



# AZIMUTH

**Clinching  
Presses Models**

**AZIMUTH MACHINERY**

*Punch presses manufacturer since 1975*

**CUSTOM MACHINE FOR YOUR UNIQUE APPLICATION**



*Upon your request, Azimuth  
customize your machine, the  
way you need it !*

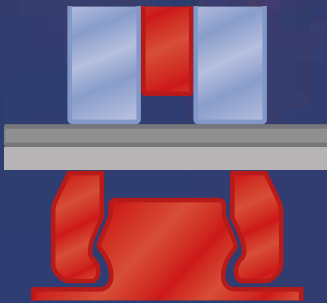


*Send us your sample today for a  
free evaluation & recommendation  
for your application*

# CLINCHING PROCESS

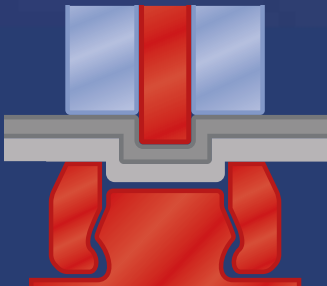
## Advantages

- Vibration-Resistant & Leak proof
- Do not destroy material coating
- Consistent & reliable joint
- May join different thicknesses together
- Long tool life of approximately 300,000 cycles



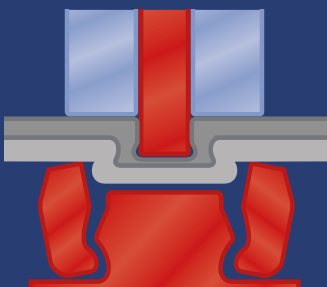
### Step 1 : Clamp

The stripper clamps the sheet metal parts to be joined.



### Step 2 : Draw

The punch draws the sheet metal into the die and the metals expand when they hit the die anvil.



### Step 3 : Lock

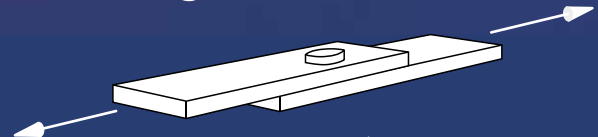
The metals, unable to continue their downward expansion, are compressed against the anvil and are forced to expand laterally, forming an interlock below the bottom sheet. The die blades expand, allowing this interlock to occur.

## Can my material be clinched ?

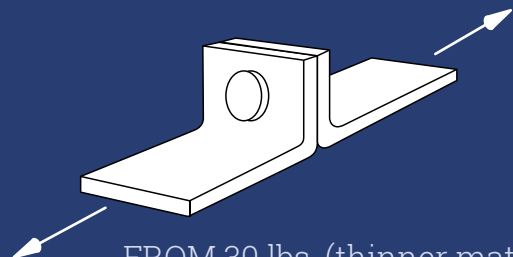
Mild Steel ( galvanized, pre-painted material ) or Aluminum are standard materials.

Stainless steel & multiple layers of material requires optional tooling.

## Shear strenght



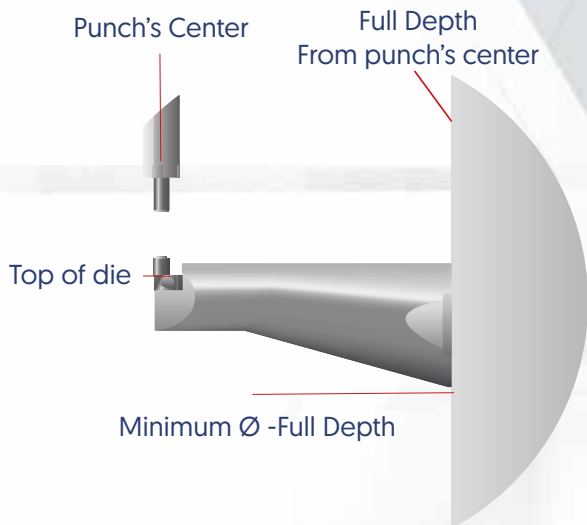
FROM 225 lbs. (thinner material)  
to 600 lbs (thicker material)



FROM 30 lbs. (thinner material)  
to 250 lbs (thicker material)

# CLINCHING PRESS - HORN TYPE

*Azimuth wide variety of clinching presses offer the possibility to cover your whole product range. Commonly used for duct type product.*



## Models

	H412	H612	H618	H624	H632
Full Depth From punch's center	12,25"	12,25"	18,25"	24,25"	32,25"
Minimum Ø -Full Depth	5,5"	5,5"	8,75"	10,25"	12,375"
Minimum Capacity	2 ply of 0,010"	2 ply of 0,010"	2 ply of 0,010"	2 ply of 0,010"	2 ply of 0,010"
Maximum Capacity	2 ply of 0,027"	2 ply of 0,075"	2 ply of 0,075"	2 ply of 0,075"	2 ply of 0,075"
Stroke per minute	250	250	250	250	250

For more specific dimension, download the Technical brochure at [www.azimuthpress.com](http://www.azimuthpress.com)



# CLINCHING PRESS - TABLE TYPE

Commonly known as Channel letter, these machines offer a good versatility to clinch Boxes or flanged products that require depth.



## Models

	CL1830	CL2430
Table depth - from punch's center	12,25"	12,25"
Table Adjustment	0-11"	0-11"
Minimum Capacity	2 ply of 0,010"	2 ply of 0,010"
Maximum Capacity	2 ply of 0,051"	2 ply of 0,051"
Stroke per minutes	250	250

For more specific dimension, download the Technical brochure at [www.azimuthpress.com](http://www.azimuthpress.com)

