Sai Machine tools has designed and developed spin riveting machines since over a decade. With systematic improvements in design, range and quality standards, we provide machines which deliver consistent output. Ultra is a trusted name in the field with an ever expanding customer base in the engineering industry.

Having a number of advantages, Ultra spin riveting is the ideal choice over other riveting methods.

Spin riveting principle:

In spin riveting the tool is mounted on a rotating spindle with the axis of tool fixed at an angle 3 to 6 degrees off the axis of the spindle. As the spindle rotates, the tool orbits the spindle axis and transcribes the pattern of an inverted cone. The tool doesn’t rotate on its own axis. The tool axis intersects the spindle axis at the working end of the tool and the orbiting tool presses on the rivet shank along a radial line that begins from the shank center.

As the pressure is applied a flowing wave of material is formed ahead of the orbital tool to produce the desired shape.

Advantages of Ultra spin riveting machines:

- A wide range of Rivet Diameter (0.5 to 20 mm)
- Even Grain flow of rivet material.
- Considerably minimum stress on the rivet material.
- Aesthetic finish of the rivet head.
- Longer tool life.
- Quieter operation.
- Simple tooling and easy setup.
### SAI MACHINE TOOLS

#### Technical Details

<table>
<thead>
<tr>
<th>Model</th>
<th>SRM-3</th>
<th>SRM-6</th>
<th>SRM-8</th>
<th>SRM-10</th>
<th>SRM-12</th>
<th>SRM-15</th>
<th>SRM-20</th>
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</thead>
<tbody>
<tr>
<td>M.S. Solid</td>
<td>0.5 to 3</td>
<td>3 to 6</td>
<td>4 to 8</td>
<td>5 to 10</td>
<td>6 to 12</td>
<td>8 to 15</td>
<td>10 to 20</td>
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<tr>
<td>S.S. Solid</td>
<td>0.5 to 2</td>
<td>2 to 4</td>
<td>3 to 5.5</td>
<td>4 to 7</td>
<td>5 to 8.5</td>
<td>6 to 10</td>
<td>7 to 13</td>
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<tr>
<td>Cu. Brass Solid</td>
<td>2 to 5</td>
<td>4 to 8</td>
<td>6 to 12</td>
<td>7 to 15</td>
<td>8 to 18</td>
<td>10 to 20</td>
<td>13 to 26</td>
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<tr>
<td>Aluminum Solid</td>
<td>3 to 6</td>
<td>5 to 10</td>
<td>7 to 15</td>
<td>7 to 17</td>
<td>10 to 20</td>
<td>10 to 20</td>
<td>14 to 28</td>
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<tr>
<td>Semi-Hollow M.S.</td>
<td>3 to 6</td>
<td>5 to 10</td>
<td>6 to 13</td>
<td>6 to 15</td>
<td>8 to 16</td>
<td>10 to 19</td>
<td>12 to 24</td>
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<tr>
<td>Semi-Hollow Cu. Brass &amp; AI</td>
<td>4 to 8</td>
<td>7 to 15</td>
<td>8 to 17</td>
<td>10 to 20</td>
<td>11 to 25</td>
<td>12 to 25</td>
<td>15 to 30</td>
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<tr>
<td>Throat Depth</td>
<td>135 m.m.</td>
<td>135 m.m.</td>
<td>150 m.m.</td>
<td>150 m.m.</td>
<td>175 m.m.</td>
<td>200 m.m.</td>
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<tr>
<td>Shat Height (Mx)</td>
<td>125 m.m.</td>
<td>150 m.m.</td>
<td>180 m.m.</td>
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<td>200 m.m.</td>
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<td>Stroke</td>
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<td>60 m.m.</td>
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<tr>
<td>Motor 415v</td>
<td>0.25 HP 0.18 KW</td>
<td>0.5 HP 0.375 KW</td>
<td>0.5 HP 0.55</td>
<td>0.5 HP 0.55</td>
<td>0.5 HP 1.10 KW</td>
<td>2 HP 1.50 KW</td>
<td>3 HP 2.20 KW</td>
</tr>
<tr>
<td>Actuation</td>
<td>Pneumatic</td>
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<td>Pneumatic</td>
<td>Pneumatic</td>
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<tr>
<td>Air Pressure kgf/cm²</td>
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<tr>
<td>Adj. timing cycle (sec.)</td>
<td>0.9 to 9</td>
<td>0.9 to 9</td>
<td>0.9 to 9</td>
<td>0.9 to 9</td>
<td>0.9 to 9</td>
<td>0.9 to 9</td>
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</tbody>
</table>

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### Manufactured by:

**SAI MACHINE TOOLS**

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*MAP WITH DIRECTIONS*