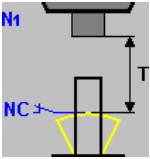
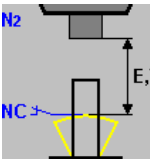
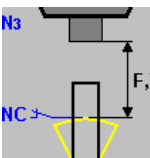
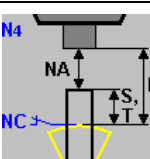


RIVETING MODE N

The following riveting modes with control variable N (external contact) 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)
N1 	Riveting process controlled until external signal T monitored					X		
N2 	Riveting process controlled until external signal T and E monitored	X				X		
N3 	Riveting process controlled until external signal T and F monitored			X		X		
N4 	Riveting process controlled until external signal NA, S, T and F monitored	X		X		X		