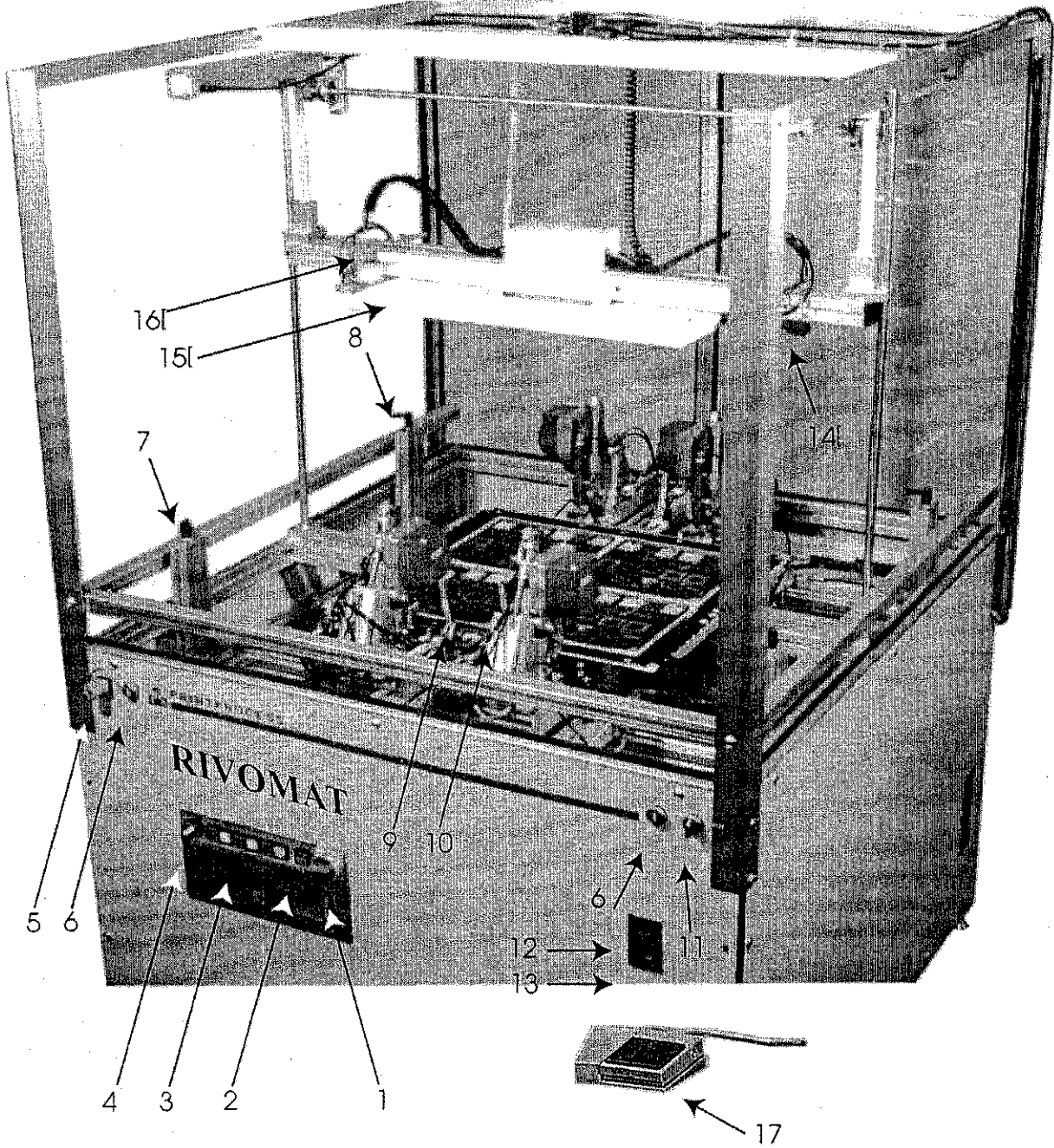




DESCRIPTION OF THE OPERATING ELEMENTS

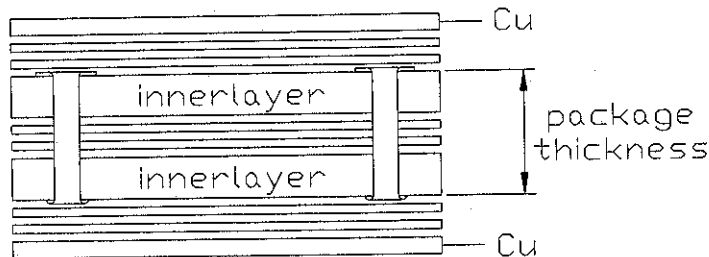




## 10 Optimum rivet lengths

The riveting unit is designed for rivets with a diameter of 2.5mm and 0.15mm wall thickness.  
The hole must be drilled to a diameter of 2.55 to 2.6mm.

Package thickness = Inner layers with prepreg without copper foil.

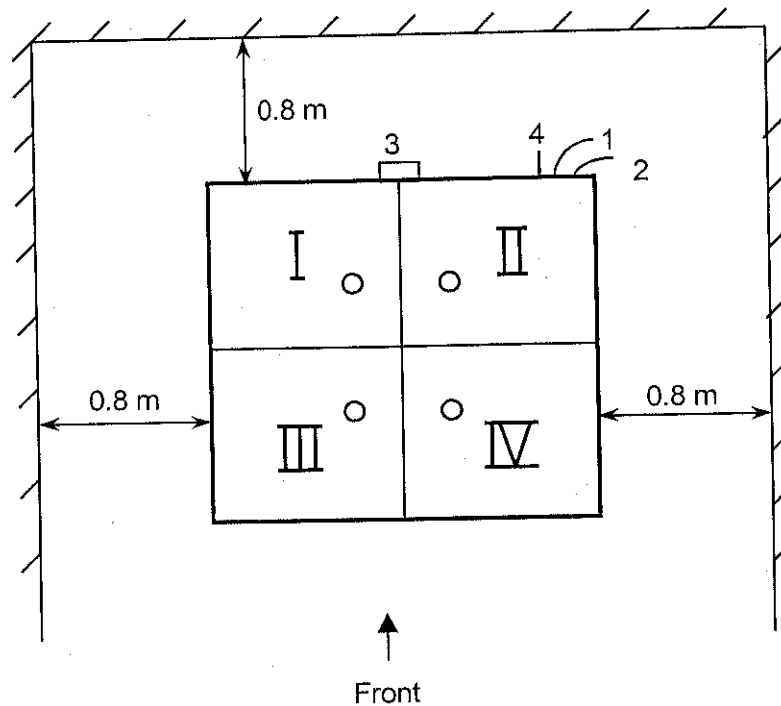


Rivet length = 1.4mm (0.055")	optimum package thickness	0.5 - 0.9mm (0.02 - 0.035")
	maximum package thickness	0.3 - 1.0mm (0.011 - 0.04")
Rivet length = 1.9mm (0.074")	optimum package thickness	0.8 - 1.4mm (0.031 - 0.055")
	maximum package thickness	0.6 - 1.5mm (0.023 - 0.06")
Rivet length = 2.5mm (0.1")	optimum package thickness	1.3 - 2.0mm (0.051 - 0.078")
	maximum package thickness	1.0 - 2.1mm (0.04 - 0.082")
Rivet length = 3.0mm (0.118")	optimum package thickness	1.9 - 2.5mm (0.074 - 0.1")
	maximum package thickness	1.5 - 2.6mm (0.06 - 0.102")
Rivet length = 4.0mm (0.157")	optimum package thickness	2.8 - 3.5mm (0.11 - 0.138")
	maximum package thickness	2.5 - 3.6mm (0.1 - 0.14")
Rivet length = 5.0mm (0.197")	optimum package thickness	3.8 - 4.5mm (0.15 - 0.177")
	maximum package thickness	3.5 - 4.6mm (0.138 - 0.18")
Rivet length = 6.0mm (0.236")	optimum package thickness	4.8 - 5.5mm (0.189 - 0.217")
	maximum package thickness	4.5 - 5.6mm (0.177 - 0.22")

**Rivet must be at least 0.4mm longer than package thickness**



## 13 Specification Rivomat II



### 13.1 Technical Data

1. Air pressure	min. 6 bar 200 l/min. tube inner diameter min. 9mm (filtered air supply)
2. Power supply	400 V / 230V 50Hz 5A
3. Vacuum extractor	Ø 60mm air quantity 3500 l/ min. 200 mbar low pressure
4. Socket outlet for vacuum extractor	230V 50Hz 3A
Working level	875 mm +/- 25 mm
Weight	280 kg
L x W x H	1.15m x 1.15m x 1.78m
Rivets per board	4 / 8 / 12 / 16 / 20 / 24
Cycle time for 4 rivets	8 sec.



**14 Distance of rivets, minimum and maximum board size**

**RIVOMAT II**

