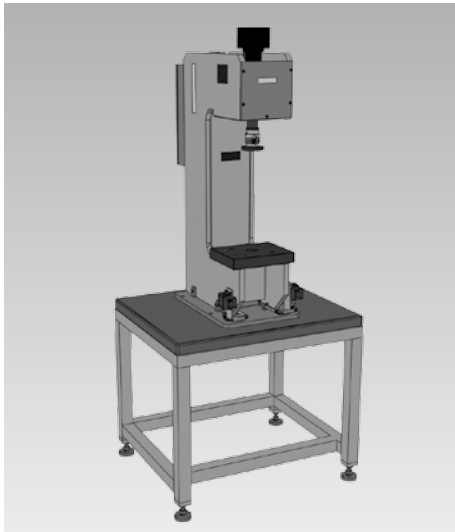




Press-in Devices, C-Frame Compact as Table-Top Version

Hydraulic drive, max. press-in force 40 to 100 kN with an integrated power unit and pressure switch-over



Advantages

- High forces / rigid frames
- No cost and time-consuming project planning
- Standardized drilling patterns for workpiece and tool holders provided by the customer
- Interchangeability of the individual elements by standardized drilling patterns
- Ergonomically designed operation
- Reduced space required
- Reduction of assembly time
- Process safety
- Sales of individual components

Application

These press-in devices are preferably used in assembly processes for the production of longitudinal pressed joints, riveted joints as well as for pressing out and testing of components.

Principal use

- Drive technology, gears box assembly
- Couplings, cardan shafts
- Compressors, pumps, hydraulic elements
- Industrial fittings
- Mechanical engineering
- Components for construction and agricultural machinery
- Electronics

Operation

For safety reasons, the press-in device is equipped with a two-hand operation. This has a divided design (two separate push-buttons) to allow workpiece feeding from the front. Alternatively, it is also possible to provide safety light grids or a protective covering. In such applications, function triggering is made by a push-button.

Description

The press-in device is a compact unit and excels by reduced space required and simple installation and start-up.

The electric control arranged behind the C-frame and the hydraulic power unit integrated in the C-frame control the hydraulic press-in cylinder on the C-frame.

On the base plate any workpiece carriers such as sliding tables can be mounted.

The piston rod of the press-in cylinder is equipped with a quick-changing device, at which the press-in tools can be mounted. This can optionally be replaced by other tool holders. The C-frame stands on an assembly table that is equipped with a wooden plate in standard design and is alternatively also available with a steel table plate.

modupress

Press-in device



Part-no. 6420-4XX-XXX

Technical characteristics

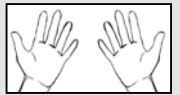
Max. press-in force: 40, 63, 100 kN
 Stroke: 100, 200, 300, 400 mm
 Actuation: hydraulic
 Frame type: C-frame

Control variant

- Pressure switch-over

Operations

- Two-hand operation



modupress interfaces

- Base plate:
140 x 140 – 4 x M10, 2 x Ø 18H7
- Tool holder:
In the bolt circle Ø 84 mm
4 counterbores M6

Accessories

- Tool holders
see data sheet P 9.200

Control variants

The C-frame press-in device is equipped with a pressure switch-over system.

Functional description

Input and output functions

The pressure required to adjust the maximum force can be adjusted by means of the pressure relief valve and read for control via the pressure gauge.

Functional description

Normal operation (press-in operation)

By operating the two mushroom push-buttons at the two-hand operating panel at the same time, the press-in cylinder extends (starting from the off-position). As soon as the set maximum force has been reached, the cylinder moves back to the off-position.

If the two-hand operation is released in an intermediate position, the press-in cylinder remains in this position.

When pressing the push-buttons again, the press-in cylinder moves in rapid speed to the off-position. Only after reaching the off-position, the press-in cylinder can be extended again.

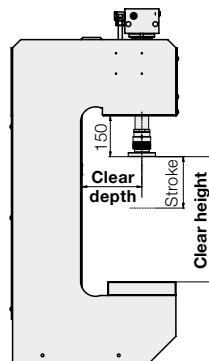
Setting mode

By means of a selector switch in the electric control, the press-in cylinder can be extended or retracted by manual control.

Function triggering is - in all operating conditions - only possible by operating simultaneously both mushroom push-buttons of the two-hand control.

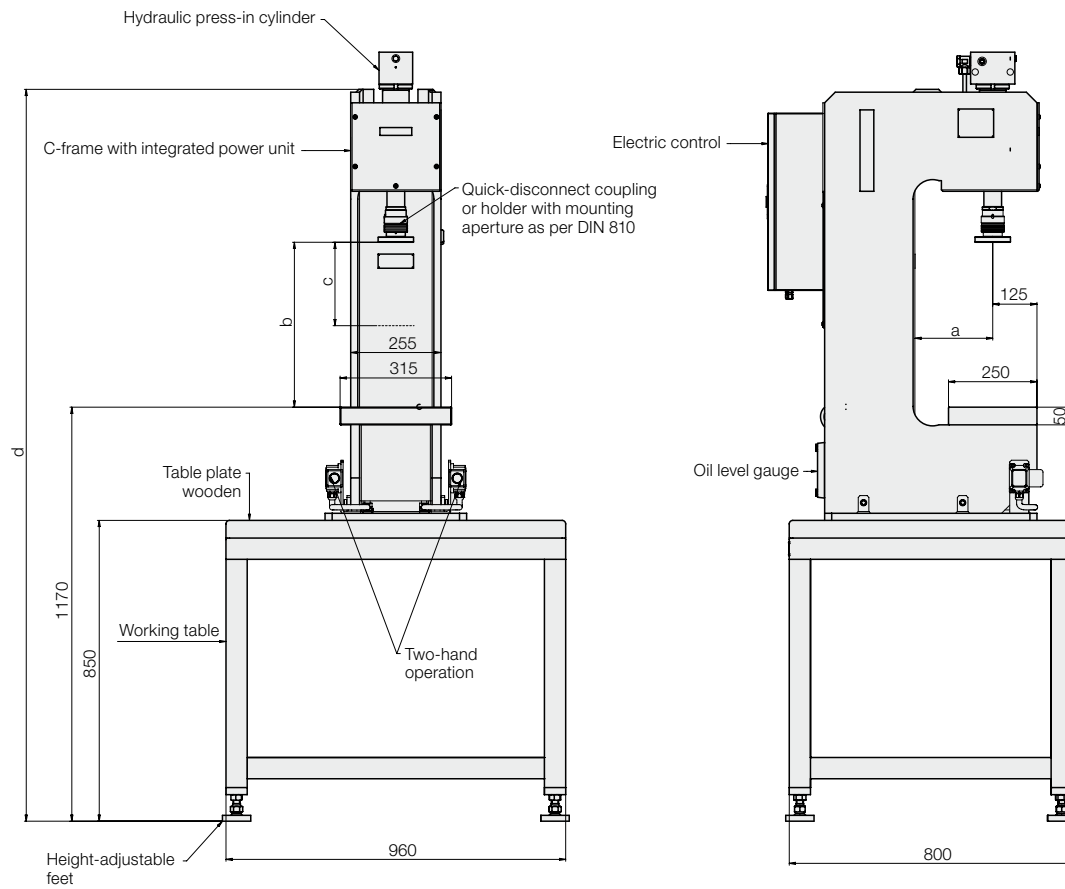
Code for part numbers - C-frame compact

6 4 2 0 - 4 X X - X X X				
Clear depth	Clear height	Press-in force	Stroke	Control variant
1 = 220 mm 2 = 330 mm	1 = 300 mm 2 = 460 mm 3 = 680 mm	1 = 40 kN 2 = 63 kN 3 = 100 kN	1 = 100 mm 2 = 200 mm 3 = 300 mm 4 = 400 mm	1 = Pressure switch-over



Example of ordering

6420-411-111 = C-frame hydraulic,
clear depth 220 mm,
clear height 300 mm,
40 kN,
stroke 100 mm,
pressure switch-over



Technical characteristics

Press-in force	[kN]	40 / 63 / 100
a = clear depth	[mm]	220 / 330
b = clear height	[mm]	300 / 460 / 680
c = cylinder stroke	[mm]	100 / 200 / 300 / 400
d = total height	[mm]	1,450 + b + stroke
Speed to extend	[mm/s]	approx. 25
Speed to retract	[mm/s]	approx. 40

Base plate

