

**RIVETING MODE H**

The following riveting modes with control variable H (closing head height) 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)
<b>H1</b> 	H controlled T and F monitored	X		X				
<b>H2</b> 	H controlled T and F monitored		X	X				
<b>H3</b> 	H controlled U, S, T and F monitored		X	X				
<b>H4</b> 	H controlled T monitored	X						
<b>H5</b> 	H controlled T monitored		X					
<b>H6</b> 	H controlled NA, S, T, F monitored like mode H1, but additionally with NA and S evaluation	X		X				