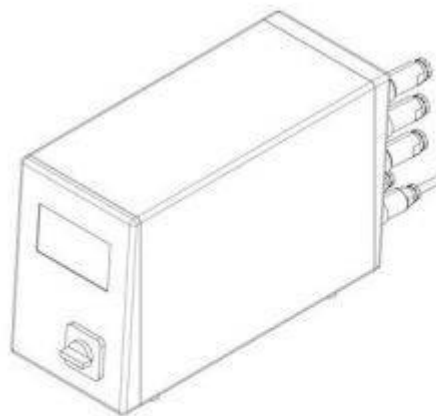


EN 20R  
HPP-25



## Data sheet EN-20R-HPP

Orbital Bench Top Riveting Machine

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

## Key features | Content of delivery

### Forming process: Orbital

#### 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/mm<sup>2</sup>)
- Spindle stroke 5 - 40 mm with 0.01mm micrometer scale and mechanical stroke limit
- Machine weight: approx. 220 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)
- BFR-RN-281, Column, incl. height adjustment and table
- Color: light grey RAL 7035

#### Including

- HPP-010-281, Process-Control HPP-25, connections X1, X2, X3, X20, X21
- Incl. SEI-010, Pressure sensors, Type HPP-25
- Incl. SEI-100-281, Distance sensor, Type HPP-25
- HPP-X4-01, Connection X4, incl. two-hand relays, for two-hand control and emergency-stop
- NSL-2HD-010, two-hand control via push button)
- FN-042, Sensor upper spindle position (TDC)
- PNP-HPP-281, Pneumatic service unit, including pressure regulator, filter, lubricator and pneumatic valve package for HPP
- NZ-201, Adjustable task light, 24 VDC, LED
- Standard accessories and user manual in the language of destination

#### Options

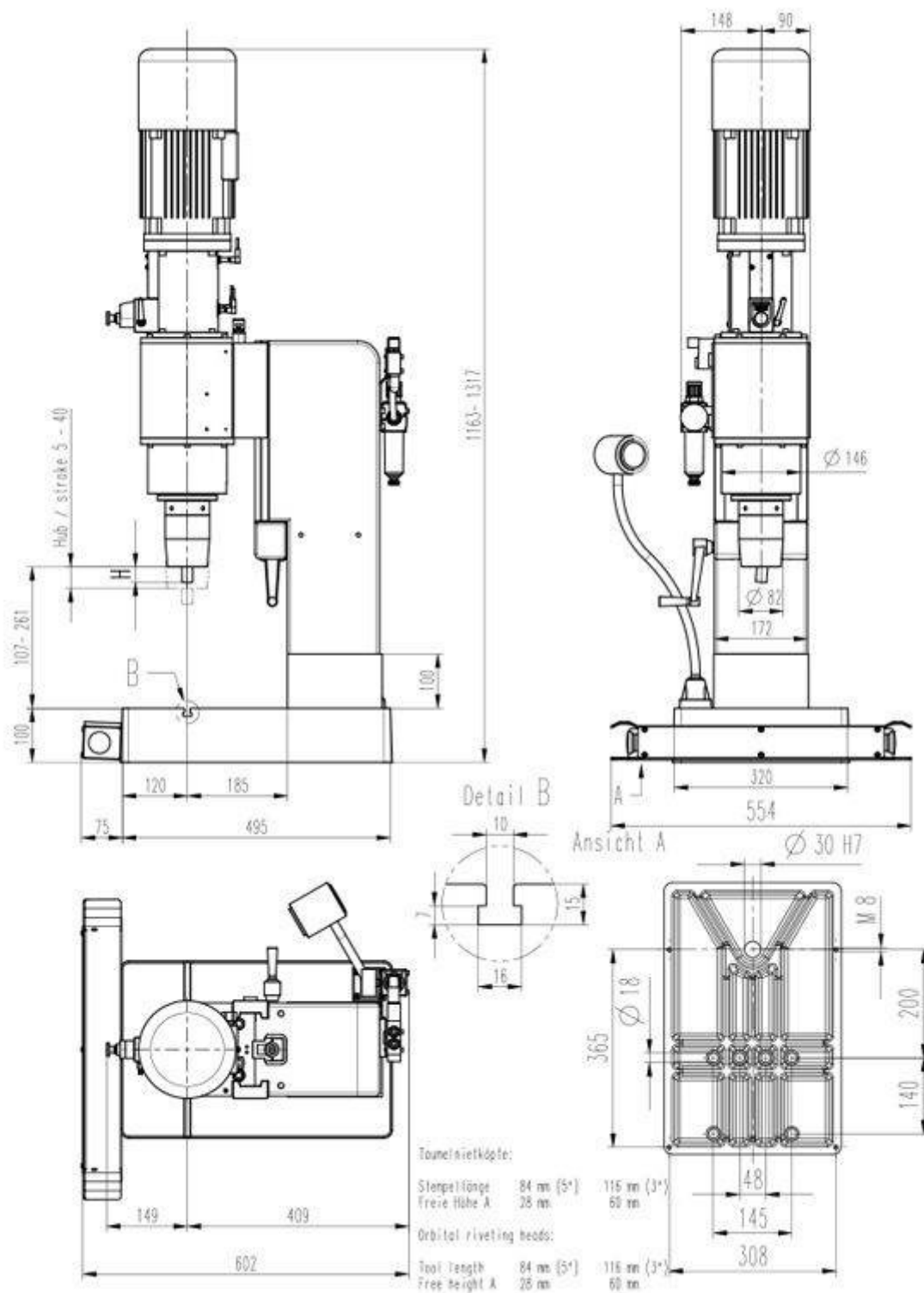
- NSL-2HD-011, Emergency-Stop (push button) for two-hand control
- HPP-X5-01, Connection X5 PVM Module (for control of PNP-PRV-020)
- PNP-PRV-020, Proportional-pressure control, integrated & ready for operation (requires HPP-X5-01)
- HPP-X6-01, Connection X6, external safety / Reset
- HPP-DLL-S7L-x, HPP-25 – Siemens S7 Communication link (S7LINK).

License code to be ordered for each HPP control

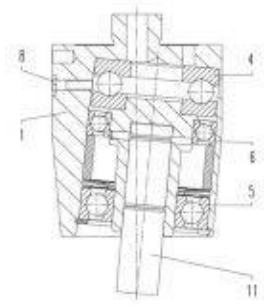
- HPP-DLL-PCT, PC-Analysis Software HPP-PCTool, incl. UDP Protocol (on USB Stick)

Subject to change.

## Drawing



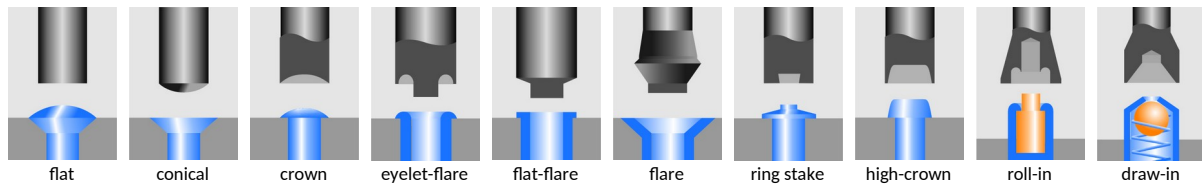
## Forming tool lengths



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



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