

## 824 OT-4e Machine Specifications and Dimensions:

Force Range	Adjustable 225 lbs. (1kN) to 16,000 lbs. (72kN) - Optional 20,000 lbs. (90kN) modification available
Throat Depth	24" (610mm)
Stroke Length	Adjustable 0 to 8.5" (0 to 220mm)
Electrical	208 to 575V 3 phase - 50 or 60 Hz
Motor	5 HP
Oil Tank Reservoir	22 gallons (83 liters)
Speed	up to 2000 insertions per hour
Repeatability	+/- 2% of force setting
Footprint	(LxWxh) 59" x 38" x 94" (1499mm x 966mm x 2388mm)
Fastener Range	.256 to 1/2" (M2 to M12)
Clinching Capability	22 gage to 11 gage Steel (1mm to 6mm) combined thickness

For more information on the 824 OT-4e and other Haeger products, visit our website at [www.haeger.com](http://www.haeger.com) or contact your authorized Haeger distributor.

Always the most cost effective solution  
for your fastener insertion challenge!



Combine Maximum Productivity  
and Process Control with Ease of  
Setup... Haeger's all new:

# 824

OneTouch 4e

Fastener  
Insertion  
System



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**Haeger**  
Creating Hardware Insertion Profit Centers

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## A. 4 Station Automatic Lower Tool Changer

An integrated cartridge with 4 tooling stations automatically retracts, indexes and positions up to 4 different tools in the lower tool holder. Maximum accessibility around the lower tool allows for parts with tall flanges to fit on the machine.

## B. 4 Station Automatic Upper Tool Changer

4 Insertion Stations and 4 Tool positions (total of 8 pre-programmed positions) provide the ability to automatically feed up to 4 different sizes and types of fasteners in one handling. Productivity of 1 insertion every 2.5 seconds, while tools are changed within 3 seconds. Fastener Detection and Fastener Length detection provides FULL process control in every station.

## C. Fast & Easy Tooling Setup on 4 MAS 350 - Modular Autofeed Systems

A unique new drive system in combination with a complete new bowl design incorporating all the latest bowl feeding technologies.

A long list of advantages, but what does this mean for you?

- Tool Change from 3 minutes to 3 seconds per MAS 350 through a one piece tool module.
- No more manual bowl setting required. Software automatically sets the proper vibration rate, air eject time and required air pressure to allow for failure free fastener feed. 'From a full bowl down to the last one out!' Reliable Feeding. Faster Changeover. No Training Required.



- Larger bowl design in combination with new drive allows for fastener sizes M1.5 through M10 all to be fed in the same bowl
- Deeper bowl design in combination with new bowl tooling design allows for fastener lengths up to 40mm all to be fed in the same bowl
- New drive design allows for a 1 single tool piece, resulting in faster and easier tool change
- Change in bowl material resulting in fasteners becoming less dirty from 'air-dust' or individual rubbing
- Lower mounting position allowing for easier filling and emptying.

## D. Integrated Tooling Storage

Easy and transparent storage of Multi-Modules for the MAS-350 Auto Feed System in combination with separate storage for the Shuttle Modules and upper and lower tools. Both storage positions located where you need the tooling, eliminating unnecessary searching and walking around allowing faster and easier tooling changeovers.

## E. Easier and Faster Programming

E1: The ALL NEW intuitive Version 10 Insertion Logic™ Software with Insertion Graphics® and integrated Statistic Process Control allows for more functionality while reducing programming time.

E2: V 10 Insertion Logic® provides you with the recommended operating time for the part programmed and stores any corrected errors during the insertion process, allowing you to provide this data with your deliveries to your customers.

## F. Energy Saving

New Variable Speed Hydraulics reduces energy consumption up to 30% compared to conventional hydraulic systems.

## G. Best Operator Ergonomics

Operator control pendant can be adjusted in 6 directions, allowing for easy access and the best view of screen instructions while standing up or sitting down.



D: INTEGRATED TOOLING STORAGE



G: OPERATOR CONTROL PENDANT CAN BE ADJUSTED IN 6 DIRECTIONS.