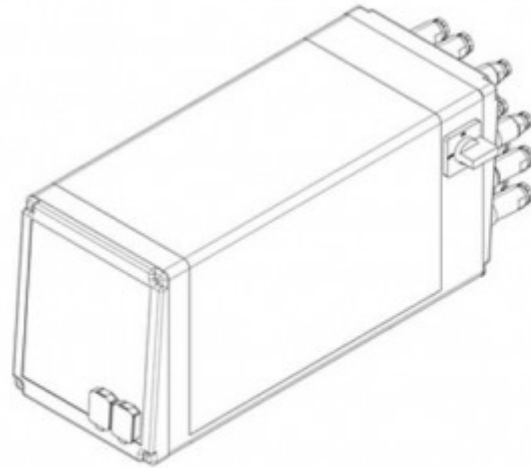


ENE 20  
HPP-25



## Data sheet ENE-20-HPP

Orbital Riveting Unit

Rivet shank Ø: up to 6 mm | Force: up to 20.00 kN | Stroke: up to 40 mm

## Key features | Content of delivery

### ENE-20-HPP Orbital Riveting Unit

#### Forming process: Orbital

#### Standard Version

- Nominal force 20 kN @ 6 bar (max. operating pressure)
  - Rivet shaft up to Ø 13 mm (Steel 370 N/mm<sup>2</sup>)
  - Spindle stroke 5 - 40 mm with 0.01mm micrometer scale and mechanical stroke limit
  - Machine weight: approx. 122 kg
  - Electro-pneumatic drive - power supply @x@V, @Hz
  - Permanently lubricated spindle
  - head angle 5° for tool length L<sub>s</sub>= 84 mm, free height 28 mm
- or
- head angle 3° for tool length L<sub>s</sub>= 116 mm, free height 60 mm (specify when ordering)
  - Color: light grey RAL 7035

#### Including

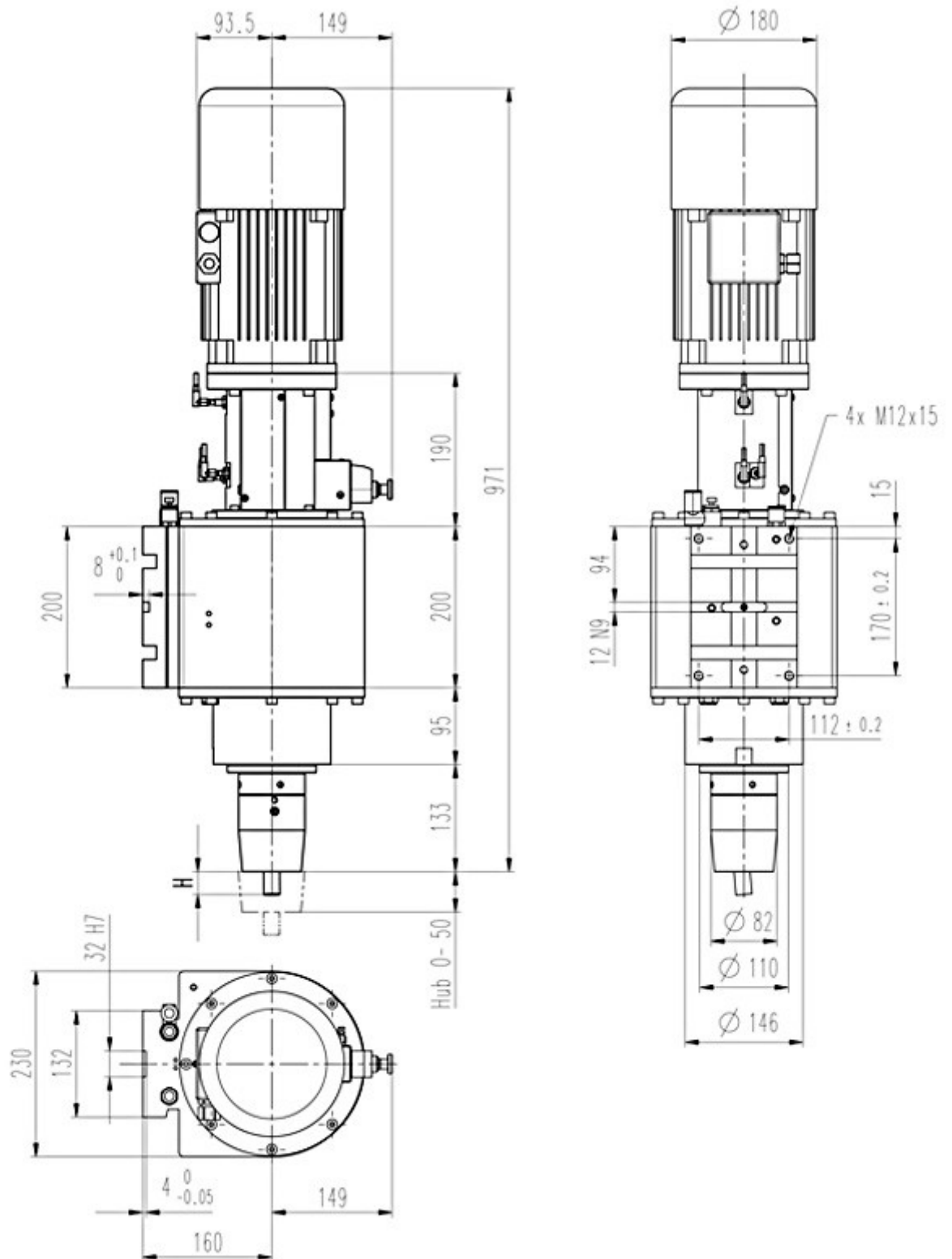
- HPP-010-281, Process-Control HPP-25, connections X1, X2, X3, X20, X21
- Incl. SEI-100-281, Distance sensor, Type HPP-25
- Incl. SEI-200-281, Pressure sensors, Type HPP-25
- HPP-X4-02, Connection X4, for emergency-stop, w/out two-hand relay
- HPP-X6-01, Connection X6, external safety / reset
- HPP-X9-01, Connection X9, PLC interface with cable, 5m
- HPP-045-03, Sensor cable extension 3 m, total length 4 m
- FN-042, Sensor upper spindle position (TDC)
- PNP-HPP-281, Pneumatic service unit and pneumatic control package for HPP
- Standard accessories and user manual in the language of destination

#### Options

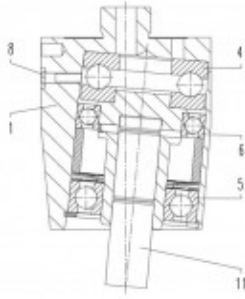
- HPP-X5-01, Connection X5 PVM Module (for control of PNP-PRV-020)
- PNP-PRV-020, Proportional-pressure control, integrated & ready for operation (requires HPP-X5-01)
- HPP-DLL-S7L-x, HPP-25 - Siemens S7 Communication link (S7LINK).  
License code to be ordered for each HPP control
- HPP-DLL-PCT, PC-Analysis Software HPP-PCTool, incl. UDP Protocol (on USB Stick)

Subject to change.

## Drawing



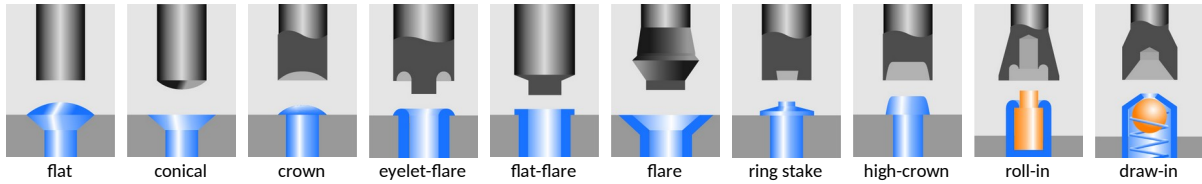
## Forming tool lengths



Radius mm Rp	Tool length mm Ls	Free height mm H	Shank Ø mm Ds	Angle of inclination α
84.00	28.00		10	5°
116.00	60.00		10	3°



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