



SPOT CLINCH[®] 4006 P35 PASS

Multi-purpose clinching machine

- Joining without fasteners
- Fast hydro-pneumatic actuator
- Safe pre-stroke 60mm
- Free hand: double foot pedal operation
- Positioning by laser pointer (option)



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High quality joining without fasteners

When clinching two or more layers of sheet metal, the material is deformed plastically inside a die through a squeezing process between punch and anvil. The joint is created as the material flows laterally pushing out the die walls.

The result is a high quality joint, without need of consumables such as screws or rivets, and without disturbing the coating, eliminating the need for post touch-up work as occurs with welding.

The easy end-of-stroke

setting nut of the SC 4006

P35 PASS

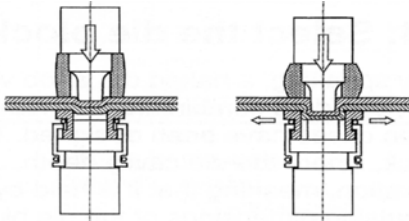
allows for

clinching

various

thicknesses and material combinations without re-

setting the tooling.



Multi-purpose, high productivity clinching machine

One of its unique features is the Passive Approach Stroke System (PASS). It consists of a separate foot pedal trigger for the approach stroke, which is run at low force. Once the punch gap is below 8mm, the second foot pedal can be activated for the clinching operation at full force. In addition to the safety aspect, the PASS facilitates the positioning of the tool at the clinch joint location prior to clinching. Furthermore, a laser pointer (option) allows precise and reproducible positioning. The hydropneumatic actuator is automatically controlled by an Optimized Cycle Controller (OCC) insuring that the clinch joint is completed in the shortest possible cycle time.

Wide range of applications

Due to its long and thin lower jaw, this unit has numerous applications in the ventilation industry and more generally in HVAC, building, appliance and many other sectors.

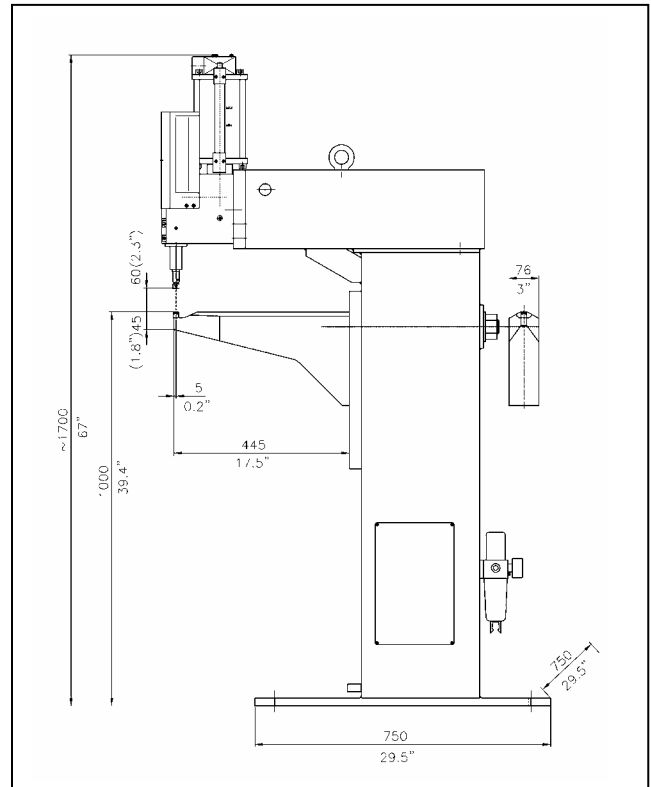


Technical specifications

Power source	6 bars (90 Psi)
Fastening force	35 kN (7.9 klbf)
Total stroke	60 mm (2.4")
Cycle time	0.8 s
Depth of jaw	445 mm (17.5")
Joint type	Round or rectangular
Max total thickness	Mild steel 3mm (.12")
	Stainless st. 2mm (.08")

Tool kits

The tool kits are selected from the original SPOT CLINCH[®] series ST 332/402/432 (rectangular) or SR402/SR403/SR502/SR503 /SR504 (round) as function of the application



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