



The **experience of decades** and **continuous improvement** made the successful HONSEL/VVG tools of the BZ- and VNG-series become reliable utilities for industrial volume productions as well as for specialist shops and handcraft.

The **sturdy construction** and **complete equipment** with all necessary conversation parts plus **comprehensive accessories** up to **process controled automation systems** leave nothing to be desired.

Latest development “**designed by Honsel**” is the modern type battery tool “**Rivdom**” on [page 129](#).

9<sup>1</sup> **Pneumatic-Hydraulic Tools for Blind Rivets (BZ-Series)**

9<sup>2</sup> **Battery Tool for Blind Rivets (Rivdom)**

9<sup>3</sup> **Pneumatic-Hydraulic tools for Blind Rivet Nuts and Blind Rivet Bolts (VNG-Series)**



9 1

# Pneumatic-Hydraulic Tools for Blind Rivets

## BZ 103 A

Pneumatic-Hydraulic Tool  
with permanent and intervall  
mandrel exhaustion



Thousandfold Approved – the latest  
version of the standard tool for  
reliable processing of blind rivets



- noise reduced
- optimized ergonomics
- new package
- all necessary spare parts included
- new instruction manual

	2,4	3,0	3,2	4,0	4,8	5,0	6,0	6,4	8,0
Aluminium									
Steel									
Stainless steel									
Copper alloys									
<b>Content</b>	<ul style="list-style-type: none"> <li>• 4 nosepieces</li> <li>• 1 set of clamping jaws</li> <li>• 1 bottle hydraulic oil / incl. re-fill unit</li> <li>• 2 mandrel collectors</li> </ul>						pressure: 5-7 bar	max. mandrel-ø: 3,8 mm	
special accessory ▶ page 138							stroke : 18 mm	air consumption: 2,4 L	
							noise: < 75 dB(A) <sub>(68,32)</sub>	working power at 7 bar: 11700 N	
							1,8 kg	hose connection: G 1/4 inside, installation left or right side	
							CE		

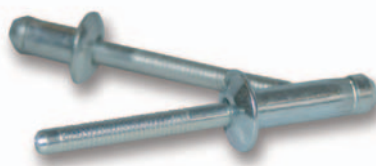
No. 320.103.000.000



For useful air pressure accessory take a look on ▶ page 128.

For an optimized processing of our structural FERRO®-BULB blind rivets on pages 40+41 the pneumatic-hydraulic tool BZ 133A is available on request.

This tool offers a **perfect adjustment** of the stroke (18 mm) and the working power (24.000 N) combined with adapted clamping jaws to the grooves of the mandrel. This guarantees powerful handling with reduced abrasion.





**The Strong Tool - even suitable for high strength blind rivets**



**BZ 123 A**  
Pneumatic-Hydraulic Tool  
with permanent and intervall  
mandrel exhaustion



- noise reduced
- optimized ergonomics
- new package
- all necessary spare parts included
- new instruction manual



	2,4	3,0	3,2	4,0	4,8	5,0	6,0	6,4	8,0
				Aluminium					
				Steel					
				Stainless steel					
				Copper alloys					
<b>Content</b>				pressure: 5-7 bar	max. mandrel-ø: 4,8 mm				
• 4 nosepieces				stroke: 25 mm	air consumption: 3,5 L				
• 1 set of clamping jaws				noise: < 75 dB(A) <sub>(68,32)</sub>	working power at 7 bar: 18700N				
• 1 bottle hydraulic oil / incl. re-fill unit				2,34 kg	hose connection: G 1/4 inside, installation left or right side				
• 2 mandrel collectors				CE					
special accessory ▶ page 138									

No. 320.123.000.000



▶ The BZ 123A handles **high strength blind rivets** of the Honsel/ VVG series FER0-BULB and FER0-BOLT (pages 42-45) perfectly.

BZ-Series



## BZ 102 / 103 Axial Pneumatic-Hydraulic Tool with permanent and intervall mandrel exhaustion

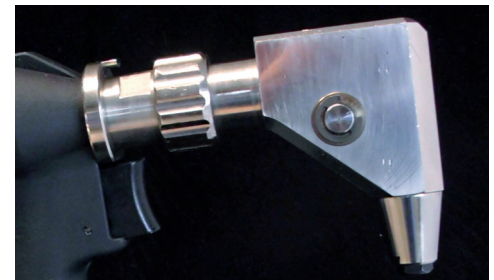
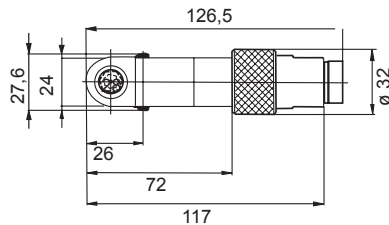
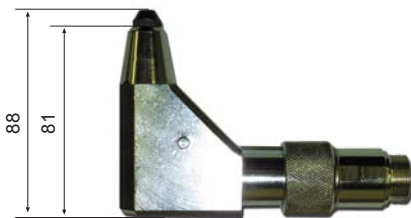


	2,4	3,0	3,2	4,0	4,8	5,0	6,0	6,4	8,0
Aluminium									
Steel									
Stainless steel									
Copper alloys									
weight	2,1 kg								
height		365 mm							
stroke			18 mm						
max. mandrel-ø							3,8 mm		
tensile force at 7 bar	11700 N								
noise			< 75 dB(A) <sub>(68,32)</sub>						
pressure			5-7 bar						
air consumption							2,4 litre		
content	4 nosepieces 1 re-fill unit		1 set of clamping jaws 1 mandrel collector				1 bottle hydraulic oil		
hose connection	ø 1/4" inside, installation left or right side								
options	<ul style="list-style-type: none"> <li>• balancer</li> <li>• mandrel conduction hose</li> <li>• mandrel conduction adapter</li> <li>• mandrel conduction box</li> </ul>								

The new option for axial handling with the approved pneumatic-hydraulic tools of the Honsel/VVG BZ-series.

No. 320.102.000.000/5

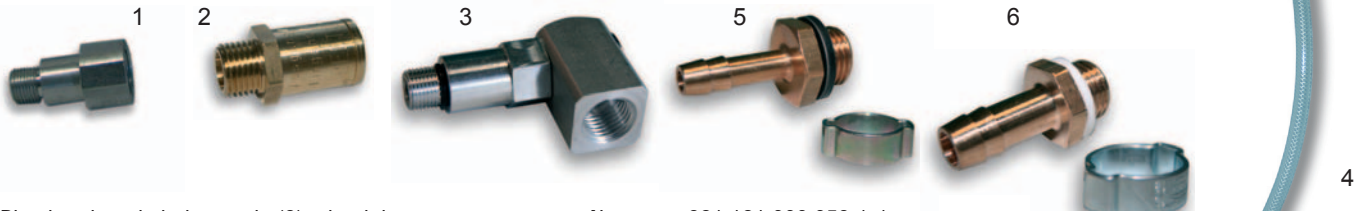
## Rivet Angle Head for BZ Blind Rivet Tools



Rivet angle heads for difficult to reach positions are available on request.

No. 321.102.000.600

## For optimized handling we suggest the following accessory for all HONSEL-/VVG-Tools:



- Pivoting threaded pipe angle (3), aluminium No.: 321.121.000.053 1-1
- Pivoting threaded pipe angle (3), stainless steel No.: 321.121.000.053 2-1
- Valve extension (1) No.: 321.121.000.052 1-1
- Pressure reducing valve (2) No.: 321.000.141.360 1-1
- Pivoting threaded pipe angle (3) including fabric tube with 1/4" external thread and hose coupling (4) No.: 321.121.000.053 3-1
- Screw-in hose connector -set- G 1/4" 6 mm (5) No.: 321.121.000.057 1-1
- Screw-in hose connector -set- G 1/4" 9 mm (6) No.: 321.101.000.058 1-1

Additional connections for compressed-air available on request



For undisturbed operation Honsel-/VVG-Tools need a continuous, periodic maintenance. Make sure that for BZ-Tools clean and dry, for VVG-Tools clean and lubricated compressed air is available. We advise the use of filter pressure reducers (BZ) or compressed-air service units (VVG).

- Compressed-air service unit (Pressure reducer/ oil fog lubricator (VVG-Serie) No.: 320 847 000 000
- Pressure reducer (BZ-Series) No.: 320 848 000 000

Additional accessory as for example balancer, spiral coiled tubes or compressors are available on request. Spare parts, special nosepieces or useful special attachments are shown in ► chapter 10, pages 135 et sqq.



## RIVDOM Battery Tool for Blind Rivets

### THE NEW DIMENSION OF INDEPENDENT BLIND RIVET HANDLING



Note: Picture above shows Rivdom with LI-ION battery -large- (321.400.000.021)



Battery -large-  
14,4V / 3,0 Ah



Battery -standard-  
14,4V / 1,5 Ah

Sturdy plastic case with metal locks in an attractive sales packaging



Premium, compact  
quick-charger

- LI-ION battery -standard- (14,4V / 1,5 Ah)  
No. 321.400.000.020
- LI-ION battery -large- (14,4V / 3,0 Ah)  
No. 321.400.000.021
- Rivdom quick-charger  
No. 321.400.000.001

	2,4	3,0	3,2	4,0	4,8	5,0	6,0	6,4	8,0	
Aluminium	[Color bar]									
Steel	[Color bar]									
Stainless steel	[Color bar]									
Copper alloys	[Color bar]									
<b>content</b>	<ul style="list-style-type: none"> <li>• 4 nosepieces</li> <li>• 1 mandrel collector</li> <li>• 1 battery 14,4V / 1,5 Ah</li> <li>• 1 quick-charger 14,4V</li> </ul>						1,54 kg 0,33 kg 0,53 kg		max. mandrel-ø: 3,4 mm working power: 9000 N stroke: 21 mm charging time 1,5 Ah: < 1 hour	
<b>optional</b>	<ul style="list-style-type: none"> <li>• battery 14,4V / 3,0 Ah</li> </ul>									



No. 320.400.000.000



## VNG 703 Pneumatic-Hydraulic Tool *force controlled*



**New Version - Force controlled**  
**User-friendly design - easy handling**



- noise reduced
- optimized ergonomics
- new package
- all necessary spare parts included
- new instruction manual

- the control by the adjustment of the necessary power guarantees an optimal and gentle setting of the blind rivet nut
- fast processing
- automatic screwing of the blind rivet nut by a slight push on the trigger
- automatic remove of the blind rivet nut after operating
- perfectly suited for the treatment of **OPTO-multigrip blind rivet nuts** (► pages 64/65)



	M3	M4	M5	M6	M8	M10	M12
	Aluminium						
	Steel						
	Stainless steel						
	Steel						
<b>Content</b> • conversation kits for blind rivet nuts • 1 bottle hydraulic oil / incl. re-fill unit	<b>pressure:</b> 5-7 bar		<b>air consumption:</b> 4,4 l				
	<b>stroke:</b> 9 mm		<b>revolutions per minute:</b> screwing 1800 removing 2500				
	<b>noise:</b> < 75 dB(A) <sub>(68,32)</sub>		<b>working power at 7 bar:</b> 20000 N				
	2,5 kg						
	special accessory ► page 139						
			<b>hose connection:</b> G 1/4 inside, installation left or right side				

No. 320.703.000.000



## VNG 753 Pneumatic-Hydraulic Tool

- Special tool with extra big stroke for processing of **SFM-PL folding blind rivet nuts** (► page 71)

For details about this tool and the handling please contact our country representations or the VVG sales team.





**The Powerful Solution.  
Well engineered - perfect stroke adjustment**



**VNG 903**  
Pneumatic-Hydraulic Tool  
stroke controlled



- noise reduced
- optimized ergonomics
- new package
- all necessary spare parts included
- new instruction manual



	M3	M4	M5	M6	M8	M10	M12
		Aluminium					optional
		Steel					optional
		Stainless steel					optional
		Steel					
<b>Content</b>	<ul style="list-style-type: none"> <li>• conversation kits for blind rivet nuts</li> <li>• 1 bottle hydraulic oil / incl. re-fill unit</li> </ul>		<b>pressure:</b> 5-7 bar <b>stroke:</b> 9 mm <b>noise:</b> < 75 dB(A) <sup>(68,32)</sup> 2,7 kg	<b>air consumption:</b> 7,5 l <b>revolutions per minute:</b> screwing 1800 removing 2500 <b>working power at 7 bar:</b> 29000 N			
special accessory ▶ page 139				<b>hose connection:</b> G 1/4 inside, installation left or right side			

No. 320.903.000.000

- automatic screwing of the blind rivet nut by pushing on the mandrel
- adjustable removing time
- automatic screwing-stop



For useful air pressure accessory take a look on ▶ page 128.

## Big Stroke Tool for Folding Blind Rivet Nuts

	M3	M4	M5	M6	M8	M10	M12
				Steel			
<b>hose connection:</b> G 1/4 inside, installation left or right side	<b>pressure:</b> 5-7 bar <b>stroke:</b> 8-15mm 2,9 kg		<b>air consumption:</b> <b>revolutions per minute:</b> screwing 1800 U/min. removing 2500 U/min. <b>working power (7 bar):</b> 19000 N				

No. 320.753.000.000





Honsel Umformtechnik GmbH is a manufacturer of joining elements and delivers also, in its capacity as system supplier, riveting equipment and units.

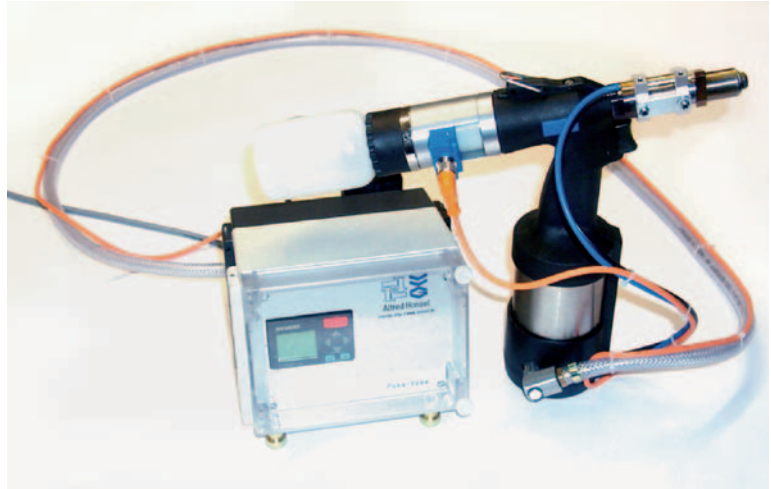
The spectrum covers manually operated riveting units, partly automated solutions and fully automatic riveting systems.

On request, the riveting equipment can also be equipped with "DMSD" process monitoring or with the "Poka-Yoke" system.

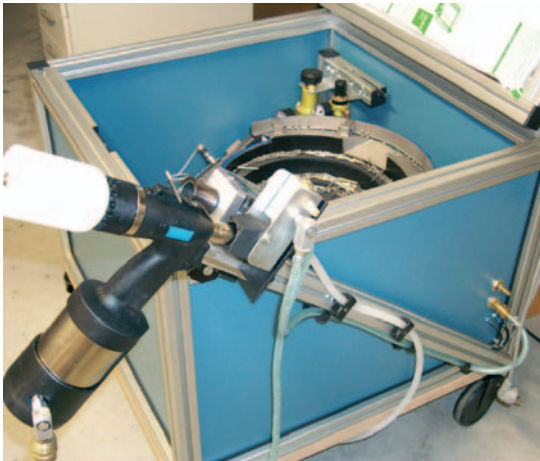
Not only ready solutions are taken from the kit in order to meet the customer requests.

Also special machines are developed completely after customers' need.

On base of tested systems, customized solutions are developed. Also modernizations and expansions of existing installations are among the special performances.



Rivet tool BZ 101 A Poka-Yoke



Partly automated feeding system ALFOMATIC BZ 101 A

An integrated strain gauge measuring strip (DMS) for the force measurement and an integrated distance measuring system make it possible to record and check the entire force-distance curve of the setting process and if the correct number of rivets has been placed.

The process result of DMSD USB process monitoring is equipped with a Honsel control and will be displayed on a two-colored LED at the rivet tool.

A PC with the DMSD PC program is required to visualize the force-distance curves and adapt them to the setting process.

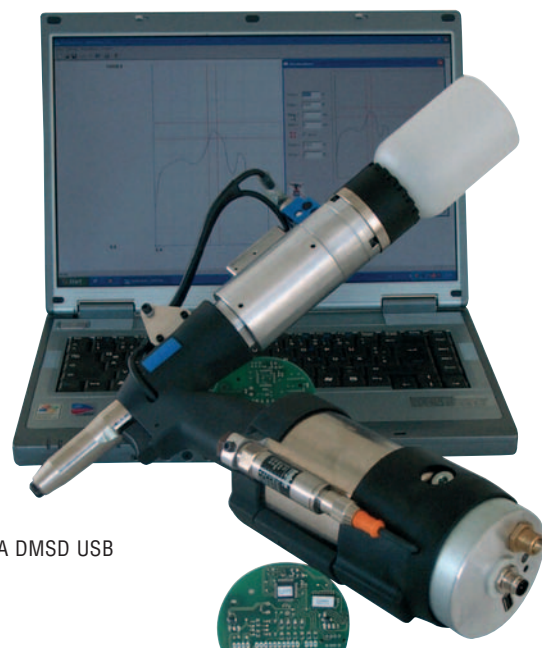
The current version of DMSD process monitoring is equipped with an Siemens PLC S7 313C and a touch panel TP277.

The force-distance curves have already been visualized by the touch panel.

Further possibilities are: switches on/of, the profi-bus, processing of a barcode, printing of labels and storage of the process data.



Tool for rivet nuts VNG 802 DMSD



Rivet tool BZ 101 A DMSD USB

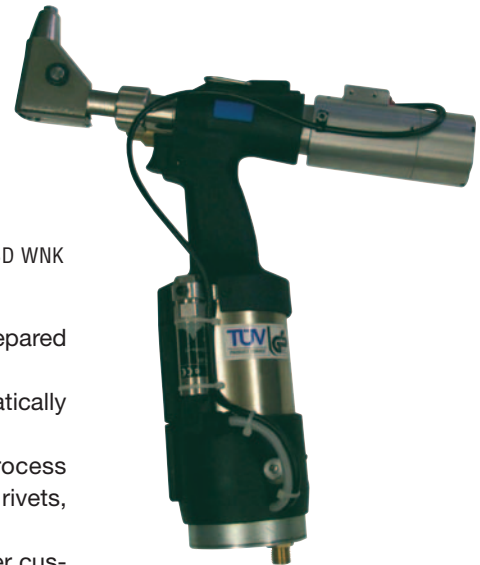




RivSys VNG 802 DMSD  
at the robot

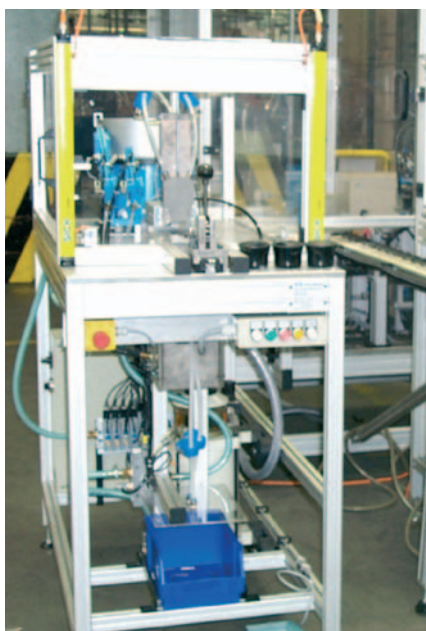


Rivet component Riwo BZ 121 A

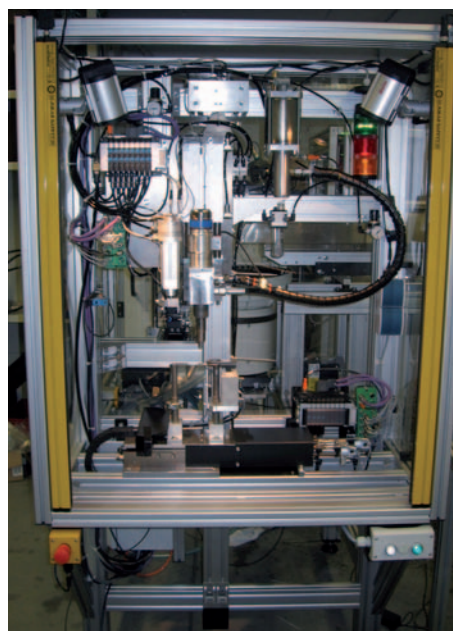


Rivet tool BZ 101 A DMSD WNK

Special nose pieces, extended front sleeves and different angular heads are prepared for badly accessible prefabricated parts. For the industrial application, the torn-off mandrel will be suctioned off automatically in a big mandrel container after the riveting process. The fully automatic rivet feeding system, the process automation and the process monitoring are important components for the full automatic processing of blind rivets, special rivets, blind rivet nuts, blind rivet bolts and expander plugs. Besides the component delivery, also complete rivet machines are realized after customized requests.



Double riveting machine



Rivet nuts component Riwo VNG 802 DMSD



Work on the rivet appliance in standing

Special machines



## HONSEL-SERVICE-CENTER

Besides development and production of pneumatic-hydraulic tools or custom machines as shown on the pages before, HONSEL-VVG provides a fast, professional and comprehensive service by well trained and experienced maintenance and repair specialists.

In addition we support our customers covering all questions for a smooth, long-standing operation with

- spare parts
- repair tools
- repair and handling trainings (on request)
- rental machines
- videos
- spare part lists and drawings
- repair instruction and manuals

to keep your HONSEL-VVG-tool running!

