





Single Piece Handling

Fastener installation with Haeger® 824 One Touch 4e

This cost evaluation is based on actual values obtained during a Haeger® 824 One Touch 4e trial with the machine operated in automatic and manual mode. It was shown that operating in automatic mode is 70% more efficient than inserting the fasteners manually. In the trial 1500 chasis (per month) were installed with 4 different types of PEM® fasteners (31 fasteners per chasis). In automatic mode time and cost savings were: 99 hours and 20 minutes and €3,398 respectively, where a total labour cost of €34.1 per hour* was used as a European average.

FASTENERS	CURRENT MANUAL HAEGER PROCESS	TIME (Seconds)	HAEGER 824OT PROCESS	TIME (Seconds)
 FH-M4-15ZI 14 x per chasis 21,000 installed	Setup	120	Setup & MAS Setup on 1st fastener	310
	Pick up chasis 1st time	11,250	Pick up chasis	11,250
	Manually insert 1st fastener	189,000	Auto Insert 1st fastener	52,500
	Stack chasis 1st time	11,250		
 FH-M5-20ZI 7x per chasis 10,500 installed	Setup	60	MAS Setup on 2nd fastener & tool change	4,050
	Pick up chasis 2nd time	11,250	Auto Insert 2nd fastener	6,250
	Manually insert 2nd fastener	94,500		
	Stack chasis 2nd time	11,250		
 CLSS-M5-1 6x per chasis 9,000 installed	Setup	60	MAS Setup on 3rd fastener & tool change	4,050
	Pick up chasis 3rd time	11,250	Auto Insert 3rd fastener	22,500
	Manually insert 3rd fastener	81,000		
	Stack chasis 3rd time	11,250		
 BSO-3.5M3-16ZI 4x per chasis 6,000 installed	Setup	60	MAS Setup on 4th fastener & tool change	4,050
	Pick up chasis 4th time	11,250	Auto Insert 4th fastener	15,000
	Manually insert 4th fastener	54,000	Stack chasis	11,250
	Stack chasis 4th time	11,250		
Total seconds		508,980	Total seconds	151,210
Total minutes		8,483	Total minutes	2,520
Minutes per chasis		5.66	Minutes per chasis	1.68
Chasis's per hour		10.61	Chasis's per hour	35.71
Total Hours Per Month		141.38	Total Hours Per Month	42.00
Parts / Hour Increase			237%	
Labour cost per chasis		€ 3.22	Labour cost per chasis	€ 0.96

Fast and Easy Tooling Setup on MAS350 and new bowl design incorporating:

1. Tool Change from 3 minutes to 3 seconds.
2. Software automatically sets the proper vibration rate.
3. Reliable feeding, faster changeover with limited training required.
4. Larger and deeper bowl design allows for fastener sizes M1.5 through M10 and fastener lengths up to 30mm all to be fed in the same bowl.
5. New upper tool design allows use for quick change 1 piece tool module.
6. Change in bowl material resulting in fasteners becoming less dirt.

Easier and Faster Programming

The all new intuitive Insertion Logic™ Software with Insertion Graphics® and integrated Statistic Process Control allows for more functionality while reducing programming time. Version 11 Insertion Logic® provides you with the recommended operating time for the part programmed and stores any corrected errors during the insertion process, allowing you to provide this data with your deliveries to your customers.

Best Operator Ergonomics

Operator control pendant can be adjusted in 6 directions, allowing for easy access and the best view of screen instructions while standing up or sitting down.

4 Insertion Stations and 4 Tool Positions

Total of 8 pre-programmed positions provide ability to automatically feed up to 4 different sizes and types of fasteners in one handling.

4 Station Automatic Lower Tool Changer

An integrated cartridge with 4 tooling stations automatically retracts, indexes and positions up to 4 different tools in the lower tool holder.

Fastener Detection

Fastener Length Detection provides full process control.



€3,398
Savings in automatic mode per 1,500 chasis.

70%
Time savings over manual process

30%
Energy Savings compared to conventional hydraulic systems due to New Variable Speed Hydraulics.