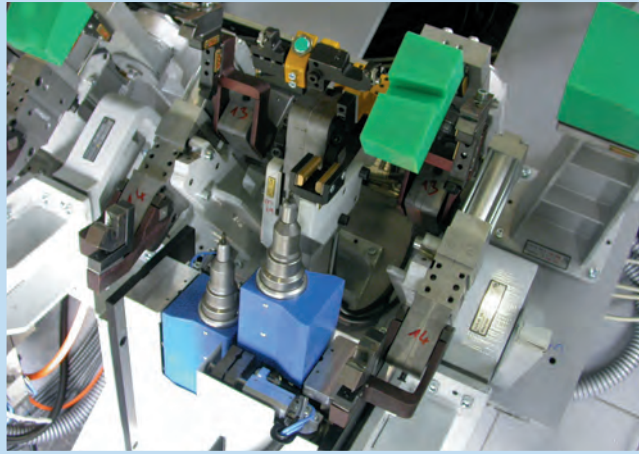


# BMS Setting systems in use in the automobile industry



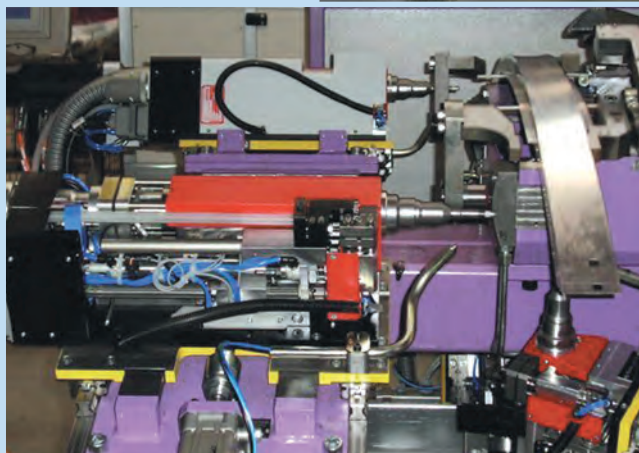
Fittings for luggage rails in roof



Engine sub-frame



Setting rivet nuts in a crashbox



Bumper pressing



**STÖGER**  
AUTOMATION



01.05.14



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## STÖGER Screw and assembly systems

BMS - electric setting system for blind rivetnuts and studs

100% Process-controlled  
Economical  
Powerful

with automatic feeding-  
well suited for many applications!



### Applications

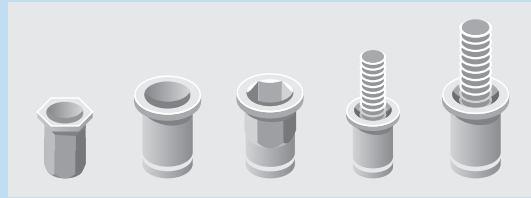
- Transfer lines
- Rotary table machines
- Positioning systems (axes)
- Robots

### Technical details

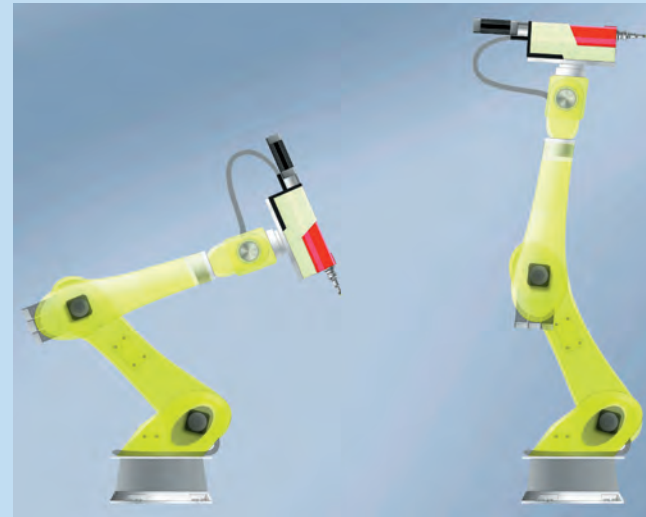
- Integrated tool stroke of 100 mm with controlled insertion pressure
- Stroke measurement direct at delivery stroke
- Just one servomotor for all functions
- Transducer for torque and setting force
- Angle control
- Thread control before and after setting (smoothness)
- Multifunctional control system with touch screen and operator guide
- Flexible fastener feeding tube
- Also suitable for blind rivets for drilling
- Optional extras possible (i.e. cam diagram)







Selection of blind rivets and studs



BMS units fitted to robots

## Easy servicing

- Compact unit
- Simple and fast toolchange

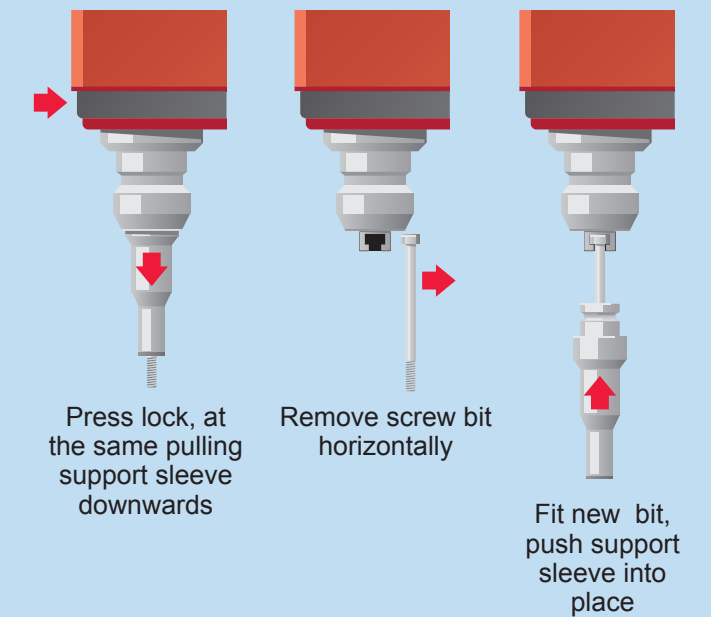
## Technical Data

	BMS 6252	BMS 6600
Rivet nut size	M5-M10 (M12)	M12-M14 *
Torque max. (Nm)	6	12
Speed max. (rpm)	1500	1000
Delivery stroke (mm)	120	120
Rivetting force max. (KN)	25	60
Rivetting stroke (mm)	25	20
Weight (Kg)	ca. 35	ca. 65

\* Special sizes on request

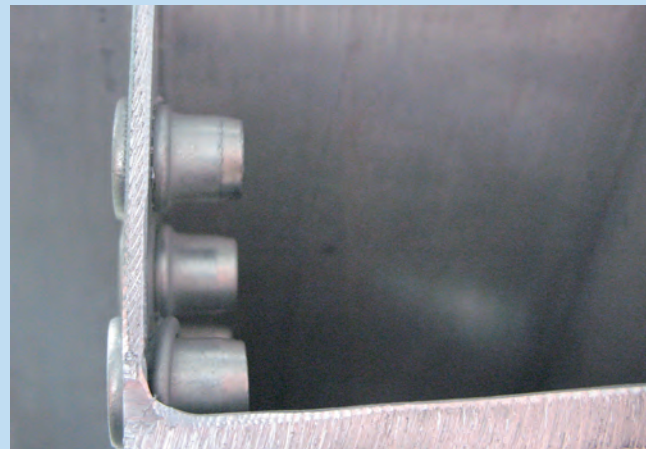
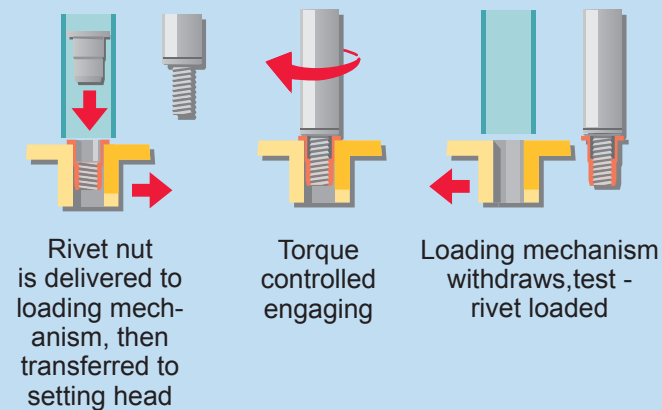
## Tool-bit change

- Without tools

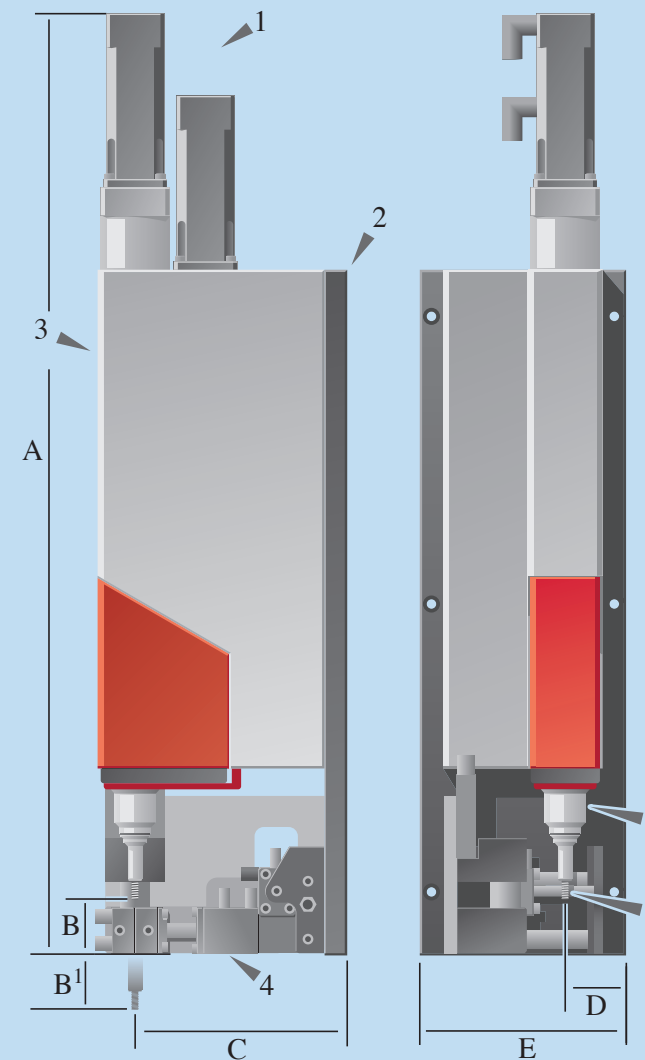
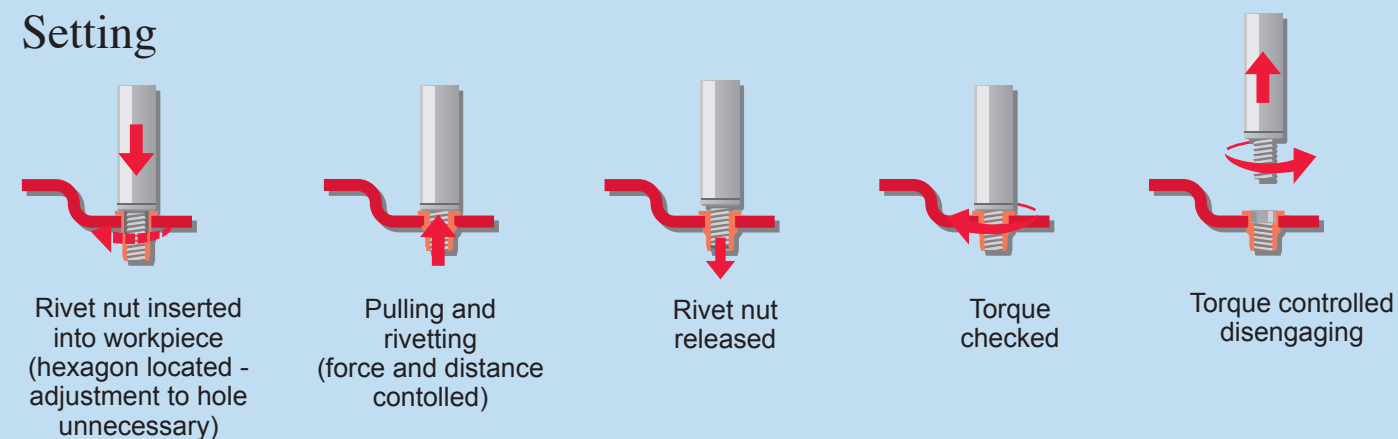


## Operating function -

### Loading



### Setting



## Layout

- 1 Servo-drives, screw & rivet
- 2 Mounting face
- 3 Integral torque transducer (force & distance, torque indirect)
- 5 Loading mechanism
- 5 Setting head with integral stroke unit
- 7 Rivetting tool

## Dimensions (mm)

	BMS 6252	BMS 6600
A	860	1182
B (withdrawn)	ca. 60	ca. 60
B <sup>1</sup> (extended))	ca. 60	ca. 60
C	180	180
D	53,5	70
E	180	180