SPECIFICATIONS

450 LBF(2 kN) to 12,814 LBF(57 kN) **Force Range**

Repeatability ±1% of Force Setting

Max Riveting Capacity M10 Nut M8 Stud M6 Standoff Carbon Steel

Throat Depth 18 inches(450 mm) 16 inches(400 mm) **Throat Height** Stroke 8 inches(200 mm)

2-56 to 3/8-16 (M2 to M10) **Fastener Sizes**

Pump

10 inches(254 mm) **Touch Screen Control Panel Touch Screen Main Power** 1.5 kW

4A Current 46/32 **Hydraulic Oil**

15.8 Gallons(60 Liters) Oil Tank Reservoir Air Pressure 87 psi(0.6 Mpa) **Power Supply** 380V 3 Phase 50-60Hz

Size (D*W*H) 36.6in x 43.3in x 78.7in (930mm x 1,100mm x 2,000mm)

1,455 LBS(660 kg) Weight

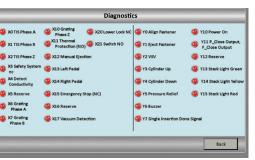


Power Options:

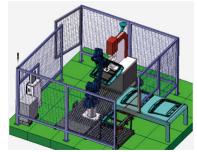
220V, 240V, 400V 415V, 480V 50-60Hz



Modular Automatic-Feed System (MAS)



Robot Riveting Cell



Robot Riveting Workstation



For inquiries please contact: sales@pencomsf.com www.pencomsf.com



FASTENER INSERTION TECHNOLOGIES



A: Positive Stop System

This type of adjustable control energizes a solenoid valve to extend or retract the cylinder at the appropriate time. When the extend valve is energized, the cylinder begins to extend and it moves until it hits a stop at the end of its travel. When the solenoid for retraction is energized, the shaft will begin to retract until it hits the stop at the end of its travel. This is an advantage in softer materials such as PCB, plastic, and

B: Easier and Faster Programming

Single Station Setting: Operators can set the force,



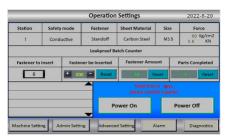
Multi-Station: This screen allows the operator to insert more than one fastener dwell time, and up travel from this single station screen. in a program. Each station can be configured to have its own individual force, dwell time, fastener quantity, and up travel.

	Multi-Station Setup							
Program	Name	TMS	T-M3.5-8-Z	No	o. <mark>-1</mark> 11	+1	Saved Code	
Station	Force	Dwell (Sec)	Fastener to Insert	Up Travel (Sec)	Auto Feed	Fastener Code	Set Up	
1	60	0.00	6	0.00	②	TMST-M3.5-8-2	Setup	
2	60	0.00	2	0.00	0	NCCT-M3-0.97-Z	Setup	
3	90	0.00	3	0.00	0	S8ST-M4-10-Z	Setup	
4	90	0.00	2	0.00	0	S85T-M5-15-Z	Setup	

When the fastener fails to feed into the shuttle in the automatic feed program, the upper tool will continue however, the batch counter will not count the insertion.

C: Automatic Turret Insertion System (ATIS)

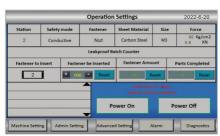
- A. Install up to four different fasteners in one program. Turning the turret will automatically convert to the appropriate pressure and dwell time.
- B. The PLC connected to the turret will follow the programming instructions for each individual fastener installation.
- C. The batch counter will automatically count the number of installed fasteners in a single application, and features a buzzer to indicate when the total installations are complete.



Station 1: TMST-M3.5-8-Z

_		=	Operation	Settings		2022-6-20
Station			Fastener	Fastener Sheet Material		Force
3			Stand	Carbon Steel	M4	90 Kg/cm2 0.9 KN
			Leakproof B	atch Counter		
Fastener to Insert Fastener be		er be inserted	Inserted Fastener Amoun		nt Parts Completed	
3 + 000		Reset	Reset Reset		Rese	
				Valid time please conta		į.
				ower On	ower Off	

Station 3: SBST-M4-10-Z



Station 2: NCCT-M3-0.97-Z

			Operation	1 Settings		2022-6-20	
Station	Safety mode Conductive		Fastener	Sheet Material	Size	Force	
4			Stand	Carbon Steel	M5	90 Kg/cm2 0.9 KN	
			Leakproof B	atch Counter		×.	
Fastener to Insert Faste		Fasten	er be Inserted	Fastener Amou	int	Parts Completed	
		+ 1	Reset	Re	set		
				Valid time is days please contact supplier.			
			P	Power On Po			

Station 4: SBST-M5-15-Z



D: Programs

A 10-inch touch screen stores up to 200 customized programs and fastener databases.



Program 0000	ATU-12 Quick Release	Program 0000		Naming Progra
Program 0000	ATU-10 Quick Release	Program 0000	8	AAAAAAA
Program 0000	RSM-10 Quick Release	Program 0000		No.
Program 0000		Program 0000		00
Program 0000		Program 0000		Save
Program 0000		Program 0000		Load Progra
Program 0000		Program 0000		
Program 0000		Program 0000		Former
Program 0000		Program 0000		
Program 0000		Program 0000		0000
Product 0000		Program 0000		0000
Program 0000		Program 0000		Next
			Multi-Station Setup	Back

E: Ergonomics

Operator control panel is adjustable in 2 directions.

F: Laser Locating

This system allows the operator to see where each fastener will be installed with precision.

G: Safety System

This feature reduces risk and harm to operators. As the press is in motion, it will stop when encountering a foreign object.

Optional

H: Modular Automatic-Feed System (MAS)

MAS handles nuts, studs, and standoffs ranging from M2 to M6 (2-56 to ¼-20) and a maximum length of 25mm (1inch). This system features a high-quality vibration bowl for the movement of parts, and a variable frequency vibration controller.

Manual Tooling Package

Including 31, 33, or 49 piece manual tool kits, J-frame, and fixing base.















J-frame and fixing base is perfect for boxes, flanges, and other hard to reach or maneuver locations.

Automatic Tooling System (Optional)

1. Shuttle Nut Tooling System



2. Automatic Bottom Feed Tooling



3. ABFT With Part Clearance



4. Shuttle Stud Tooling System

5. Shuttle Standoff Tooling System



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