

# Surelok II 12 24v HS

Reliable Design  
Unsurpassed Quality  
The Surelok II now with 24v High  
Speed Option

## Superior Features Include

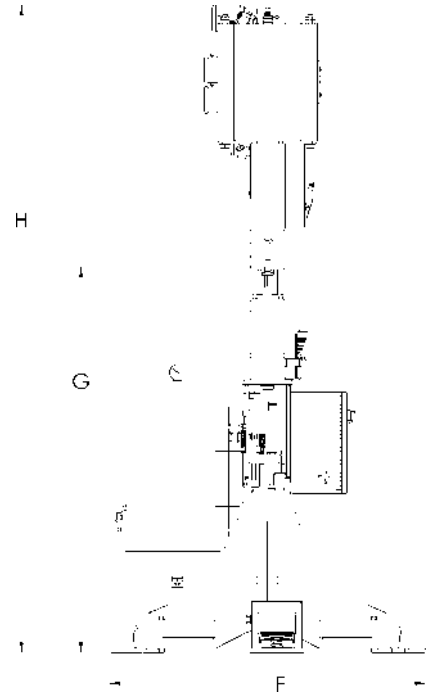
- Trusted Norlok WAMP Pneumatic Power Unit
- 12" Throat frame clinches from 32 gauge to 14 gauge mild steel
- Intelligent Safety Stroke now with adjustable "Anti Fatigue"  
400ms to 3sec Auto Cycle
- Fastest OSHA safe clinching in the world - 2.5 clinches per second



**INNOVATIONS IN ENGINEERING**

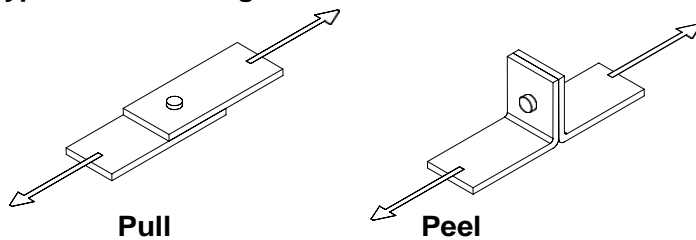
## SPECIFICATIONS – SURELOK II

- Press Design:** Solid 3" (76mm) 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:** 12" (305mm)
- Work Height:** 45" (1143mm)
- Upper Tooling:** Round 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
- Power Requirements:** 90 to 120psi (6.1 - 8.1 Bar)  
100psi (6.8 Bar) (recommended)  
Approx .5 cuft (.014cu m) free air/cycle  
5HP (3.75kW) @ 60 clinches per min.  
115/230 VAC 50/60 Hz .46/.26 Amps
- Weight:** 852 lb (387 kg)

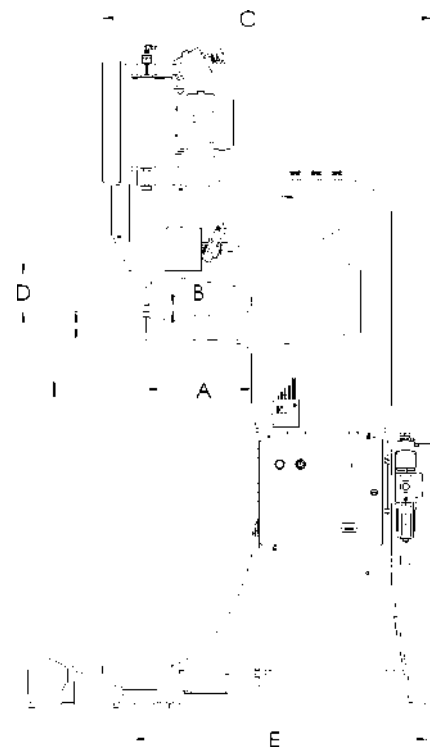


SURELOK	
A	12" (304 mm)
B	1.0" (25.4 mm)
C	38" (965 mm)
D	4.25" (108 mm)
E	34" (864 mm)
F	37" (940 mm)
G	45" (1143 mm)
H	76" (1930 mm)
I	3.3" (83.8 mm)

### 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



Pipe diameter	Die reach into Pipe
4" (101 mm)Ø	9" (228 mm)
5"+ (127 mm)Ø	12" (305 mm)