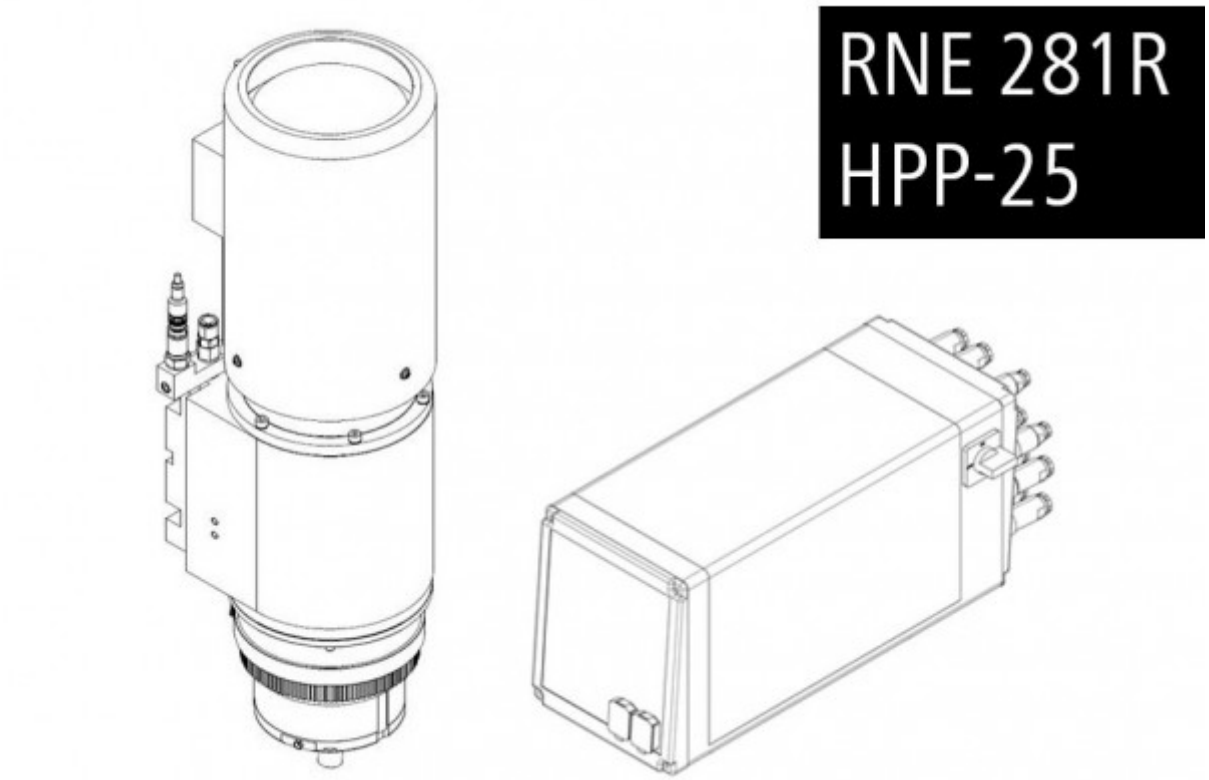
DATA SHEET




# Data sheet RNE281R-HPP

## Riveting Unit

Rivet shank Ø: up to 7 mm | Force: up to 9.50 kN | Stroke: up to 40 mm

BalTec

## Key features | Content of delivery

**RNE281R-HPP Riveting Unit**

**Forming process: Radial**

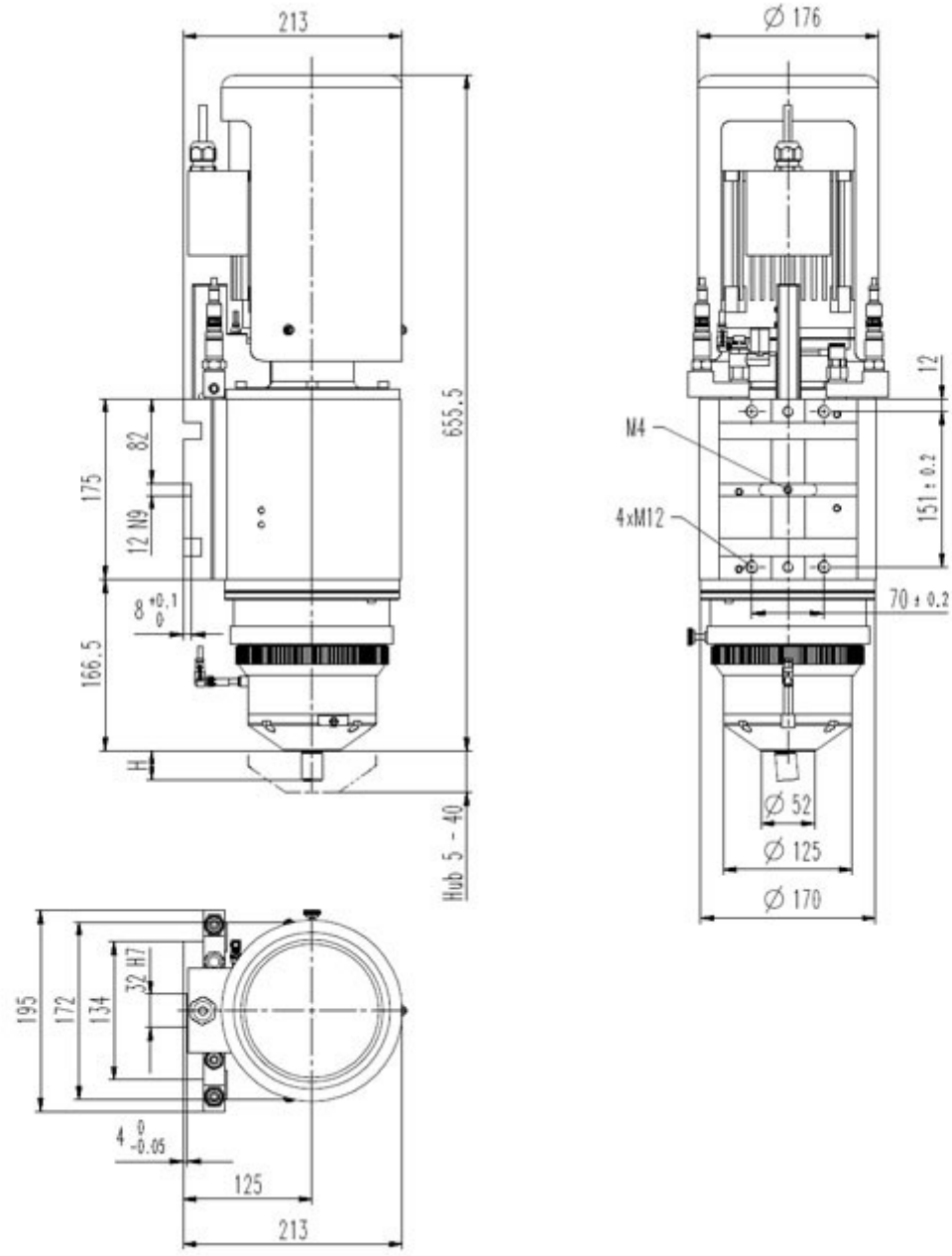
Standard Version
REDUCED FORCE
- Nominal force 9.5 kN @ 6 bar (max. operating pressure)
- Rivet shaft up to Ø 7.5 mm (Steel 370 N/mm2)
- Spindle stroke 5 - 40 mm with 0.01 mm micrometer scale and mechanical stroke limit
- Machine weight: approx. 75 kg
- Electro-pneumatic drive – power supply @x@V, @Hz
- Permanently lubricated spindle
- Pressure cup & tool holder Rp=@ mm for forming tool length Ls=@ mm
- Color: light grey RAL 7035

Including
- HPP-010-281, Process-Control HPP-25 for 281R, connections X1, X2, X3, X20, X21; The measurements of the HPP-25 process control are additionally: (W x H X D in mm) 232 x 243 x 581
- 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
- SEI-OTH-281, Sensor upper spindle home position (TDC)
- PNP-HPP-281R, Pneumatic service unit and pneumatic control package for HPP
- NZ-039, Automatic lubrication with reservoir grease level monitor
- Standard accessories and user manual in the language of destination

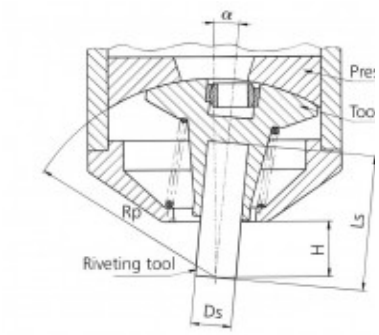
Options
- HPP-X5-01, Connection X5 PVM Module in HPP (for control of PNP-PRV-020)
- PNP-PRV-020, Proportional-Pressure control integrated & ready for operation (requires HPP-X5-01)
- NHE-MYC-U-02, Rivet base detection device NHE-U
- NHE-MST-xxx, RBD lever and touch sleeve (@)
- HPP-DLL-S7L-x, HPP-25 – 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**


213
655.5
175
82
12 N9
8 +0.1 0
166.5
H
Hub 5 - 40
Ø 176
12
M4
4xM12
151 ± 0.2
70 ± 0.2
Ø 52
Ø 125
Ø 170
195
172
134
32 H7
4 0 -0.05
125
213

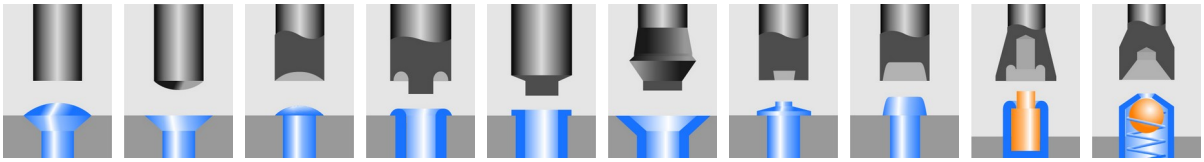
## Długość narzędzia formującego




| Promień mm Rp | Długość narzędzia mm Ls | Swo-bodna wysokość mm H | Średnica nitu Ø mm Ds | Angle of inclination α |
|---|---|---|---|---|
| 100.00 | 68.00 | 28.00 | 10 | 5° 37' |
| 116.00 | 84.00 | 44.00 | 10 | 4° 47' |
| 132.00 | 100.00 | 60.00 | 10 | 4° 10' |
| 148.00 | 116.00 | 76.00 | 10 | 3° 41' |
| 170.00 | 135.00 | 98.00 | 10 | 3° 10' |
| 191.00 | 159.00 | 119.00 | 10 | 2° 49' |
| 240.00 | 208.00 | 168.00 | 10 | 2° 13' |

## Profile narzędzi formujących

Złożone wymagania projektowe dla nowych zastosowań i konstrukcji stanowią wyzwanie dla naszych inżynierów każdego dnia. W technice mocowań, specyficzna forma może stanowić różnicę między sukcesem a porażką. Chętnie doradzimy Państwu w doborze odpowiedniego narzędzia.



płaski | stożkowy | korona | oczkowy | wklęsły-płaski | kloszowy | pierścieniowy | wysoka korona | wewnętrzne | zewnętrzne

## Branże i zastosowania

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United Kingdom

BalTec France
France

BalTec Corporation
USA / Canada / Mexico

BalTec do Brasil
Brazil

BalTec Machinery (Shanghai) Ltd.
China

BalTec Italia Srl
Italia