

# Pneumatic Component Heads



## Automated Assembly Components

Multiple heads can be incorporated into an engineered automated assembly system combining part feeding and rivet setting operations. Our in-house engineering staff has many years experience and can solve your most difficult assembly problems and find solutions to improve product and assembly efficiency.

↑ The Model 1500 is an air cylinder powered rocker arm style setter that will compensate for work thickness variation, but also has an adjustable down stop to control the rivet set height if desired.

↑ When nested or grouped in a cluster, two or more Model 1500's are capable of setting multiple rivets as close together as 3/4" on center. This machine is specially designed to rivet fragile parts and brittle materials and fasten assemblies where parts may vary in thickness. Setting pressures are easily controlled.

↑ The Model 1600 utilizes an air cylinder powered toggle link mechanism which drives the rivet to a positive setting height as the links straighten out. An optional spring compensator can be built into the top pivot pin to accommodate varying work thicknesses.

↑ The Model 1600 has a narrow frame which allows nesting of multiple heads enabling setting of rivets as close as 2" on center when mounted on a common base.

↑ The Offset version of the Model 1600 is specially suited for applications where a rivet is set close to a flange or other clearance problem.

↑ Like other National Riveters, Models 1500B, 1600B and 1600B Offset can be customized to your specific needs and requirements. Check with National's Engineering Department. Chances are excellent that they have a solution for you based on experience and the most modern equipment available today.



Model 1500

### Model 1500 Specifications

<b>Rivet Capacity</b>	.058" dia. x .406" length, min. .156" dia. x .625" length, max.		
<b>Throat Depth</b>	12"		
<b>Stroke</b>	2"		
<b>Hopper</b>	Rotary		
<b>Cycle Time</b>	1 second		
<b>Upset Force</b>	2400#		
<b>Power</b>	Pneumatic/115v controls		
<b>Operating Air Pressure</b>	40 - 80 P.S.I. (variable)		
<b>Weight</b>	150#		
<b>Bench Space</b>	H: 36"	W: 10"	D: 24"