

SCREWDRIVING
AND FASTENING
SYSTEMS WITH
AUTOMATIC FEEDING

STÖGER
AUTOMATION

BMS

Fully automatic setting unit
for blind rivet nuts with
patented quality control



Our setting system with force-displacement measurement for the automatic installation of blind rivet nuts and blind rivet bolts convince thanks to their versatility, performance level and short cycle time of 5 seconds. The compact design with a closed housing to protect against dust and the quick tool change underline our commitment to economic feasibility. The automated process for setting blind rivet nuts is 100 percent monitored. The system can be used in a stationary setting, in transfer systems, rotary table systems or robot systems. The blind rivet nuts are singulated in a feeder system as bulk materials and automatically fed into the correct position via a flexible feed hose in relation to the setting unit.



THE ADVANTAGES AT ONE GLANCE:

- + *The patented torque test checks the secure fitting of the rivet after drawing.*
- + *The functionality of the thread is tested for ease of movement both when winding in and winding out. Rivets that are detected as faulty when winding in are automatically ejected and replaced. An error message is issued for threads that are detected as faulty when winding out.*
- + *The search function for the hexagonal blind rivet nuts facilitates precise positioning in the workpiece.*
- + *Breakage of the drawing tool is immediately detected by the system and reported.*
- + *The drawing tool is a commercially available standard screw; there is no need for expensive spare parts*
- + *The drawing tool can be changed within just 10 seconds without the need for any auxiliary tools*
- + *Automatic feeding of the fastening elements*



Technical data

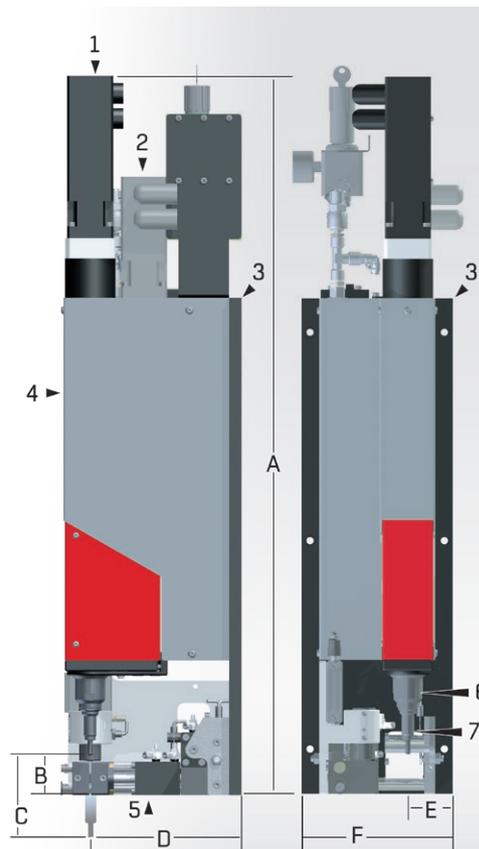
	BMS 6252	BMS 6600
Size	M5-M10*	M5-M14*
Feed stroke	125 mm	125 mm
Drawing force	25 kN	60 kN
Weight	31.5 kg	approx. 65 kg

* Standard; other sizes possible

Modules

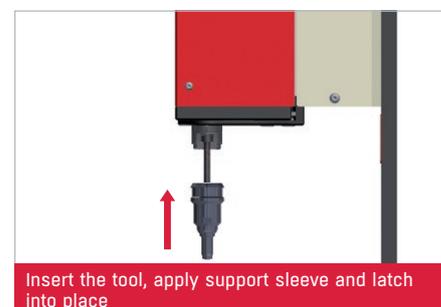
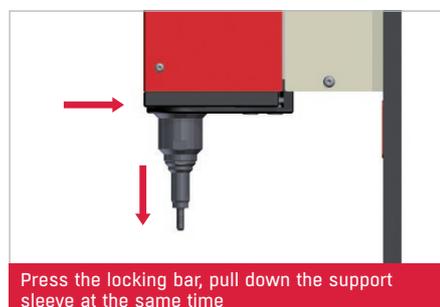
	BMS 6252	BMS 6600
Length (A)	860	1185
Distance of drawing tool to lower edge installation plate (B)	approx. 50	approx. 45
Total feed stroke (C)	approx. 125	approx. 125
Setting axle protection (D)	180	180
Distance of drawing tool - installation plate ... (E)	53.5	70
Installation plate width (F)	180	215
Minimum distance for twin-spindle implementation	70	105

All data in mm



- 1 Servo drive (for drawing tool)
- 2 Servo drive (for turning)
- 3 Installation plate
- 4 Integrated load cell
- 5 Loading device
- 6 Setting head with integrated stroke
- 7 Drawing tool

Tool change functionality



CAD data available on www.stoeger.com/en/downloads.html under file "Setting & riveting"

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