

User report

For internal use only

Automotive industries



Clinking

Designation	Clinking frame
Type	DFB-850
Ident no.	00000087110
Manufactured	05/2012
Order no.	584883
Number	6 pieces and 2 pieces
Other	

Customer	DAIMLER
Location	Bremen (Germany)
Model	C-class BR 205 (W, S, C, A)
Component	Wing, front
Handling	by robots and stationary
Production line	Z3
S.O.P.	02/2014
Launch	03.2014 (Limousine)

Task:

Joining front fender left and right hand side consisting of 3 parts each of various material sheet thicknesses that should be joint without using adhesive. One difficulty is the restricted component accessibility to the fender support.



Solution:

The front fenders are manufactured without adhesive but with a clinking frame having an extremely narrow frame horn. In addition a die with a low construction height is used.

Only in this way the component accessibility is made possible for the joining tasks between fender sheet plate and support.

The components result in a sheet thickness mixture that is joint with one similar punch and die combination. A total of 11 clinking points is placed on each fender. The clinking frames are part of the servo motor-driven clinking system and they are designed for stationary as well as for mobile use on a robot.

Customer rating:

- always on-time deliveries
- unproblematic launch and use
- easy handling of user interface
- structured software
- good training material and structured qualification
- positively rated supplier

DFB-850

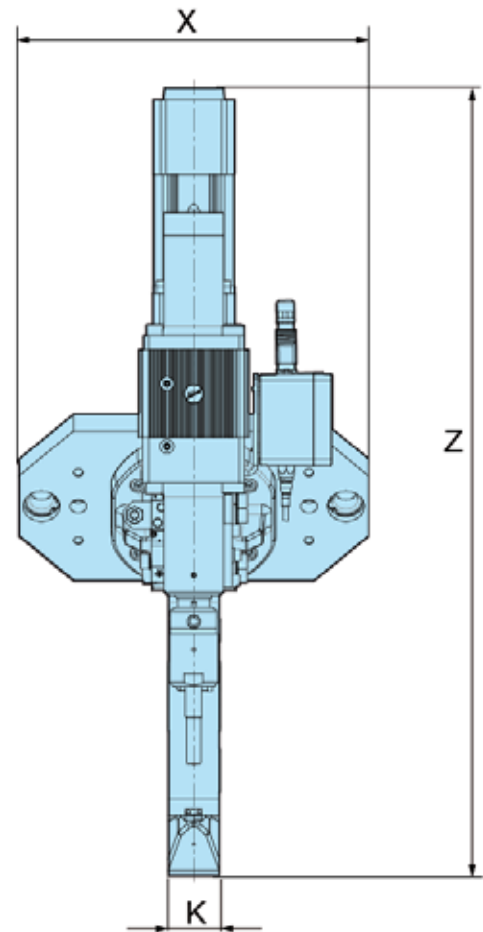
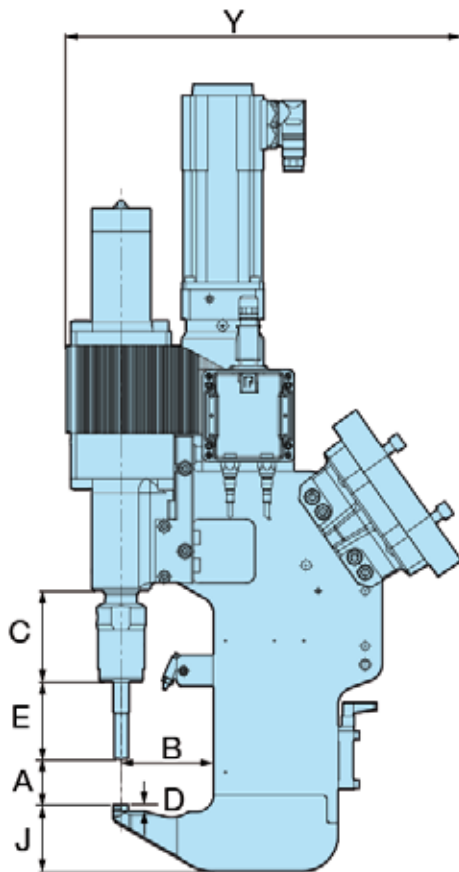


Flat die R-DF



Name	Clinching frame
Type	DFB-850
Ident no.	0000087110
Drive	servo motor-drive
Pressure force	max. 80 kN
Stroke length	50 mm
pneumatic pressure	min. / max. 5 / 6 bar
Weight	90 kg

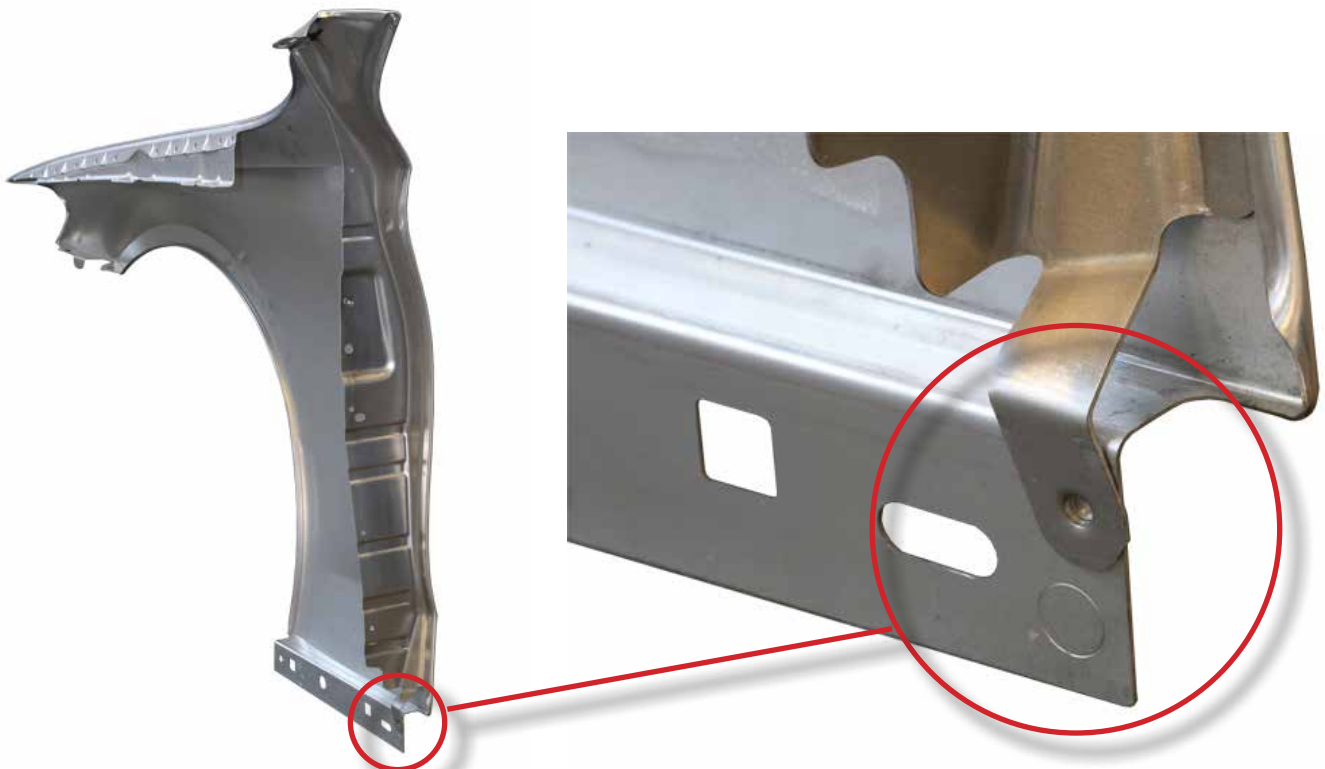
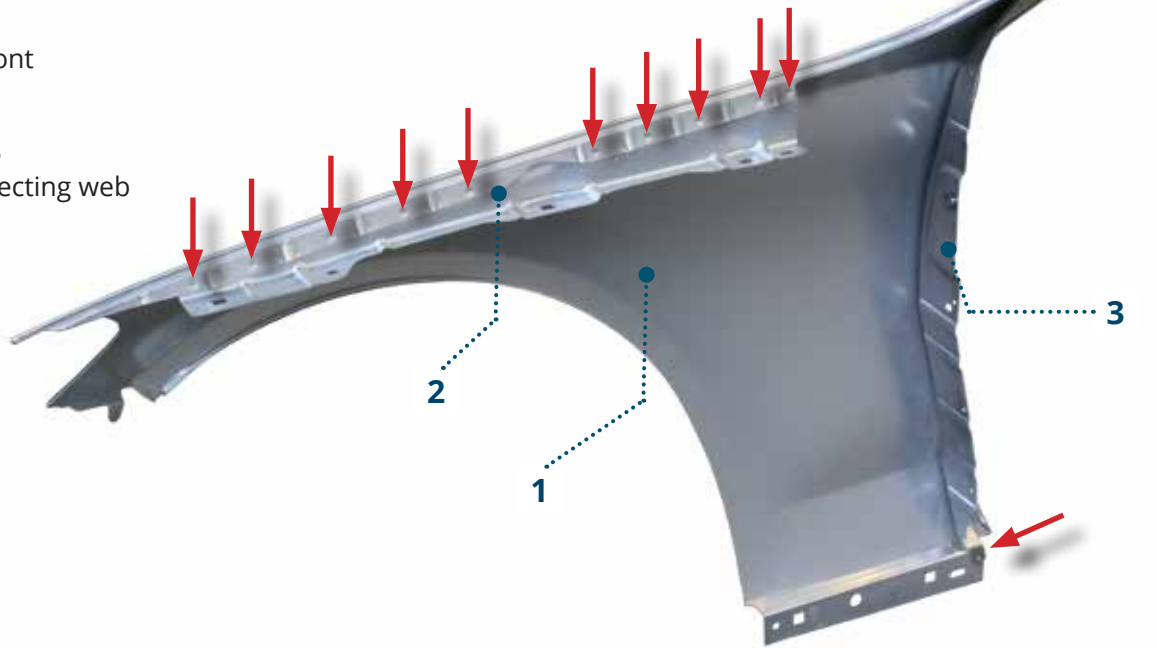
Opening width	[A]	[mm]	48
Throat depth, horizontal	[B]	[mm]	100
	[C]	[mm]	99
Tool holder protrusion at frame end	[D]	[mm]	6,8
Tool holder protrusion, ram side	[E]	[mm]	84,5
Frame end height	[J]	[mm]	73,5
C-frame width	[K]	[mm]	56
Width	[X]	[mm]	380
Length	[Y]	[mm]	429
Height	[Z]	[mm]	855,5



Joining task	1	2	
Clinching variant	R-DF 8	R-DF 8	
Component	t_1 Wing	Connecting web	
Material	t_1 Al	Al	
Punch side layer thickness	t_1 1,0 mm	1,0 mm	
Intermediate layer	none	none	
Component	t_2 Brace	Wing	
Material	t_2 Al	Al	
Die side layer thickness	t_2 1,5 mm	1,0 mm	
No. of clinching points	10	1	11

Wing, front

- 1 Wing
- 2 Brace
- 3 Connecting web



Servo motor-driven clinching system:

Overview and Setup:

- 1 **Clinching frame** for robot integration with servo motor drive and clinching tools (punch and die)
- 2 **Micro spray system** (optional accessory)
- 3 **Control cabinet** with servo regulator for drive unit and integrated process monitoring system, Visualisation software
- 4 **Cable set** for connection between control cabinet and clinching frame (in stationary design) and between control cabinet and robot base (when handling by robot)

Optional accessories:

- Micro spray system
- Floating mounting at clinching frame

(The illustrated components serve only as example and may differ in design and dimension.)



Trading successful for over 85 years

Since our company was established in 1936 by Walter Eckold, the only aspect of our business not to change from that year to this has been our commitment to our customers. Our priority remains to provide our customers with economical and environmentally viable cutting edge technological solutions to their ever changing manufacturing processes.

During our 80 years of trading we have amassed a knowledgeable highly skilled engineering workforce in our specialist areas of shaping and joining sheet metal. These specialist skills enable us to quote from one off standard pieces of equipment to fully tailor-made automated robotic systems. A full range of all our specialist techniques can be found in all sheet metal, craft and industry work-places. Join with us, the successful sheet metal experts, to shape your future metalworking solutions.

Service von A-Z

- Tests and analyses for our customers
- Creation of sample sheets/components
- Preparation of feasibility studies for the design of moulds
- Concept development and constructive realisation of the technical solution
- Production in our own factory
- Commissioning at the customer's premises
- Carrying out regular maintenance
- Support with optimisations in the customer's process
 - Support with the robot position teaching process
 - Creation of micrographs / evaluation of clinching point quality
 - Online support

Start-up support after commissioning up to SOP

Training of system operators/maintenance staff/experts

Data and facts

- Founded in 1936
- Products in use in over 100 countries
- Over 25 sales partners worldwide
- Sales companies in Great Britain, Hungary, USA
- Certified according to ISO 9001:2015
- Certified according to ISO 14001:2015



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