



Product photo not binding

Data sheet MRX 1

Multiple riveting head MRX 1

Radial | for RN/RNE 081, 151, 181, 181R, 231, 231R

Introduction | Applications/Limitations

Multiple riveting head MRX 1 for RN/RNE 081, 151, 181/R, 231/R

Forming process: Radial

Introduction

The multiple riveting head is applied where several rivets are to be formed within a certain area simultaneously. The multiple riveting head is therefore provided with 2 or more form tools. The multiple riveting head is fitted in place of the cap on the riveting unit. Pressure cup, form tool holder and pressure spring of the riveting unit are no longer necessary.

Applications/Limitations

Basically, different bearing and guide plates are used for the various rivet patterns.

It is possible to accommodate several rivet patterns in one and the same multiple riveting head so that, by changing the form tool, different parts can be riveted.

With the aid of the multiple riveting head (with certain limitations), riveting at different heights is possible.

The variations given above, however, require more precise clarification (forces, available space).

To provide such clarification, we require a sample for assessment or for riveting trials.

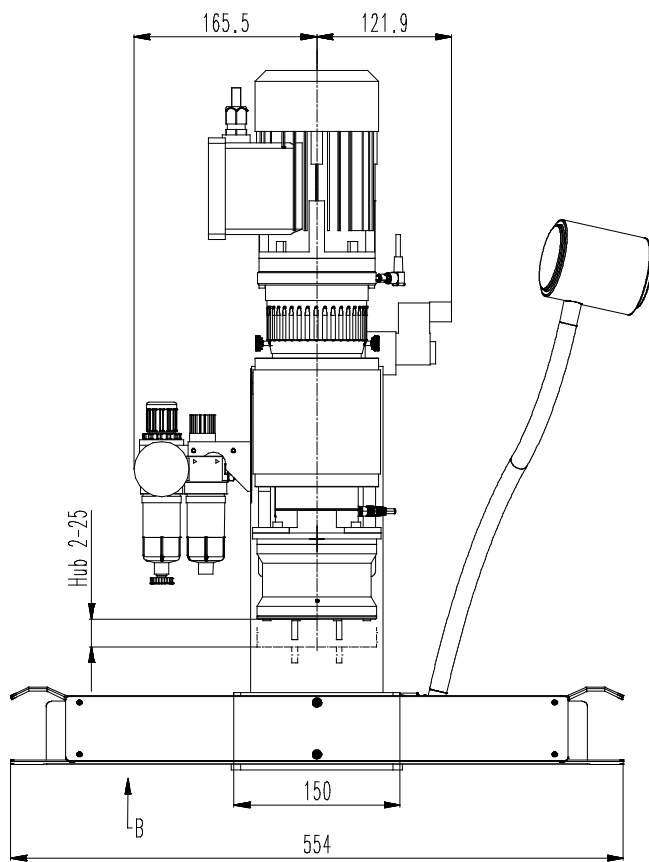
Utilization of the multiple riveting heads is subject to the following limitations:

- The riveting unit's available force is divided into the number of rivet positions
- Process monitoring is not useful and is not offered
- One sided load is to be avoided as these could result in a side load on the riveting head (see chapter "Riveting position area multiple riveting head")
- Forming a single rivet is to be avoided

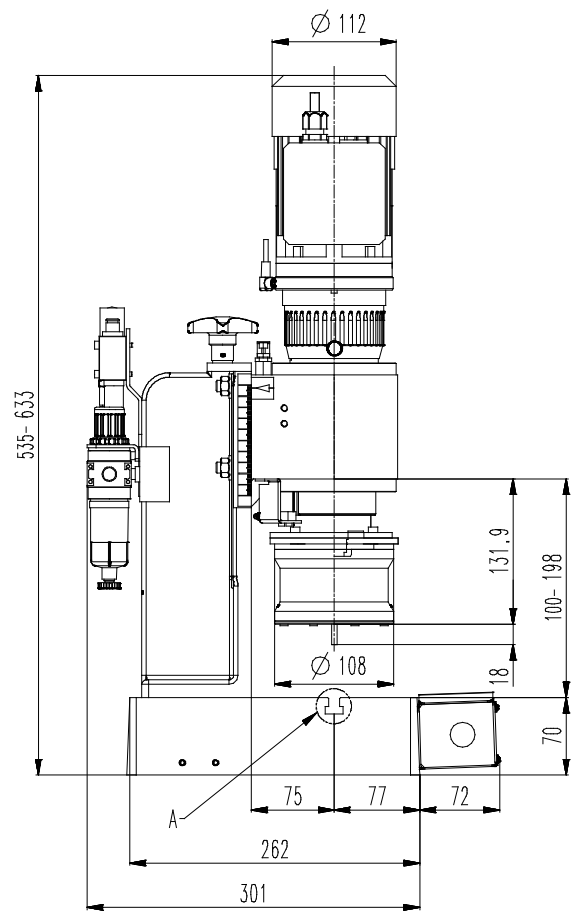
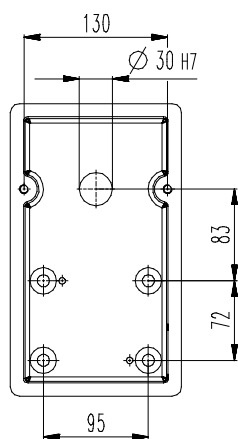
Technical data

- Max. riveting force per form tool: 6 kN
- Unlimited diameter: Ø 60 mm
- Minimum and maximum distances
Min. distance between 2 points: 8.0 mm
Max. distance between 2 points: 70 mm
- Form tool Ø: 5 mm
- Tool radius, length: Rp 40, Ls 40.
Others available on request.
- Angle: 4° 17'
- Free height: 18.0 mm
- Max. head diameter for form tool with flat or high crowned profile: 3 mm
- Exterior Ø housing: 116 mm
- Exterior Ø in operation
(with movement of housing): 120.5 mm
- Weight: 3.5 kg

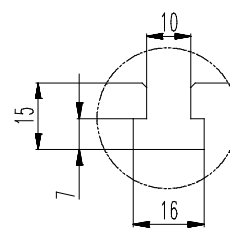
Drawing RN 081-MRX 1 – 814300.01



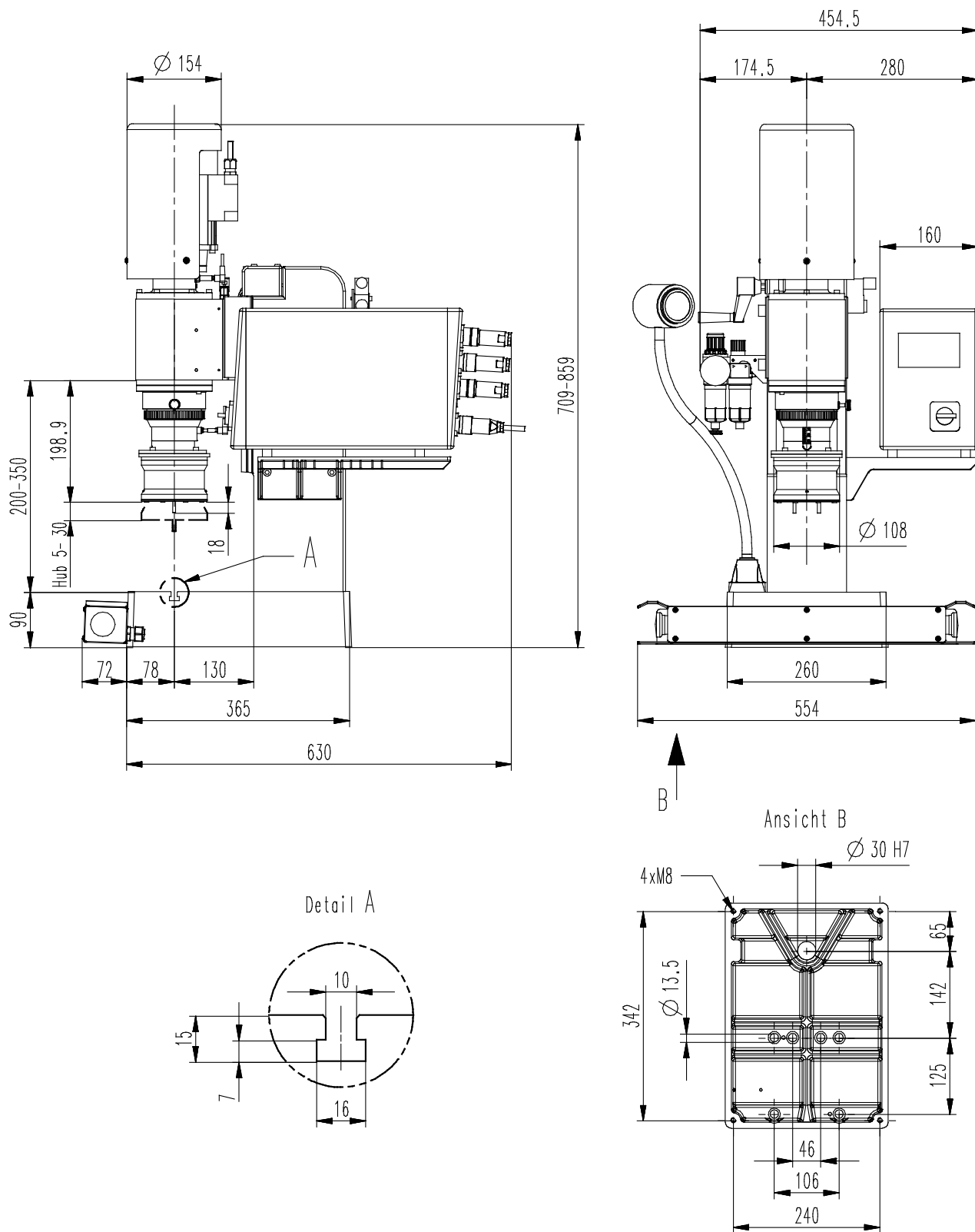
Ansicht B



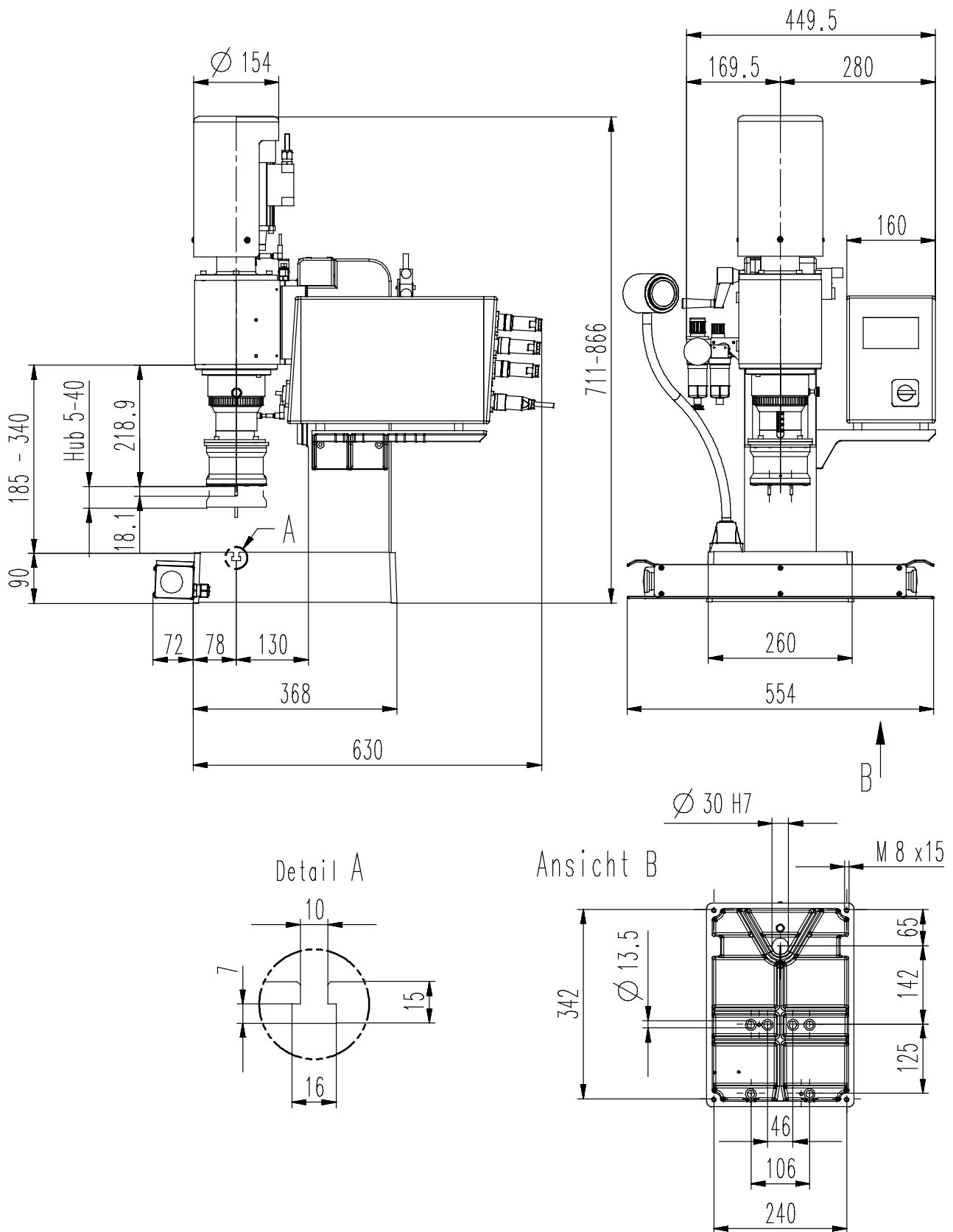
Detail A



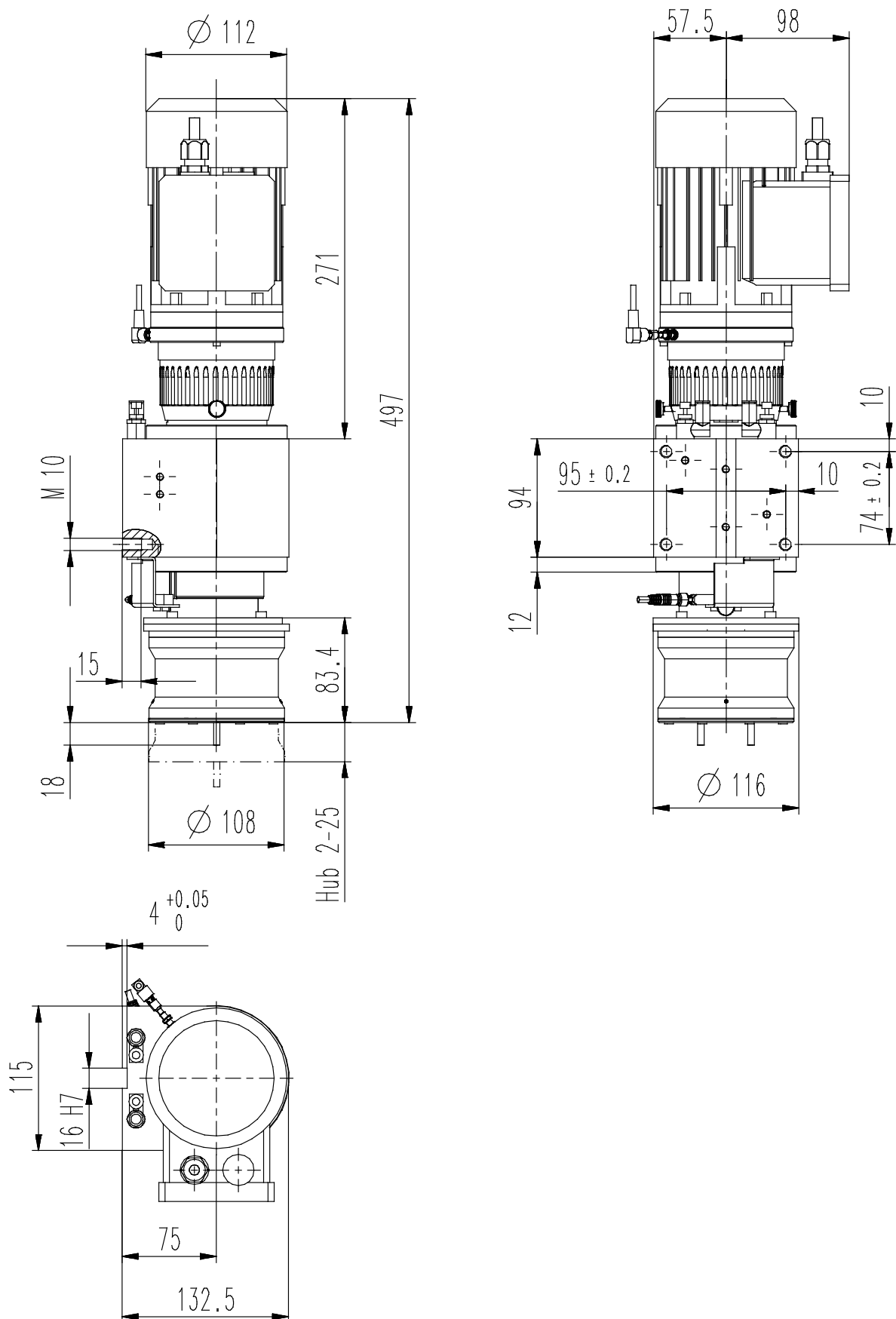
Drawing RN 151, 181/R-MRX 1 – 825300.36



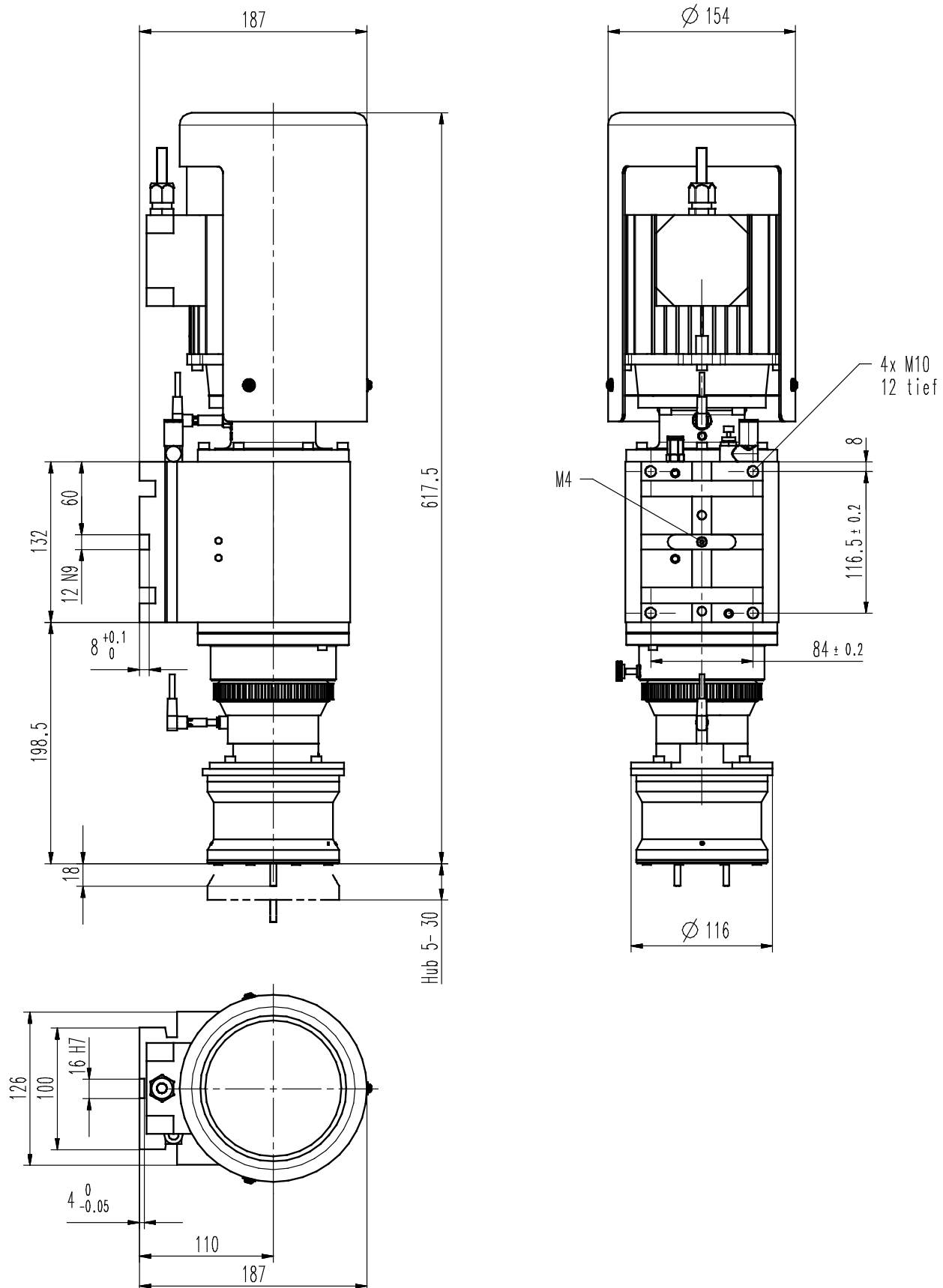
Drawing RN 231/R-MRX 1 – 826300.37



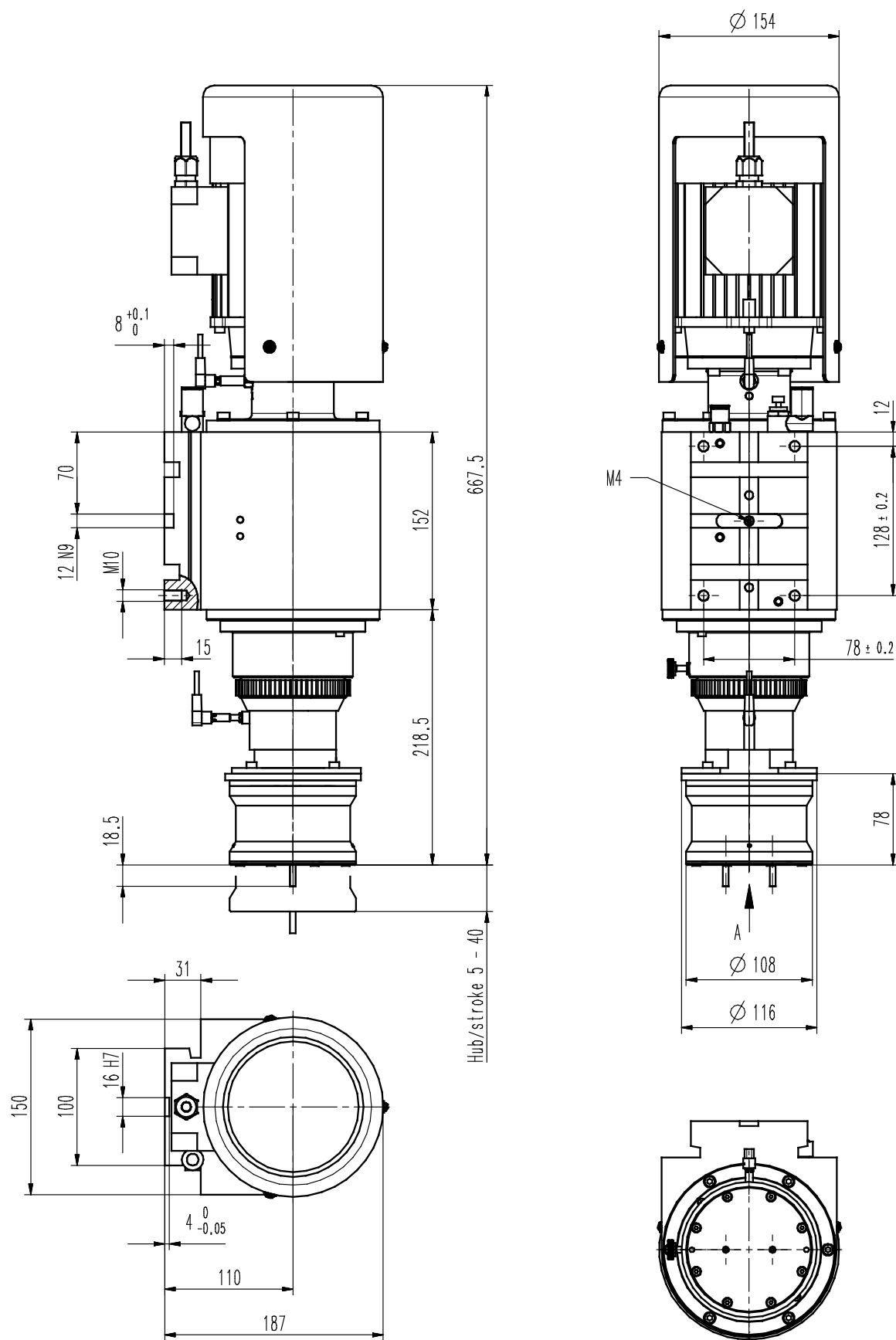
Drawing RNE 081-MRX 1 – 814400.01



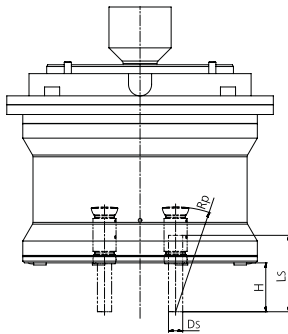
Drawing RNE 151, 181/R-MRX 1 – 825400.31



Drawing RNE 231-MRX 1 – 826400.31



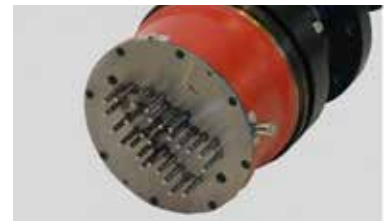
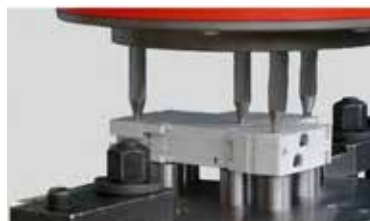
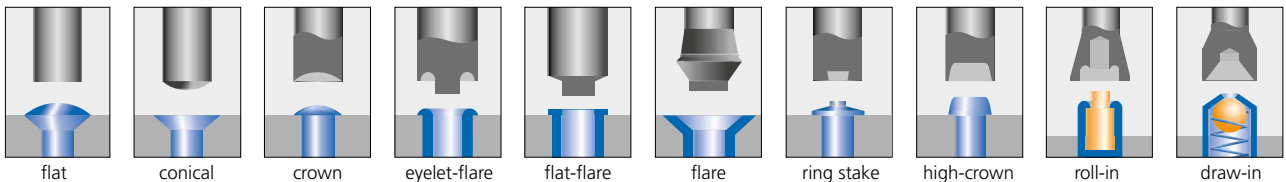
Forming tool dimensions



Radius mm Rp	Tool length mm Ls	Free height mm H	Shank Ø mm Ds	Angle of inclination α
40	40	18	5	4° 17'

Forming tool profile

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