

PUNCHING WITHOUT PRE-DRILLING

# APress 600

Overhang 600 mm



# ALFRA PRESS AP 600 - STATIONARY PUNCHING MACHINE

The stationary punching machine has been developed for control cabinet and switch gear makers and is suitable for quick punching-out of circular, square, rectangular or special forms in sheet metal and control cabinet doors up to 2200 mm x 1000 mm and 30 mm margin fold height. Punching possible right up to margins.

**Simple, rapid tool change carried out in seconds – even on fitted door.**

Limit stop system can be moved in X and Y directions.

## Description:

- Stable press body in heavy-duty, torsionally-stiff welded construction
- Dual-action hydraulic cylinder, flanged force-locking and form-locking to machine body
- Anti-twist piston rod  $\varnothing$  55 mm made of tempered stainless steel with tool holder
- Die bed, fixed force-locking to press body
- Rapid tool change helps in problem areas with a wide range of break-through types
- Hold-down device with safety function, fixed with electrical safety lock for accident prevention
- Length and depth limit stops movable in X and Y directions, bearings in hardened double ball bearing slides for smooth mobility
- Tape measure display for length and depth adjustment
- Digital measuring indicator for X and Y axes
- Dual-circuit hydraulic unit with electric pump, oil container and solenoid valves (very low noise)
- Safety footswitch with double pedal for infinitely variable operation of punching and return stroke

## Technical data:

Overhang with limit stop:	600 mm
Punching stroke:	66 mm
Punching force F:	60 kN at 165 bar
Motor power:	0.75 kW
Operating voltage:	400 V
Weight approx.:	360 kg
Overall height:	1,600 mm
Working height:	1,000 mm
Width of puncher body:	310 mm
Depth of puncher body:	1,150 mm
Length of limit stock rails:	1,500 mm
Space requirement approx.:	2,000 x 3,000 mm

## Punching capacity:

Circular from:	$\varnothing$ 3.2 - 70.0 mm
Square up to:	68.0 x 68.0 mm
Special forms up to a max. diagonal of:	90.0 mm

## Material thicknesses (max):

Sheet steel (S235):	3.0 mm
Stainless steel ( $F = 600 \text{ N/mm}^2$ ):	2.0 mm
Aluminium ( $F = 22 \text{ N/mm}^2$ ):	4.0 mm
Punchable plastics up to:	4.0 mm

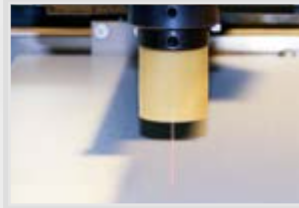
ALFRA PRESS AP 600

Prod.-No.  
03090

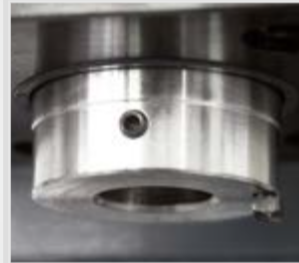
## Note:

- All circular tools for ALFRA PRESS punching machines AP 250 - AP 800 are made of special tool steel and have a special cutting geometry developed by ALFRA

**Special tools can be manufactured in our own toolmaking works at short notice!**



Laser pointer for optical display of tool centre



Stable piston rod ( $\varnothing$  55 mm) with tool anti-twist device



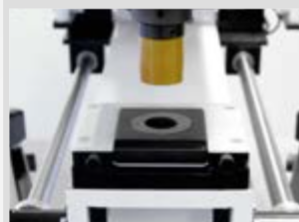
Tool drawer with compartments



Dual-circuit hydraulic unit in cabinet base



Reciprocal quick-clamping system for edge folds either top or bottom



Die bed holder. Tool changes can also be carried out when control cabinet door is fitted



Length and depth limit stops guided in double ball bearing slides on both sides. 2 adjustable limit stops right and left on the Y-axis

# PUNCHING WITHOUT PRE-DRILLING



**Overhang 600 mm**

## Stationary hole puncher – AP 600

Type	Designation	Prod.-No.
Machine	Stationary punching machine ALFRA PRESS 600 with hydraulic cylinder, cabinet base, length and depth limit stops movable in X and Y directions, cylinder pistons with anti-twist device for use with all punch sockets, dual-action hydraulic unit, safety footswitch, Laser pointer for optical display of tool centre, Digital measuring indicator Y-axis, Digital measuring indicator X-axis, Pivoting double joint arm for supporting workpiece	03090
Punch socket	with scraper and centring pin for round puncher with mounting shaft for AP 500 - 600 Ø 3.2 - 30.5 mm	03036
	with centring pin for round puncher with 19 mm female thread for AP 500 - 600 Ø 32.5 - 63.5 mm	03035
Die holder	Type A Circular die Type A Ø 3.2 - 25.4 mm	03040
	Type B Circular die Type A Ø 28.3 - 40.5 mm	03041
	Type C Circular die Type A Ø 40.6 - 63.5 mm	03077

## Square and rectangular hole punches – AP 600

suitable for steel, for stainless steel applications on request, with mounting shaft and centring point, including die

Type	Designation	Prod.-No.	AP 250	AP 400	AP 500	AP 600
Square holes	12.7 x 12.7 mm for AP 500 - 600	03042			●	●
	19.0 x 19.0 mm for AP 500 - 600	03044			●	●
	22.2 x 22.2 mm for AP 500 - 600	03045			●	●
	25.4 x 25.4 mm for AP 500 - 600	03046			●	●
	46.0 x 46.0 mm for AP 500 - 600	03047			●	●
	68.0 x 68.0 mm for AP 600	03050				●
Rectangular holes	22.0 x 30.0 mm for AP 500 - 600	03048			●	●
	22.0 x 42.0 mm for AP 500 - 600	03049			●	●
Special holes	Ø 22.5 mm 1 lug 3.2 mm for AP 500 - 600	03051			●	●
	Ø 22.5 mm with 2 lugs 3.2 mm for AP 500 - 600	03052			●	●
	Ø 22.5 mm, flattened on 4 sides to 20.1 mm for AP 500 - 600	03055			●	●

# ALFRA PRESS AP 600 - STATIONARY PUNCHING MACHINE

## Circular punches and dies – AP 600

suitable for steel and stainless steel

Type	Mounting holder	Ø in mm	Size Metric	Size PG	Prod.-No.	AP 250	AP 400	AP 500	AP600	AP 800
Punch Ø 3.2 - 30.5 mm		3.2			03131	●	●	●	●	●
		4.5			03132	●	●	●	●	●
		5.4			03133	●	●	●	●	●
		6.5			03134	●	●	●	●	●
		8.5	M8		03135	●	●	●	●	●
		10.5	M10		03136	●	●	●	●	●
		12.7	M12	PG7	03137	●	●	●	●	●
		15.2		PG9	03138	●	●	●	●	●
		16.2	M16		03139	●	●	●	●	●
		18.6		PG11	03140	●	●	●	●	●
		20.4	M20	PG13	03141	●	●	●	●	●
		22.5		PG16	03142	●	●	●	●	●
		25.4	M25		03143	●	●	●	●	●
		28.3		PG21	03144	●	●	●	●	●
Punch Ø 32.5-63.5 mm		30.5			03145	●	●	●	●	●
		32.5	M32		03146	●	●	●	●	●
		37.0		PG29	03158	●	●	●	●	●
		40.5	M40		03147	●	●	●	●	●
		47.0		PG36	03159			●	●	●
		50.5	M50		03148			●	●	●
		54.0		PG42	03160			●	●	●
Die Ø 3.2 - 25.4 mm	TYPE A	60.0		PG48	03161			●	●	●
		63.5	M63		03149			●	●	●
		3.2			03063	●	●	●	●	●
		4.5			03066	●	●	●	●	●
		5.4			03068	●	●	●	●	●
		6.5			03074	●	●	●	●	●
		8.5	M8		03076	●	●	●	●	●
		10.5	M10		03079	●	●	●	●	●
		12.7	M12	PG7	03022	●	●	●	●	●
		15.2		PG9	03023	●	●	●	●	●
		16.2	M16		03084	●	●	●	●	●
Die Ø 28.3 - 40.5 mm	TYPE B	18.6		PG11	03024	●	●	●	●	●
		20.4	M20	PG13	03025	●	●	●	●	●
		22.5		PG16	03026	●	●	●	●	●
		25.4	M25		03085	●	●	●	●	●
		28.3		PG21	03027			●	●	●
		30.5			03028			●	●	●
Die Ø 47.0 - 63.5 mm	TYPE C	32.5	M32		03163			●	●	●
		37.0		PG29	03029			●	●	●
		40.5	M40		03164			●	●	●
		47.0		PG36	03030			●	●	●
		50.5	M50		03168			●	●	●
54.0			03031			●	●	●		
60.0		PG48	03032			●	●	●		
63.5	M63		03169			●	●	●		