



Data sheet Process Control HPP-25

Process monitoring and process control
with integrated riveting control

Key features | Content of delivery

Process Control HPP-25

Combinable with all pneumatic and hydraulic BalTec riveting and roller forming units as well as riveting and roller forming machines of the forming processes radial, orbital, roller forming (Exception: Double riveting machines RND, riveting unit RNE 081 and work cells)

Standard version

- Total hardware in semiconductor technology executed
- All connections on the back side via quick disconnect
- 6 different control criteria, 5 counter functions, 63 storable riveting programs
- Up-/Download for parameter and riveting programs
- Download for process data, riveting curves and alarm-history
- Graphical display of riveting force and distance curve
- 45 different riveting modes are possible, including projection measurement and control to closing head height H

Complimentary options

- HPP-X4.01, connection for two hand switch, emergency stop, incl. two hand relay
- HPP-X4.02, connection for emergency stop (w/o two hand control)
- HPP-X5.01*, connection for PVM modul for pressure control valve, output 4-20 mA (for 151-331)
- HPP-X5.02*, connection for PVM, output 0-700 mA (for 481)
- HPP-X6-01, connection for external safety/reset
- HPP-X7.01, connection for sliding table, sensor/actor box, 4 connections, PLC interface, control box
- HPP-X7.02, connection for custom specific functions

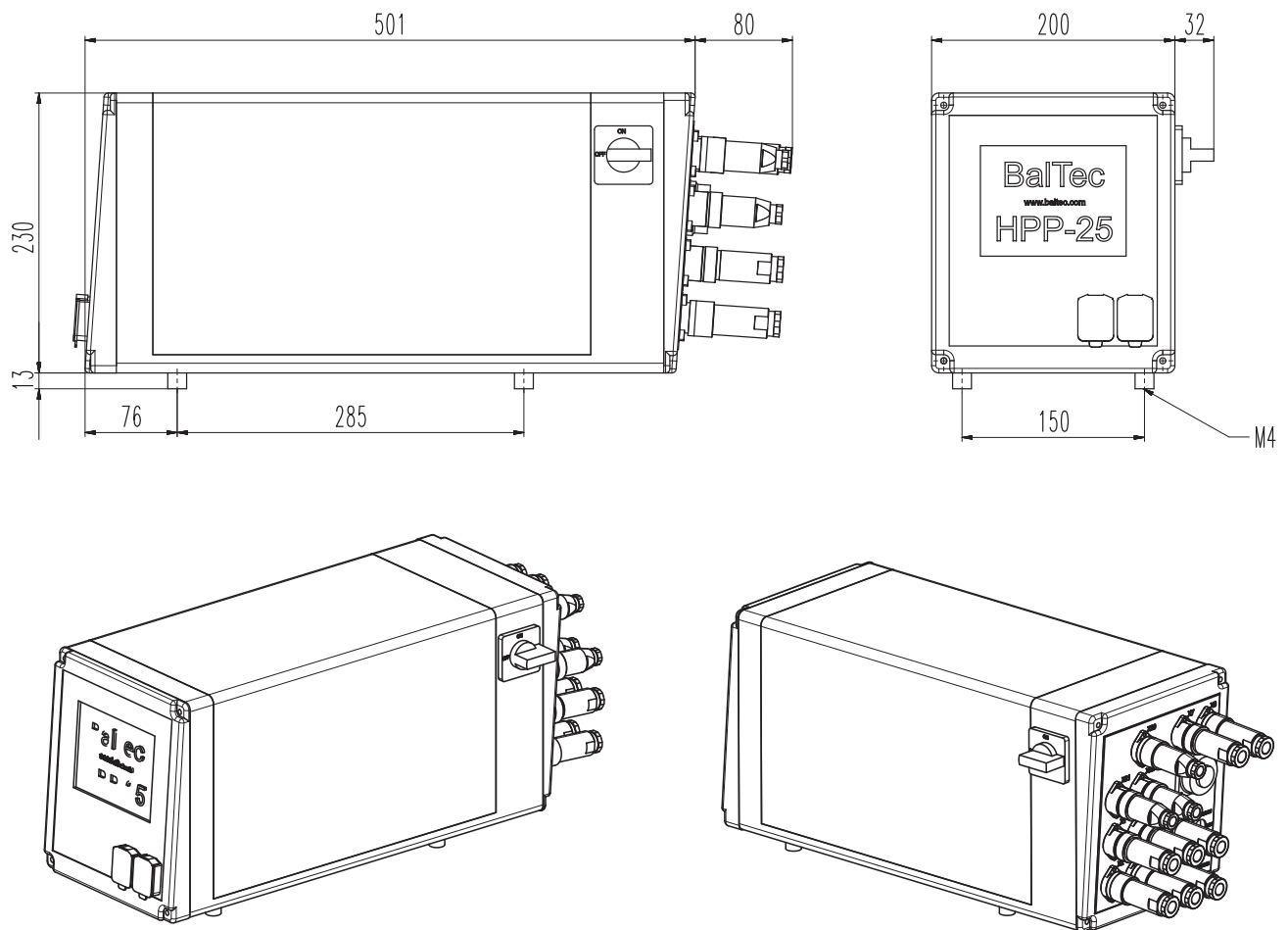
Including

- Mini SD card serves as storage for logger data (<2 GB)
- Distance and force sensor installed (includes X1, X2, X3, X20, X21)
- User manual in the language of destination

- HPP-X9-01, interface to Siemens PLC, incl. X9 jack/plug and cable (5 m) NOT combinable with two hand control
- HPP-090, release code for auto compensation (w/o mechanical components)
- HPP-044, signal light for status OK/NOK (only with HPP-X9-01)
- HPP-045, cable extension set custom length
- HPP-046, ethernet connection on back side instead of front side
- S7 Link (Siemens)

* Proportional pressure valve not included

Drawing HPP-25 – 826337



Technical data

- Design: Sheet metal design with die cast front and rear panels
- Degree of protection: IP53
- Cable entry: All connections via quick disconnect
- Supply voltages: 3 x 160-190 / 200-240 / 320-380 / 380-500 / 500-600 V
1 x 100-120 / 160-190 / 200-240 V
- Interfaces: PLC and ethernet (UDP-Protocol) | S7-Link as option
- Processor: ARM 9
- Display: 5,7" Touchscreen, LED backlit
- Weight: 12 kg

Connection plug assignment (rear panel)

- X1: Valve down/up, sensor TDC

- X2: Release, start (foot switch) take over-sensor

- X3: Grease, work lamp, grease sensor

- X4: Two hand switch, emergency stop

- X5: Pressure/Flow control valve,
rapid/working speed valve, sensor BDC

- X6: External reset and safety circuit

- X7: Depending on execution, see complimentary options

- X8: Depending on execution, see complimentary options

- X9: PLC Interface

- X10: Switch NHE

- X11: Pressure lower chamber

- X12: Pressure upper chamber

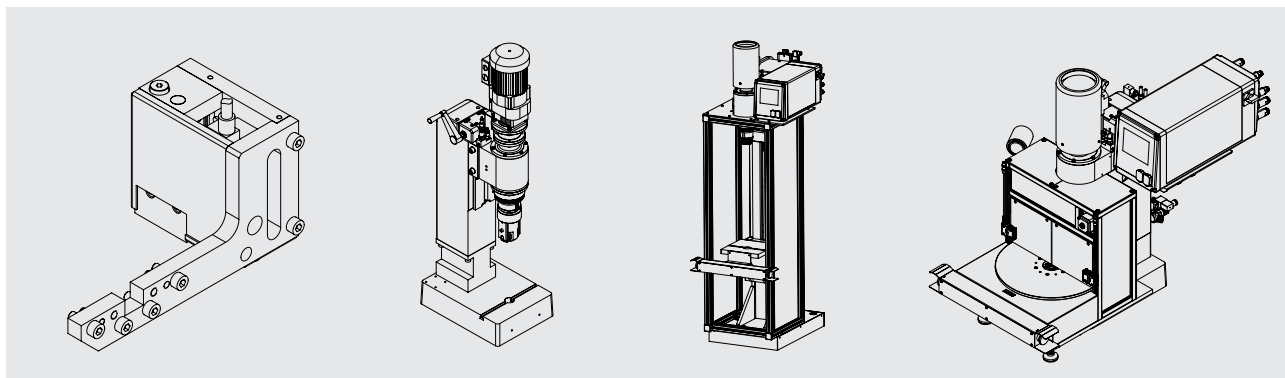
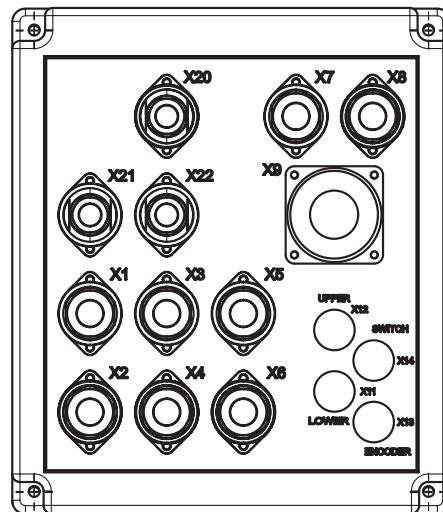
- X13: Path measuring

- X14: Switch NHE

- X15: Power supply

- X16: Riveting motor

- X17: Hydraulic motor



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