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### El-12-84-C-Series / 84" C-Frame Riveter



### El-12-84-C-Series

Electroimpact, Inc. is pleased to offer an 84" Stationary C-Frame Drill Rivet Machine. The Drill Rivet Machine offers a larger part processing capability and can be supplied with various options to meet your manufacturing needs. Ease of set-up and tool-changes with minimum downtime and Automatic Feed System with various tooling makes the Drill Rivet Machine a standard for rivet installation.

# EI-12-84-C Series Drill and Rivet Machine

## Standard Features

- C-Frame 84 Inch Throat Depth
- Maximum Cycle Time 4.5 Seconds Clamp to Unclamp
- Stationary Mounted Platform Fork Lift Mounts
- Work Height Approximately 71 Inches
- Capable of Installing Universal, Flat Head, Modified Universal Head Rivets, and Hi Set Rivets from – 5 to –6 grip diameters with Proper Tooling
- One Upper Anvil Assembly -5 Rivet Size
- One Pressure Foot Bushing -5 Rivet Size
- One Straight (Stake) Lower Anvil -5 Rivet Size
- Approx. Ft. Print 42.0" W X 106.0"H X 171.00" L
- Approx. Weight 18,000 lbs.
- Three Position Head (Drill/Countersink, Sealant, and Rivet)
- Adjustable Forced Air Chip Blowers
- Capable of Drilling Aluminum, Steel, and Titanium Alloys
- Drill Spindle to Accept Acura Flex Collets
- Countersink Depth Selection in 0.0005 Inch Increments
- Variable Drill Feed Adjustable from 2-96 IPM
- Adjustable Drill Speed from 0 to 6000 RPM
- Countersink Adjustment Range .75 Inches
- DC Servo Motor Spindle Drive
- Adjustable (software) dwell delay of 0-5 seconds
- Laser Spot Locator
- Sealant Insertion Station
- Pneumatic Control Sealant Dispenser "Semco"
- Quick Change Sealant Tips "Semco"
- Alternate Probe Station with Options Selected.
- Upset Force of 12,000 (Capable of –8 (1/4" rivet installation)
- G200 Tooling Capability
- Adjustable Clamp Force from 50 to 300 Pounds
- Maximum Stack Thickness .500 Inches
- Deep Drop Daylight Opening of 7 Inches
- Quick Change Lower Tooling Mount
- Manual Tool Rotation of 360 degrees
- Lower Tool Force Air Chip Blowers
- Upset Force Air/Oil
- Clamp stroke 1.00 inches (25.4mm)
- Tipped Rivet Detection Switch
- Clamp Safety and Over Travel Switches
- Deep Drop Control Switch
- Direct Logic Programmable Controller
- Machine Cycle Timer
- Machine Cycle Counter
- Digital RPM Display
- Set Up, Tool Change, and Run Modes
- Front Fixed Operator Interface Terminal
- Operators Control Panel Touch Screen
- Operating Power 110VAC, 20AMPS
- 120 VAC Duplex Outlets 2 Each
- Modem For Remote Troubleshooting
- Tandem Foot Switch Controls With Emergency Stop Button

- Compress Air: 85-100 psi, 50 to 100 CFM
- Pneumatic Master Air Shut Off, Air Filter and Dry Air Regulator Unit
- Mini-Hopper Feed Units
- Quick Change Brackets
- Missing Rivet Detector

### **Optional**

- Cassette Rivet Feed System
- Bin-Hopper Feed System
- Rivet Clear System
- Automatic Fastening System Vibratory Feeder Bowls /Orientor Injectors
- Allen Bradley Programmable Logic Controller
- Siemens Programmable Logic Controller
- Soft-touch Operators Station/With Help Feature Mounted on a Multi-Link Moveable Arm
- Camera system (one each upper and lower camera with monitors)
- Ethernet Communication for Remote Troubleshooting
- Safety Light Curtains
- Operating Power 220VAC Single Phase or 220VAC 3 Phase
- Lower Ram Grip Sensing via Encoder, Displayed in Grip Length Increments/Inches
- Adjustable Drill Speed from 500 to 12,000 RPM
- Broken Drill Detector
- Optional Four Position Head (Drill/Countersink, Sealant, Probe, Rivet) Or Dual Drill Spindles with Shave Capability
- Drill Lubrication System
- White Light Rivet Spot Locator
- Work light High Intensity Halogen Lamp
- Probe Station For Locating Pre-Drilled Holes
- Vortex Drill Chiller with Pulse Timer
- Resilient/Retractable Pressure Foot Bushing
- Rotatable Pressure Foot Bushing
- Shatterproof Guard Upper Head / Safety Switch Interlocks
- Upper Tooling Pressure Foot Bushing Clearance 2.5 Inches