

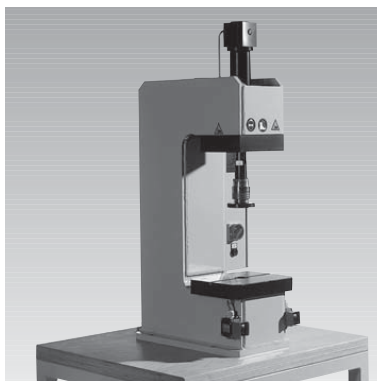


ROEMHELD

Issue 9-07 E

P 6.6030

Press-in Devices 25 - 63 kN table-top version with control



Advantages

- High flexibility in the operative range
- Improved ergonomics
- Repeatable quality
- Reduction of assembly time
- Short amortisation time
- Closed force-loop
- Defined force ratios
- Light component load
- Quick-change tooling system

Quick-change tooling system

The quick-change tooling system offers the possibility to change to other contact pieces within a very short time. Uncoupling of the quick-change tooling system is made by lifting of the exterior sleeve only. The contact piece can be detached and changed. After release of the exterior sleeve the quick-change tooling system engages automatically and locates the contact piece in a defined position. In unloaded mode the contact pieces are self-centring. During pressing-in the forces are compensated by the contact piece and introduced to a spherical surface support, thereby it can align itself parallel to the centre line and compensate the elastic deformation of the components. A gentle press-in operation without lateral forces on the workpieces is realised.

Application

Presses are preferably used in assembly processes for production of longitudinal pressed joints. In addition, the mounting conditions require frequently a C-shaped press-in device for optimised accessibility and high precision at the same time.

Description

The press-in device is a compact function unit and excels by reduced space required and simple installation and start-up. The press consists of 3 basic elements: mechanical press frame, electro-hydraulic control and two-hand operating panel.

The press-in device can optionally be used individually or mounted on a table frame. Due to safety reasons, operation of the hydraulic cylinder is always made by a two-hand operating panel.

Functions

By operating the mushroom push-buttons at the two-hand operating panel at the same time, the hydraulic cylinder extends (starting from the retracted off-position). When the maximum press-in pressure is obtained, reversing to retraction is automatically effected and the hydraulic cylinder retracts rapidly to the retracted off-position. If the two-hand operation will be taken off in an intermediate position, the hydraulic cylinder remains in this position and extends in case of renewed operation. If the cylinder has to retract from an intermediate position, the corresponding push-button in the control box has to be operated first. Function triggering is - in all operating conditions - only possible by operating simultaneously both mushroom push-buttons of the two-hand operating panel.

Application and installation instructions

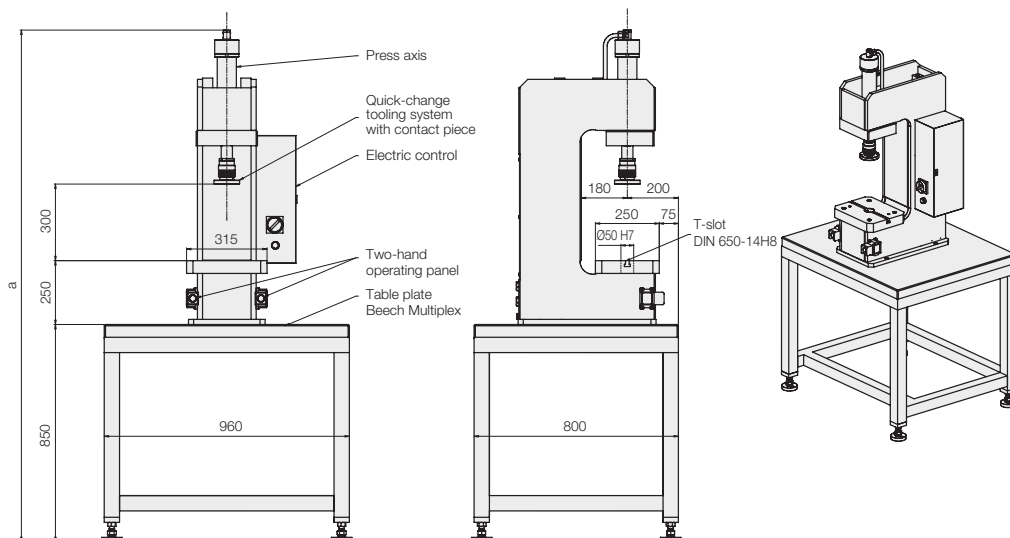
When installing the press-in device pay attention to a flat floor; the press has to be firmly screwed up onto the location table. All 4 feet of the table frame must contact the floor. According to the operating instructions the electric connection has to be effected and the hydraulic power unit must be filled with mineral oil during installation.



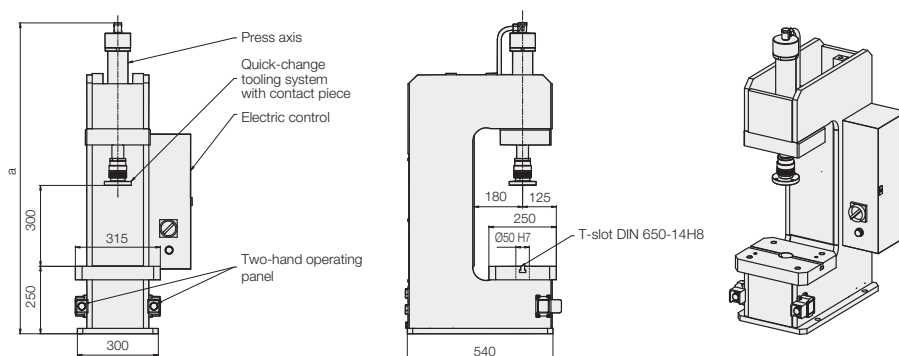


ROEMHELD

Technical characteristics



| Part-no. | Stroke [mm] | Press-in force [kN] | a [mm] | Rating [kW] | v-press-in stroke [mm/s] | v-retract [mm/s] |
|----------|-------------|---------------------|--------|-------------|--------------------------|------------------|
| 6600-171 | 250 | 25 | 1980 | 0,75 | 22 | 36 |
| 6600-172 | 250 | 40 | 1990 | 1,1 | 23 | 37 |
| 6600-173 | 250 | 63 | 2010 | 1,5 | 23 | 37 |



| Part-no. | Stroke [mm] | Press-in force [kN] | a [mm] | Rating [kW] | v-press-in stroke [mm/s] | v-retract [mm/s] |
|----------|-------------|---------------------|--------|-------------|--------------------------|------------------|
| 6600-175 | 250 | 25 | 1130 | 0,75 | 22 | 36 |
| 6600-176 | 250 | 40 | 1140 | 1,1 | 23 | 37 |
| 6600-177 | 250 | 63 | 1160 | 1,5 | 23 | 37 |

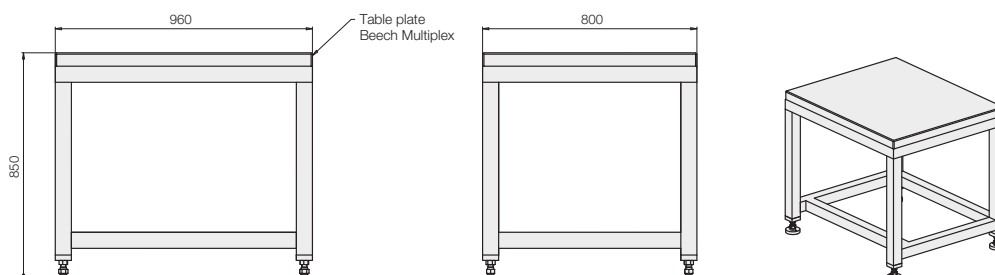


Table / Base press **Part-no. 6600-180**