FASTENERS PRESS 824 PLUS

HIGH-PRECISION ASSEMBLY TECHNOLOGY

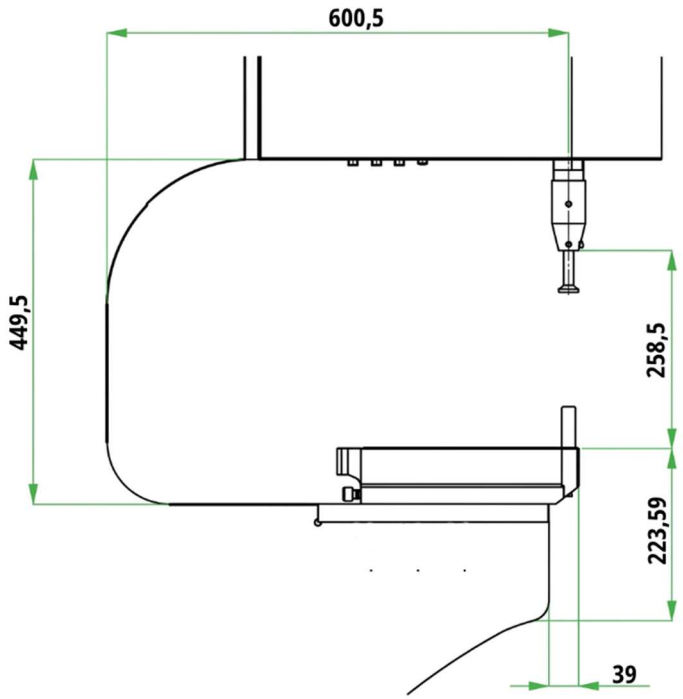
TECHNICAL SPECIFICATIONS

DATA AND STANDARD CONFIGURATION

TYPE	FASTENERS PRESS 824 PLUS
Die depth	600 mm
Maximum die height	450 mm
Punch stroke	250 mm
Upper punch approach speed	60 mm / sec
Anti-crushing protection system	Safety system with electrical conductivity check
Maximum pressure	80 kN (8T)
Uppear dead centre	10 mm – 100 mm
Drive system	Hydraulic with electronic control
Repeatability of set pressure	±1%
Touch screen	10" PLC
Dimensions (mm)	H x L x D 2050 - 1100 - 950
Electrical specifications	380V 5.5 kW / three-phase + neutral
Gross weight	1100 Kg

DIMENSIONS - FUNCTIONALITY

TECHNICAL DESIGN AND OPERATIONAL BENEFITS



Millimetre-precise dimensions of the press-fit groove for assessing the dimensions of the parts during the insertion stage

OPERATIONAL BENEFITS

- **Total safety:** integrated, comprehensive protection during operation, which eliminates any risk to the operator during the pressing cycle thanks to a safety system that monitors electrical conductivity.
- **Intuitive ease of use:** immediate and precise adjustment of the working pressure and punch stroke directly from the regulator located next to the pressure gauge.
- **Automation system designed for integration** with an automatic fastener feeding system (optional at the time of purchase).
- **Fast, optimised cycle times** to maximise line productivity and minimise downtime.
- **Minimal maintenance:** mechanical design intended to reduce the need for maintenance and ensure extremely high reliability.
- **Standard components:** all components fitted are top-of-the-range, reliable and readily available on the international market.

CONSTRUCTION TECHNOLOGY

CONTROLS, COMPONENTS AND ARCHITECTURE

A) Laser pointer
Indicates the insertion point on the plate with red dot, making it easier to identify the exact position of the hole in the mould.

B) Hydraulic cylinder

C) Display
Digital display for piece counting, setting the number of fasteners per cycle, counting the number of work cycles performed, and controlling the punch lift and automatic pressure control depending on the automatic kit.

D) The control panel features

- Emergency stop button
- Operating light
- Key switch to override the automatic cycle operation system (this bypasses the machine's safety feature, which requires the pedal to be pressed once to move the punch into position and a second press to authorise the work cycle).

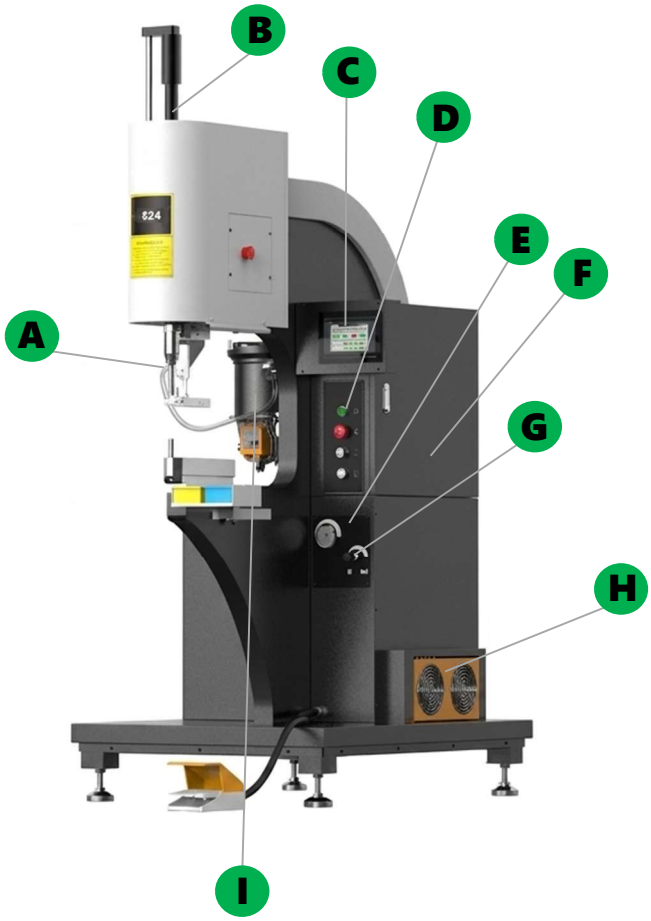
E) Automatic feeder settings
Recommended for the production of large batches of the same type of insert, it significantly increases productivity – by at least three times – compared with manual processing times.

F) Electrical panel
All the components are readily available.

G) Quick adjustment of the pressing force, which remains visible throughout each work cycle
It is very quick and easy to make precise adjustments for machining hard or particularly soft materials.

H) Hydraulic system cooling system

I) Automatic feeder (optional)

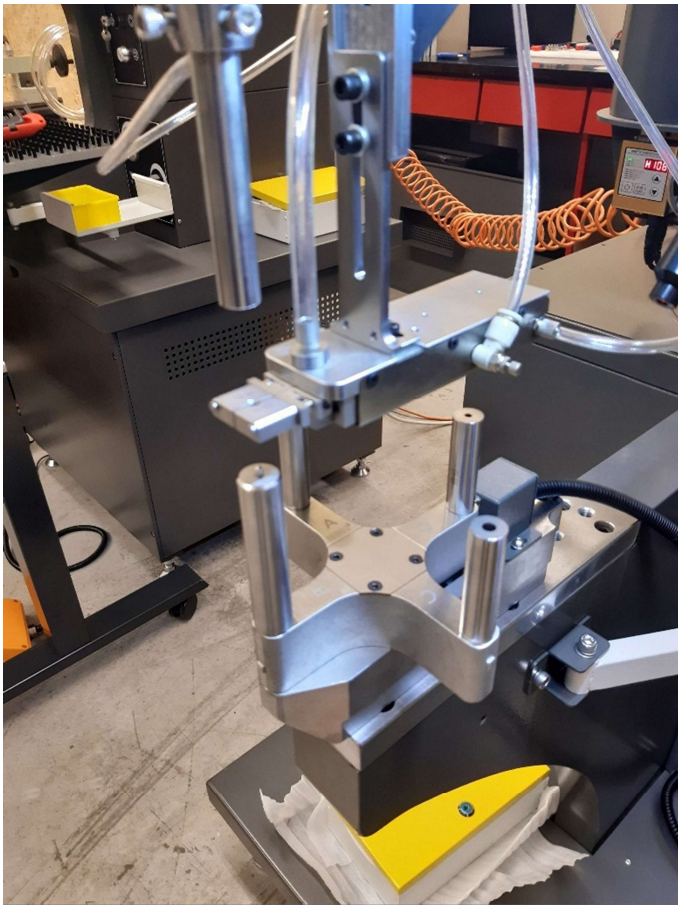


PROCESS AUTOMATION

AUTOMATIC DIE POSITIONING SYSTEM

Digital display

- **Piecework and cycle counting:** real-time monitoring of machined components and completed work cycles.
- **Element configuration:** precise setting of the number of fasteners for each individual cycle.
- **Punch management:** optimised control of the punch's lift and stroke.
- **Automatic pressure:** automatic adjustment and control of pressure depending on the kit installed. As the turret rotates, in both automatic and manual modes, the press automatically adjusts the pressure to the value set for each die.



Automatic nuts feeding kit

Available on request for:

- **M3 nut** (Ø 4,2 mm)
- **M4 nut** (Ø 5,4 mm)
- **M5 nut**
- **M6 nut**

Automatic studs feeding kit

Available on request for:

- **M3 Threaded stud** (L max 20 mm)
- **M4 Threaded stud** (L max 20 mm)
- **M5 Threaded stud** (L max 20 mm)
- **M6 Threaded stud** (L max 20 mm)

Automatic spacers feeding kit

Available on request for:

- **M3 spacer** (Ø 4,2 mm | L max 12 mm)
- **M3 spacer** (Ø 5,4 mm | L max 12 mm)
- **M4/M5 spacer** (Ø 7,2 mm | L max 12 mm)

EQUIPMENT AND ACCESSORIES

TOOL KITS AND PRODUCTION CONFIGURATIONS

Standard tool kit
Set of dies (one per type):
Self-clinching nuts M3 - M4 - M5 - M6 - M8
Self-clinching studs M3 - M4 - M5 - M6 - M8
Self-clinching spacers M3 (d.4,2) - M3 (d.5,4) M4/M5(d.7,2)
Punches: N° 2, one narrow profile and one wide profile
Set of allen keys from 0,5 mm to 10 mm
N° 1 Set of punch safety springs
N° 2 toolbox opening keys

Manual support bench (OPTIONAL)
An adjustable manual bench, fitted with a wheeled movement system. The design ensures maximum operational flexibility, allowing the accessory to be quickly locked into position or completely removed, depending on the machining requirements.

Automatic feeder
The press is designed to accommodate an automatic feeder, a solution recommended for high-volume mass production. The use of the automatic system significantly increases productivity compared with the manual cycle, reducing cycle times depending on the type and size of the components. The system replaces the standard tool kit and is compatible with the full range of fasteners that can be used on the 824 model.