Heating of steel rivet ends (turbines)

**Objective**  Heating steel rivets prior to head forming

**Material**

**Temperature**  1292 ºF (700ºC)

**Frequency**  283 kHz

**Equipment**  
- Ambrell 3.5 kW induction heating system, equipped with a remote workhead containing one 1.5µF capacitor.
- An induction heating coil designed and developed specifically for this application.

**Process**  A single turn solenoid coil is used to heat the rivet to 1292 ºF (700ºC) for 10 to 15 seconds prior to head forming. A hand held work head is used.

**Results/Benefits**  Induction heating benefits:
- Easy to use because of the hand held unit and footswitch
- No flame or gas required
- Repeatable, fixed heat cycle
- Saves energy, only rivet head is heated
Single turn coil in place to heat rivet head for head forming

Coil heating rivet head