

RIVETING MODE F

The following riveting modes with control variable F (riveting force) are available:

Riveting mode	Description	necessary hardware						
		Path sensor at riveting spindle (X13)	Path sensor at NHE (X13)	Pressure sensors (X11,12)	Projection measurement NHE (X14)	NHE riveting end (X14)	Switch BDC (X5)	External NA (X14)
F1 	F controlled from TDC E and T monitored	X		X				
F2 	F controlled after detection of NA NA, S and T monitored	X		X				
F3 	F controlled after detection of NA NA detection by external signal NA, S and T monitored	X		X			X	
F4 	F controlled from TDC T monitored			X				