**824 OT-4e Machine Specifications and Dimensions:**

- **Force Range**: Adjustable 1000 lbs. (4.46kN) to 16,000 lbs. (72kN) - Optional 20,000 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 1400 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 M10)
- **Clinching Capability**: 22 gage to 11 gage Steel (1mm to 6mm) combined thickness

For more information on the 824 OT-4e 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!**
A. 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.

B. 4 Station Automatic Upper Tool Changer
4 Insertion Stations and 4 Tool positions (total of 8 pre-programmed 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.

C. 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.

D. Integrated Tooling Storage
Easy and transparent storage of Multi-Modules for the MAS-350 Auto Feed System in combination with separate storage for the Shuttle Modules and upper and lower tools. Both storage positions located where you need the tooling, eliminating unnecessary searching and walking around allowing faster and easier tooling changeovers.

E. Easier and Faster Programming
E1: The ALL NEW intuitive Version 11 Insertion Logic TM Software with Insertion Graphics® and integrated Statistic Process Control allows for more functionality while reducing programming time.
E2: V 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.

F. Energy Saving
New Variable Speed Hydraulics reduces energy consumption up to 30% compared to conventional hydraulic systems.

G. 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.