

Fastening Technology / Installation Technology

## RL-2 Series

Tools for blind rivets,  
and lockbolt systems





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RL-2 Series



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# Titgemeyer Tools & Automation

Titgemeyer Tools & Automation was originally formed under the name RIVETEC in 1990 in the Czech town of Albrechtice. The company has been a member of Titgemeyer Group since the year 2000 and is now based in Pisek. The company develops, produces and sells professional riveting tools that can be used for every type of rivet and rivet application - including with process control. Titgemeyer Tools & Automation also designs and manufactures bespoke special finishing tools, assembly lines and automation solutions.



## Presenting: a new series of hydro-pneumatic riveting tools

The high-performance RL Series has proven to be a valuable set of tools for the trades and industrial companies alike. Their versatility, allowing them to be used for a broad range of applications, is one of their outstanding features. Day in, day out, these tools prove their durability, reliability and sturdiness - even in the toughest of conditions.

This new series has been developed on the basis of preceding tools but comes complete with entirely new functional components - these changes have led us to create a new, competitive tool with a long list of enhancements.

# Powerful

## High riveting force

Without losing the original compact design, we have succeeded in increasing the riveting force delivered by our RL-2 Series. Their improved strength and reduced weight have resulted in very high-performance hydro-pneumatic riveting tools with built-in power reserves for performing the desired applications.



## Low-weight

Every tool is dramatically lighter than its predecessor.

## Sturdy design

The new professional RL-2 tools have been manufactured to withstand the tough conditions of any production line.

## High-quality finish

Through our long-standing experience in the manufacture of riveting tools, we can supply our customers with tools that offer a very high-quality finish.

## Benefits at a glance

- Low-weight
- High riveting force
- Fast installation speed
- Enhanced ergonomics
- Improved centre of gravity
- Easy to manoeuvre
- Low-noise
- Improved cost-effectiveness
- Easy to maintain
- Very high-quality finish
- Sturdy design
- Easy to use
- Extensive range of accessories
- Protective rubber base
- Easy to use; low maintenance
- Reliable and tried-and-tested
- ISO 9001 certified
- CE Mark



# Time-saving

## Improved cost-effectiveness

The new RL-2 Series of riveting tools (RL20-2 and RL60-2) now come with a separate air suction trigger as standard. This feature dramatically improves the tool's cost-effectiveness as the air suction trigger is only used when the tool is in operation.



## Easy to handle

Operating the tool couldn't be easier or simpler. Needless to say, the balancer suspension attachment has not been changed and comes supplied with every tool.

## Compatible accessories

Almost every accessory has been made to be compatible with the new tool and its predecessor, making it easy to switch from an old tool to the new one.

## A wealth of accessories

Our range of available accessories means that these tools can perform the vast majority of applications.





### Benefits at a glance

- Low-weight
- High riveting force
- Fast installation speed
- Enhanced ergonomics
- Improved centre of gravity
- Easy to manoeuvre
- Low-noise
- Improved cost-effectiveness
- Easy to maintain
- Very high-quality finish
- Sturdy design
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### Protective rubber base

The new tools come with a protective rubber base to protect the tool against knocks and bumps.

### Easy to maintain

While developing the new RL-2 Series, we envisioned designing them in such a way that caring for them would be as simple as possible. Our approach was to simplify as many elements as possible to enable fast disassembly and assembly of the tool and its components.

In some cases, not a single tool is needed in order to carry out the maintenance work.

### Easy oil refill

One of the new features has been to improve the location of the oil refill screw, which has been relocated from the lower rear side of the handle to the top of the tool. This new location is ideal as the tool can be placed on the workbench whenever oil needs be refilled or air removed from the hydraulic system.



# Fast

## **Faster rivet installation cycles**

By incorporating an innovative rivet system, the new tools are 30% faster than their current RL Series counterparts.

The entire rivet installation cycle now only takes around 1 second.

## **Automatic rivet installation cycle**

The entire line of products comes equipped with an automatic, full rivet installation cycle. A full rivet installation cycle is performed each time that the trigger is operated.



## **Greater mobility**

The tool's manoeuvrability has been considerably improved. The air connection has been relocated to the rear centre of the tool. Relocating the connection now means that both left-handed and right-handed operators can use every feature of the tool.

# Ergonomic

## **Enhanced ergonomics**

The tool's handling and ergonomics have been significantly improved. The trigger for starting the rivet installation task has been replaced. The new trigger requires less force to activate, making it more operator-friendly than its predecessor.

## **Higher centre of gravity**

Both the centre of gravity and the overall manoeuvrability of the tool have been improved. The centre of gravity has been moved to exactly where it belongs - from the lower end of the tool to its centre. Now, every new tool is easier to operate and more comfortable in the hand. The pressure placed on the operator's wrist has been reduced.





# Expert advice



## Our advice reaps the perfect results for you

For over 100 years, our company has been a standard bearer for expert advice and first-class service.



## Technical support

We offer our customers comprehensive technical support. This includes general advice, an analysis of the specific requirements, implementation, operator training and maintenance.

Even the best technology starts to show signs of wear and tear at some point. And to ensure that we quickly detect when this time comes, we offer a professional maintenance and repair service - in our dedicated workshop.

## Our replacement tools to keep your production going

Would you like us to repair or maintain your tools, or do you need a spare? Not a problem. On request, we will lend you the spare tool that you need from our service pool.

This is our service to you so that you can continue your work without interruption.

## Benefits at a glance

- Low-weight
- High riveting force
- Fast installation speed
- Enhanced ergonomics
- Improved centre of gravity
- Easy to manoeuvre
- Low-noise
- Improved cost-effectiveness
- Easy to maintain
- Very high-quality finish
- Sturdy design
- Easy to use
- Extensive range of accessories
- Protective rubber base
- Easy to use; low maintenance
- Reliable and tried-and-tested
- ISO 9001 certified
- CE Mark

**Get on touch. We will be happy to advise you.**

## RL20-2

### Fast installation speed and high stroke

The RL20-2 is a hydro-pneumatic riveting tool for installing blind rivets ranging from 2.4 mm to 5.0 mm in diameter. It is a truly lightweight tool that feels good in the hand. Its rivet installation speed is less than one second. The RL20-2 has a 19 mm stroke coupled with an insertion force of 11.9 kN at 6 bar. It is reliable, quiet and easy to operate. A tool designed for use by the trades - powerful, fast, time-saving.



### Benefits at a glance

- High speed processing cycle
- Riveting cycle faster than 1 second
- Economical air consumption due to separate trigger
- Simple handling
- Easy to maintain
- Low weight
- Balanced pressure point at the trigger
- Center of gravity of the tool is in the middle of the tool
- Ergonomic handle
- Air connection at the Back of the tool
- Suspension device for balancer
- Tool-free removal of the pulling unit
- Safety relief valve in the tool
- Rivet mandrel container with quick release

**RL20-2**

Pneumatic-hydraulic riveting tool  
for processing blind rivets 2,4 mm - 5,0 mm.

**Technical specifications**

Weight (according to the version): 1,4 kg  
 Dimensions (HxL): 269 x 277 mm  
 Blind rivet diameter: 2,4 - 5 mm,  
 max. mandrel Ø 4 mm  
 Pulling force: 11,9 kN / 6 bar  
 Stroke: 19 mm  
 Rivet cycle: 0,9 s (without rivet)  
 Air consumption for 1 rivet: 2,7 l  
 Noise level: 86,5 dB  
 Operating pressure: 6 bar  
 Air supply connection: 6 mm (G 1/4")  
 Hydraulic oil standard: ISO HN 32  
 Hydraulic oil example: OH-HM 32  
 Lubricant standard: ISO XCCHB-2  
 Lubricant example: LV2EP

**Scope of delivery**

RL20-2 rivet installation tool  
 Nose pieces: 2.4 mm; 3.0 / 3.2 mm; 4.0 mm; 4.8 / 5.0 mm  
 Oil refill set  
 Angled air supply  
 Operating instructions  
**Article No. 431 450 700**

**Working range**

Rivet Ø [mm]	2.4*	3.0/3.2	4.0	4.8/5.0	6.0	6.4
Aluminium, copper, brass	•	•	•	•		
Steel	•	•	•	•		
Stainless steel	•	•	•	•		

\* Depending on rivet type

\*\* Not suitable for cup-type blind rivets.



## RL60-2

### For every event

The RL60-2 blind rivet installation tool not only handles standard and cup-type blind rivets but also high-strength special blind rivets with high clamp strength. Its 27 mm stroke coupled with an insertion force of 17.9 kN at 6 bar make the RL60-2 a high-performance all-rounder. A rivet installation cycle takes around one second to complete. The hydro-pneumatic riveting tool ensures that work can be carried out safely. Its versatility allows it to be used in workshops or industrial companies alike – powerful, fast, time-saving.



### Benefits at a glance

- High speed processing cycle
- Riveting cycle approx. 1 second
- Economical air consumption due to separate trigger
- Simple handling
- Easy to maintain
- Low weight
- Balanced pressure point at the trigger
- Center of gravity of the tool is in the middle of the tool
- Ergonomic handle
- Air connection at the back of the tool
- Suspension device for balancer
- Tool-free removal of the pulling unit
- Safety relief valve in the tool
- Rivet mandrel container with quick release

**RL60-2**

Pneumatic-hydraulic riveting tool for processing blind rivets 4.0 mm - 6.4 mm and high-strength blind rivets 4,8 mm - 6,4 mm

**Technical specifications**

Weight (according to the version): 1,99 kg  
 Dimensions (HxL): 331 x 336 mm  
 Blind rivet diameter: 4,0 - 6,4 mm, max. mandrel Ø 4 mm  
 Pulling force: 17,9 kN / 6 bar  
 Stroke: 27 mm  
 Rivet cycle: 1,0 s (without rivet)  
 Air consumption for 1 rivet: 5,8 l  
 Noise level: 85,5 dB  
 Operating pressure: 6,0 bar, max. 7 bar  
 Air supply connection: 6 mm (G 1/4")  
 Hydraulic oil standard: ISO HN 32  
 Hydraulic oil example: OH-HM 32  
 Lubricant standard: ISO XCCHB-2  
 Lubricant example: LV2EP



**Scope of delivery**

RL60-2 rivet installation tool  
 Nose pieces: 4,0 mm; 4,8 / 5,0 mm; 6,0 mm; 6,4 mm;  
 Oil refill set  
 Angled air supply  
 Operating instructions  
**Article No. 431 500 750**

**Working range**

Rivet Ø [mm]	2.4	3.0/3.2	4.0	4.8/5.0	6.0	6.4
Aluminium, copper			•	•	•	•
Steel			•	•	•	•
Stainless steel			•	•	•	•*

\* Depending on rivet type

**Working range - high-strength blind rivets**

Fastener	TIBULB			TIBULB Plus	HUCKLOK	Magna-Lok/ M-Lock			TIFAS M-Bolt		Magna-Bulb			BOM						
	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]				
	4.8	6.4	7.8	6.4	6.4	4.8	6.4	9.5	4.8	6.4	4.8	6.4	7.8	4.8	6.4	7.8	9.5	12.7	15.9	19.1
Aluminium	•					•	•		•	•										
Steel	•	(•)*		(•)*	•	•	•		•	•	•	•								
Stainless steel	•					•	•		•	•										

\* Can be used if tool is retrofitted with jaw case retrofit kit 431 821 870 and nose piece 431 502 870.

## RL75-2

### Perfectly installed lockbolts

The RL75-2 is a hydro-pneumatic riveting tool for installing lockbolts and high-strength blind rivets made of aluminium, steel or stainless steel with a working range of 4.8 to 6.4 mm. It has a 17 mm stroke and an insertion force of 28 kN at 6 bar.

Its high capacity and ease of use are stand-out features of this high-performance installation tool - powerful, fast, time-saving.



### Benefits at a glance

- High speed processing cycle
- Easy handling
- Easy to maintain
- Low weight
- High pulling force
- Balanced pressure point on the trigger
- Ergonomic handle
- Center of gravity of the tool is in the middle of the tool
- Air connection at the back of the tool
- Suspension device for balancer
- Safety relief valve in the tool
- Rivet mandrel container with quick release (optionally available adapter + container)

**RL75-2**

Pneumatic-hydraulic riveting tool for processing lockbolts and high-strength blind rivets..

**Technical specifications**

Weight (according to the version):	1,71 kg
Dimensions (HxL):	331 x 218 mm
Lockbolts:	5,0 - 6,5 mm
High-strength blind rivets:	4,8 - 6,4 mm
Pulling force:	28 kN / 6 bar
Stroke:	17 mm
Rivet cycle:	0,9 s (without rivet)
Air consumption for 1 rivet:	5,8 l
Noise level:	86 dB
Operating pressure:	6,0 bar, max. 7 bar
Air supply connection:	6 mm (G 1/4")
Hydraulic oil standard:	ISO HN 32
Hydraulic oil example:	OH-HM 32
Lubricant standard:	ISO XCCHB-2
Lubricant example:	LV2EP



**Scope of delivery**

- RL75-2 rivet installation tool
- Oil refill set
- Angled air supply
- Operating instructions
- Article No. 385 060 350

**Working range - lockbolts\***

Fastener	Standard lockbolt ø [mm]				DeltaBolt® lockbolt ø [mm]				Multigrip lockbolt ø [mm]				Hucktainer® Plus ø [mm]
	4.8	6.4	8.0	9.6	4.8	6.4	8.0	9.6	4.8	6.4	7.8	9.6	9.5
Aluminium	.	.							.	.			
Steel	.	.			.	.			.	.			.
Stainless steel	.	.							.	.			

**Working range - high-strength blind rivets\***

Fastener	TIBULB blind rivet ø [mm]			M-LOCK blind rivet ø [mm]			MAGNA-BULB® blind rivet ø [mm]			BOM® blind rivet ø [mm]			
	4.8	6.4	7.8	4.8	6.4	9.5	4.8	6.4	7.8	4.8	6.4	7.8	9.5
Aluminium	.	.		.	.								
Steel	.	.	.	.	.		.	.					
Stainless steel	.	.		.	.								

Subject to change

Pulling heads are not included in the scope of delivery.

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## About us

The Titgemeyer Group is a leading company for fastening technology fastening technology and vehicle components at 15 locations in Europe. The traditional company develops, manufactures and sells more than 30,000 fastening elements, tools and vehicle components – in series production and on request.

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