

## **DIXON AUTOMATIC TOOL, INC.**

Products for Automated Assembly

# **BMS SERIES**

# Fully automatic Setting Unit for Blind Rivet Nuts with Patented Quality Control

Mfr. Stöger Automation

Sales Representative in USA, Canada and Mexico For 24 years

The setting system with force-displacement measurement for the automatic installation of Blind Rivet Nuts and Blind Rivet Bolts prove their versatility, performance level and total cycle time of 8 seconds. The compact design with a closed housing to protect against dust and the quick tool change underline our commitment to economic feasibility. The automated process for setting Blind Rivet Nuts is monitored 100%. The system can be used in a stationary setting, in transfer systems, rotary table systems, or robot systems. The Blind Rivet Nuts are singulated in a feed system as bulk materials and automatically feed into the correct position via a flexible feed hose in relation to the setting unit.



#### THE ADVANTAGES AT A GLANCE:

- The patented torque test checks the secure fitting of the rivet after drawing.
- The functionality of the thread is tested for ease of movement both when turning in and turning out. Rivets that are detected as faulty when winding in are automatically ejected and replaced. An error message is issued for threads that are detected as faulty when winding out.
- The search function for the hexagonal Blind Rivet Nuts facilitates precision positioning in the workpiece.
- Breakage of the drawing tool is immediately detected by the system and reported.
- The drawing tool is a commercially available standard screw; there is not need for expensive spare parts.
- The drawing tool can be changed within just 10 seconds without the need for any auxiliary tools.
- Automatic feeding of the fastening elements.



### **Technical Data**

	BMS 6252	BMS 6600	
Size	M5-M10*	M5-M14*	
Feed Stroke	125mm	125mm	
Drawing Force	25 kN	60 kN	
Weight	31.5 kg	Approx. 65 kg	

\*Standard other sizes possible.

#### **Modules**

All data mm	BMS 6252	BMS 6600
Length (A)	860	1185
Distance of drawing tool to lower edge installation plate (B)	approx. 50	approx. 45
Total feed stroke (C)	approx. 125	approx. 125
Setting axle Protection (D)	180	180
Distance of drawing tool installation plate (E)	53.5	70
Installation plate width (F)	180	215
Minimum distance for twin spindle implementation	70	105

- Servo drive (for drawing 5. Loading device tool)
  Serve drive (for turning)
  Setting head with integrated stroke
- 2. Servo drive (for turning)
- 3. Installation plate 7. Drawing tool
- 4. Integrated load cell

### **Tool Change Functionality**







Press the locking bar, pull down the support sleeve at the same time.

Remove the screw tool sideways.

Insert the tool, apply support sleeve and latch into place.



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