



Passion for Tools



**APPLICATION SOLUTIONS
CONTROL CABINET AND CONTROL ENGINEERING**

THE HISTORY BEHIND THE COVER IMAGE

We started producing our own hole punchers for control cabinet and switch gear construction in Germany more than 40 years ago.

By this stage we had already gathered a lot of experience in the sales of such tools.

Thanks to our closeness to our customers, we have been able to continuously integrate their requirements and suggested improvements into further developments.

This resulted in the production of additional, new products: hydraulic manual punchers for energy-saving actuation of hole punchers, cutting devices for mounting rails, machines and tools for busbar production, stationery punching machines for efficient control cabinet and housing production, and much more.

The starting shot for top quality "Made In Germany" products was actually fired many years ago. Now, many customers worldwide are profiting from the company's history.

An ALFRA Type TriCut® hole puncher has three cutters which means that the possibility of canting during puncher breakthrough can be completely ruled out. The materials and finish have been carefully selected to provide users with the quality and durability that they have come to expect.

Our draw bolts with ball bearing are completely new! The bearing is packed into an aluminium cage in an elaborate production process. The unit is completely protected against dust, dirt and external mechanical influences. The benefits are a minimum of force application and long-wearing tools for optimum cost/usage affect.



The articles named above have been continuously developed over many decades. You will be able to find them in our new catalogue - in a completely up-to-date improved version.

The articles are produced at our production facilities in Hockenheim and Stahnsdorf near Berlin. This is a practical expression of company philosophy, it protects jobs and protects you from defective goods. We don't want to supply you with anything less.

We use this process to set quality standards by which you as a welcome and much appreciated customer can judge us at any time.

ALFRA offers you decades of accumulated know-how in the technology of hole punchers, screw holes, hole crackers etc. Our range of equipment for "hole making" is extremely varied and unique.

MonoCut®, TwinCut®, TriCut® and TriCut+® In addition to FormCut® and FormCut+®, associated with more than 100 years of company history, speak for themselves.



ENERGY AWARENESS BY ALFRA



**Over the last 4 years we have reduced our CO₂ emissions by almost 400 tonnes!
We have produced 600 megawatt-hours of power for our own use!**

Only if you manufacture in-house, can you control and shape the entire manufacturing process.

We have consistently implemented a resource-saving approach to our environment into daily practice in recent years and developed a heightened awareness of "what comes from where" and how to effectively make use of these valuable resources.

With the use of alternative energy, i.e. photovoltaics, we have achieved almost climate-neutral production process in recent years.

And lest we forget: we are, of course, certified according to ISO Standards since 1997!

This means that you can feel good about our tools – not just because they are so technically advanced and are so durable.

But also because the entire production cycle has been carefully designed to ensure that our tools won't leave any traces which could pollute the environment or leave problems for the generations that will follow us.



**MADE IN
GERMANY**



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ALFRA HOLE PUNCHERS® APPLICATION OVERVIEW

	FOR STAINLESS STEEL (VA)			
	FOR SHEET STEEL (S235)			
	 ALFRA HOLE PUNCHERS® MonoCut®	 ALFRA HOLE PUNCHERS® TriCut®	 ALFRA HOLE PUNCHERS® TriCut+®	 ALFRA HOLE PUNCHERS® TwinCut®
Material thickness when using				
Ø 6 mm draw bolt	-	1,5 mm	-	-
Ø 9.5 mm draw bolt	2 mm	2 mm	-	2 mm
Ø 11.1 mm draw bolt	-	-	2 mm	2,5 mm
Ø 19 mm draw bolt	3 mm	3 mm	2,5 mm	3 mm
Diameter	12,7 mm M12 PG7 up to 152 mm	12,7 mm M12 PG7 up to 63,5 mm M63	15,2 mm PG9 up to 63,5 mm M63	12,7 mm M12 PG7 up to 63,5 mm M63
custom-made products	✓	✓	✓	✓
Ø for predrilling				
Ø 6 mm draw bolt	-	6,2 mm	-	-
Ø 9.5 mm draw bolt	11 mm	10 mm	-	10 mm
Ø 11.1 mm draw bolt	-	-	11,5 mm	11,5 mm
Ø 19 mm draw bolt	20,5 mm	19,5 mm	19,5 mm	19,5 mm
Ø 28.3 mm draw bolt	30,5 mm	-	-	-
Machining possibilities using				
wrench or ratchet	✓ Up to Ø 89 mm	✓	✓	✓
Hydraulic drive	✓	✓	✓	✓

BALL BEARING SCREW

- ① High-tensile bolts for the toughest operating conditions
- ② Protrusion of ball bearing outside protective ring ensures perfect force transmission to wrench or punching tool
- ③ Ball bearings encapsulated in aluminium rings
Extremely long-life and perfectly protected against soiling
- ④ UNF fine thread



ALFRA HOLE PUNCHER® MONOCUT®



Hole puncher MonoCut® for sheet steel (S235)

- ① With UNF fine thread
- ② With 4 crosshair markings for simple, central alignment



"The max. material thickness for which a hole puncher can be used always depends on the screw and draw bolts used."

Usable up to a material thickness of:

- 3.0 mm sheet steel with 3/4" (19.0 mm) screw or draw bolt
- 2.0 mm sheet steel with 3/8" (9.5 mm) screw or draw bolt

Hole puncher MonoCut® – sets










All sets are supplied in heavy-duty practical plastic cases.

Ø mm	12.7	15.2	16.2	18.6	19.0	20.4	22.5	25.4	28.3	30.5	31.7	32.5	34.6	37.0	38.0	40.5	43.2	47.0	49.6	50.5	54.0	60.0	61.5	63.5
Ø metric	M12	-	M16	-	-	M20	-	M25	-	-	-	M32	-	-	-	M40	-	-	-	M50	-	-	-	M63
Ø PG	7	9	-	11	-	13	16	-	21	-	-	-	-	29	-	-	-	36	-	-	42	48	-	-
Ø Inch	1/2"	-	-	-	3/4"	-	7/8"	1"	-	1-7/32"	1-1/4"	-	-	-	1-1/2"	-	1-11/16"	-	1-15/16"	-	2-1/8"	-	2-3/8"	2-1/2"
Ø Conduit	0.5	0.598	0.638	0.732	0.748	0.803	0.886	1.0	1.114	1.201	1.248	1.280	1.362	1.457	1.496	1.594	1.701	1.850	1.953	1.988	2.126	2.362	2.421	2.5
Prod.-No.																								
01290			•			•		•				•				•								
01291			•			•		•				•				•				•				•
01298	•	•		•		•	•		•	•				•				•			•	•		
01459							•		•				•				•		•				•	
01463	•				•			•				•			•					•				
01451		•		•		•	•		•															

+ 2 joint screws Ø 9.5 x 50.0 mm, 1 pre-drill HSS Ø 11.0 mm, 1 tube lubricating paste

ALFRA HOLE PUNCHER® MONOCUT®

Ø in mm	Max. Material thickness in mm (S235)	Size Metric	Size PG	Size Inch	Size Conduit & Pipe Size						
						Punchers and dies		matching draw bolt	matching draw bolt	matching draw bolt with ball bearing	
						draw bolt with ball bearing	draw bolt				
Prod.-No.											
12.7	2.0	M 12	7	1/2"	0,500	-	01002	01001	02003	01335	01339
14.3	2.0	-	-	9/16"	0,563	-	01014	01013			
15.2	2.0	-	9	-	0,598	-	01006	01005			
16.0	2.0	-	-	-	0,630	-	01016	01015			
16.2	2.0	M 16	-	-	0,638	-	01010	01009			
17.5	2.0	-	-	11/16"	0,689	-	01018	01017			
18.6	2.0	-	11	-	0,732	-	01022	01021			
19.0	2.0	-	-	3/4"	0,748	-	01026	01025			
20.0	2.0	-	-	-	0,787	-	01030	01029			
20.4	2.0	M 20	13	-	0,803	-	01034	01033			
20.6	2.0	-	-	13/16"	0,811	-	01038	01037			
22.0	2.0	-	-	-	0,866	-	01042	01041			
22.5	2.0	-	16	7/8"	0,886	1/2"	01046	01045			
23.8	2.0	-	-	15/16"	0,937	-	01050	01049			
25.0	2.0	-	-	-	0,984	-	01054	01053			
25.4	2.0	M 25	-	1"	1,000	-	01058	01057			
27.0	2.0	-	-	1-1/16"	1,063	-	01078	01077			
28.3	2.0	-	21	-	1,114	3/4"	01070	01069			
28.3	3.0	-	21	-	1,114	3/4"	01074	01073			
28.6	2.0	-	-	1-1/8"	1,126	-	01080	01079			
30.1	2.0	-	-	-	1,185	-	01086	01085			
30.5	2.0	-	-	1-7/32"	1,201	-	01094	01093			
31.7	2.0	-	-	1-1/4"	1,248	-	01102	01101			
32.5	2.0	M 32	-	-	1,280	-	01106	01105			
33.4	2.0	-	-	1-5/16"	1,315	-	01110	01109			
34.6	3.0	-	-	1-11/32"	1,362	1"	01118	01117			
35.0	2.0	-	-	1-3/8"	1,378	-	01122	01121			
35.0	3.0	-	-	1-3/8"	1,378	-	01126	01125			
37.0	3.0	-	29	-	1,457	-	01130	01129			
38.0	3.0	-	-	1-1/2"	1,496	-	01134	01133			
40.5	3.0	M 40	-	-	1,594	-	01150	01149			
41.3	3.0	-	-	1-5/8"	1,626	-	01154	01153			
42.8	3.0	-	-	-	1,685	-	01158	01157			
43.2	3.0	-	-	1-11/16"	1,701	1 1/4"	01162	01161			
44.5	3.0	-	-	1-3/4"	1,752	-	01164	01163			
47.0	3.0	-	36	-	1,850	-	01166	01165			
47.6	3.0	-	-	1-7/8"	1,874	-	01182	01181			
49.6	3.0	-	-	1-15/16"	1,953	1 1/2"	01170	01169			
50.5	3.0	M 50	-	-	1,988	-	01178	01177			
54.0	3.0	-	42	2-1/8"	2,126	-	01190	01189			
57.2	3.0	-	-	2-1/4"	2,252	-	01194	01193			
60.0	3.0	-	48	-	2,362	-	01202	01201			
61.5	3.0	-	-	2-3/8"	2,421	2"	01206	01205			
63.5	3.0	M 63	-	2-1/2"	2,500	-	01210	01209			
66.7	3.0	-	-	2-5/8"	2,626	-	01214	01213			
above Ø 68.0 mm we recommend the use of hydraulic equipment.											
68.0	3.0	-	-	-	2,677	-	01242	01241			
70.0	3.0	-	-	2-3/4"	2,756	-	01222	01221			
70.6	3.0	-	-	-	2,780	-	01220	01219			
74.0	3.0	-	-	2-7/8"	2,913	2 1/2"	01234	01233			
75.5	3.0	M 75	-	2-7/8"	2,972	-	01226	01225			
76.2	3.0	-	-	3"	3,000	-	01230	01229			
80.0	3.0	-	-	3-1/8"	3,150	-	01238	01237			
82.0	3.0	-	-	-	3,228	-	01246	01245			
Above 89.0 mm, the use of hydraulic equipment is generally required.								Required accessories:			
								draw bolt	special draw bolt	counternut	
89.0	3.0	-	-	3-1/2"	3,504	3"	01251	01252			
92.0	3.0	-	-	3-5/8"	3,622	-	01253	01254			
100.5	3.0	-	-	-	3,957	-	01257	01258			
115.5	3.0	-	-	4-1/2"	4,547	4"	01265	01266			
120.0	3.0	-	-	-	4,724	-	01267	01268			

ALFRA SPLIT HOLE PUNCHER TRICUT®



Split hole puncher TriCut® for sheet steel (S235)

- ① With 3-fold split
- ② With UNF fine thread
- ③ With 4 crosshair markings for simple, central alignment



"The max. material thickness for which a hole puncher can be used always depends on the screw and draw bolts used."

Usable up to a material thickness of:

- 3.0 mm sheet steel with 3/4" (19.0 mm) screw or draw bolt
- 2.0 mm sheet steel with 3/8" (9.5 mm) screw or draw bolt
- 1.5 mm steel sheet with M6 (6.0 mm) screw or draw bolt





Split hole puncher TriCut® - sets



All sets are supplied in heavy-duty practical plastic cases.

Ø mm	12.5	15.2	16.2	18.6	19.0	20.4	22.5	25.4	28.3	30.5	31.7	32.5	34.6	37.0	38.0	40.5	43.2	47.0	49.6	50.5	54.0	60.0	61.5	63.5	
Ø metric	M12	-	M 16	-	-	M 20	-	M 25	-	-	-	M 32	-	-	-	M 40	-	-	-	M 50	-	-	-	M 63	
Ø PG	7	9	-	11	-	13	16	-	21	-	-	-	-	29	-	-	-	36	-	-	42	48	-	-	
Ø Inch	1/2"	-	-	-	3/4"	-	7/8"	1"	-	1-7/32"	1-1/4"	-	-	-	1-1/2"	-	1-11/16"	-	1-15/16"	-	2-1/8"	-	2-3/8"	2-1/2"	
	0.5	0,598	0,638	0,732	0,748	0,803	0,886	1.0	1,114	1,201	1,248	1,280	1,362	1,457	1,496	1,594	1,701	1,850	1,953	1,988	2,126	2,362	2,421	2.5	
Ø Conduit	-	-	-	-	-	-	1/2"	-	3/4"	-	-	-	1"	-	-	-	1 1/4"	-	1 1/2"	-	-	-	-	2"	-
Prod.-No.																									
01762			•			•		•				•				•									
01757			•			•		•				•				•				•				•	
01760							•		•				•				•		•				•		
01761	•				•			•			•				•					•					
01754	•		•			•		•				•				•									
01755	+ 1 ball bearing screw Ø 6.0 x 40.0 mm, 1 ball bearing screw Ø 9.5 x 50.0 mm, 1 ball bearing screw Ø 19.0 x 55.0 mm, 1 pre-drill HSS Ø 10.0 mm, 1 can lubricating paste																								
01755	+ 2 ball bearing screws Ø 9.5 x 50.0 mm, 1 ball bearing screw Ø 19.0 x 55.0 mm, 1 ball bearing screw Ø 19.0 x 75.0 mm, 1 pre-drill HSS Ø 10.0 mm, 1 can lubricating paste																								
01750		•		•		•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	
01751	+ 2 ball bearing screws Ø 9.5 x 50.0 mm, 1 pre-drill HSS Ø 10.0 mm, 1 tube lubricating paste																								
01751		•		•		•	•	•	•	•	•	•	•	•	•	•	•	•	•		•	•			
01751	+ 2 ball bearing screws Ø 9.5 x 50.0 mm, 1 ball bearing screw Ø 19.0 x 55.0 mm, 1 ball bearing screw Ø 19.0 x 75.0 mm, 1 pre-drill HSS Ø 10.0 mm, 1 can lubricating paste																								

ALFRA SPLIT HOLE PUNCHER TRICUT®

Ø in mm	Max. Material thickness in mm (S235)	Size Metric	Size PG	Size Inch	Size Conduit & Pipe Size					
Prod.-No.										
12.5	1.5	M 12	7	1/2"	0,500	-	01674	01770	02022	01334
15.2	2.0	-	9	-	0,598	-	01680	01771	02003	01339
16.2	2.0	M 16	-	-	0,638	-	01683	01772		
18.6	2.0	-	11	-	0,732	-	01686	01773		
20.4	2.0	M 20	13	-	0,803	-	01689	01774		
22.5	2.0	-	16	7/8"	0,886	1/2"	01692	01775		
25.4	2.0	M 25	-	1"	1,000	-	01695	01776		
28.3	2.0	-	21	-	1,114	3/4"	01698	01777		
28.3	3.0	-	21	-	1,114	3/4"	01701	01778	02002	01340
30.5	2.0	-	-	1-7/32"	1,201	-	01703	01779	02003	01339
32.5	3.0	M 32	-	-	1,280	-	01708	01780	02002	01340
34.6	3.0	-	-	1-11/32"	1,362	1"	01711	01788		
37.0	3.0	-	29	-	1,457	-	01713	01781		
40.5	3.0	M 40	-	-	1,594	-	01715	01782		01341
43.2	3.0	-	-	1-11/16"	1,701	1 1/4"	01718	01789		
47.0	3.0	-	36	-	1,850	-	01720	01783		
49.6	3.0	-	-	1-15/16"	1,953	1 1/2"	01723	01790		
50.5	3.0	M 50	-	-	1,988	-	01736	01784		
54.0	3.0	-	42	2-1/8"	2,126	-	01727	01785		
60.0	3.0	-	48	-	2,362	-	01729	01786		
61.5	3.0	-	-	2-3/8"	2,421	2"	01732	01791		
63.5	3.0	M 63	-	2-1/2"	2,500	-	01739	01787		

ALFRA SPLIT HOLE PUNCHER TRICUT+®



Split hole puncher TriCut+® for sheet steel (S235) and stainless steel

- 1 With 3-fold split
- 2 With UNF fine thread
- 3 With 4 crosshair markings for simple, central alignment



"The max. material thickness for which a hole puncher can be used always depends on the screw and draw bolts used."

Usable up to a material thickness of:

- 2.5 mm stainless steel with 3/4" (19.0 mm) screw or draw bolt
- 2.0 mm stainless steel with 7/16" (11.1 mm) screw or draw bolt

Split hole puncher TriCut+® - sets



All sets are supplied in heavy-duty practical plastic cases.

Ø mm	15.2	16.2	18.6	19.0	20.4	22.5	25.4	28.3	30.5	31.7	32.5	34.6	37.0	38.0	40.5	43.2	47.0	49.6	50.5	54.0	60.0	61.5	63.5
Ø metric	-	M 16	-	-	M 20	-	M 25	-	-	-	M 32	-	-	-	M 40	-	-	-	M 50	-	-	-	M 63
Ø PG	9	-	11	-	13	16	-	21	-	-	-	-	29	-	-	-	36	-	-	42	48	-	-
Ø Inch	-	-	-	3/4"	-	7/8"	1"	-	1-7/32"	1-1/4"	-	-	-	1-1/2"	-	1-11/16"	-	1-15/16"	-	2-1/8"	-	2-3/8"	2-1/2"
	0,598	0,638	0,732	0,748	0,803	0,886	1.0	1,114	1,201	1,248	1,280	1,362	1,457	1,496	1,594	1,701	1,850	1,953	1,988	2,126	2,362	2,421	2.5
Ø Conduit	-	-	-	-	-	1/2"	-	3/4"	-	-	-	1"	-	-	-	1 1/4"	-	1 1/2"	-	-	-	2"	-
Prod.-No.																							
01652		•			•		•				•				•								
01653		•			•		•				•				•				•				•
01645						•		•				•				•		•				•	
01646				•			•				•			•					•				

ALFRA SPLIT HOLE PUNCHER TRICUT+®

Ø in mm	Max. Material thickness in mm (VA)	Size Metric	Size PG	Size Inch	Size Conduit & Pipe Size	 Punchers and dies, draw bolt with ball bearing	 Punchers and dies	 matching draw bolt	 matching draw bolt with ball bearing
Prod.-No.									
15.2	2.0	-	9	-	0,598	-	01465	01600	02007
16.2	2.0	M 16	-	-	0,638	-	01466	01656	
18.6	2.0	-	11	-	0,732	-	01467	01603	
20.4	2.0	M 20	13	-	0,803	-	01468	01606	
22.5	2.0	-	16	7/8"	0,886	1/2"	01469	01609	
25.4	2.5	M 25	-	1"	1,000	-	01470	01659	
28.3	2.5	-	21	-	1,114	3/4"	01471	01612	02002
30.5	2.5	-	-	1-7/32"	1,201	-	01472	01615	
32.5	2.5	M 32	-	-	1,280	-	01473	01662	
34.6	2.5	-	-	1-11/32"	1,362	1"	01474	01618	
37.0	2.5	-	29	-	1,457	-	01475	01621	
40.5	2.5	M 40	-	-	1,594	-	01476	01665	
43.2	2.5	-	-	1-11/16"	1,701	1 1/4"	01477	01624	
47.0	2.5	-	36	-	1,850	-	01478	01627	
49.6	2.5	-	-	1-15/16"	1,953	1 1/2"	01479	01630	
50.5	2.5	M 50	-	-	1,988	-	01480	01668	
54.0	2.5	-	42	2-1/8"	2,126	-	01481	01633	01341
60.0	2.5	-	48	-	2,362	-	01482	01636	
61.5	2.5	-	-	2-3/8"	2,421	2"	01483	01640	
63.5	2.5	M 63	-	2-1/2"	2,500	-	01484	01671	

ALFRA SPLIT HOLE PUNCHER TWINCUT®



Split hole puncher TwinCut® for sheet steel (S235) and stainless steel

- 1 With 2-fold split
- 2 With UNF fine thread
- 3 With 4 crosshair markings for simple, central alignment



"The max. material thickness for which a hole puncher can be used always depends on the screw and draw bolts used."

Usable up to a material thickness of:

- 3.0 mm stainless steel with 3/4" (19.0 mm) screw or draw bolt
- 2.5 mm stainless steel with 7/16" (11.1 mm) screw or draw bolt
- 2.0 mm stainless steel with 3/8" (9.5 mm) screw or draw bolt





Split hole puncher TwinCut® - sets



All sets are supplied in heavy-duty practical plastic cases.

Ø mm	12.7	15.2	16.2	18.6	19.0	20.4	22.5	25.4	28.3	30.5	31.7	32.5	34.6	37.0	38.0	40.5	43.2	47.0	49.6	50.5	54.0	60.0	61.5	63.5
Ø metric	M12	-	M 16	-	-	M 20	-	M 25	-	-	-	M 32	-	-	-	M 40	-	-	-	M 50	-	-	-	M 63
Ø PG	7	9	-	11	-	13	16	-	21	-	-	-	-	29	-	-	-	36	-	-	42	48	-	-
Ø Inch	1/2"	-	-	-	3/4"	-	7/8"	1"	-	1-7/32"	1-1/4"	-	-	-	1-1/2"	-	1-11/16"	-	1-15/16"	-	2-1/8"	-	2-3/8"	2-1/2"
	0.5	0,598	0,638	0,732	0,748	0,803	0,886	1.0	1,114	1,201	1,248	1,280	1,362	1,457	1,496	1,594	1,701	1,850	1,953	1,988	2,126	2,362	2,421	2.5
Ø Conduit	-	-	-	-	-	-	1/2"	-	3/4"	-	-	-	1"	-	-	-	1 1/4"	-	1 1/2"	-	-	-	2"	-
Prod.-No.																								
01566																								
01567																								

ALFRA SPLIT HOLE PUNCHER TWINCUT®

Ø in mm	Max. Material thickness in mm (VA)	Size Metric	Size PG	Size Inch	Size Conduit & Pipe Size				
Prod.-No.									
12.7	2.0	M 12	7	1/2"	0,500	01576	01510	02003	01339
15.2	2.0	-	9	-	0,598	01577	01513		
16.2	2.0	M 16	-	-	0,638	01578	01516		
18.6	2.5	-	11	-	0,732	01579	01519		
20.4	2.5	M 20	13	-	0,803	01580	01522	02007	01342
22.5	2.5	-	16	7/8"	0,886	01581	01525		
25.4	2.5	M 25	-	1"	1,000	01582	01528		
28.3	3.0	-	21	-	1,114	01583	01531		
30.5	3.0	-	-	1-7/32"	1,201	01584	01534	02002	01340
32.5	3.0	M 32	-	-	1,280	01585	01537		
34.6	3.0	-	-	1-11/32"	1,362	01586	01561		
37.0	3.0	-	29	-	1,457	01587	01540		
40.5	3.0	M 40	-	-	1,594	01588	01543		01341
43.2	3.0	-	-	1-11/16"	1,701	01589	01562		
47.0	3.0	-	36	-	1,850	01590	01546		
49.6	3.0	-	-	1-15/16"	1,953	01591	01563		
50.5	3.0	M 50	-	-	1,988	01592	01549		
54.0	3.0	-	42	2-1/8"	2,126	01593	01552		
60.0	3.0	-	48	-	2,362	01594	01555		
61.5	3.0	-	-	2-3/8"	2,421	01595	01564		
63.5	3.0	M 63	-	2-1/2"	2,500	01596	01558		

ALFRA HOLE PUNCHER® FORMCUT®



Hole puncher FormCut® for sheet steel (S235)

- 1 with sideways puncher part ejection
- 2 With UNF fine thread
- 3 With 4 crosshair markings for simple, central alignment



 **MADE IN GERMANY**

"The max. material thickness at which a square or rectangular hole puncher (or even special tool) can be used always depends on the draw bolt and the cross-section of the tool (length x width or special shape)."

ALFRA HOLE PUNCHER® FORMCUT®

Size in mm	Max. Material thickness in mm (S235)	For use in	pre-drilling in mm	 incl. 1 - 4	1  draw bolt	2  counternut	3  Ball bearing pressure nut	4  Adapter for hydraulic
		 						

Hole puncher FormCut® - square - for sheet steel (S235)

					Prod.-No.				
12.7 x 12.7	1.75	●	●	10	01300	01348	01355	01352	01353
15.8 x 15.8	1.75	●	●	10	01301				
19.0 x 19.0	2.0	●	●	14	01302	01347	01351		
22.2 x 22.2	2.0	●	●	14	01303				
24.0 x 24.0	2.0	●	●	14	01331	01360	01354	01359	01361
25.4 x 25.4	2.0	●	●	17	01304				
45.5 x 45.5	3.0		●	20	01313	01345	01350		
46.0 x 46.0	3.0		●	20	01305				
50.8 x 50.8	3.0		●	24	01306	01344	01349		
68.0 x 68.0	3.0		●	24	01308				
92.0 x 92.0	3.0		●	30	01309	01343	01356		
125.0 x 125.0	3.0		●	30	01431				
138.0 x 138.0	3.0		●	30	01311				

Size in mm	Max. Material thickness in mm (S235)	Number of poles	For use in	pre-drilling in mm	 incl. 1 - 4	1  draw bolt	2  counternut or bridge	3  Ball bearing pressure nut	4  Adapter for hydraulic
			 						

Hole puncher FormCut® - rectangular - for sheet steel (S235)

					Prod.-No.				
17.0 x 19.0	2.0		●	14	01317	01347	01351	01352	01353
21.8 x 25.8	2.0		●	17	01318				
22.0 x 30.0	2.0		●	17	01319	01360	01418	01359	01361
22.0 x 42.0	2.0		●	17	01320				
25.0 x 50.0	2.0		●	17	01332	01344	01349		
45.0 x 92.0	2.0		●	24	01314				
46.0 x 92.0	2.0		●	24	01329	01343	01358		
68.0 x 138.0	3.0		●	30	01330				

Hole puncher FormCut® - rectangular - for heavy plug connectors (S235) - for sheet steel (S235)

36.0 x 52.0	2.0	6-pole		●	24	01325	01344	01350		
36.0 x 65.0	2.0	10-pole		●	24	01326				
36.0 x 86.0	2.0	16-pole		●	24	01327				
36.0 x 91.0	2.0			●	24	01323				
36.0 x 112.0	2.0	24-pole		●	24	01328	01343	01349		
46.0 x 86.0	2.0			●	24	01322				
46.0 x 112.0	2.0			●	30	01324				

ALFRA HOLE PUNCH® FORMCUT+®



Hole puncher FormCut+® for sheet steel (S235) and stainless steel

- 1 with sideways puncher part ejection
- 2 With UNF fine thread
- 3 With 4 crosshair markings for simple, central alignment



 **MADE IN GERMANY**

"The max. material thickness at which a square or rectangular hole puncher (or even special tool) can be used always depends on the draw bolt and the cross-section of the tool (length x width or special shape)."

ALFRA HOLE PUNCH® FORMCUT+®

Size in mm	Max. Material thickness in mm (VA)	For use in	pre-drilling in mm					
		 		incl. 1 - 4	draw bolt	counternut	Ball bearing pressure nut	Adapter for hydraulic

Hole puncher FormCut+® - square - for stainless steel (VA)

					Prod.-No.				
12.7 x 12.7	1.25	●	●	10	013001	01348	01355	01352	01353
15.8 x 15.8	1.25	●	●	10	013011				
19.0 x 19.0	1.5	●	●	14	013021	01347	01351		
22.2 x 22.2	1.5	●	●	14	013031				
24.0 x 24.0	1.5	●	●	14	013311	01360	01354	01359	01361
25.4 x 25.4	1.5	●	●	17	013041				
45.5 x 45.5	2.0		●	20	013131	01345	01350		
46.0 x 46.0	2.0		●	20	013051				
50.8 x 50.8	2.0		●	24	013061	01344			
68.0 x 68.0	2.0		●	24	013081		01349		
92.0 x 92.0	2.0		●	30	013091	01343			
125.0 x 125.0	2.0		●	30	014311		01356		
138.0 x 138.0	2.0		●	30	013111		01356		

Size in mm	Max. Material thickness in mm (VA)	Number of poles	For use in	pre-drilling in mm					
			 		incl. 1 - 4	draw bolt	counternut or bridge	Ball bearing pressure nut	Adapter for hydraulic

Hole puncher FormCut+® - rectangular - for stainless steel (VA)

					Prod.-No.				
17.0 x 19.0	1.5		●	14	013171	01347		01352	01353
21.8 x 25.8	1.5		●	17	013181		01351		
22.0 x 30.0	1.5		●	17	013191	01360		01359	01361
22.0 x 42.0	1.5		●	17	013201				
25.0 x 50.0	1.5		●	17	013321		01418		
45.0 x 92.0	2.0		●	24	013141	01344	01349		
46.0 x 92.0	2.0		●	24	013291				
68.0 x 138.0	2.0		●	30	013301	01343	01358		

Hole puncher FormCut+® - rectangular - for heavy plug connectors - for stainless steel (VA)

36.0 x 52.0	2.0	6-pole		●	24	013251	01344	01350		
36.0 x 65.0	2.0	10-pole		●	24	013261				
36.0 x 86.0	2.0	16-pole		●	24	013271				
36.0 x 91.0	2.0			●	24	013231		01349		
36.0 x 112.0	2.0	24-pole		●	24	013281	01343	01357		
46.0 x 86.0	2.0			●	24	013221	01344			
46.0 x 112.0	2.0			●	30	013241		01349		

ALFRA HOLE PUNCHER® – SANITARY

- For punching out holes in washbasins

Size mm	Designation	Bolt size mm	Prod.-No.
Ø 28.3	Hole puncher complete	M 10 x 1	01293
Ø 31.7	Hole puncher complete	M 10 x 1	01294
Ø 35.0	Hole puncher complete	M 10 x 1	01295
Ø 37.0	Hole puncher complete	M 10 x 1	01292
	Draw bolt	M 10 x 1	01299



Prod.-No. 01450

Hole puncher set - sanitary

Prod.-No.

01450

In plastic case

Contents: 3 hole punchers 28.3 + 31.7 + 35.0 mm

3 draw bolts M 10.0 x 1

1 ring open-ended wrench 17

ALFRA DUAL HOLE PUNCHERS – SANITARY

- For punching out holes in washbasins

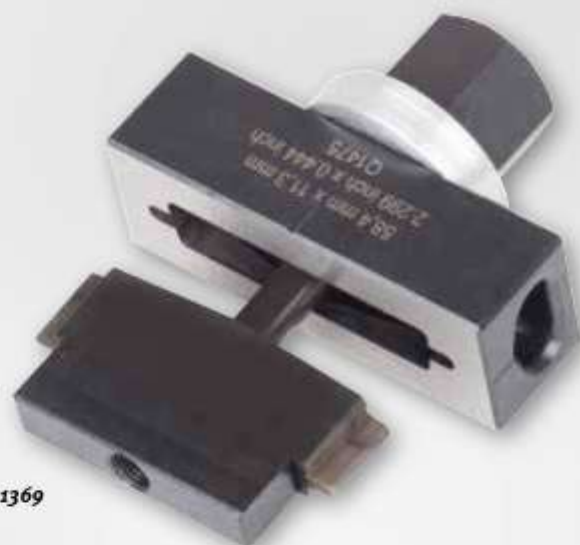
- Spanner actuation size 19 mm

Size mm	Designation	Bolt size mm	Prod.-No.
28 and 32	hole punchers cpl.	10 x 55 special	01456
32 and 35	hole punchers cpl.	10 x 55 special	01460
	Draw bolt	10 x 55 special	01457

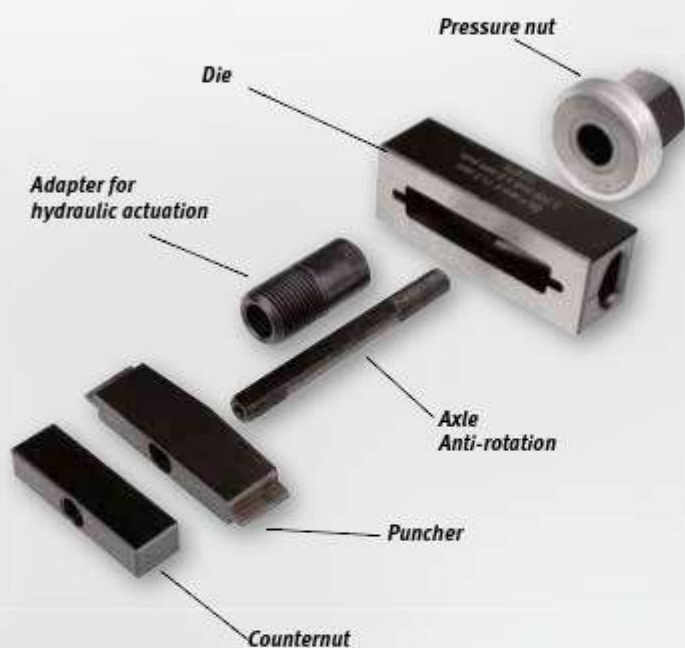


ALFRA HOLE PUNCHER® – SUB-MIN-D

- For "Sub-Min-D" multiple plug connectors - for sheet steel (S235) and stainless steel
- For punching out the cutout for 9-50-pole plug connectors.
Anti-rotation axles for punchers and dies are used as draw bolts.
- All hole punchers are fitted with side ejection for the waste piece. No jamming in the die.
- The hole punchers are supplied in heavy duty, practical plastic cases.



Prod.-No. 01369



Size in mm	Max. Material thickness in mm (S235)/VA	Number of poles	For use in	pre-drilling in mm	incl. 1 - 4	1	2	3	4
			 			draw bolt	counternut or bridge	Ball bearing pressure nut	Adapter for hydraulic





Hole puncher Sub-Mini-D - rectangular

						Prod.-No.			
19.8 x 11.3	2.0/1.5	9-pole	●	●	10	01366	01438	01442	01352
28.2 x 11.3	2.0/1.5	15-pole	●	●	10	01367		01443	
41.9 x 11.3	1.75/1.25	25-pole	●	●	10	01368		01447	
58.4 x 11.3	1.75/1.25	37-pole	●	●	10	01369		01444	
55.7 x 13.9	1.65/1.0	50-pole	●	●	10	01370		01445	
									01353

ALFRA HOLE PUNCHER® – SPECIAL FORMS

- All hole puncher are fitted with side ejection for the waste piece. No jamming in the die.
- The hole puncher are supplied in heavy duty, practical plastic cases.










Size in mm	Max. Material thickness in mm (S235)	For use in		pre- drilling in mm	 incl. 1 - 4	1  draw bolt	2  counternut or bridge	3  Ball bearing pressure nut	4  Adapter for hydraulic
Hole punchers special forms									
					Prod.-No.				
 Ø 22.5 with 3 mm lug	2,0	●	●	14	01420	01333	01351	01352	01353
 Ø 22.5 2-sided flattened to 18.5 mm	2,0	●	●	14	01421	01347			
 Ø 22.5 4-sided flattened to 20.1 mm	2,0	●	●	14	01422				
 33.3 x 17.0 x 10.0 for profile cylinder	2,0	●	●	14	01423	01348	01355		
 Ø 16.3 4-sided flattened to 14.1 mm	1,75	●	●	11	01427				

ALFRA HOLE PUNCHER® CUSTOM-MADE PRODUCTS

- We can make any form of circular, square, rectangular hole puncher to your drawings at short notice.
- Please state whether your enquiry is for manual or hydraulic actuation in addition to the sheet thickness and material number.
- Ask for our technical support.

Hole puncher custom-made products






 Circular	Ø diameter d				Material thickness		Material type		
	mm				mm		Sheet steel (S235)	<input type="checkbox"/>	
							Stainless steel (VA)	<input type="checkbox"/>	
 Circular with lugs	Ø diameter d		Number of lugs	Lug width	Material thickness		Material type		
	mm			mm		mm		Sheet steel (S235)	<input type="checkbox"/>
								Stainless steel (VA)	<input type="checkbox"/>
 Square	Edge length a				Material thickness		Material type		
	mm				mm		Sheet steel (S235)	<input type="checkbox"/>	
							Stainless steel (VA)	<input type="checkbox"/>	
 Rectangle	Width b		Height h		Material thickness		Material type		
	mm		mm		mm		Sheet steel (S235)	<input type="checkbox"/>	
							Stainless steel (VA)	<input type="checkbox"/>	
 Circular flattened on one side	Ø diameter d		Flattened to		Material thickness		Material type		
	mm		mm		mm		Sheet steel (S235)	<input type="checkbox"/>	
							Stainless steel (VA)	<input type="checkbox"/>	
 Circular flattened on two sides	Ø diameter d		Flattened to		Material thickness		Material type		
	mm		mm		mm		Sheet steel (S235)	<input type="checkbox"/>	
							Stainless steel (VA)	<input type="checkbox"/>	
 Square with 4 flattened corners	Edge length a		Corners flattened to		Material thickness		Material type		
	mm		mm		mm		Sheet steel (S235)	<input type="checkbox"/>	
							Stainless steel (VA)	<input type="checkbox"/>	

ALFRA HYDRAULIC MANUAL PUNCHERS



- Up to 680 bar pressure
- Up to 138 x 138 mm square
- Up to 152 mm round
- Only 1.45 kg



	 ALFRA COMPACT®	 ALFRA COMPACTCOMBI®	 ALFRA COMPACT FLEX®	 ALFRA AKKU-COMPACT®	 ALFRA AKKU-COMPACT FLEX®
Page	26 - 27	28 - 29	32	33	30 - 31
Prod.-No.	02001	02050	02065	02070	02082
Punching force	75 kN	75 kN	75 kN	75 kN	75 kN
Hydraulic pressure max.	680 bar	680 bar	680 bar	680 bar	680 bar
Piston stroke	18 mm	18 mm	18 mm	18 mm	18 mm
Tool mounting	19 mm	19 mm	19 mm	19 mm	19 mm
Hydraulic hose length	-	-	600 mm	-	600 mm
Hydraulic medium	HLP32 hydraulic oil	HLP32 hydraulic oil	HLP32 hydraulic oil	HLP32 hydraulic oil	HLP32 hydraulic oil
Weight	1.45 kg	1.75 kg	1.97 kg	3.7 kg with Battery	2.5 kg with Battery

COMPACT® MANUAL PUNCHER STRAIGHT

Compact® manual puncher straight

for use in construction of switch gear and control cabinets - suitable for all hole puncher types
Loading only takes place in the tension direction and makes work considerably easier

- 1 Precisely-matched overpressure valve
- 2 Reinforced handle - soft touch
- 3 Body hard-anodised, stable grip, elegant
- 4 Weighs only 1.45 kg
- 5 High-compression cylinder bore surface
- 6 Lasered production code on rear
- 7 High punching force of 75 kN



COMPACT® MANUAL PUNCHER STRAIGHT SETS



Ø mm	15,2	16,2	18,6	20,4	22,5	25,4	28,3	32,5	37	40,5	47	50,5	54	60	63,5
Ø metric	-	M 16	-	M 20	-	M 25	-	M 32	-	M 40	-	M 50	-	-	M 63
Ø PG	9	-	11	13	16	-	21	-	29	-	36	-	42	48	-
Ø Inch					7/8"	1"							2-1/8"		2-1/2"
	0.598	0.638	0.732	0.803	0.886	1.000	1.114	1.280	1.457	1.594	1.850	1.988	2.126	2.362	2.500

Item no

Set MonoCut® - for sheet steel (S235):

1 Compact® manual puncher straight / MonoCut® punches and dies / 1 draw bolt Ø 19 mm / 1 draw bolt Ø 19 x 9,5 mm / 1 HSS pre-drill Ø 11 mm / 1 spacer sleeve set (3-part)

	02006	•		•	•	•		•		•		•			
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Set TriCut® - for sheet steel (S235):

1 Compact® manual puncher straight / TriCut® punches and dies / 1 draw bolt Ø 19 mm / 1 draw bolt Ø 19 x 9,5 mm / 1 HSS pre-drill Ø 10 mm / 1 spacer sleeve set (3-part)

	01752	•		•	•	•		•		•		•		•	•
	01765		•		•		•		•						
	01758		•		•		•		•		•				•

Set TriCut+® - for sheet steel (S235) and stainless steel sheeting:

1 Compact® manual puncher straight / TriCut® punches and dies / 1 draw bolt Ø 19 mm / 1 draw bolt Ø 19 x 11,1 mm / 1 HSS pre-drill Ø 11,5 mm / 1 spacer sleeve set (3-part)

	01650	•		•	•	•		•		•		•			
	01642		•		•		•		•						
	01654		•		•		•		•		•				•

Set TwinCut® - for sheet steel (S235) and stainless steel sheeting:

1 Compact® manual puncher straight / TwinCut® punches and dies / 1 draw bolt Ø 19 mm / 1 draw bolt Ø 19 x 9,5 mm / 1 draw bolt Ø 19 x 11,1 mm / 1 HSS pre-drill Ø 11,5 mm / 1 spacer sleeve set (3-part)

	01570		•		•		•		•						
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Compact® manual puncher straight:

1 Compact® manual puncher straight / 1 draw bolt Ø 19 mm / 1 draw bolt Ø 19 x 9,5 mm / 1 HSS pre-drill Ø 11 mm / 1 spacer sleeve set (3-part)

	02001	without punches and dies													
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COMPACTCOMBI® MANUAL PUNCHER 90°

CompactCombi® manual puncher 90°

for use in construction of switch gear and control cabinets - suitable for all hole puncher types
Loading only takes place in the tension direction and makes work considerably easier

- 1 Precisely-matched overpressure valve
- 2 Reinforced handle - soft touch
- 3 Body hard-anodised, stable grip, elegant
- 4 Weighs only 1.75 kg
- 5 High-compression cylinder bore surface
- 6 Lasered production code on rear
- 7 High punching force of 75 kN



COMPACTCOMBI® MANUAL PUNCHER 90° SETS



Ø mm	15,2	16,2	18,6	20,4	22,5	25,4	28,3	32,5	37	40,5	47	50,5	54	60	63,5
Ø metric	-	M 16	-	M 20	-	M 25	-	M 32	-	M 40	-	M 50	-	-	M 63
Ø PG	9	-	11	13	16	-	21	-	29	-	36	-	42	48	-
Ø Inch					7/8"	1"							2-1/8"		2-1/2"
	0.598	0.638	0.732	0.803	0.886	1.000	1.114	1.280	1.457	1.594	1.850	1.988	2.126	2.362	2.500

Item no

Set MonoCut® - for sheet steel (S235):

1 CompactCombi® manual puncher 90° / MonoCut® punches and dies / 1 draw bolt Ø 19 mm / 1 draw bolt Ø 19 x 9,5 mm / 1 HSS pre-drill Ø 11 mm / 1 spacer sleeve set (3-part)

	02052	•		•	•	•		•		•		•		•	
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Set TriCut® - for sheet steel (S235):

1 CompactCombi® manual puncher 90° / TriCut® punches and dies / 1 draw bolt Ø 19 mm / 1 draw bolt Ø 19 x 9,5 mm / 1 HSS pre-drill Ø 11 mm / 1 spacer sleeve set (3-part)

	01753	•		•	•	•		•		•		•		•	
	01766		•		•		•		•		•				
	01759		•		•		•		•		•		•		•

Set TriCut+® - for sheet steel (S235) and stainless steel sheeting:

1 CompactCombi® manual puncher 90° / TriCut+® punches and dies / 1 draw bolt Ø 19 mm / 1 draw bolt Ø 19 x 11,1 mm / 1 HSS pre-drill Ø 11,5 mm / 1 spacer sleeve set (3-part)

	01651	•		•	•	•		•		•		•		•	
	01643		•		•		•		•		•				
	01655		•		•		•		•		•		•		•

Set TwinCut® - for sheet steel (S235) and stainless steel sheeting:

1 CompactCombi® manual puncher 90° / TwinCut® punches and dies / 1 draw bolt Ø 19 mm / 1 draw bolt Ø 19 x 9,5 mm / 1 draw bolt Ø 19 x 11,1 mm / 1 HSS pre-drill Ø 11,5 mm / 1 spacer sleeve set (3-part)

	01575		•		•		•		•		•				
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CompactCombi® manual puncher 90°:

1 CompactCombi® manual puncher 90° / 1 draw bolt Ø 19 mm / 1 draw bolt Ø 19 x 9,5 mm / 1 HSS pre-drill Ø 11 mm / 1 spacer sleeve set (3-part)

	02050	without punches and dies.													
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AKKU-COMPACT FLEX®

Akku-Compact Flex®

for use in construction of switch gear and control cabinets - suitable for all hole puncher types

Loading only takes place in the tension direction and makes work considerably easier



- ① Handle inset soft touch
- ② High-pressure hose - flexible, elastic
- ③ USB interface for readable pressure values, service intervals etc....
- ④ Pressure sensor - automatic detection of puncher breakthrough. Once the material has been punched through, the puncher can not damage the die.



AKKU-COMPACT FLEX®

Practical manual hydraulics with 18 V Li-ion battery for punching circular, square and rectangular cutouts in control cabinet and switch gear construction. Extremely easy to handle and light thanks to high-tensile aluminium head.

- Light and easy to handle, only 2.5 kg including battery

Technical data:

Punching

Circular holes:

up to 82 mm Ø

3.0 mm sheet steel (S235)

2.0 mm stainless steel ($F = 600 \text{ N/mm}^2$)

89 - 152 mm Ø only with special traction bolt* and spacer*

2.0 mm sheet steel (S235)

1.5 mm stainless steel ($F = 600 \text{ N/mm}^2$)

Shaped holes:

68 x 68 mm

3.0 mm sheet steel (S235).

2.0 mm stainless steel ($F = 600 \text{ N/mm}^2$)

92 x 92 mm only with special traction bolt* and spacer*

2.0 mm sheet steel (S235)

1.5 mm stainless steel ($F = 600 \text{ N/mm}^2$)

Drive

Max. punching force:

75 kN

Max. hydraulic pressure:

680 bar

Battery

18 V Li-ion / 1.5 Ah

Charging time: 30 mins. after full discharge

Use:

-10° - +40° C

Battery charger

Charges all batteries 18 - 28 V, compatible for NiCD, NiMH and Li-ion batteries.

Automatic temperature monitoring. Battery cell overcharging is prevented by switchover from rapid charging to trickle charging.

The charging state is shown by the LED display.

The PCB is completely enclosed.

Punching capacity with 1.5 Ah battery

195 x Ø 22.5 mm MonoCut® to 2.5 mm S235

165 x Ø 22.5 mm TriCut® to 2.5 mm S235

105 x Ø 63.5 mm MonoCut® to 2.5 mm S235

65 x Ø 63.5 mm TriCut® to 2.5 mm S235

170 x Ø 22.5 mm TwinCut® to 1.5 mm V2A

95 x Ø 63.5 mm TwinCut® to 1.5 mm V2A

Weight

2.5 kg including battery

Scope of delivery:

ALFRA Akku-Compact Flex® manual hydraulics

with 1 battery 18 V, charger 18 - 28 V

Draw bolts - 9.5 x 19 mm - Prod.-No. 02003

Draw bolts - 19 x 120 mm - Prod.-No. 02002

Spacer sleeve set 3-part - Prod.-No. 02004

Pre-drill 11 mm Ø - Prod.-No. 08023

in heavy duty, practical plastic case

Prod.-No.

02082

Spare parts:

Replacement battery

Prod.-No.

02082-01

Battery charger 220 V - 240 V

02082-03

* Special draw bolt for square holes 92 x 92 mm

01395

* Special draw bolt for round holes 89 - 152 mm

01398L

* Special spacer sleeve

01396



Prod.-No. 02082



Prod.-No. 02072



Prod.-No. 02071

COMPACT FLEX® HAND HYDRAULICS

Compact Flex® manual hydraulics

for use in construction of switch gear and control cabinets - suitable for all hole puncher types
Loading only takes place in the tension direction and makes work considerably easier

- 1 Precisely-matched overpressure valve
- 2 Reinforced handle - soft touch
- 3 Body hard-anodised, stable grip, elegant
- 4 Weighs only 2 kg
- 5 High-compression cylinder bore surface
- 6 Lasered production code on rear
- 7 High punching force of 75 kN
- 8 High-pressure hose flexible - elastic



Punching capacity

Punching force:	75 kN
Operating pressure max.:	680 bar
Hydraulic hose length:	600 mm
Weight:	2.0 kg

Scope of delivery:

- 1 Compact Flex® manual hydraulic punch
- 1 draw bolt Ø 19.0
- 1 draw bolt Ø 19.0 x 9.5 mm
- 1 HSS pre-drill Ø 11.0 mm
- 1 spacer sleeve set 3-part

Compact Flex® manual hydraulics
in heavy duty, practical plastic case

Prod.-No.
02065

ALFRA BATTERY COMPACT HYDRAULIC PUNCH

Practical manual hydraulics with 18 V NiMH battery for punching circular, square and rectangular cutouts in control cabinet and switch gear construction. Extremely easy to handle and light thanks to high-tensile aluminium head.

- Light and easy to handle, only 3.7 kg with battery package
- With overpressure valve.
- High-performance drive motor with ergonomically-designed "soft touch" handle
- Battery packages can be pushed in from both sides, therefore weight compensation.

Technical data:

Punching

Circular holes:

up to 82 mm Ø

3.0 mm sheet steel (S235)

2.0 mm stainless steel ($F = 600 \text{ N/mm}^2$)

89 - 152 mm Ø only with special traction bolt* and spacer*

2.0 mm sheet steel (S235)

1.5 mm stainless steel ($F = 600 \text{ N/mm}^2$)

Shaped holes:

68 x 68 mm

3.0 mm sheet steel (S235).

2.0 mm stainless steel ($F = 600 \text{ N/mm}^2$)

92 x 92 mm only with special traction bolt* and spacer*

2.0 mm sheet steel (S235)

1.5 mm stainless steel ($F = 600 \text{ N/mm}^2$)

Drive

Punching force:

75 kN with overpressure valve

Battery

18 V, 3.0 Ah NiMH

Charging time:

45 mins. after full discharge

Charging cycles:

~ 500 under normal conditions

Use:

0° - + 40° C, capacity loss below 0° C

Battery charger

Charges all batteries 18 - 28 V, compatible for NiCD, NiMH and Li-Ion batteries.

Automatic temperature monitoring. Battery cell overcharging is prevented by switchover from rapid charging to trickle charging.

The charging state is shown by the LED display.

The PCB is completely enclosed.

Punching time/Punching capacity

Ø 22.5 mm	2 mm sheet steel (S235)	5 sec.	190 holes/battery
Ø 63.5 mm	2 mm sheet steel (S235)	7 sec.	100 holes/battery
68 x 68 mm	2 mm sheet steel (S235)	7 sec.	70 holes/battery

Weight

3.7 kg with battery

2.7 kg without battery

Weight cpl. 7.8 kg without punching tools

Scope of delivery:

ALFRA Akku-Compact manual hydraulics

with 2 batteries 18 V, charger 18 - 28 V

Draw bolts - 9.5 x 19 mm - Prod.-No. 02003

Draw bolts - 19 x 120 mm - Prod.-No. 02002

Spacer sleeve set 3-part - Prod.-No. 02004

Pre-drill 11 mm Ø - Prod.-No. 08023

in heavy duty, practical plastic case

Prod.-No.

02070

Spare parts:

Replacement battery

Prod.-No.

02071

Battery charger 220 V - 240 V

02072

* Special draw bolt for square holes 92 x 92 mm

01395

* Special draw bolt for round holes 89 - 152 mm

01398L

* Special spacer sleeve

01396



Prod.-No. 02070



Prod.-No. 02072



Prod.-No. 02071

PUMP SUMMARY

Recommended combination ■ ■	AHP-M	AHP-S	DSP-120	LHP 700	FOOT PUMP	ALH 600
Possible combination ■						
Prod.-No.	03855	03854	02027	02140	02121	03190
 Prod.-No. 02012 / 02013	■ *	■ ■	■	■	■ ■	■
 Prod.-No. 03200SET	■ ■	■				
 Prod.-No. 03250	■ ■ *	■	■	■	■	■
 Prod.-No. 03256	■ ■ *	■	■	■	■	■
 Prod.-No. 03258	■ ■ *	■	■	■	■	■
 Prod.-No. 03260	■ ■ *	■	■	■	■	■
 Prod.-No. 03300	■ ■ *	■	■	■	■	■
 Prod.-No. 03360/03380	■ ■ *	■	■		■ ■	■ ■
 AP 250		■				■ ■
 AP 400		■				■ ■

* in combination with optional footswitch/hand switch

ALFRA ELECTRO-HYDRAULIC PUMP AHP S

Technical data:

Max. pressure:	700 bar
Max. flow rate:	0.58 l/min
Oil type:	HLP 32
Filling volume:	3.2 l
Working volume:	2.2 l
Weight:	27 kg
Voltage / frequency:	230 V / 50 Hz
Power:	0.75 kW
Current consumption:	3.26 A
Motor speed:	2,800 rpm



Electro-hydraulic pump AHP S
incl. hand switch
Optional foot switch 2-pedal

Prod.-No.

03854

03866

ALFRA ELECTRO-HYDRAULIC PUMP AHP M



Technical data:

Max. pressure:	700 bar
Max. flow rate:	1.1 l/min
Oil type:	HLP 32
Filling volume:	3.2 l
Working volume:	2.2 l
Weight:	29 kg
Operating voltage:	230 V / 50 Hz
Power:	1.3 kW
Current consumption:	5.65 A
Motor speed:	2,800 rpm

Electro-hydraulic pump AHP M
Optional hand switch for AHP S and AHP M
Optional foot switch 2-pedal

Prod.-No.

03855

03859

03866



Prod.-No. 03859 optional

ALFRA FOOT PUMP

- Max. operating pressure 700 bar
- Fitted pressure limiting valve.
- For all circular, square, rectangular and special shape hole punchers.
- The foot pump leaves both hands free for precise positioning and punching on the control cabinet. The foot pump carrying frame is splayed. This guarantees steady working with no risk of tipping.

Tank volume: 270 cm³
 Usable oil volume: 210 cm³
 Delivery volume: 1.7 cm³ per piston stroke

Contents: 1 hydraulic cylinder with quick coupling
 1 hydraulic hose 2.8 m
 1 draw bolt Ø 19.0 and 19.0 x 9.5 mm
 1 spacer sleeve set 5-part
 1 pre-drill Ø 11.0 mm

Prod.-No.

Set foot pump with hydraulic cylinder and accessories

02120

Foot pump only, with 2.8 m hydraulic hose

02121



Prod.-No. 02120



ALFRA ELECTRO-HYDRAULIC PUMP DSP-120

Compact electro-hydraulic pump, two-stage operation withholding function for single-action hydraulic cylinder.

Technical data

Operating voltage:	230 V/50 Hz
Motor power:	0.4 kW
max. operating pressure:	700 bar
Flow rate 0 - 20 bar:	2.0 l/min
Flow rate 20 - 700 bar:	0.2 l/min
Tank volume:	1.2 l
Usable oil volume:	0.8 l
Weight approx.:	7.5 kg

Electro-hydraulic pump with accessories

Prod.-No.
02025

Contents: 1 hydraulic cylinder SKP-1
1 hydraulic hose 1.8 m
1 draw bolt Ø 19.0 and 19.0 x 9.5 mm
1 spacer sleeve set multi-part
1 pre-drill Ø 11.0 mm
1 hand switch

Electro-hydraulic pump only, 220 V, with 1.8 m
hydraulic hose, quick coupling and hand switch
Foot switch 2-pedal
Hand switch

02027

02029

02030



ALFRA AIR-HYDRAULIC PUMP – LHP 700

Air-hydraulic pump for the operation of single-action hydraulic cylinders for whole punchers, cable cutters, presses or similar applications.

- Heavy-duty tank
- Tank venting filter
- Reduced noise levels
- Oil level indicator on tank
- Precise start-up under load possible
- Precise activation - the drain valve activated by the foot pedal allows precise lowering of the load.
- Hydraulic hose 2.0 m with quick coupling

Technical data

max. operating pressure:	700 bar
(at a feed line pressure of 7 bar)	
Feed pressure/working range:	2.8 - 10 bar
Air connection:	1/4" thread
Flow rate depressurised:	1.0 l/min
Flow rate p max. (with 7 bar air):	0.1 l/min
Tank volume:	2.4 l
Usable oil volume:	2.1 l
Weight:	6.3 kg

Air-hydraulic pump

Prod.-No.
02140



Prod.-No. 02140

ACCESSORY PARTS – DRAW BOLTS, BALL BEARING SCREWS

	Size in inch	Size in mm	Prod.-No.
Draw bolt	-	6.0	02024
Adapter	-	19.0 / 6.0	02023
Draw bolt cpl.	-	19.0 / 6.0	02022
Draw bolt	3/8"	9.5	02009
Adapter	3/4" / 3/8"	19.0 / 9.5	01353
Draw bolt compl.	3/4" / 3/8"	19.0 / 9.5	02003
Draw bolt	3/4" / 3/8"	19.0 / 9.5*	02010
Draw bolt	7/16"	11.1	01424
Adapter	3/4" / 7/16"	19.0 / 11.1	01425
Draw bolt compl.	3/4" / 7/16"	19.0 / 11.1	02007
Draw bolt	3/4" / 7/16"	19.0 / 11.1*	02011
Draw bolt	3/4"	19.0	02002

* draw bolts made of high-alloy tool steel for higher loading

	Ø x l in inch	Ø x l in mm	Prod.-No.
Draw bolt with ball bearing	-	6.0 x 46 mm	01334
Draw bolt with ball bearing	3/8" x 2"	9.5 x 50 mm	01339
Draw bolt with ball bearing	3/4" x 2-3/16"	19.0 x 55 mm	01340
Draw bolt	7/16" x 2-3/8"	11.1 x 60 mm	01442
Draw bolt with ball bearing	3/4" x 2-15/16"	19.0 x 75 mm	01341



Prod.-No. 02003 – complete



Prod.-No. 02007 – complete



Prod.-No. 02002



Prod.-No. 02010



Prod.-No. 02011



- 1 High-tensile bolts for the toughest operating conditions
- 2 Protrusion of ball bearing outside protective ring ensures perfect force transmission to wrench or punching tool
- 3 Ballbearings encapsulated in aluminium rings
Extremely long-life and perfectly protected against soiling
- 4 UNF fine thread



ACCESSORY PARTS - FOR HYDRAULIC PUMPS

		Prod.-No.
Hydraulic hose for foot pump	2.80 m	02122
Hydraulic hose for LHP 700	2.00 m	02112
Hydraulic hose for DSP 120	2.50 m	02026
Hydraulic hose for AHP S and AHP M	2.00 m	02116



Prod.-No. 02112

HYDRAULIC CYLINDERS AND ACCESSORIES

	Prod.-No.
Hydraulic cylinder SKP-1 with quick coupling (up to 11 t)	02012
Weight 2.5 kg	
Hydraulic cylinder SKP-1 Mini with quick coupling (up to 7 t)	02013
Weight 0.86 kg	
Spacer sleeve set 3-part	02004
Spacer sleeve set 5-part	02014
Pre-drill Ø 10.0 mm	08036
Pre-drill Ø 11.0 mm	08023
Pre-drill Ø 11.5 mm	08035
Pre-drill SVB with 5 drill Ø 8.5/11.5/12.5/16.5/21.0 mm	08016



Prod.-No. 02013



Prod.-No. 02014



Prod.-No. 08023



Prod.-No. 08016



Prod.-No. 02012

QUICK-CONNECT COUPLINGS – FOR ALFRA HYDRAULIC EQUIPMENT

- Non-drip coupling and decoupling
- Easy-to-use operability
- Dust protection cap

	Prod.-No.
Connection coupling with internal thread R 1/4" (for fitting to hose end)	01452
Connection coupling with internal thread R 3/8" (for fitting to hose end)	014523/8NPT
Connection nipple with internal thread R 1/4" (for fitting to cylinder)	01453
Adapter R 1/4" external thread	01454



Prod.-No. 01453



Prod.-No. 01452

HYDRAULIC OIL – FOR ALFRA HYDRAULIC PUMPS

	Prod.-No.
1 litre hydraulic oil HLP 46	01455

Caution:
Ensure everything is completely clean when refilling hydraulic equipment!



Prod.-No. 01455

ALFRA – SPECIAL METAL LUBRICATING PASTE

Application areas:

- Prevents seizing up, wear, cold-welding, solidifying and fretting corrosion on threads of screws, nuts, bolts, tube threads and fittings.
- ALFRA special metal lubricating paste is also particularly suitable for the lubrication of cutting points on punching tools and high-loading bearings and sliding surfaces.
- Release-active and silicone-free.
- Contents: 120 g

	Prod.-No.
ALFRA special metal lubricating paste	33005

Completely recommended for the use of hole punchers using wrenches.



Prod.-No. 33005

ALFRA – NOTCHING PLIERS

- Punchers notched grooves in sheet steel up to 2.0 mm thick simply and quickly (S235).
- Saves time-consuming filing of grooves for non-twist securing of pushbuttons, switches and instruments.
- Notched grooves possible in sizes of 3.2 mm and 4.8 mm.
- Replaceable notched groove puncher.
- Easy punching due to large lever arm.
- Plastic-coated handle.
- Weight 1.3 kg.



Prod.-No. 03015

The notched groove puncher is introduced to the pre-punched opening, aligned to the crosshair markings and then the notched groove tongs are actuated.

Your clean groove is finished!

ALFRA notching pliers

Prod.-No.
03015

Spare part

Notch puncher with rivet pin

Prod.-No.
030151



ALFRA CUTTING DEVICES



FOR MOUNTING RAILS

- **Handle: reinforced - soft touch**
- **Limit stop with mm/inch laser-engraved**
- **Burr-free, precise 90° cuts**
- **Lowest-possible cutting play**



ALFRA PROFILE RAIL CUTTING DEVICE® – PSG DUO®



1

- 1 Handle: reinforced - soft touch
- 2 Limit stop with mm/inch laser-engraved
- 3 2 separate profiles for burr-free precise 90° cuts - stable profile guiding
- 4 Profile throughput is optimised for lowest-possible cutting play

2



Prod.-No. 03199

3



4

ALFRA PROFILE RAIL CUTTING DEVICE® – PSG DUO®

For common mounting rails with hand lever operation

Cuts both profile rails TS 35/7.5 + 35/15 mm precisely and without effort

- With guide support for 90°-angle precise cutting
- With reinforced cam located directly above the shear plate
- Lower force application due to improved force transmission
- Maintenance-free
- Cutting to length without waste
- Shear plate re-grindable
- Anodised, laser-engraved longitudinal limit stop 1000 mm with guidance fixture for precise angled cutting to length with millimetre and inch scaling.
- Easy to install on the workbench
- Scale divisions metric and inches



Prod.-No. 03199

ALFRA profile rail cutting device® – PSG Duo®

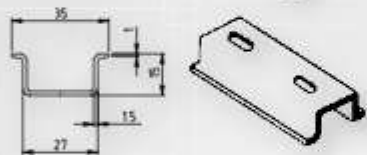
Prod.-No.
03199

Profile rails

Mounting rail
35 mm/7.5
as per EN 60715



Mounting rail
35 mm/15
as per EN 60715



Custom-made products for special profiles such as cable ducting on request!



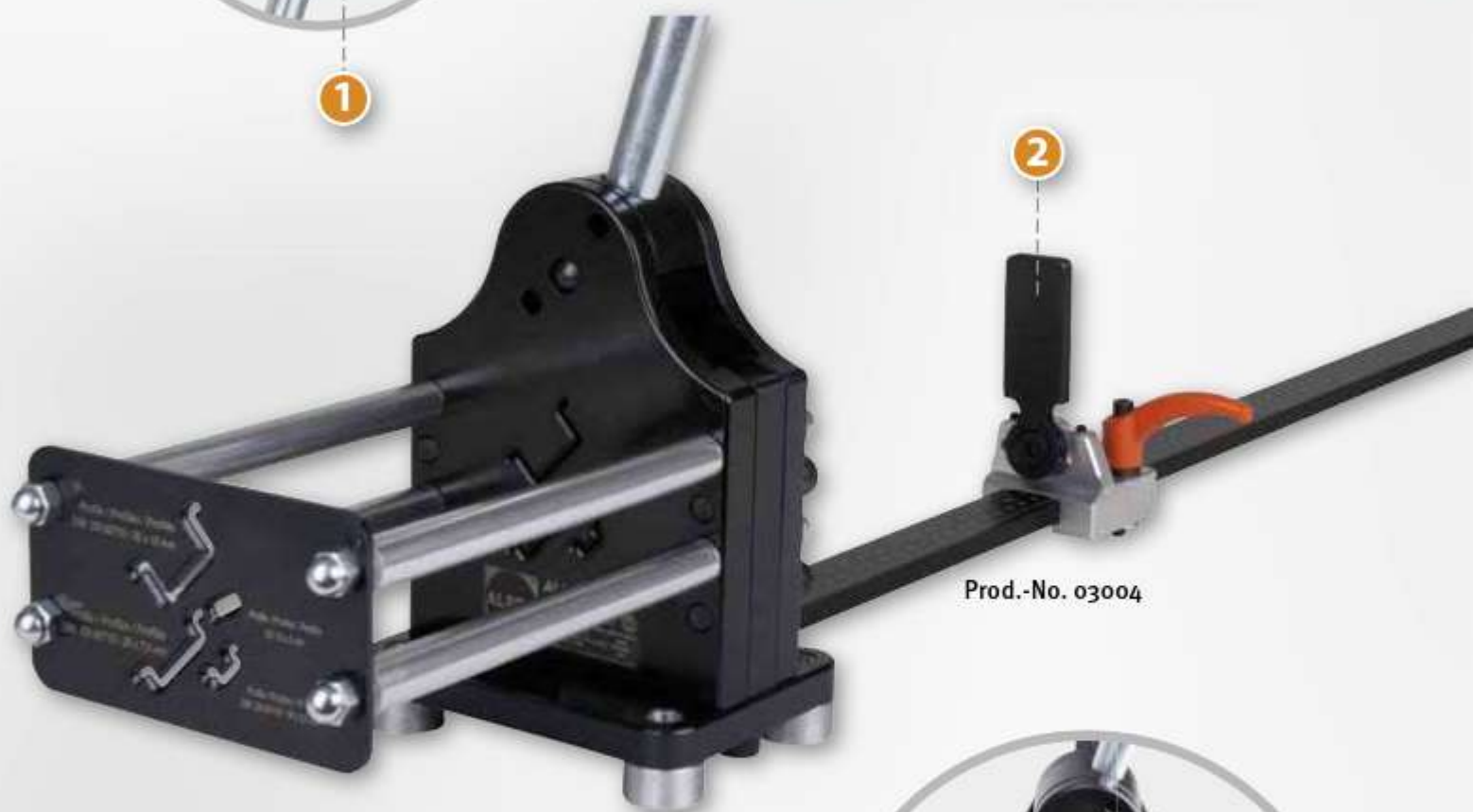
ALFRA PROFILE RAIL CUTTING DEVICE® – PSG 4®



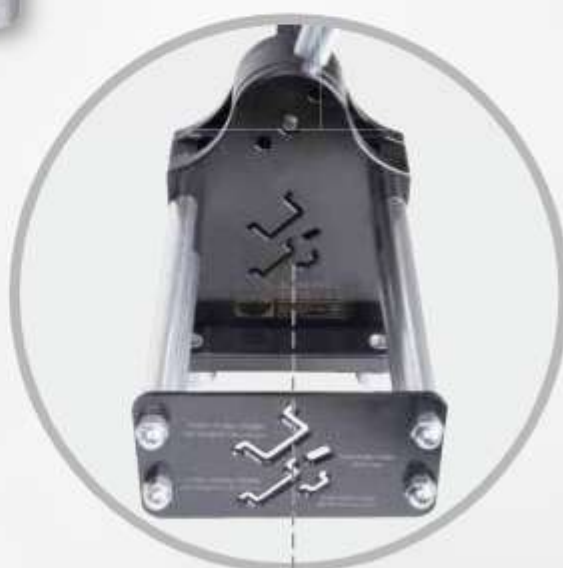
1

- 1 Handle: reinforced - soft touch
- 2 Limit stop with mm/inch laser-engraved
- 3 Profile throughput is optimised for lowest-possible cutting play

2



Prod.-No. 03004



3

ALFRA PROFILE RAIL CUTTING DEVICE® – PSG 4®

For hand-operated mounting rails

Cuts profile and ground rails precisely and without effort.

Standard version for TS 35/7.5 - 35/15 - 15/5.5 - Cu 10.0 x 3.0 mm

- With reinforced cam located directly above the shear plate
- Lower force application due to improved force transmission
- Burr-free cutting to length without waste
- Maintenance-free
- Anodised, laser-engraved length limit stop 1000 mm with guiding device for precise angled cutting to length, with millimetre and inch scaling.
- Shear plate re-grindable
- Guidance fixture for 90° angle-precise cutting
- Easy to install on the workbench
- Custom-made products are also possible (please send us a sample rail of about 1000 mm length).

ALFRA profile rail cutting device® – PSG 4®

Prod.-No.
03004



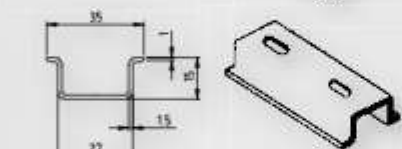
Guidance fixture
for 90° angle-precise cutting

Standard version

Mounting rail
35 mm/7.5
as per EN 60715



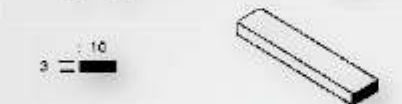
Mounting rail
35 mm/15
as per EN 60715



Mounting rail
15 mm/5.5
as per EN 60715



Copper ground rails
10 mm x 3 mm



Prod.-No. 03004



ALFRA PROFILE RAIL CUTTING DEVICE® – PSG 5+®



1

- 1 Handle: reinforced - soft touch
- 2 Limit stop with mm/inch laser-engraved compatible with PSG series
- 3 Profile throughput is optimised for lowest-possible cutting play



2

Prod.-No. 03001



3

ALFRA PROFILE RAIL CUTTING DEVICE® – PSG 5+®

For mounting rails, for hand lever operation for **cutting to length and hole punching longitudinally and transversely** on the depicted mounting rails.

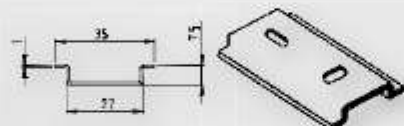
- With reinforced cam located directly above the shear plate
- Lower force application due to improved force transmission
- Burr-free cutting to length without waste
- Maintenance-free
- Anodised, laser-engraved length limit stop 1000 mm with guiding device for precise angled cutting to length, with millimetre and inch scaling.
- Shear plate can be re-ground, puncher replaceable
- Custom-made products are also possible (please send us a sample rail of about 1000 mm length).

Scope of delivery standard version

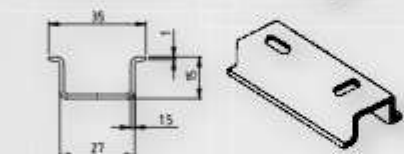
with transverse and longitudinal hole puncher 12 x 6.4 mm, 1000 mm length limit stop and guidance fixture incl. C-profile 3415	Prod.-No. 03001
with transverse and longitudinal hole puncher 12 x 6.4 mm, 1000 mm length limit stop and guidance fixture incl. G-profile as per EN 60715	03001G
as 03001, however with round hole puncher Ø 5.5 or 6.0 mm	03002
as 03001, however with hydraulic cylinder	03003

Standard version

Mounting rail
35mm/7.5
as per EN 60715



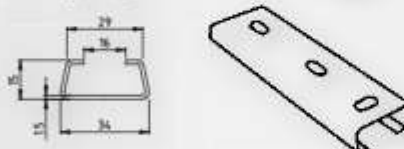
Mounting rail
35 mm/15
as per EN 60715



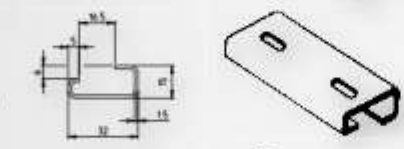
Mounting rail
15 mm/5.5
as per EN 60715



C-profile 3415
(included in Prod.-No. 03001)



G-profile
as per EN 60715
(included in Prod.-No. 03001G)



Copper ground rails
10 mm x 3 mm



Spare parts for universal cutting and punching device

Spare puncher + die 12 x 6.4 mm f. longitudinal hole	Prod.-No. 03005
Spare puncher + die 12 x 6.4 mm f. transverse hole	03006
Spare puncher + die 5.5 mm f. round hole	03007
Spare puncher + 6.0 mm f. round hole	03008
Special versions for mounting rails or flat rails, also in stainless steel or aluminium or plastic on request	03011



Prod.-No. 03001

Tool for fixing holes (longitudinal and transverse) integrated. Guidance fixture for 90° angle-precise cutting



Prod.-No. 03003

We recommend our pump type AHP 5 (Prod.-No. 03854) as a drive

ALFRA CABLE DUCTING CUTTING DEVICE – VKS 125



ALFRA CABLE DUCT CUTTING DEVICE – VKS 125

ALFRA cable duct cutting device – VKS 125

Cuts cable ducting and covers up to 125 mm wide in seconds precisely and without effort. Fixing tabs for easy fitting to the Workbench are attached to the device and to the longitudinal limit stop.

The VKS 125 is fitted with a sprung cutter protector which covers the cutter when it is not being used.

- Burr-free cutting to length without waste
- 90° angle-precise cutting
- Maintenance-free
- Easy to install on the workbench

"... no more plastic swarf and no more deburring!"

ALFRA VKS 125
Cutter for VKS 125

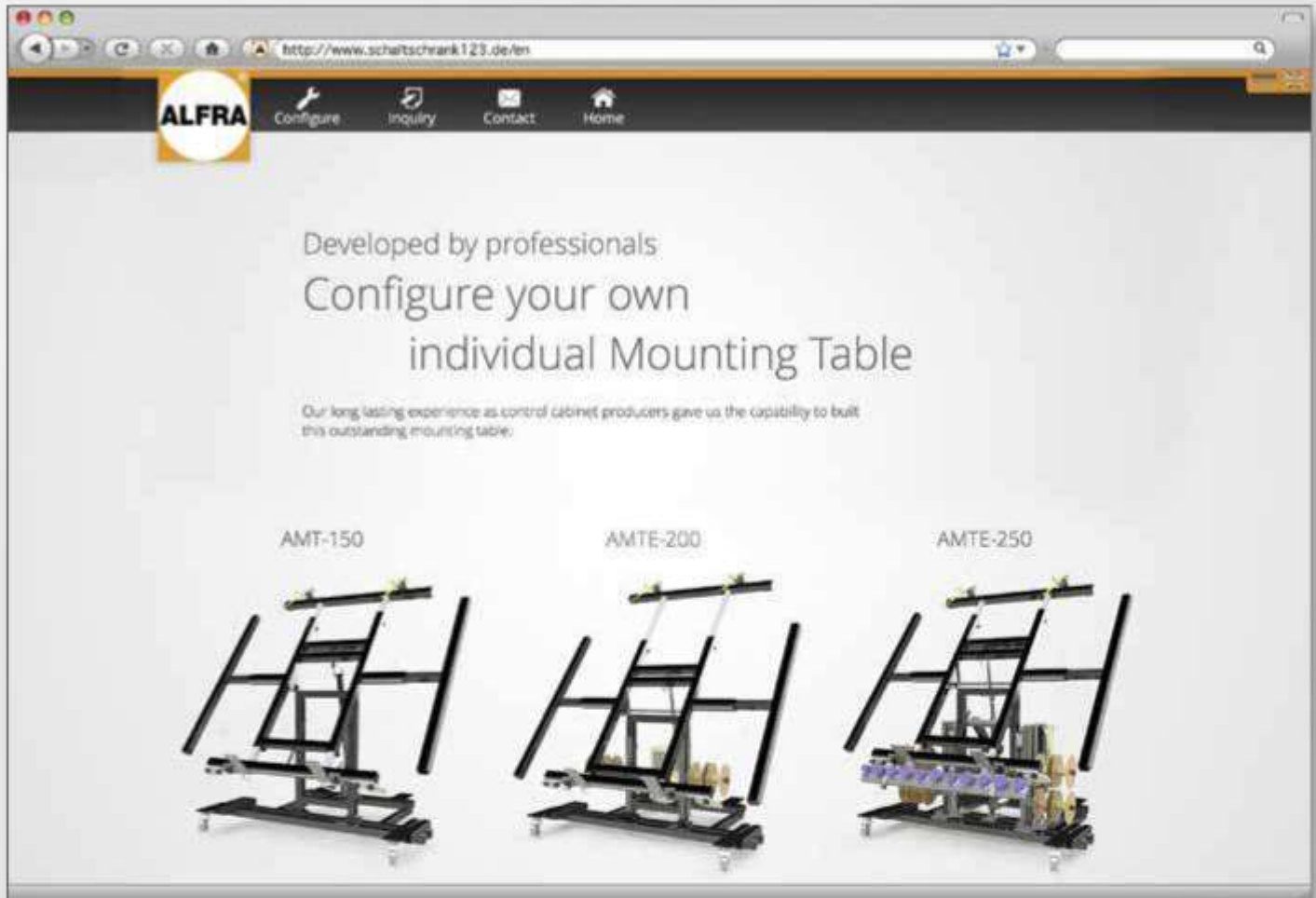
Prod.-No.
031920
03192



ALFRA ASSEMBLY TABLE



Simply put together your desired assembly table with its accessories on our website and then request a quotation by clicking:
www.schaltschrank123.de/en



ALFRA ASSEMBLY TABLE AMT150



AMT 150

Prod.-No.	03100
Simple, variable fixing of mounting panels using quick-action clamp.	✓
Intelligent release system enables unrestricted processing of the entire mounting panel	✓
Infinitely variable adjustment from vertical to horizontal	using handcrank or battery drill
Infinitely variable height adjustment	via angle of inclination
Electric motor	-
Battery-operated	-
Adjustable angle of inclination	0 - 80°
Working height	fixed: 100 cm
4 guide rollers with total fixing	✓
Max. size mounting panels W x H	1,100 x 1,900 mm
Max. useful load	200 kg
Space requirement	1,400 x 1,200 mm
Weight	83 kg
Scope of delivery	Assembly table AMT 150 2 x clamping unit with bolt 2 x clamping unit with quick lock Screw adapter for operating with battery drill

OPTIONS FOR ALL AMTs



EXTENSION SET
Table width extension for horizontal support of mounting panels
Prod.-No. 03100-001



CLAMPING UNIT WITH QUICK LOCK
Prod.-No. 03100-003



CLAMPING UNIT WITH BOLT
Prod.-No. 03100-002

OPTION FOR AMT 150

SCREW ADAPTER AMT 150
for operation with battery drill
Prod.-No. 03100-004

ALFRA ELECTRIC ASSEMBLY TABLE AMTE 200 / AMTE 250

		
AMTE 200	AMTE 250	
031002	031001	
✓	✓	
✓	✓	
using battery-operated electric motors	using battery-operated electric motors	
by angle of inclination using battery-operated electric motors	using battery-operated electric motors	
✓	✓	
✓	✓	
0 - 80°	0 - 80°	
fixed: 90 cm	variable: 80 - 110 cm	
✓	✓	
1,100 x 1,900 mm	1,100 x 1,900 mm	
200 kg	300 kg	
1,400 x 1,200 mm	1,400 x 1,200 mm	
93 kg	140 kg	
Electric assembly table AMTE 200 2 x clamping unit with bolt 2 x clamping unit with quick lock external charging station for the battery	Electric assembly table AMTE 250 2 x clamping unit with bolt 2 x clamping unit with quick lock external charging station for the battery	
OPTIONS FOR ALL AMTs	OPTIONS FOR AMTE 200 / 250	OPTION FOR AMTE 250
 CONTROL CABINET SET Prod.-No. 03100-005	 CABLE GUIDANCE Prod.-No. 031001-003  CABLE ROLL HOLDER Prod.-No. 031001-002	 ROLLER CONVEYOR for sideways insertion of the mounting panel into the control cabinet Prod.-No. 031001-004
OPTIONS FOR AMTE 200 / 250		
SPARE BATTERY Prod.-No. 031001-001		CHARGING PLUG for 110 V 60 Hz Prod.-No. 031001-0011

ALFRA BUSBAR MACHINING

Prod.-No. 03855



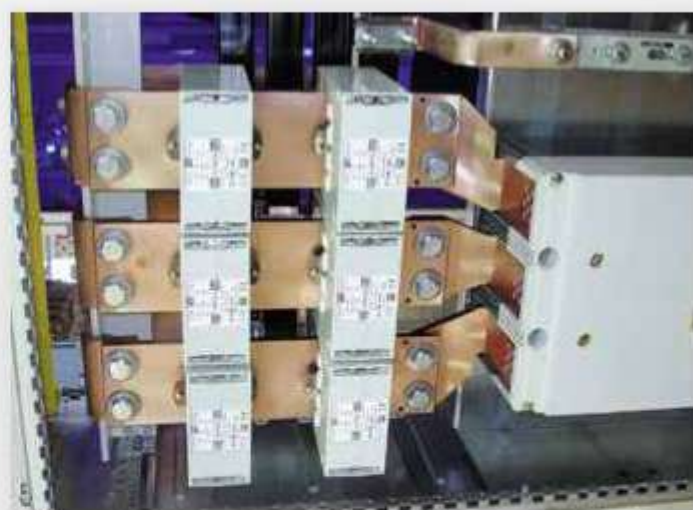
Prod.-No. 03200



Prod.-No. 03201



Prod.-No. 03202



ALFRA BUSBAR BENDING AND HOLE PUNCHING DEVICE

Busbars at 120 x 12 mm (160 x 10 mm on request) can easily be bent using a universal working cylinder, and holes of Ø 6.6 up to 21.5 mm including longitudinal holes can be punched through the simple insertion of hole punchers

Bending busbars

Turn switch to "bend".

To bend busbars, the bending die is inserted in the hydraulic piston and the electric angle measurer is placed in the round guidance crew on the counter block. The contact cable is connected to the electric motor.

The required angle is fixed on the angle scale using an adjusting screw. Since copper springs back, we recommend making a setting 1° - 3° above the required angle depending on the material thickness.

You should check the first bending angle. This bending angle can be reproduced as often as required since the bending process is automatically interrupted on achieving the angle by the electrical contact switch.

Perforating busbars

Switch setting to "perforate".

The puncher with the neoprene scraper and the matching die are placed in the locating hole.

The puncher is fixed sideways using a grub screw. Depending on the busbar width and the required hole arrangement, the processing block can be infinitely variably raised or lowered hydraulically using the handwheel. A counter attached to the handwheel shows the height of the hole centre in millimetres.

We recommend centre-punching the busbar and then aligning the puncher centring point above the centre puncher to guarantee a precise hole location.

The neoprene scraper and a fitted electronic sensor ensure automatic puncher retraction.

Technical data:

Bending

Bending Cu max:	120 x 12 mm
Bending up to:	more than 90°
smallest leg length:	50 mm
smallest U-bend:	100 mm
smallest Z-bend:	72 mm (depending on material thickness)
The values stated are based on copper rails 120 x 10 mm	

Punching

Punching Cu:	6.6 - 21.5 mm
	also longitudinal hole up to max. L = 21 mm
Material thickness Cu max:	12 mm
Material width up to:	110 mm central
External dimensions L x W x H:	700 x 410 x 410 mm
Weight:	60 kg

Special version for processing of busbars up to 160 x 10 mm available on request.



ALFRA BUSBAR BENDING AND HOLE PUNCHING DEVICE

	Prod.-No.
ALFRA busbar bending and hole punching device with electrical angle measurer R10, bending die R10 and length limit stop	03200SET
Electrical angle measurer R10	03201
Bending die R10	03202
Length limit stop	03203
Bending die with movable jaws (120 x 10 mm Cu)	03228
Digital angle measurer	03229
Stage bending tool with 2 pairs of pressure plates for 5 and 10 mm stages (max. range: 100 x 5 mm / 60 x 10 mm Cu)	03246



Prod.-No. 03200SET

Electro-hydraulic pump AHP M

Technical data:

Max. pressure:	700 bar
Max. flow rate:	1.1 l/min
Oil type:	HLP 32
Filling volume:	3.2 l
Working volume:	2.2 l
Weight:	29 kg
Operating voltage:	230 V / 50 Hz
Power:	1.3 kW
Current consumption:	5.65 A
Motor speed:	2800 rpm

	Prod.-No.
Electro-hydraulic pump AHP M	03855
Optional hand switch for AHP S and AHP M	03859
Optional foot switch 2-pedal	03863



Prod.-No. 03229

Freely-programmable digital angle measurer
Can be used for devices
Prod.-No. 03200 and 03980



Prod.-No. 03201



Prod.-No. 03228



Prod.-No. 03202

Electro-hydraulic pump AHP S

Technical data:

Max. pressure:	700 bar
Max. flow rate:	0.58 l/min
Oil type:	HLP 32
Filling volume:	3.2 l
Working volume:	2.2 l
Weight:	27 kg
Voltage / frequency:	230 V / 50 Hz
Power:	0.75 kW
Current consumption:	3.26 A
Motor speed:	2800 rpm

	Prod.-No.
Electro-hydraulic pump AHP S	03854
incl. hand switch	03855
Optional foot switch 2-pedal	03866



Prod.-No. 03855



Prod.-No. 03854

ALFRA BUSBAR BENDING AND HOLE PUNCHING DEVICE

ALFRA busbar set 1:

Prod.-No.
03911

- Prod.-No. 03200SET
ALFRA busbar bending and hole punching device with electrical angle measurer R10, bending die R10 and length limit stop
- Prod.-No. 03855
electro-hydraulic pump **AHP M**



Prod.-No. 03911

ALFRA busbar set 2:

Prod.-No.
03921

- Prod.-No. 03200SET
ALFRA busbar bending and hole punching device with electrical angle measurer R10, bending die R10 and length limit stop
- Prod.-No. 03854
electro-hydraulic pump **AHP S**



Accessories

Available punches and dies

Puncher Ø in mm	Metric Screw connection	Max. Material thickness in mm	Prod.-No.
6.6	6.0	5.0	03204
9.0	8.0	6.0	03205
9.5	8.0	6.0	03206
11.0	10.0	12.0	03207
11.5	10.0	12.0	03208
13.5	12.0	12.0	03209
14.0	12.0	12.0	03210
17.5	16.0	12.0	03211
18.0	16.0	12.0	03212
21.0	20.0	12.0	03213
21.5	20.0	12.0	03214



Prod.-No. 03921

Die ØMax. in mm	Material thickness in mm	Prod.-No.
6.6	5.0	03230
9.0	6.0	03231
9.5	6.0	03232
11.0	12.0	03233
11.5	12.0	03234
13.5	12.0	03235
14.0	12.0	03236
17.5	12.0	03237
18.0	12.0	03238
21.0	12.0	03239
21.5	12.0	03240

Punchers and dies for longitudinal holes up to max. L x W = 21 x 18 mm Prod.-No.
03241



longitudinal hole puncher and dies

Round puncher and dies

ALFRA BUSBAR CUTTING DEVICE – S 125

**For clean, burr-free cutting of copper busbars
125 x 12 mm.**

- Ideal supplementary device for busbar bending and hole punching device.
- Cutting time with electro-hydraulic pump depending on rail width 5 - 15 sec.
- Hold-down device and guidance fixture for central, precise cutting.
- Top cutter replaceable and resharpenable.
- Weight: 16 kg

ALFRA busbar cutting device – S 125	Prod.-No. 03250
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Replacement top cutter	03251
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With use of electro-hydraulic pump AHP M in direct connection with the cutting device, we recommend the use of a footswitch with START – STOP – OFF function.

Footswitch with START – STOP – OFF (direct connection to basic device 03200)	03865
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Footswitch with START – STOP – OFF (direct connection to hydraulic pump 03855)	03863
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As a drive we recommend electro-hydraulic pump AHP M	03855
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Prod.-No. 03250

ALFRA – WORKSHOP TROLLEY

For the bus bar bending and hole punching device 03200SET and the busbar cutting device 03250

Ideal for transportation - also in vans with standard fittings

Specially-developed workshop trolley for storing both processing devices and saving space. The electro-hydraulic pump can be connected to a fitted 2-way valve in the trolley. The processing devices are connected to each other with hydraulic hoses.

2 support rollers fitted to the side of the table make bending and cutting of long rails easier.

The trolley has an additional drawer with tool compartments for storing all punchers and dies. The trolley runs on 4 casters, 2 of which have a locking device.

The fittings include a single and double power socket in addition to a self-rolling 230 V connecting cable at 3 m length.

Table size:	1,050 x 700 mm
Dimensions:	L=1150, W=700, H=900 mm
Weight:	100 kg without devices

Workshop trolley, with 2-way valve, coupling, Drawer with tool compartments	Prod.-No. 03950
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Prod.-No. 03950 illustration shows fitted workshop trolley

ALFRA 4-STATION PROCESSING TROLLEY

For

- bending busbars at 120 x 12 mm,
- for perforating busbars Ø 6.6 - 21.5 mm,
- for cutting busbars 125 x 12 mm,
- two additional hydraulic outputs for various applications

- The processing stations for busbar cutting and hole punching and for cutting are recessed in the table. This enables quick, clean working.
- You can use a hand wheel to infinitely variably raise and lower the universal working cylinder by hydraulic power according to the hole pattern to be punched.
- The processing devices are connected to a hydraulic central unit fitted to the inside of the trolley.
- A support extension, which can be pulled out of the side, is provided as a support for longer rails.
- Press heads (e.g. press head 10 - 300 mm² Prod.-No. 03360) and hydraulic cylinder Prod.-No. 02012 can be connected to 2 hydraulic hoses fitted to the side for hole-punching.
- 1 footswitch including connecting cable is included in delivery. Up to 3 additional foot switches can be connected to the various stations.
- 4 tool drawers with compartments for punchers and dies are fitted to the trolley.
It runs on 4 casters, 2 of which have a locking device.

Technical data:

Motor voltage:	230 V / 50 Hz
Motor power:	2.2 kW
max. operating pressure:	700 bar
Flow rate:	max. 1.7 l/min.
Tank volume:	3.2 l
Usable oil volume:	2.2 l
Weight approx.:	240 kg
Table size:	1,150 x 700 mm
Dimensions L x W x H:	1,250 x 760 x 1,210 mm

Prod.-No.
03980

ALFRA 4-Station processing trolley

Required extra accessories

Punchers and dies Ø 6.6 - 21.5 mm
Puncher: Prod.-No. 03204 - 03214
Die: Prod.-No. 03230 - 03240

Hydraulic press head 10 - 300 mm² 03360

Hydraulic cylinder 02012

Footswitch with connecting cable, 3-pole 03861



Prod.-No. 03980 supplied without additional devices



4 tool draws with compartments for punchers and dies are fitted to the trolley.

ALFRA BUSBAR BENDING AND HOLE PUNCHING DEVICE – LPV

Bending busbars up to 120 x 12 mm

Perforating busbars Ø 6.6 up to 21.5 mm

The device consists of a base frame made of torsion-free aluminium profile with a mounting for the base bodies for bending and perforating. A length limit stop makes adjustment of the hole arrangement easier during punching. To make working with longer copper rails easier, the insert frame with support frame can be extended to up to around 700 mm. All limit stops and support frames are quick and easy to fix using clamping levers.

Technical data:

Bending:

Bending Cu max: 120 x 12 mm
 Bending up to: more than 90°
 smallest leg length: 50 mm
 smallest U-bend: 100 mm
 smallest Z-bend: 72 mm
 The values stated are based on copper rails 120 x 10 mm

Punching:

Punching Cu: Ø 6.6 - 21.5 mm
 also longitudinal hole up to max. L = 21 mm
 Material thickness Cu max: 12 mm
 Material width up to: 110 mm central
 Dimensions L x W x H: 615 x 370 x 315 mm
 Weight: 44 kg



Prod.-No. 03256 scope of delivery without punches and dies



*We recommend our electro-hydraulic pump AHP S
 Prod.-No. 03854 as a drive*

ALFRA busbar bending and hole punching device – LPV

Prod.-No.

03256

Accessories

Available punches and dies

Puncher Ø in mm	Metric Screw connection	Max. Material thickness in mm	Prod.-No.
6.6	6.0	5.0	03204
9.0	8.0	6.0	03205
9.5	8.0	6.0	03206
11.0	10.0	12.0	03207
11.5	10.0	12.0	03208
13.5	12.0	12.0	03209
14.0	12.0	12.0	03210
17.5	16.0	12.0	03211
18.0	16.0	12.0	03212
21.0	20.0	12.0	03213
21.5	20.0	12.0	03214



Die ØMax. in mm	Material thickness in mm	Prod.-No.
6.6	5.0	03230
9.0	6.0	03231
9.5	6.0	03232
11.0	12.0	03233
11.5	12.0	03234
13.5	12.0	03235
14.0	12.0	03236
17.5	12.0	03237
18.0	12.0	03238
21.0	12.0	03239
21.5	12.0	03240

Punchers and dies for longitudinal holes up to max. L x W = 21 x 18 mm

Prod.-No.

03241



*longitudinal hole puncher
 and dies*

Round puncher and dies

ALFRA BUSBAR BENDING AND HOLE PUNCHING DEVICE – BS 160

- The device consists of a base frame made of special aluminium and a hydraulic cylinder up to 600 bar.
- Using bending dies R=11 mm and R=5 mm and height adjustment, all busbars of up to max. 160 mm width can be bent to various angles.
- The angle measurement is engraved on the top section.
- Changing over to bending and hole-punching is easy and simple.

Technical data:

Bending

Bending Cu max.:	160 x 12 mm
Bending angle up to:	92°
smallest leg length:	50 mm internal dimension
smallest U-bend:	160 mm internal dimension
smallest Z-bend:	55 mm (material-dependent) internal dimension

Punching/perforating

Punching Cu max.:	Ø 6.6 - 21.5 mm also longitudinal hole up to max. L = 21 mm
-------------------	--

Material thickness Cu max.:	12 mm
Material width up to:	160 mm central
Dimensions L x W x H:	390 x 150 x 330 mm
Weight:	20 kg

Recommended drive type

Electro-hydraulic pump AHP 5	Prod.-No. 03854
Air-hydraulic pump LHP 700	Prod.-No. 02140
Foot pump	Prod.-No. 02121

Prod.-No.

ALFRA BS 160 with bending die
and bending puncher R=11 mm for busbars 9-12 mm

03258

Accessories

Bending puncher R=5 mm for busbars 3-8 mm

03259

Available punchers and dies

Puncher Ø in mm	Metric Screw connection	Max. Material thickness in mm	Prod.-No.
6.6	6.0	5.0	03204
9.0	8.0	6.0	03205
9.5	8.0	6.0	03206
11.0	10.0	12.0	03207
11.5	10.0	12.0	03208
13.5	12.0	12.0	03209
14.0	12.0	12.0	03210
17.5	16.0	12.0	03211
18.0	16.0	12.0	03212
21.0	20.0	12.0	03213
21.5	20.0	12.0	03214

Die ØMax. in mm	Material thickness in mm	Prod.-No.
6.6	5.0	03230
9.0	6.0	03231
9.5	6.0	03232
11.0	12.0	03233
11.5	12.0	03234
13.5	12.0	03235
14.0	12.0	03236
17.5	12.0	03237
18.0	12.0	03238
21.0	12.0	03239
21.5	12.0	03240

Punchers and dies for longitudinal holes up to max. L x W = 21 x 18 mm Prod.-No.

03241

Bending busbars up to 160 x 12 mm

Perforating busbars Ø 6.6 - 21.5 mm



ALFRA – FLEXIBLE BUSBAR PROCESSING DEVICE

for punching (without insulation) and cutting of flexible supply bars

Thickness up to 10 mm (without insulation)

Width up to 100 mm (without insulation)

Application areas:

- Cutting and perforation of ribbed copper rails
- Cutting thickness: max. 10 mm
- Hole range: Through holes for bolts M6 – M14
- Dimensions L x W x D: 400 x 250 x 150 mm (without limit stop)
- Weight: 32 kg

Basic device

- Used for mounting of: cutting block and perforating tools
- The pressure unit, consisting of hydraulic piston and cylinder including puncher mounting in the top section, is permanently integrated in the basic unit.
- The concentric locating hole for the die and cutting block insert are located in the bottom section. In addition, foldable limit stops are fitted to the front and side for hole punching in the device.



ALFRA ribbed busbar processing device

Cutting block

Prod.-No.

03300

03301

Accessories

Puncher with neoprene and pressure plates:

Ø 6.0 mm

Ø 9.0 mm

Ø 11.0 mm

Ø 14.0 mm



03304

03305

03306

03307

Die:

Ø 6.0 mm

Ø 9.0 mm

Ø 11.0 mm

Ø 14.0 mm



03309

03310

03311

03312

Other diameters on request.



Prod.-No. 02121



Prod.-No. 03854

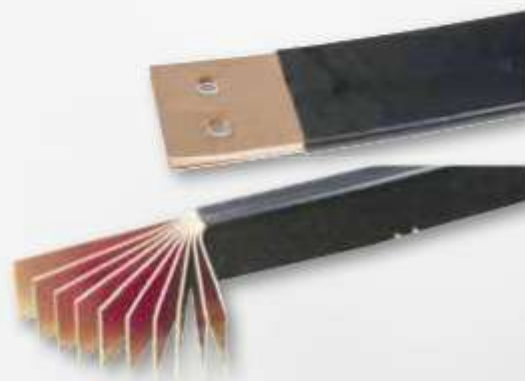
We recommend our electro-hydraulic pump AHP S as a drive

Prod.-No. 03854 or our foot pump Prod.-No. 02121.

Prod.-No. 03300



Prod.-No. 03301 cutting block with length limit stop.



ALFRA HYDRAULIC PUNCHER – AP-65

- Specially developed for assembly work. Compact, strong construction. Easily portable - flexible in use.
- For punching steel and copper
- Application areas: Punching busbars, general punching tasks in steel and bridge construction, scaffolding etc.

Technical data:

Piston stroke: 18 mm
Punching force: 270 kN

Overhang:

Working pressure max.: 700 bar
Puncher Ø 5.5 - 10 mm
Material thickness max. 8 mm, (S235)
Puncher Ø 10 - 21 mm
Material thickness max. 10 mm, (S235)

Weight: 16 kg
Dimensions: 220 x 110 x 335 mm

Prod.-No.

Hydraulic puncher AP-65

03260

Prod.-No. 03260

Tools for copper, aluminium and steel

Ø mm	max. material thickness	Prod.-No. Puncher	Prod.-No. Die
5.5	5 mm	03265	03275
6.6	6 mm	03266	03276
8.0	6 mm	03285	03290
9.0	8 mm	03267	03277
11.0	10 mm	03268	03278
14.0	10 mm	03269	03279
18.0	10 mm	03270	03280
21.0	10 mm	03271	03281

other diameters on request where edge holes are possible



Prod.-No. 03854

We recommend our electro-hydraulic pump as a drive
AHP S Prod.-No. 03854.



Punchers and dies for AP-65

ALFRA HYDRAULIC CRIMPING UNIT

C-shape for simple handling

- C-shape, press head rotatable through 320°, hydraulics integrated in handle. Automatic switchover from rapid feed to press feed.
- Fitted pressure limiting valve.
- Replaceable hexagonal press inserts, semicircular.
- Supplied in plastic case.

Technical data:

Pressing force:	130 kN
Pressing power:	700 bar
Weight:	5.4 kg
Opening width:	26 mm
Length:	545 mm



Hydraulic crimping unit

Prod.-No.

03361

Prod.-No. 03361 head can be rotated through 320°

Hexagonal press inserts

Semicircular pressing shape for cable shoes and connectors

suitable for pressing units 03360/03380/03361

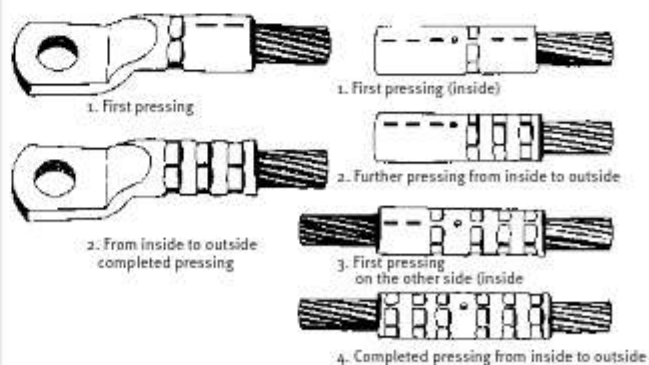
Tool Ref.no.	Press width mm	Copper Cross-section in mm²	Aluminium	Prod.-No.
8	14	16	–	03365
10	14	25	–	03366
12	12	35	25	03367
14	12	50	35	03368
16	12	70	50	03369
18	12	95	70	03370
20	12	120	–	03371
22	14	150	95 + 120	03372
25	14	185	150	03373
28	14	240	185	03374
30	5	–	–	03375
32	5	300	240	03376
34	5	–	300	03377



Hexagonal press inserts

Notes on hexagonal pressings

(Manufacturer information is definitive)



ALFRA HYDRAULIC PRESS HEADS

C-shape for simple handling

- pressing cable shoes and connectors made of copper and aluminium of between 10 – 300 mm².
- Hexagonal press inserts semicircular.
- Supplied in sheet steel transport boxes.
- Electro-hydraulic pump Prod.-No. 03854 or foot pump 02121 can be used to operate both press heads.

Technical data:

Pressing force:	130 kN
Pressing power:	700 bar
Weight:	3.9 kg
Opening width:	26 mm
Length:	245 mm



Prod.-No. 03360

Prod.-No.
03360

Hydraulic press head

Technical data:

Pressing force:	130 kN
Pressing power:	700 bar
Weight:	4.6 kg
Opening width:	38 mm
Length:	275 mm



Prod.-No.
03380

Prod.-No. 03380

Hydraulic press head

Hexagonal press inserts

Semicircular pressing shape for cable shoes and connectors

suitable for pressing units 03360/03380/03361

Tool Ref.no.	Press width mm	Copper Cross-section in mm ²	Aluminium Cross-section in mm ²	Prod.-No.
8	14	16	–	03365
10	14	25	–	03366
12	12	35	25	03367
14	12	50	35	03368
16	12	70	50	03369
18	12	95	70	03370
20	12	120	–	03371
22	14	150	95 + 120	03372
25	14	185	150	03373
28	14	240	185	03374
30	5	–	–	03375
32	5	300	240	03376
34	5	–	300	03377



Hexagonal press inserts

ALFRA HYDRAULIC CABLE CUTTER – AKS 85

Ideal for cutting cables up to Ø 85 mm

Advantages

- Guided cutter blade.
- Independent, can be used in any location.
- Clean cuts at minimal deformation.

Application areas:

Power supply companies, power distribution construction, telecommunications, municipal utilities and their providers, crane construction, mining, shipbuilding, maintenance or repair etc.

Technical data:

Cutting force:	55 kN
Cutting pressure:	700 bar
Weight:	6.3 kg
Length:	450 mm

Cutting performance:

telephone cable:	up to Ø 85 mm
electric cable with armouring:	up to Ø 85 mm
insulated aluminium cable:	3 x 240 mm ²
(earthing cable)	
insulated aluminium cable:	630 mm ²
(single-core)	
aluminium wire:	up to Ø 46 mm
copper wire:	up to Ø 28 mm



Prod.-No. 04002

hydraulic cable cutter AKS 85
supplied in sailcloth bag

Prod.-No.
04002

ALFRA HYDRAULIC MANUAL CABLE CUTTER - HKS 85

With built-in manual hydraulics for cutting cables up to Ø 85 mm

The most ergonomic working position can be selected thanks to the integrated hydraulics in the rotating handle.

The cable cutter can be used on scaffolds, on high tension pylons or in manholes etc. independently of hydraulic pumps.

Application areas:

Power supply companies, power distribution construction, telecommunications, municipal utilities and their providers, crane construction, mining, shipbuilding, maintenance or repair etc.

Technical data:

Cutting force:	55 kN
Cutting pressure:	700 bar
Weight:	6.6 kg
Length:	740 mm

The cutting performance is equivalent to Type AKS 85.



Prod.-No.
04015

Prod.-No. 04015 head can be rotated through 320°

Hydraulic manual cable cutter HKS 85
supplied in sailcloth bag

ALFRA PRESS





ALFRA PRESS - OVERVIEW



ALFRA PRESS AP 250



ALFRA PRESS AP 400

Page	74	78	
Application	Control cabinet housing, Control cabinet doors, Mounting panels	Control cabinet housing, Control cabinet doors, Mounting panels	
Prod.-No.	03170	03195	
Overhang with limit stop in mm	250	400	
Overall height in mm	820	1,700	
Total weight in kg approx.	50 (without base)	220	
Space requirement in mm	1,000 X 1,000	1,200 X 800	
Tool dimension in mm:			
Circular Ø	3.2 – 40.5	3.2 – 40.5	
Square up to	28.0 x 28.0	28.0 x 28.0	
Max. diagonals of	40.0	40.0	
Max. material thickness in mm:			
Sheet steel S235 / stainless steel	2.5 / 2.0	2.5 / 2.0	
Aluminium / plastic	4.0	4.0	
Hydraulic system:			
Mode of action	single-action	single-action	
Punching force F	46 kN at 600 bar	46 kN at 600 bar	
Punching stroke in mm	50	50	
Operating voltage in V	-	-	
Workpiece fold in mm	22	22	

ALFRA PRESS - OVERVIEW



ALFRA PRESS AP 500



ALFRA PRESS AP 600-2



ALFRA PRESS AP 800

	82	86	90
	Control cabinet doors, Mounting panels, various control cabinet housings	Control cabinet doors, Mounting panels	Control cabinet doors, Mounting panels
	03093	03090	03400
	500	600	800
	1,500	1,600	1,700
	200	360	850
	1,500 x 1,500 mm	2,000 x 3,000	2,360 x 4,440
	3.2 – 63.5	3.2 – 70.0	3.2 – 120.0
	46.0 x 46.0	68.0 x 68.0	110.0 x 110.0
	60.0	90.0	140.0
	3.0 / 2.0	3.0 / 2.0	3.0 / 2.0
	4.0	4.0	4.0
	double-action	double-action	double-action
	48 kN at 130 bar	60 kN at 165 bar	135 kN at 190 bar
	66	66	72
	220	400	400
	30°	30°	40°

PUNCHING WITHOUT PRE-DRILLING

*Ap*ress **250**

Overhang 250 mm



ALFRA PRESS AP 250

For rapid punching-out of circular, square, rectangular or special forms without pre-drilling in control cabinet doors, terminal boxes, cable ducts, housings, cable management panels etc. right up to margins. Simple tool change carried out in seconds.

Description:

- Flexible in use - on mobile base (optional) or stationary, fitted on the workbench.
- Rapid tool change helps in problem areas with a wide range of break-through types.
- A range of die mountings is available, even for punching very close to margins.
- Rows of punch-outs are no problem thanks to attachable folding stops.
- Tip: Use a laser pointer as an option - no scribing, no centre punching, a simple crosshair with the pin is sufficient.
- Operation using a manual pump is sufficient as a "starter solution" - this makes "punching without pre-drilling" possible at low cost.

Technical data:

Overhang with limit stop:	250 mm
Overhang without limit stop:	265 mm
Punching stroke:	50 mm
Punching force F:	46 kN at 600 bar
Hydraulic connection:	R 1/4"
Weight without base:	50 kg
Weight with base:	120 kg
Space requirement with base approx.:	1,000 mm x 1,000 mm

Punching capacity:

Circular:	Ø 3.2 - 40.5 mm
Square:	28.0 x 28.0 mm
Rectangle:	22.0 x 30.0 mm
Special forms up to a max. diagonal of:	40.0 mm

Material thicknesses (max):

Sheet steel (S235):	2.5 mm
Stainless steel (F = 600 N/mm²):	2.0 mm
Aluminium (F = 22 N/mm²):	4.0 mm
Punchable plastics:	4.0 mm

Prod.-No.

ALFRA PRESS AP 250 (without options)

03170

Note:

- All circular tools for ALFRA PRESS punchers AP 250 - AP 800 are made of special tool steel and have a special cutting geometry developed by ALFRA.

Special tools can be manufactured in our own toolmaking works at short notice!

Technical features when punching close to margins with die holder Type I



Smallest-possible axial dimension (border spacing) when using die holder Type I
Prod.-No. 03174



Laser pointer for optical display of tool centre



Tool drawer, pivoting



Length and depth limit stop with foldable add-on stops



Pivoting support arms, height adjustable, each with 2 rubber supports (option)



We recommend our electro-hydraulic pump ALH-600 Prod.-No. 03190 as a drive unit.

Prod.-No. 03190

PUNCHING WITHOUT PRE-DRILLING



Overhang 250 mm

Stationary hole puncher - AP 250

Type	Designation	Prod.-No.
Machine	Punching yoke ALFRA PRESS 250 with hydraulic cylinder and quick coupling, cylinder piston with non-twist device for insertion of all puncher sockets	03170
Pump	Electro-hydraulic pump ALH 600	03190
Special fitting	Laser pointer with power unit for electro-hydraulic pump ALH 600	03181
	Laser pointer, cpl. with power unit and connector plug for separate mains cable 230V/50Hz	03182
	Combined length and depth limit stops with 2 adjustable limit stops per axis. The limit stops in the X direction are foldable and are suitable as an add-on limit stop for rows of punch-outs.	03177
	Pivoting support arms (pairs) height adjustable, each with 2 rubber supports	03179
	Limit switch for stroke limitation (only in combination with hydraulic pump ALH-600)	03183
	Mobile base	03189
Puncher socket	with scraper and centring pin Ø 3.2 - 30.5 mm with mounting shaft for AP 250 - 400	03171
	with scraper and centring pin for round puncher Ø 32.5 - 40.5 mm with 19 mm Female thread for AP 250 - 400	03172
Die holder	Type I Dies Ø 3.2 - 22.5 mm for punching right up to margins for AP 250 - 400	03174
	Type II Dies Ø 3.2 - 30.5 mm and moulding tool up to 21 x 21 mm (30.5 mm max. diagonals) for AP 250 - 400	03175
	Type IV Dies Ø 30.6 - 40.5 mm and moulding tool up to 28 x 28 mm (40.0 mm max. diagonals) AP 250 - 400	03176

Square and rectangular hole punchers - AP 250

suitable for steel, for stainless steel applications on request, with mounting shaft and centring point, including die

Type	Designation	Prod.-No.	AP 250	AP 400	AP 500	AP 600	AP 800
Square holes	21.0 x 21.0 mm for AP 250 - 400	03087	●	●			
	25.4 x 25.4 mm for AP 250 - 400	03088	●	●			
Rectangular holes	22.0 x 30.0 mm for AP 250 - 400	03089	●	●			
Special holes	Ø 22.5 mm with 4 lugs for AP 250 - 400	03086	●	●			
Spare neoprene scraper	for puncher socket (03171) Ø 3.2 - 30.5 mm	03185	●	●			
	for puncher socket (03172) Ø 30.6 - 40.5 mm	03186	●	●			

Circular punchers and dies - AP 250 suitable for steel and stainless steel

Type	Mounting holder	Ø in mm	Size Metric	Size PG	Prod.-No.	AP 250	AP 400	AP 500	AP600-2	AP 800
Puncher Ø 3.2 - 30.5 mm		3.2			03131	●	●	●	●	●
		4.5			03132	●	●	●	●	●
		5.4			03133	●	●	●	●	●
		6.5			03134	●	●	●	●	●
		8.5	M8		03135	●	●	●	●	●
		10.5	M10		03136	●	●	●	●	●
		12.7	M12	PG7	03137	●	●	●	●	●
		15.2		PG9	03138	●	●	●	●	●
		16.2	M16		03139	●	●	●	●	●
		18.6		PG11	03140	●	●	●	●	●
		20.4	M20	PG13	03141	●	●	●	●	●
		22.5		PG16	03142	●	●	●	●	●
		25.4	M25		03143	●	●	●	●	●
		28.3		PG21	03144	●	●	●	●	●
		30.5			03145	●	●	●	●	●
Punch Ø 32.5 - 40.5 mm		32.5	M32		03146	●	●	●	●	●
		37.0		PG29	03158	●	●	●	●	●
		40.5	M40		03147	●	●	●	●	●
Die Ø 3.2 - 22.5 mm	TYPE I	3.2			03500	●	●			
		4.5			03501	●	●			
		5.4			03502	●	●			
		6.5			03503	●	●			
		8.5	M8		03504	●	●			
		10.5	M10		03505	●	●			
		12.7	M12	PG7	03506	●	●			
		15.2		PG9	03507	●	●			
		16.2	M16		03508	●	●			
		18.6		PG11	03509	●	●			
		20.4	M20	PG13	03510	●	●			
		22.5		PG16	03511	●	●			
Die Ø 3.2 - 30.5 mm	TYPE II	3.2			03063	●	●	●	●	●
		4.5			03066	●	●	●	●	●
		5.4			03068	●	●	●	●	●
		6.5			03074	●	●	●	●	●
		8.5	M8		03076	●	●	●	●	●
		10.5	M10		03079	●	●	●	●	●
		12.7	M12	PG7	03022	●	●	●	●	●
		15.2		PG9	03023	●	●	●	●	●
		16.2	M16		03084	●	●	●	●	●
		18.6		PG11	03024	●	●	●	●	●
		20.4	M20	PG13	03025	●	●	●	●	●
		22.5		PG16	03026	●	●	●	●	●
		25.4	M25		03085	●	●	●	●	●
		28.3		PG21	03110	●	●	●	●	●
		30.5			03111	●	●	●	●	●
Die Ø 30.6 - 40.5 mm	TYPE IV	32.5	M32		03165	●	●			
		37.0		PG29	03166	●	●			
		40.5	M40		03167	●	●			

PUNCHING WITHOUT PRE-DRILLING

Apress **400**

Overhang 400 mm



ALFRA PRESS AP 400

For rapid punching-out in circular, square, rectangular or special forms without pre-drilling in control cabinet doors, terminal boxes, cable ducts, housings, cable management panels etc. right up to margins. Simple tool change carried out in seconds.

Description:

- Flexible in use - on mobile base.
- Rapid tool change helps in problem areas with a wide range of break-through types.
- A range of die mountings is available, even for punching very close to margins.
- Rows of punch-outs are no problem thanks to attachable folding stops.
- Tip: Use a laser pointer as an option - no scribing, no centre punching, a simple crosshair with the pin is sufficient.
- Operation using a manual pump is sufficient as a "starter solution" - this makes "punching without pre-drilling" possible at low cost.

Technical data:

Overhang with limit stop:	400 mm
Overhang without limit stop:	430 mm
Punching stroke:	50 mm
Punching force F:	46 kN at 600 bar
Hydraulic connection:	R 1/4"
Weight:	220 kg
Space requirement with base approx.:	1,200 x 800 mm

Punching capacity:

Circular from:	Ø 3.2 - 40.5 mm
Square up to:	28.0 x 28.0 mm
Rectangular up to:	22.0 x 30.0 mm
Special forms up to a max. diagonal of:	40.0 mm

Material thicknesses (max):

Sheet steel (S235):	2.5 mm
Stainless steel (F = 600 N/mm ²):	2.0 mm
Aluminium (F = 22 N/mm ²):	4.0 mm
Punchable plastics:	4.0 mm

Prod.-No.

ALFRA PRESS AP 400 (without options)

03195

Note:

- All circular tools for ALFRA PRESS punchers AP 250 - AP 800 are made of special tool steel and have a special cutting geometry developed by ALFRA.

Special tools can be manufactured in our own toolmaking works at short notice!

Technical features when punching close to margins with die holder Type I

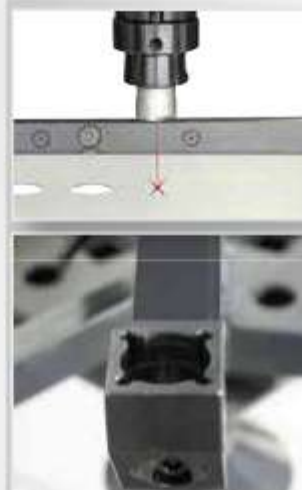


Smallest-possible axial dimension (border spacing) when using die holder Type I

Prod.-No. 03174



Laser pointer for optical display of tool centre



Die holder Type II



Tool drawer, pivoting



Length and depth limit stop with foldable add-on stops (Option)



Pivoting support arms, height adjustable, each with 3 rubber supports (option)



Prod.-No. 03190

We recommend our electro-hydraulic pump ALH-600 Prod.-No. 03190 as a drive unit.

PUNCHING WITHOUT PRE-DRILLING



Overhang 400 mm

Stationary hole puncher - AP 400

Type	Designation	Prod.-No.
Machine Pump	Punching yoke ALFRA PRESS 400 with hydraulic cylinder and quick coupling, cylinder piston with non-twist device for insertion of all puncher sockets	03195
	Electro-hydraulic pump ALH 600	03190
Special fitting	Laser pointer with power unit for electro-hydraulic pump ALH 600	03181
	Laser pointer, with power unit and connector plug for separate mains cable 230V/50Hz	03182
	Combined length and depth limit stops with 2 adjustable limit stops per axis. The limit stops in the X direction are foldable and are suitable as an add-on limit stop for rows of punch-outs.	03196
	Pivoting support arms (pairs) height adjustable, each with 2 rubber supports	03197
Puncher socket	with scraper and centring pin Ø 3.2 - 30.5 mm with mounting shaft for AP 250 - 400	03171
	with scraper and centring pin for round puncher Ø 32.5 - 40.5 mm with 19 mm Female thread for AP 250 - 400	03172
Die holder	Type I Dies Ø 3.2 - 22.5 mm for punching right up to margins for AP 250 - 400	03174
	Type II Dies Ø 3.2 - 30.5 mm and moulding tool up to 21 x 21 mm (30.5 mm max. diagonals) for AP 250 - 400	03175
	Type IV Dies Ø 30.6 - 40.5 mm and moulding tool up to 28 x 28 mm (40.0 mm max. diagonals) AP 250 - 400	03176

Square and rectangular hole punchers - AP 400

suitable for steel, for stainless steel applications on request, with mounting shaft and centring point, including die

Type	Designation	Prod.-No.	AP 250	AP 400	AP 500	AP 600	AP 800
Square holes	21.0 x 21.0 mm for AP 250 - 400	03087	●	●			
	25.4 x 25.4 mm for AP 250 - 400	03088	●	●			
Rectangular holes	22.0 x 30.0 mm for AP 250 - 400	03089	●	●			
Special holes	Ø 22.5 mm with 4 lugs for AP 250 - 400	03086	●	●			
Spare neoprene scraper	for puncher socket (03171) Ø 3.2 - 30.5 mm	03185	●	●			
	for puncher socket (03172) Ø 30.6 - 40.5 mm	03186	●	●			

Circular punchers and dies - AP 400 suitable for steel and stainless steel

Type	Mounting holder	Ø in mm	Size Metric	Size PG	Prod.-No.	AP 250	AP 400	AP 500	AP600-2	AP 800
Puncher Ø 3.2 - 30.5 mm		3.2			03131	•	•	•	•	•
		4.5			03132	•	•	•	•	•
		5.4			03133	•	•	•	•	•
		6.5			03134	•	•	•	•	•
		8.5	M8		03135	•	•	•	•	•
		10.5	M10		03136	•	•	•	•	•
		12.7	M12	PG7	03137	•	•	•	•	•
		15.2		PG9	03138	•	•	•	•	•
		16.2	M16		03139	•	•	•	•	•
		18.6		PG11	03140	•	•	•	•	•
		20.4	M20	PG13	03141	•	•	•	•	•
		22.5		PG16	03142	•	•	•	•	•
		25.4	M25		03143	•	•	•	•	•
		28.3		PG21	03144	•	•	•	•	•
		30.5			03145	•	•	•	•	•
Punch Ø 32.5 - 40.5 mm		32.5	M32		03146	•	•	•	•	•
		37.0		PG29	03158	•	•	•	•	•
		40.5	M40		03147	•	•	•	•	•
Die Ø 3.2 - 22.5 mm	TYPE I	3.2			03500	•	•			
		4.5			03501	•	•			
		5.4			03502	•	•			
		6.5			03503	•	•			
		8.5	M8		03504	•	•			
		10.5	M10		03505	•	•			
		12.7	M12	PG7	03506	•	•			
		15.2		PG9	03507	•	•			
		16.2	M16		03508	•	•			
		18.6		PG11	03509	•	•			
		20.4	M20	PG13	03510	•	•			
		22.5		PG16	03511	•	•			
Die Ø 30.6 - 40.5 mm	TYPE II	3.2			03063	•	•	•	•	•
		4.5			03066	•	•	•	•	•
		5.4			03068	•	•	•	•	•
		6.5			03074	•	•	•	•	•
		8.5	M8		03076	•	•	•	•	•
		10.5	M10		03079	•	•	•	•	•
		12.7	M12	PG7	03022	•	•	•	•	•
		15.2		PG9	03023	•	•	•	•	•
		16.2	M16		03084	•	•	•	•	•
		18.6		PG11	03024	•	•	•	•	•
		20.4	M20	PG13	03025	•	•	•	•	•
		22.5		PG16	03026	•	•	•	•	•
		25.4	M25		03085	•	•	•	•	•
		28.3		PG21	03110	•	•	•	•	•
		30.5			03111	•	•	•	•	•
Die Ø 30.6 - 40.5 mm	TYPE IV	32.5	M32		03165	•	•			
		37.0		PG29	03166	•	•			
		40.5	M40		03167	•	•			

PUNCHING WITHOUT PRE-DRILLING

APress 500

Overhang 500 mm



ALFRA PRESS AP 500

The stationary hole puncher has been developed for control cabinet and switch gear makers and is suitable for quick punching-out of circular, square, rectangular or special forms in sheet metal and control cabinet doors up to 2000 mm x 1000 mm and 30 mm margin fold height. Punching possible right up to margins. Simple, rapid tool change carried out in seconds.

Control cabinets/housings up to 300 mm in depth can also be processed.

Description:

- Stable press body with adjustable stand feet.
- Dual-action hydraulic cylinder, flanged force-locking and form-locking to machine body.
- Anti-twist piston rod \varnothing 55 mm made of tempered stainless steel with tool holder.
- Die bed, fixed force-locking to press body.
- Rapid tool change helps in problem areas with a wide range of break-through types.
- Hold-down device with safety function, fixed with electrical safety lock for accident prevention.
- Height-adjustable length and depth limit stops - available in 2 versions.
- Tape measure display for length and depth limit stops.
- Dual-circuit hydraulic unit with electric pump, oil container and solenoid valves (very low noise).
- Safety footswitch with double pedal for infinitely variable operation of punching and return stroke.

Technical data:

Overhang with limit stop:	500 mm
Overhang without limit stop:	540 mm
Punching stroke:	66 mm
Punching force F:	48 kN at 130 bar
Motor power:	0.37 kW
Operating voltage:	220 V
Weight approx.:	200 kg
Overall height:	1,500 mm
Working height:	1,000 mm
Width of puncher body:	130 mm
Depth of puncher body:	950 mm
Length of limit stock rails:	1,500 mm
Space requirement approx.:	1,500 x 1,500 mm

Punching capacity:

Circular from:	\varnothing 3.2 - 63.5 mm
Square up to:	46.0 x 46.0 mm
Special forms up to a max. diagonal of:	60.0 mm

Material thicknesses (max):

Sheet steel (S235):	3.0 mm
Stainless steel ($F = 600 \text{ N/mm}^2$):	2.0 mm
Aluminium ($F = 22 \text{ N/mm}^2$):	4.0 mm
Punchable plastics:	4.0 mm

Prod.-No.

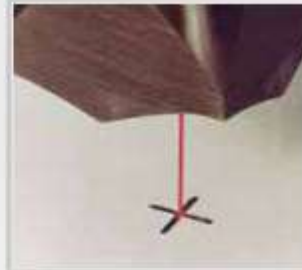
ALFRA PRESS AP 500 (without options)

03093

Note:

- All circular tools for ALFRA PRESS punchers AP 250 - AP 800 are made of special tool steel and have a special cutting geometry developed by ALFRA.

Special tools can be manufactured in our own toolmaking works at short notice!



Laser pointer for optical display of tool centre



Electrical safety lock for accident prevention.



Limit stop system in Y direction
Mobile, 2 guide shafts in press body.



Die holder



Tape measures display for Y-axis



Dual-circuit hydraulic unit

PUNCHING WITHOUT PRE-DRILLING



Overhang 500 mm

Stationary hole puncher - AP 500

Type	Designation	Prod.-No.
Machine	Stationary hole puncher ALFRA PRESS 500 with hydraulic cylinder, dual-action Hydraulic unit, adjustable stand feet, safety footswitch	03093
Special fitting	Laser pointer for optical display of tool centre	03021
	Length and depth limit stops movable in Y direction	03094
	Length and depth limit stops movable in X and Y direction	03095
	Pivoting double joint arm for supporting workpiece (individual)	03078
Puncher socket	with scraper and centring pin for round puncher with mounting shaft AP 500 - 600 Ø 3.2 - 30.5 mm	03036
	with centring pin for round puncher with 19 mm mounting shaft for AP 500 - 600 Ø 32.5 - 63.5 mm	03035
Die holder	Type A Circular die Type A Ø 3.2 - 25.4 mm	03040
	Type B Circular die Type A Ø 28.3 - 40.5 mm	03041
	Type C Circular die Type A Ø 40.6 - 63.5 mm	03077

Square and rectangular hole punchers - AP 500

suitable for steel, for stainless steel applications on request, with mounting shaft and centring point, including die

Type	Designation	Prod.-No.	AP 250	AP 400	AP 500	AP 600	AP 800
Square holes	12.7 x 12.7 mm for AP 500 - 600	03042			●	●	
	19.0 x 19.0 mm for AP 500 - 600	03044			●	●	
	22.2 x 22.2 mm for AP 500 - 600	03045			●	●	
	25.4 x 25.4 mm for AP 500 - 600	03046			●	●	
	46.0 x 46.0 mm for AP 500 - 600	03047			●	●	
	68.0 x 68.0 mm for AP 600	03050				●	
Rectangular holes	22.0 x 30.0 mm for AP 500 - 600	03048			●	●	
	22.0 x 42.0 mm for AP 500 - 600	03049			●	●	
Special holes	Ø 22.5 mm 1 lug 3.2 mm for AP 500 - 600	03051			●	●	
	Ø 22.5 mm with 2 lugs 3.2 mm for AP 500 - 600	03052			●	●	
	Ø 22.5 mm, flattened on 4 sides to 20.1 mm for AP 500 - 600	03055			●	●	

ALFRA PRESS AP 500

Circular punchers and dies - AP 500 suitable for steel and stainless steel										
Type	Mounting holder	Ø in mm	Size Metric	Size PG	Prod.-No.	AP 250	AP 400	AP 500	AP600-2	AP 800
Puncher Ø 3.2 - 30.5 mm		3.2			03131	●	●	●	●	●
		4.5			03132	●	●	●	●	●
		5.4			03133	●	●	●	●	●
		6.5			03134	●	●	●	●	●
		8.5	M8		03135	●	●	●	●	●
		10.5	M10		03136	●	●	●	●	●
		12.7	M12	PG7	03137	●	●	●	●	●
		15.2		PG9	03138	●	●	●	●	●
		16.2	M16		03139	●	●	●	●	●
		18.6		PG11	03140	●	●	●	●	●
		20.4	M20	PG13	03141	●	●	●	●	●
		22.5		PG16	03142	●	●	●	●	●
		25.4	M25		03143	●	●	●	●	●
		28.3		PG21	03144	●	●	●	●	●
		30.5			03145	●	●	●	●	●
Puncher Ø 32.5 - 63.5 mm		32.5	M32		03146	●	●	●	●	●
		37.0		PG29	03158	●	●	●	●	●
		40.5	M40		03147	●	●	●	●	●
		47.0		PG36	03159			●	●	●
		50.5	M50		03148			●	●	●
		54.0		PG42	03160			●	●	●
		60.0		PG48	03161			●	●	●
		63.5	M63		03149			●	●	●
Die Ø 3.2 - 25.4 mm	TYPE A	3.2			03063	●	●	●	●	●
		4.5			03066	●	●	●	●	●
		5.4			03068	●	●	●	●	●
		6.5			03074	●	●	●	●	●
		8.5	M8		03076	●	●	●	●	●
		10.5	M10		03079	●	●	●	●	●
		12.7	M12	PG7	03022	●	●	●	●	●
		15.2		PG9	03023	●	●	●	●	●
		16.2	M16		03084	●	●	●	●	●
		18.6		PG11	03024	●	●	●	●	●
		20.4	M20	PG13	03025	●	●	●	●	●
		22.5		PG16	03026	●	●	●	●	●
		25.4	M25		03085	●	●	●	●	●
Die Ø 28.3 - 40.5 mm	TYPE B	28.3		PG21	03027			●	●	●
		30.5			03028			●	●	●
		32.5	M32		03163			●	●	●
		37.0		PG29	03029			●	●	●
		40.5	M40		03164			●	●	●
Die Ø 47.0 - 63.5 mm	TYPE C	47.0		PG36	03030			●	●	●
		50.5	M50		03168			●	●	●
		54.0			03031			●	●	●
		60.0		PG48	03032			●	●	●
		63.5	M63		03169			●	●	●

PUNCHING WITHOUT PRE-DRILLING

APress 600-2

Overhang 600 mm



ALFRA PRESS AP 600-2

The stationary hole puncher has been developed for control cabinet and switch gear makers and is suitable for quick punching-out of circular, square, rectangular or special forms in sheet metal and control cabinet doors up to 2200 mm x 1000 mm and 30 mm margin fold height. Punching possible right up to margins. Simple, rapid tool change carried out in seconds - even on fitted door. Limit stop system can be moved in X and Y directions.

Description:

- Stable press body in heavy-duty, torsionally-stiff welded construction.
- Dual-action hydraulic cylinder, flanged force-locking and form-locking to machine body.
- Anti-twist piston rod Ø 55 mm made of tempered stainless steel with tool holder.
- Die bed, fixed force-locking to press body.
- Rapid tool change helps in problem areas with a wide range of breakthrough types.
- Hold-down device with safety function, fixed with electrical safety lock for accident prevention.
- Length and depth limit stops movable in X and Y directions, bearings in hardened double ball bearing slides for smooth mobility.
- Tape measure display for length and depth adjustment.
- Digital measuring indicator optionally available for X and Y axes.
- Dual-circuit hydraulic unit with electric pump, oil container and solenoid valves (very low noise).
- Safety footswitch with double pedal for infinitely variable operation of punching and return stroke.

Technical data:

Overhang with limit stop:	600 mm
Punching stroke:	66 mm
Punching force F:	60 kN at 165 bar
Motor power:	0.75 KW
Operating voltage:	400 V
Weight approx.:	360 kg
Overall height:	1,600 mm
Working height:	1,000 mm
Width of puncher body:	310 mm
Depth of puncher body:	1,150 mm
Length of limit stock rails:	1,500 mm
Space requirement approx.:	2,000 x 3,000 mm

Punching capacity:	
Circular from:	Ø 3.2 - 70.0 mm
Square up to:	68.0 x 68.0 mm
Special forms up to a max. diagonal of:	90.0 mm

Material thicknesses (max):	
Sheet steel (S235):	3.0 mm
Stainless steel ($F = 600 \text{ N/mm}^2$):	2.0 mm
Aluminium ($F = 22 \text{ N/mm}^2$):	4.0 mm
Punchable plastics up to:	4.0 mm

Prod.-No.
03090

ALFRA PRESS AP 600-2 (without options)

Note:

- All circular tools for ALFRA PRESS punchers AP 250 - AP 800 are made of special tool steel and have a special cutting geometry developed by ALFRA.

Special tools can be manufactured in our own toolmaking works at short notice!



Laser pointer for optical display of tool centre



Stable piston rod (Ø 55 mm) with tool anti-twist device



Tool drawer with compartments



Dual-circuit hydraulic unit in cabinet base



Reciprocal quick-clamping system for edge folds either top or bottom



Die bed holder. Tool changes can also be carried out when control cabinet door is fitted.



Length and depth limit stops guided in double ball bearing slides on both sides. 2 adjustable limit stops right and left on the Y-axis.

PUNCHING WITHOUT PRE-DRILLING

APress 600-2

Overhang 600 mm

Stationary hole puncher - AP 600-2

Type	Designation	Prod.-No.
Machine	Stationary hole puncher ALFRA PRESS 600-2 with hydraulic cylinder, cabinet base, length and depth limit stops movable in X and Y directions, cylinder pistons with anti-twist device for use with all puncher sockets, dual-action hydraulic unit, safety footswitch.	03090
Special fitting	Laser pointer for optical display of tool centre	03021
	Digital measuring indicator Y-axis	03091
	Digital measuring indicator X-axis	03092
	Pivoting double joint arm for supporting workpiece (individual)	03078
Puncher socket	with scraper and centring pin for round puncher with mounting shaft for AP 500 - 600 Ø 3.2 - 30.5 mm	03036
	with centring pin for round puncher with 19 mm female thread for AP 500 - 600 Ø 32.5 - 40.5 mm	03035
Die holder	Type A Circular die Type A Ø 3.2 - 25.4 mm	03040
	Type B Circular die Type A Ø 28.3 - 40.5 mm	03041
	Type C Circular die Type A Ø 40.5 - 63.5 mm	03077

Square and rectangular hole punchers - AP 600-2

suitable for steel, for stainless steel applications on request, with mounting shaft and centring point, including die

Type	Designation	Prod.-No.	AP 250	AP 400	AP 500	AP 600	AP 800
Square holes	12.7 x 12.7 mm for AP 500 - 600	03042			●	●	
	19.0 x 19.0 mm for AP 500 - 600	03044			●	●	
	22.2 x 22.2 mm for AP 500 - 600	03045			●	●	
	25.4 x 25.4 mm for AP 500 - 600	03046			●	●	
	46.0 x 46.0 mm for AP 500 - 600	03047			●	●	
	68.0 x 68.0 mm for AP 600	03050				●	
Rectangular holes	22.0 x 30.0 mm for AP 500 - 600	03048			●	●	
	22.0 x 42.0 mm for AP 500 - 600	03049			●	●	
Special holes	Ø 22.5 mm 1 lug 3.2 mm for AP 500 - 600	03051			●	●	
	Ø 22.5 mm with 2 lugs 3.2 mm for AP 500 - 600	03052			●	●	
	Ø 22.5 mm, flattened on 4 sides to 20.1 mm for AP 500 - 600	03055			●	●	

ALFRA PRESS AP 600-2

Circular punchers and dies - AP 600-2 suitable for steel and stainless steel										
Type	Mounting holder	Ø in mm	Size Metric	Size PG	Prod.-No.	AP 250	AP 400	AP 500	AP600-2	AP 800
Puncher Ø 3.2 - 30.5 mm		3.2			03131	•	•	•	•	•
		4.5			03132	•	•	•	•	•
		5.4			03133	•	•	•	•	•
		6.5			03134	•	•	•	•	•
		8.5	M8		03135	•	•	•	•	•
		10.5	M10		03136	•	•	•	•	•
		12.7	M12	PG7	03137	•	•	•	•	•
		15.2		PG9	03138	•	•	•	•	•
		16.2	M16		03139	•	•	•	•	•
		18.6		PG11	03140	•	•	•	•	•
		20.4	M20	PG13	03141	•	•	•	•	•
		22.5		PG16	03142	•	•	•	•	•
		25.4	M25		03143	•	•	•	•	•
		28.3		PG21	03144	•	•	•	•	•
		30.5			03145	•	•	•	•	•
Puncher Ø 32.5 - 63.5 mm		32.5	M32		03146	•	•	•	•	•
		37.0		PG29	03158	•	•	•	•	•
		40.5	M40		03147	•	•	•	•	•
		47.0		PG36	03159			•	•	•
		50.5	M50		03148			•	•	•
		54.0		PG42	03160			•	•	•
		60.0		PG48	03161			•	•	•
		63.5	M63		03149			•	•	•
Die Ø 3.2 - 25.4 mm	TYPE A	3.2			03063	•	•	•	•	•
		4.5			03066	•	•	•	•	•
		5.4			03068	•	•	•	•	•
		6.5			03074	•	•	•	•	•
		8.5	M8		03076	•	•	•	•	•
		10.5	M10		03079	•	•	•	•	•
		12.7	M12	PG7	03022	•	•	•	•	•
		15.2		PG9	03023	•	•	•	•	•
		16.2	M16		03084	•	•	•	•	•
		18.6		PG11	03024	•	•	•	•	•
		20.4	M20	PG13	03025	•	•	•	•	•
		22.5		PG16	03026	•	•	•	•	•
		25.4	M25		03085	•	•	•	•	•
Die Ø 28.3 - 40.5 mm	TYPE B	28.3		PG21	03027			•	•	•
		30.5			03028			•	•	•
		32.5	M32		03163			•	•	•
		37.0		PG29	03029			•	•	•
		40.5	M40		03164			•	•	•
Die Ø 47.0 - 63.5 mm	TYPE C	47.0		PG36	03030			•	•	•
		50.5	M50		03168			•	•	•
		54.0			03031			•	•	•
		60.0		PG48	03032			•	•	•
		63.5	M63		03169			•	•	•

PUNCHING WITHOUT PRE-DRILLING

APress 800

Overhang 800 mm



ALFRA PRESS AP 800

The stationary hole puncher has been developed for control cabinet and switch gear makers and is suitable for quick punching-out of circular, square, rectangular or special forms in sheet metal and control cabinet doors up to 2200 mm x 1000 mm and 40 mm margin fold height. Punching possible right up to margins. Simple, rapid tool change carried out in seconds - even on fitted door. Limit stop system can be moved in X and Y directions.

Description:

- Stable press body in heavy-duty, torsionally-stiff welded construction, fitted on stands with rubber-bonded metal feet.
- Pivoting control panel with digital display, emergency stop button, electrical operating buttons and two-hand operation.
- Dual-action hydraulic cylinder, flanged force-locking and form-locking to machine body.
- Anti-twist piston rod \varnothing 63 mm made of tempered stainless steel with tool holder.
- Die bed, fixed force-locking to press body.
- Time relay for piston return saves working time.
- Hold-down device/scrapper combination with figure protection.
- X - Y limit stop system, easily movable in heavy-duty, precise profile roller guides.
- Form and force-fitting workpiece mounting and clamping device.
- Pivoting workpiece mounting left of press body for easy raising of workpiece.
- Locking of limit stop system using electrically-operated hydraulic brakes.
- Digital path measurement and display of X and Y travel with a display accuracy of 0.1 mm and a measuring accuracy of 1%.
- Rapid tool change helps in problem areas with a wide range of break-through types.
- Dual-circuit hydraulic unit with electric pump, oil container and solenoid valves (very low noise).

Technical data:

Overhang with limit stop:	800 mm
Punching stroke:	72 mm
Punching force F:	135 kN at 190 bar
Motor power:	1.5 kW
Operating voltage:	400 V
Weight approx.:	850 kg
Overall height:	1,700 mm
Working height:	1,000 mm
Width of puncher body:	280 mm
Depth of puncher body:	1,700 mm
Space requirement approx.:	2,360 x 4,440 mm

Punching capacity:

Circular from:	\varnothing 3.2 - 120.0 mm
Square up to:	110.0 x 110.0 mm
Special forms up to a max. diagonal of:	140.0 mm

Material thicknesses (max):

Sheet steel (S235):	3.0 mm
Stainless steel ($F = 600 \text{ N/mm}^2$):	2.0 mm
Aluminium ($F = 22 \text{ N/mm}^2$):	4.0 mm
Punchable plastics up to:	4.0 mm

ALFRA PRESS AP 800 (without options)

Prod.-No.
03400

Special tools can be manufactured in our own toolmaking works at short notice!



Pivoting control panel with two-hand operation



Form and force-locking workpiece mounting with quick-action clamping system



Tool holder, anti-twist in piston rod, hold-down device / scraper combination



Die holder, tool change also possible with fitted control cabinet door



Path measurement of X and Y travel



Dual-circuit hydraulic unit



Hold-down device/scraper combination

PUNCHING WITHOUT PRE-DRILLING



Overhang 800 mm

Stationary hole puncher - AP 800

Type	Designation	Prod.-No.
Machine	Stationary hole puncher ALFRA PRESS 800 in heavy duty welded construction, dual-action hydraulic cylinder, limit stop system can be moved in X and Y directions, hold-down device/scrapper combination with safety function, cylinder pistons with anti-twist device for use with all puncher sockets, dual-circuit hydraulic unit, movable control panel, time relay for piston return, pivoting workpiece mounting, die holder, rubber-bonded metal feet.	03400
Special fitting	Laser pointer for optical display of tool centre	03021
Puncher socket	with centring pin for round puncher with mounting shaft	03413
	with scraper and centring pin for round puncher with 19 mm female thread	03411
Die holder	Type A Ø 3.2 - 25.4 mm	03405
	Type B Ø 28.3 - 40.5 mm	03406
	Type C Ø 40.6 - 63.5 mm	03407
	Ø 64.0 - 80.0 mm	03408
	Ø 80.1 - 100.0 mm	03409

Square and rectangular hole punchers - AP 800

suitable for steel, for stainless steel applications on request, with mounting shaft and centring point, including die

Type	Designation	Prod.-No.	AP 250	AP 400	AP 500	AP 600	AP 800
Square holes	46.0 x 46.0 mm	03425					•
	68.0 x 68.0 mm	03491					•
	92.0 x 92.0 mm	03435					•
Rectangular holes	22.0 x 30.0 mm	03417					•
	24.0 x 36.0 mm	03419					•
	22.0 x 42.0 mm	03421					•
	35.0 x 65.0 mm	03428					•
	46.0 x 92.0 mm	03433					•
Special holes	Ø 22.5 mm with 2 lugs 3.2 mm	03452					•
	Ø 30.5 mm with 2 lugs 3.2 mm	03454					•
	Double louvre tool 100.0 x 8.0 mm up to 2.0 mm material thickness	03456					•

Circular punchers and dies - AP 800 suitable for steel and stainless steel

Type	Mounting holder	Ø in mm	Size Metric	Size PG	Prod.-No.	AP 250	AP 400	AP 500	AP600-2	AP 800
Puncher Ø 3.2 - 30.5 mm		3.2			03131	•	•	•	•	•
		4.5			03132	•	•	•	•	•
		5.4			03133	•	•	•	•	•
		6.5			03134	•	•	•	•	•
		8.5	M8		03135	•	•	•	•	•
		10.5	M10		03136	•	•	•	•	•
		12.7	M12	PG7	03137	•	•	•	•	•
		15.2		PG9	03138	•	•	•	•	•
		16.2	M16		03139	•	•	•	•	•
		18.6		PG11	03140	•	•	•	•	•
		20.4	M20	PG13	03141	•	•	•	•	•
		22.5		PG16	03142	•	•	•	•	•
		25.4	M25		03143	•	•	•	•	•
		28.3		PG21	03144	•	•	•	•	•
		30.5			03145	•	•	•	•	•
Puncher Ø 32.5 - 63.5 mm		32.5	M32		03146	•	•	•	•	•
		37.0		PG29	03158	•	•	•	•	•
		40.5	M40		03147	•	•	•	•	•
		47.0		PG36	03159			•	•	•
		50.5	M50		03148			•	•	•
		54.0		PG42	03160			•	•	•
		60.0		PG48	03161			•	•	•
		63.5	M63		03149			•	•	•
Die Ø 3.2 - 25.4 mm	TYPE A	3.2			03063	•	•	•	•	•
		4.5			03066	•	•	•	•	•
		5.4			03068	•	•	•	•	•
		6.5			03074	•	•	•	•	•
		8.5	M8		03076	•	•	•	•	•
		10.5	M10		03079	•	•	•	•	•
		12.7	M12	PG7	03022	•	•	•	•	•
		15.2		PG9	03023	•	•	•	•	•
		16.2	M16		03084	•	•	•	•	•
		18.6		PG11	03024	•	•	•	•	•
		20.4	M20	PG13	03025	•	•	•	•	•
		22.5		PG16	03026	•	•	•	•	•
		25.4	M25		03085	•	•	•	•	•
		28.3		PG21	03027			•	•	•
Die Ø 28.3 - 40.5 mm	TYPE B	30.5			03028			•	•	•
		32.5	M32		03163			•	•	•
		37.0		PG29	03029			•	•	•
		40.5	M40		03164			•	•	•
		47.0		PG36	03030			•	•	•
Die Ø 47.0 - 63.5 mm	TYPE C	50.5	M50		03168			•	•	•
		54.0			03031			•	•	•
		60.0		PG48	03032			•	•	•
		63.5	M63		03169			•	•	•

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YOUR NOTES

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A large grid of graph paper for taking notes. The grid is composed of small squares, with a larger square grid in the top right corner. The grid is intended for students to write their notes on.

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