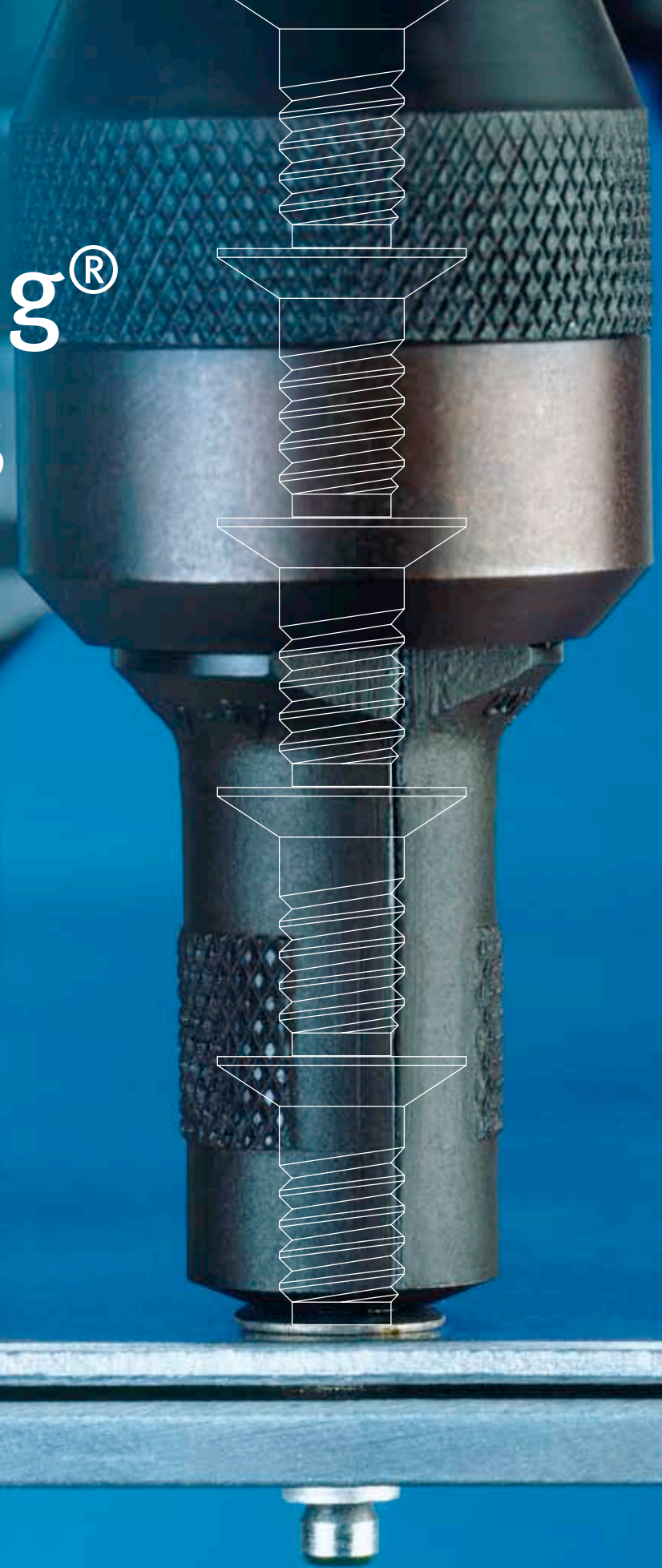
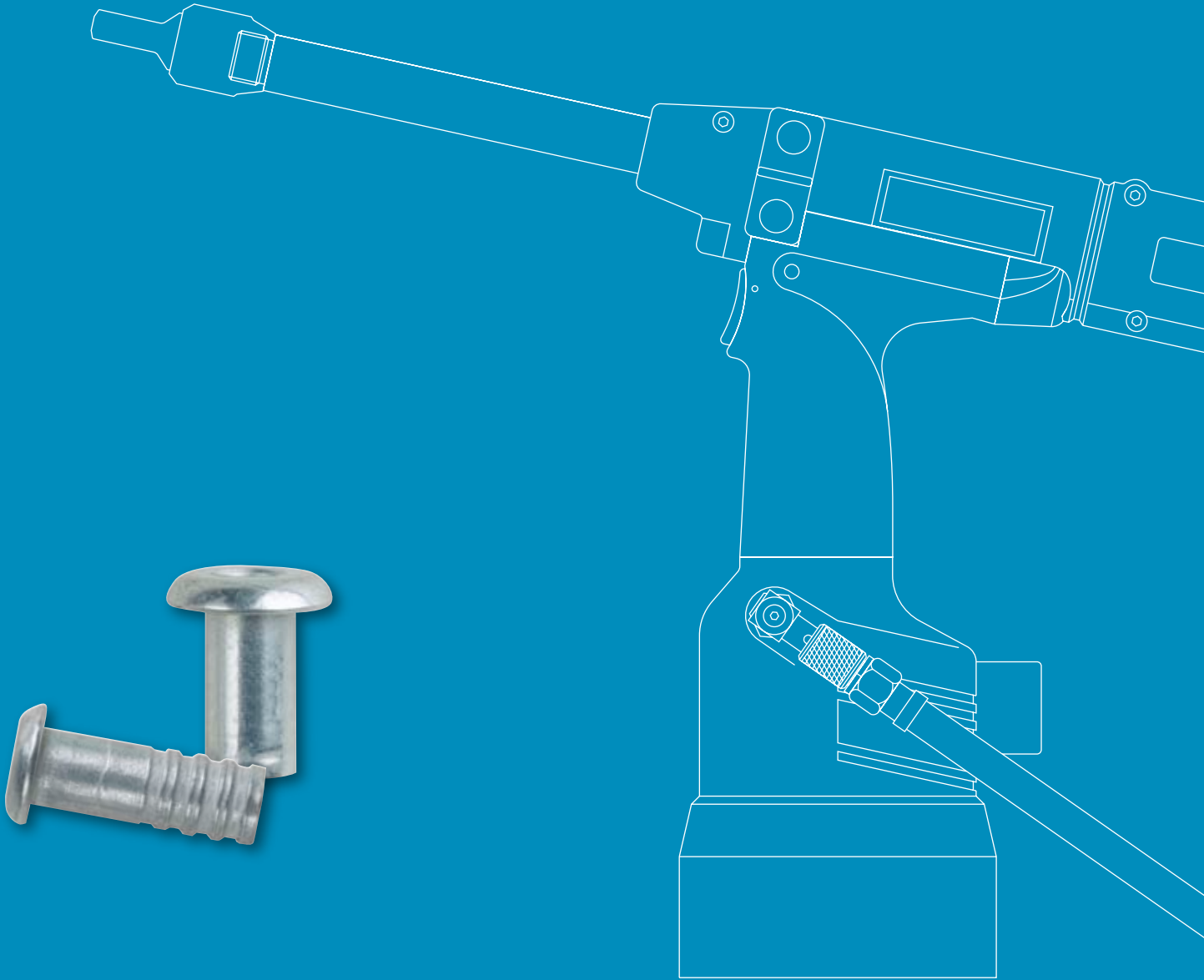


Speed Fastening[®] Systems





Reduce Assembly Costs

For fast and reliable assembly processes Avdel Speed Fastening® technology offers the most effective blind fastening solution.

High precision, system-compatible function, ease of operation and quick processes are guaranteed because you can fasten continuously from magazine or bowl fed fasteners and thus place up to 60 fasteners per minute.

Avdel Speed Fastening® Systems can be used to assemble metal and plastics, composite material and electronic components. With an average cycle time of less than two seconds these systems provide a fast installation from one side (blind).

Avdel Speed Fastening® Systems provide the possibility to significantly cut your assembly cost: short cycle times increase the productivity, and the intrinsic reliability of the process reduces rework and other quality costs. Avdel Speed Fastening® Systems are suited for use in small, medium and large batch processes as well as continuous production lines.

For smaller batches Avdel offers a choice of powertools and simple assembly workstations. For larger batches, multihead systems offer a cost effective solution. For continuous flow lines Avdel has the technology to develop fully automated assembly systems. In every case we not only see ourselves as a provider of fasteners, tools and machines but as a development and system partner with the objective of helping our customers improve their assembly performance.

Together with our customers we develop blind fastening systems that simplify your production process and improve the quality of your products.

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Avdel® Speed Fastening® Systems

Avdel speed fastening is a unique assembly system designed for rapid and reliable fastening in medium and high volume applications.

Originally designed for the aviation industry, Avdel Speed Fastening® Systems are now used by many of the world's foremost manufacturing companies in sectors as diverse as household goods, lighting, electronic subassemblies, light metal fabrication and automotive. Avdel speed fasteners are available in a wide range of materials, finishes, lengths and diameters and are ideal for fastening metals, plastics, composites and electronic components.

Speed fasteners are single piece fasteners which are either magazine fed or fed via a vibrating bowl to a wide choice of installation equipment. This ranges from the ultra-lightweight 753 handtool to fully automated, state of the art assembly systems.

Benefits of assembly

Increased manufacturing throughput

An Avdel Speed Fastening® System can be fully optimised to give cycle times of less than two seconds. This rapid, blind sided process delivers a throughput up to four times greater than a traditional threaded or riveted solution.

Reduced component handling

The fasteners are fed via a magazine or into a bowl feeder. This eliminates the need for individual component handling, saves time and reduces the potential for operator injury.

No component spillage

Because the fasteners are held captively they should not be dropped onto the floor or into the application. This avoids wasted time and improves product quality while improving the working environment.

No stem loss

Traditional breakstem fasteners all too often suffer from stem loss once installed. This can lead to application rattle, electrical short circuits or worse. Speed fasteners have no stems.

Improved joint quality

Speed installation technology provides a consistent, repeatable joint. What's more, unlike threaded fasteners, there is no requirement for torque control – no more problems of stripped holes or loose joints.

Improved joint performance

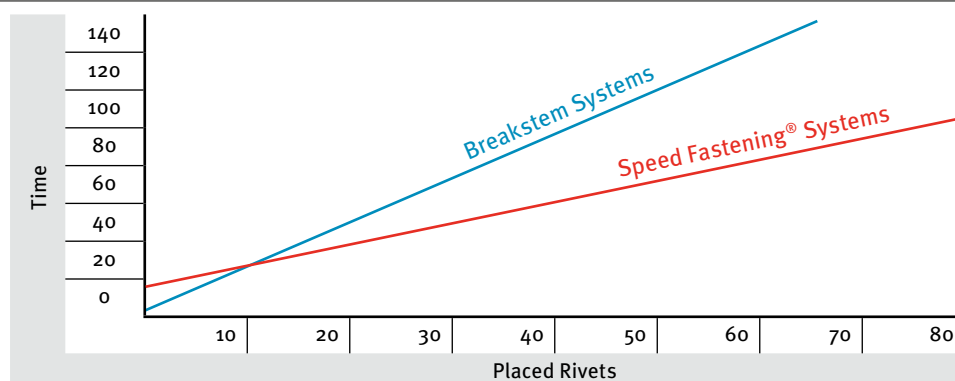
Once installed speed fasteners give excellent clamp up, shear and tension performance. They are also virtually immune from vibration loosening.

Process flexibility

Avdel Speed Fastening® Systems can be used for low volume, off-line batch or jobbing shop work through to flow line processes. From hand held tools to multiheaded modular workstations, we can design a Speed Fastening® System to suit your assembly requirements. A wide variety of products in many industries are assembled with these systems including automotive, electronics, domestic appliance and general industrial.

Time Analysis

Avdel® Speed Fastening® is the more efficient system after only 10 placed rivets.



Range Overview

Brand		Material	Key features
Briv®		Aluminium Alloy Steel Stainless Steel Brass	Bulbed tail Large headform High clamp and shear
Rivscrew®		Steel	Threaded fastener Removable with hex key and reusable Fastens into materials up to Vickers hardness 105 Hv5
Chobert®		Aluminium Alloy Steel Brass	Internal tapered bore Controlled clamp High shear Ideal for soft and brittle materials
Grovit®		Aluminium Alloy Steel	Designed for blind hole applications Annular grooves on body For use in wood, plastics, fibreglass and aluminium
Avtronic®		Brass Aluminium Alloy	Attaches DIN 41612 connectors and other components to PCBs Annular grooves on body
Avsert®		Brass	Threaded stand-off pillars for PCBs Internally threaded bore Many stand-off heights
Avlug®		Brass	Solderable terminal posts for PCBs Rolled/knurled shank

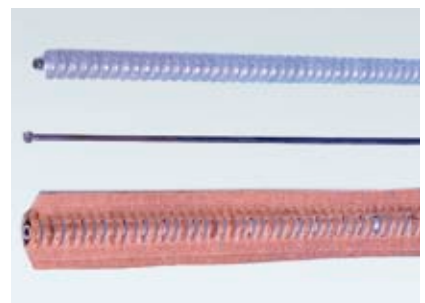
Assembly with standard tool



Fasteners fed via a vibrating bowl



Magazine fed fasteners



Specifying a Speed Fastening® System

To optimise the performance of your Avdel Speed Fastening® System it is important to select the correct combination of fastener, nose equipment, mandrel and follower spring. It is also critical to ensure that the combination selected is suited for use with your choice of installation process. If you need any help in specifying the required components then do not hesitate to contact your local Avdel representative. Further information on corrosion, safety and RoHS can be found on our website www.avdel-global.com.

Fastener Selection

Standard Fasteners – Rivcrew®, Briv® & Chobert®

Removability

Rivcrew® fasteners are ideal for applications requiring disassembly for repair or rework. They can simply be unscrewed using a standard hexagonal allen key.

Clamp

Briv® fasteners should be specified in applications requiring high clamp loads. Chobert® fasteners provide a lighter, controlled clamp making them ideal for softer or low strength materials.

Head Type

Fasteners are available with dome head. Briv® and Chobert® are also available with countersunk headform. Other head diameters may also be available as specials – please contact your local Avdel representative.

Specialist Fasteners

Avtronic®

Designed for attaching DIN and other connectors, card ejectors and heatsinks to printed circuit boards.

Avsert®

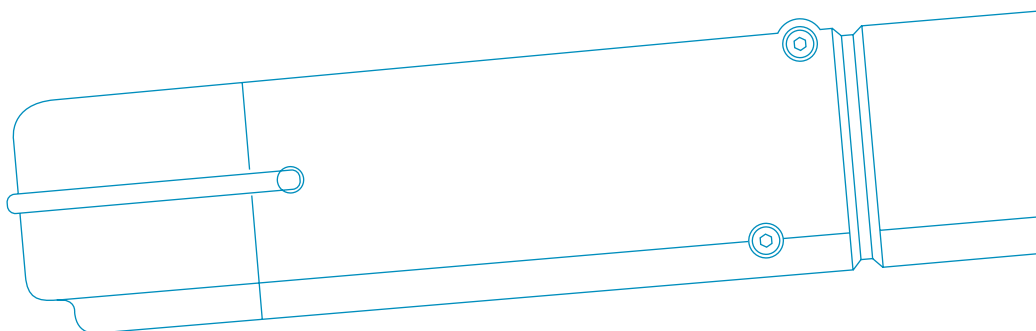
Cost effective stand-off pillars for printed circuit boards.

Avlug®

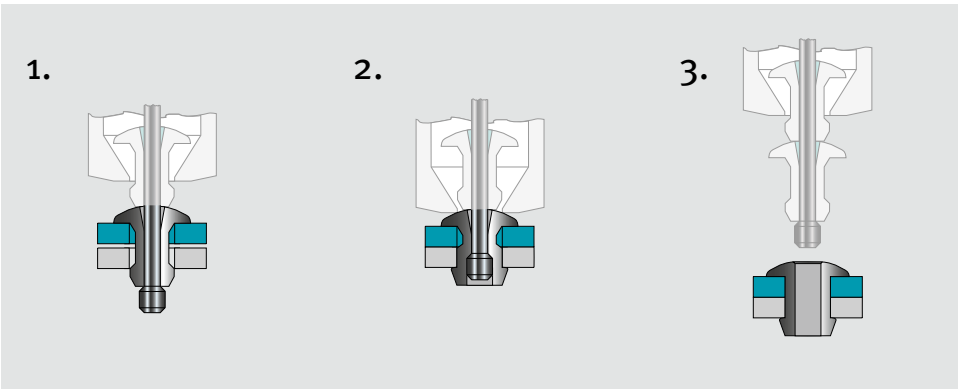
Cost effective terminal posts for printed circuit boards.

Fastener Material & Surface Finish

Avdel speed fasteners are available in stainless steel, steel, aluminium and brass. The choice of material should be made on the basis of performance (shear and tensile strength), suitability for use with the parent material and corrosion resistance. For performance data please see the relevant technical data sheets.



Typical placing sequence

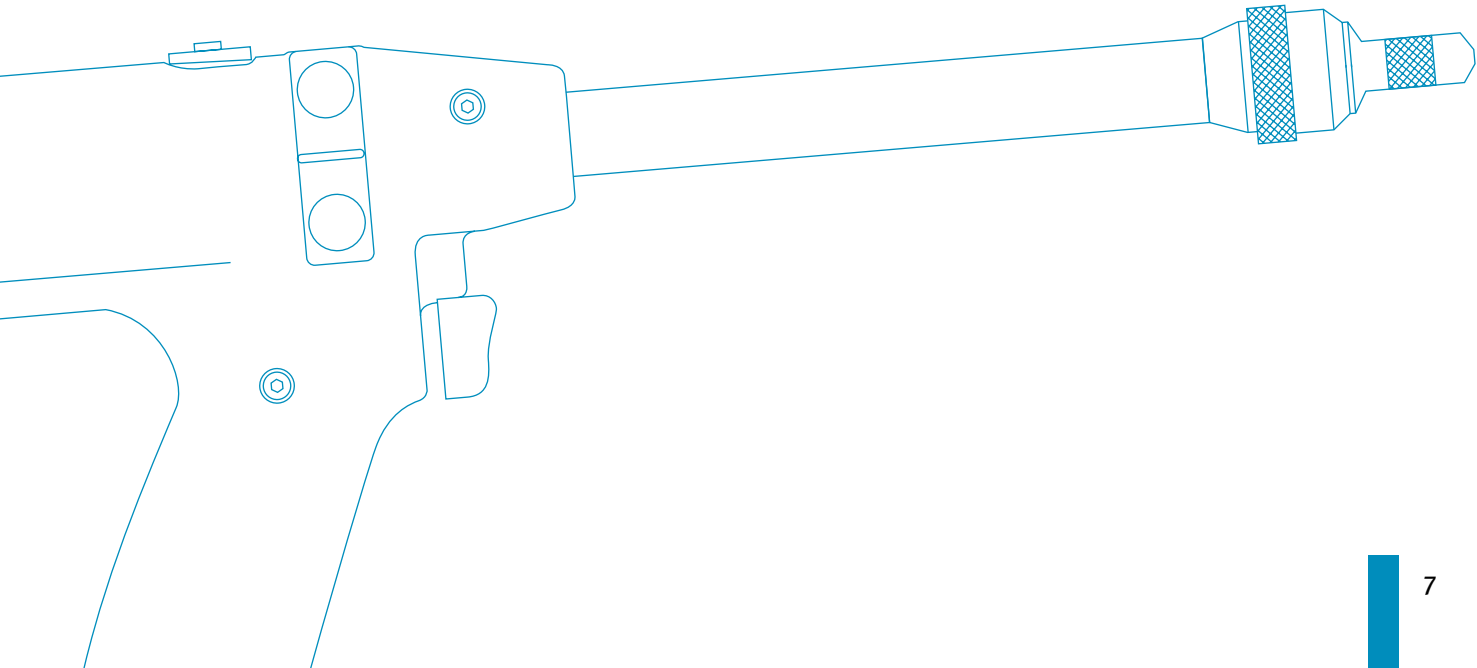


Please visit our website www.avdel-global.com for fastener placing animations.

1. The mandrel with pre-loaded fastener is located in the hole.
2. Tool activation pulls the mandrel through the fastener, expanding it within the hole to provide high clamp and secure joints.
3. At the end of the installation cycle, the next fastener is automatically delivered to the nose of the tool, ready to repeat the assembly process.

The surface finishes for Avdel® speed fasteners are as follows:

Steel	Zinc plate and clear passivation Option: Enamel paint Zinc nickel Organic coatings
Aluminium Alloy	Natural Option: Anodising Enamel paint
Stainless Steel	Polished
Brass	Brightened or hot tin dipped (for solderability)



Selection Guide

This table is designed as a guide to help you select the most suitable Avdel® speed fastener for your particular application. Full technical and performance data for each speed fastener can be found on our website or contact your local Avdel representative.

Product Range	Material	Finish						Head-form	Fastener Size (nom)														Thread Size			
		Natural	Zinc Plated	Polished or Brightened	Electro Tin Plated	Tin Plated	Dome	Countersunk	1.6 mm (1/16")	2.4 mm (3/32")	2.5 mm	2.8 mm	3.0 mm	3.2 mm (1/8")	3.5 mm	4.0 mm (5/32")	4.5 mm	4.8 mm (3/16")	6.0 mm	6.4 mm (1/4")	M2.5	M3	Series No.	Page No.		
Briv®	Aluminium Alloy (5% Mg)	●					●		●					●	●	●	●	●					1801	9		
	Aluminium Alloy (5% Mg)	●						●						●	●								1802			
	Steel		●				●							●	●	●	●						1821			
	Steel		●					●						●	●								1822			
	Brass				●		●		●					●	●	●	●						1833			
	Stainless Steel			●			●							●	●	●	●						1841			
Chobert®	Steel		●				●							●	●	●	●	●					1121	10		
	Aluminium Alloy (3.5% Mg)	●					●		●					●	●	●	●	●	●				1131			
	Brass				●		●		●					●	●	●	●	●					1143			
Grovit®	Steel		●				●							●	●	●	●	●					1101	11		
	Aluminium Alloy (2.5% Mg)	●					●		●					●	●	●	●	●					1103			
RivscREW®* RivscREW® PL	Steel		●				●				●	●		●	●								1722	12		
	Steel		●				●					●		●	●	●							1742	13		
Avtronic®	Brass				●		●			●	●												1188	14		
	Aluminium Alloy (5% Mg)	●					●			●	●												1189			
Avsert®	Brass					●														●	●		1117	15		
	Brass					●														●	●		1118			
Avlug®	Brass				●		●		●	●				●									1107	16		

*RivscREW® 1722 - the placed head form depends on the nose equipment used, standard RivscREW® nose equipment gives a dome head form.

Our policy is one of continuous product development and improvement and we reserve the right to change the specification of any product without prior notice.

Briv[®] High Shear, High Clamp Fasteners

Speed (repetition) fasteners with a bulbed tail providing consistent high clamp and shear. Can be used to assemble many materials including metal, plastic and aluminium alloy.



Key features and benefits

- Bulbed tail and foreshortening of the fastener during installation ensures high clamp
- Bulbed tail and large headform provide a large bearing area for soft materials
- Tapered tail for ease of hole entry
- Expands radially during installation to ensure maximum hole fill
- Lower in-place costs than welding or nail rivets
- Bright tin plated brass option for ease of soldering and good electrical conductivity
- Stainless steel option for applications subject to high temperature or corrosion
- Can be bowl fed for larger volume applications using automated equipment

Specifications

Sizes:

2.4 mm (3/32") to 6 mm

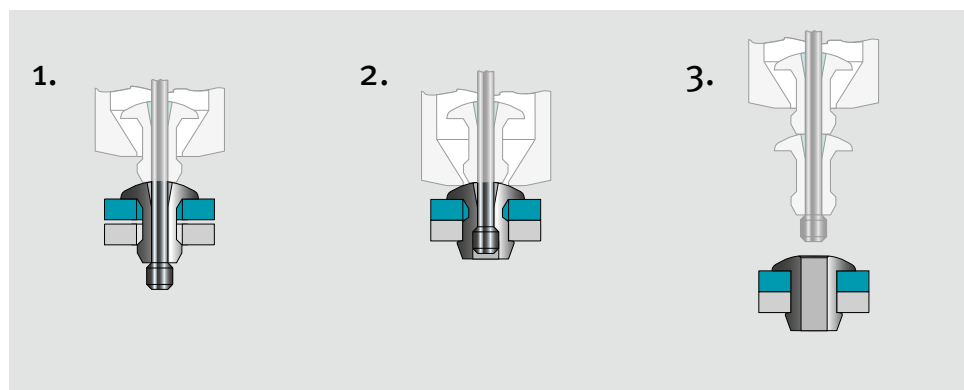
Materials:

Aluminium alloy, steel, stainless steel and brass

Headforms:

Dome, countersunk

Typical placing sequence



Please visit our website www.avdel-global.com for fastener placing animations.

Assembly applications

- Automotive
- Electronic components
- Sheet metal
- Electrical engineering
- Domestic appliances
- Furniture
- General light fabrication

Vacuum pump for diesel engines



Domestic heating systems



Office furniture



Computer cabinet



Automotive plastic connector to moulded chassis



Automotive stereo speaker



Chobert® For Soft and Brittle Materials

Speed (repetition) fasteners which provide consistent controlled clamp, ideal for soft or brittle materials.



Key features and benefits

- Internally tapered bore ensures consistent light clamp to reduce potential damage to materials
- Expands radially during installation to ensure maximum hole fill
- Lower in-place costs than welding or nail rivets
- Ideal pivot pin or hose tail
- Bright tin plated brass option for ease of soldering and good electrical conductivity
- Can be bowl fed for larger volume applications using automated equipment

Specifications

Sizes:

2.4 mm to 6.4 mm
(3/32" to 1/4")

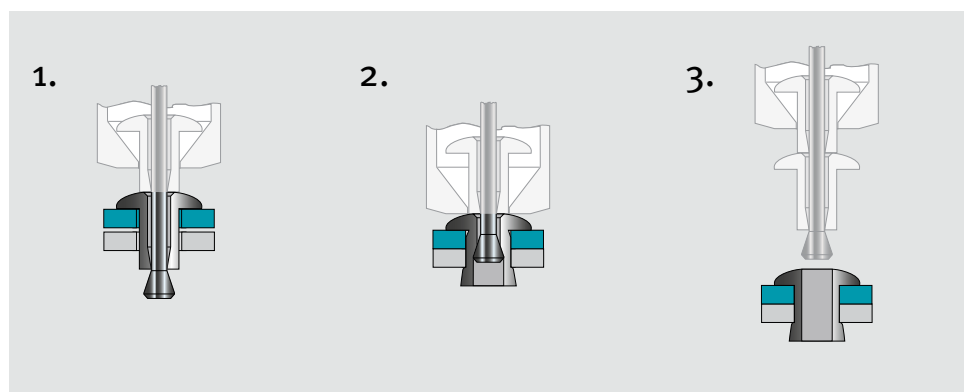
Materials:

Aluminium alloy,
steel and brass

Headforms:

Dome, countersunk

Typical placing sequence



Please visit our website www.avdel-global.com for fastener placing animations.

Assembly applications

- Automotive
- Electronic components
- Sheet metal
- Electrical engineering
- Injection moulded components
- Switchgear
- Domestic appliances
- General sheet metal
- General light fabrication

Window hinge



Alloy tube with nylon bush



Computer rack glass door hinge



Housing for car alarm



Composite material latch for wheel cover



Cooler



Grovit[®] For Blind Hole Applications

Designed for blind hole applications in wood, plastics, fibre-glass and aluminium. Can also be used in harder substrates.



Key features and benefits

- Annular grooves on the body expand radially during installation
- Provide a vibration resistant joint and increased pull-out resistance

Specifications

Sizes:

2.4 mm to 4.8 mm
(3/32" to 3/16")

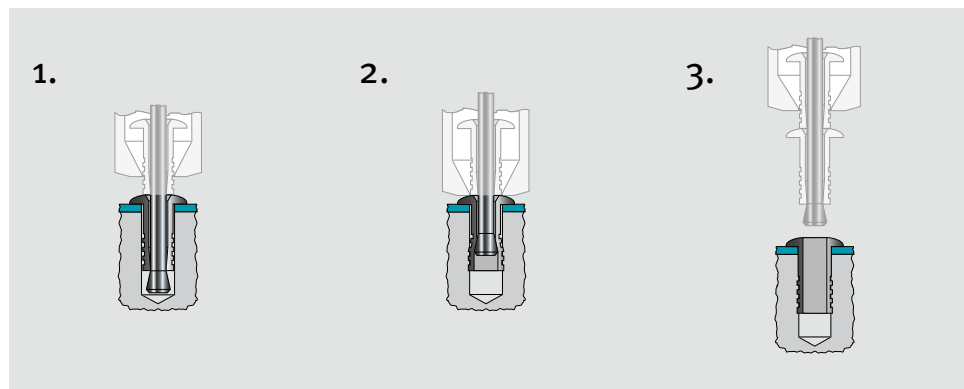
Materials:

Zinc plated steel and
aluminium alloy

Headforms:

Dome

Typical placing sequence



Please visit our website www.avdel-global.com for fastener placing animations.

Assembly applications

- Automotive
- Domestic appliances
- Electrical equipment
- Injection moulded components

Grovit[®] fastener in timber



Trouser press



Trouser press (detail)



PVC connector block in air conditioning unit



Grovit[®] fastener used as a quick connect low pressure bleed hose



PVC strip connector



Rivscrew® Threaded, Removable Fasteners

Threaded, removable speed (repetition) fasteners that combine the speed of rivet placement with the removability of a screw.



Key features and benefits

- Expands radially during installation to form a thread in host material, eliminating the risk of over torquing and strip-out
- Placed using a hexagon mandrel which expands the threaded diameter radially, adjacent to its six corners
- Removable for servicing with a hex key and reusable
- Providing a higher vibration resistant “thread lock” in the parent material compared to standard screws
- Can be used to fasten most materials up to Vickers hardness 105 Hv5
- Eliminates the need for costly tapping or thread-forming operations
- Bright tin plated steel option for ease of soldering and good electrical conductivity
- Can be bowl fed for larger volume applications using automated equipment

Specifications

Sizes:

2.8 mm to 4.0 mm

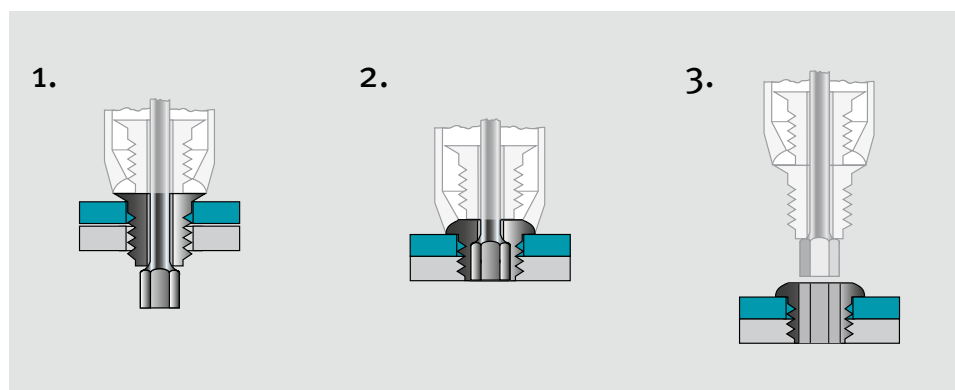
Materials:

Zinc plated steel

Headforms:

Dome

Typical placing sequence



Please visit our website www.avdel-global.com for fastener placing animations.

Assembly applications

- Aluminium die-cast boxes
- Cast magnesium
- Semi-conductors to thin wall and extruded heatsinks
- Semi-conductors to PCBs
- PCBs to chassis assemblies
- Fastening into injection moulded plastic bosses
- General engineering involving plastics, nylon, polycarbonate etc.

Rivscrew® is removable and reusable



Alternator diode plate to nylon moulding



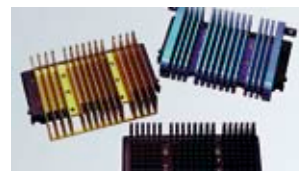
Automotive die-cast chassis with PCB



Semi-conductors to heatsinks and printed circuit boards



Heatsinks to processor cartridges



Seat belt tensioner



Rivscrew[®] PL For Plastics

Threaded, removable speed (repetition) fasteners that combine the speed of rivet placement with the removability of a screw.



Key features and benefits

Rivscrew[®] PL fasteners have the same features and benefits as the standard Rivscrew[®] fastener plus:

- Especially designed for soft and hard plastics
- Special thread design for a wide range of plastics with a flexural modulus between 340,000 and 1,400,000 p.s.i (2,000 to 10,000 N/mm²)
- Wide grip range from 3.0 to 11.8 mm covered by one fastener

Specifications

Sizes:

3.0 mm to 4.5 mm

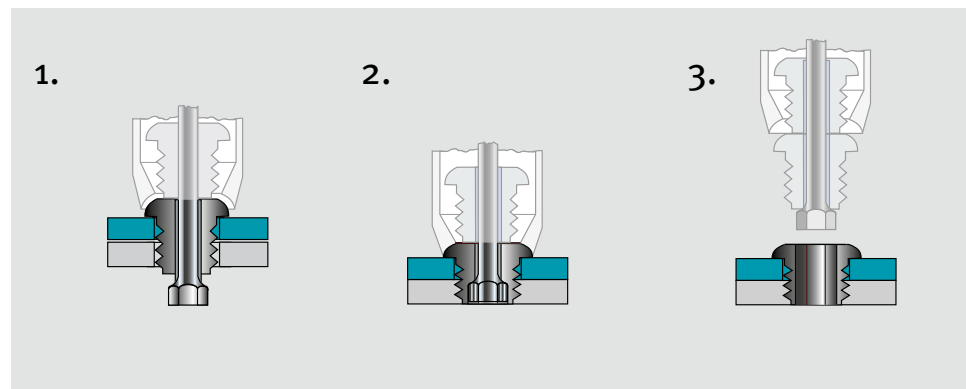
Materials:

Zinc plated steel

Headforms:

Dome

Typical placing sequence



Please visit our website www.avdel-global.com for fastener placing animations.

Assembly applications

- Bumper covers
- Lighting
- Plastic trim
- Printers
- Domestic appliances
- Toys
- Plastic enclosures



Avtronic® For Attaching Connectors to PCBs

Initially designed to attach DIN 41612 connectors to PCBs but can also be used to attach a wide range of other connectors and components.



Key features and benefits

- Annular grooves on the body expand radially during installation
- Provide a vibration resistant joint, increased pull-out resistance and good residual clamp
- Various body lengths provide a wide grip range to accommodate most combinations of connector and PC board thickness
- Ideal tack rivet
- Can be used in blind hole applications

Specifications

Sizes:

2.5 mm and 2.8 mm

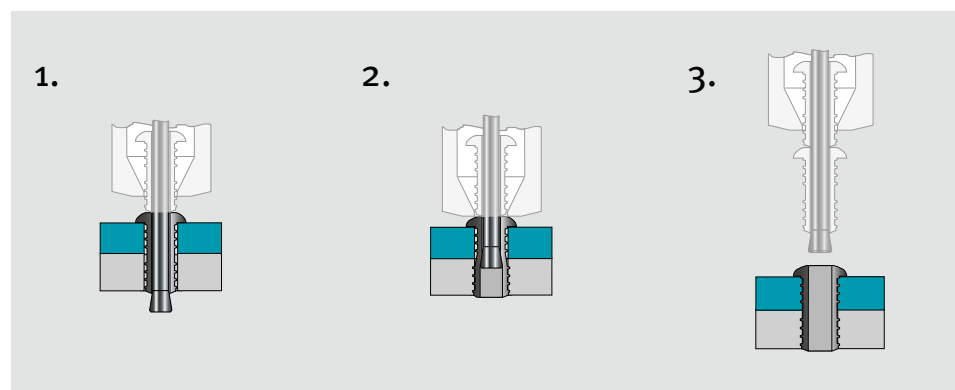
Materials:

Electro tin plated brass
and aluminium alloy

Headforms:

Dome

Typical placing sequence

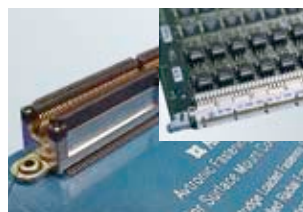


Please visit our website www.avdel-global.com for fastener placing animations.

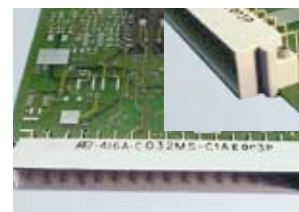
Assembly applications

- DIN and other connectors
- Heatsinks
- Card ejectors
- Brackets and stiffener bars

Surface mounted connectors to PCBs



DIN 41612 male edge connector



Automotive vertical mounted connectors



Traffic light reflector and contact point



Avsert® Threaded Stand-off Pillars for PCBs

Threaded stand-off pillars for PCBs in a range of metric internal threads and many stand-off heights.



Key features and benefits

- Internally threaded bore takes a threaded part e.g. D-subminiature connectors
- Available in many stand-off heights to accommodate a wide variety of components
- Can be used for board thicknesses of 0.8 – 2.0 mm (short spigot) or 0.8 – 2.4 mm max (long spigot).
- Suitable as a female mating bush for D-subminiature connectors

Specifications

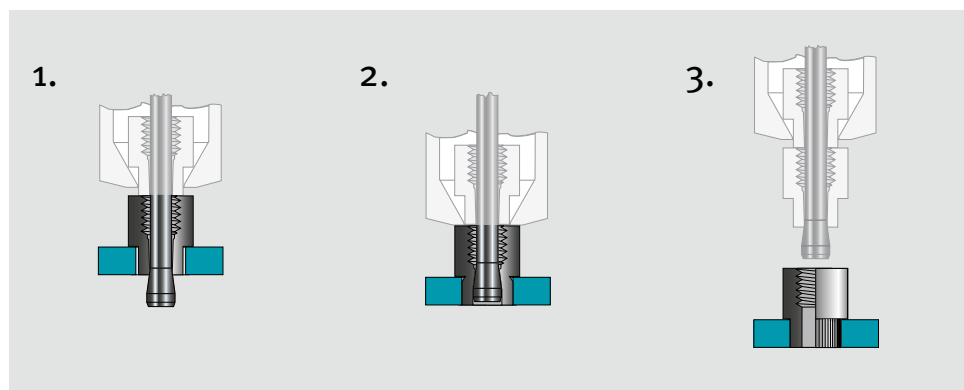
Sizes:

M2.5 x 0.45 and
M3 x 0.5 threads

Materials:

Tin plated brass

Typical placing sequence



Please visit our website www.avdel-global.com for fastener placing animations.

Assembly applications

- Aluminium geartrays and extrusions
- D-connectors
- PCBs
- Telecommunications equipment



DB25 subminiature connector
4.40 UNC female



Avlug[®] Solderable Terminal Posts

Secure, easy-to-solder terminal posts for PCBs.



Key features and benefits

- Rolled/knurled shank ensures secure placement in the PCB
- Suitable for wire wrapping or a test point for CRO tubes
- Available with diameters as small as 1.6 mm for assembly

Specifications

Sizes:

1.6 mm to 3.2 mm
(1/16" – 1/8")

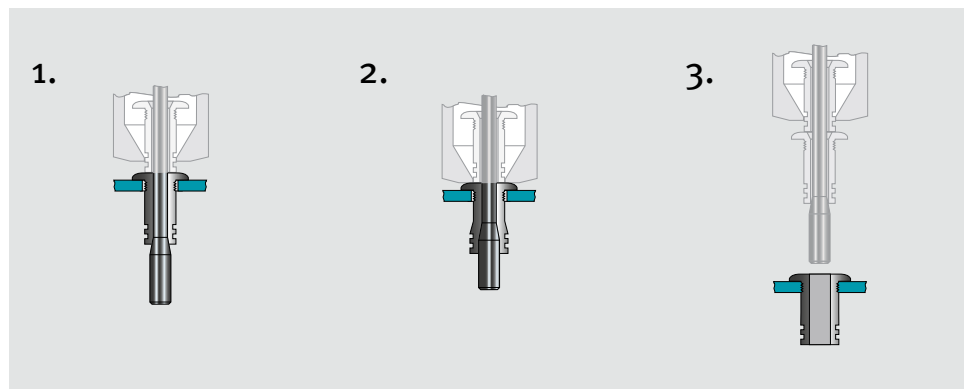
Materials:

Electro tin plated brass

Headforms:

Dome

Typical placing sequence

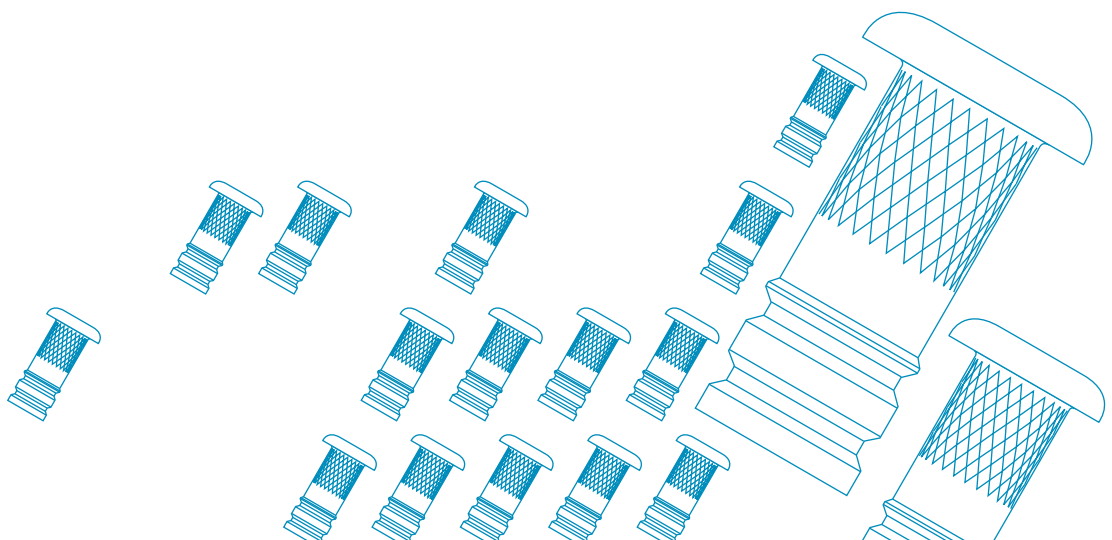
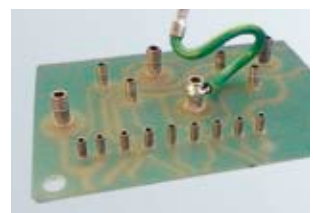


Please visit our website www.avdel-global.com for fastener placing animations.

Assembly applications

- Terminal posts
- Wire wrap

Terminal post - wire wrap



Installation Systems

From cost-effective handtools to bespoke assembly systems, Speed Fastening® equipment offers rapid and reliable assembly to meet your specific requirements. The equipment is an integral part of the Speed Fastening® System and offers the following benefits:

- High speed, reliable fastener feed
- Assembly cycle times within two seconds
- Single side assembly
- Simple operation
- One tool covers the entire range of speed fasteners
- Quick reload
- Low maintenance costs
- Ideal for low volume batch work through to fully automated assembly lines

Handtools

For low volume production up to 250,000 fastener p.a.

Handtools



753 Standard tool



7537 Handtool



Workstations

For medium volume production from 250,000 up to 1,000,000 fastener p.a.

Workstations



7535 Pantograph workstation



Rivmatic® workstation



Assembly Workstations

For high volume production > 1,000,000 fastener p.a.

Bespoke systems



Twin head fixed pitch workstation



23 placing heads to assemble a computer chassis



Handtools

7530 Handtool

High performance, hydro-pneumatic handtool in heavy duty plastic, designed for rapid, blind side installation of speed fasteners. The intensifier is separated from the handtool. One tool places the entire range of speed fasteners.

- Average cycle time of less than 2 seconds to increase productivity – up to 1500 fasteners per hour
- High capacity, magazine fed fasteners reduces component handling and subsequent spillage
- Robust & durable construction makes it suitable for most industrial environments
- Lightweight construction (split handtool and intensifier) and zero actuation recoil reduces operator fatigue
- Available with in-line handle and top or bottom hose configuration
- Low maintenance handtool maximises productive time – no requirement for specialist maintenance training
- Long life, self priming intensifier provides consistent actuation and hence joint formation
- Long reach barrel for use in many difficult access applications

753 Standard tool



Suspended

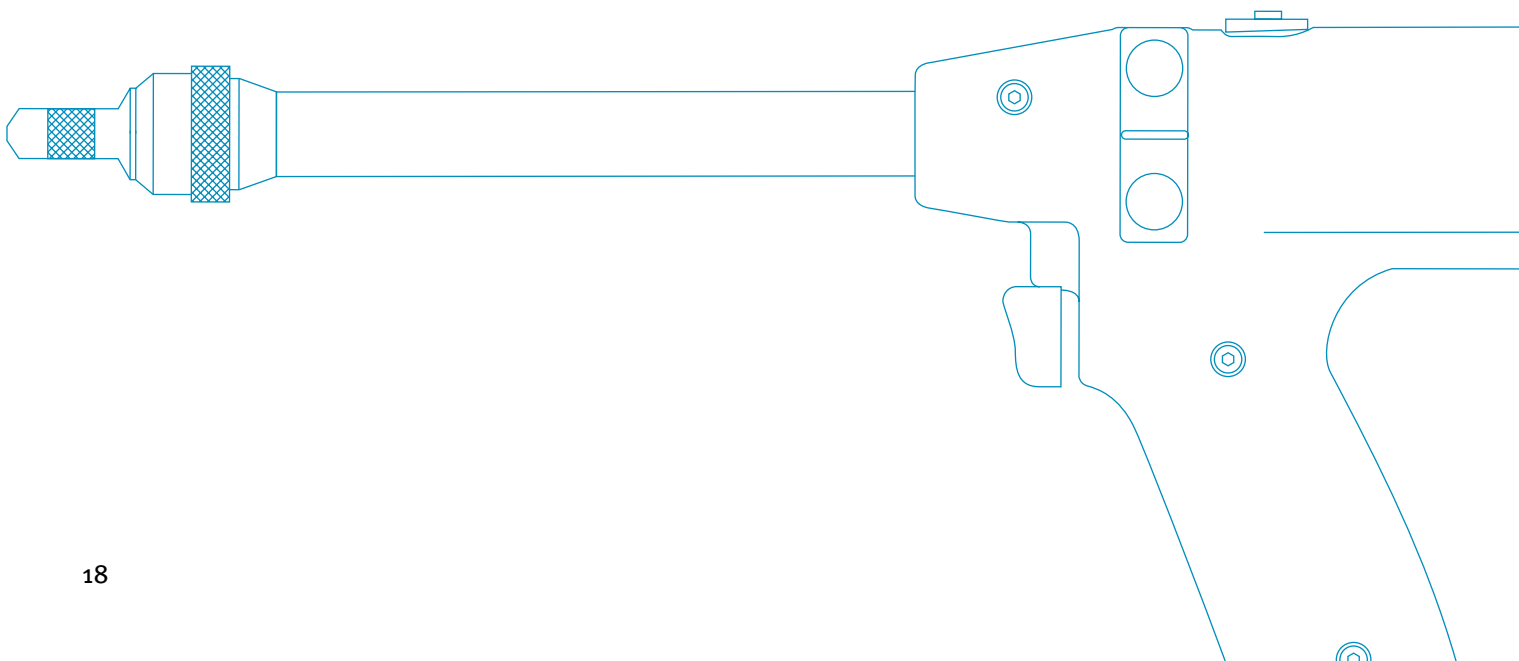


Autoload MK 4



A suspended version is available that can be supported on a balancer to be quickly and easily moved or discarded – reducing downtime and operator fatigue.

The Autoload option provides bowl fed fasteners to minimise reloading downtime and maximise productivity. The fasteners are automatically loaded onto the mandrel. When fasteners on one mandrel are spent, the tool is placed in the nest, and the system inserts a fully-loaded replacement into the modified 753 tool. The system features an operator interface board that displays real-time reports on machine cycles and fault diagnostics. The data also can be linked to a network allowing off-site monitoring and maintenance.



7537 Handtool

Lightweight, hydro-pneumatic handtool with integrated intensifier places the whole range of speed fasteners.

- Average cycle time of approx. 1 second increases productivity
- No need for long umbilical makes it flexible to use in different production environment
- Specially toughened plastic body and heavy duty rubber base increase the impact resistance and durability
- Can place the same range of fasteners and uses the same nose equipment as 7530 handtool
- Ease of maintenance due to integral cycle counter

7536 Handtool

Lightweight, hydro-pneumatic handtool with separated intensifier places the whole range of speed fasteners, including the \varnothing 1.6 mm Avlug® speed fastener.

- Control box and air cursor for reliable use of small diameter fasteners
- Uses hydraulics for placing fasteners (reduced shock loads)
- Uses same placing equipment and common parts of the 7530 tool

7271 Handtool

High performance, pneumatic handtool in heavy duty plastic, designed for rapid, blind side installation of speed fasteners.

- Average cycle time of less than 2 seconds to increase productivity – up to 1500 fasteners per hour
- High capacity, magazine fed fasteners reduces component handling and subsequent spillage
- Robust & durable construction makes it suitable for most industrial environments

7537



7536



7271



Workstations Single-head

These single-head workstations can place the entire range of Avdel Speed Fastening® Systems and stand out for their ergonomic design. Rapid assembly makes them cost-effective, even with small batch sizes. Simple to operate, high mobility and easy integration into the production process are the main features. Time-consuming training of an operator is not necessary. The hydraulic riveting units provide a smooth and shock-free riveting, ideal for sensitive components. All tools only require compressed-air supply.

Pantograph Workstation

- Tool supported on an extendable arm
- Wide arm reach to over 0.8 m
- Single hand operation
- The arm can be moved around the worktop to make space for other tasks
- Long-life intensifier – can be bench or floor mounted

Fixed Arm Workstation

- Tool supported on a fixed arm
- Foot pedal control, leaving both hands free to position the workpiece
- Easy alignment of workpiece
- Height adjustable arm to meet the operator's precise ergonomic needs

Underbench Workstation

- Cost-effective workstation, requiring minimum space
- Mounted below the worktop leaving a free worksurface
- Foot pedal control, leaving both hands free to position the workpiece
- Easy alignment and precision assembly of small components
- Integral safety guard

70510 Underbench workstation



70510 Underbench workstation



7535 Pantograph workstation



7535 Fixed arm workstation



Rivmatic® workstation



Workstations Multi-head

Mini-MAS

The Avdel Mini-MAS is a twin-head assembly station for fast, parallel assembly with compact and ergonomic design making it very easy to integrate into existing assembly lines.

- Double-head parallel riveting optimizes your assembly and increases the quality of the joining
- The rivets are presented in pairs and provide practical jig points for your components.
- Possible linear positioning of one riveting module provides progressive adjustment of the riveting pitch from 29 mm up to 120 mm (close pitch version 17 mm – 108 mm)
- Suitable for many applications
- Hydraulic riveting modules provide smooth and shock-free riveting
- Activation by a foot pedal, leaving the hands free for component handling
- Seated workstation (stand version optional available)
- ESD construction as an option

Mini-MAS



Standard nose equipment



Close pitch version



Multi-head Assembly Workstations

Multi-head assembly workstations are designed for the synchronous placement of multiple fasteners. Systems can be simple fixed, two head workstations or complex systems where as many as 60 fasteners can be placed at the same time. Most multi headed systems are customised to some extent which means that the user can enjoy the benefits of an assembly solution designed to their own specific requirements.

- Synchronous fastener placement maximises productivity and throughput
- In built fixturing reduces assembly time
- Modular assembly technology reduces maintenance costs
- Diagnostics capability improves quality control; preventive maintenance regimes can be implemented
- These workstations can be readily integrated into existing production facilities

Assembly Workstations

Automated Assembly Systems

Automated assembly systems are designed for integration within production lines and offer a complete operator free assembly solution for highest levels of productivity.

- Bowl fed fasteners for continuous fastening
- In line integration
- Diagnostic capability through operator interface
- Modular design with simple equipment access for simple maintenance processes

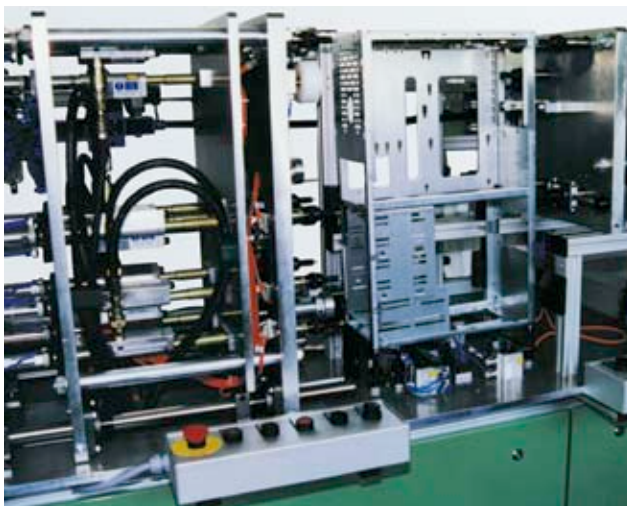
MIRS System to assemble vacuum pump



PMP System



29 placing heads to assemble computer chassis



10 placing heads to assemble automotive sealing strips



The Range of Avdel® Blind Fastening Systems



Speed Fastening® Systems

Extra fast and reliable fastening from one side. Because rivets are fed automatically.



Breakstem Systems

Blind fastening systems with various features. From multi-grip rivet up to high strength stainless steel rivet.



Lockbolt Systems

For joints with highest impact. High clamp force and vibration resistance.



Blind Threaded Inserts

Fast system for sustainable threads with high torque-to-turn.



Installation Equipment

From manually operated handtools to customized assembly workstations.

Avdel® Speed Fastening® Systems

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