



RIVCLINCH® (SPOT CLINCH®) 4006 P50 MAS

Cost effective, multi-purpose clinching machine

BÖLLHOFF

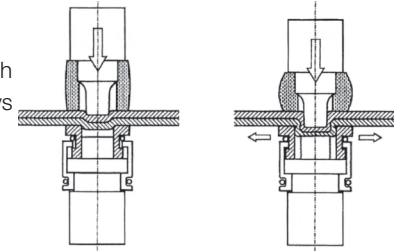
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Metal joining without fasteners

When clinching two or more layers of sheet metal, the material is plastically deformed inside a die through a squeezing process between the punch and the anvil. The joint is created as the material flows sideways pushing out the die walls.

The result is a high quality joint, without the need for consumables such as screws or rivets, and without disturbing the coating, thus eliminating the need for post touch-up work as occurs with welding.



Multi-purpose, high productivity clinching machine

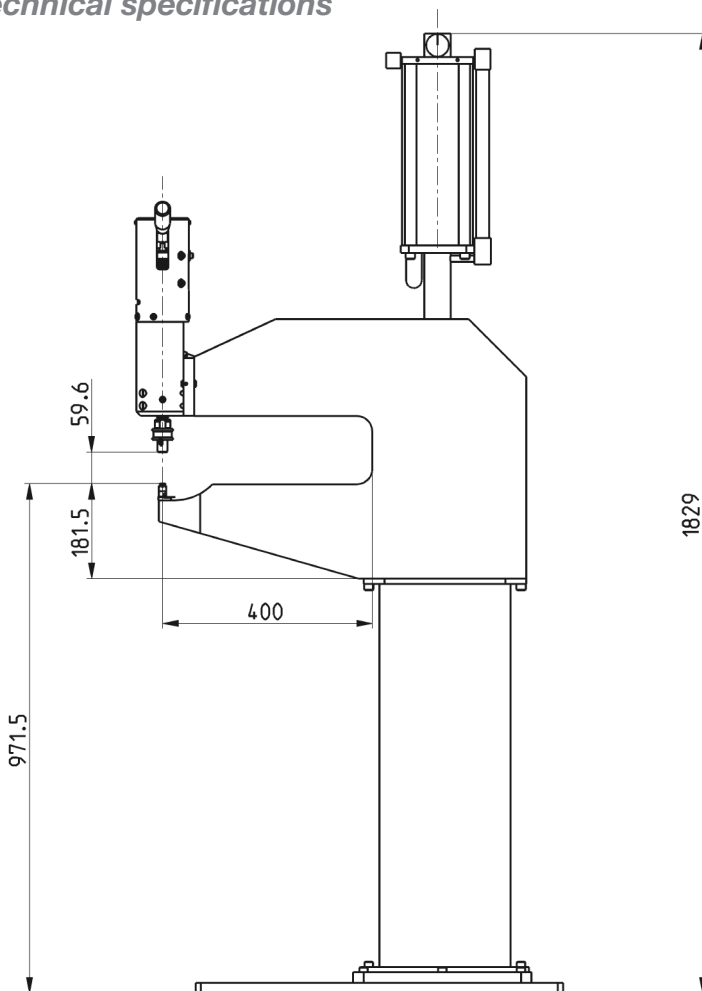
One of its unique features is the Manual Approach Stroke (MAS). A lever situated on the top right side of the cylinder is used to move manually the piston up and down for pre-positioning the tooling close to the joining area, and to allow a large access to work pieces up to 60 mm high. Once the piston is down, the punch gap is below 8 mm, and the foot pedal can be activated for the clinching operation at full force. In addition to the safety aspect, the MAS facilitates the positioning of the tool at the clinch joint location prior to clinching, and allows to makes series of joints at full speed without re-opening the full stroke at each clinch operation. As an option, the work cycle can be automatically controlled by an Optimized Cycle Controller (OCC) insuring that the clinch joint is completed in the shortest possible cycle time.

Wide range of applications

A wide range of patented RIVCLINCH® (SPOT CLINCH®) tool are available for this machine, allowing to joint thin sheet as well as thick material up to more than 4 mm total thickness, in most combination of materials such as mild steel, Aluminium and Copper.

Due to its long and thin lower jaw, this unit finds a large number of applications of joining metal components in the Building sector, HVAC, Appliances, Vehicles, Furniture, Electric and many other sectors.

Technical specifications



Accessories

The machine is delivered complete, ready to use. Only simple connection to 6 bars compressed air is required.

Tool kits

The tool kits must be selected from the original RIVCLINCH® (SPOT CLINCH®) series SR 603 (round) or ST502 (rectangular) based on the application. Other types of tool kits, for specific applications (Ventilation ducting, Filters, Stainless steel, Aluminum, and also other dimensions of tool kits are available. Ask for the latest Tool kit List by your distributor.

Weight	240 kg
Working air pressure	6 bar
Tool force at 6 bar	35 / 50 kN
Cycle time	1.0 - 1.2 sec
Work stroke	8 mm
Pre-stroke (manual)	52 mm
Depth of jaws	400 mm
Max. total sheet thickness, mild steel	4 mm
Max. total sheet thickness, Aluminum	5 mm
Max. total sheet thickness, stainless steel	3 mm

Products numbers

Designation	Part No
RIVCLINCH® (SPOT CLINCH®) 4006 P50 MAS	3 842 2107 710

