

UNIVERSAL PUNCH- AND RIVETING SYSTEM PNP 90 XT²

WHAT IS NEW?

Mehr Kraft / More Power

10 T.



PNP 90 XT²



The riveting evolution is based on PNP 90 UN 2.0

2-circuit-hydraulic-system

Compressive force

10 T.



8 T.
Traction



Processing of high-strength steels



Ca. 72 %

of the current Mercedes-Benz C-/ S-/ SL-/ E-Class bodyshell panels is made of high-tensile steel.



Source

<http://blog.mercedes-benz-passion.com/2009/04/passive-sicherheit-in-der-neuen-e-klasse/>

Use of existing riveting tools from PNP 90 UN 2.0

By assembling the special designed adapter set, it is possible to use already existing RIVKIT UN 2.0. Thus, the Hydraulic actuator XT2 is threaded accordingly and expresses a maximum of 60 kN.



Blind Riveting Adapter with Universaladaptation

25 kN

Also available with 60 kN setting force



Welding rod

Extension 160mm



Especially for areas which are difficult to reach and processing smaller working diameter.



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Advantages

- + Higher operation force of 10T
- + Easy handling by external pump-system
- + High Endurance and minimal wear / no further accessories or riveting cranes are needed
- + Rivetingtools are refixed by special alloy
- + Higher recirculation power of 8T
- + Further product characteristic have already been met
- + Mercedes-Benz approval
- + Official trolley supplied with the system
- + Upgradeable from PNP90 UN 2.0 to PNP 90 XT²
- + RIVKITS of PNP 90 UN 2.0 are suitable to the new hydraulic actuator (operating pressure gets regulated automatically)
- + Universal punching- and rivetingsystem
- + Processing of high-strength steels



Upgrade possibilities

UPGRADE-KIT BASIC*

- Pump Retool Kit
- Hydraulic Actuator XT²
- Duo-Hose Package DN4-XT²
- Rivet Clamp NB 45
- Riveting Tool Kit 2 „Punching“
- Adapter Kit 60 kN



* Additional costs will be incurred by upgrading the existing PNP 90 UN 2.0 (effort circa 20 - 30 minutes).

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Technical Comparison

PNP 90

- + Upgrade ready PNP 90 UN 2.0 > PNP 90 XT²
- + Low maintenance
- + Long lifetime
- + Covers all common riveting processes



	UN 2.0	XT ²
Setting force „extend“	max. 60 kN / 6 T	max. 100 kN / 10 T
Setting force „retract“	-	max. 80 kN / 8 T
Travel	15 mm	50 mm
Length	330 mm	330 mm
Width	230 mm	260 mm
Height (incl. handle)	213 mm	213 mm
Operating pressure	max. 600 bar	
Input pressure	6 Bar / 87 PSI	

Hydraulic Actuator

- + Processing of high-strength materials
- + Combination with existing riveting tools is possible
- + Push Pull Function
- + Quick and easy change of punching dies



	HP 35 UN	HA XT ²
Travel	15 mm	50 mm
Length	50 mm	65 mm
Width	117 mm	185 mm
Height (incl. handle)	213 mm	213 mm
Hydraulic	1-Circle-Hydraulic	2-Circle-Hydraulic

Rivet Clamps PNP 90 UN 2.0



	NB 40	NB 115	NB 230
Clamp opening	80 mm		140 mm
Opening depth	40 mm	115 mm	230 mm
Length	106 mm	213 mm	364,1 mm
Width	45 mm	44 mm	44,5 mm
Height (incl. handle)	158,8 mm	220,3 mm	347,9 mm
Weight	1,5 kg	3 kg	9,5 kg
Locking mechanism	Ball Lock Pins		

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Rivet Clamps
PNP 90 XT²

- + Large opening depth
- + Conical shutter
- + High endurance



	NB 45	NB 115	NB 230
Clamp opening	80 mm		140 mm
Opening depth	45 mm	115 mm	230 mm
Length	120 mm	230 mm	390 mm
Width	75 mm	75 mm	75 mm
Height (incl. handle)	160 mm	210 mm	350 mm
Weight	2,5 kg	6,2 kg	11,6 kg
Locking mechanism	Conical		

Riveting tools PNP 90 UN 2.0 & PNP 90 XT²



RIVKIT UN 2.0



RIVKIT UN 2.0
BMW EDITION



RIVKIT UN 2.0
AUDI EDITION

AVAILABLE SOON: Jaguar-RIVKIT

Riveting tools PNP 90 XT²

RIVKIT XT² - Kit 1 "PUNCHING"



Approved by
Daimler AG.



Riveting tools PNP 90 XT²

RIVKIT XT² - Kit 2 "FLOW FORM RIVET"



Approved by
Daimler AG.



UNIVERSAL PUNCH- AND RIVETING SYSTEM PNP 90 XT²

Travel	20 mm
Setting force	24,5 kN / 2,45 T
Weight	0,8 kg
Length (adjustable)	200 mm (109 - 273 mm)
Width	37 mm
Height	62 mm
Operating pressure (hydr.)	max. 600 Bar
Operating pressure (pneum.)	6 Bar / 67 PSI
Suitable for	PNP 90 UN 2.0 PNP 90 SNW XT ²
Universaladaption (ø-Stud)	1,8 - 4,4 mm

Blind Riveting Adapter BNW 25 kN
modular & universal



The fast and universal way to fix blind rivets.

Blind Riveting Tool
with Universal Adaption + Accessory Kit



+ Fast affixing of blind rivets

The simple way to process areas which are difficult to access.

Tool Kit BNW 25 kW [hard-to-reach]
+ For hard to reach areas



Studs

- ø 3,6 - 4,4 mm
- ø 1,8 - 2,3 mm
- ø 2,3 - 3,0 mm
- ø 4,0 - 4,2 mm



Ejector

Tool kit for Blind rivet nuts, 25 kN-Edition, stroke controlled

- M 5
- M 6
- M 8
- M 10
- M 10 LH
- M 12



M 6 - coarse thread

