

BW-50A ORBITAL RIVETER
Heading Capacity: .200"

A machine with a larger (.200") riveting capacity, the BW-50A features improved peen and peen holder design like the BW-35, and also offers noiseless flaring, swaging and crimping. The machine is equipped with a standard 115V, 60Hz, Single Phase motor, an air filter regulator and lubricator. A 230V, 60Hz, Three Phase motor is optional.

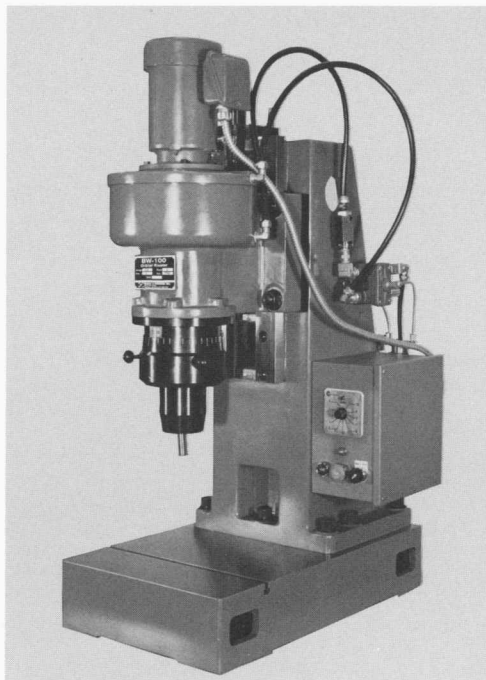
The new one-piece peen holder includes an O-ring to seal out foreign matter, minimizing contamination and prolonging bearing life. The peen is straight, easily produced from drill rod, and projects 1" for additional work clearance capability.

Air line pressure ranges from 30 to 70 p.s.i., and maximum peen pressure is 440 to 1100 lbs. The BW-50A has a crank handle for height adjustment. Stroke and dwell time controls are like the BW-35. Standard bearings are lifetime-lubricated. A machine base with "T" slot is provided.

Safety Feature

The B&W Dual Palm Switches, of the non-tiedown, non-repeat type, are a safety feature meeting OSHA requirements. Both palm buttons must be closed concurrently if the Orbital Riveter is to fire. The buttons are in wells to prevent accidental firing.

This safety feature is available on all B&W Orbital Riveters.



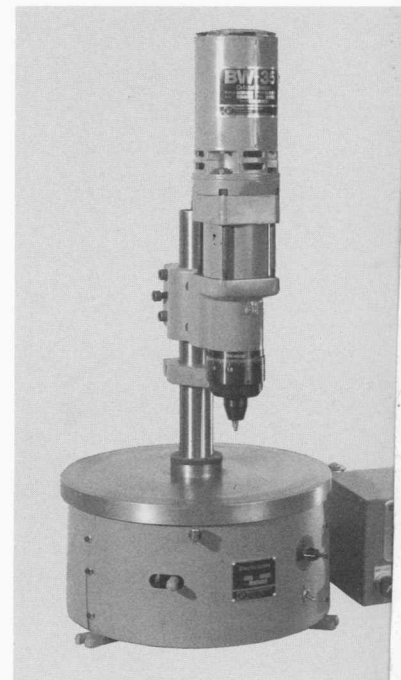
BW-100 ORBITAL RIVETER
Heading Capacity: .437"

The largest and newest of the Orbital Riveters with the widest (.437") heading capacity, the BW-100 is as useful as its smaller counterparts for riveting, flaring, swaging and crimping, and is as noiseless.

The BW-100 is equipped with a standard 230V, 60Hz, Three Phase motor. It also features the improved peen and peen holder design of the other two machines, and assembles larger parts smoothly and accurately, utilizing a relatively small amount of pressure. Air line pressure ranges from 30 to 70 p.s.i., and maximum peen pressure is 1300 to 3300 lbs.

The BW-100 has a vertical screw for height adjustment. Stroke and dwell time controls are like the BW-35. Standard bearings are lifetime-lubricated. A machine base with "T" slot is provided.

This machine, like other Black & Webster Orbital Riveters, can be used alone or in semi- or fully automatic assembly systems.



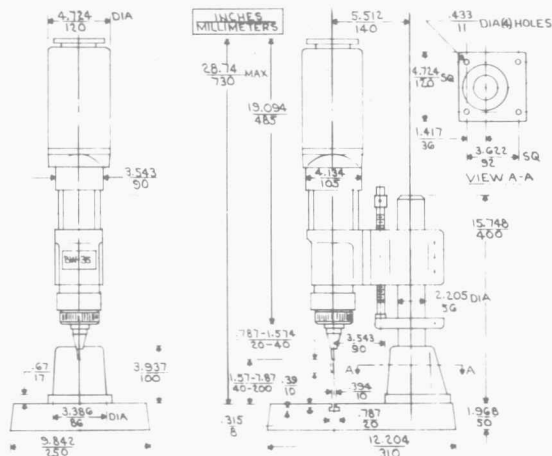
ORBITAL POWER HEAD ON INDEXING TABLE

Orbital Riveter models BW-100 and BW-50A can be used in conjunction with Black & Webster Electrotables. These tables, featuring Geneva action and electronic timers, position the work automatically, accurately, and safely, and trigger the machine operation. Indexing repeatability is $\pm .001"$, with 6, 8 or 12 static positions. Rotation can be clockwise or counterclockwise.

Model BW-35 is centered on a column, as illustrated. Model BW-50A is mounted on a top plate.

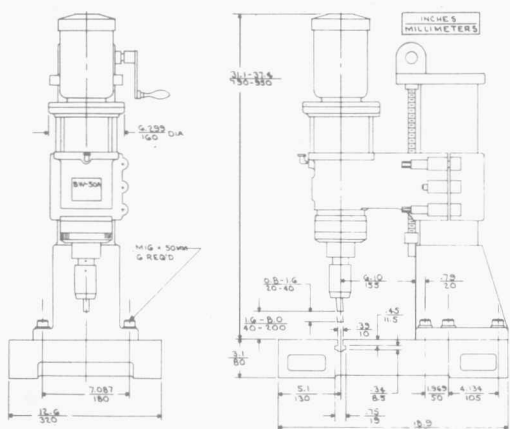
SPECIFICATIONS

MODEL BW-35

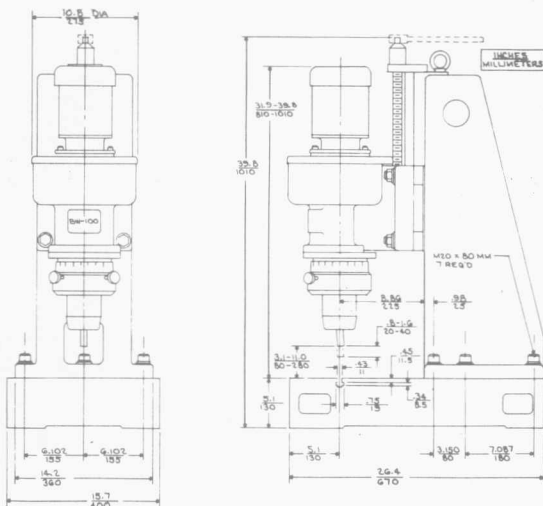


Rivet Capacity (Solid, Mild Steel)	3 mm	.12 in.
(Solid, AL, CU)	5 mm	.20 in.
Air Pressure	2-5 kg/cm ²	28-71 psi
Head Force	70-180 kg	160-400 lbs.
Adjustable Time Setting	0-10 seconds	
Stroke	20-40 mm	.80-1.60 in.
Distance from Peen (Up Position) to Table	40-200 mm	1.6-8.0 in.
Distance from Peen to Column Face	100 mm (90 mm at base)	3 15/16 in. (-3 1/2 in. at base)
Power Requirement	115 v/60 Hz/1 phase	
Main Drive Motor	2 amp/1750 rpm	
Air Usage (Free Air per stroke @ 5 kg/cm ²)	1.8 L.	.064 ft. ³
Stroke Speed Control	variable	
Weight	54 kg	119 lbs.

MODEL BW-50A



Rivet Capacity (Solid, Mild Steel)	5 mm	.20 in.
(Solid, AL, CU)	8 mm	.32 in.
Air Pressure	2-5 kg/cm ²	28-71 psi
Head Force	200-500 kg	440-1100 lbs.
Adjustable Time Setting	0-10 seconds	
Stroke	20-40 mm	.80-1.60 in.
Distance from Peen (Up Position) to Table	60-200 mm	2.4-8.0 in.
Distance from Peen to Column Face	155 mm	6 1/8 in.
Power Requirement	115 v/60 Hz/1 phase standard 230 v/60 Hz/3 phase optional	
Main Drive Motor	3 amp/1750 rpm standard 1 amp/1750 rpm optional	
Air Usage (per stroke @ 5 kg/cm ²)	5L.	.177 ft. ³
Stroke Speed Control	variable	
Weight	130 kg	286 lbs.



MODEL BW-100

Rivet Capacity (Solid, Mild Steel)	4-11 mm	.16-.437 in.
(Solid, AL, CU)	4-16 mm	.16-.65 in.
Air Pressure	2-5 kg/cm ²	28-71 psi
Head Force	600-1500 kg	1300-3300 lbs.
Adjustable Time Setting	0-10 seconds	
Stroke	20-40 mm	.80-1.60 in.
Distance from Peen (Up Position) to Table	60-200 mm	2.4-8.0 in.
Distance from Peen to Column Face	225 mm	8 7/8 in.
Power Requirement	230 v/60 Hz/3 phase	
Main Drive Motor	2 amp/1750 rpm	
Air Usage (per stroke @ 5 kg/cm ²)	13.2 L.	.462 ft. ³
Stroke Speed Control	variable	
Weight	303 kg	670 lbs.



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Black & Webster products

Electropunch (Electric assembly & marking machine); Orbital Riveters; Electric Indexing Tables; Electric Vibratory Feeders; Hugold Air Presses & Pneumatic Indexing Tables; Terminal & Contact Setters; Automatic Assembly Systems; Protectoswitch (Accessory for operator safety); Black Diamond & Worcester Drill Grinders; Blake Tap Grinders; Industrial Plastics.