

Atlas Copco Riveting Systems

Air dampened – Hard riveting with a soft touch



Atlas Copco

Minimum vibration, maximum productivity

Atlas Copco's top-of-the-line riveting systems are designed to minimize the riveter's exposure to vibration, while maintaining high tool performance. The RRH recoilless riveting hammer has an air cushion behind the hammer piston which efficiently kills vibrations. The same air dampening technique is used in RBB bucking bars. It raises individual productivity and boosts output in your plant.

The Atlas Copco riveting system includes vibration-damped hammers RRH and bucking bars RBB – as well as conventional riveting hammers RRN.

The vibration-damped riveting hammers – RRH – are available in different sizes.

Each size is available in "Trigger start" and "Push to start" models.

The conventional riveting hammer – RRN – is available in one size: RRN11P.

Critical factors

The number of blows and the power are critical factors which determine the strength of a riveted joint. A few powerful blows are needed to fill out the hole and form a head when upsetting the rivet. The impact force is critical to some extent when working with aluminum alloys, as too many blows can embrittle the metal.

In terms of capacity, the tools overlap. The selection guide below helps you to find the right tool for your particular application of riveting.

The vibration-damped bucking bars RBB are available in two versions – the simple spring damped – SP type and the air servo assisted SA type.



Selection Guide

Hammer model ^a	Nominal Max. Rivet Diameter Capacity						Bucking bar model required ^b	
	Dural		Steel		Titanium			
	mm	in	mm	in	mm	in		
RRN11	2-5	3/32 - 3/16	1-4	3/32 - 5/32				
RRH04	2-5	3/32 - 3/16	1-4	3/21 - 5/32			RBB04	RBB10
RRH06	4-7	5/32 - 1/4	3-6	1/8 - 1/4	2-4	3/32 - 5/32	RBB10	RBB16
RRH08	5-8	3/16 - 5/16	4-7	5/32 - 1/4	3-6	1/8 - 1/4	RBB10	RBB16
RRH10	5-9	3/16 - 3/8	6-8	1/4 - 5/16	4-7	5/32 - 1/4	RBB16	
RRH12	8-11	5/16 - 7/16	7-10	1/4 - 3/8	6-9	1/4 - 1/8	RBB16	
RRH14	11-13	7/16 - 1/2	9-12	3/8 - 15/32	8-11	5/16 - 7/16	RBB16	

^a Hammer capacity depends on direct/indirect riveting as well as Panel density and stiffness.

^b Bucking bar capacity is dependent on dolly weight.

RRH is a unique series of riveting hammers incorporating completely revolutionary ergonomic advantages.

- **Versatile** – RRH can easily cope with rivets in diameters up to 13 mm.
- **Vibration-damped system** – The RRH vibration-damped riveting hammer, combined with the RBB vibration-damped bucking bar, offer an unbeatable system for riveting.
- **Adjustable power.**
- **Adjustable hand guard** – Support hand grip is vibration-damped.
- Now new models with trigger start for excellent handling. Pistol grip with rubber coating.



Model	Blows Hz	Nozzle		Piston dia		Stroke		Energy per blow		Weight		Air consumption		Hose size		Air inlet BSP	Ordering No.
		mm	in	mm	in	mm	in	J	ft lb	kg	lb	l/s	cfm	mm	in		
With push start																	
RRH04P-01	66	10.0	0.4	15	0.6	40	1.6	2.0	1.5	1.0	2.2	3.7	6	6.3	1/4	1/4	8426 1109 07
RRH04P-02	66	10.2	0.4	15	0.6	40	1.6	2.0	1.5	1.0	2.2	3.7	6	6.3	1/4	1/4	8426 1109 15
RRH04P-12	66	10.2	0.4	15	0.6	40	1.6	2.0	1.5	1.0	2.2	3.7	6	6.3	1/4	1/4	8426 1109 25
RRH06P	36	10.2	0.4	15	0.6	102	4.0	6.0	4.4	1.3	2.9	9.0	19	10.0	3/8	1/4	8426 1110 04
RRH08P	24	10.2	0.4	15	0.6	137	5.4	8.0	5.9	1.4	3.0	10.0	21	10.0	3/8	1/4	8426 1110 09
RRH10P	25	12.7	0.5	19	0.7	118	4.6	13.0	9.6	2.0	4.4	12.0	24	10.0	3/8	1/4	8426 1110 20
RRH12P	20	12.7	0.5	19	0.7	153	6.0	16.0	11.8	2.1	4.6	13.0	28	10.0	3/8	1/4	8426 1110 47
RRH14P	18	12.7	0.5	19	0.7	188	7.4	19.5	14.4	2.2	4.8	13.0	28	10.0	3/8	1/4	8426 1110 80
With trigger start																	
RRH04P TS-12	66	10.2	0.4	15	0.6	40	1.6	2.0	1.5	1.0	2.2	3.7	6	6.3	1/4	1/4	8426 1109 27
RRH06P TS	36	10.2	0.4	15	0.6	102	4.0	6.0	4.4	1.3	2.9	9.0	19	10.0	3/8	1/4	8426 1110 66
RRH08P TS	24	10.2	0.4	15	0.6	137	5.4	8.0	5.9	1.4	3.0	10.0	21	10.0	3/8	1/4	8426 1110 68
RRH10P TS	25	12.7	0.5	19	0.7	118	4.6	13.0	9.6	2.0	4.4	12.0	24	10.0	3/8	1/4	8426 1110 70
RRH12P TS	20	12.7	0.5	19	0.7	153	6.0	16.0	11.8	2.1	4.6	13.0	28	10.0	3/8	1/4	8426 1110 72
RRH14P TS	18	12.7	0.5	19	0.7	188	7.4	19.5	14.4	2.2	4.8	13.0	28	10.0	3/8	1/4	8426 1110 81

-01 means 10 mm short shank rivet set.

-02 means 10.2 mm short shank rivet set.

-12 means 10.2 mm stand shank rivet set.

Conventional Type

Riveting Hammers

For riveting in confined spaces we recommend our RRN11 riveting hammer.

- **RRN11** – is the smallest riveting hammer available on the market, with unique accessibility.
- **Adjustable** – The RRN11 has a built-in adjustment knob with which you can set the power for different rivet materials and sizes.
- **Controllable** – The trigger is easily operated and provides excellent control.



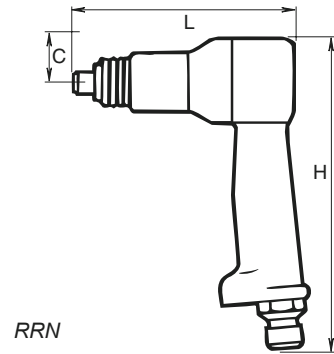
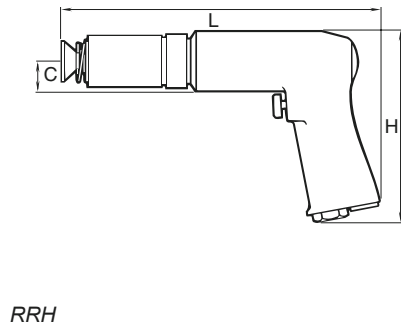
Model	Blows Hz	Nozzle		Piston dia		Stroke		Energy per blow		Weight		Air consumption		Hose size		Air inlet BSP	Ordering No.
		mm	in	mm	in	mm	in	J	ft lb	kg	lb	l/s	cfm	mm	in		
RRN11P-01	66	10.0	0.4	15	0.6	40	1.6	2.0	1.5	1.2	2.6	3.4	7.2	6.3	1/4	1/8	8426 1101 05
RRN11P-02	66	10.2	0.4	15	0.6	40	1.6	2.0	1.5	1.2	2.6	3.4	7.2	6.3	1/4	1/8	8426 1101 13

-01 means 10 mm short shank rivet set.

-02 means 10.2 mm short shank rivet set.

Dimensions

Model	L mm	H mm	C mm
RRH			
RRH04-01	160	147	23
RRH04-02	160	147	23
RRH04-12	175	147	23
RRH06	225	147	24
RRH08P	244	147	24
RRH10P	264	150	27
RRH12P	299	150	27
RRH14P	334	150	27
RRN			
RRN11P	100	170	23



Accessories Included

For RRH models

Hose fitting
Flush set
Open spring retainer

For RRN11P

Hose fitting and retainer
Blank rivet set
Retainers for blank and flush rivet set

Optional Accessories

Rivet sets. RRH and RRN

Hammer type	Model	Shank mm	Flush set Ordering No.	Blank rivet set Ordering No.
RRH04P-01 RRN11P-01	(-01)	10.0 spec	3085 0347 00	3006 0983 00
RRH04P-02 RRN11P-02	(-02)	10.2 spec	3085 0352 00	3085 0353 00
RRH04P-12 RRH06P RRH08P	(-12)	10.2 std	3085 0324 00	3085 0022 00
RRH10P RRH12P RRN14P		12.7 std	3085 0323 00	3085 0021 00
RRH04P-12 RRH06P RRH08P		10.2 std		Mandrel blank 3085 0212 00
RRH04P-12 RRH06P RRH08P		10.2 std		3085 0212 02

Kits for conversion to trigger start operation

Model	Ordering No.
RRH04P-12	3520 0363 80
RRH06/08P	3520 0210 81
RRH10/12P/14P	3520 0364 80

An efficient riveting system consists of vibration-damped bucking bars together with vibration-damped riveting hammers.

- **Self-adjustable** – RBB10SA and RBB16SA feature a self-adjusting damping system which requires a compressed air supply. RBB04SP, RBB10SP and RBB16SP use a spring as damping element and consequently do not require an air supply.
- **Flexible** – The bucking bars can be fitted with several different interchangeable dolly configurations via a quick change retainer for maximum flexibility.
- **Cramped spaces** – Mini bucking bars RBB04SP are ideal for work in confined spaces. The large mass types -04, -05 will in most applications set the rivet faster than the smaller models.



Model	Weight		Diameter		Air consumption		Ordering No.
	kg	lb	mm	in	l/s	cfm	
With standard dolly^a							
RBB10SA	1.3	2.9	48	2.0	0.5	1.1	8426 9101 77
RBB10SP	1.1	2.4	48	2.0	–	–	8426 9101 74
RBB16SA	1.9	4.2	48	2.0	0.5	1.1	8426 9101 78
RBB16SP	1.7	3.7	48	2.0	–	–	8426 9101 76
Without dolly and rod							
RBB10SP-U	0.9	2.0	48	2.0	–	1.1	8426 9101 86
Mini bucking bars							
RBB04SP-01	0.8	1.8	46	1.8	–	–	8426 9101 10
RBB04SP-04	1.3	2.9	46	1.8	–	–	8426 9101 13
RBB04SP-05	1.4	3.1	46	1.8	–	–	8426 9101 14
RBB04SP-06	1.1	2.5	46	1.8	–	–	8426 9101 15

^a Standard dolly assy (3085 0335 93).

Accessories Included

All SA-models

Hose and hose fitting

All 10/16 models

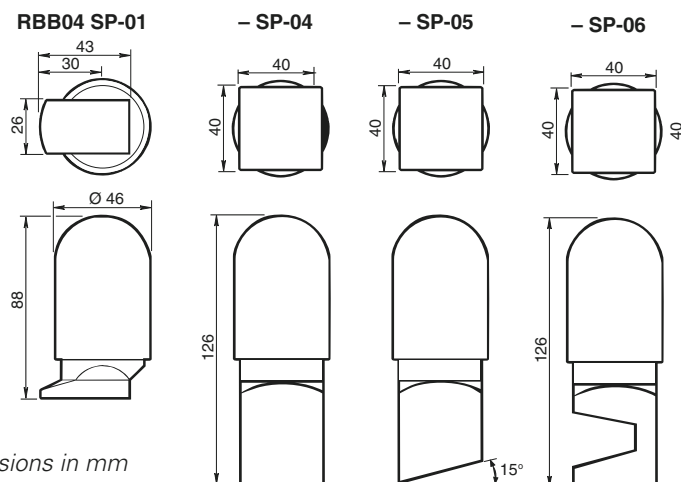
Plastic cover

Optional Accessories

Designation	Ordering No.
Rod 5 mm	3085 0365 03
Rod 50 mm	3085 0365 04
Rod 100 mm	3085 0365 05
Plastic cover for	
RBB10SA	3520 0317 00
RBB10SP	3520 0315 00
RBB16SA	3520 0318 00
RBB16SP	3520 0316 00

Dimensions

Dimensions Mini bucking bars



Dimensions in mm

Dimensions RBB10/16

Model	L mm	H mm	C mm
RBB10SA/SP	165	49	140
RBB16SA/SP	200	49	198

