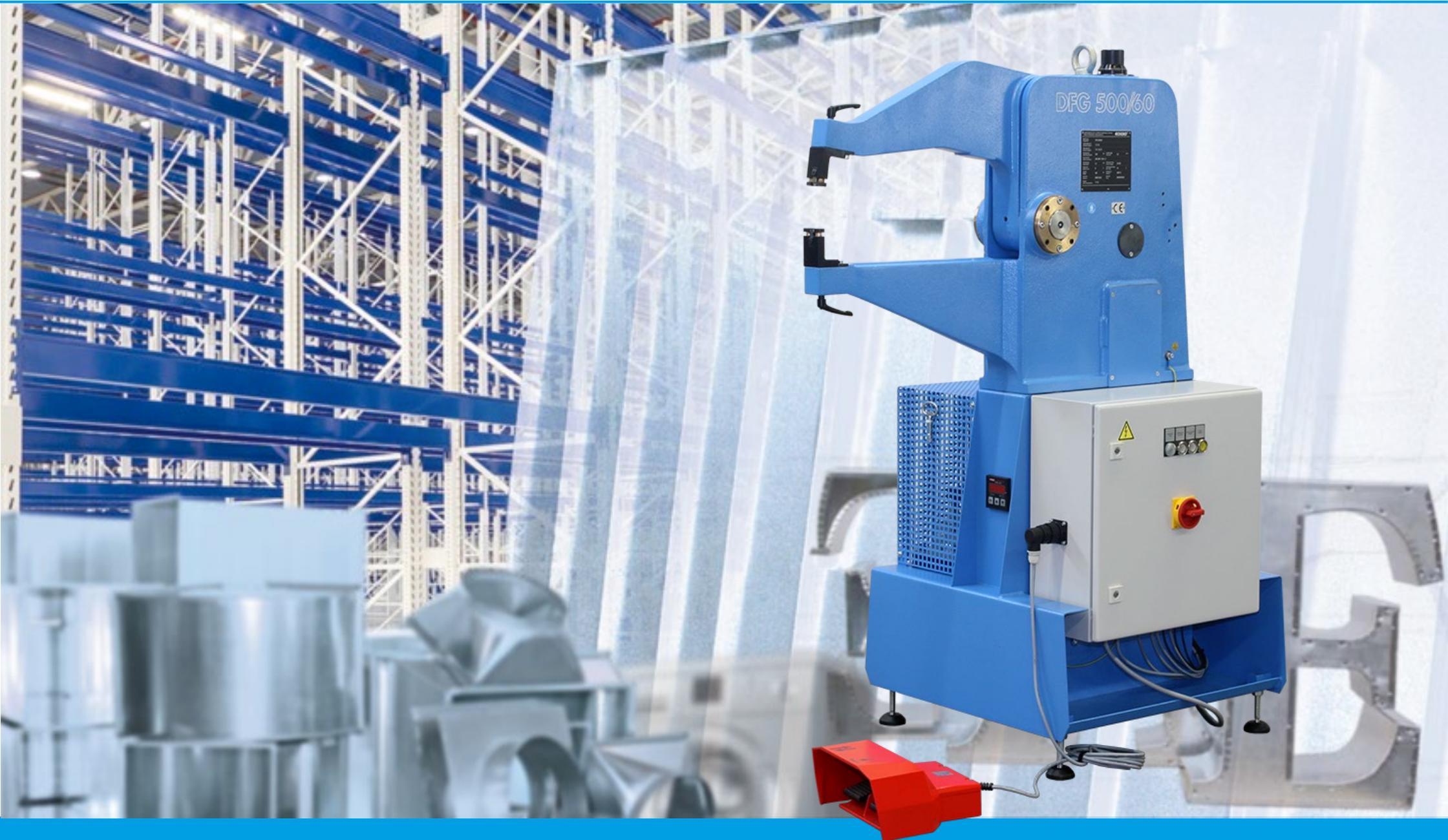


## Stationary clinching unit DFG 500/60



## Stationary clinching unit DFG 500/60

### Characteristics and advantages

- processing of bulky components, resp. components that are hollow body-like
- tool holder adjustable by 4 x 90° degrees
- large horizontal and vertical throat
- high-value joining result due to adjustable path restriction
- suitable for use under permanent load
- low-noise



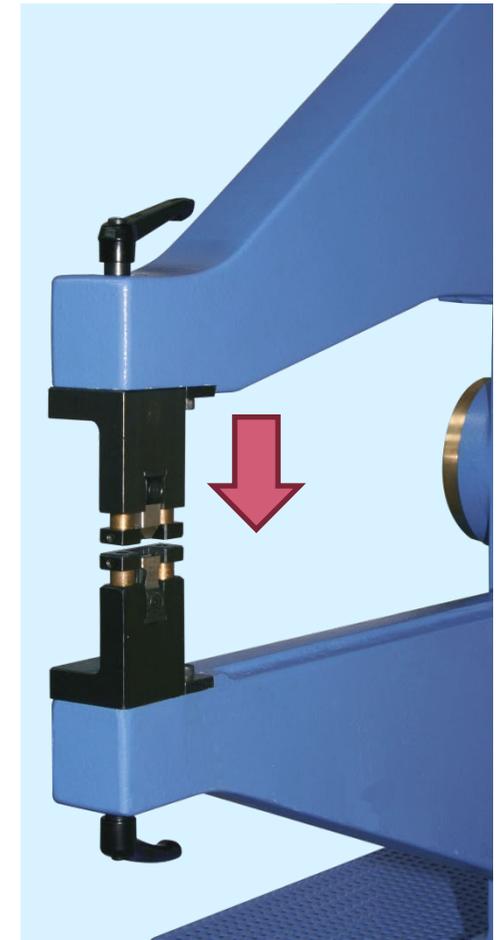
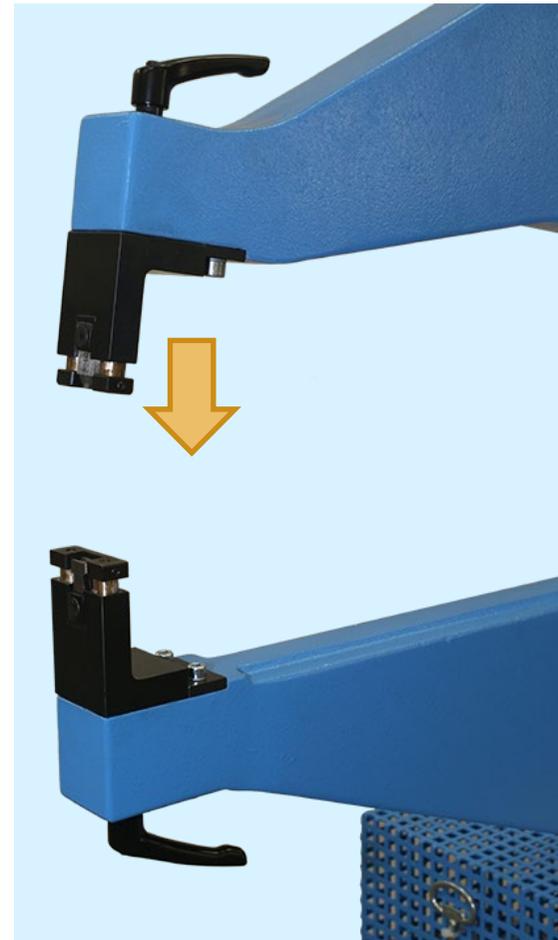
## Stationary clinching unit DFG 500/60

### Stroke process

- closing of the pliers arm by foot switch
- a safety control drives the arm with low pressure into operating position
- followed by the working stroke

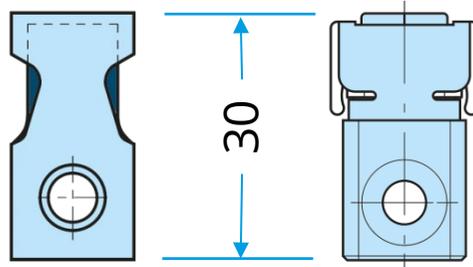
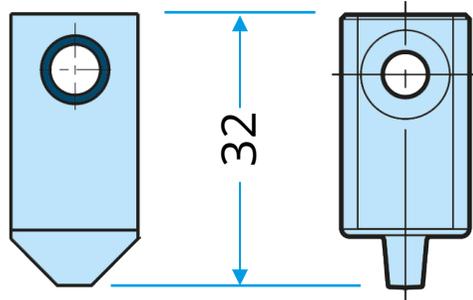


foot switch



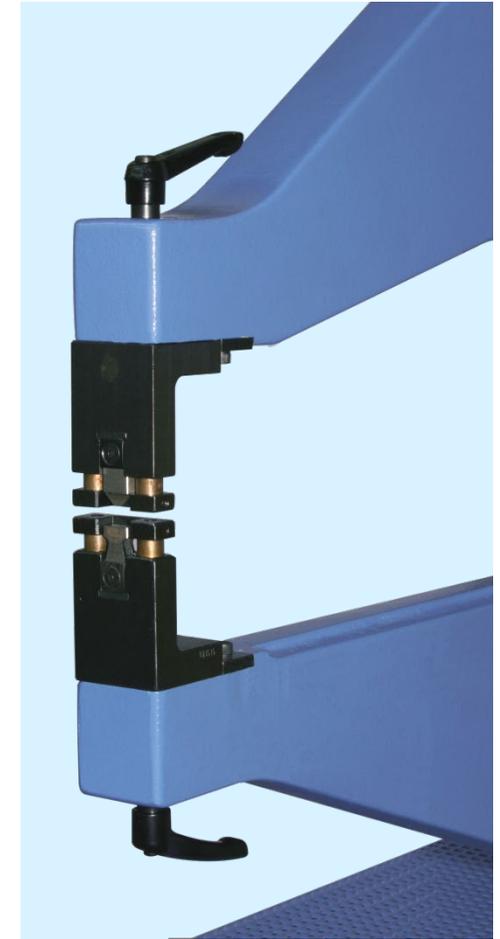
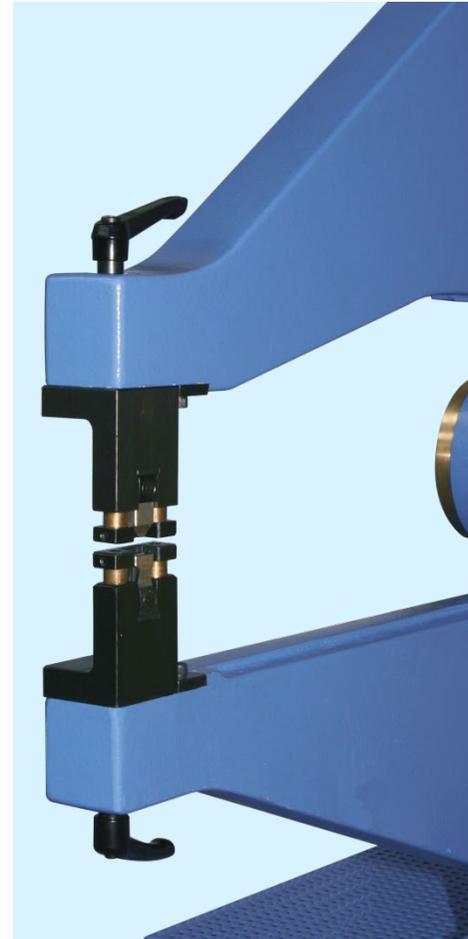
## Interchangeable tool holders

- each moveable by 90°
- for clinching tools with an overall height of 30/32 mm
- other tool holders are available upon enquiry



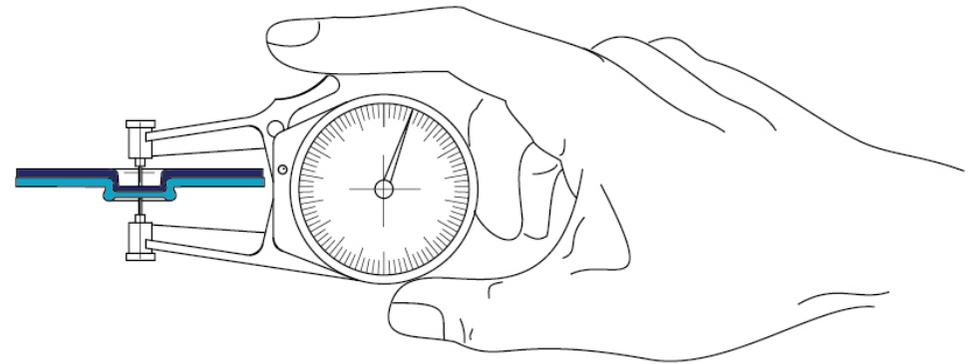
S-DF

R-DF



## Adjustable path limitation

- settable according to the respective joining task
- considerate operational demand of the machine
- reproducible results even under steady load

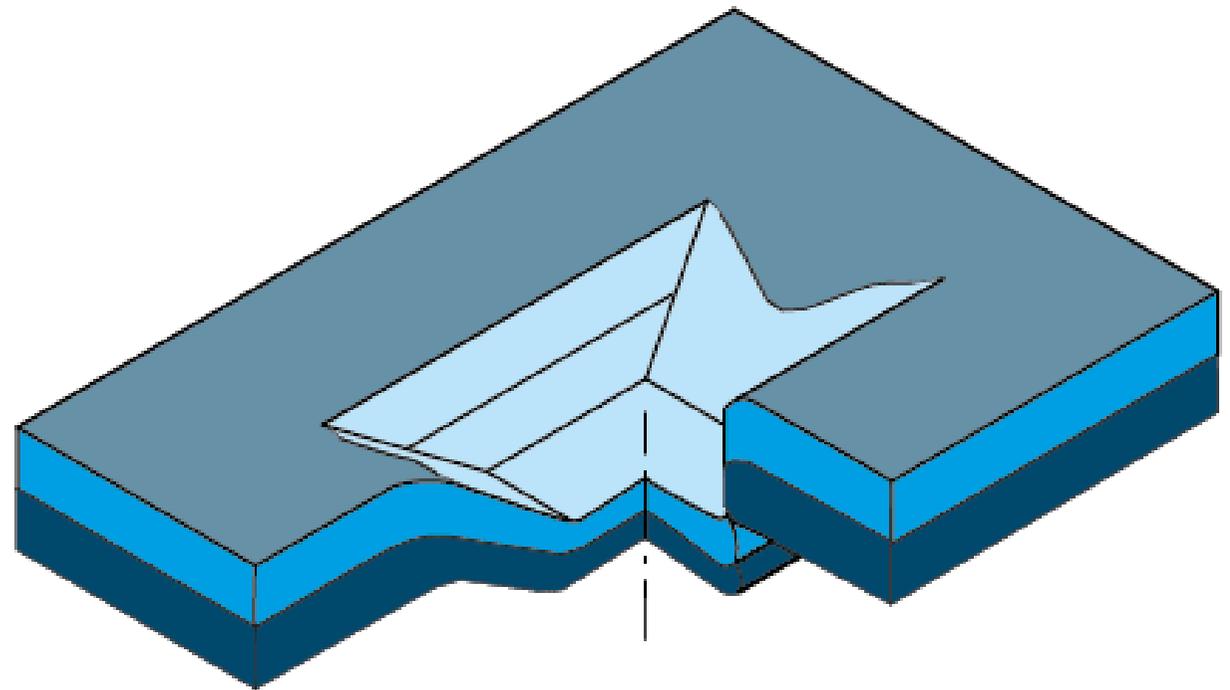


## Characteristics and advantages of the clinching technique

- no pre- or after-treatment
- no heat on the workpiece, no sparks
- no toxic gases or fumes
- suitable for painted or coated sheets, protective layer stays on
- no additional fasteners or other materials required
- suitable for sheets differing in thickness and material quality
- low energy consumption
- low-noise
- simple, and non-destructive quality control

## Clinching type S-DF

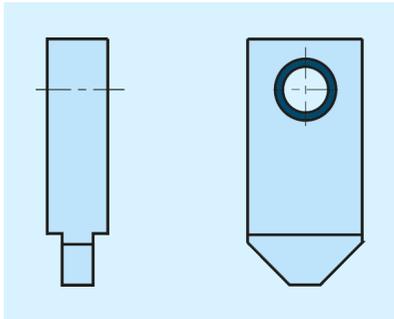
- rotation proof
- suitable for multiple layer connections
- clinching with partial cutting
- single layer thickness min. 0.5 mm
- max. layer thickness 0.5 – 4.0 mm\*
- mild steel (400 N/mm<sup>2</sup>), AL-quality (good forming)



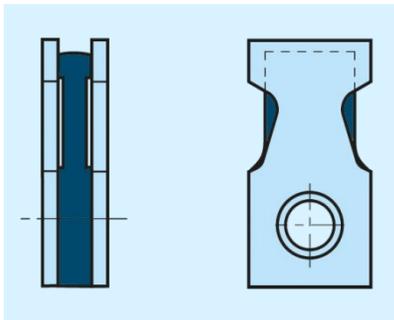
Clinching type S-DF, beam-shaped clinching element

\*Max. total thickness refers to steel or aluminium alloys with good forming properties, a total elongation  $A_{80} \geq 12\%$  and a yield ratio  $R_{p0,2} / R_m \leq 0,7$ ; e. g. steel: DC04 · DX56 · CR180BH or aluminium: AlMg3 · AlMg4,5Mn0,4 · AlMg0,4Si1,2(T4). Deviations from these sheet thickness combinations might be possible. For details, contact ECKOLD.

## Punches and dies: S-DF

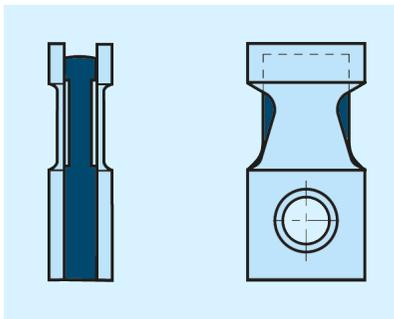


Punch SD 711.00



Die SMD 721.XX

- suitable for many applications

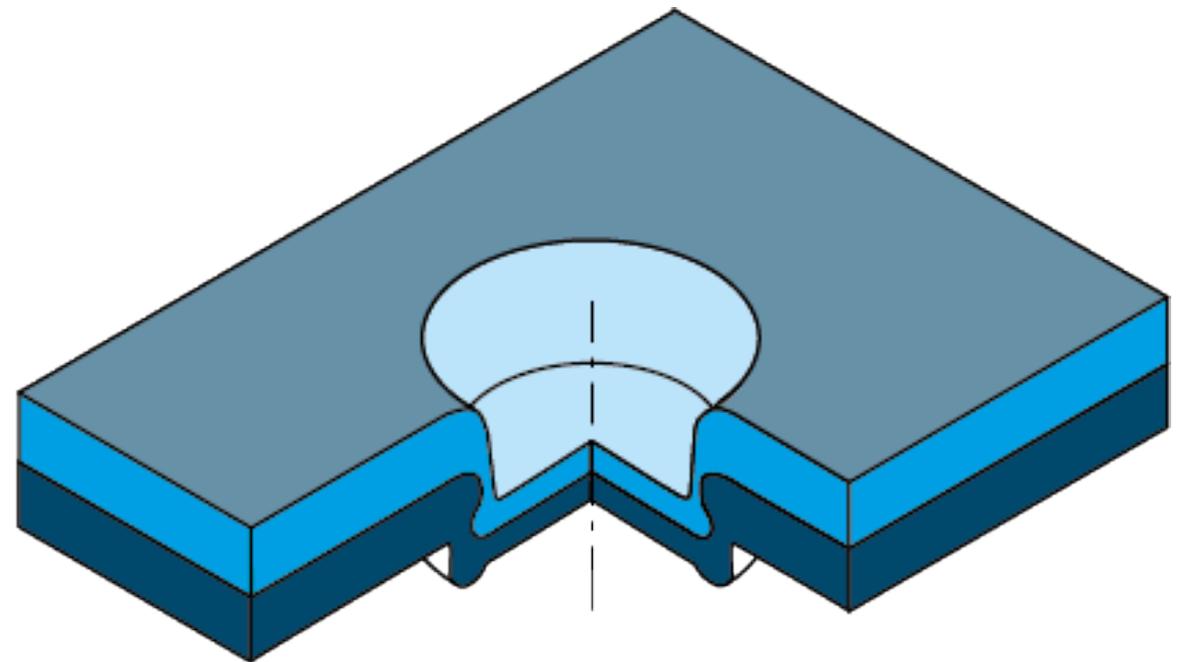


Die SMD 731.XX

- for the clinching of soft materials such as aluminium or copper
- other types of dies on request

## Clinching type R-DF

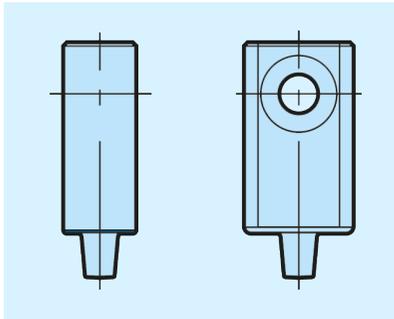
- airtight connections
- same shear load in all directions
- clinching with partial cutting
- single layer thickness min. 0.5 mm
- max. layer thickness 0.5 – 4.0 mm\*
- mild steel (400 N/mm<sup>2</sup>), AL-quality (good forming)



Clinching type R-DF, round clinching element

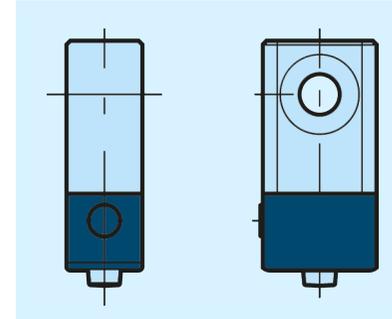
\*Max. total thickness refers to steel or aluminium alloys with good forming properties, a total elongation  $A_{80} \geq 12\%$  and a yield ratio  $R_{p0,2} / R_m \leq 0,7$ ; e. g. steel: DC04 · DX56 · CR180BH or aluminium: AlMg3 · AlMg4,5Mn0,4 · AlMg0,4Si1,2(T4). Deviations from these sheet thickness combinations might be possible. For details, contact ECKOLD.

## Punches and dies: R-DF



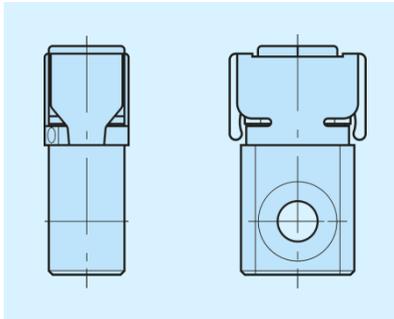
Punch 900.XX79YY

- for mild steel



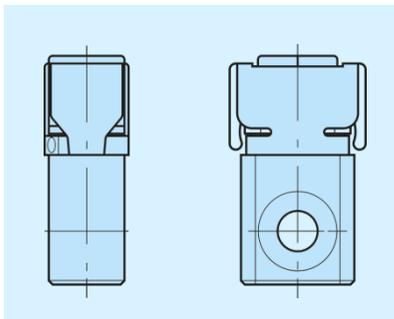
Punch 900.XX47YY

- for aluminium



Die 951.XX (R-DF 6)

- $a_{ges} = \max. 3.0 \text{ mm}$



Die 950.XX (R-DF 8)

- $a_{ges} = \max. 3.0 \text{ mm}$
- other types of dies on request

## Technical data

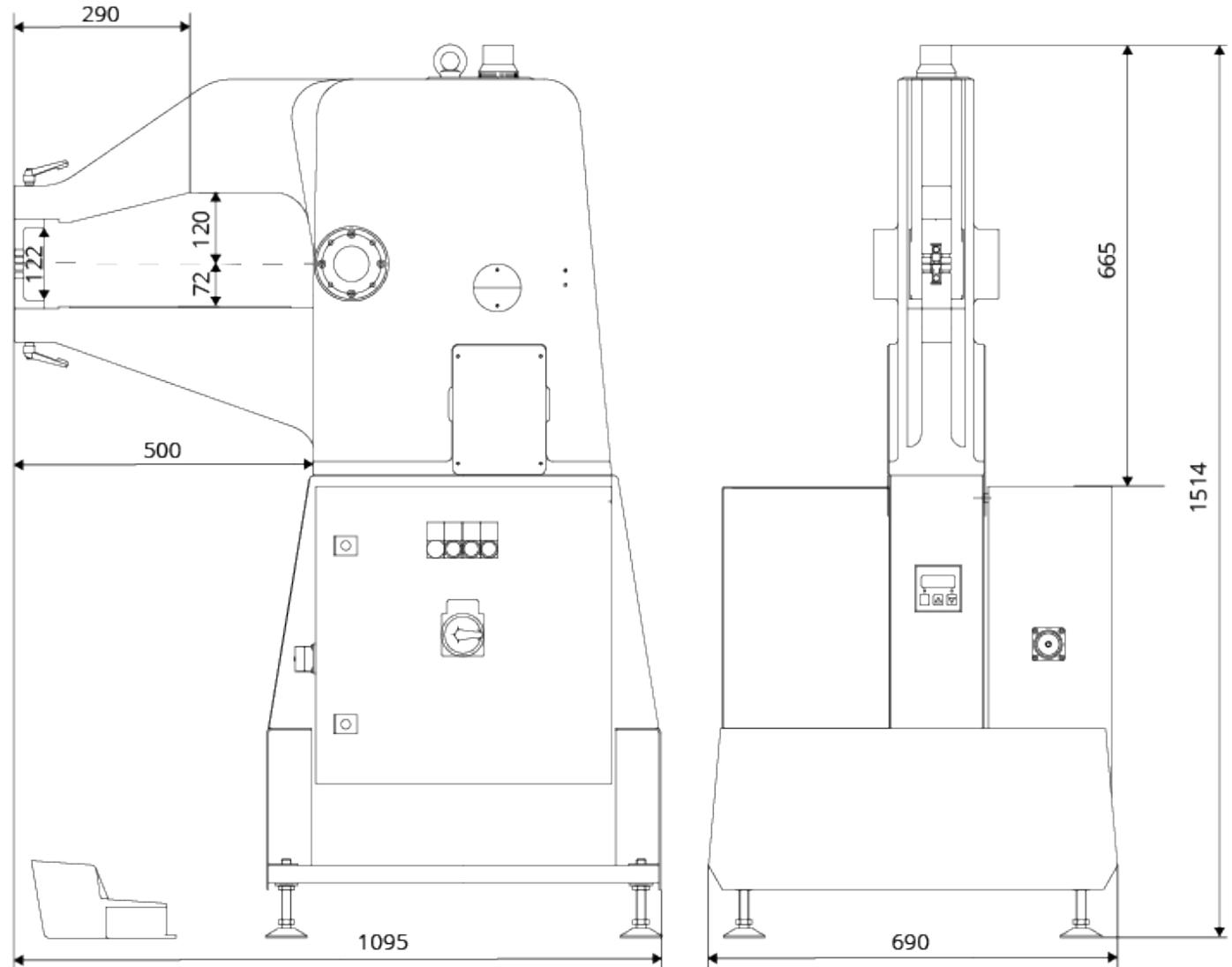
Parameters	DFG 500/60
Pressure force	adjustable max. 60 kN at 500 bar
Drive via integrated hydraulic drive unit	380 – 420 V / 3 Ph / 50 Hz
Stroke release	double foot switch with safety appliance
Adjustable path limitation	continuously adjustable
Provided for	S-DF · R-DF
Throat horizontal	500 mm
Throat vertical	max. 192 mm
Gap	85 mm
Weight	approx. 400 kg

### Drive



hydraulic

## Technical data



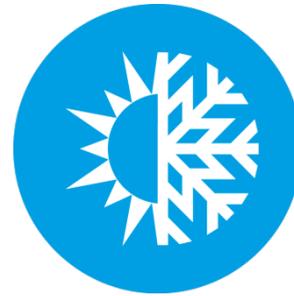
## Target sectors



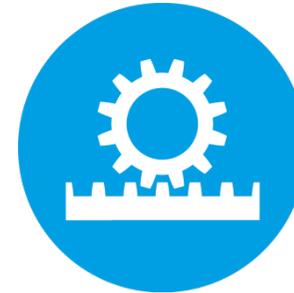
Automotive industries



White goods industries



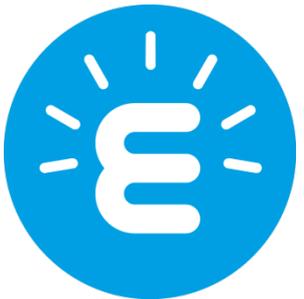
Ventilation and ducting industries



General fabricators



Shelf and storage solutions



Sign manufacturers



Schools and training centers



6 Allée des Carrières  
Z.A.E Des Portes de la Forêt  
F-77090 COLLEGIEN

DISTRIBUTEUR EXCLUSIF EN FRANCE, ALGERIE, MAROC ET TUNISIE POUR :



Tél. : +33 (0) 1 64 30 92 47  
Fax : +33 (0) 1 64 30 81 92  
Email : [info@eckotech.fr](mailto:info@eckotech.fr)  
Site internet : [www.eckotech.fr](http://www.eckotech.fr)

SARL au capital de 100 000 €  
SIRET : 350 241 378 00016  
Code APE : 4662Z - N° EORI : FR35024137800016  
N° d'identification européenne : FR 67 350 241 378