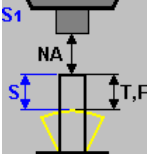
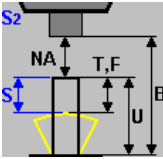
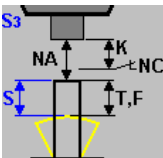
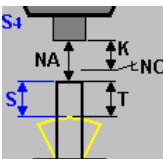
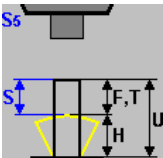
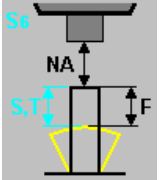


RIVETING MODE S

The following riveting modes with control variable S (riveting path) 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)
S1 	S controlled after detection of NA NA, T and F monitored	X		X				
S2 	S controlled after detection of NA NA, B, U, T and F monitored	X		X	X			
S3 	S controlled after detection of NA NA detection by external signal NA, T and F monitored	X		X			X	
S4 	S controlled after detection of NA NA detection by external signal NA and T monitored	X					X	
S5 	S controlled after detection of NA U, F, T and H monitored		X	X				
S6 	S or T controlled after detection of NA F (S or T) monitored The first control value that is reached, will finish the cycle, the second control value will be used for evaluation	X		X				