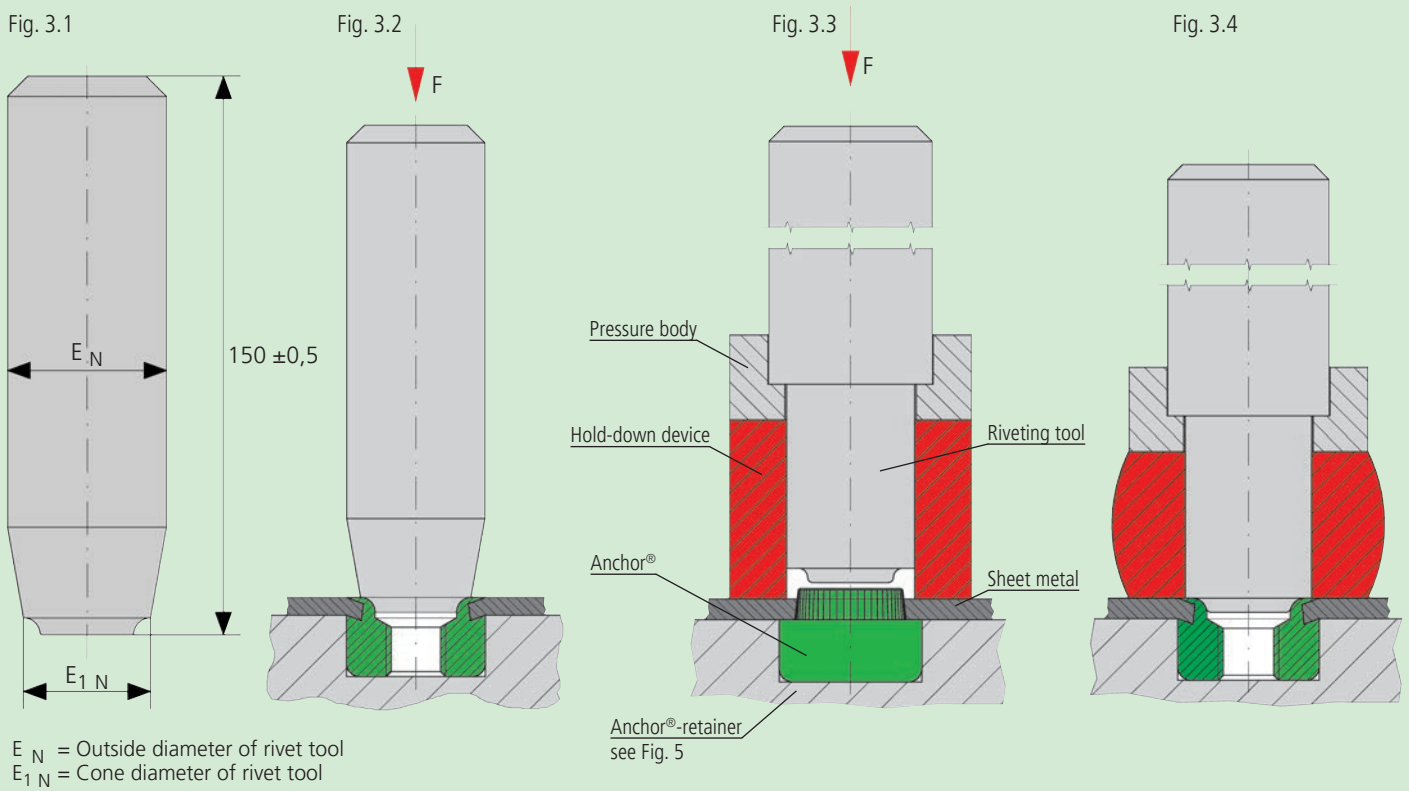
Anchor®– installation ...



E_N = Outside diameter of rivet tool
$E_{1\,N}$ = Cone diameter of rivet tool

Fig. 3

Installation

Punch, lasing or drill hole, insert anchor and rivet the shank with a simple riveting tool (Fig. 3.2).

- using a simple press
- by inserting Anchor® and riveting using a tumble or radial riveting process
- automatic feed in follow-on tools
- to prevent deformation of thin mouldings, use a tool with holding-down device (Fig. 3.3 and 3.4).

Riveting force for application in sheet steel

M 2	to M 3	appr. 15	to	27 kN
M 3,5	to M 4	20	to	30 kN
M 5		22	to	42 kN
M 6		30	to	54 kN
M 8		45	to	81 kN
M 10		65	to	97 kN
M 12	to M 16	80	to	160 kN

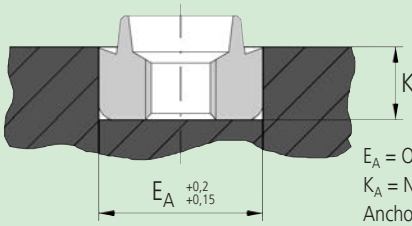
Riveting force for application in stainless steel sheet

M 2	to M 3	appr. 15	to	33 kN
M 3,5	to M 4	20	to	40 kN
M 5		25	to	50 kN
M 6		40	to	75 kN
M 8		80	to	120 kN
M 10		120	to	150 kN
M 12	to M 16	140	to	230 kN

The required riveting force must be determined by trial and error. For different material qualities and surfaces, higher press-in force may be required.
The firmest fit is achieved if the recommended hole diameters and tolerances are precisely adhered to.

Fig. 4

Dimensions of the Anchor® mounting



E_A = Outside diameter of the Anchor® nut
K_A = Nut height of the Anchor® nut
Anchor® nut conform to works standards 701, 721 and 740

Fig. 5

Animation

Kerb Konus

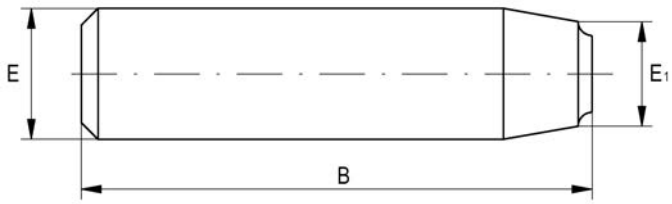
Riveting tool
Standard model

Anchor®
Anchor®-Tanktyp

Anchor® riveting tool

Riveting tool for processing of Anchor®.

The neck of the Anchor® is riveted with the help of the riveting tool such that optimal firm seating is achieved in a thin moulded part.



Dimensions in mm

Article number	Thread measurement A	External diameter E	Cone diameter E_1	Length B ±0,5
401 000 020. 000	M 2 / M 2,5 / M 3	12	7,1	150
401 000 035. 000	M 3,5 / M 4	12	8,7	150
401 000 050. 000	M 5	16	10,3	150
401 000 060. 000	M 6	16	11,9	150
401 000 080. 000	M 8	20	15,5	150
401 000 100. 000	M 10	20	18,3	150
401 000 120. 000	M 12 / M 14 / M 16	25	22,2	150

Kerb Konus

Riveting tool
Standard model

Anchor®-Mini

Anchor® riveting tool for Anchor®-Mini

Riveting tool for processing of Anchor®-Mini.

The neck of the Anchor®-Mini is riveted with the help of the riveting tool such that optimal firm seating is achieved in a thin moulded part.

Dimensions in mm

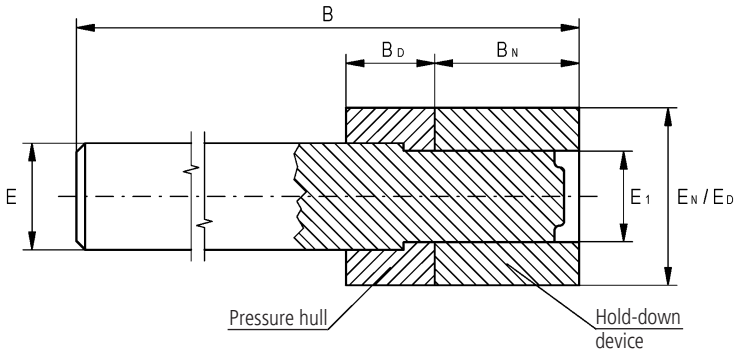
Article number	Thread measurement A	External diameter E	Cone diameter E_1	Length B ±0,5
421 000 020. 000	M 2	12	4,8	150
421 000 025. 000	M 2,5 / M 3	12	5,5	150
421 000 035. 000	M 3,5 / M 4	12	7,1	150
421 000 050. 000	M 5	12	8,7	150
421 000 060. 000	M 6	12	10,3	150
421 000 080. 000	M 8	12	11,5	150

Anchor® Riveting tool with hold-down device

Riveting tool for processing of Anchor®.

The neck of the Anchor® is riveted with the help of the riveting tool such that optimal firm seating is achieved in a thin moulded part.

The hold-down device serves to prevent deformation of the moulded part.



Dimensions in mm

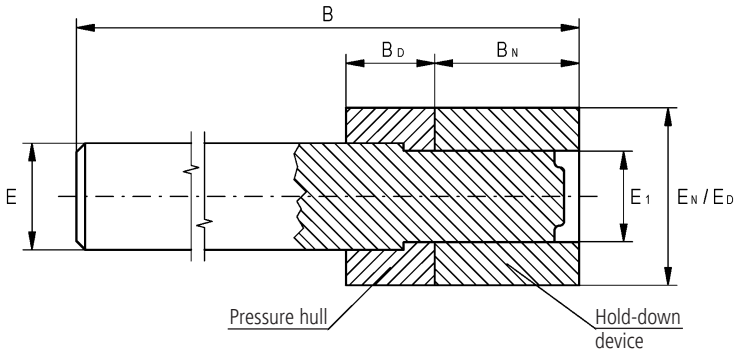
Article number	Thread measurement A	External diameter E	Shaft diameter E_1	Hold-down device B_N	Pressure hull B_D	Hold-down device/ pressure hull E_N / E_D	Length B ±0,5
406 000 020. 000	M 2 / M 2,5 / M 3	12	7,1	16,5	10	20	150
406 000 035. 000	M 3,5 / M 4	12	8,7	16,5	10	20	150
406 000 050. 000	M 5	16	10,7	22,5	10	25	150
406 000 060. 000	M 6	16	12,5	22,5	10	25	150
406 000 080. 000	M 8	20	15,7	22,5	10	32	150
406 000 100. 000	M 10	20	18,5	25	10	32	150
406 000 120. 000	M 12 / M 14 / M 16	25	22,5	25	10	32	150

Anchor® Riveting tool with hold-down device for Anchor®-Mini

Riveting tool for processing of Anchor®-Mini.

The neck of the Anchor®-Mini is riveted with the help of the riveting tool such that optimal firm seating is achieved in a thin moulded part.

The hold-down device serves to prevent deformation of the moulded part.



Dimensions in mm

Article number	Thread measurement A	External diameter E	Shaft diameter E_1	Hold-down device B_N	Pressure hull B_D	Hold-down device/ Pressure hull E_N / E_D	Length B ±0,5
426 000 020. 000	M 2	12	4,8	16,3	10	20	150
426 000 025. 000	M 2,5 / M 3	12	5,5	16,3	10	20	150
426 000 035. 000	M 3,5 / M 4	12	7,1	16,3	10	20	150
426 000 050. 000	M 5	12	8,7	16,3	10	20	150
426 000 060. 000	M 6	12	10,3	16,3	10	20	150
426 000 080. 000	M 8	12	11,5	22,3	10	25	150