Universal Hydraulic Presses for Production & Prototype Applications

For Use With Tog-L-Loc® Sheet Metal Joining System

BTM CORPORATION
www.btmcorp.com
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.

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.
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.

**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.
BTM Universal Hydraulic Presses
Model H10U

**Specifications**

<table>
<thead>
<tr>
<th>Feature</th>
<th>Specification</th>
</tr>
</thead>
<tbody>
<tr>
<td>Hydraulic Pressure</td>
<td>Max 2500psi / 172bar</td>
</tr>
<tr>
<td>Force Output</td>
<td>1.5 to 10 Tons / 7 to 92 KN</td>
</tr>
<tr>
<td>Max. Stroke</td>
<td>6&quot; / 150 mm</td>
</tr>
<tr>
<td>Min. Stroke “peck cycle”</td>
<td>.63&quot; / 16 mm</td>
</tr>
<tr>
<td>Throat Depth - Fixed Frame</td>
<td>19.7&quot; / 500 mm Max.</td>
</tr>
<tr>
<td>Throat Depth - Inclinable</td>
<td>18.0&quot; / 457.2 mm Max.</td>
</tr>
<tr>
<td>Min. Metal Thickness (CRS)</td>
<td>.016&quot; / 0.4 mm Total</td>
</tr>
<tr>
<td>Max. Metal Thickness (CRS)</td>
<td>.134&quot; / 3.4 mm Total</td>
</tr>
<tr>
<td>Power Requirement</td>
<td>230 or 460 VAC</td>
</tr>
<tr>
<td>Plug Requirement</td>
<td>Twist Lock (Cat No. 2743)</td>
</tr>
<tr>
<td></td>
<td>3-Pole 4 Wire Grounding</td>
</tr>
<tr>
<td></td>
<td>30 AMP 3 PH 600 AC</td>
</tr>
</tbody>
</table>

**Unit Dimensions**

- **[100]** 3.9
- **[201]** 79.3
- **[500]** 19.7
- **[467]** 18.4
- **[1142]** 45.0
- **[1189]** 66.5
- **[1689]** 66.5
- **[902]** 36.5
- **[457]** 18.0
- **[1118]** 44.0
- **[1270]** 50.0
- **[819.2]** 32.25
- **[648]** 25.5
- **[830]** 32.3
- **[1045]** 41.1
- **[1045]** 41.1
- **[1397]** 55.0

**Inclined Dimensions**

- **[1397]** 55.0
- **[1689]** 66.5
- **[902]** 36.5
- **[457]** 18.0
- **[1118]** 44.0
- **[1270]** 50.0
- **[819.2]** 32.25
- **[648]** 25.5
- **[830]** 32.3
- **[1045]** 41.1
- **[1045]** 41.1
- **[1397]** 55.0

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