



Haeger® 824™ OneTouch™ 5e

Fastener Insertion System Combine Maximum Productivity and Process Control with Ease of Setup

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.

Maximum accessibility around the lower tool allows for parts with tall flanges to fit on the machine.

4 Station Automatic Upper Tool Changer

4 Insertion Stations and 4 Tool positions provide the ability to automatically feed up to 4 different sizes and types of fasteners in one handling. Productivity of 1 insertion every 2.5 seconds, while tools are changed within 3 seconds. Fastener Detection and Fastener Length detection provides FULL process control in every station.

Fast & Easy Tooling Setup on 4 MAS 350 - Modular Autofeed Systems

A unique new drive system in combination with a complete new bowl design incorporating all the latest bowl feeding technologies. A long list of advantages, but what does this mean for you?

- Tool Change from 3 minutes to 3 seconds per MAS 350 through a one piece tool module.
- No more manual bowl setting required. Software automatically sets the proper vibration rate, air eject time and required air pressure to allow for failure free fastener feed. From a full bowl down to the last one out! Reliable Feeding. Faster Changeover. No Training Required.
- Larger bowl design in combination with new drive allows for fastener sizes M1.5 through M10 all to be fed in the same bowl.
- Deeper bowl design in combination with new bowl tooling design allows for fastener lengths up to 30mm all to be fed in the same bowl.
- New upper tool design allows use for quick change 1 piece tool module, resulting in faster and easier tool change.
- Change in bowl material resulting in fasteners becoming less dirty from “air-dust” or individual rubbing.
- Lower mounting position allowing for easier filling and emptying.



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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 12 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.



Operator control pendant can be adjusted in 6 directions.

Specifications

Fastener Range	#2-56 to 1/2" (M2 to M12)
Force Range	Adjustable 800 lbs to 16,000 lbs (3.6-72 kN)
Drive System Type	Hydraulic
Insertions per Hour	Up to 1,400
Control System	Insertion Logic
Auto-Feed	Standard
Batch Counter	Standard
Fastener Database	Standard
Insertion Graphics	Standard
Fastener Length Detection	Standard
Positive Stop	Standard
Screen Size	15"
Robot Ready	Optional
Remote Connection	Standard
Repeatability	+/- 2%
Throat Depth	24" (610 mm)
Stroke Length	0 to 8.5" (0 to 220 mm)
Up Travel %	100% - Return to Shuttle
Electrical Requirements	3 Phase Low 16 A 208-240 V or High 9.6 A 380-480 V
Air Requirements	90 to 100 PSI (6 to 7 BAR) 1/2" (12mm) dia. minimum line flow
Oil Reservoir Capacity	22 gallons (83 liters)
Weight	3,200 lbs (1,452 kg)
Footprint	64"L x 44"W x 99"H (1626 mm x 1118 mm x 2515 mm)



Haeger® 618™ MSP 5e™

Features:

- 6 ton (53kN) ram force and 18 inch (450mm) throat depth with adjustable ram retract position.
- Reliability/energy efficiency of a fully hydraulic machine.
- Haeger's patented safety system.
- Tooling Protection System and Batch Counter.

Positive Stop System (Optional)

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.



Modular
Autofeed
System.

MAS 9 or MAS 350 Modular Autofeed System (Optional)

Customer has the choice to pick either feed system based on which type of auto tooling they want. The maximum stud and standoff lengths are up to 30mm.

Built-in TPS Controls

The Tooling Protection System (TPS) is designed to protect both the tooling and the workpiece from damage.

Tooling rack

Quick and easy access to tooling.

Multi-Shuttle Tooling Platform for Nuts, Studs and Standoffs.

The Multi-Shuttle Platform provides a universal quick and easy tool change over between nuts, studs and standoffs – enabling 2-minute total tool changes without realignment. Changeover between Manual and Automatic Tooling setup is faster and easier.

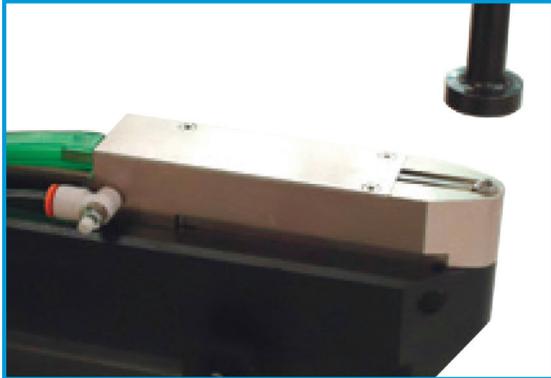


Multi-shuttle tooling platform
for nuts studs and standoffs.



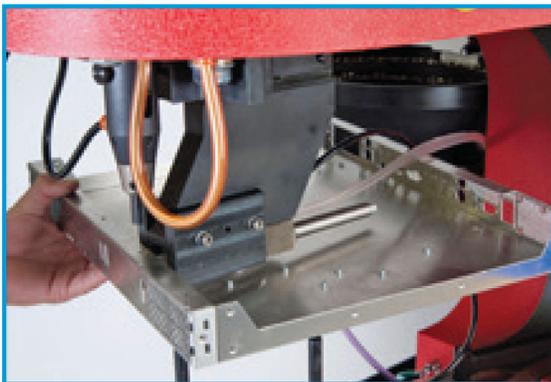
ROBOT COMMUNICATION AVAILABLE

Haeger® 618™ MSP 5e™

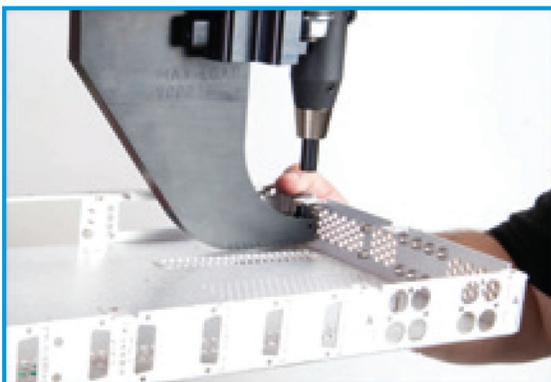


Automatic Bottom

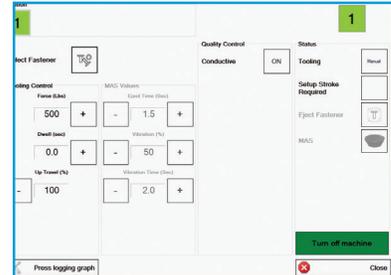
Feed Tooling (ABFT) for inserting nuts into at parts as well as into hard-to-reach holes. Such as those on the underside of a flange.



Automatic Bottom Feed J-Frame is used for those difficult to reach flanges.

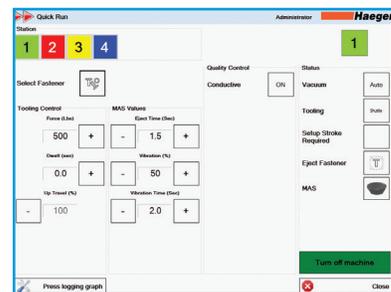


Manual tooling J-Frame is used for small boxes and short reverse flanges.

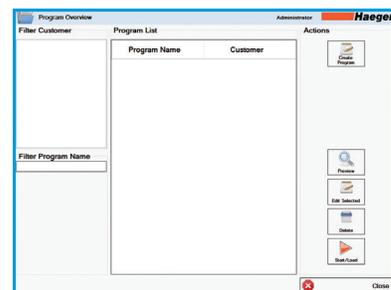


Single Station settings:

Operators can set the Force, Dwell and Up Travel from this single station screen.



Multi-Station: Multi-Station is an option that allows the operator to insert more than one fastener in a program. Each station can be configured to have its own individual Force, Dwell Time and Up Travel.



Programs:

Up to 10,000 programs can be stored and loaded.

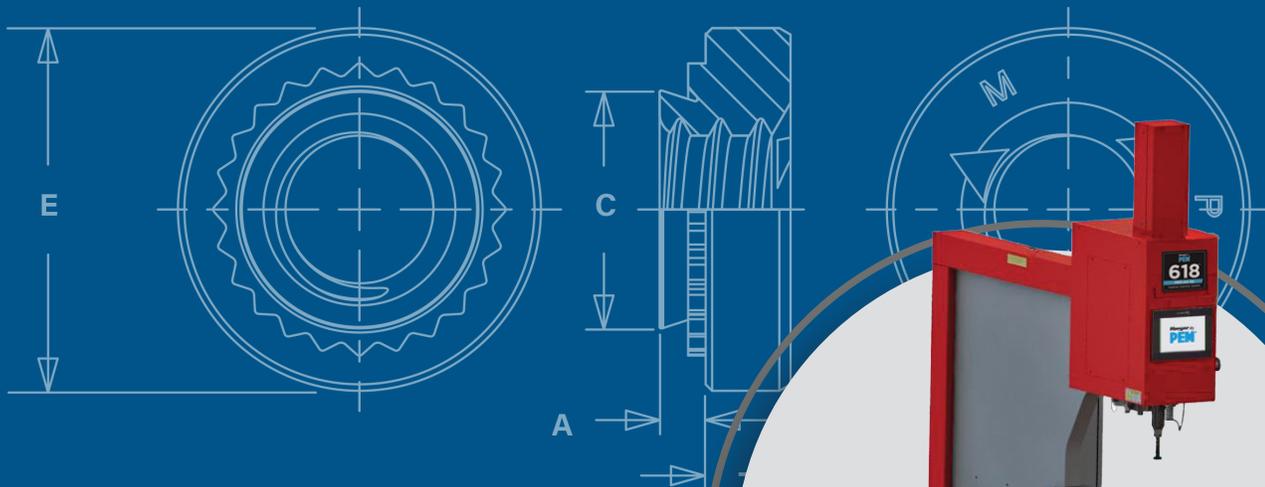


Haeger® 618™ MSP 5e™

Specifications

Fastener Range	#2-56 to 5/16" (M2 to M8)
Force Range	Adjustable 600 lbs to 12,000 lbs (2.6-53 kN)
Drive System Type	Hydraulic
Insertions per Hour	Up to 1,400
Control System	Insertion Logic
Auto-Feed	Optional
Batch Counter	Standard
Fastener Database	Standard
Insertion Graphics	No
Fastener Length Detection	No
Positive Stop	N/A
Screen Size	10"
Robot Ready	Optional
Remote Connection	Standard
Repeatability	+/- 2%
Throat Depth	18" (450 mm)
Stroke Length	0 to 8.0" (0 to 200 mm)
Up Travel %	10-100%
Electrical Requirements	3 Phase Low 9 A 208-240 V or High 3.7 A 380-480 V
Air Requirements	90 to 100 PSI (6 to 7 BAR) 1/2" (12mm) dia. minimum line flow
Oil Reservoir Capacity	10 gallons (39 liters)
Weight	1,600 lbs (726 kg)
Footprint	45"L x 34"W x 84"H (1092 mm x 864 mm x 2134 mm)

HAEGER® 618™ PRO-AA™ FASTENER INSERTION MACHINE



Haeger® 618™ Pro-AA™ Fastener Insertion Machine

Designed for fabricators with simplified needs, featuring quick setup and quiet installation

Features & Benefits

- Features an adjustable arm on the frame that can be moved up or down to adapt to different workpiece.
- 6 tons (53.4 kN) ram force and 18 inches (457 mm) throat depth.
- The new hydraulic system improves the efficiency by 11% compared with the 618™ Plus Insertion Machine.
- Equipped with Haeger® patented safety system.
- PLC control system.
- 7-inch screen operation interface.
- Built-in counter.



Manual tooling J-Frame is used for small boxes and short reverse flanges.

Specifications

Fastener Range	#2-56 to 5/16" (M2 to M8)
Force Range	Adjustable 400 to 12,000 lbs. (1.8 to 53.4 kN)
Drive System Type	Hydraulic
Insertions per Hour	Up to 1,400
Control System	PLC Control
Auto-Feed	N/A
Batch Counter	Standard
Fastener Database	N/A
Insertion Graphics	No
Fastener Length Detection	No
Positive Stop	N/A
Screen Size	7"
Robot Ready	N/A
Remote Connection	N/A
Repeatability	+ - 2%
Throat Depth	18" (450 mm)
Stroke Length	0 to 8.0" (0 to 200 mm)
Up Travel %	10-100%
Electrical Requirements	3 Phase Low 9 A 208-240 V or High 3.7 A 380-480 V
Air Requirements	90 to 100 PSI (6 to 7 BAR) 1/2" (12mm) dia. minimum line flow
Oil Reservoir Capacity	10 gallons (39 liters)
Weight	1,175 lbs (533 kg)
Footprint	51" x 32" x 90" (1295mm x 813mm x 2286mm)



For more information on the 618™ Pro-AA™ and other Haeger® products, visit our website at www.haeger.com or contact your authorized Haeger® distributor.

All HAEGER® products meet our stringent quality standards. If you require additional industry or other specific [quality certifications](#), special procedures and/or part numbers are required. Please contact your local sales office or representative for further information.

Regulatory [compliance information](#) is available in Technical Support section of our website. Specifications subject to change without notice. See our website for the most current version of this bulletin.