

## 824 Plus Machine Specifications and Dimensions:

|                      |                                                                                                    |
|----------------------|----------------------------------------------------------------------------------------------------|
| Force Range          | Adjustable 225 lbs. (1kN) to 16000 lbs. (72kN) - Optional 20000 lbs. (90kN) modification available |
| Throat Depth         | 24" (610mm)                                                                                        |
| Stroke Length        | Adjustable 0 to 8.5" (0 to 220mm)                                                                  |
| Electrical           | 208 to 575V 3 phase - 50 or 60 Hz                                                                  |
| Motor                | 5 HP                                                                                               |
| Oil Tank Reservoir   | 22 gallons (83 liters)                                                                             |
| Speed                | up to 2000 insertions per hour                                                                     |
| Repeatability        | +/- 2% of force setting                                                                            |
| Footprint            | (LxWxh) 59" x 38" x 94" (1499mm x 966mm x 2388mm)                                                  |
| Fastener Range       | .256 to 1/2" (M2 to M12)                                                                           |
| Clinching Capability | 22 gage to 11 gage Steel (1mm to 6mm) combined thickness                                           |

For more information on the 824 Plus and other Haeger products, visit our website at [www.haeger.com](http://www.haeger.com) or contact your authorized Haeger distributor.

Always the most cost effective solution  
for your fastener insertion challenge!



Safe, Dependable, Versatile,  
Affordable ... Haeger !

# 824

PLUS

Fastener  
Insertion  
System



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Creating Hardware Insertion Profit Centers

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## A 824 Plus

8-tons (72kn) ram force and 24 inches (610mm) throat depth with adjustable ram retract position. Reliability and energy efficiency of a fully hydraulic machine. Equipped with Haeger's patented safety system.

## B Positive Stop System

The Positive Stop System provides an easily adjustable method of precisely maintaining the stopping point of the machine cylinder. The system is particularly well suited for improving uniformity on soft, delicate work pieces. It is also effective when inserting small hardware.

In addition to aluminum, the system also provides excellent insertion results on a wide variety of softer materials such as fiberglass, printed circuit boards, and many plastic or composite materials.

## C Crank Assembly

The crank Assembly with Digital Readout for Positive Stop cylinder enables repeat jobs to be setup quickly and accurately.

## D MAS 9 Modular Autofeed System

MAS 9 Modular Autofeed System works with nuts, studs & standoffs sizes 4-40 /M2 through ¼-20 /M6. Maximum stud & standoff lengths up to 30mm



ABFT J-Frame for the difficult to reach flanges



Manual J-Frame for parts with small return flanges



### SHUTTLE TOOLING FOR STUDS AND STANDOFFS

For the 618Plus, 824Plus and 824MSP. Install studs and standoffs into a variety of part configurations including fasteners close to vertical flanges. This tooling allows the operator to see the fastener and speeds insertion.



### BOTTOM FEED TOOLING FOR NUTS

For the 618Plus, 824Plus, 824MSP & 824WT. Automatic insertion of nuts into flat parts as well as into hard to reach holes, such as those on the underside of a flange.



### SHUTTLE NUT TOOLING

For the 618Plus, 824Plus & 824MSP. Ideal for automatic insertion of nuts and short standoffs, especially in applications requiring small profile vacuum tooling.