

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
RRH06	4-7	5/32 - 1/4	3-6	1/8 - 1/4	2-4	3/32 - 5/32	
RRH08	5-8	3/16 - 5/16	4-7	5/32 - 1/4	3-6	1/8 - 1/4	
RRH10	5-9	3/16 - 3/8	6-8	1/4 - 5/16	4-7	5/32 - 1/4	
RRH12	8-11	5/16 - 7/16	7-10	1/4 - 3/8	6-9	1/4 - 3/8	
RRH14	11-13	7/16 - 1/2	9-12	3/8 - 15/32	8-11	5/16 - 7/16	

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

^b Bucking bar capacity is dependent on dolly weight.

Vibration-damped

Riveting Hammers

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	Airframe ref	Blows per minute	Rivet set shank		Piston dia		Stroke		Energy per blow		Weight		Air consumption		Hose size		Air inlet	Ordering No.
			mm	in	mm	in	mm	in	J	ft lb	kg	lb	l/s	cfm	mm	in	BSP	
With push start																		
RRH04P-01	2X	3960	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 1111 07
RRH04P-02	2X	3960	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 1111 15
RRH04P-12	2X	3960	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 1111 25
RRH06P	3X	2160	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 1111 04
RRH08P	4X	1440	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 1111 09
RRH10P	5XB	1500	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	7XB	1200	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	9XB	1080	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	2X	3960	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 1111 27
RRH06P TS	3X	2160	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 1111 66
RRH08P TS	4X	1440	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 1111 68
RRH10P TS	5XB	1500	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	7XB	1200	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	9XB	1080	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
RRH12P TS -ENG	7XB	1200	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 49
RRH14P TS -ENG	9XB	1080	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 82

-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.



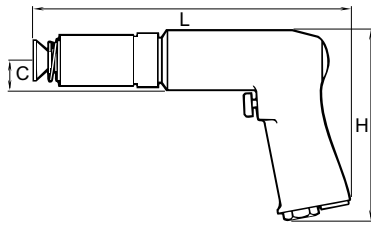
Model	Airframe ref	Blows per minute	Rivet set shank		Piston dia		Stroke		Energy per blow		Weight		Air consumption		Hose size		Air inlet	Ordering No.
			mm	in	mm	in	mm	in	J	ft lb	kg	lb	l/s	cfm	mm	in	BSP	
RRN11P-01	2X	3960	10.0	0.4	15	0.6	40	1.6	2.0	1.5	1.2	2.6	3.4	7.2	6.3	1/4	1/8	8426 1101 05
RRN11P-02	2X	3960	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.

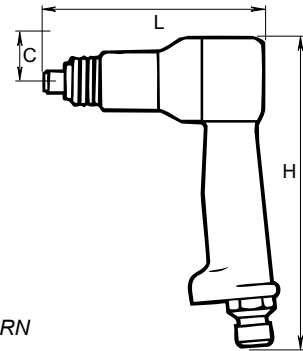
-02 means 10.2 mm short shank rivet set.

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



RRH



RRN

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 RRH14P		12.7 std		3085 0323 00		3085 0021 00
RRH04P-12 RRH06P RRH08P		10.2 std				3085 0212 00 Mandrel blank
RRH04P-12 RRH06P RRH08P		10.2 std				3085 0212 02

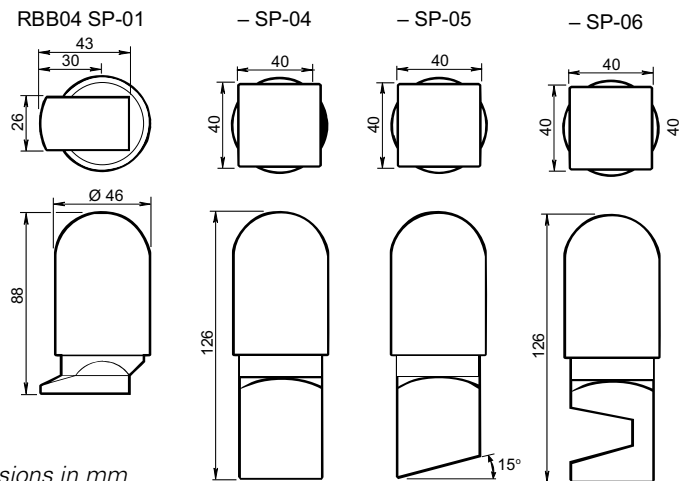
An efficient riveting system consists of vibration-damped bucking bars together with vibration-damped riveting hammers.

- **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		Ordering No.
	kg	lb	mm	in	
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

Dimensions



Dimensions in mm