizes</b>	#10 – 1/2" internal thread 5/16" – 5/8" external thread
<b>Materials</b>	Inserts - C1215 or equivalent (carbon); 303 stainless steel (stainless)
<b>Keys</b>	Inserts with internal thread size 5/16" or M7 and larger are furnished with 4 locking keys. Keys made from 302 stainless steel.



### Heavy Duty

Similar to Thin Wall Keyserts with a thicker wall for applications where more strength is required.

<b>Sizes</b>	#8 – 1-1/2" internal thread 5/16" – 1-7/8" external thread
<b>Materials</b>	Inserts - C1215 or equivalent (carbon); 303 stainless steel (stainless)
<b>Keys</b>	Inserts with internal thread size 5/16" or M7 and larger are furnished with 4 locking keys. Keys made from 302 stainless steel.



### Extra Heavy Duty

Extra Heavy Duty Keyserts are preferred when:

- Extra strength/torque out is required
- The parent material has sufficient space for a heavier wall
- Larger hole needs to be reduced to a smaller size

<b>Sizes</b>	#6 – 1" internal thread 5/16" – 1-1/2" external thread
<b>Materials</b>	Inserts - C1215 or equivalent (carbon); 303 stainless steel (stainless)
<b>Keys</b>	Inserts with internal thread size 5/16" or M7 and larger are furnished with 4 locking keys. Keys made from 302 stainless steel.



### Solid

Solid threaded inserts are perfect for:

- Relocating holes that have been drilled or tapped in the wrong place
- Plugging holes or filling in holes that are too big

<b>Sizes</b>	5/16" – 1-3/8" external thread
<b>Materials</b>	Inserts - C1215 or equivalent (carbon); 303 stainless steel (stainless)
<b>Keys</b>	Inserts with internal thread size 5/16" or M7 and larger are furnished with 4 locking keys. Keys made from 302 stainless steel.



## A wide range of fasteners, latches, and customized solutions.

Alcoa's range of quick-release fasteners and draw latches from Camloc® is the result of more than 70 years worth of aerospace, automotive, and industrial engineering expertise.

This comprehensive range of high-performance fasteners and latches has been proven effective and reliable in applications ranging from electronics, transportation, industrial, aerospace, and defense.

## Quick release fasteners

Camloc Quick-Release Fasteners feature 1/4-turn, push-turn, and push-push fastening mechanisms. This provides for an easy-to-install, vibration-resistant joining solution where quick and repetitive attachment and removal of panels is necessary.

### Benefits include:

- Locking and unlocking requires a simple 1/4 turn or a push.
- Can be locked and unlocked in a matter of seconds - saving time and reducing costs.
- Vibration resistant - performs well in the most intensive applications.
- Safe and easy to use.
- A range of fastener styles and sizes.

### 1/4 Turn



### Push-Turn



### Push-Push



Series	Max.Tensile Strength	Slotted Recess Head	Cross Recess Head	Hex Head Slotted Recess	Hex Head Recess	Fixed Wing Head	Offset Fixed Wing Head	Folding Bail Handle	Star Formed Head	Wing Head	Square Head	Knurled Head	Triangular Head	Folding Wing Head	Push Button Head
5F	494	•	•												
99F	516	•													
2600	981	•	•			•			•	•		•	•		
2700	981	•	•		•										
50F	2729	•	•	•	•	•	•								
4002	3467	•	•		•	•		•							
991F	7376			•	•	•	•	•						•	
715F	516	•			•	•	•						•		
716F	1033	•											•		
720F	885	•	•								•				
15F	981														•

## Draw latches

Draw latches from Camloc provide an adjustable, high-performance method ideal for securing machine and equipment parts that must be opened or removed frequently.

### Benefits include:

- Easy locking and unlocking – simply dip / undip the handle.
- Excellent tensile load carrying capacity – reducing the number of fasteners required.
- Tolerance adjustments through draw-hook mechanism – allows for variations in latch and strike proximity.
- Also available with secondary locking mechanism – increasing vibration resistance.



V934L series



V95L series



V96L series



1429L series



V951L series



V917L series



V18L series

Series	Max.Tensile Strength (lbs)	Without Secondary Lock	With Secondary Lock	With Hasp	For Riveting Or Screwing	For Welding	Adjustable Drawhook
V934L	406	•	•		•		
V95L	162	•			•		
V96L	738	•			•		
1429L	1106	•	•		•		
V951L	1696	•	•	•	•	•	•
V917L	2655	•	•	•	•	•	•
V18L	4425	•	•	•	•	•	•
V46L	3245	•			•	•	•

## Customized Solutions

Camloc's experienced design team has the capability to develop and produce parts according to your requirements. Our dedicated engineering team can adapt existing products or develop customized quick-release fastener and latch solutions to meet diverse and constantly changing industrial demands.

### Benefits include:

- Ability to provide a specialized solution within the required time-frame and budget.
- Rapid response time: from concept to prototype to production.
- An experienced design team dedicated to the development of specialized parts.



# Alcoa Fastening Systems & Rings



For more than 120 years, the name Alcoa has been recognized worldwide as a strong leader in product quality and customer support. These strengths are found in every product manufactured for Alcoa Fastening Systems & Rings, offering the greatest breadth and depth of fastening system solutions in the industry.

Alcoa Fastening Systems & Rings (AFSR) maintains company offices in the United States and in many other countries. AFSR fastener distributors are also located in many of the world's industrial centers, where they provide a ready source of AFSR fasteners, installation tools, tool parts, and application assistance.

## Americas

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