



***sigma***

**Quality range of Hydro-Pneumatic  
power tools designed for the  
installation of rivets and rivet nuts**

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- *Lightweight and ergonomic with balanced handling to cater for all industries*
- *Complete Range of fast efficient durable tools*
- *Maintenance friendly with quick disconnect nose housing and jaw case for easy cleaning.*

***sigma***

The word "sigma" is written in a bold, italicized, sans-serif font. The letters are filled with a blue-tinted image of industrial machinery, specifically what appears to be a lathe or a similar precision manufacturing tool. The background of the entire image is a solid dark blue.

## 1. Rivet tools

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### RL-4000 Series

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### 1. Standard Models

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## 1.1.1 RL-4000S

The RL-4000S is compact and lightweight. This tool, combined with its sigma tech reliability, is the ideal tool for production lines with rivets up to 4.0mm.

- Ergonomic jaw case allows fast manual removal to enable easy maintenance
- Suitable for applications up to 4.0mm rivets
- Ergonomic compact lightweight design
- 5-7 Bar operating pressure
- Pull traction control
- Ergonomically designed manual release jaw case (enabling easy maintenance)
- Low operator fatigue
- Ideal tool for electronics and light industry applications



### Specification

Weight	Height	Length	Tool stroke	Air pressure	Pull force	Air consumption
0.98kg	238mm	208mm	18mm	5.0-7.0bar	4850N	60L/min

### Rivet Capacity

Rivet type	Rivet material	Rivet size		
	Body-rod	[2.4mm]	[3.2mm]	[4.0mm]
Open type	aluminum-aluminum	✓	✓	✓
	aluminum-iron	✓	✓	✓
	iron-iron	✓	✓	✓
	sst-sst	✓	✓	✓
Close type	aluminum-aluminum	✓	✓	✓
	al.-iron/ss	✓	✓	✓
	iron-iron	✓	✓	✓
Bulb	type al.-al.	✓	✓	✓
Grip type	iron-iron	✓	✓	✓
Peel type	al.-iron	✓	✓	✓
Self-lock type	iron-iron	✓	✓	



## 1.1.2 RL-4000SL

The RL-4000SL is compact and lightweight yet manages to incorporate an impressive 28mm single pull tool stroke, essential for longer rivets

- Ergonomic compact lightweight design
- Extra long 28mm tool stroke
- 5-7 Bar operating pressure
- Pull traction control
- Ergonomically designed manual release jaw case (enabling easy maintenance)
- Low operator fatigue
- Ideal tool for installation of single pull long rivets



### Specification

Weight	Height	Length	Tool stroke	Air pressure	Pull force	Air consumption
1.18kg	265mm	228mm	28mm	5.0-7.0bar	6000N	60L/min

### Rivet Capacity

Rivet type	Rivet material	Rivet size		
	Body-rod	[2.4mm]	[3.2mm]	[4.0mm]
Open type	aluminum-aluminum	√	√	√
	aluminum-iron	√	√	√
	iron-iron	√	√	√
	sst-sst	√	√	√
Close type	aluminum-aluminum	√	√	√
	al.-iron/ss	√	√	√
	iron-iron	√	√	√
Bulb	type al.-al.	√	√	√
Grip type	iron-iron	√	√	√
Peel type	al.-iron	√	√	√
Self-lock type	iron-iron	√	√	√

## 1.1.3 RL-4000M

The RL-4000M is sigma tech's most popular non vacuum riveter. It incorporates all the benefits of the range but features a 9400N pull force allowing a greater rivet capacity.

- Ergonomic compact lightweight design
- Reduced head diameter
- Pull traction control
- 5-7 Bar operating pressure
- Maximum pull force 9400N
- Ergonomically designed manual release jaw case (enabling easy maintenance)
- Low air consumption



### Specification

Weight	Height	Length	Tool stroke	Air pressure	Pull force	Air consumption
1.28kg	270mm	216mm	18mm	5.0-7.0bar	9400N	70L/min

### Rivet Capacity

Rivet type	Rivet material	Rivet size		
	Body-rod	[3.2mm]	[4.0mm]	[4.8mm]
Open type	aluminum-aluminum	✓	✓	✓
	aluminum-iron	✓	✓	✓
	iron-iron	✓	✓	✓
	sst-sst	✓	✓	
Close type	aluminum-aluminum	✓	✓	✓
	al.-iron/ss	✓	✓	✓
	iron-iron	✓	✓	✓
	sst-sst	✓	✓	
Bulb type	al.-al.	✓	✓	✓
Grip type	iron-iron	✓	✓	✓
Peel type	al.-iron	✓	✓	✓
Self-lock type	iron-iron	✓	✓	✓
Cup lock type	iron-iron			✓
	sst-sst			✓

## 1.1.4 RL-4000L

The RL-4000L combines 11800N of pull force with a 20mm stroke whilst only having an air consumption of 75L/min. Ideal for 6.4mm aluminium / iron rivets.

- Ergonomic compact lightweight design
- Pull traction control
- 5-7 Bar operating pressure
- Maximum pull force 11800N
- Ergonomically designed manual release jaw case (enabling easy maintenance)
- Heavy duty 6.4mm diameter riveter (aluminium)



### Specification

Weight	Height	Length	Tool stroke	Air pressure	Pull force	Air consumption
1.46kg	281mm	216mm	20mm	5.0-7.0bar	11800N	75L/min

### Rivet Capacity

Rivet type	Rivet material	Rivet size		
	Body-rod	[4.0mm]	[4.8mm]	[6.4mm]
Open type	aluminum-aluminum	✓	✓	✓
	aluminum-iron	✓	✓	
	iron-iron	✓	✓	✓
	sst-sst	✓	✓	
Close type	aluminum-aluminum	✓	✓	✓
	al.-iron/ss	✓	✓	
	iron-iron	✓	✓	✓
	sst-sst	✓	✓	
Bulb type	al.-al.	✓	✓	✓
Grip type	iron-iron	✓	✓	
Peel type	al.-iron	✓	✓	✓
Self-lock type	iron-iron	✓	✓	✓
Cup lock type	al.-al. & iron-iron & sst-sst	✓	✓	

## 1.1.5 RL-4000H

The RL-4000H combines a maximum 18500N of pull force with a 26mm stroke. This sigma tech heavy duty riveter can install rivets up to 6.4mm including stainless steel, hemlock, and various structured rivets.

- Ergonomic compact design
- 5-7 Bar operating pressure
- Pull traction control
- Maximum pull force 18500N
- Ergonomically designed manual release jaw case (enabling easy maintenance)
- Heavy duty 6.4mm diameter riveter (aluminium)



### Specification

Weight	Height	Length	Tool stroke	Air pressure	Pull force	Air consumption
1.96kg	327mm	222mm	26mm	5.0-7.0bar	18500N	80L/min

### Rivet Capacity

Rivet type	Rivet material	Rivet size	
	Body-rod	[4.8mm]	[6.4mm]
Open type	aluminum-aluminum	✓	✓
	aluminum-iron	✓	✓
	iron-iron	✓	✓
	sst-sst	✓	✓
Close type	aluminum-aluminum	✓	✓
	al.-iron/sst & cuprum-iron	✓	✓
	iron-iron	✓	✓
	sst-sst	✓	✓
Bulb type	al.-al.	✓	✓
Grip type	iron-iron	✓	✓
Peel type	al.-iron	✓	✓
Self-lock type	iron-iron	✓	✓
Cup lock type	al.-al. & iron-iron & sst-sst	✓	✓



## 1.2.1 RL-4000SV

The RL-4000SV is compact and lightweight. This vacuum stem collector model, combined with its sigma tech reliability, is the ideal tool for production lines with rivets up to 4.0mm.

- Ergonomic compact lightweight design
- 5-7 Bar operating pressure
- Pull traction control
- Ergonomically designed manual release jaw case (enabling easy maintenance)
- Low operator fatigue
- Built in energy efficient on off control valve
- Quick release vacuum rivet nail collector
- Ideal tool for electronics and light industry applications



### Specification

Weight	Height	Length	Tool stroke	Air pressure	Pull force	Air consumption
1.12kg	238mm	291mm	18mm	5.0-7.0bar	4850N	60L/min

### Rivet Capacity

Rivet type	Rivet material	Rivet size		
	Body-rod	[2.4mm]	[3.2mm]	[4.0mm]
Open type	aluminum-aluminum	✓	✓	✓
	aluminum-iron	✓	✓	✓
	iron-iron	✓	✓	✓
	sst-sst	✓	✓	
Close type	aluminum-aluminum	✓	✓	✓
	al.-iron/ss	✓	✓	
	iron-iron	✓	✓	✓
Bulb type	al.-al.	✓	✓	✓
Grip type	iron-iron	✓	✓	✓
Peel type	al.-iron	✓	✓	✓
Self-lock type	iron-iron	✓	✓	

## 1.2.2 RL-4000SLV

The RL-4000SLV is a vacuum stem collector model. It is compact and lightweight yet manages to incorporate an impressive 28mm single pull tool stroke, essential for longer rivets.

- Ergonomic compact lightweight design
- Extra long 28mm tool stroke
- 5-7 Bar operating pressure
- Pull traction control
- Ergonomically designed manual release jaw case (enabling easy maintenance)
- Low operator fatigue
- Built in energy efficient on off control valve
- Quick release vacuum rivet nail collector
- Ideal tool for installation of single pull long rivets



### Specification

Weight	Height	Length	Tool stroke	Air pressure	Pull force	Air consumption
1.32kg	265mm	312mm	28mm	5.0-7.0bar	6000N	60L/min

### Rivet Capacity

Rivet type	Rivet material	Rivet size		
	Body-rod	[2.4mm]	[3.2mm]	[4.0mm]
Open type	aluminum-aluminum	✓	✓	✓
	aluminum-iron	✓	✓	✓
	iron-iron	✓	✓	✓
	sst-sst	✓	✓	✓
Close type	aluminum-aluminum	✓	✓	✓
	al.-iron/ss	✓	✓	✓
	iron-iron	✓	✓	✓
Bulb type	al.-al.	✓	✓	✓
Grip type	iron-iron	✓	✓	✓
Peel type	al.-iron	✓	✓	✓
Self-lock type	iron-iron	✓	✓	✓

## 1.2.3 RL-4000MV

The RL-4000MV is sigma tech's most popular vacuum riveter. It incorporates all the benefits of the range but features a 9400N pull force allowing a greater rivet capacity.

- Ergonomic compact lightweight design
- Reduced head diameter
- Pull traction control
- 5-7 Bar operating pressure
- Maximum pull force 9400N
- Ergonomically designed manual release jaw case (enabling easy maintenance)
- Low air consumption
- Built in energy efficient on off control valve
- Quick release vacuum rivet nail collector



### Specification

Weight	Height	Length	Tool stroke	Air pressure	Pull force	Air consumption
1.44kg	270mm	300mm	18mm	5.0-7.0bar	9400N	70L/min

### Rivet Capacity

Rivet type	Rivet material	Rivet size		
	Body-rod	[3.2mm]	[4.0mm]	[4.8mm]
Open type	aluminum-aluminum	✓	✓	✓
	aluminum-iron	✓	✓	✓
	iron-iron	✓	✓	✓
	sst-sst	✓	✓	
Close type	aluminum-aluminum	✓	✓	✓
	al.-iron/ss	✓	✓	✓
	iron-iron	✓	✓	✓
	sst-sst	✓	✓	
Bulb type	al.-al.	✓	✓	✓
Grip type	iron-iron	✓	✓	✓
Peel type	al.-iron	✓	✓	✓
Self-lock type	iron-iron	✓	✓	✓

## 1.2.4 RL-4000LV

The RL-4000LV combines 11800N of pull force with a 20mm stroke whilst only having an air consumption of 75L/min. Ideal for 6.4mm aluminium / iron rivets.

- Ergonomic compact lightweight design
- Pull traction control
- 5-7 Bar operating pressure
- Maximum pull force 11800N
- Ergonomically designed manual release jaw case (enabling easy maintenance)
- Heavy duty 6.4mm diameter riveter (aluminium)
- Built in energy efficient on off control valve
- Quick release vacuum rivet nail collector



### Specification

Weight	Height	Length	Tool stroke	Air pressure	Pull force	Air consumption
1.58kg	281mm	300mm	20mm	5.0-7.0bar	11800N	75L/min

### Rivet Capacity

Rivet type	Rivet material	Rivet size		
	Body-rod	[4.0mm]	[4.8mm]	[6.4mm]
Open type	aluminum-aluminum	✓	✓	✓
	aluminum-iron	✓	✓	
	iron-iron	✓	✓	✓
	sst-sst	✓	✓	
Close type	aluminum-aluminum	✓	✓	✓
	al.-iron/ss	✓	✓	
	iron-iron	✓	✓	✓
	sst-sst	✓	✓	
Bulb type	al.-al.	✓	✓	✓
Grip type	iron-iron	✓	✓	
Peel type	al.-iron	✓	✓	✓
Self-lock type	iron-iron	✓	✓	✓
Cup lock type	al.-al. & iron-iron & sst-sst	✓	✓	



## 1.2.5 RL-4000HV

The RL-4000HV combines a maximum 18500N of pull force with a 26mm stroke. This sigma tech heavy duty riveter can install rivets up to 6.4mm including stainless steel, hemlock, and various structured rivets. Now available with vacuum rivet nail collection.

- Ergonomic compact design
- 5-7 Bar operating pressure
- Pull traction control
- Maximum pull force 18500N
- Ergonomically designed manual release jaw case (enabling easy maintenance)
- Heavy duty 6.4mm diameter riveter (aluminium)
- Built in energy efficient on off control valve
- Quick release vacuum rivet nail collector



### Specification

Weight	Height	Length	Tool stroke	Air pressure	Pull force	Air consumption
2.28kg	327mm	327mm	26mm	5.0-7.0bar	18500N	80L/min

### Rivet Capacity

Rivet type	Rivet material Body-rod	Rivet size	
		[4.8mm]	[6.4mm]
Open type	aluminum-aluminum	✓	✓
	aluminum-iron	✓	✓
	iron-iron	✓	✓
	sst-sst	✓	✓
Close type	aluminum-aluminum	✓	✓
	al.-iron/sst & cuprum-iron	✓	✓
	iron-iron	✓	✓
	sst-sst	✓	✓
Bulb type	al.-al.	✓	✓
Grip type	iron-iron	✓	✓
Peel type	al.-iron	✓	✓
Self-lock type	iron-iron	✓	✓
Cup lock type	al.-al. & iron-iron & sst-sst	✓	✓

## 1.3 Extended Nose Riveters



Sigma extended nose models are ideal for inconvenient, confined, or deep hole applications. The reduced weight and nose diameter ensures the renowned sigma tech ergonomics are maintained, retaining maximum operator comfort.

- Ergonomically designed manual release jaw case (enabling easy maintenance).
- Quick release vacuum rivet nail collector.

### Specification

Model	Weight	Pipe Diameter	Pipe Length	Tool stroke	Air pressure	Pull force	Air consumption	Rivet size
RL-4100SV	1.26kg	17.4mm	189mm	18mm	5.0-7.0bar	4850N	60L/min	2.4-4.0
RL-4100SLV	1.46kg	17.4mm	199mm	18mm	5.0-7.0bar	6000N	60L/min	2.4-4.0
RL-4100MV	1.54kg	20.5mm	194mm	18mm	5.0-7.0bar	9400N	70L/min	3.2-4.8
RL-4100LV	1.68kg	20.51mm	194mm	18mm	5.0-7.0bar	11800N	75L/min	4.0-6.4
RL-4100HV	2.48kg	22.3mm	207mm	26mm	5.0-7.0bar	18500N	80L/min	4.8-6.4

## 1.4 Auxiliary Control Riveters



Designed to meet the growing automation market the sigma tech auxiliary control riveters are ideal for "hands free" applications including multi tool start and fixtured tooling.

- Operate the tool via a pedal switch or alternative method.
- Can be used in a fixed position for convenience.
- Both hands are made available for other work to improve efficiency.
- Multiple tools can be operated simultaneously by a single command.

### Specification

Model	Weight	Length	Tool stroke	Air pressure	Pull force	Rivet size
RL-4200S	0.98kg	238mm	18mm	5.0-7.0bar	4850N	2.4-4.0
RL-4200SV	1.12kg	238mm	18mm	5.0-7.0bar	4850N	2.4-4.0
RL-4200SL	1.18kg	265mm	28mm	5.0-7.0bar	6000N	2.4-4.0
RL-4200SLV	1.32kg	265mm	28mm	5.0-7.0bar	6000N	2.4-4.0
RL-4200M	1.28kg	270mm	18mm	5.0-7.0bar	9400N	3.2-4.8
RL-4200MV	1.44kg	270mm	18mm	5.0-7.0bar	9400N	3.2-4.8
RL-4200L	1.46kg	281mm	20mm	5.0-7.0bar	11800N	4.0-6.4
RL-4200LV	1.58kg	281mm	20mm	5.0-7.0bar	11800N	4.0-6.4
RL-4200H	1.96kg	327mm	26mm	5.0-7.0bar	18500N	4.8-6.4
RL-4200HV	2.28kg	327mm	26mm	5.0-7.0bar	18500N	4.8-6.4

## 2.1.1 RL-0312



The number one choice for automatic installation of M3-M12 riv nuts.

- Simple single trigger operation
- High tensile long life mandrel
- Efficient tool stroke adjustment
- Revolutionary anti-jam sigma tech motor design
- High rotation clamp force control

### Specification

Weight	Height	Length	Tool stroke	Air pressure	Pull force	Air consumption
2.46kg	280mm	290mm	7mm	5.0-7.0bar	19000N	70L/min

### Rivet Sizes

Metric system:	M3, M4, M5, M6, M8, M10, M12
English system:	1/8, 5/32, 3/16, 1/4, 5/16, 3/8, 7/16, 1/2
American system:	6-32, 8-32, 10-24, 12-24, 1/4-20, 5/16-18, 3/8-16, 7/16-14, 1/2-13



## 2.1.2 RL-0312H - Rivet stud tool



- High Tensile install tool that can rivet different material studs from M4 -M10 quickly.
- High tensile drive mechanism
- Revolutionary anti-jam sigma tech motor design

### Specification

Weight	Height	Length	Tool stroke	Air pressure	Pull force	Air consumption
2.52kg	280mm	290mm	7mm	5.0-7.0bar	19000N	70L/min

### Rivet Sizes

Metric system:	M4,M5,M6,M8,M10
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## 2.2.1 RL-0310H



RL-0310H rivet stud gun is the dedicated tool & best choice for riveting stud ranges from M3~M8.

### Specification

Weight	Height	Length	Tool stroke	Air pressure	Pull force
2.15kg	295mm	280mm	7mm	5.0~7.0bar	19000N

### Rivet Sizes

Metric system:	M3,M4,M5,M6,M8
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## 3.1.1 RL-48A - Special angle head assembly



To cater for those awkward to reach applications we offer an angle head assembly, the tool will adapt to the standard RL-4000M non vacuum tool and it is an ideal addition to the range where a standard product cannot work due to access problems. The angle head will pull rivets upto 4.0mm in all materials.

### Specification

Weight	Height	Length	Rivet size	Elbow height	Elbow length	Elbow Weight
1.75kg	290mm	250mm	2.4/3.2/4.0	77.3mm	140.7mm	0.4kg

## Distributed By:

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