

Hydro-pneumatic riveting machine

The N 332 has convincing features

- 50.000 N riveting force with an air pressure of 8 bar.
- Working pressure from 1 to 8 bar steplessly adjustable.
- The maximum stroke of 50 mm facilitates faultless riveting even in not easily accessible places.
- Short set up time due to quick change tool mounting.
- Deriveting without problems.
- Riveting tools for all sizes (page 15).

The machine can either be mounted on a bench or on a pedestal (accessory).

N 332/80-CE



The N 332/80-CE has an extended stroke of 80 mm and a throat clearance of 230 mm. It is especially suited to the handling of brake shoes with double webs. The extended throat permits the riveting of the rear line of holes without turning the brake shoes.



Accessories

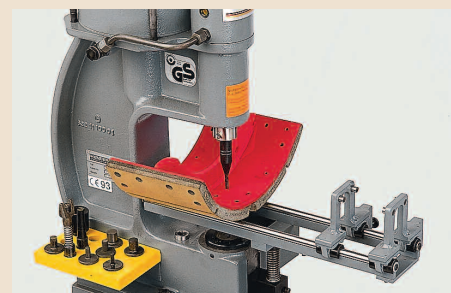
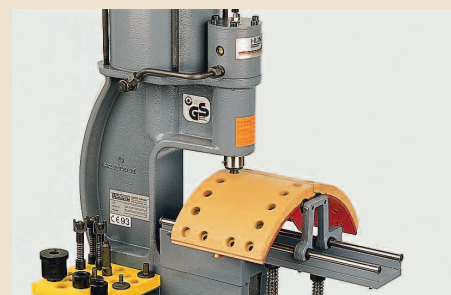


The brake shoe support holds the shoe in the correct position for riveting and deriveting, preventing it tipping.



Optional swivel attachment to facilitate the introduction of double web shoes.

Inverted brake lining riveting process, invented by HUNGER



With all riveting machines marketed hitherto, it has been necessary to insert the rivets individually from below into the lining and prevent them by hand from dropping out. With the newly developed HUNGER device, the riveting punch is at the bottom and the riveting dolly at the top (**top photo**).

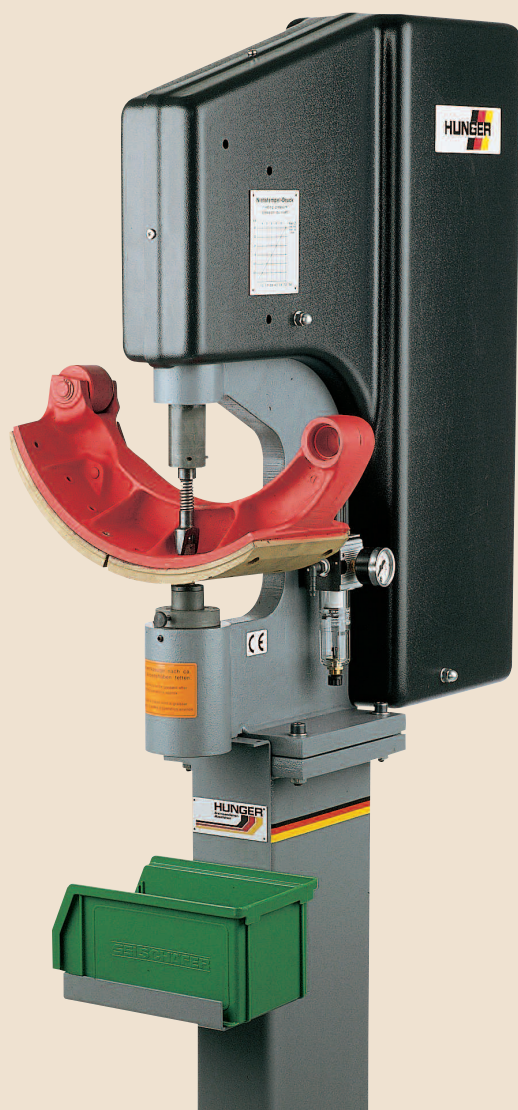
The brake lining is therefore on top of the brake shoe. Hence all the rivets can be inserted in the lining from the top without having to prevent them from dropping out during the riveting process (**medium photo**).

During deriveting the brake shoe supports stay in the stand-by position (**lower photo**).

Advantages of the new process

- Faster riveting.
- Optimal alignment between rivet holes in lining and shoe.
- Can be retrofitted to all previously supplied HUNGER N 332 riveting machines.

Low cost pneumatic riveting machine



Accurate riveting of brake linings is an essential requirement for the safe operation of vehicle brakes and avoidance of a major source of brake squeal.

With the N 333 the rapid and correct riveting and deriveting of brake linings is an easy and comfortable job.

The machine has a maximum riveting force of **50,000 N** at a working pressure of **9 bar**.

The riveting force can be infinitely varied in accordance with the rivet diameter and read directly on the pressure gauge. This facilitates faultless results without damage in the vicinity of the rivet.

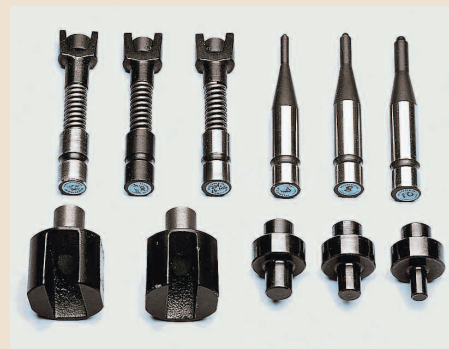
The riveting stroke of 50 mm ensures trouble free operation even when access is difficult.

The tool speed of **1,65 m/min** makes for rapid throughput.

The quick change tool clamps provide simple and quick tool changes, shortening down time.

The machine can either be mounted on a bench or on a pedestal (option).

Riveting tools



Tools for riveting and deriveting in various versions and all possible sizes.

Riveting punches with a preload spring press the lining and shoe closely together before clinching the rivet, thus avoiding loose linings.

These tools fit all HUNGER riveting machines.

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