

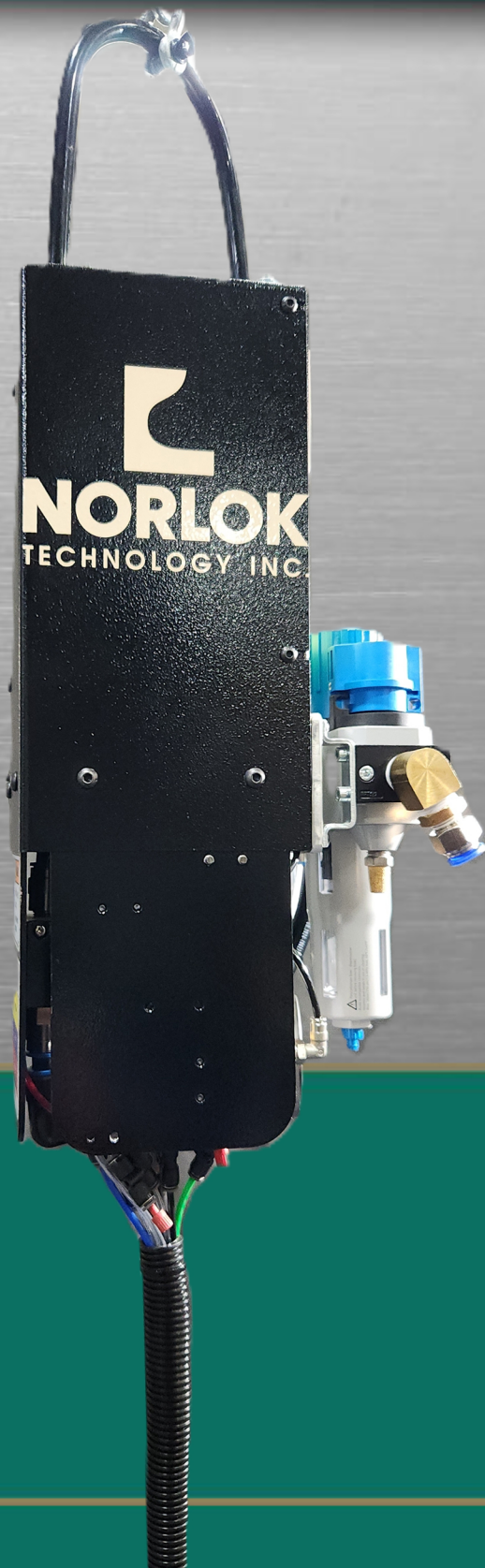
The WATSON

Performance in a small package



The Watson offers all the benefits of clinching in a lightweight version that gives you the portability you need.

- Simple tool adjustments
- Close tooling access
- Air powered
- Easy maintenance
- Fully customizable
- Fasten up to two ply 14ga mild steel, 18 ga stainless steel (with optional tooling)
- Slip on flange duct option fastens up to 3 ply 18ga with optional tooling



INNOVATIONS IN ENGINEERING

Medium Duty Watson

Capacity: Medium Duty (0.18" diameter punch)
MAX: Two ply .075"[1.9mm] mild steel*
MIN: Two ply .010"[0.25mm] mild steel



Stroke: 1-1/2" [38mm]
Throat: 2" [51mm]
Weight: 21 lbs [9.5kg] -hand tool only-
 47 lbs [21kg] -power unit-

Cycle Speed: 25 CPM (standard speed)
30-40 CPM (modified stroke)

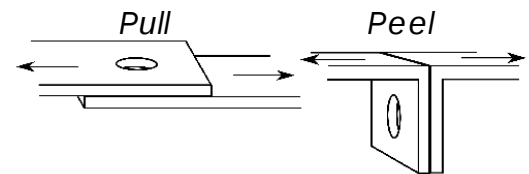
Air Requirements: 70-90psi [5-6 bar]
Approx 0.8 cu ft free air per cycle
5HP @ 40 clinches per minute

Options:

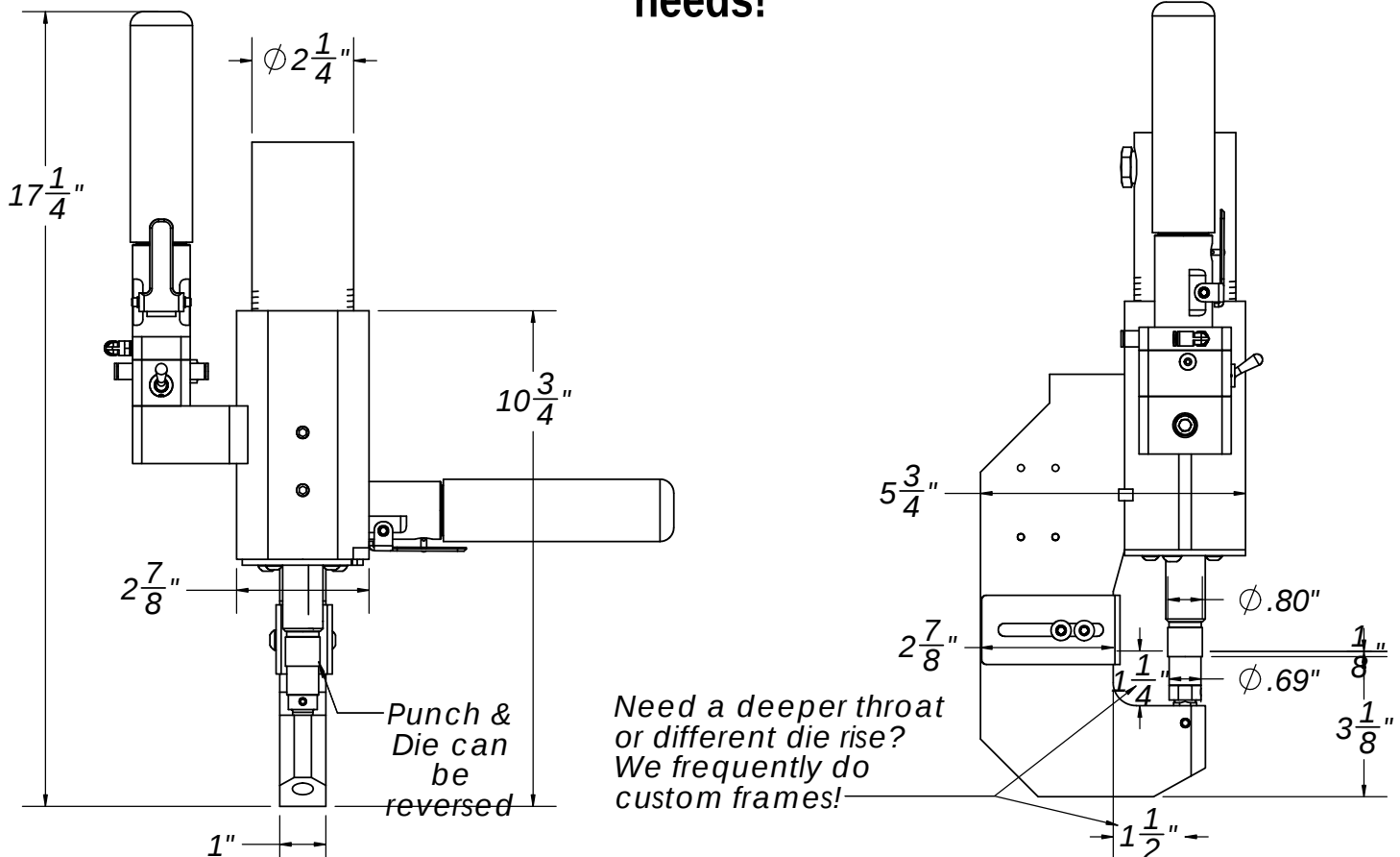
- Hanging Gymbal**
Rotate in the X, Y, or both for machine manipulation
- Spring Balancer**
Provides weightless machine motion
- Mobile Hanging Cart**
For machine mobility around the shop

Clinch Joint Strength in Mild Steel

Material Thickness	Pull (lbs/N)	Peel (lbs/N)	Die Type
.075"/1.90mm	550/2400	225/1000	#50
.060"/1.50mm	475/2100	175/775	#50
.050"/1.25mm	430/1900	150/665	#50
.040"/1.00mm	400/1780	120/530	#40
.030"/0.75mm	325/1450	85/380	#40
.020"/0.50mm	285/1250	70/310	#30
.010"/0.25mm	210/935	35/155	#30



Norlok has an extensive selection of Watson designs for getting over large flanges, into narrow openings, and reaching deep into parts. If not already designed, we will design a machine to meet your clinching needs!



*Alternate 14q tooling may be required