



RND 331
RC-30

Data sheet RND331-RC3

Double Riveting Machine

Rivet shank Ø: up to 16 mm | Force: up to 33.00 kN | Stroke: up to 50 mm

Key features | Content of delivery

Forming process: Radial

Standard Version

- Complete work station
- Two identical RNE 331 riveting units (both riveting units cycle simultaneously)
- Frame to which riveting units are mounted. Distance between riveting heads adjustable
- With riveting units 281 - 331, frame, including floor standing table
- Nominal force 33 kN @ 6 bar (max. operating pressure)
- Rivet shaft up to Ø 16 mm (Steel 370 N/mm²)
- Spindle stroke 5 - 50 mm with 0.01mm micrometer scale and mechanical stroke limit
- Machine weight: approx. 420 kg (Additional weight of the machine table is 145 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

- RC3-010, RC-30 Time Based Control, connections X1, X2, X3, X20, X21, X22. One unit to control both riveting units
- RC3-X4-01, Connection X4, incl. two-hand relays, for Emergency-Stop and two-hand control
- NSL-2HD-010, two-hand control via push button, w/out emergency-stop
- PNP-010-331, Pneumatic service unit, lubrication and control package for RC-30. One unit to control both riveting units
- NZ-201, one adjustable task light, 24 VDC, LED
- Manual grease press (is not supplied with automatic spindle lubrication system)
- Standard accessories and user manual in the language of destination

Options

- RND-050, customized (per application) safety enclosure for CE compliance
- RC3-X5-01, Connection X5, incl. PVM Module
- RC3-X6-01, Connection X6, external safety / Reset
- NZ-039, Automatic spindle lubrication system with lubricant level monitor. One unit to service both riveting units
- NSL-2HD-011, Emergency-Stop (push button) for two-hand control

Subject to change.

The technical drawing includes three main views:

- Front View:** Shows the overall dimensions of the machine. The total width is 1348 mm, with a base width of 940 mm and a central section width of 1100 mm. The total height is 1130 mm. Key components like the motor, pump, and control panel are labeled.
- Side View:** Shows the profile of the machine. The total height is 1576 mm, with a base height of 455 mm. The width of the base is 600 mm, and the distance between the legs is 440 mm. The top section has a width of 841 mm, divided into 480 mm and 350 mm segments.
- Detail Views:**
 - Detail A:** A cross-section view of a component with dimensions 10, 16, 15, and 7.
 - Detail B:** A cross-section view of another component with dimensions 130, 160, 50, 125, and 50.

The model number 7557-1937 is printed at the bottom center of the drawing.

Forming tool lengths



Radius mm Rp	Tool length mm Ls	Free height mm H	Shank Ø mm Ds	Angle of inclination α
100.00	68.00	28.00	20	5° 37'
116.00	84.00	44.00	20	4° 47'
132.00	100.00	60.00	20	4° 10'
148.00	116.00	76.00	20	3° 41'
170.00	138.00	98.00	20	3° 10'
191.00	159.00	119.00	20	2° 49'
240.00	208.00	168.00	20	2° 13'

Forming tool profile



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