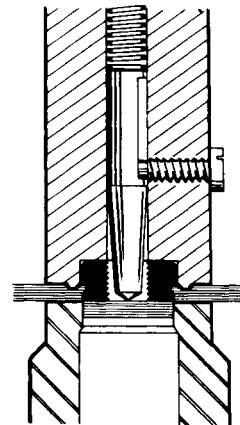
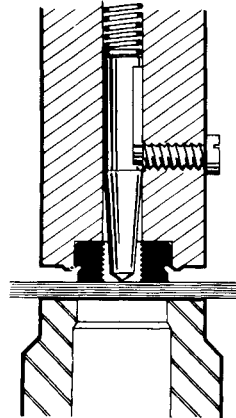
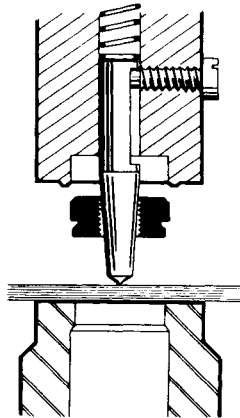


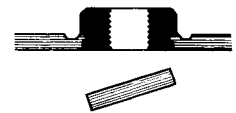
PRESTINCERT MECHANICAL FASTENINGS

COMPONENTS PUNCHED DIRECTLY INTO SHEET METAL — NO FIXING HOLES REQUIRED



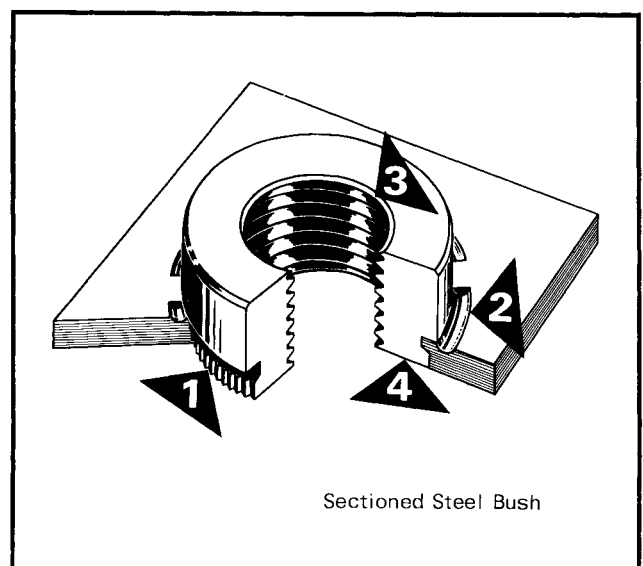
INSERTED AND FIXED
IN ONE OPERATION

NO FIXING HOLES
REQUIRED



STRONG TWO-WAY FIXTURE —

- 1) Knurled to prevent rotation.
 - 2) Swaged for maximum strength
- PLUS
- 3) Deep thread security — over the full component length.
 - 4) Commercially flush finish.



Sectioned Steel Bush



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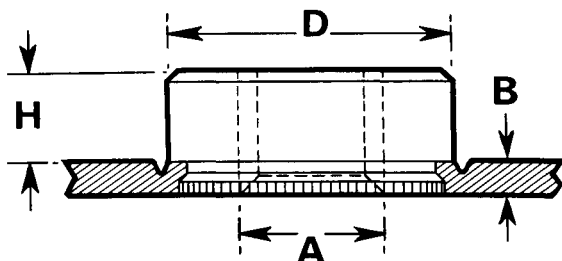
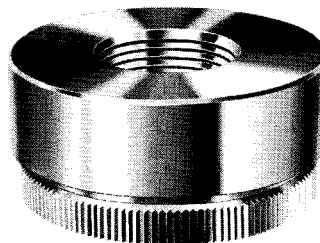
PRESTINCERT STANDARD STEEL BUSHES

PUNCHED DIRECTLY INTO SHEET STEEL — NO FIXING HOLES REQUIRED

Six basic Shapes

Suitable for use with steel and aluminium sheet of tensile strength up to 30 tons per square inch (47 Kp/mm²) 20-14 swg (1mm-2mm).

* Refer to Prestincert Ltd. for minimum manufacturing quantity.
CP Cadmium & Passivated Finish.



Bush Shape	Height 'H'	Diameter 'D'	Bush Shape	Height 'H'	Diameter 'D'
01	0.064" (1,63mm)	0.250" (6,35mm)	11	0.157" (3,99mm)	0.437" (11,10mm)
02	0.079" (2,01mm)	0.312" (7,94mm)	12	0.177" (4,50mm)	0.562" (14,28mm)
03	0.110" (2,80mm)	0.375" (9,53mm)	13	0.203" (5,16mm)	0.625" (15,88mm)

BA THREADS

The first TWO digits of the part number indicate the Bush Shape (See Table above)

Thread X Sheet SWG	Sheet Thickness Inches (mm)	Finish	Part Number	Single Point Insertion Tool Number	Thread X Sheet SWG	Sheet Thickness Inches (mm)	Finish	Part Number	Single Point Insertion Tool Number
6BA x 20	0.036" (0,91)	CP	01-20-006-31	C7001/01A	2 BA x 20	0.036" (0,91)	CP	03-20-002-31	C7003/03B
18	0.048" (1,2)	CP	01-18-006-31	C7001/01A	18	0.048" (1,2)	CP	03-18-002-31	C7003/03B
16	0.064" (1,6)	CP	01-16-006-31	C7001/01A	16	0.064" (1,6)	CP	03-16-002-31	C7003/03B
					14	0.080" (2,03)	Clean	11-14-002-30	C7011/11B
4 BA x 20	0.036" (0,91)	CP	02-20-004-31	C7002/02B	0 BA x 20	0.036" (0,91)	Clean	11-20-000-30*	C7011/11C
18	0.048" (1,2)	CP	02-18-004-31	C7002/02B	18	0.048" (1,2)	Clean	11-18-000-30*	C7011/11C
16	0.064" (1,6)	CP	02-16-004-31	C7002/02B	16	0.064" (1,6)	Clean	11-16-000-30*	C7011/11C
14	0.080" (2,03)	CP	03-14-004-31	C7003/03E	14	0.080" (2,03)	Clean	12-14-000-30*	C7012/12C

BSW THREADS

The first TWO digits of the part number indicate the Bush Shape (See Table above)

3/16" x 20	0.036" (0,91)	CP	03-20-188-11	C7003/03B	5/16" x 20	0.036" (0,91)	Clean	12-20-313-10	C7014/12D
BSW 18	0.048" (1,2)	CP	03-18-188-11	C7003/03B	BSW 18	0.048" (1,2)	Clean	12-18-313-10	C7012/12D
16	0.064" (1,6)	CP	03-16-188-11	C7003/03B	16	0.064" (1,6)	Clean	12-16-313-10	C7012/12D
14	0.080" (2,03)	Clean	11-14-188-10*	C7011/11B	14	0.080" (2,03)	Clean	13-14-313-10	C7013/13C
1/4" x 20	0.036" (0,91)	Clean	11-20-250-10	C7011/11C	3/8" x 20	0.036" (0,91)	Clean	13-20-375-10*	C7015/13D
BSW 18	0.048" (1,2)	Clean	11-18-250-10	C7011/11C	BSW 18	0.048" (1,2)	Clean	13-18-375-10	C7013/13D
16	0.064" (1,6)	Clean	11-16-250-10	C7011/11C	16	0.064" (1,6)	Clean	13-16-375-10	C7013/13D
14	0.080" (2,03)	Clean	12-14-250-10	C7012/12C	14	0.080" (2,03)	Clean	13-14-375-10	C7013/13D

BSF THREADS

The first TWO digits of the part number indicate the Bush Shape (See Table above)

3/16" x 20	0.036" (0,91)	CP	03-20-188-21*	C7003/03B	5/16" x 20	0.036" (0,91)	Clean	12-20-313-20	C7014/12D
BSF 18	0.048" (1,2)	CP	03-18-188-21*	C7003/03B	BSF 18	0.048" (1,2)	Clean	12-18-313-20	C7012/12D
16	0.064" (1,6)	CP	03-16-188-21*	C7003/03B	16	0.064" (1,6)	Clean	12-16-313-20	C7012/12D
14	0.080" (2,03)	Clean	11-14-188-20*	C7011/11B	14	0.080" (2,03)	Clean	13-14-313-20	C7013/13C
1/4" x 20	0.036" (0,91)	Clean	11-20-250-20	C7011/11C	3/8" x 20	0.036" (0,91)	Clean	13-20-375-20*	C7015/13D
BSF 18	0.048" (1,2)	Clean	11-18-250-20	C7011/11C	BSF 18	0.048" (1,2)	Clean	13-18-375-20	C7013/13D
16	0.064" (1,6)	Clean	11-16-250-20	C7011/11C	16	0.064" (1,6)	Clean	13-16-375-20	C7013/13D
14	0.080" (2,03)	Clean	12-14-250-20	C7012/12C	14	0.080" (2,03)	Clean	13-14-375-20	C7013/13D



PRESTINCERT
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540 GREAT CAMBRIDGE ROAD
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PRESTINCERT STANDARD STEEL BUSHES

PUNCHED DIRECTLY INTO SHEET STEEL — NO FIXING HOLES REQUIRED

Suitable for use with steel and aluminium sheet of tensile strength up to 30 tons per square inch (47 Kp/mm²) 20-14 swg (1mm-2mm). Metric & Unified Bushes have coding ring on external diameter.

* Refer to Prestincert Limited for minimum manufacturing quantity.

CP Cadmium & Passivated Finish.

UNF THREADS

					The first two digits of the part number indicate the Bush shape (see Table Page 3)				
Thread X Sheet SWG	Sheet Thickness Inches (mm)	Finish	Part Number	Single Point Insertion Tool Number	Thread X Sheet SWG	Sheet Thickness Inches (mm)	Finish	Part Number	Single Point Insertion Tool Number
10-32 x 20	0.036" (0.91)	CP	03-20-010-51	C7003/03D	5/16" x 20	0.036" (0.91)	Clean	12-20-313-50	C7014/12D
UNF 18	0.048" (1.2)	CP	03-18-010-51	C7003/03D	UNF 18	0.048" (1.2)	Clean	12-18-313-50	C7012/12D
16	0.064" (1.6)	CP	03-16-010-51	C7003/03D	16	0.064" (1.6)	Clean	12-16-313-50	C7012/12D
14	0.080" (2.03)	Clean	11-14-010-50*	C7011/11B	14	0.080" (2.03)	Clean	13-14-313-50	C7013/13C
1/4" x 20	0.036" (0.91)	Clean	11-20-250-50	C7011/11C	3/8" x 20	0.036" (0.91)	Clean	13-20-375-50*	C7015/13D
UNF 18	0.048" (1.2)	Clean	11-18-250-50	C7011/11C	UNF 18	0.048" (1.2)	Clean	13-18-375-50	C7013/13D
16	0.064" (1.6)	Clean	11-16-250-50	C7011/11C	16	0.064" (1.6)	Clean	13-16-375-50	C7013/13D
14	0.080" (2.03)	Clean	12-14-250-50	C7012/12C	14	0.080" (2.03)	Clean	13-14-375-50	C7013/13D

UNC THREADS

					The first two digits of the part number indicate the Bush shape (see Table Page 3)				
4-40 x 20	0.036" (0.91)	CP	01-20-004-61	C7001/01A	1/4" x 20	0.036" (0.91)	Clean	11-20-250-60	C7011/11C
UNC 18	0.048" (1.2)	CP	01-18-004-61	C7001/01A	UNC 18	0.048" (1.2)	Clean	11-18-250-60	C7011/11C
16	0.064" (1.6)	CP	01-16-004-61	C7001/01A	16	0.064" (1.6)	Clean	11-16-250-60	C7011/11C
					14	0.080" (2.03)	Clean	12-14-250-60	C7012/12C
6-32 x 20	0.036" (0.91)	CP	02-20-006-61	C7002/02B	5/16" x 20	0.036" (0.91)	Clean	12-20-313-60	C7014/12D
UNC 18	0.048" (1.2)	CP	02-18-006-61	C7002/02B	UNC 18	0.048" (1.2)	Clean	12-18-313-60	C7012/12D
16	0.064" (1.6)	CP	02-16-006-61	C7002/02B	16	0.064" (1.6)	Clean	12-16-313-60	C7012/12D
14	0.080" (2.03)	CP	03-14-006-61*	C7003/03E	14	0.080" (2.03)	Clean	13-14-313-60	C7013/13C
10-24 x 20	0.036" (0.91)	CP	03-20-010-61*	C7003/03B	3/8" x 20	0.036" (0.91)	Clean	13-20-375-60*	C7015/13D
UNC 18	0.048" (1.2)	CP	03-18-010-61*	C7003/03B	UNC 18	0.048" (1.2)	Clean	13-18-375-60	C7013/13D
16	0.064" (1.6)	CP	03-16-010-61*	C7003/03B	16	0.064" (1.6)	Clean	13-16-375-60	C7013/13D
14	0.080" (2.03)	Clean	11-14-010-60*	C7011/11B	14	0.080" (2.03)	Clean	13-14-375-60	C7013/13D

METRIC THREADS

Thread mm	Sheet Thickness	Finish	Bush Shape	Part Number	Single Point Insertion Tool Number	Thread mm	Sheet Thickness	Finish	Bush Shape	Part Number	Single Point Insertion Tool Number
M2.5	1.0mm	CP	01	M25 10	C7001/01A	M7	1.0mm	Clean	12	M70 10*	C7014/12D
M2.5	1.5mm	CP	01	M25 15	C7001/01A	M7	1.5mm	Clean	12	M70 15*	C7012/12D
M2.5	2.0mm	CP	02	M25 20*	C7002/2,5	M7	2.0mm	Clean	12	M70 20*	C7012/12D
M3	1.0mm	CP	02	M30 10	C7002/02A	M8	1.0mm	Clean	12	M80 10	C7014/12D
M3	1.5mm	CP	02	M30 15	C7002/02A	M8	1.5mm	Clean	12	M80 15	C7012/12D
M3	2.0mm	CP	03	M30 20*	C7003/03C	M8	2.0mm	Clean	13	M80 20	C7013/13C
M4	1.0mm	CP	03	M40 10	C7003/03A	M9	1.0mm	Clean	13	M90 10*	C7015/13D
M4	1.5mm	CP	03	M40 15	C7003/03A	M9	1.5mm	Clean	13	M90 15*	C7013/13D
M4	2.0mm	Clean	11	M40 20	C7011/11B	M9	2.0mm	Clean	13	M90 20*	C7013/13D
M5	1.0mm	Clean	11	M50 10	C7011/11B	M10	1.0mm	Clean	13	M100 10*	C7015/13D
M5	1.5mm	Clean	11	M50 15	C7011/11B	M10	1.5mm	Clean	13	M100 15*	C7013/13D
M5	2.0mm	Clean	12	M50 20	C7012/12B	M10	2.0mm	Clean	13	M100 20*	C7013/13D
M6	1.0mm	Clean	11	M60 10	C7011/11C	(Metric threaded bushes for British sheet manufactured upon request)					
M6	1.5mm	Clean	11	M60 15	C7011/11C						
M6	2.0mm	Clean	12	M60 20	C7012/12C						



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PRESTIN CERT STANDARD STEEL BUSHES

PUNCHED DIRECTLY INTO SHEET STEEL — NO FIXING HOLES REQUIRED

TEST RESULTS using standard steel bushes and steel sheet of 25-30 tons per square inch tensile strength (B.S.1449)

BUSH SHAPE X SWG	MINIMUM INSERTION FORCE	PUSH-OUT FORCE (F)	TORQUE (T) REQUIRED TO TURN BUSH IN SHEET	BUSH SHAPE X SWG	MINIMUM INSERTION FORCE	PUSH-OUT FORCE (F)	TORQUE (T) REQUIRED TO TURN BUSH IN SHEET
01 x 20 SWG	3½ tons	224 lbs.	65 lbs. ins.	11 x 20 SWG	5 tons	303 lbs.	156 lbs. ins.
01 x 18 SWG	3½ tons	285 lbs.	82 lbs. ins.	11 x 18 SWG	5 tons	333 lbs.	204 lbs. ins.
01 x 16 SWG	4 tons	308 lbs.	106 lbs. ins.	11 x 16 SWG	5½ tons	467 lbs.	293 lbs. ins.
				11 x 14 SWG	5 tons	574 lbs.	325 lbs. ins.
02 x 20 SWG	4 tons	246 lbs.	76 lbs. ins.	12 x 20 SWG	6 tons	285 lbs.	276 lbs. ins.
02 x 18 SWG	4 tons	294 lbs.	137 lbs. ins.	12 x 18 SWG	7 tons	468 lbs.	306 lbs. ins.
02 x 16 SWG	4½ tons	320 lbs.	188 lbs. ins.	12 x 16 SWG	7 tons	579 lbs.	432 lbs. ins.
				12 x 14 SWG	6 tons	764 lbs.	546 lbs. ins.
03 x 20 SWG	4½ tons	288 lbs.	120 lbs. ins.	13 x 20 SWG	7 tons	280 lbs.	300 lbs. ins.
03 x 18 SWG	4½ tons	327 lbs.	187 lbs. ins.	13 x 18 SWG	8 tons	427 lbs.	312 lbs. ins.
03 x 16 SWG	5 tons	341 lbs.	251 lbs. ins.	13 x 16 SWG	9 tons	495 lbs.	426 lbs. ins.
				13 x 14 SWG	8 tons	682 lbs.	540 lbs. ins.

INSERTION FORCE

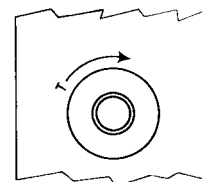
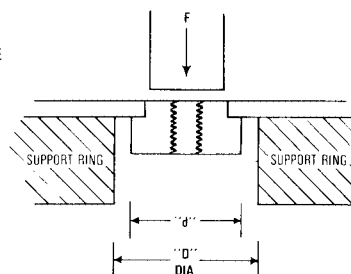
IN PRODUCTION WE WOULD RECOMMEND AN INCREASE OF 10-15% ON THE MINIMUM FIGURES SHOWN.

WITHDRAWAL AND TORQUE

OWING TO TOLERANCE OF SHEET THICKNESS, ETC., ONLY AVERAGE FIGURES CAN BE GIVEN.

PUSH-OUT FORCE

TORSIONAL STRENGTH



$$D' = (2 \times \text{sheet thickness}) + 'd'$$

TEST RESULTS using standard steel bushes and steel sheet of 40-47 Kp/mm² tensile strength.

BUSH SHAPE X SHEET THICKNESS	MINIMUM INSERTION FORCE	PUSH-OUT FORCE (F)	TORQUE (T) REQUIRED TO TURN BUSH IN SHEET	BUSH SHAPE X SHEET THICKNESS	MINIMUM INSERTION FORCE	PUSH-OUT FORCE (F)	TORQUE (T) REQUIRED TO TURN BUSH IN SHEET
01 x 1,00mm	3556 kg	102 kg	0.755 kpm	11 x 1,00mm	5080 kg	138 kg	1.80 kpm
01 x 1,50mm	4064 kg	140 kg	1.244 kpm	11 x 1,50mm	5080 kg	212 kg	2.49 kpm
				11 x 2,00mm	4572 kg	261 kg	3.37 kpm
02 x 1,00mm	4064 kg	112 kg	0.865 kpm	12 x 1,00mm	6096 kg	129 kg	3.29 kpm
02 x 1,50mm	4572 kg	145 kg	2.176 kpm	12 x 1,50mm	7112 kg	263 kg	4.98 kpm
02 x 2,00mm	4600 kg	155 kg	2.400 kpm	12 x 2,00 kg	6096 kg	347 kg	6.29 kpm
03 x 1,00mm	4572 kg	131 kg	1.382 kpm	13 x 1,00mm	7112 kg	127 kg	3.46 kpm
03 x 1,50mm	5080 kg	155 kg	2.764 kpm	13 x 1,50mm	9144 kg	225 kg	4.90 kpm
03 x 2,00mm	5080 kg	167 kg	3.290 kpm	13 x 2,00mm	8128 kg	310 kg	6.22 kpm



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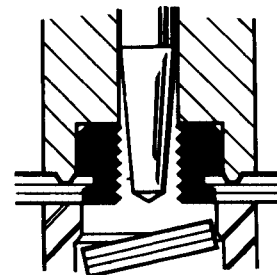


SIMPLE INSERTION TOOLS

for 'DOWNWARD' Bush Insertion.

Normally used on manual presses

See Page 6

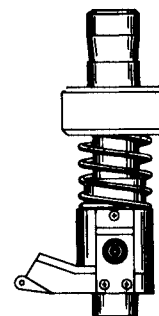


AUTOMATIC INSERTION SYSTEM

for SPEEDY 'DOWNWARD' Bush Insertion.

Normally used on power presses

See Page 12



PRESTINCERT—REDMAN UNIT TOOLING

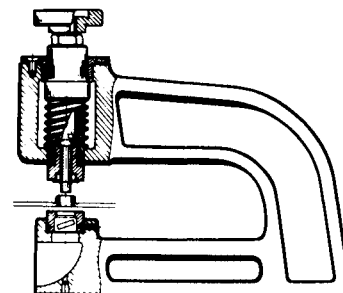
Pre-aligned for use on Brake Presses and other types of presses.

PR1 for 'DOWNWARD' Bush Insertion

PR2 for 'UPWARD' Bush Insertion

PR3 for AUTOMATIC Bush Insertion

See Page 10



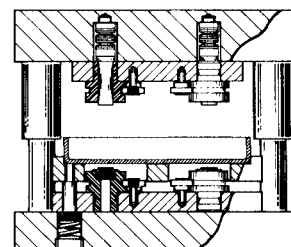
MULTI-INSERTION TOOLING

Manufactured to customer's requirements

for either 'DOWNWARD' or 'UPWARD' Bush Insertion.

Normally used on manual or power presses

See Page 9

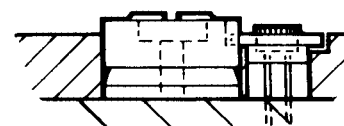
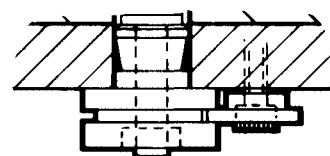


TOOLING INSERTS

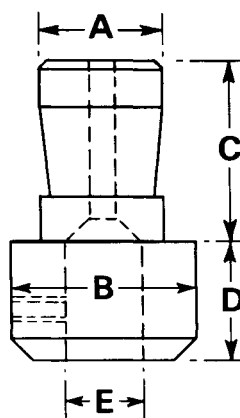
for incorporation into die sets, tool holders.

Available for either 'DOWNWARD' or 'UPWARD' Bush Insertion

See Page 8



TOP ADAPTOR



INSERTION TOOLS

(comprising Top Ringstake Tool with component retaining pin, and Base Die)

	E DIA.	F DIA.	G	H	I	J DIA.	K	L DIA.
C7001	0.311"	5/8"	3/4"	2 1/8"	29/64"	5/8"	1 3/8"	0.750"
C7002	(7,90 mm)	(15,9 mm)	(19,05 mm)	(54mm)	(11,5 mm)	(15,9 mm)	(34,9 mm)	(19,05 mm)
C7003								
C7011*	0.625"	1 1/8"	7/8"	2 5/8"	—	1 1/8"	1"	1,125"
C7012*	(15,90 mm)	(28,6 mm)	(22,2 mm)	(66,67 mm)		(28,6 mm)	(25,4 mm)	(28,60 mm)
C7013*								
C7014*								
C7015*								

* Setting piece supplied.

The following supplementary Adaptors and Bolsters can be supplied:

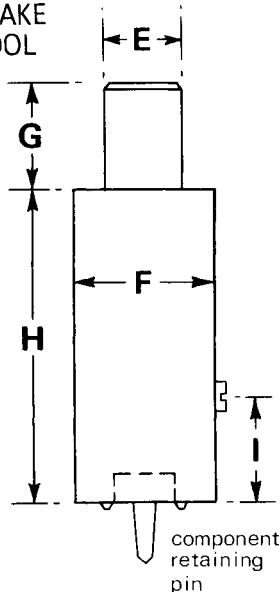
TOP ADAPTORS

	A DIA.	B DIA.	C	D	E DIA.
T23078/A	1"	1 1/4"	1 1/2"	7/8"	0.314" (7,98mm)
T26861	1"	1 1/2"	1 1/2"	1"	0.627" (15,93mm)
T27338	(16mm)	(31,8mm)	(38,1mm)	(25,4mm)	0.314" (7,98mm)
T27339	(20mm)	(31,8mm)	(38,1mm)	(25,4mm)	0.314" (7,98mm)
T27340	(20mm)	(38,1mm)	(38,1mm)	(25,4mm)	0.627" (15,93mm)
T27341	(25mm)	(38,1mm)	(38,1mm)	(25,4mm)	0.627" (15,93mm)

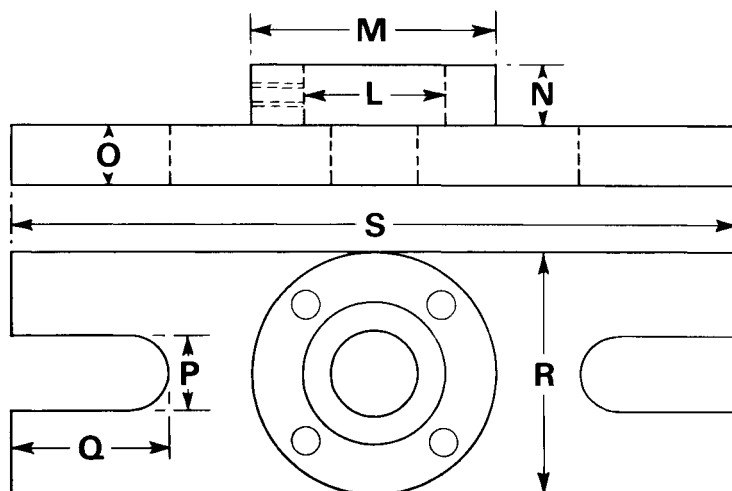
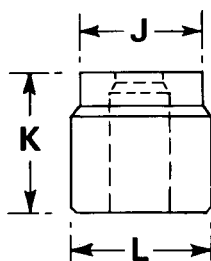
BASE BOLSTERS

	L DIA.	M DIA.	N	O	P	Q	R	S
T23076/D	0.752"	1 1/4"	1/2"	1/2"	5/8"	1"	2"	6"
	(19,10 mm)	(44,5 mm)	(12,7 mm)	(12,7 mm)	(15,9 mm)	(25,4 mm)	(50,8 mm)	(142,4 mm)
T23076/E	1.128"	2"	1/2"	1/2"	5/8"	1"	2"	6"
	(28,65 mm)	(50,8 mm)	(12,7 mm)	(12,7 mm)	(15,9 mm)	(25,4 mm)	(50,8 mm)	(142,4 mm)

TOP RING-STAKE TOOL



BASE DIE



BASE BOLSTER



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ENFIELD · MIDDLESEX · ENGLAND



PRESTINCERT TYPICAL METHODS OF LOCATION*

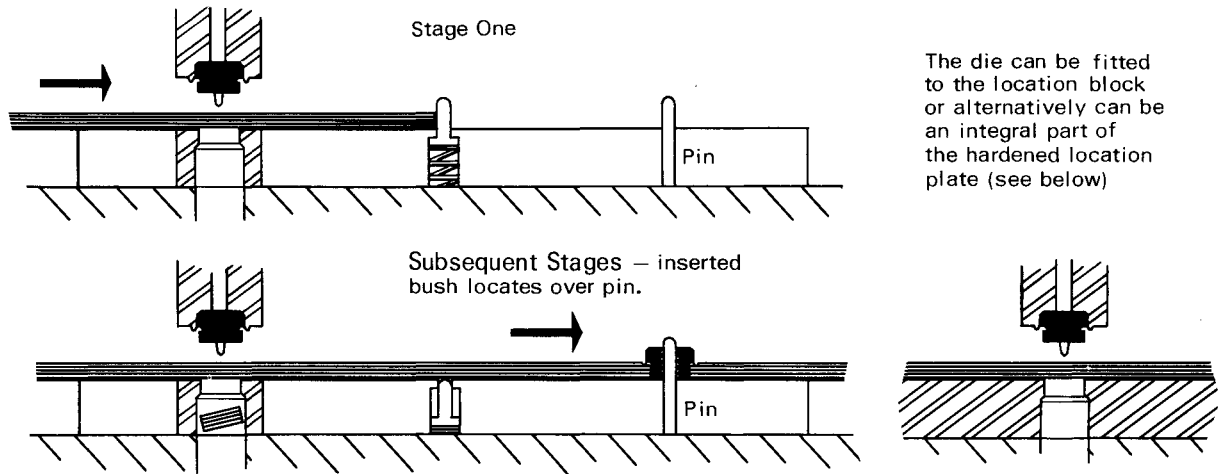
COMPONENTS PUNCHED DIRECTLY INTO SHEET METAL — NO FIXING HOLES REQUIRED

STANDARD PRESS TECHNIQUES

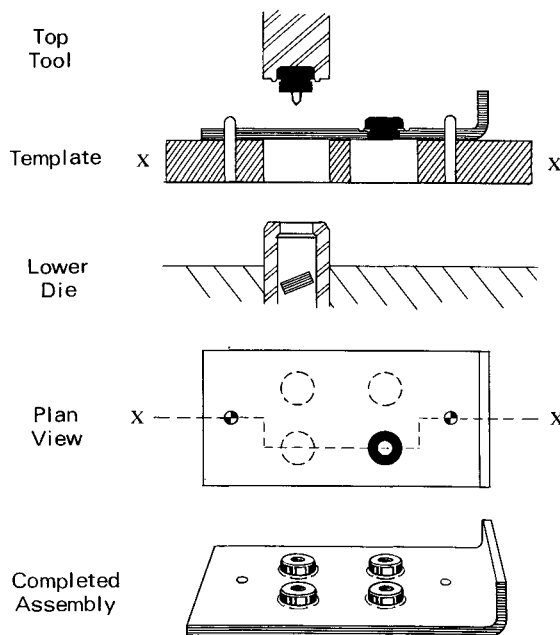
In common with normal press practice (as applied to piercing/planishing) it is essential that the TOP and BOTTOM tools be CORRECTLY aligned.

* Similar methods can be used with Prestincert Electrical/Electronic Fastenings

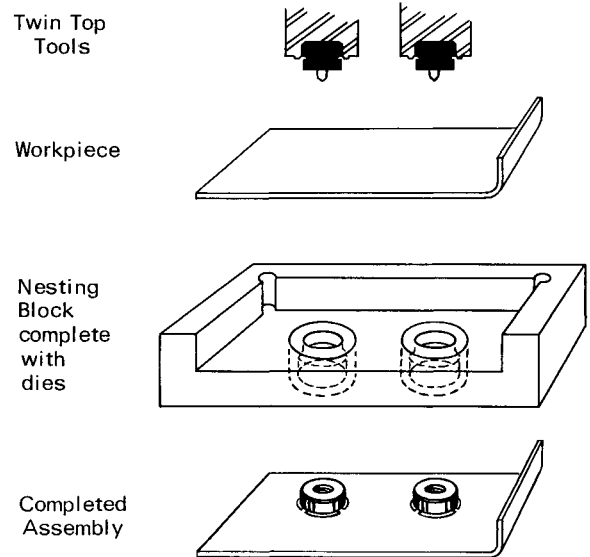
INDEXING



TEMPLATE locating on lower die



NESTING



Although NO FIXING HOLE is required by the Prestincert, for other operations on the sheet, i.e. location and forming, it may be convenient or desirable in particular applications to include a hole of no greater diameter than the centre-pin of the upper Prestincert Tool.



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PRESTIN CERT STANDARD TOOLING INSERTS

COMPONENTS PUNCHED DIRECTLY INTO SHEET STEEL — NO FIXING HOLES REQUIRED

AVAILABLE FOR BUSH SHAPES 02, 03, 11, 12 & 13

C77 & C77/R SERIES FOR DOWNWARD INSERTION

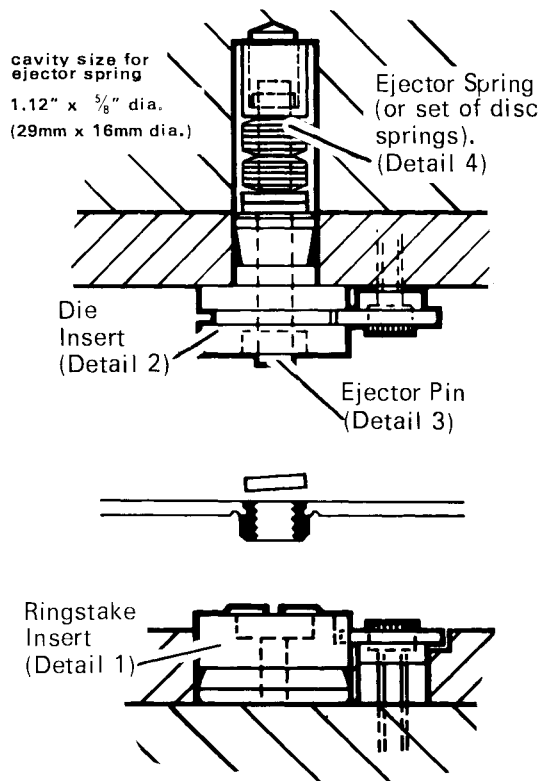
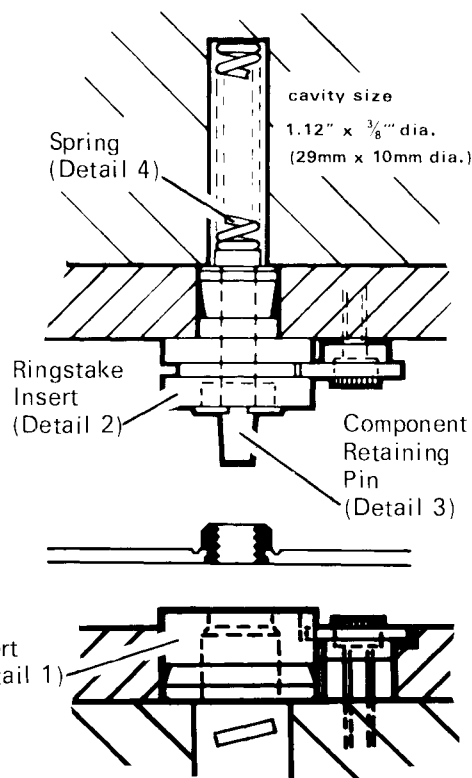
Die Insert	Detail 1
Ringstake Insert	2
Component Retaining Pin	3
Spring	4

For 18swg, 16swg & 14swg thickness steel
(also 1,25mm; 1,5mm & 2,0mm).

BUSH	02	TOOL	C.7702
SHAPE	03	INSERT	C.7703
	11	No.	C.7711
	12		C.7712
	13		C.7713

For 20swg & 1mm thickness steel :

BUSH	02	TOOL	C.7702/R
SHAPE	03	INSERT	C.7703/R
	11	No.	C.7711/R
	12		C.7712/R
	13		C.7713/R



C88 and C88/R SERIES FOR UPWARD INSERTION

Ringstake Insert	Detail 1
Die Insert	2
Ejector Pin	3
Ejector spring	4

For 18swg, 16swg & 14swg thickness steel
(also 1,25mm; 1,5mm & 2,0mm).

BUSH	02	TOOL	C.8802
SHAPE	03	INSERT	C.8803
	11	No.	C.8811
	12		C.8812
	13		C.8813

For 20swg & 1mm thickness steel :

BUSH	02	TOOL	C.8802/R
SHAPE	03	INSERT	C.8803/R
	11	No.	C.8811/R
	12		C.8812/R
	13		C.8813/R

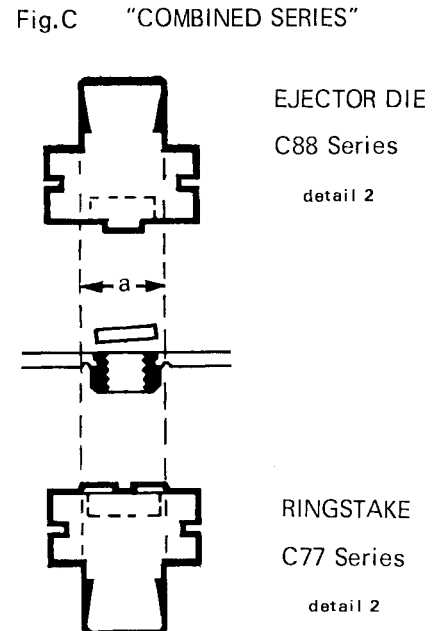
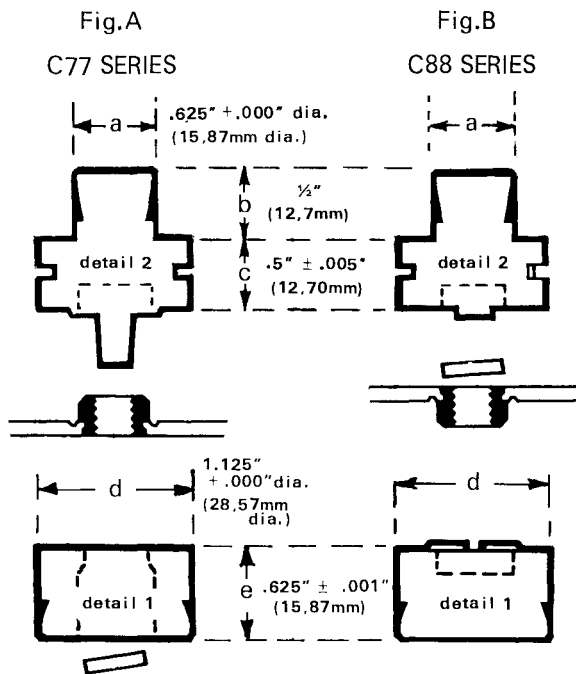
Detailed drawings will
be supplied upon request.



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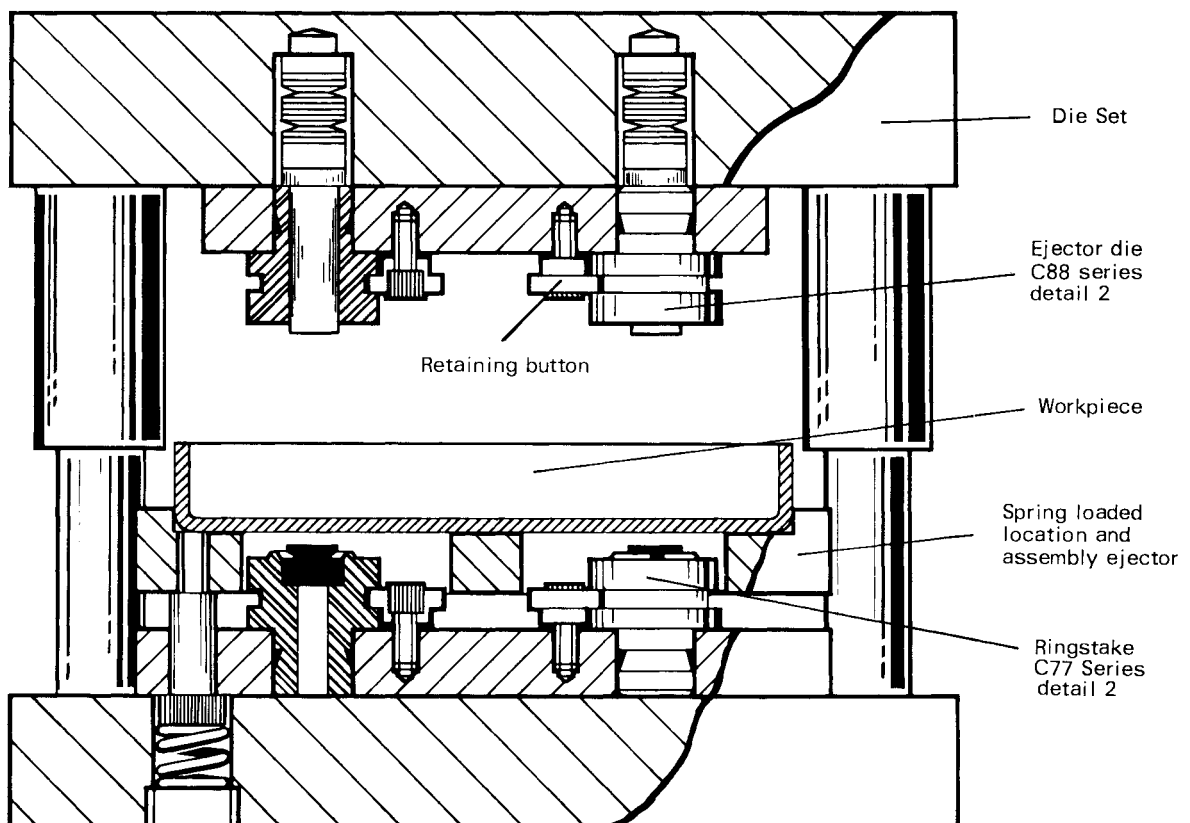


EXTERNAL DIMENSIONS



TYPICAL MULTI-INSERTION TOOL — designed for UPWARD Bush Insertion

This example incorporates C88 series ejector dies with C77 series Ringstake inserts — to take advantage of in-line boring (see fig.C above)



Multi-insertion tools are manufactured to meet customer's requirements.



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An extension of the well known Redman Unit Tooling for cropping, notching and punching — PR Unit Tooling is designed for *punching* Prestincert Threaded bushes into steel sheet in ONE operation.

Pre-aligned for use on Press Brakes, PR Unit Tooling is equally suited to other Presses where single or group insertion is required at specific centres or location.

MODELS AVAILABLE:—

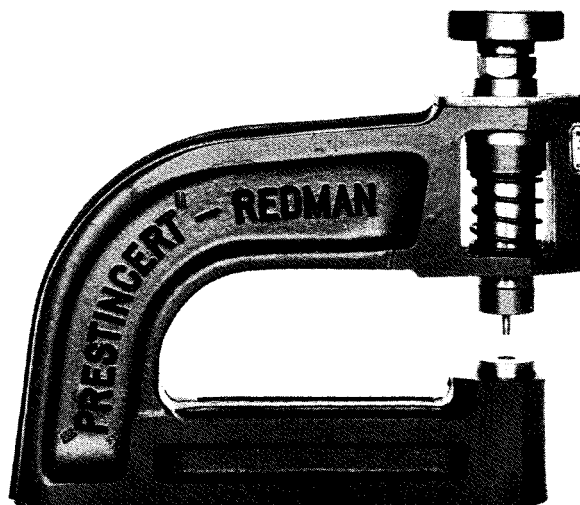
PR1 — Downward Insertion

PR2 — Upward Insertion

PR3 — Automatic Insertion
(Downward)

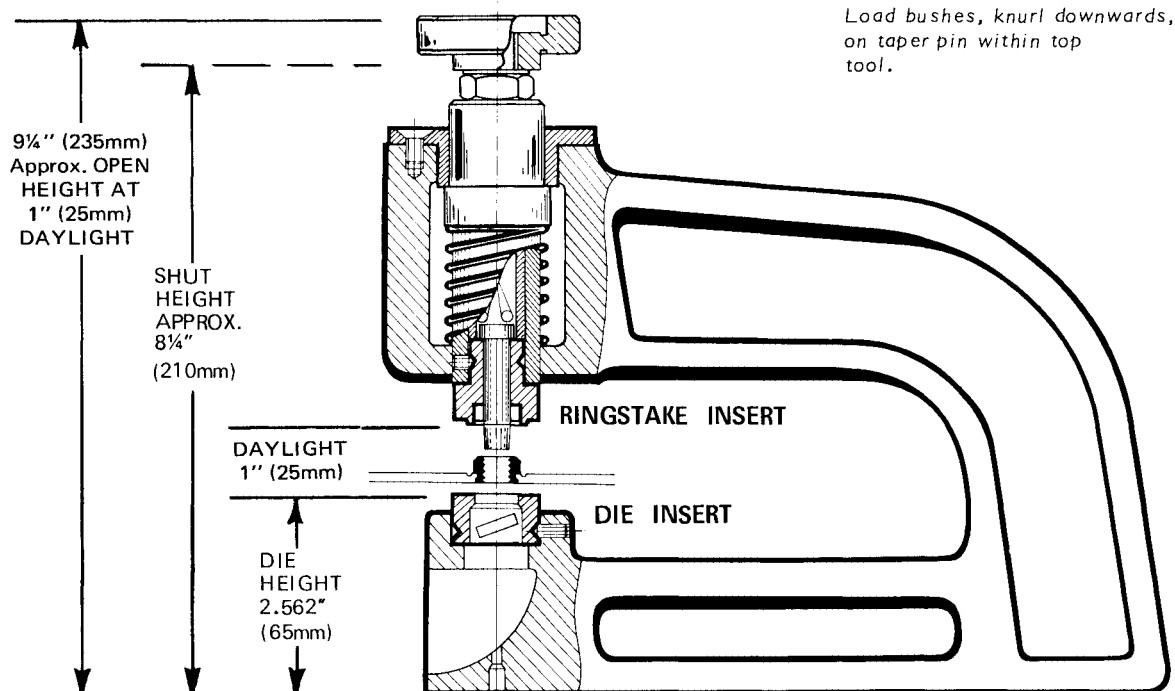
When ordering, specify:—

- 1) Model and Throat Depth;
- 2) Thread Form of bush;
- 3) Sheet Metal thickness.



PR1 FOR DOWNWARD INSERTION (incorporating C77 & C77/R Series Tooling Inserts.) — NOW FITTED WITH C7500 TOOL OVERLOAD PROTECTION UNITS.

Throat Depths available 6" (152mm); 12" (305mm); 18" (457mm)
Minimum Pitch 2 1/4" (57,2mm)



It is not always possible to combine bush insertion with piercing operations — consult Prestincert Limited.



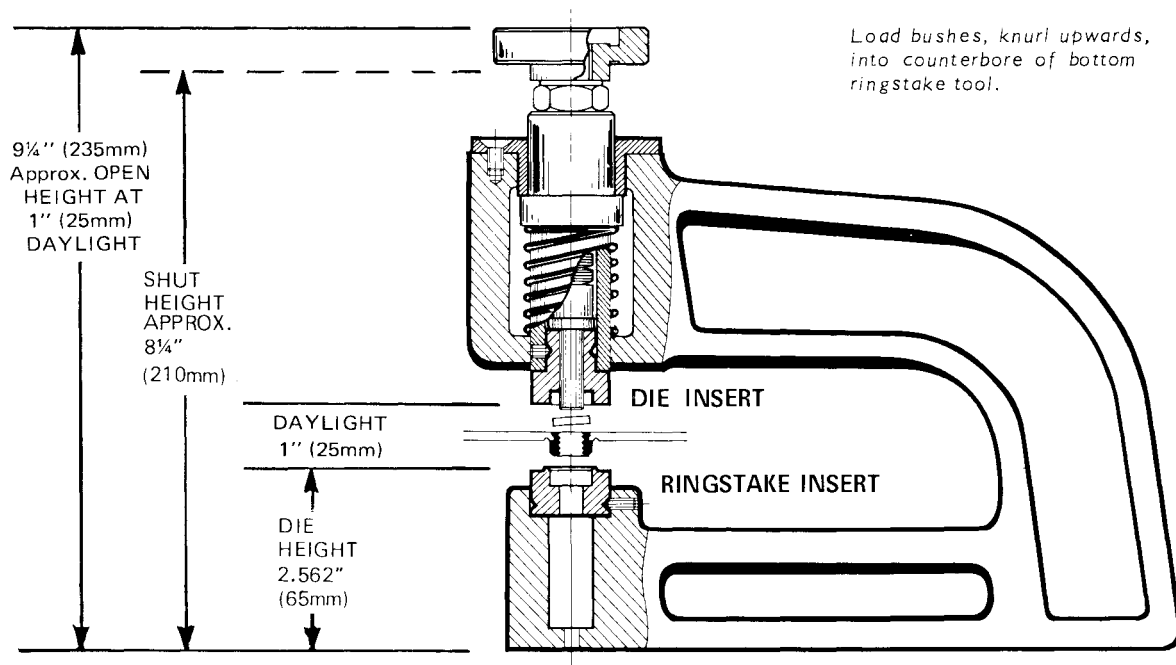
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PR2 FOR UPWARD INSERTION (incorporating C88 & C88/R Series Tooling Inserts.)

— NOW FITTED WITH C7500 TOOL OVERLOAD PROTECTION UNITS.

Throat Depths available 6" (152mm); 12" (305mm); 18" (457mm)
Minimum Pitch 2¼" (57mm)



It is not always possible to combine bush insertion with piercing operations — consult Prestincert Limited.

PR3 FOR AUTOMATIC (DOWNWARD) INSERTION.

Separate models available for Bush Shapes 03, 11, 12 & 13.

The Prestincert Automatic Insertion Tool will, under normal press operation, *punch* Prestincert Steel Bushes into the workpiece at every stroke. Automatic recharging takes place during the upstroke of the press, giving a continuous operating cycle.

Available in two standard throat depths: 8" (203mm) and 18" (457mm) X 3½" (92mm) centres

For full details, consult Prestincert Limited.

TOOL OVERLOAD PROTECTION UNITS

PR Unit Tooling is different from conventional Redman Piercing Tools, in that they "bottom" to provide ringstaking around the Prestincert Bushes.

C.7500 Tool Overload Protection Units, now fitted as standard, are recommended for use where the pitch, and Open Height of the Press, permit. They are designed to fracture and thus prevent damage to PR Unit Tooling through the use of oversize material, the inadvertent loading of two bushes, or oversetting of the Press.



PRESTINCERT AUTOMATIC INSERTION SYSTEM

FOR *SPEEDY* INSERTION OF BUSHES INTO STEEL

AUTOMATIC INSERTION SYSTEM

Apart from the obvious advantages of a faster and therefore cheaper assembly, the System reduces fatigue and human error and provides greater safety of operation.

Basically, the system comprises:—

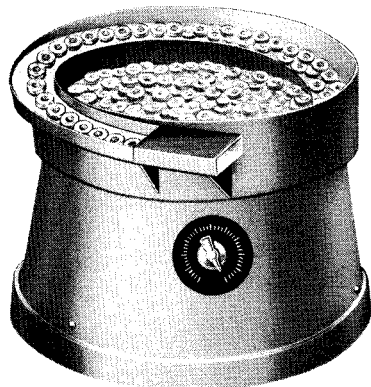
- A) THE AUTOMATIC INSERTION TOOL**
- B) A LENGTH OF CONNECTING FLIGHTING**
- C) A FEEDING UNIT**

Automatic Insertion Tools are made to accept Prestincert standard steel bushes for insertion into sheet metal of thickness 14-20 SWG (1.0mm—2.0mm) being designed for use with press equipment having *accuracy* of stroke movement.

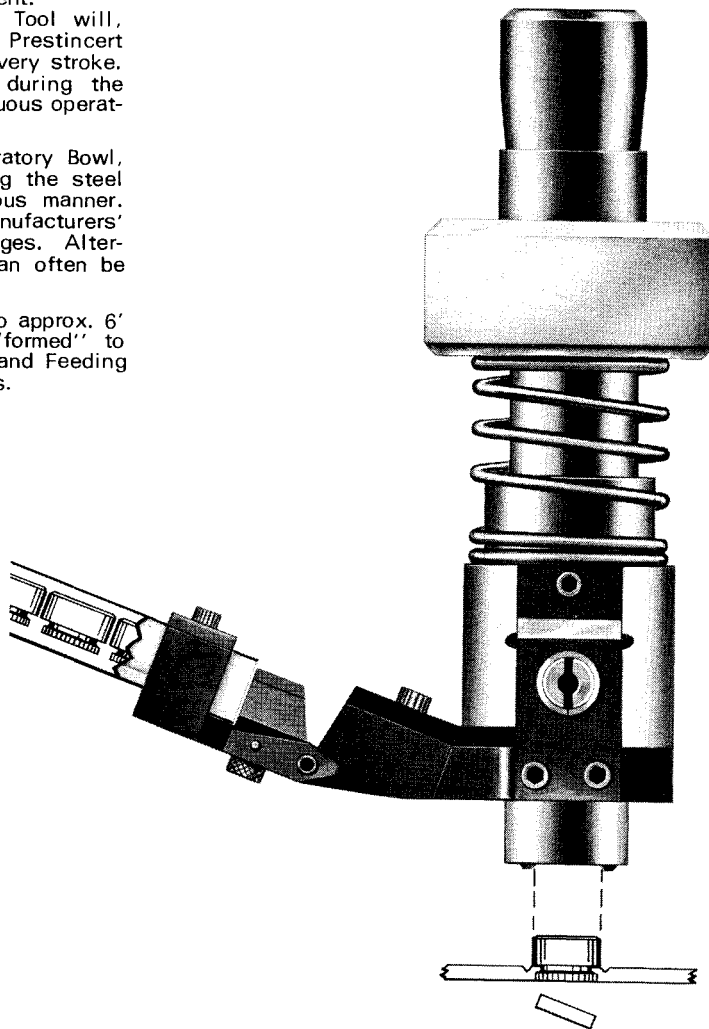
The Prestincert Automatic Insertion Tool will, under normal press operation, *punch* Prestincert Steel Bushes into the workpiece at every stroke. Automatic recharging takes place during the upstroke of the press, giving a continuous operating cycle.

The Feeding Unit, typically a Vibratory Bowl, must be suitably sensed for passing the steel bushes in an upright and continuous manner. Bowls can be supplied ex U.K. at manufacturers' cost, plus handling and delivery charges. Alternatively, existing dispenser units can often be utilised.

Flighting is supplied in lengths up to approx. 6' (1.85 metres) and when conveniently "formed" to connect the Automatic Insertion Tool and Feeding Unit, is fixed by stainless steel bands.



Typical Feeding Unit



Automatic Insertion Tools can be fixed to the ram of the Press by the plate top or spigot peg — both of these items being supplied. The spigot top is detachable when using the plate top which has four screw holes located for fixing to the Press. It is also advisable to bore and ream further holes in both top plate of the Automatic Insertion Tool and of the Press — to accept hardened dowels.

Standard dies are supplied, these should be aligned with the Automatic Insertion Tool by conventional Press tool setting methods.

We recommend the use of a dead stop to protect the Automatic Insertion Tool.



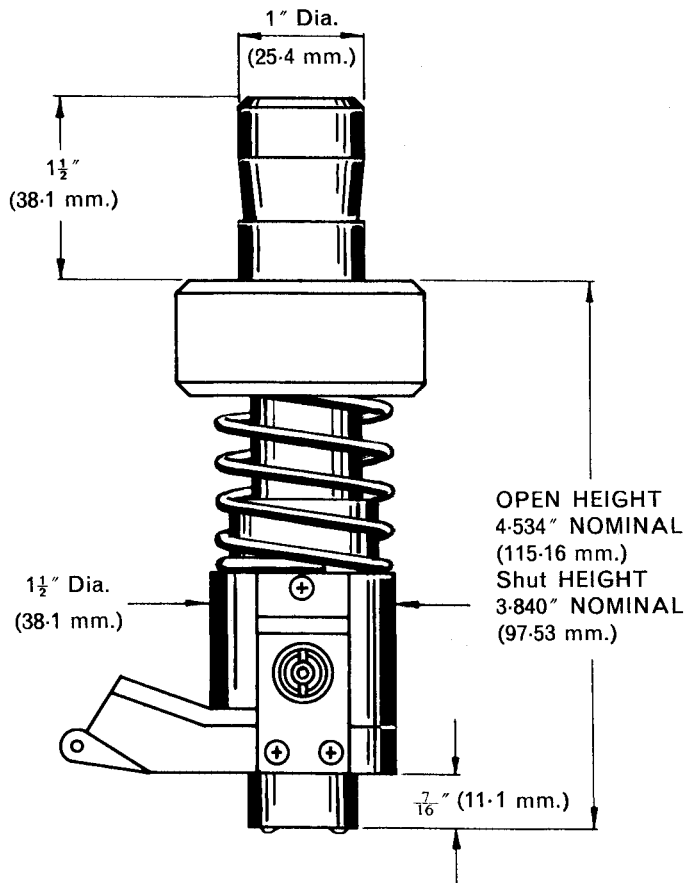
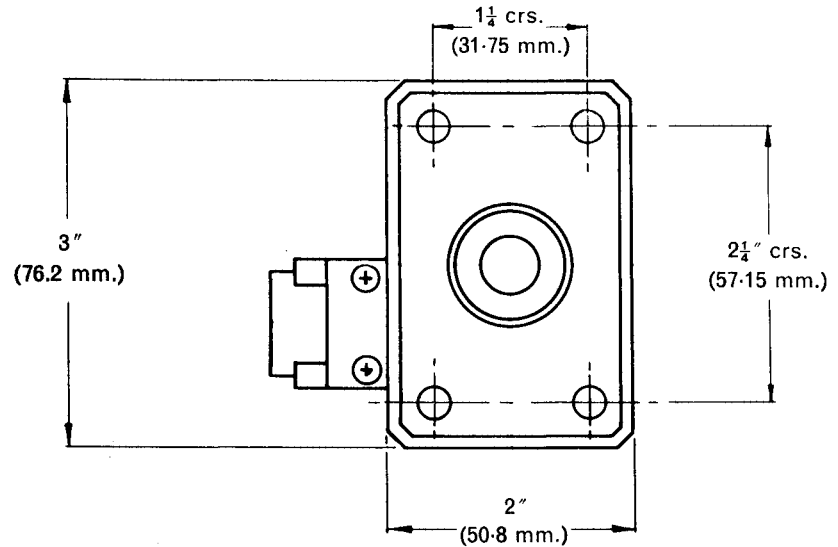
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PRESTIN CERT AUTOMATIC INSERTION SYSTEM

FOR *SPEEDY* INSERTION OF BUSHES INTO STEEL

GENERAL ARRANGEMENT



Tool Number	Bush Shape
T25771/03*	03
T25771/11	11
T25771/12	12
T25771/13	13

* Non-standard dimensions



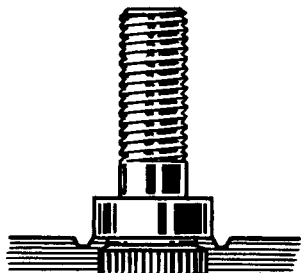
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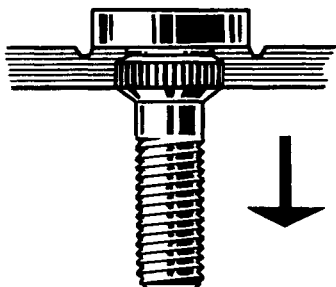
COMPONENTS PUNCHED DIRECTLY INTO SHEET METAL — NO FIXING HOLES REQUIRED

STUDS

TYPE A

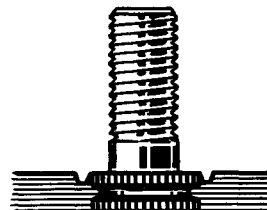


TYPE B



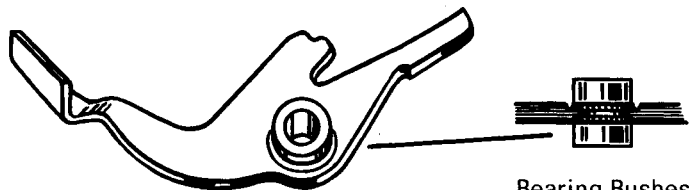
This type does require a pre-pierced hole.

TYPE C



'CUSTOM-MADE' COMPONENTS

Apart from our standard range of threaded bushes, a wide variety of Threaded, Spacer and Bearing Bushes, Pillars, Threaded Studs, etc. are manufactured to meet customers needs.

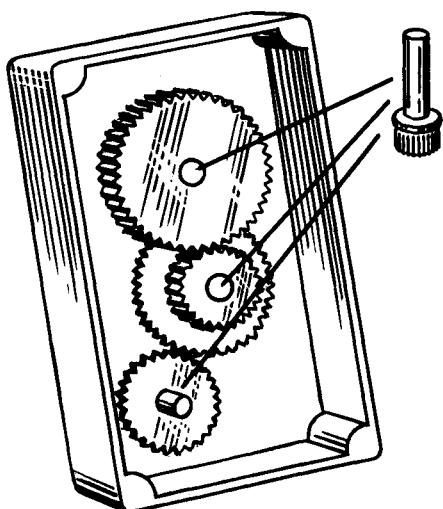


Bearing Bushes



Spacer Bushes

Bearing Studs



Pillars

