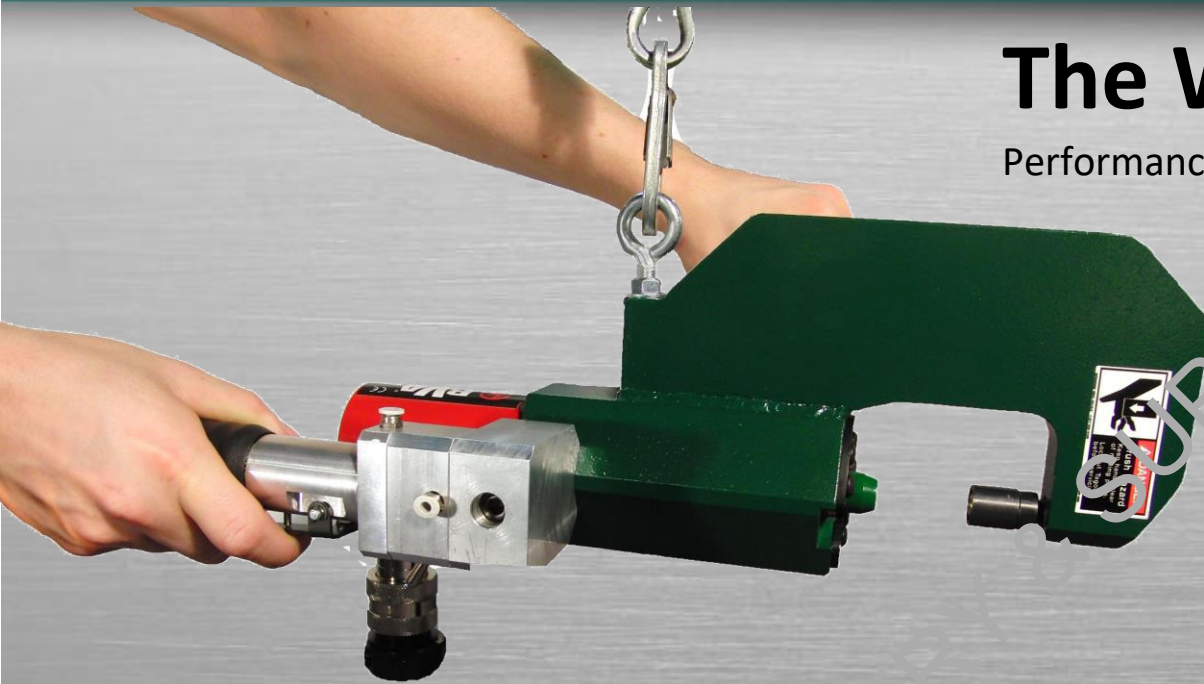


The WATSON

Performance in a small package



The Watson offers all the benefits of clinching in a lightweight version that gives you the portability you need.

- Simple tool adjustments
- Close tooling access
- Air powered
- Easy maintenance
- Fully customizable
- Fasten up to two ply 14ga mild steel, 18 ga stainless steel (with optional tooling)

INNOVATIONS IN ENGINEERING

Medium Duty Watson

Capacity: Medium Duty (0.18" diameter punch)
 MAX: Two ply .075"[1.9mm] mild steel*
 MIN: Two ply .010"[0.25mm] mild steel



Stroke: 1.7" [43mm]
Throat: 1-1/2" [38mm]
Weight: 21 lbs [9.5kg] -hand tool only-
 47 lbs [21kg] -power unit-

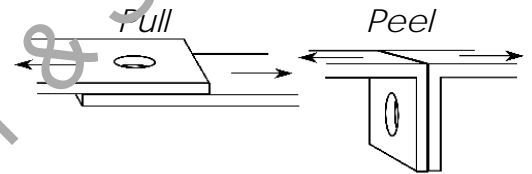
Clinch Joint Strength in Mild Steel

| Material Thickness | Pull (lbs/N) | Peel (lbs/N) | Die Type |
|--------------------|--------------|--------------|----------|
| .075"/1.90mm | 550/2400 | 225/1000 | #50 |
| .060"/1.50mm | 475/2100 | 175/775 | #50 |
| .050"/1.25mm | 430/1900 | 150/665 | #50 |
| .040"/1.00mm | 400/1780 | 120/530 | #40 |
| .030"/0.75mm | 325/1450 | 85/380 | #40 |
| .020"/0.50mm | 225/1250 | 70/310 | #30 |
| .010"/0.25mm | 210/935 | 35/155 | #30 |

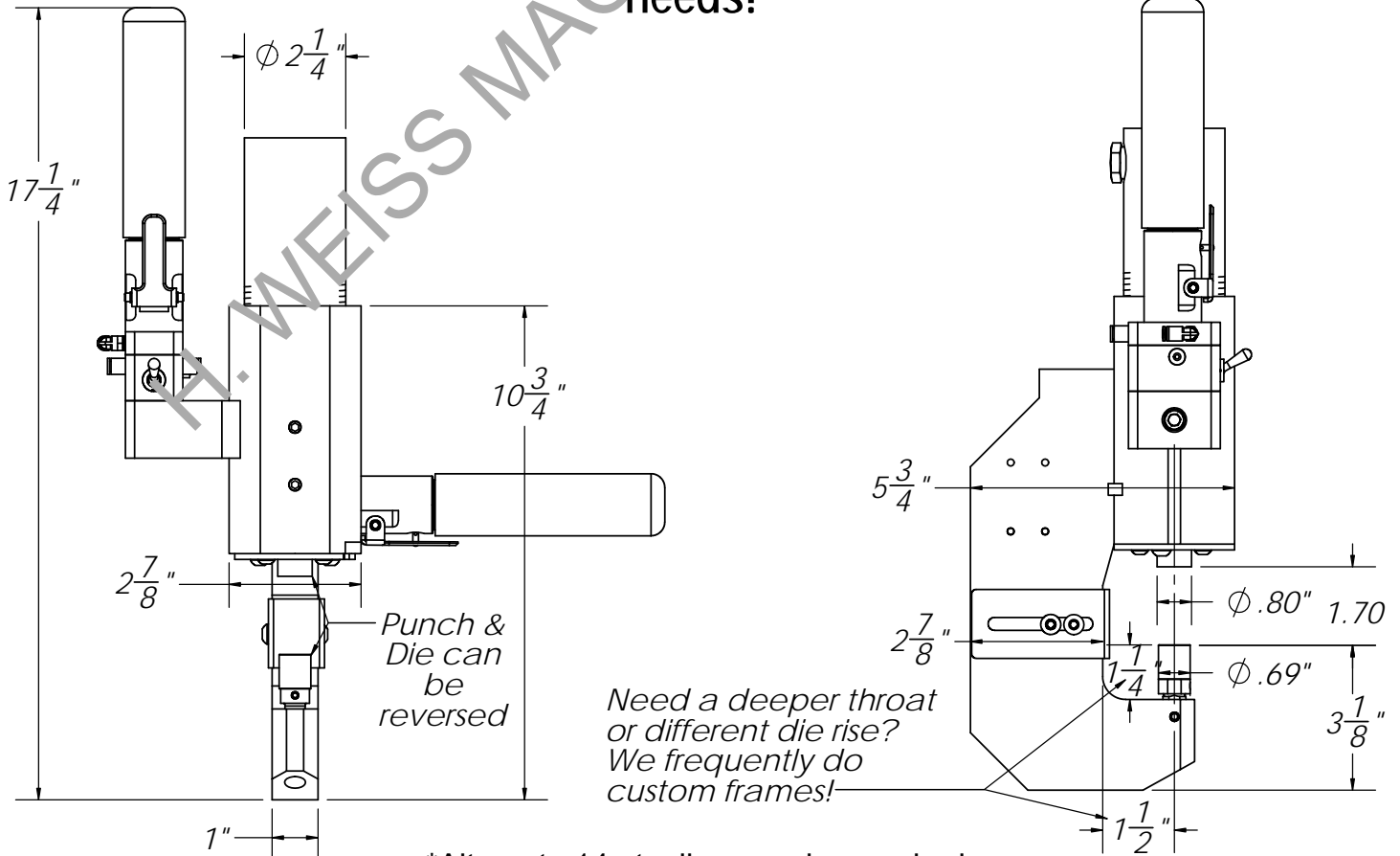
Cycle Speed: 25 CPM (standard speed)
 30-40 CPM (modified stroke)

Air Requirements: 70-90psi [5-6 bar]
 Approx 0.8 cu ft free air per cycle
 5HP @ 40 clinches per minute

- Options:**
- Hanging Gymbal**
 Rotate in the X, Y, or both for machine manipulation
 - Spring Balancer**
 Provides weightless machine motion
 - Mobile Hanging Cart**
 For machine mobility around the shop



Norlok has an extensive selection of Watson designs for getting over large flanges, into narrow openings, and reaching deep into parts. If not already designed, we will design a machine to meet your clinching needs!



*Alternate 14g tooling may be required