The bdtronic heat staking technology BHS Hot Jet® is an economic joining technology for joining thermoplastics. A riveting head with hot air nozzle, inside quick-change stamp, highly accurate temperature regulation allows homogeneous heating up of the riveting pin to the suitable forming temperature and hence to maximally strong joint. Individual process control, a specifically developed coating and unique stamp design ensures a non-stick effect and low maintenance as well as repeatable production processes.
CONTROL

- High performance hot air generator
- Integrated panel control
- Easy-to-use touch interface
- User management
- Error management with clear text messages
- Data logging of error messages
- Process analysis
- Unlimited program memory
- On-screen process data
- Maintenance function
- Profibus/Profinet optional
- Temperature regulation in ms
- Stamp management
- Intuitive process programming
- Process parameter handing over

RIVETING HEAD

- Heating tube for homogeneous heating around the pin through hot air
- Riveting head with quick-change-system
- Integrated precise riveting stroke
- Variable forming force
- Maintenance friendly
- Non-stick effect
- Long shelf life of stamp due to special coating

PROCESS CONTROL/PROCESS ANALYSIS

- Position control over complete riveting stroke
- Distance measurement or riveting movement
- Temperature monitoring
- Gas flow monitoring and regulation
- Accuracy distance measurement +/- 0,1mm
- End position monitoring

SET POINTS

- Forming force 20-90N
- Working temperature range up to 350°C
- Temperature deviation +/-5°C
- Gas flow rate hot air 30-100 nl/min

(Errors and changes reserved, as of February 2019)