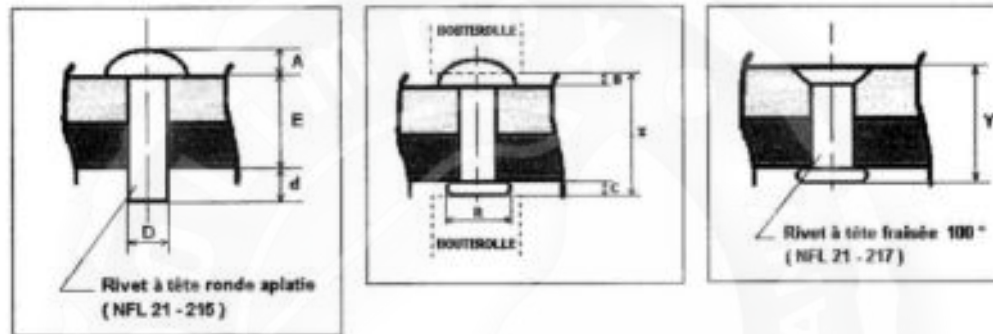


Riveting





FORMULES :

$$d = 1,5 D$$

$$X = E + (B + C)$$

$$Y = E + C$$

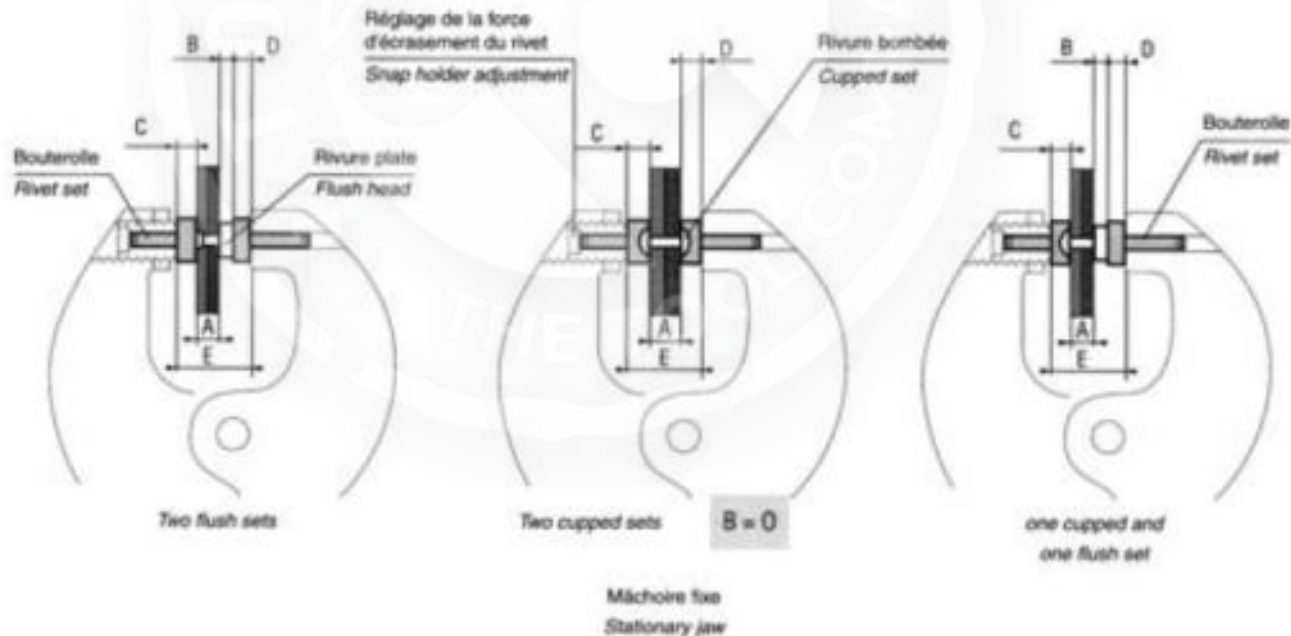
(D)	1,6	2,4	3,2	3,8	4	4,8	5,6	6,4
(A)	0,7	1,05	1,4	1,6	1,7	2,05	2,4	2,75
(R)	2,8 +/- 0,5	4,05 +/- 0,75	5,25 +/- 0,75	5,75 +/- 0,75	6,55 +/- 0,95	7,7 +/- 1	9 +/- 1	10 +/- 1
(C)	0,85 +/- 0,25	1,2 +/- 0,4	1,6 +/- 0,5	1,75 +/- 0,55	1,95 +/- 0,65	2,4 +/- 0,8	2,8 +/- 0,9	3,15 +/- 1,05
(B)	0,2	0,2	0,2		0,2	0,3	0,3	0,3
(B + C)	1,05 +/- 0,25	1,4 +/- 0,4	1,8 +/- 0,5		1,15 +/- 0,65	2,7 +/- 0,8	3,1 +/- 0,9	3,45 +/- 1,05
E mini	0,4	0,8	1	1,2	1,4	1,8	2,3	2,5
Effort (T)	0,4	0,8	1,4	1,8	2,2	3,1	4,2	5,5

• To develop maximum power the riveter must squeeze the rivet near to the end of the riveting stroke. Therefore, the combine length of the two rivets sets must be correct.

• The operator can adjust exactly the position of the rivet by adjusting the snap holder (stroke 5 mm). This allows the operator use the same rivet set for different thicknesses.

Determine the correct length of rivet sets as follows.

- A - épaisseur des éléments à assembler / *component thickness*
- B - épaisseur de la rivure plate / *height of finished rivet head (flush)*
- C - épaisseur de la bouterolle (fixe) / *rivet set height (fixed)*
- D - épaisseur de la bouterolle (mobile) / *rivet set height (mobile)*
- E - ouverture en fin de rivetage (réglage par le support bouterolle) / *closed height dimension of the jaws (adjust by moving the snap holder)*



RIVETING NEEDED FORCE OVERVIEW

Rivet Extra-Lenght = 1,5 x Rivet Ø	Ø RIVET	Ø mm	Ø 1,6	Ø 2,4	Ø 3,2	Ø 3,6	Ø 4	Ø 4,8	Ø 5,6	Ø 6,4	Ø 7	8
	ALU	"C" Hauteur rivure Squezzed Head Thickness	Nominal	0,86 mm	1,2 mm	1,6 mm	1,75 mm	1,95 mm	2,4 mm	2,8 mm	3,15 mm	
Riveting Force		x1000daN	0,4 T	0,8 T	1,4 T	1,8 T	2,2 T	3,1 T	4,2 T	5,5 T	6,5 T	8,5 T

Rivet Extra-Lenght = 1,0 x Rivet Ø	Ø RIVET	mm	Ø 2,4	Ø 3,2	Ø 3,6	Ø 4	Ø 4,8	Ø 5,6
	Titane	"C" Hauteur rivure Squezzed Head Thickness	Nominal		>1,05 mm	>1,2 mm	>1,4 mm	>1,65 mm
Riveting Force		x1000daN		1,4 T	2,5 T	3,2 T	3,9 T	5,6 T

Rivet Extra-Lenght = 0,8 x Rivet Ø	Ø RIVET	mm	Ø 2,4	Ø 3,2	Ø 3,6	Ø 4	Ø 4,8	Ø 5,6
	Steel	"C" Hauteur rivure Squezzed Head Thickness	Nominal	0,78 mm	1,05 mm	1,23 mm	1,4 mm	1,65 mm
Riveting Force		x1000daN	1,2 T	2,1 T	2,6 T	3,2 T	4,6 T	6,8 T

Note : All Rivet Force at Room Temperature

Alligator	RB.40-60	2,6 T
Alligator	RB.40-85	1,8 T
Alligator	RB.43-60	1,4 T
Alligator	RB.44-60	3,0 T
Alligator	RB.44-100	2,8 T
Alligator	RB.44-130	2,2T
C-yoke	RB.41	2,2 T
C-yoke	RB.42	1,4 T
C-yoke	RB.49	3,5 T



PRECISION / PRECISION

- RB 400 → pour rivets tête ronde / for countersink rivets
- RB 401 → pour rivets tête ronde aplatis / for universal head type rivets
- RB 402 → pour rivets tête ronde-tête aplatis / for special reduced universal head rivets

Sur demande, nous réalisons aussi des sets de 4,8 / 20 pour les squeezer avec un 210° d'angle.

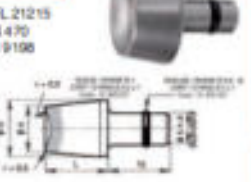
RB 400 → Code / Code number: 80702
 RB 401 → Code / Code number: 80712
 RB 402 → Code / Code number: 80722

RB 400



Ø Rivet / Rivet Dia	1,8 & 2,4 1/8" & 3/32"	3,2 & 3,5 1/8" & 9/64"	4 5/32"	4,8 9/32"	5,6 & 6,4 7/32" & 1/4"	
Ø	2 D	7 9	9 14	10 14	12 16	
L	4 7 10 12,5 16 20	6070305 6070306 6070340 6070325 6070375 6070395	6070306 6070305 6070345 6070340 6070375 6070395	6070345 6070320 6070355 6070355 6070375 6070395	6070355 6070360 6070360 6070365 6070365 6070365	6070365 6070365 6070365 6070365 6070365 6070365
L	4 7	6070305 6070320	RB 40-13-30 Group Ø 4 Uniquement Shank & die only (8797)			

RB 401



NFL 21215
AN 470
LN 9190

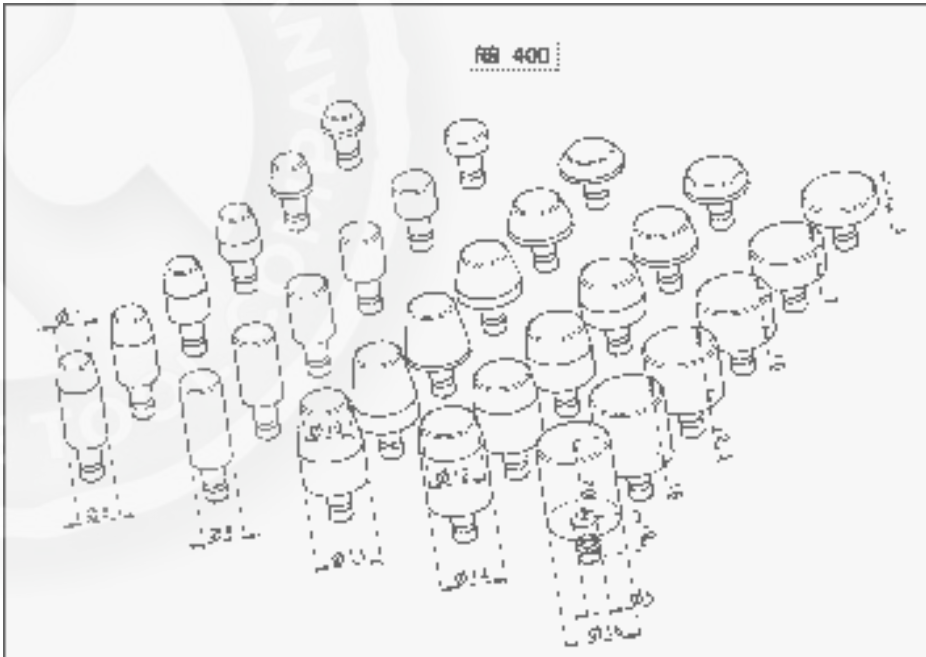
Ø Rivet / Rivet Dia	2,4 3/32"	3,2 1/8"	4 5/32"	4,8 3/16"	5,6 7/32"	6,4 1/4"
Ø	2 D	7 9	9 14	10 14	12 14	16
L	4 7 10 12,5 16 20	6071305 6071306 6071340 6071325 6071375 6071395	6071306 6071305 6071345 6071340 6071375 6071395	6071345 6071320 6071355 6071355 6071375 6071395	6071355 6071360 6071360 6071365 6071365 6071365	6071365 6071370 6071370 6071375 6071375 6071375
L	4 7	6071105 6071120	RB 40-13-30 Group Ø 4 Uniquement Shank & die only (1575)			

RB 402

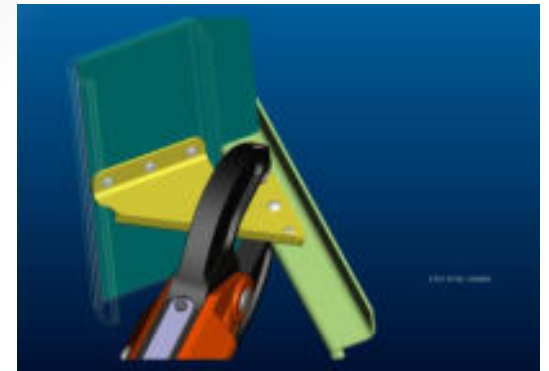
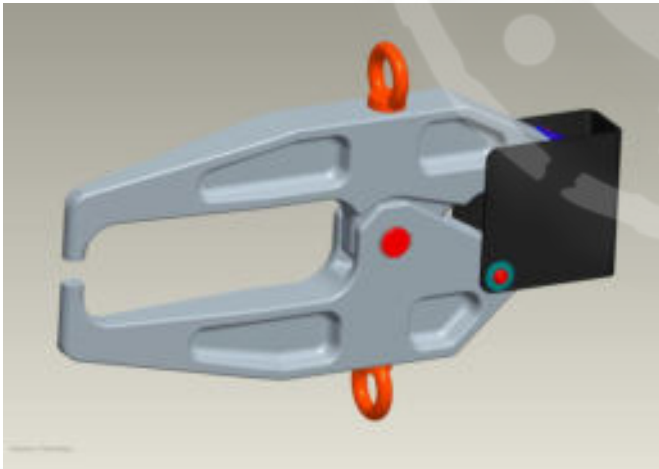
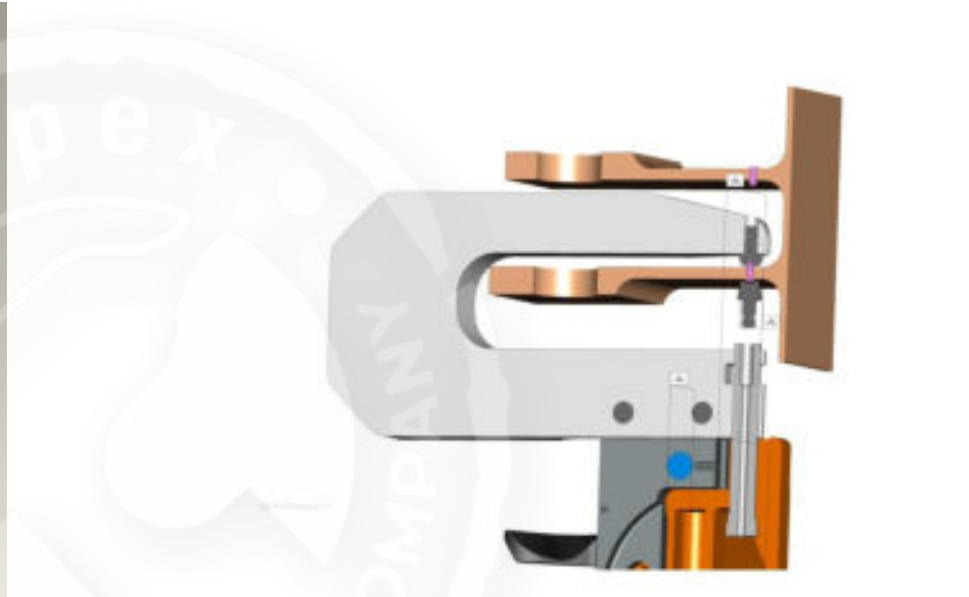
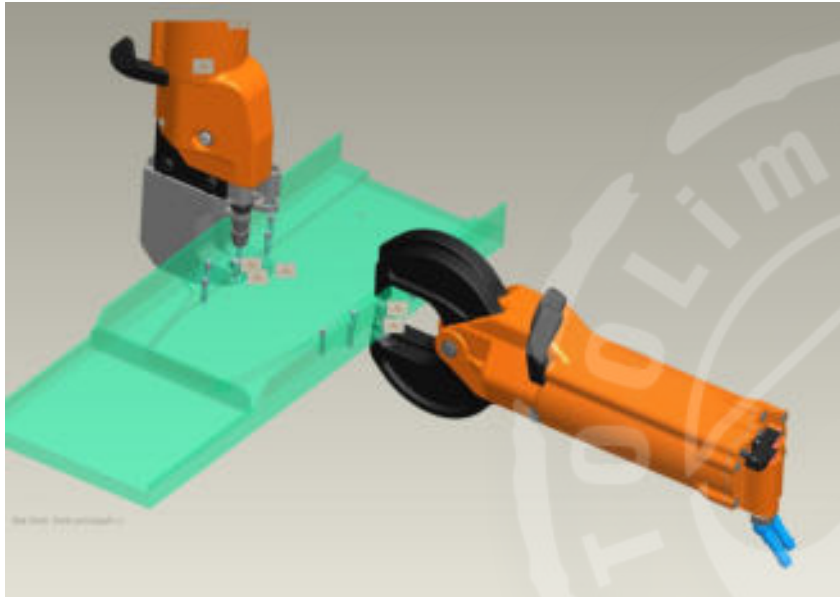


NSA 5411 - Thane
NSA 5415 - Monel

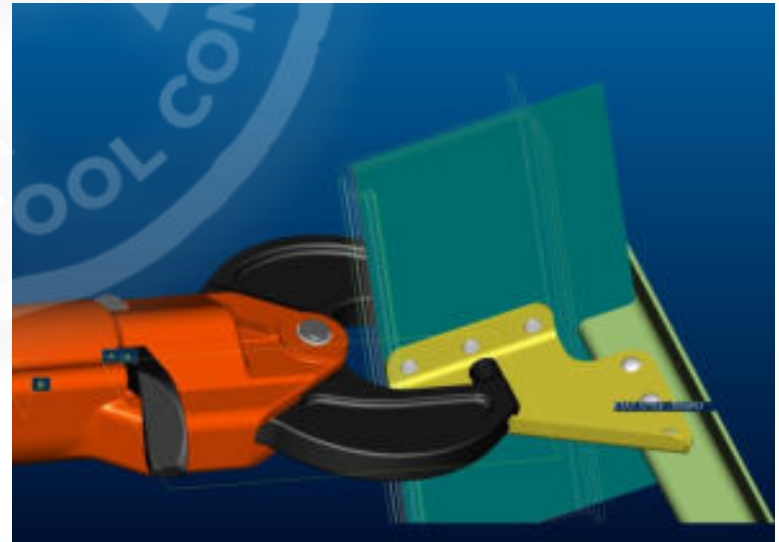
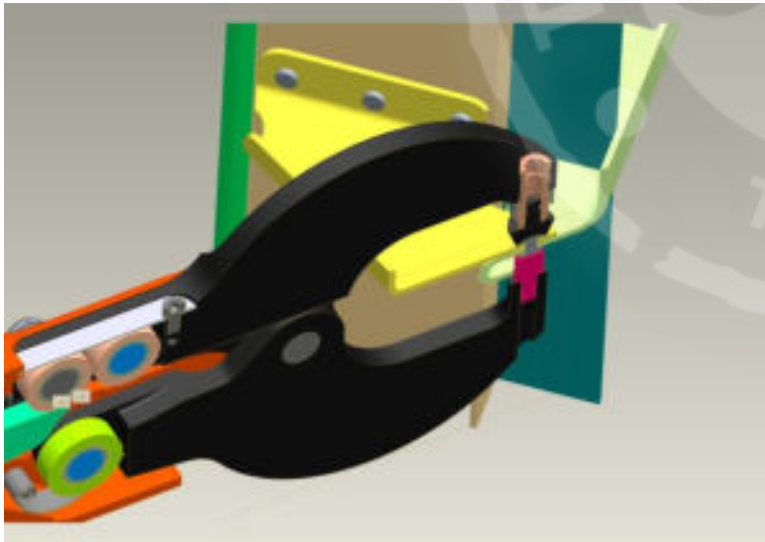
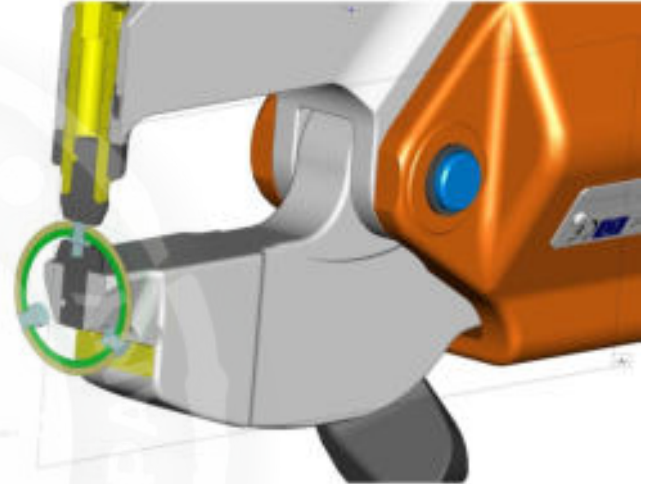
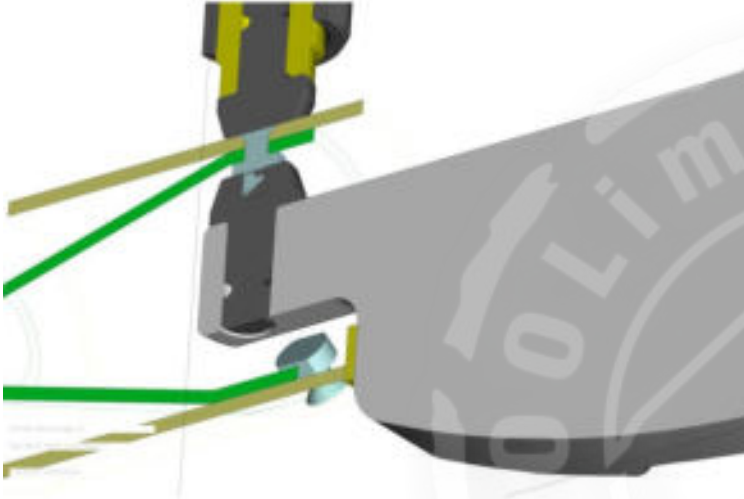
Ø Rivet / Rivet Dia	2,4 3/32"	3,2 1/8"	3,8 3/16"	4 5/32"	4,8 3/16"	5,6 7/32"
Ø	2 D	7 9	9 9	10 14	12 14	14
L	4 7 10 12,5 16 20	6072305 6072305 6072340 6072325 6072375 6072395	6072305 6072305 6072340 6072340 6072375 6072395	6072345 6072340 6072340 6072345 6072375 6072395	6072355 6072360 6072360 6072365 6072365 6072365	6072365 6072365 6072365 6072365 6072365 6072365



Examples of Riveting Projects



Examples of Riveting Projects

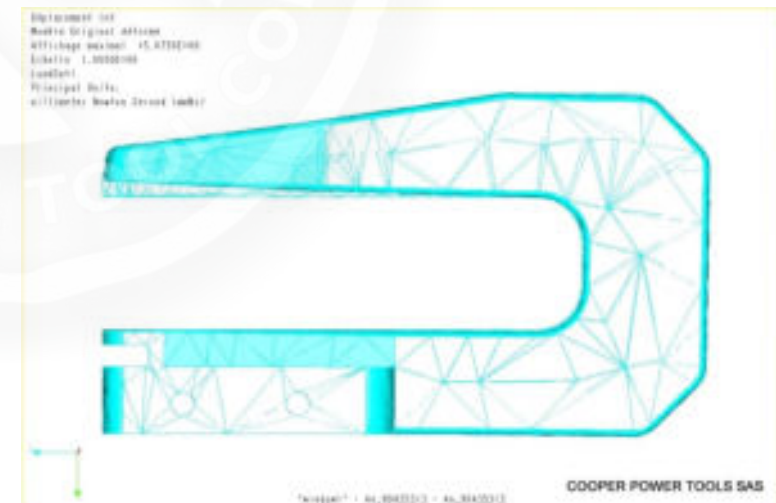
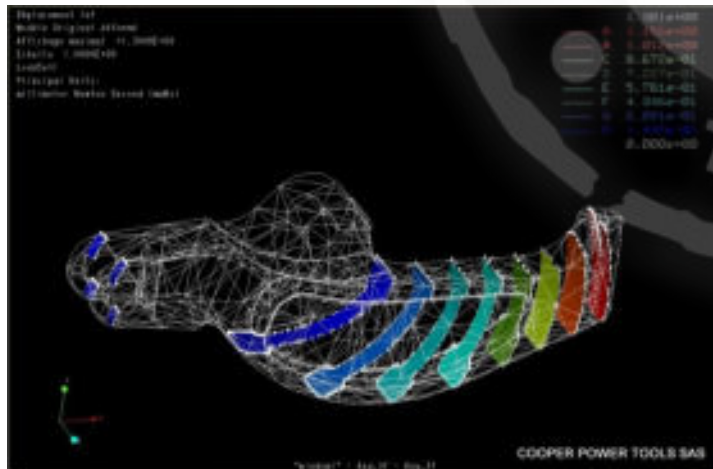
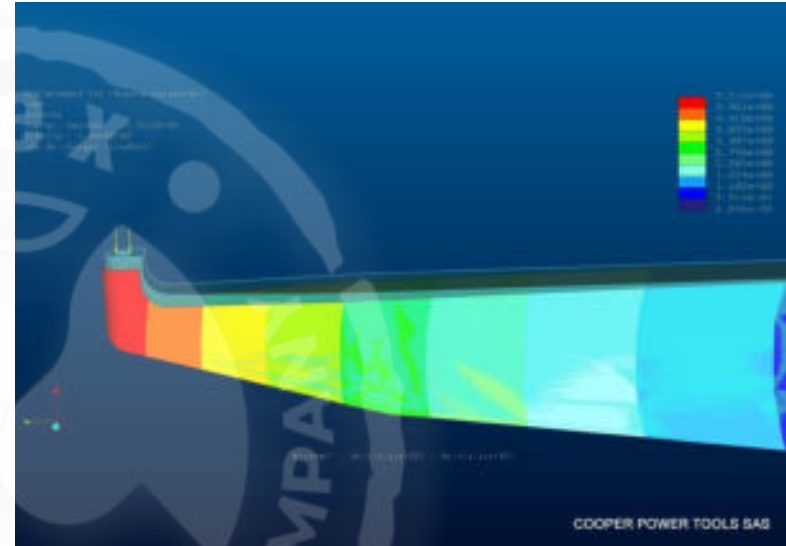
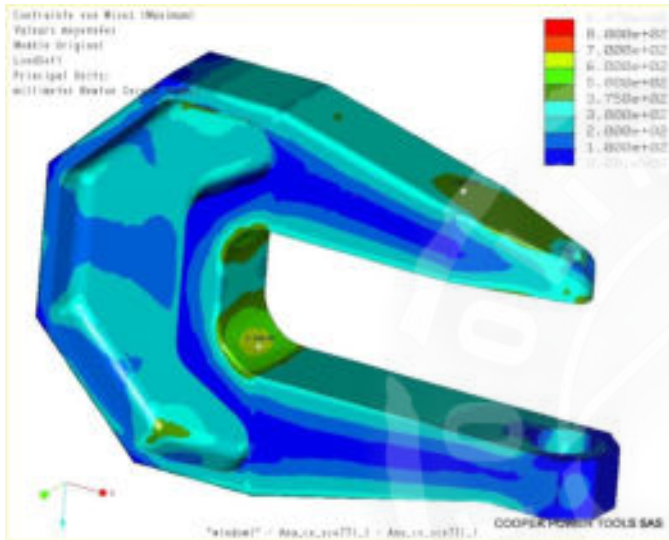


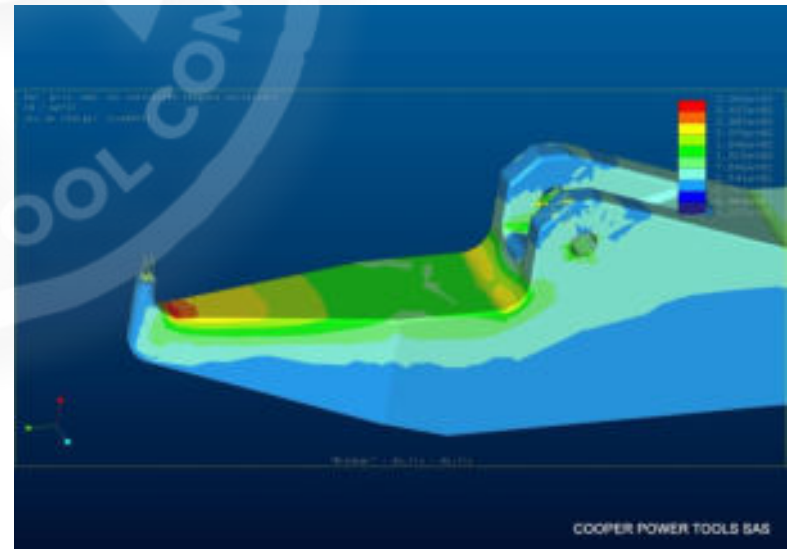
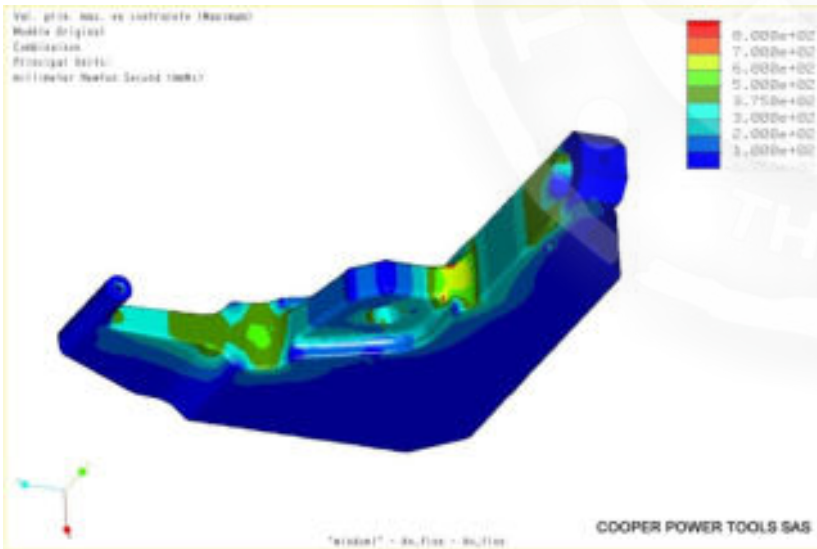
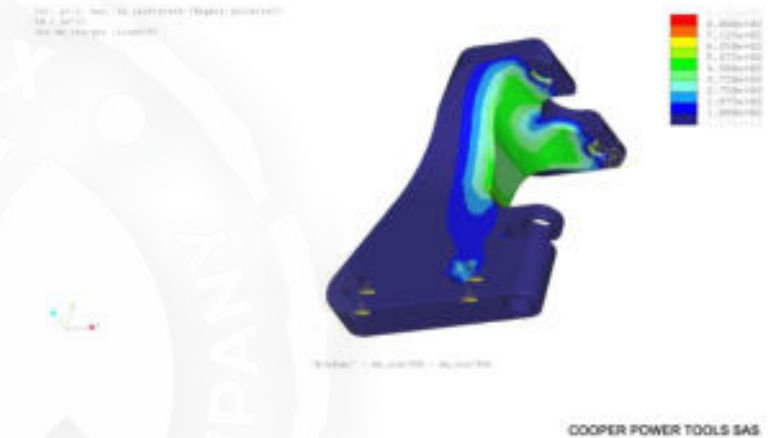
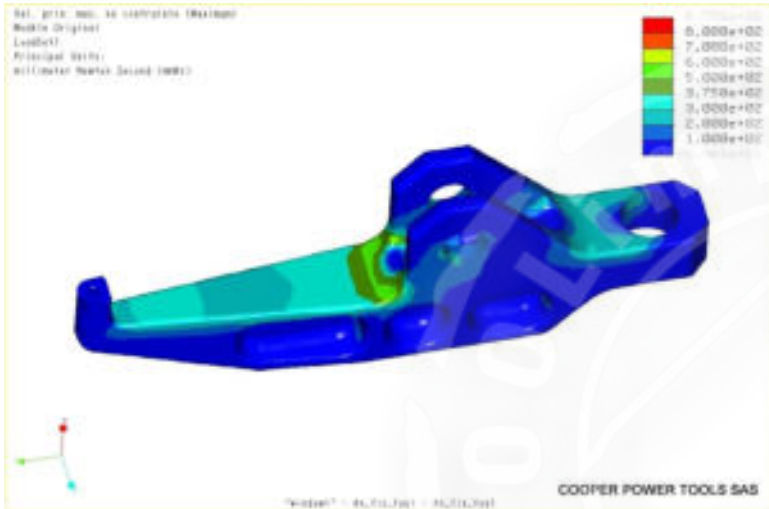
Examples of Riveting Projects



Examples of Riveting Projects







FEA analysis: promechanica

CATIA V5: Possible to convert or to provide files for CATIA V5

3D Printer for mockups and preliminary tests capability

