



20 kHz Model 220 PRESS/THRUSTER



FEATURES

- **Narrow 4.5" (114mm) profile** for close center-to-center distances in multihead and automation installations
- **Rugged construction** using the highest quality components provides superior performance, precision, and reliability
- **Compact, single-rail linear ball slide assembly system** offers accurate positioning, stable movement, and friction-free resistance
- **Dual pressure** increases clamp force to improve melt during the weld cycle, or to provide tighter assembly during the hold cycle
- **Optional hydraulic slow speed** available for precise, repeatable control of horn travel during the weld cycle
- **7" (178mm) stroke** with mechanical bottom stop adjustable in .001" (.025mm) increments
- **Top-of-stroke limit switch** for automation application
- **All controls are accessible from the front** for convenient set-up and operation
- **Easy to use front panel position indicators** with universal icons instantly show settings of position and bottom stop, and optional slow speed, pre-trigger, and end-of-weld switches
- **Chrome-plated column and titanium booster** are standard
- **High-performance Magnum™ transducer** is standard
- **Internally mounted optional linear encoder** saves space in multihead and automated installations
- **Remote pneumatics availability** offers increased flexibility in system integration
- **OSHA-required lockout for air supply** is standard
- **Ergonomic base and cycle activation switches** reduce operator fatigue
- **Status indicators in base** for Power, In Cycle, and Abort clearly communicate system conditions
- **Twist-release emergency stop switch** meets international safety standards
- **Press/thruster design provides system flexibility and upgradeability**, reducing equipment investment
- **Compatible with all current Dukane assembly system components**
- **Press/thruster can be used with 20 kHz Dynamic Process Controllers™ in 500, 1200, 1700, 2200, and 3300 watt power levels**

SPECIFICATIONS

Options

HYDRAULIC SPEED CONTROL precision hydraulic control of the melt velocity. Critical to achieve maximum weld strength in staking, inserting and shear joint applications.

LINEAR OPTICAL ENCODER Ability to weld by collapse and absolute distance through out 7 inches of stroke with .0005 of an inch resolution. (requires DPC III or IV *Plus* w/ distance module)

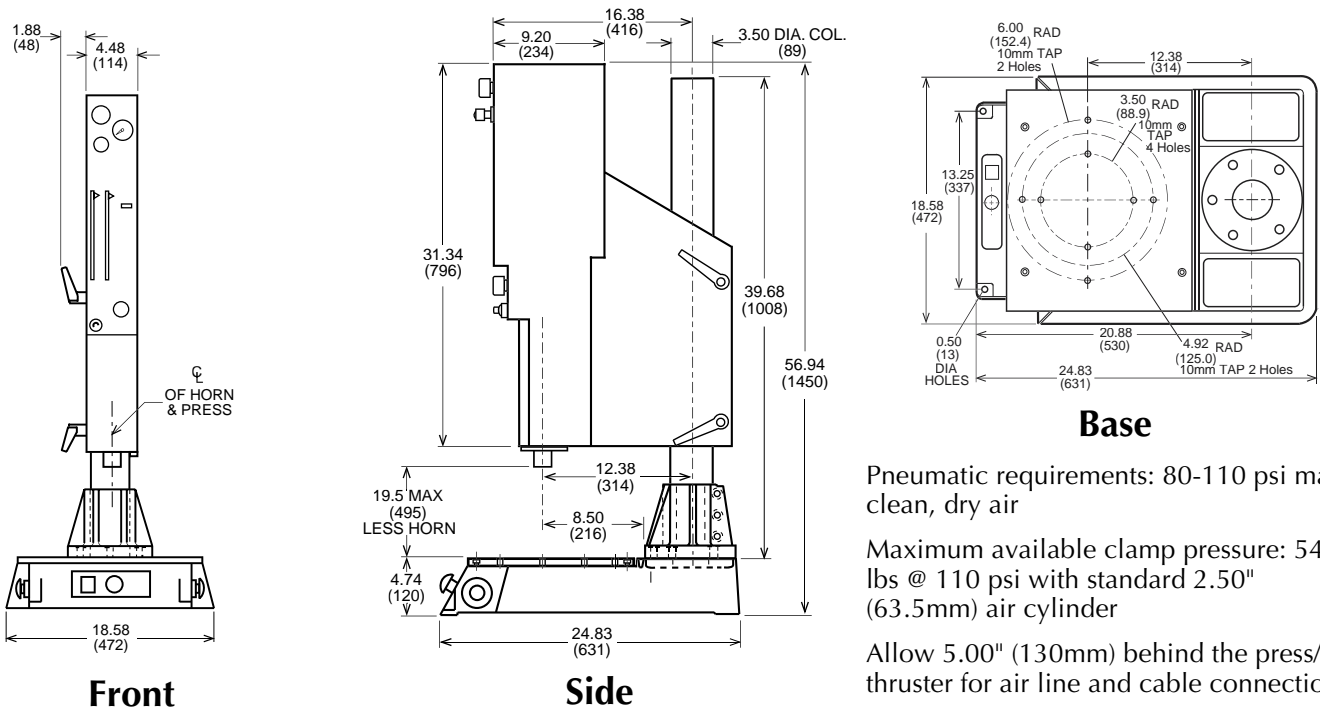
PRE-TRIGGER and END-of-WELD LIMIT SWITCHES Pre-trigger provides ability to initiate weld (sonics on) phase of the cycle prior to contacting part. Great for staking applications. End of weld provides ability to weld to predetermined position in the stroke, simple absolute distance.

4" (1219mm) chrome column increases part load area height by 12 inches

1.50" (38mm), or 2.00" (51mm) and 3.00" (76mm) air cylinder

PROGRAMMABLE pressure profiling and force by interface with **electronic pressure regulator, pressure transducer, and load cell press options** offer increased control, repeatability, and consistency

OPTICAL cycle activation switches



Base

Pneumatic requirements: 80-110 psi max. clean, dry air

Maximum available clamp pressure: 540 lbs @ 110 psi with standard 2.50" (63.5mm) air cylinder

Allow 5.00" (130mm) behind the press/thruster for air line and cable connections

Thruster Dimensions

Housing height:	31.34" (796mm)
Housing width:	4.48" (114mm)
Housing depth:	10.00" (254mm) at greatest point
Weight:	45.00 lbs (20Kg)

Press Dimensions

Base width:	18.58" (472mm)
Base depth:	24.83" (631mm)
Column height:	39.00" (991mm)
Column diameter:	3.50" (89mm)
Maximum height:	56.94" (1450mm)
Housing width:	4.48" (114mm)
Column C.L. to Horn C.L.:	12.38" (314mm)
Useable throat:	8.50" (216mm)
Stroke:	7.00" (178mm)
Weight:	170.00 lbs (77Kg)