

Fastening Technology / Installation Tools

## Tools

for Threaded Inserts



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# Overview – tools for threaded inserts

Tools for threaded inserts	Article No.	Technology	M3	M4	M5	M6	M8	M10	M12	M14	M16
HL1	349 041 001	hand tool		•							
	349 051 001	hand tool			•						
	349 061 001	hand tool				•					
HL1M	349 081 001	hand tool			•		•				
	349 101 001	hand tool						•			
	349 121 001	hand tool							•		
TIOS® HN6	348 710 000	hand tool	•	•*	•*	•*					
TIOS® HN10 S	348 720 000	hand tool		•	•	•	•	•			
TIOS® HN12 PT	348 740 000	hand tool		•	•	•	•	•	•		
TIOS® HN12 R	348 730 000	hand tool			•	•	•	•	•		
TIOS® EN18	352 400 001	battery		•*	•*	•*	•*	•(Al)			
Gesipa Firebird®	351 000 000	battery	•	•*	•*	•*	•(St/Al)*	•(Al)			
RL 50	348 200 250	hydropneum.	•	•*	•*	•*	•	•	•(Al)		
RL 50A	348 200 300	hydropneum.	•	•*	•*	•*	•	•*	•(Al)		
RL 50S	348 200 400	hydropneum.	•	•*	•*	•*	•	•*	•(Al)		
RL 50AS	348 200 500	hydropneum.	•	•*	•*	•*	•	•*	•(Al)		
RL 100	348 300 000	hydropneum.				•*	•*	•	•	•	•**
ProSert™ XTN20	347 000 000	hydropneum.	•(Al/St)	•*	•*	•*	•(Al/St)*	•(Al)			

\* Also suitable for blind rivet studs

\*\* Always check first to see if the installation of M16 blind rivet nuts is possible

# HL1

Manual rivet tool for installing M4 to M6 blind rivet nuts

## Benefits at a glance

- Set comprising ratchet, hex key and installation head with threaded mandrel (M4, M5 or M6)
- Easy to operate and low-maintenance
- Sturdy design and low-weight
- Ideal for repairs or installing small quantities

## Technical specifications

Weight: 0.8 kg

## Scope of delivery

HL1 manual rivet tool (complete), comprising  
 Ratchet  
 Hex key  
 Threaded mandrel  
 Setting head  
 Operating instructions

	Article No.
HL1 manual rivet tool (complete) for M4	349 041 001
HL1 manual rivet tool (complete) for M5	349 051 001
HL1 manual rivet tool (complete) for M6	349 061 001

## Working range

Blind rivet nuts	M4	M5	M6
Aluminium	•	•	•
Steel	•	•	•
Stainless steel	•	•	•

## Spare parts / Consumables

Description	Article No.
Threaded mandrel M4	349 047 870
Threaded mandrel M5	349 057 870
Threaded mandrel M6	349 320 870
Setting head M4	349 304 870
Setting head M5	349 305 870
Setting head M6	349 306 870
Hex key for M4 - M6	349 311 870
Ratchet for M4 - M6	349 309 870



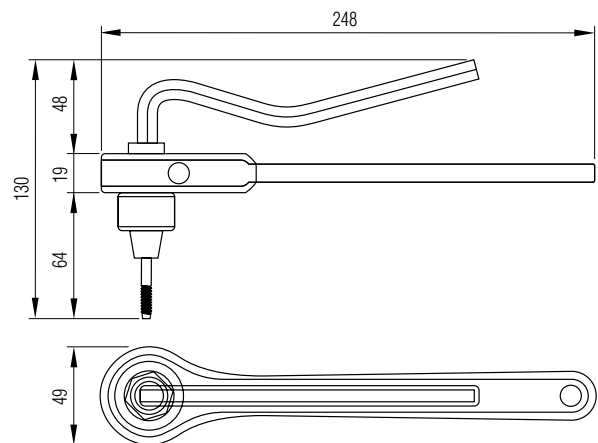
Ratchet (M4 - M6)



Hex key (M4 - M6)



Nose piece with threaded mandrel (M4, M5 oder M6)



# HL1M

Manual rivet tool for installing M8 to M20 blind rivet nuts

### Benefits at a glance

- Set comprising ratchet, hex key and nose piece with threaded mandrel (M8, M10 or M12)
- Easy to use; requires little maintenance
- Sturdy design, low maintenance
- Ideal for repairs or installing small quantities of fasteners

### Technical specifications

Weight: 0.8 kg

### Scope of delivery

- HL1M manual rivet tool (complete), comprising
- Ratchet
- Hex key
- Threaded mandrel
- Setting head
- Operating instructions



Ratchet (M8 - M12)



Hex key (M8 - M12)



Setting head with threaded mandrel (M8, M10 or M12)

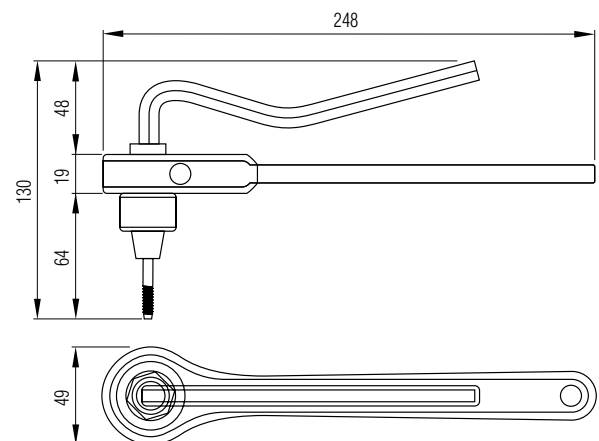
	Article No.
HL1M manual rivet tool (complete) for M8	349 081 001
HL1M manual rivet tool (complete) for M10	349 101 001
HL1M manual rivet tool (complete) for M12	349 121 001

### Working range

Blind rivet nuts	M8	M10	M12
Aluminium	•	•	•
Steel	•	•	•
Stainless steel	•	•	•

### Spare parts / Consumables

Description	Article No.
Threaded mandrel M8	349 302 870
Threaded mandrel M10	349 303 870
Threaded mandrel M12	349 322 870
Setting head M8	349 307 870
Setting head M10	349 308 870
Setting head M12	349 323 870
Hex key for M8 - M12	349 312 870
Ratchet wrench for M8 - M12	349 310 870



## TIOS® HN6

Manual rivet tool for installing M3 - M6 blind rivet nuts and M4 - M6 blind rivet studs

### Benefits at a glance

- Opening spring for one-handed operation
- Threaded mandrels for blind rivet nuts and blind rivet studs supplied with tool
- High-quality plier casing and handles
- Ergonomic handles
- Extremely easy operation and stroke settings

### Technical specifications

Stroke: 7.0 mm  
 Length: 265.0 mm  
 Width: 134.0 mm  
 Weight: 0.7 kg

### Scope of delivery

TIOS HN6 manual rivet tool  
 Threaded mandrels: M3 / M4\* / M5\* / M6\*  
 Nose pieces: M3 / M4 / M5 / M6  
 Operating instructions  
 Article No. 348 710 000



### Working range

Blind rivet nuts	M3	M4	M5	M6
Aluminium, copper	•	•*	•*	•*
Steel	•	•*	•*	•*
Stainless steel	•	•*	•*	•*

\* For use with blind rivet studs

### Spare parts / Consumables

Description	Article No.
Threaded mandrel M3	348 710 103
Threaded mandrel M4	348 710 104
Threaded mandrel M5	348 710 105
Threaded mandrel M6	348 710 100
Setting head, complete, M3	348 710 203
Setting head, complete, M4	348 710 204
Setting head, complete, M5	348 710 205
Setting head, complete, M6	348 710 206

## TIOS® HN10 S

Manual rivet tool for installing M4 - M10 blind rivet nuts with spindle mechanism

### Benefits at a glance

- The threaded mandrel is turned by pulling on the spindle
- This makes for quick and easy pre-installation of the blind rivet nuts on the threaded mandrel
- Stroke scale on head side for easy stroke settings
- Tool-less rapid change system for threaded mandrels
- Threaded mandrels for blind rivet nuts included with delivery

### Technical specifications

Stroke: 7.0 mm  
 Length: 480.0 mm  
 Width: 180.0 mm  
 Weight: 2.0 kg

### Scope of delivery

TIOS HN10 S manual rivet tool  
 Threaded mandrels: M4 / M5 / M6 / M8 / M10  
 Nose pieces: M4 / M5 / M6 / M8 / M10  
 Operating instructions  
 Article No. 348 720 000



### Working range

Blind rivet nuts	M4	M5	M6	M8	M10
Aluminium, copper	•	•	•	•	•
Steel	•	•	•	•	•
Stainless steel	•	•	•	•	•

### Spare parts / Consumables

Description	Article No.
Threaded mandrel M4	348 720 104
Threaded mandrel M5	348 720 105
Threaded mandrel M6	348 720 106
Threaded mandrel M8	348 720 108
Threaded mandrel M10	348 720 110
Nose piece, complete, M4	348 720 114
Nose piece, complete, M5	348 720 113
Nose piece, complete, M6	348 720 112
Nose piece, complete, M8	348 720 111
Nose piece, complete, M10	348 720 115
Lockpin for threaded mandrel	348 740 303

# TIOS® HN12 PT

Manual rivet tool for installing M4 - M12 blind rivet nuts, with ratchet action

## Benefits at a glance

- Manual rivet tool with ratchet action
- Unique force transmission concept for blind rivet nuts up to M12 stainless steel
- Stroke scale on head side for easy stroke settings
- Tool-less rapid change system for threaded mandrels
- Threaded mandrels for blind rivet nuts included with delivery

## Technical specifications

Stroke: 12.0 mm  
 Length: 465.0 mm  
 Width: 180.0 mm  
 Weight: 1.8 kg

## Scope of delivery

TIOS HN12 PT manual rivet tool  
 Threaded mandrels: M4 / M5 / M6 / M8 / M10 / M12  
 Nose pieces: M4 / M5 / M6 / M8 / M10 / M12  
 Operating instructions  
 Article No. 348 740 000



## Working range

Blind rivet nuts	M4	M5	M6	M8	M10	M12
Aluminium, copper	•	•	•	•	•	•
Steel	•	•	•	•	•	•
Stainless steel	•	•	•	•	•	•

## Spare parts / Consumables

Description	Article No.
Threaded mandrel M4	348 740 104
Threaded mandrel M5	348 740 105
Threaded mandrel M6	348 740 106
Threaded mandrel M8	348 740 108
Threaded mandrel M10	348 740 110
Threaded mandrel M12	348 740 112
Nose piece, complete, M4	348 740 116
Nose piece, complete, M5	348 740 115
Nose piece, complete, M6	348 740 114
Nose piece, complete, M8	348 740 109
Nose piece, complete, M10	348 740 113
Nose piece, complete, M12	348 740 111
Lockpin for threaded mandrel	348 740 303

## TIOS® HN12 R

Manual rivet tool for installing M5 - M12 blind rivet nuts

### Benefits at a glance

- Ratchet action for maximum force transmission in confined spaces
- The upper lever turns around its middle axis
- Patented telescopic lever for customised adjustment of lever lengths
- Stroke scale for easy stroke settings
- Tool-less rapid change system for threaded mandrels
- Threaded mandrels for blind rivet nuts included with delivery

### Technical specifications

Stroke: 10.0 mm  
 Length: 219.0 - 317.0 mm  
 Width: 177.0 mm  
 Weight: 1.5 kg

### Scope of delivery

TIOS HN12 R manual rivet tool  
 Threaded mandrels: M5 / M6 / M8 / M10 / M12  
 Nose pieces: M5 / M6 / M8 / M10 / M12  
 Operating instructions  
 Article No. 348 730 000

### Working range

Blind rivet nuts	M5	M6	M8	M10	M12
Aluminium, copper	•	•	•	•	•
Steel	•	•	•	•	•
Stainless steel	•	•	•	•	•

### Spare parts / Consumables

Description	Article No.
Threaded mandrel M5	348 730 101
Threaded mandrel M6	348 730 102
Threaded mandrel M8	348 730 103
Threaded mandrel M10	348 730 104
Threaded mandrel M12	348 730 105
Nose piece M5	348 730 106
Nose piece M6	348 730 107
Nose piece M8	348 730 108
Nose piece M10	348 730 109
Nose piece M12	348 730 110



## TIOS® EN18

Battery-driven blind rivet nut tool for installing M3 - M10 blind rivet nuts and M4 - M6 blind rivet studs

### Benefits at a glance

- 90 pre-programmed setting forces to choose from
- OLED display with symbols and plain text
- Rapid-change nose pieces: M3 - M10
- Intelligent lithium-ion battery technology
- Long battery life per charge: up to 2300 installations per battery charge
- Brushless 18 V DC motor (BLOC)

### Technical specifications

Insertion force:	18.0 kN
Motor:	18 V brushless DC motor
Weight:	2.5 kg with battery (2.5 Ah)

### Scope of delivery

TIOS EN18 battery-operated blind rivet nut tool  
 Operating instructions  
 Storage case  
**Article No. 352 400 000<sup>1</sup>**

TIOS EN18 battery-operated blind rivet nut tool  
 TIOS LIO1825 18 V / 2.5 Ah insertable battery  
 TIOS LIO2830 18 V single charger  
 Operating instructions  
 Storage case  
**Article No. 352 400 001<sup>1</sup>**

TIOS EN18 Control battery-operated rivet installation tool  
 Scope of delivery as Article No. **352 400 000<sup>1</sup>**  
 but with load-displacement monitoring  
**Article No. 352 400 010<sup>1</sup>**

TIOS EN18 Control battery-operated rivet installation tool  
 (complete)  
 Scope of delivery as Article No. **352 400 000<sup>1</sup>**  
 but with load-displacement monitoring  
**Article No. 352 400 011<sup>1</sup>**

### Optional

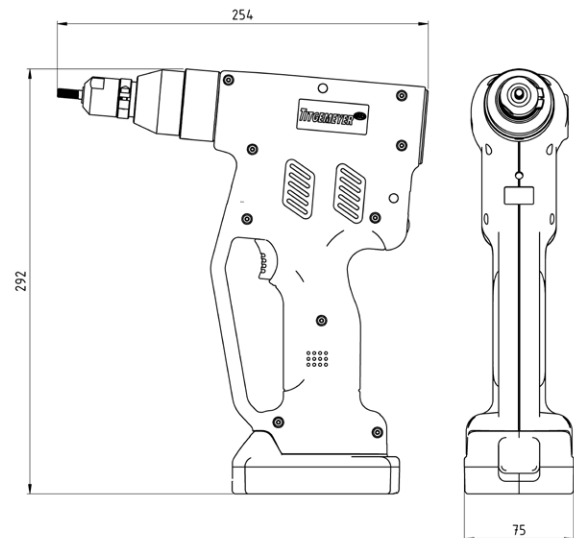
TIOS-CONTROL process control (load-displacement monitoring)  
 Radio module (WiFi 2.4 GHz and 5 GHz, Zigbee 2,4 GHz)  
 Barcode reader (for program settings and parts recognition)

### Working range

Blind rivet nuts	M3	M4	M5	M6	M8	M10
Aluminium	•	*•	*•	*•	•	•
Steel	•	*•	*•	*•	•	•
Stainless steel	•	*•	*•	*•	•	•

\* For use with blind rivet studs

<sup>1</sup> Pulling head units not included. Please order separately.



## Spare parts / Consumables

Thread size	Pulling unit* complete Article No.	Mundstück Mundstück	Threaded mandrel Article No.
M3	352 400 100	351 013 000	351 003 000
M4	352 400 101	351 014 000	351 004 000
M5	352 400 102	351 015 000	351 005 000
M6	352 400 103	351 016 000	351 006 000
M8	352 400 104	351 018 000	351 008 000
M10	352 400 105	351 020 000	351 010 000

\* Pulling head units not included. Please order separately.

The pulling head unit does not depend on the size of thread and is only needed once.

## Batteries and charger

Description	Article No.
TIOS LI01825 2.5 Ah insertable battery	352 200 905
TIOS LI01850 5.0 Ah insertable battery	352 200 904
TIOS LI02830 single charger	352 200 910
TIOS LI02830-4 multi-charger, 4 charging points	352 200 911
TIOS LI02830-8 multi charger, 8 charging points	352 200 912

## Accessories

Description	Article No.
Fixing kit, complete	352 200 921

## Installed rivets per charged battery (2.5 Ah)

Thread size	Aluminium [Qty.]	Steel [Qty.]
M5	1150	850
M6	1050	800
M8	900	450

# FireBird®

Battery-operated blind rivet nut tool for installing M3 - M10 blind rivet nuts and M4 - M8 blind rivet studs

## Benefits at a glance

- Ergonomic design
- Short installation times
- Compact, shock-proof housing

## Technical specifications

Stroke:	5.5 mm
Insertion force:	13.0 kN
Motor:	14.4V DC motor
Length:	285.0 mm
Height:	287.0 mm
Nose cap ø:	29.0 mm
Nose cap length:	87.0 mm
Weight:	2.3 kg with battery (1.3 Ah)

## Scope of delivery

FireBird® battery-operated blind rivet nut tool  
 Quick-change battery 14.4V / 1.3 Ah  
 Rapid charger 14.4V  
 Threaded mandrels: M4 / M5 / M6  
 Nose pieces: M4 / M5 / M6  
 Operating instructions  
 Storage case (metal)  
**Article No. 351 000 000**



## Working range

Rivet nuts	M3	M4	M5	M6	M8	M10
Aluminium	•	•*	•*	•*	•*	•
Steel	•	•*	•*	•*	•*	
Stainless steel	•	•*	•*	•*		

\* For use with blind rivet studs

## Spare parts / Consumables

Thread size	Nose piece Article No.	Threaded mandrel Article No.	Internal threaded mandrel, Article No.
M3	351 013 000	351 003 000	
M4	351 014 000	351 004 000	
M5	351 015 000	351 005 000	
M6	351 016 000	351 006 000	351 073 000
M8	351 018 000	351 008 000	351 074 000
M10	351 020 000	351 010 000	

## Batteries and charger

Description	Weight [kg]	Article No.
Charger 14.4V Li-Ion	0.6	431 976 000
Quick-change battery 14.4 V / 1.3 Ah Li-Ion	0.4	431 978 000
Quick-change battery 14.4 V / 2.6 Ah Li-Ion	0.5	431 982 000

## Installed rivets per charged battery (2.5 Ah)

Thread size	Aluminium [Qty.]	Steel [Qty.]
M3	600	550
M4	520	480
M5	480	400
M6	400	300
M8	340	180
M10	300	

# RL 50

Hydropneumatic blind rivet nut tool for installing M3 to M12 blind rivet nuts and M4 - M8 blind rivet studs

### Benefits at a glance

- Big on performance, small in size
- One-step trigger
- Infinitely adjustable stroke
- Easy to use; requires little maintenance
- Automatic spin-off after each installation
- Low-noise
- Air supply fittable on left or right
- Spin-off action can also be triggered manually
- Safety valve prevents operating pressure overload
- Reliable and tried-and-tested

### Technical specifications

Stroke:	1.5 - 5.8 mm
Insertion force:	23.5 kN at 6 bar
Installation force/Weight ratio:	10.7 kN/kg
Air consumption:	4.6 l/rivet
Air supply pressure:	5 - 7 bar
Air supply:	ø 6 mm (G1/4")
Weight:	2.2 kg

### Scope of delivery

- RL 50 blind rivet tool
- Threaded mandrels: M4 / M5 / M6 / M8 / M10
- Nose pieces: M4 / M5 / M6 / M8 / M10
- Oil refill set
- Angled air supply
- Operating instructions
- Article No. 348 200 250

### Optional extras

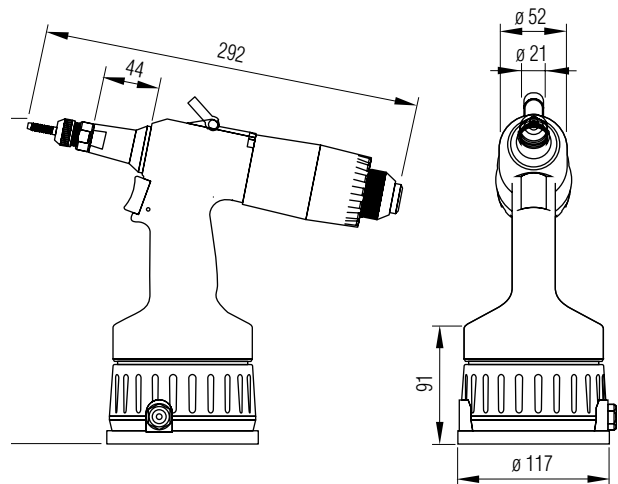
- RL 50A - with autospin function
- Article No. 348 200 300

- RL 50S - with tool-less stroke settings
- Article No. 348 200 400

### Working range

Blind rivet nuts	M3	M4	M5	M6	M8	M10	M12
Aluminium	•	*	*	*	*	•	•
Steel	•	*	*	*	*	•	•
Stainless steel	•	*	*	*	*	•	•

\* For use with blind rivet studs



### Spare parts / Consumables

Thread size	Nose piece Article No.	Threaded mandrel Article No.	Internal threaded mandrel Article No.
M3	348 213 870	348 203 870	
M4	348 214 870	348 204 870	348 224 000
M5	348 215 870	348 205 870	348 225 000
M6	348 216 870	348 206 870	348 226 870
M8	348 218 870	348 208 870	348 228 870
M10	348 220 870	348 210 870	
M12	348 222 870	348 212 000	

### Optional accessories

Description	Article No.
Hydraulic oil 1 l	460 299 870

# RL 50AS

Hydropneumatic blind rivet nut tool for installing M3 to M12 blind rivet nuts and M4 - M8 blind rivet studs

## Benefits at a glance

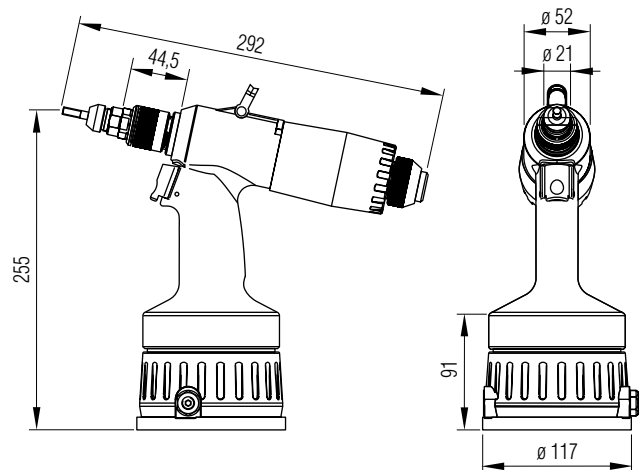
- Tool-less stroke settings
- Automatic spindling (“auto-spin”)
- Big on performance, small in size
- One-step trigger
- Infinitely adjustable stroke
- Easy to use; requires little maintenance
- Automatic spin-off after each installation
- Low-noise
- Air supply fittable on left or right
- Spin-off action can also be triggered manually
- Safety valve prevents operating pressure overload

## Technical specifications

Stroke:	1.5 - 5.8 mm
Insertion force:	23.5 kN at 6 bar
Installation force/Weight ratio:	10.7 kN/kg
Air consumption:	4.6 l/rivet
Air supply pressure:	5 - 7 bar
Air supply:	ø 6 mm (G1/4")
Weight:	2.2 kg

## Scope of delivery

RL 50AS blind rivet tool  
 Threaded mandrels: M4 / M5 / M6 / M8 / M10  
 Nose pieces: M4 / M5 / M6 / M8 / M10  
 Oil refill set  
 Angled air supply  
 Operating instructions  
**Article No. 348 200 500**



## Working range

Blind rivet nuts	M3	M4	M5	M6	M8	M10	M12
Aluminium	•	•*	•*	•*	•*	•	•
Steel	•	•*	•*	•*	•*	•	•
Stainless steel	•	•*	•*	•*	•*	•	•

\* For use with blind rivet studs

## Spare parts / Consumables

Thread size	Nose piece Article No.	Threaded mandrel Article No.	Internal threaded mandrel Article No.
M3	348 213 870	348 203 870	
M4	348 214 870	348 204 870	348 224 000
M5	348 215 870	348 205 870	348 225 000
M6	348 216 870	348 206 870	348 226 870
M8	348 218 870	348 208 870	348 228 870
M10	348 220 870	348 210 870	
M12	348 222 870	348 212 000	

## Optional accessories

Description	Article No.
Hydraulic oil 1 l	460 299 870

# RL 100

Hydropneumatic blind rivet nut tool for installing M6 to M16 blind rivet nuts and M6 - M8 blind rivet studs

### Benefits at a glance

- For use with sizes M6 - M16
- Big on performance, small in size
- One-step trigger
- Infinitely adjustable stroke
- Easy to use; requires little maintenance
- Automatic spin-off after each installation
- Low-noise
- Air supply fittable on left or right
- Spin-off action can also be triggered manually
- Safety valve prevents operating pressure overload
- Reliable and tried-and-tested

### Technical specifications

Stroke:	2.5 - 9.0 mm
Insertion force:	34.0 kN at 6 bar
Installation force/Weight ratio:	11.7 kN/kg
Air consumption:	6.2 l/rivet
Air supply pressure:	5 - 7 bar
Air supply:	ø 6 mm (G1/4")
Weight:	2.9 kg

### Scope of delivery

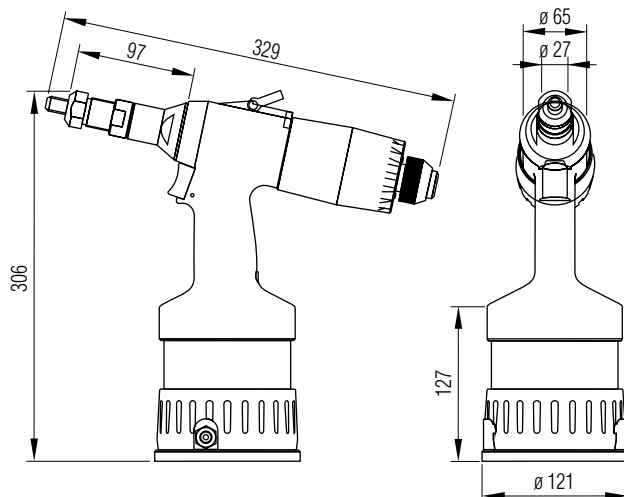
- RL 100 blind rivet tool
- Threaded mandrels: M8 / M10 / M12
- Nose pieces: M8 / M10 / M12
- Oil refill set
- Angled air supply
- Operating instructions
- Article No. 348 300 250

### Working range

Blind rivet nuts	M6	M8	M10	M12	M14	M16**
Aluminium	*	*	.	.	.	.
Steel	*	*	.	.	.	.
Stainless steel	*	*	.	.	.	.

\* For use with blind rivet studs

\*\* Always check first to see if the installation of M16 blind rivet nuts is possible.



### Spare parts / Consumables

Thread size	Nose piece Article No.	Threaded mandrel Article No.	Internal threaded mandrel Article No.
M6	348 382 870	348 381 870	
M8	348 318 870	348 308 870	
M10	348 320 870	348 310 870	
M12	348 322 870	348 312 870	
M14	348 324 870	348 314 870	
M16	348 326 870	348 316 870	

### Optional accessories

Description	Article No.
Hydraulic oil 1 l	460 299 870

# ProSert™ XTN20

Hydropneumatic blind rivet nut tool for installing M3 - M10 blind rivet nuts and M3 - M10 blind rivet studs

## Benefits at a glance

- Patented dual operating technology, with power control or motion control on request
- Flexible when using various thread sizes and grip ranges
- Focus on only a handful of tools in the workplace
- High power-to-weight ratio of 11.1 kN/kg
- Tool-less stroke and pressure settings
- No tools required to replace threaded mandrel
- Low maintenance due to high-strength threaded mandrels
- Practical spin-off button
- First-rate ergonomic handling
- Lightweight at just 1.59 kg



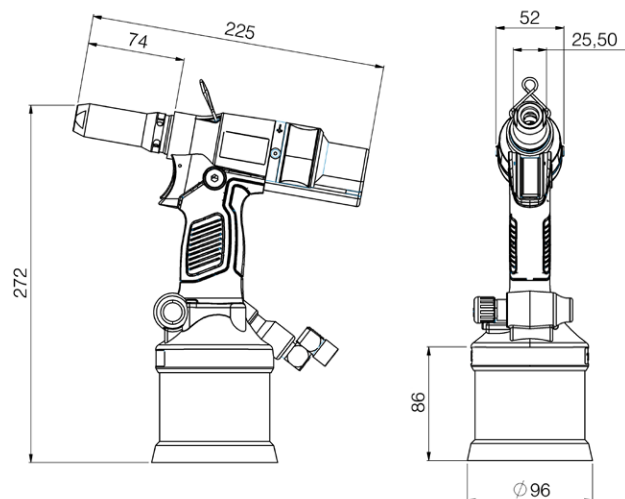
## Technical specifications

Stroke:	3.0 – 7.0 mm
Insertion force:	17.6 kN at 5 bar
Air consumption per rivet:	approx. 6.5 l
Air supply pressure:	5 – 7 bar
Air supply:	ø 6 mm (G1/4")
Weight:	1.6 kg

## Scope of delivery

ProSert XTN20 blind rivet nut tool  
Threaded mandrels: M4, M5, M6, M8  
Nose pieces: M4, M5, M6, M8  
Maintenance kit  
Operating Instructions  
Article No. 347 000 000\*

\* 1/4" air supply coupling sold separately



## Working range

Blind rivet nuts	M3	M4	M5	M6	M8	M10
Aluminium	•	•*	•*	•*	•*	•
Steel	•	•*	•*	•*	•*	
Stainless steel		•*	•*	•		

\* For use with blind rivet studs

## Spare parts / Consumables

Thread size	Pulling unit* complete Article No.	Nose piece Article No.	Threaded mandrel Article No.	Mandrel extended by 15 mm Article No.	Drive mandrel Article No.	Guide bush Article No.
M3	347 000 140	347 000 129	347 000 130		347 000 131	
M4	347 000 119	347 000 104	347 000 100		347 000 115	347 000 111
M5	347 000 120	347 000 105	347 000 101	347 000 901	347 000 116	347 000 112
M6	347 000 121	347 000 106	347 000 102	347 000 902	347 000 117	347 000 113
M8	347 000 122	347 000 107	347 000 103	347 000 903	347 000 118	347 000 114
M10				347 000 904		

\* All sizes come supplied with the required lock nut Article No. 347 000 108.

# RL 6100

Hydropneumatic hexagonal cutter for cutting hexagonal holes

### Benefits at a glance

- Big on performance, small in size
- Wall thicknesses: steel up to 5 mm and aluminium up to 6 mm
- Entire process triggered from one single button
- Sturdy design
- Easy to use; requires little maintenance
- Easy-change cutter
- Low-noise
- Air supply fittable on left or right
- Fixing point for balancer
- Safety valve prevents operating pressure overload

### Technical specifications

Stroke:	9 mm
Insertion force:	34 kN at 6 bar
Installation force/Weight ratio:	11.7 kN/kg
Air consumption:	6.2 l/hole
Air supply pressure:	5 - 7 bar
Air supply:	ø 6 mm (G1/4")
Weight:	2.9 kg

### Scope of delivery

- TIOS 6100\* hexagonal cutter
- Angled air supply
- Operating instructions
- Oil refill set
- Article No. 348 450 200\*

\* Supplied without stamp or nose piece.

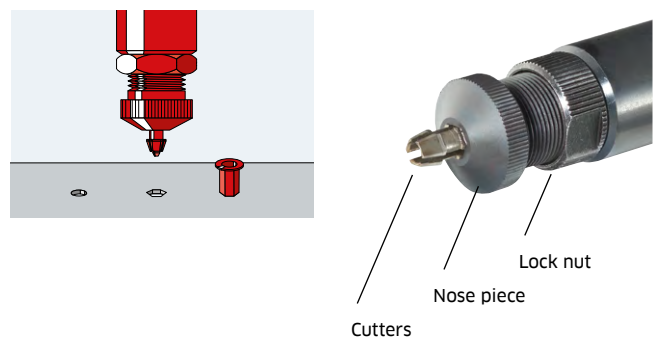
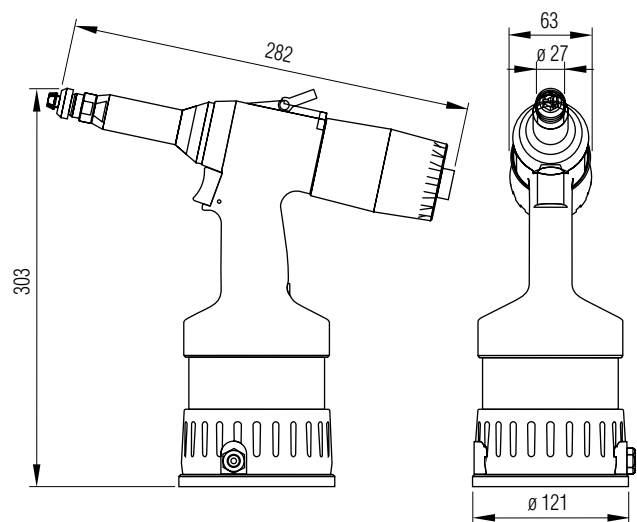
### Consumables

Description	Article No.
Nose piece M4	349 780 001
Cutter for M4 1 to 6 mm	349 764 000
Nose piece M5	349 781 001
Cutter for M5 1 to 6 mm	349 742 000
Nose piece M6	349 782 001
Cutter for M6 1 to 6 mm	349 743 000
Nose piece M8	349 783 001
Cutter for M8 1 to 6 mm	349 751 000
Nose piece M10	349 784 001
Cutter for M10 1 to 6 mm	349 771 870
M10 retooling kit	349 772 870

\* The M10 retooling set is required to retool to an M10 stamp.

### Optional accessories

Description	Article No.
Hydraulic oil 1 l	460 299 870



## Working range (material thickness in mm)

Thread size	Hexagonal hole SW** [mm]	Bore $\phi$ [mm]	Material	Material strength [Mpa]					
				100	200	300	400	500	600
M4*	6.1	6.2 - 6.4	Steel			5.8	5.0	4.5	4.0
			Duralumin (Al)	6.0	6.0	6.0	6.0	5.7	
M5*	7.1	7.2 - 7.4	Steel			5.0	4.3	3.9	3.5
			Duralumin (Al)	6.0	6.0	5.6	5.2	4.9	
M6*	9.1	9.3 - 9.5	Steel			4.1	3.5	3.2	2.9
			Duralumin (Al)	5.5	5.0	4.6	4.3	4.0	
M8*	11.1	11.3 - 11.5	Steel			3.5	3.1	2.8	2.6
			Duralumin (Al)	4.6	4.2	3.9	3.7	3.5	
M10*	13.1	13.3 - 13.5	Steel			3.0	2.6	2.4	2.0
			Duralumin (Al)	4.4	4.1	3.7	3.2	3.0	

\* Size of fastener, hole diameter prior to cutting

\*\* SW = wrench size from hexagon

## Hydraulic assembly press/unit

The hydraulic assembly press is ideal for securely installing self-clinching fasteners. The high-quality components ensure that the assembly press always runs reliably and requires little maintenance. With an installation force of 70 kN, every standard self-clinching fastener can be installed using this machine. With its extensive range of accessories, the LSC 7010 with HA 200 offers additional practical and economic means of working with metals, e.g. clinching, edging or chamfering.

### Benefits at a glance

- Optimum installation force settings
- Electronic and mechanical safety system
- The mechanical safety system makes the installation of non-conductive fasteners possible.
- Powered by standard mains supply (400V)
- Easy to use, quick retooling times
- Low maintenance and service
- Excellent price-to-performance ratio

## C-frame LSC 7010

### Technical specifications

Height:	1897 mm
Width:	812 mm
Depth:	1000 mm
Weight:	250 kg
Max. press-in force:	70 kN
Protrusion:	520 mm
Operating stroke:	130 mm

Article No. 463 300 201



## HA 200 hydraulic unit

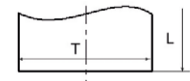
### Technical specifications

Height:	845 mm
Width:	515 mm
Depth:	670 mm
Weight:	110 kg
Max. pressure:	220 bar
Nominal voltage:	3/N/PE 400/230V AC
Rated frequency:	50 Hz
Rated current:	max. 4.0 A
Wattage:	1.5 kW

Article No. 463 300 200

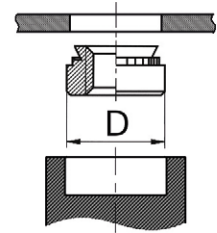
## pressti® die parts

Size	T [mm]	L [mm]	Weight approx. [kg/item]	Description	Article No.
Long	16	68	0.3	VI00001418	463 300 001
Short	16	34	0.3	VI00001417	463 300 002
Wide	50	32	0.4	VI00001666	463 300 003



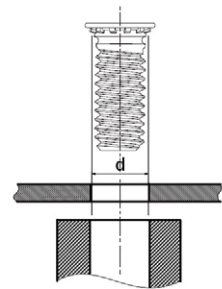
## pressti® template for self-clinching nuts

Thread size	D [mm]	Weight approx. [kg/item]	Description	Article No.
M2 / M2.5 / M3	6.3	0.3	VI00001426	463 300 004
M4	7.9	0.3	VI00001428	463 300 005
M5	8.7	0.3	VI00001429	463 300 006
M6	11.05	0.3	VI00001430	463 300 007
M8	12.65	0.3	VI00001431	463 300 008
M10	17.35	0.3	VI00001432	463 300 009



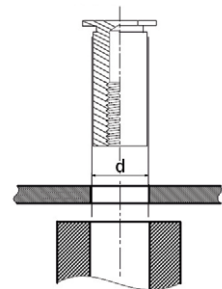
## pressti® template for self-clinching studs

Thread size	D [mm]	Weight approx. [kg/item]	Description	Article No.
M2.5	2.5	0.3	VI00001419	463 300 010
M3	3.0	0.3	VI00001420	463 300 011
M4	4.0	0.3	VI00001421	463 300 012
M5	5.0	0.3	VI00001422	463 300 013
M6	6.0	0.3	VI00001423	463 300 014
M8	8.0	0.3	VI00001424	463 300 015
M10	10.0	0.3	VI00001425	463 300 016

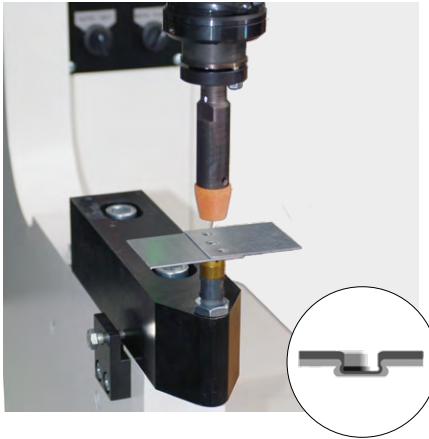


## pressti® template for self-clinching studs

Thread size	D [mm]	Weight approx. [kg/item]	Description	Article No.
M2 - M3	4.2	0.3	VI00001421	463 300 012
M3	5.4	0.3	VI00001422	463 300 013
M4 - M5	7.2	0.3	VI00001441	463 300 019

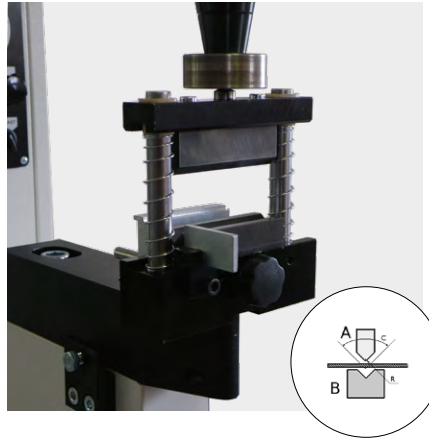


## Other possible uses for the LSC 7010



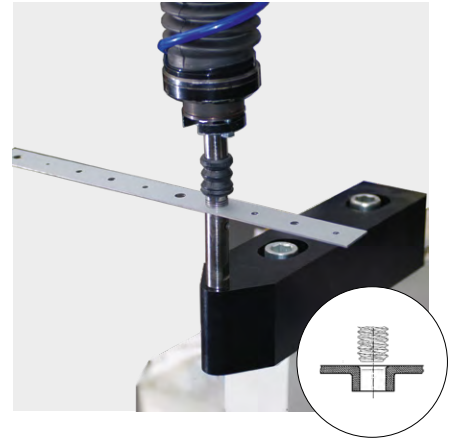
### Clinching / Metal joining:

This method replaces the conventional spot welding of thin sheeting.



### Bending / Chamfering:

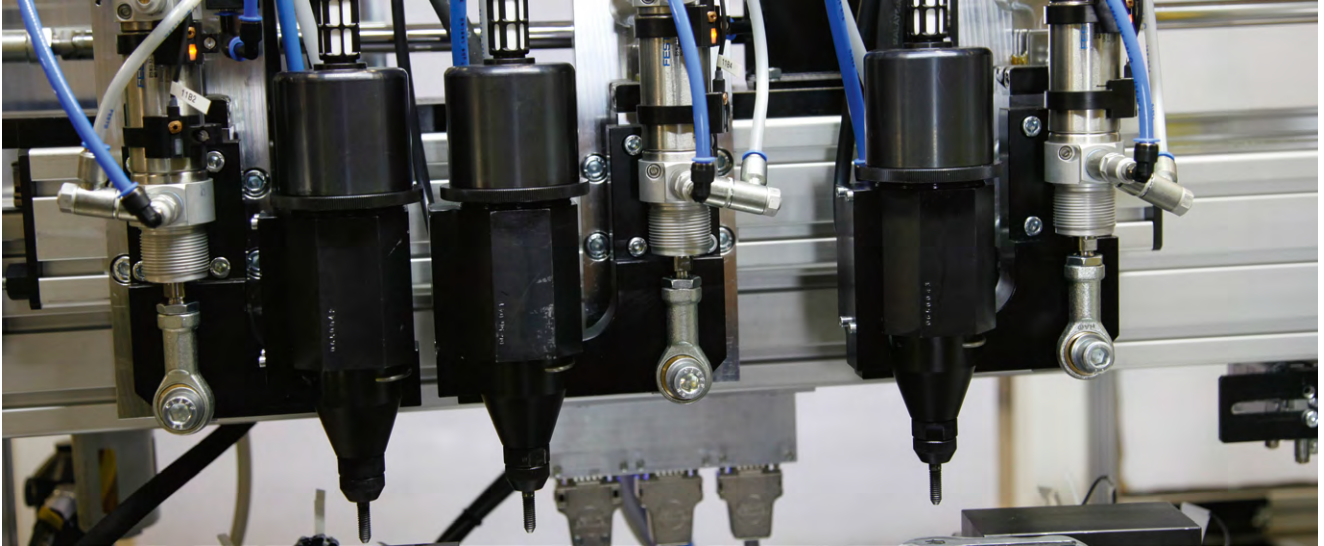
This press makes light work of bending and chamfering thin sheeting up to a maximum width of 80 mm and a thickness of 2 - 3 mm depending on the material. It also comes fitted with side and end stops. Depending on the requirements, these can be set to 9 - 70 mm.



### Edging:

This technology extends the surface when tapping thin sheeting of between 0.8 and 2 mm thickness.

## Bespoke semi-automatic and fully-automatic installation systems for the fastener range



Rivetec is a Titgemeyer Group subsidiary situated in Pisek, CZ. Our experts have been designing and manufacturing high-quality rivet tools, automation technology and assembly systems there for 25 years. Needless to say, all perfectly tailored to the every need of customers in the trades, industry and retail sector.

Our range includes rivet installation units, power units and control units as well as feeder systems and spent mandrel extractors. Through the modular system, individual components can be combined for each specific use. Our specialists will be happy to advise you on-site and provide you with customised solutions.

### Benefits at a glance

- Automatic sorting of fasteners
- Precise feeding of fasteners
- Integrated process control

Contact us if you are looking for rational fastening technology!

