

BOLLHOFF

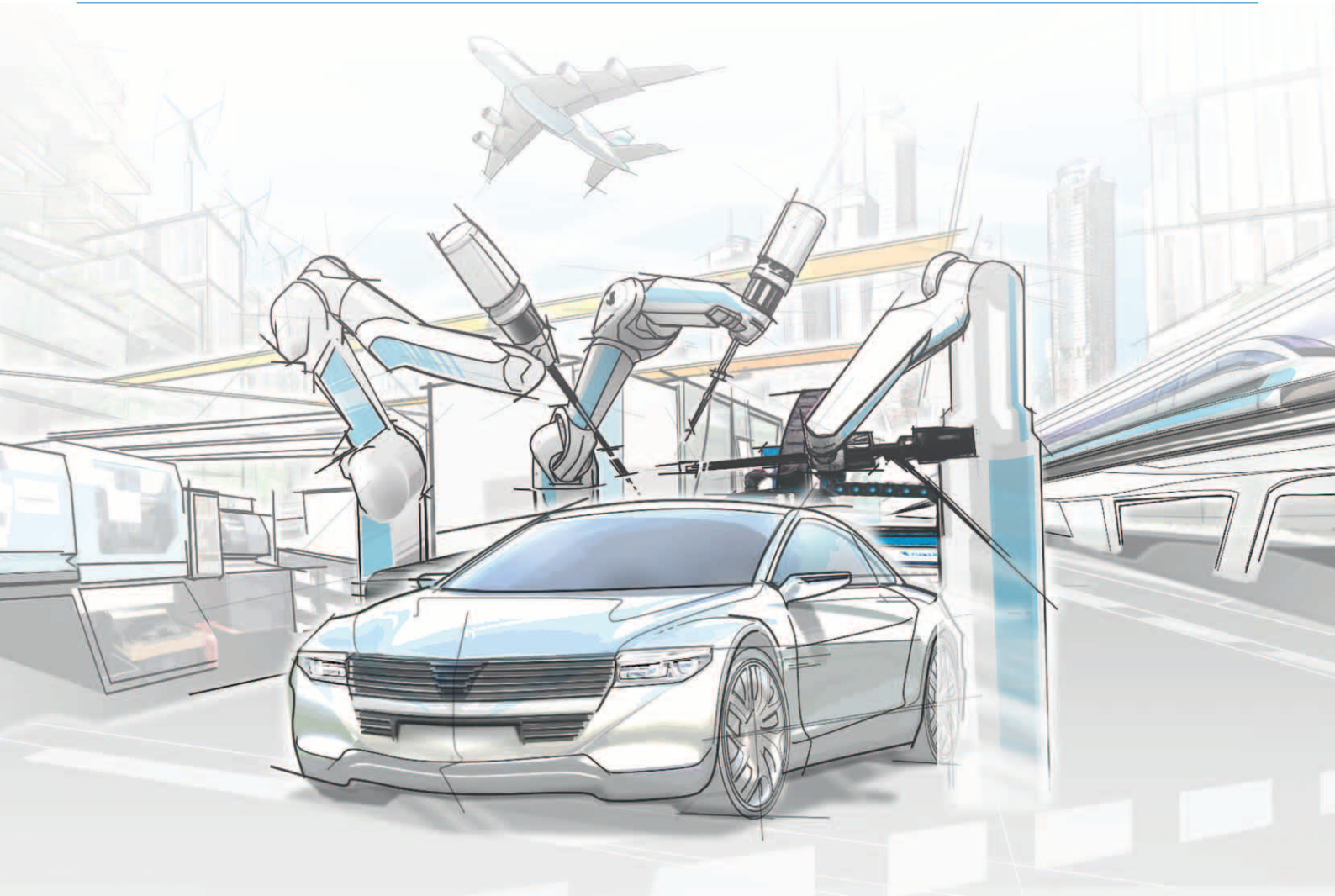
RIVQUICK®

Setting tools for break stem rivets



We are your **expert**
for **fastening** and
assembly technology.





Automotive industry

- Vehicle bodies and two-wheel vehicles
- Electric vehicle charging stations
- Trailers

Heating and air conditioning

- Precision air conditioning cabinets
- Air conditioning units and water heaters
- Air handling units

Street furniture

- Waste disposal containers
- Casing
- Electric vehicle charging stations

Building equipment

- Opening frames
- Roof windows
- Elevators

Household appliances

- Ovens
- Washing machines
- Cooking appliances

And many other industrial sectors

- Railway
- Agricultural machinery, etc.

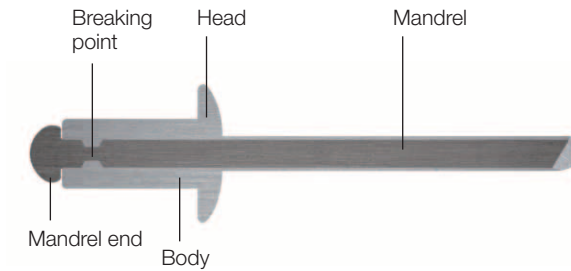
RIVQUICK® – Working principle and setting

Break stem rivet

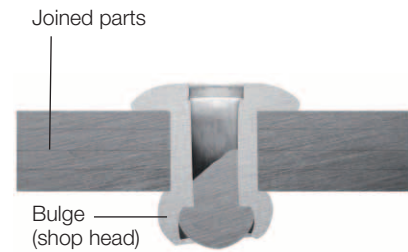
Break stem rivets are produced from durable materials and are made up of 2 components: the body and the mandrel.

During setting, the end of the body is squeezed and upset.

RIVQUICK® standard rivet



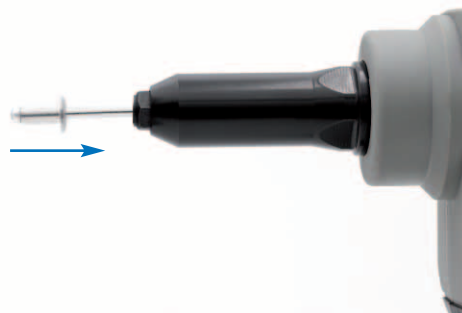
RIVQUICK® standard rivet after setting



Setting a blind rivet is a simple operation:

Insert the rivet until contact with the parts to be joined, then set the rivet and you're done!

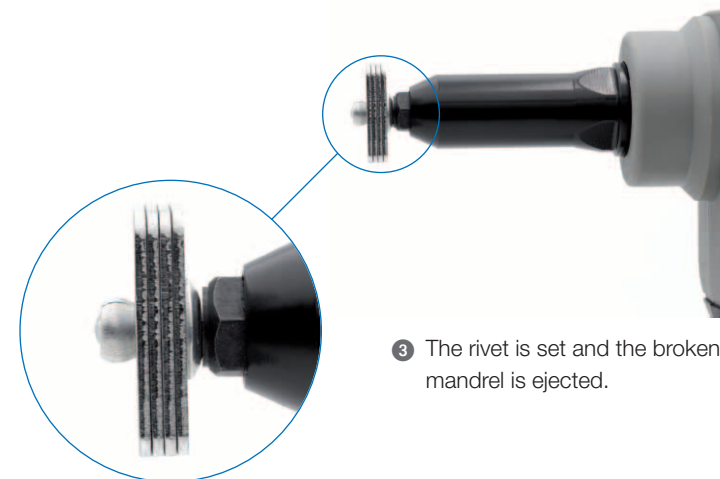
Setting sequence



1 Place the rivet in the nose of the tool.



2 Place the rivet in the parts to be joined until all components are in contact with each other.



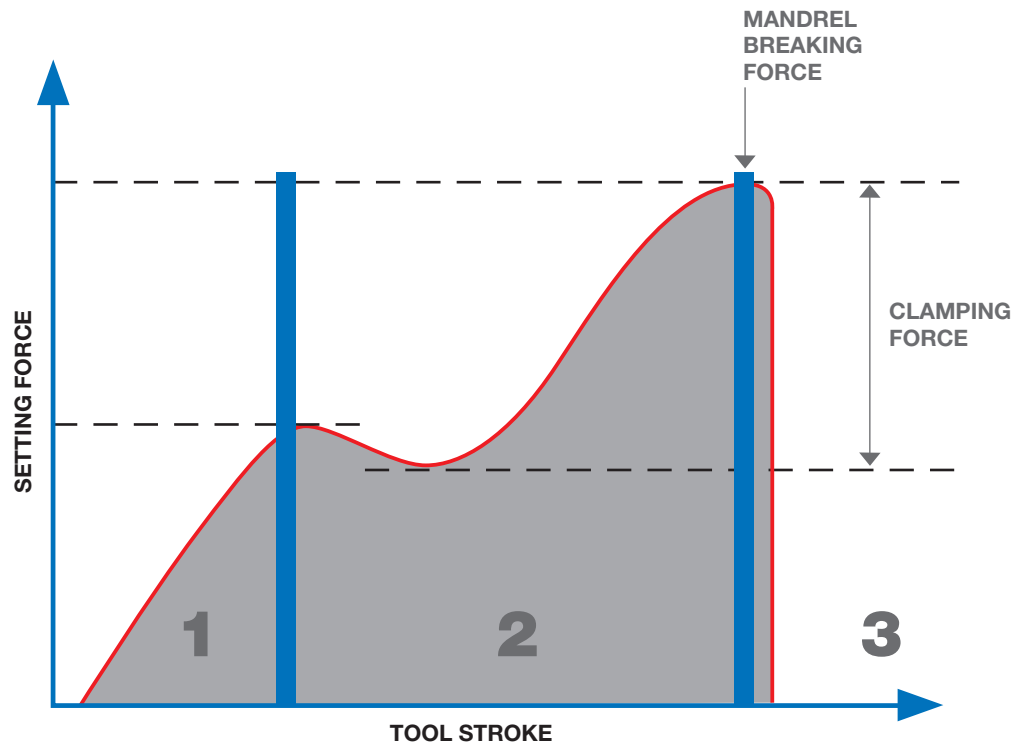
3 The rivet is set and the broken mandrel is ejected.

RIVQUICK® – Working principle and setting

Setting a RIVQUICK® blind rivet - Description

To set a rivet, the operator needs to use a setting tool, whether hand-operated, pneumatic or battery-powered. The setting tool should be selected based on the technical characteristics of the rivet to be set (type, size, materials, etc.), the environment and the production rate.

Setting curve



First the rivet is placed in the nose of the setting tool, then it is inserted into the hole and the setting cycle can start. The setting sequence of a blind rivet includes three steps.

1: Prestressing of the rivet

At the beginning of the cycle, the nose piece of the setting tool locks the mandrel of the rivet, resulting in the distortion of the rivet body and prestressing of the rivet.

2: Distortion of the body and formation of the bulge

The distortion of the rivet body widens the bulge until it lies flat against the joined component.

3: Flattening of the bulge, clamping of the joint and shearing of the mandrel

The rivet is now set, the movement of the mandrel increases the clamping force in the joint until the mandrel breaks, thereby completing the setting operation.

RIVQUICK® – Setting tools for break stem rivets

RIVQUICK® P Series

A light and robust range of hydropneumatic setting tools for small quantities and long production runs.

**Ergonomically designed tool:**

- Mandrel collector,
- Vacuum mandrel collection system,
- Ring for suspension to a load balancer,
- Ergonomically designed handle
- Optimised centre of gravity for easier handling.

Fail-safe operation:

- Air outlet designed to protect the operator,
- Compressed air safety shutoff valve.

Quick and reliable

- Short cycle times,
- Suitable for diameters between 2.4 mm and 6.4 mm.

RIVQUICK® – Setting tools for break stem rivets**RIVQUICK® B Series**

Simple and efficient battery-powered tools for more freedom.

**Easy to use:**

- Wireless technology for improved operator freedom of movement,
- Ring for suspension to a load balancer.

Ergonomically designed tool:

- Balanced weight for ergonomic grip and reduced operator fatigue,
- Mandrel collector.

Sturdy and reliable:

- Suitable for diameters between 2.4 mm and 6.4 mm,
- Long endurance thanks to the Lithium-Ion battery.

RIVQUICK® P series – Technical characteristics

RIVQUICK® P1000



	Ø RIVQUICK®									
	2,4*	3,0*	3,2*	4,0	4,8	4,8V**	5,0	6,0	6,4	6,4V**
Aluminium	■	■	■	■	■					
Zinc plated steel	■	■	■	■	■					
Stainless steel	■	■	■	■	■					

226 030 01000

*Conversion kit **226 030** 00086 is necessary for nose pieces Ø 2.4 and Ø 3.2 (for mandrel diameters < 2.0 mm)

RIVQUICK® P2000



	Ø RIVQUICK®									
	2,4*	3,0*	3,2*	4,0	4,8	4,8V**	5,0	6,0	6,4	6,4V**
Aluminium				■	■	■	■	■	■	■
Zinc plated steel				■	■	■	■	■	■	■
Stainless steel				■	■	■	■	■	■	■

226 031 01000

Recommended for RIVQUICK® Varibulb and RIVQUICK® Varibolt Ø 4.8 mm.

To set RIVQUICK® Varibolt rivets, a nose piece Varibolt Ø 4.8 (**226 031** 48001) must be used.

RIVQUICK® P3000

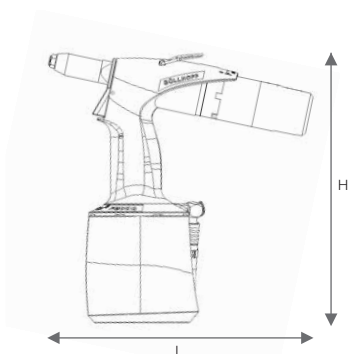


	Ø RIVQUICK®									
	2,4*	3,0*	3,2*	4,0	4,8	4,8V**	5,0	6,0	6,4	6,4V**
Aluminium					■	■	■	■	■	■
Zinc plated steel					■	■	■	■	■	■
Stainless steel					■	■	■	■	■	■

226 032 01000

Recommended for RIVQUICK® Varibolt and RIVQUICK® Varilock Ø 6.4 mm. To set RIVQUICK® Varibolt rivets, nose pieces Varibolt Ø 4.8 (**226 031** 48001) and Varibolt Ø 6.4 (**226 032** 64001) must be used.




** "4,8V" and "6,4V" refer to RIVQUICK® Varibulb and RIVQUICK® Varibolt, Ø 4.8 mm and Ø 6.4 mm.



	RIVQUICK® P1000	RIVQUICK® P2000	RIVQUICK® P3000
Tool stroke	17 mm	21 mm	25 mm
Setting force	7 300 N	12 500 N	16 000 N
Air pressure	5 bar (min.) to 7 bar (max.)	5 bar (min.) to 7 bar (max.)	5 bar (min.) to 7 bar (max.)
Weight	1.250 kg	1.650 kg	2.050 kg
L x H x W	268 x 264 x 101 mm	272 x 275 x 120 mm	272 x 277 x 130 mm

RIVQUICK® P series – Accessories

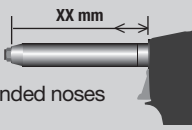



Spare parts / Tooling


		RIVQUICK® P1000	RIVQUICK® P2000	RIVQUICK® P3000
Nose piece 	Ø 2,4	226 030 24001*	-	-
	Ø 3,2	● 226 030 32001*	-	-
	Ø 4,0	226 030 40001		-
	Ø 5,0	● 226 030 50001		
	Ø 6,0	-	● 226 031 60001	
	Ø 6,4	-	226 031 64001	● 226 031 64001
	Ø 4,8 Varibolt	-	● 226 031 48001	
	Ø 6,4 Varibolt	-	● 226 032 64001	
1 set of jaws 3 pieces 	Ø 2,4 → Ø 6,4	226 030 00002		
1 set of jaws 3 pieces 	< Ø 2,4	226 030 00089		

● = Supplied with a new machine

 *Conversion kit **226 030** 00086 is necessary for nose pieces Ø 2.4 and Ø 3.2 (for mandrel diameters < 2.0 mm).

Accessories

		RIVQUICK® P1000	RIVQUICK® P2000	RIVQUICK® P3000
Extended noses 	XX = 110 mm	226 030 00110	226 031 00110	226 032 00110
	XX = 160 mm	226 030 00120	226 031 00120	226 032 00120
	XX = 210 mm	226 030 00130	226 031 00130	226 032 00130
Extended mandrel collector / large capacity 		226 030 00087		
Conversion kit for mandrel Ø < 2 mm 		226 030 00086		
Stäubli air fitting kit 	Ø 6,0	282 590 10988		
	Ø 8,0	282 590 10989		

		L +10 mm	L +15 mm	L +20 mm	L +25 mm
Extended nose pieces 	Ø 2,4	226 030 24101	226 030 24151	226 030 24201	226 030 24251
	Ø 3,2	226 030 32101	226 030 32151	226 030 32201	226 030 32251
	Ø 4,0	226 030 40101	226 030 40151	226 030 40201	226 030 40251
	Ø 5,0	226 030 50101	226 030 50151	226 030 50201	226 030 50251
	Ø 6,0	226 030 60101	226 030 60151	226 030 60201	226 030 60251
	Ø 6,4	226 030 64101	226 030 64151	226 030 64201	226 030 64251




Dedicated to special rivets with extended mandrels.

RIVQUICK® B series – Technical characteristics

RIVQUICK® B2000



	Ø RIVQUICK®							
	2,4	3,0	3,2	4,0	4,8	5,0	6,0	6,4
Aluminium	■	■	■	■	■	■		
Zinc plated steel	■	■	■	■	■	■		
Stainless steel	■	■	■	■	■	■		

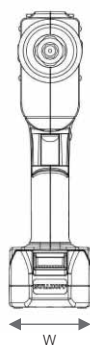
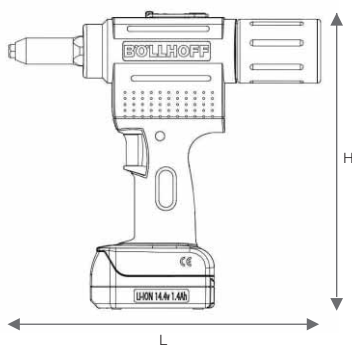
 **226 040** 01000

RIVQUICK® B3000



	Ø RIVQUICK®							
	2,4	3,0	3,2	4,0	4,8	5,0	6,0	6,4
Aluminium				■	■	■	■	■
Zinc plated steel				■	■	■	■	■
Stainless steel				■	■	■	■	■

 **226 041** 01000







	RIVQUICK® B2000	RIVQUICK® B3000
Tool stroke	20 mm	27 mm
Setting force	10 000 N	18 000 N
Battery	Li-Ion 14,4 V-1,4Ah	Li-Ion 14,4 V-2,8Ah
Sound level	< 70 dB (A)	< 70 dB (A)
Number of cycles / battery	550*	770*
Charging time	< 60 min	< 60 min
Cycle time	27 to 30 pcs/min	20 to 25 pcs/min
Weight	2.000 kg	2.200 kg
L x H x W	272 x 275 x 120 mm	272 x 277 x 130 mm

*Setting of alu/steel rivets diameter 4.0


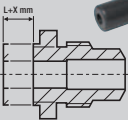
RIVQUICK® B series – Accessories

Spare parts / Tooling

		RIVQUICK® B2000	RIVQUICK® B3000
Nose piece 	Ø 2,4	● 226 040 24001	–
	Ø 3,2	● 226 040 32001	–
	Ø 4,0	● 226 040 40001	
	Ø 5,0	● 226 040 50001	
	Ø 6,0	–	● 226 041 60001
	Ø 6,4	–	● 226 041 64001
	Ø 4,8 Varibolt	–	● 226 041 48002
	Ø 6,4 Varibolt	–	● 226 041 64003
1 set of jaws 3 pieces 	Ø 2,4 → Ø 6,0	226 040 00004	
	Ø 6,4	–	226 041 00004
Battery 	Li-Ion-14,4V 1,4Ah	226 040 00018	
	Li-Ion-14,4V 2,8Ah	226 040 00019	
Battery charger 		EU version: 226 040 00020	
		UK version: 226 040 00025	
	100-240V ~50-60Hz-1A	US version: 226 040 00026	

● = Supplied with a new machine

Accessories

		L + 15 mm
Extended nose pieces  	Ø 3,2	226 040 32002
	Ø 4,0	226 040 40002
	Ø 5,0	226 040 50002

 Dedicated to special rivets with extended mandrels.

BÖLLHOFF

Passion for successful joining.

Böllhoff Group

Innovative partner for joining technology with assembly and logistics solutions.

Find your local partner at www.boellhoff.com or contact us at fat@boellhoff.com.

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