



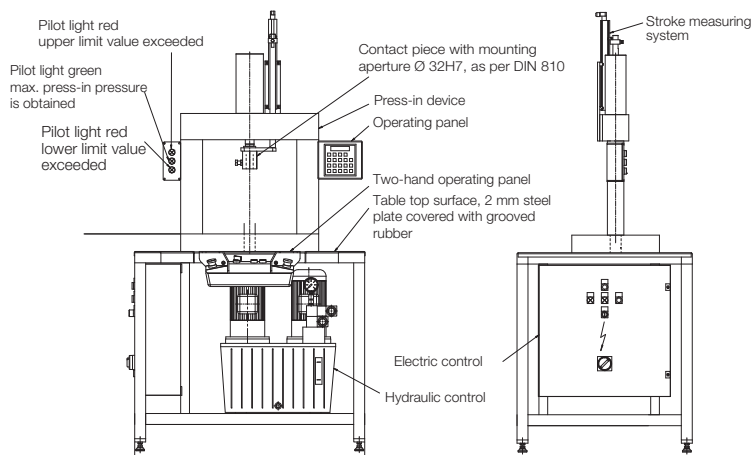
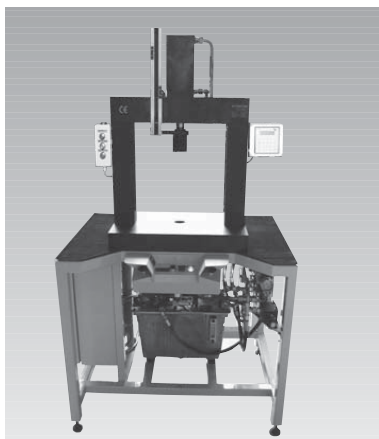
# ROEMHELD

Issue 9-07 E

## P 6.6061

### Press-In Devices 150 kN

with press-in force control and interpretation of the press-in process



#### Application

Press-in devices for assembly with press-in force control and quality assurance of the press-in operation are preferably used in assembly processes for production of longitudinal pressed joints; in addition perfect press fit of frictionally-engaged joinings is guaranteed. Quality assurance and the proof of realisation of longitudinal pressed joints are more and more demanded due to product liability and in accordance with ISO 9000. Due to their geometrical and simple shape it is normally cheaper to produce frictionally-engaged assemblies than positive assemblies.

#### Description

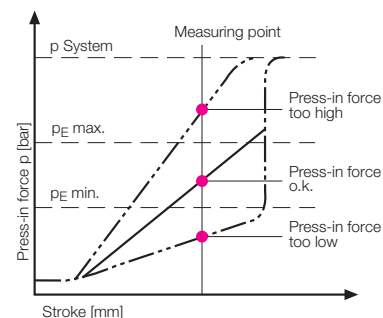
Press-in devices as bench devices with press-in force control and interpretation of the press-in operation are complete functional units and consist of 3 basic components: mechanical press-in frame, electro-hydraulic control and underframe for tables. Above the table plate there are - according to the application of ergonomic design rules - the mechanical press-in frame with the data input board for the process parameters and the indicator board. The two-hand operating panel is mounted to the exterior table frame. The electric control box and the hydraulic power unit are installed in the lower table area. Due to safety reasons, operation of the hydraulic cylinder is always made by a two-hand operating panel.

#### Advantages

- High flexibility in assembly
- Improved ergonomics
- Quality assurance of operation
- Reduction of assembly time
- Short amortisation time
- Closed force-loop
- Defined force ratios
- Light component load
- Quick-change tooling system

#### Industry/applications (selection)

- Drive technology, gears box assembly
- Couplings, cardan shafts
- Compressors, pumps, hydraulic elements
- Industrial fittings
- Materials-handling technology
- Automotive industry and their suppliers
- Machine tool building
- Building and agricultural machines
- Electronics



#### Application example

This installation is adapted to the assembly process of electric motors: with a triple press-in device 3 stator bushings are pressed in into the housings in one cycle.

This corresponds to the assembly sequence of the preceding and following assembly steps in production, so that there will not be any waiting times.

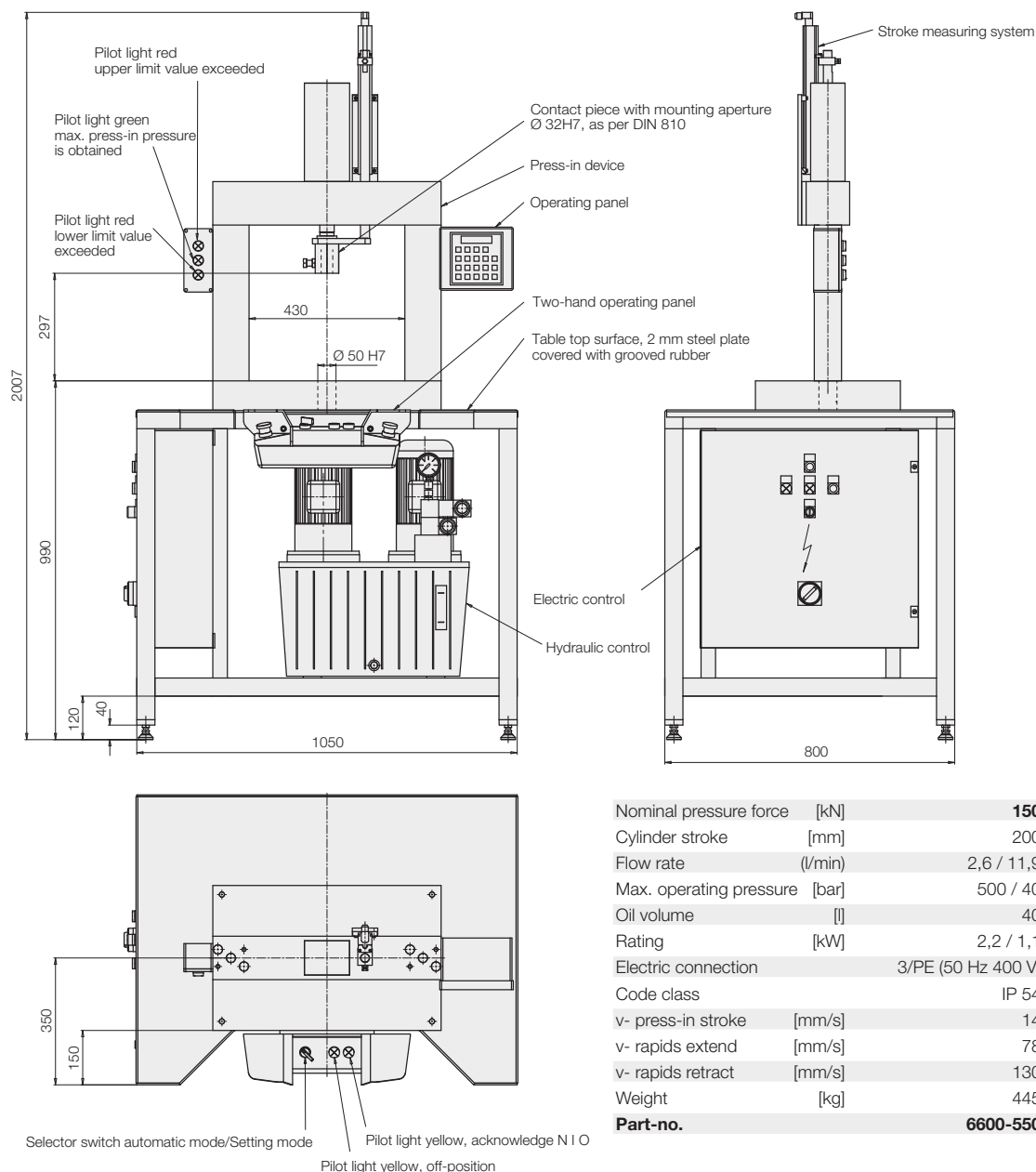
The press-in device realises in each press-in axis a press-in force control, thereby the quality of the operation and a reliable further processing are guaranteed.





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### Press-in device 150 kN



Nominal pressure force	[kN]	<b>150</b>
Cylinder stroke	[mm]	200
Flow rate	[l/min]	2,6 / 11,9
Max. operating pressure	[bar]	500 / 40
Oil volume	[l]	40
Rating	[kW]	2,2 / 1,1
Electric connection		3/PE (50 Hz 400 V)
Code class		IP 54
v- press-in stroke	[mm/s]	14
v- rapids extend	[mm/s]	78
v- rapids retract	[mm/s]	130
Weight	[kg]	445
<b>Part-no.</b>		<b>6600-550</b>

#### Variants (selection)

- Base plate additionally equipped with diagonal slots as per DIN 650
- Table frame out of aluminium
- Press-in frame with additional protection cover

#### Functions

see data sheet M 6.6060, page 2.

Special versions on request