

Surelok II 13 24V HS

Reliable design

Unsurpassed quality

The Surelok II now with 24V high speed option

Superior features include

- Trusted Norlok WAMP pneumatic power unit
- 13" throat
- Fasten material from 32 gauge up to 14 gauge*
- Intelligent Safety Stroke now with adjustable "Anti Fatigue" 400ms to 3sec Auto Cycle
- Adjustable 1" (25.4mm) stroke
- Fastest OSHA safe clinching in the world - 2.5 clinches per second



INNOVATIONS IN ENGINEERING

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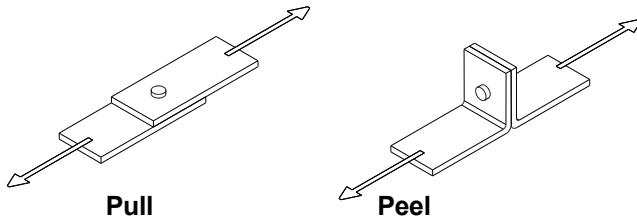
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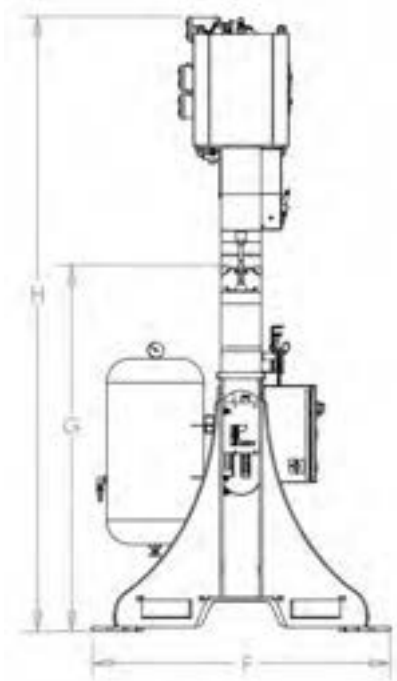
SPECIFICATIONS – SURELOK II 13 24V HS

Press Design:	5" Thick (127mm) steel "C" frame. Rigid steel frame = longer tool life
Features:	WAMP pneumatic power unit. Regulator, Shut-off valve Foot pedal operated
Stroke:	1" (25.4mm) max. (adjustable) "Intelligent" safety stroke for greater operator safety.
Throat:	13" (330mm)
Work Height:	45" (1143mm)
Upper Tooling:	Round tooling Only Close tooling access allows for more applications. Simple adjustments to suit material thickness.
Lower Tooling:	Die insert on a hardened die plate with a hardened protection collar.
Capacity:	MAX: 2 ply .075" (1.9mm) mild steel. MIN: 2 ply .010" (.25mm) mild steel.
Cycle speed:	150 cycles/minute @3/8" stroke
Air Requirements:	90psi to 120psi (6.1 – 8.1 Bar) 100psi (6.8 Bar) (recommended) Approx .5 cu ft (.014cu m) free air/cycle. 5 HP (3.75 kW) @ 60 clinches per min. 115/230 VAC 50/60 Hz .46/.26 Amps
Weight:	1270 lb. (577kg)

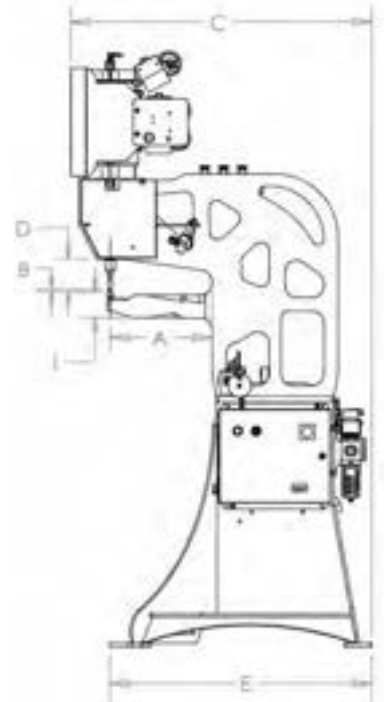
Typical Joint Strengths in Mild Steel:



Material Thickness" (mm)	Pull lbs(N)	Peel lbs(N)	Die Type
.075 (1.9)	550 (2447)	225 (1001)	#50
.060 (1.5)	475 (2113)	175 (778)	#50
.050(1.25)	430 (1913)	150 (667)	#40/#50
.040 (1.0)	400 (1779)	120 (534)	#40
.034 (.86)	375 (1668)	100 (445)	#30/#40
.028 (.71)	325 (1446)	85 (378)	#30
.022 (.55)	285 (1268)	70 (311)	#30



SL II 13 24V HS	
A	13" [330 mm]
B	1" [25.4 mm]
C	38.5" [978 mm]
D	4.25" [108 mm]
E	33" [838 mm]
F	37.5" [953 mm]
G	45" [1143 mm]
H	76" [1930 mm]
I	3.3" [83.8 mm]



Pipe diameter	Die reach into Pipe
3" (76mm) Ø	5-1/4" [133 mm]
4" (102mm) Ø	9" [228 mm]
5" +(127mm) Ø	12" [305 mm]