

# Apress 250

Overhang 250 mm



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 breakthrough 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/mm <sup>2</sup> ):	2.0 mm
Aluminium (F = 22 N/mm <sup>2</sup> ):	4.0 mm
Punchable plastics:	4.0 mm

Prod.-No.

ALFRA PRESS AP 250 (without options)

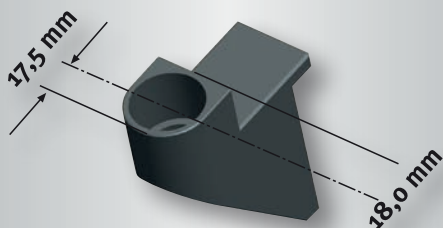
03170

**Note:**

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

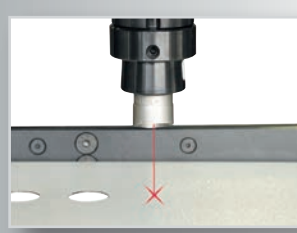
**Special tools can be manufactured in our own toolmaking works at short notice!**

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

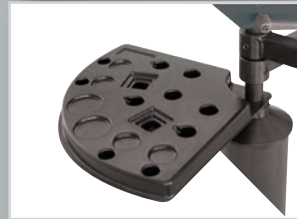


Smallest-possible axial dimension (border spacing) when using die holder Type I

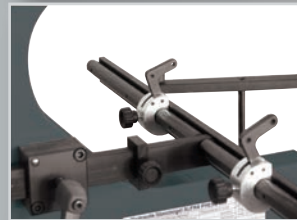
Prod.-No. 03174



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)



Prod.-No. 03190

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

# APress 250

Overhang 250 mm

## Stationary hole punch - 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 punch 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
Punch 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 punch 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 punches - AP 250 (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 punch socket (03171) Ø 3.2 - 30.5 mm	03185	●	●			
	for punch socket (03172) Ø 30.6 - 40.5 mm	03186	●	●			

## Circular punches and dies - AP 250

Type	Mounting holder	Ø in mm	Size Metric	Size PG	Prod.-No.	AP 250	AP 400	AP 500	AP 600-2	AP 800
Punch 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 - 40.5mm	TYPE IV	32.5	M32		03165	●	●			
		37.0		PG29	03166	●	●			
		40.5	M40		03167	●	●			