

# Universal Hydraulic Presses for Production & Prototype Applications

For Use With **Tog-L-Loc**<sup>®</sup> Sheet Metal Joining System



**BTM**<sup>®</sup>  
CORPORATION

[www.btmcorp.com](http://www.btmcorp.com)

## Fixed Frame



## Inclinable Frame



## Items Joined with Tog-L-Loc®



## Benefits of Tog-L-Loc®

- Joins plain, coated, and dissimilar metals.
- No rivets, screws or other fasteners are required.
- Eliminates spot welding operations.
- Long tool life; 250,000 joints common.
- Joins in a single press stroke.
- Non destructive checking with a simple gage.
- Strong and highly fatigue resistant.
- Leakproof joints.
- No sparks, fumes, or residue.

## Tog-L-Loc® - HOW IT WORKS



CLAMPS

DRAWS

LOCKS

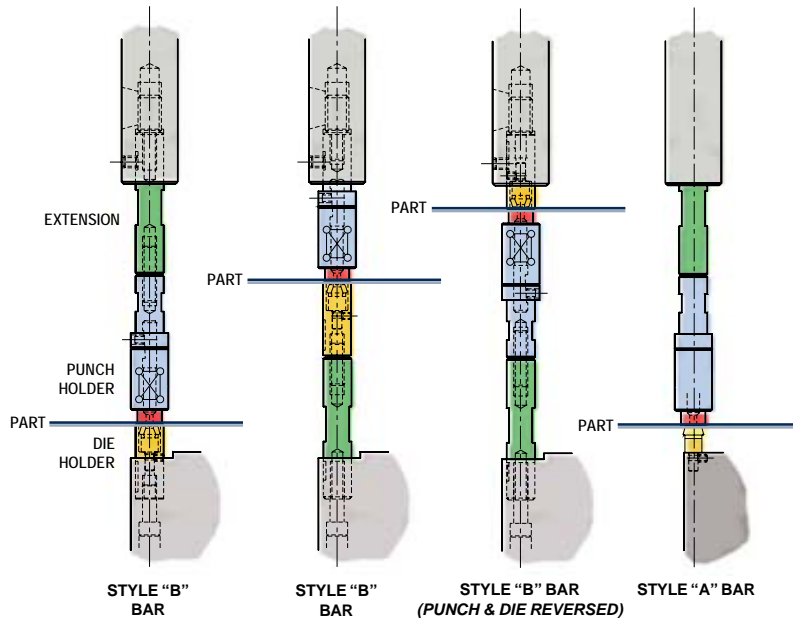
The stripper clamps the metal to the face of the die, locking it in place. The punch draws the metals into the die and squeezes the bottom of the drawn section. The moving die blades allow an outward flow of metal, expanding the diameter to form a strong circular lock.

# Universal Hydraulic Presses Model H10U



## Tooling Examples

Standard tools may be arranged to suit part configuration. Interchangeable and reversible tool holders and optional tooling bar styles provide optimum flexibility for part clearances and flush surface requirements.



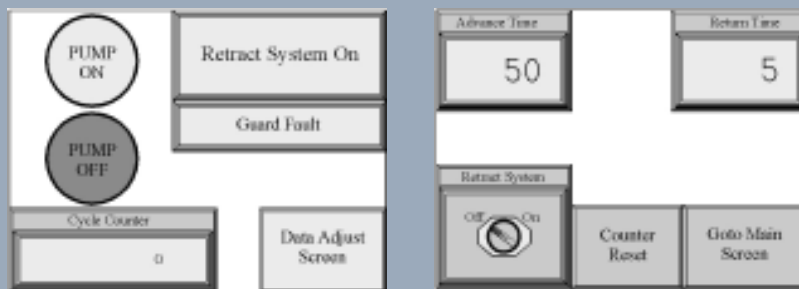
## Foot Pedal Operation

The H10U utilizes a dual foot pedal which gives the operator excellent control over the function of the machine. The LEFT pedal advances the ram. The RIGHT pedal is used to return the ram completely home. The length of the return stroke can be adjusted to provide a short "peck" stroke.



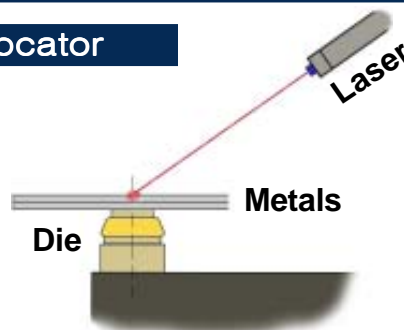
## Hydraulic Power Unit Controls

The operation of the hydraulic power supply is controlled through a touch screen display pad located on the front of the unit. From this pad, the operator can turn the hydraulic pump off and on, and set the ram advance/return time, as well as the ram dwell time.



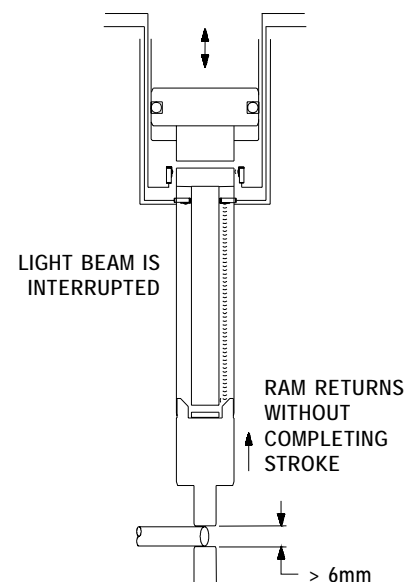
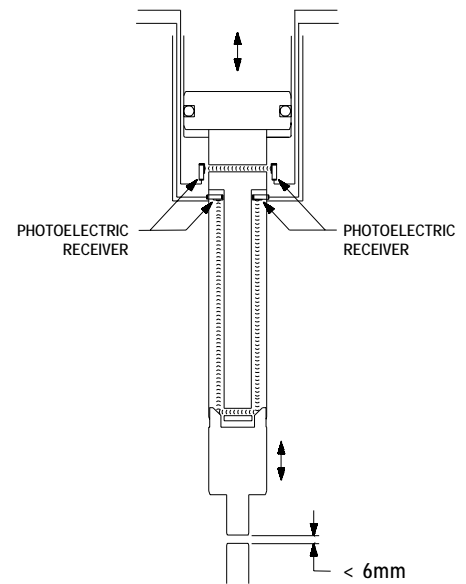
## Optional Laser Joint Locator

The optional laser joint locator simplifies accurate joint placement by indicating the center of the die on the top surface of the part.



## SAFETY

The BTM H10U Tog-L-Loc Machine is equipped with an innovative ram guarding system which eliminates cumbersome ring guards and other external devices. It utilizes two beams of infrared light modulated at approximately 10kHz to prevent "contamination" by ambient light sources. If the advancing ram contacts an object before reaching 6mm from the end of its stroke, the floating tool holder will interrupt the light beam and the ram will automatically return to the up position.



### Specifications

Hydraulic Pressure	Max 2500psi / 172bar
Force Output	1.5 to 10 Tons / 7 to 92 KN
Max. Stroke	6" / 150 mm
Min. Stroke "peck cycle"	.63" / 16 mm
Throat Depth - Fixed Frame	19.7" / 500 mm Max.
Throat Depth - Inclinable	18.0" / 457.2 mm Max.
Min. Metal Thickness (CRS)	.016" / 0,4 mm Total
Max. Metal Thickness (CRS)	.134" / 3,4 mm Total
Power Requirement	230 or 460 VAC
Plug Requirement	Twist Lock (Cat No. 2743) 3-Pole 4 Wire Grounding 30 AMP 3 PH 600 AC

### Unit Dimensions

### Inclinable Dimensions

