

RIVETING MODE T

The following riveting modes with control variable T (riveting time) 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)
<p>T1</p>	<p>T controlled from TDC No additional values monitored</p>							
<p>T2</p>	<p>T controlled from BDC No additional values monitored</p>						X	
<p>T3</p>	<p>T controlled from TDC E and F monitored</p>	X		X				
<p>T4</p>	<p>T controlled after detection of NA (forming time) NA, S and T monitored</p>	X		X				
<p>T5</p>	<p>T controlled after detection of NA NA, U, S, F and B monitored</p>	X		X	X			
<p>T6</p>	<p>T controlled after detection of NA NA detection by external signal NA, K, S and F monitored</p>	X		X				X
<p>T7</p>	<p>T controlled from TDC E monitored</p>	X						

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)
<p>T8</p>	T controlled from TDC F monitored			X				
<p>T9</p>	T controlled from BDC E monitored	X					X	
<p>T10</p>	T controlled from BDC F monitored			X			X	
<p>T11</p>	T controlled from BDC E and F monitored	X		X			X	
<p>T12</p>	T controlled after detection of NA NA detection by external signal NA and S monitored	X						X
<p>T13</p>	T controlled after detection of NA with NHE U, H and F monitored		X	X				
<p>T14</p>	T controlled from TDC or until contact NHE No additional values monitored						X	
<p>T15</p>	T or H controlled The first control value that is reached, will finish the cycle, the second control value will be used for evaluation	X		X				