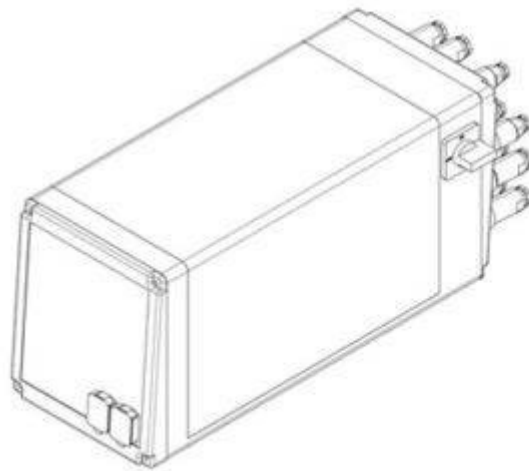


RNE 481  
HPP-25



## Data sheet RNE481-HPP

### Riveting Unit

Rivet shank Ø: up to 30 mm | Force: up to 100.00 kN | Stroke: up to 90 mm

## Key features | Content of delivery

### Forming process: Radial

#### Standard Version

- Nominal force 100 kN @ 145 bar (max. operating pressure)
- Rivet shaft up to Ø 30 mm (Steel 370 N/mm<sup>2</sup>)
- Spindle stroke 5 - 90 mm with 0.01 mm micrometer scale and mechanical stroke limit
- Machine weight: approx. 195 kg
- Hydraulic pack weight: approx. 103 kg
- Electro-hydraulic 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

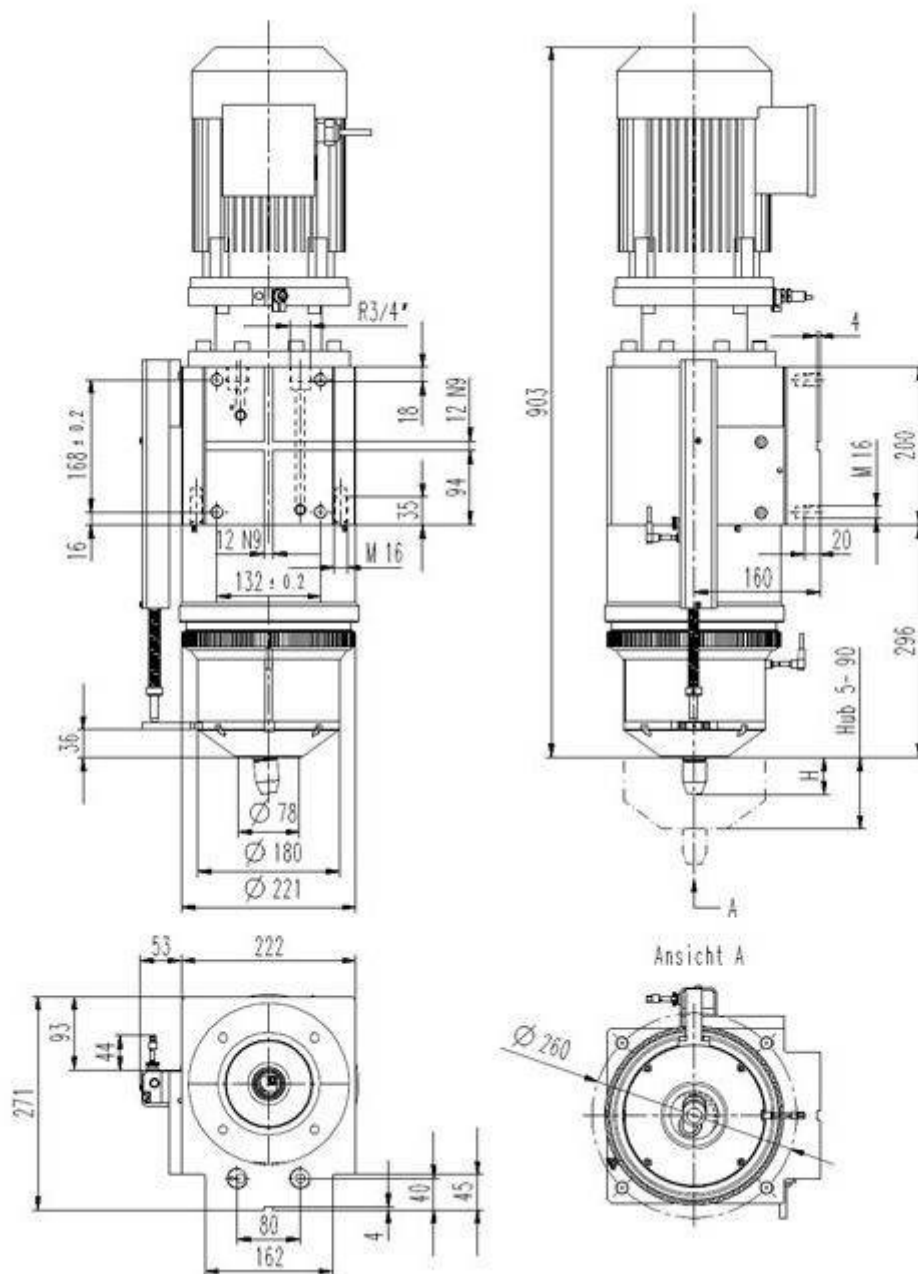
- HPP-010-481, Process-Control HPP-25, connections X1, X2, X3, X20, X21, X22; The measurements of the HPP-25 process control are additionally: (W x H x D in mm) 232 x 243 x 581
- Incl. SEI-100-481, Distance sensor, Type HPP-25
- Incl. SEI-200-481, Pressure sensors, Type HPP-25
- HPP-X4-02, Connection X4, for emergency-stop, w/out two hand relay
- HPP-X5-02, Connection X5 PVM Module (for control of flow valve)
- Proportional flow valve for fast approach/form speed of spindle, integrated in hydraulic unit, ready for operation
- 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-481, Sensor upper spindle position (TDC)
- PNH-010-481, Hydraulic power unit, with oil, pressure regulation on the valve manifold; The measurements are additionally: (W x H x D in mm) 490 x 547 x 349 mm
- NZ-039, Automatic lubrication with reservoir grease level monitor
- Standard accessories and user manual in the language of destination

#### Options

- NHE-BIG-U-02, Rivet base detection device NHE-U
- NHE-MST-xxx, NHE probe arm and probe (@)
- 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

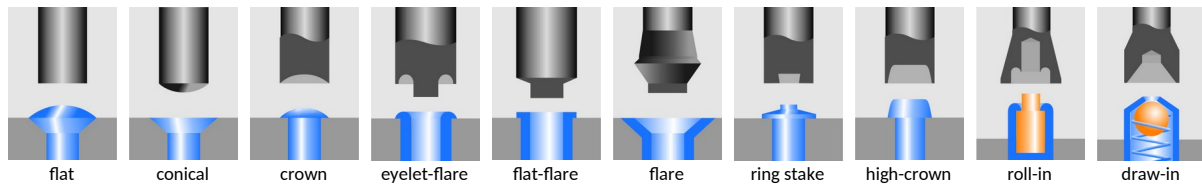


Radius mm Rp	Tool length mm Ls	Free height mm H	Shank Ø mm Ds	Angle of inclination α
148.00	100.00	45.00	30	6° 15'
196.00	148.00	96.00	30	4° 38'
240.00	192.00	137.00	30	3° 45'
290.00	242.00	187.00	30	3° 04'

## Forming tool profile



Our engineers are routinely meeting the demands of complex design problems. Having the specific tools needed for your metal forming project can mean the difference between success and failure. Contact us with your unique application for custom tooling.



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