Press fitting - the reliable way

100% QUALITY CONTROL FOR MANUALLY OPERATED PRESSES
Price and quality pressures are constantly rising, squeezing out any room for manufacturing defects. There is an ever-increasing need to monitor not only complex operations but also simple production and assembly processes.

Prevent costly product recalls! To obtain certainty for yourself and your customers, you need to be able to make reliable, quality-relevant statements about the components you manufacture. This particularly applies to monitoring press-fit operations on manual presses. There are many applications in this field in which margins are tight, and budgets and time are strictly limited.

You reduce cost-intensive defects and enhance your production output.
You monitor every process 100%.
You prevent expensive product recalls that harm your image.
You create the documented certainty that your customers demand.
You will access new markets, applications and customers.

SUSTAINABLE FOR YOUR RESOURCES
Do you already use manual presses and carry out monitoring via visual checks or by feel? Then it’s time to act!
Eliminate all uncertainties and equip the manual presses you are using with the press-fit monitoring system that’s right for you. With our 3-solution concept you render the processes on your manually operated or pneumatically/hydraulically assisted manual presses reliable and documentable in next to no time.

HOW MUCH PRESS-FITTING CONTROL DO YOU NEED TO PRODUCE 100% FAULT-FREE?
Together let’s choose the right tools for monitoring your manual presses and tailor them precisely to your needs!
We offer 3 different solutions to cover all of your manual press applications.
Especially in areas you might not have considered yet, e.g. small production runs in mechanical engineering and component assembly, medical technology, electrical engineering, pharmaceuticals and household appliances.

Monitor everything Efficient and profitable Fast and reliable
In production, laboratory or in test facilities
On all standard manual presses
Can be fitted to existing or new presses
Extremely attractive entry-level prices
Continuous monitoring for less than 0.3 cents/part
Built-in visual/acoustic signaling and part counter
Plug & Work in 30 minutes
Autoconfig mode instead of time-consuming adjustment work
Tamper-proof and practical designs

burster COMPLETE – THE EASY WAY TO GET STARTED
You choose the right solution for your application as well as current and future requirements, from our 3-solution concept. Whether very simple or highly complex, for small or large quantities, with our 3 different solutions you will gain 100% certainty. Benefit also from our all-round service package that makes selection, setup and operation easy.
The 3-solution concept

**MANY APPLICATIONS, ONE GOAL: 100% MANUAL PRESS MONITORING.**

Whichever option fits the current requirements profile for your business or holds promising potential for the future – our monitoring concepts are the right way to go. You will also benefit from our all-round service offer that makes setup and initial operation easy.

**BASIC SOLUTION**
- Low-cost for self-contained workstations
  - ForceMaster 9110
  - Load cells 8451/8552
  - Only force or force-displacement monitoring
  - Displacement transducer 8712/8713
  - Accessories and service support

**COMFORT SOLUTION**
- Flexible with various evaluation capabilities and graphical of the process display
  - DIGIFORCE® 9311
  - Load cells 8451/8552
  - Displacement transducers 8712/8713
  - Accessories and service support

**HIGH-END SOLUTION**
- Innovative, high-precision solution with countless measurement and evaluation options
  - DIGIFORCE® 9307
  - Load cells 8451/8552
  - Precision tension and compression load cells 8431/8432
  - Displacement transducers 8712/8713
  - Accessories and service support

From simple force indication to recording complex force-displacement processes, our systems solve all tasks in countless applications.

- Assembling gears
- Press-fitting case lids
- Press-fitting sealing plugs
- Clearance checks for pumps
- Fitting connecting plugs
- Mounting shaft sealing rings
- Powder compaction
- Fitting watch hands
- Press-insertion of ball bearings
- Crimping sleeves/ connectors
- Inserting balls to seal holes
- Electrical component assembly
- Spring testing with hysteresis monitoring
- Monitoring snap-fit processes

**THE IDEAL STARTER PACKAGE**
FOR MANY BASIC APPLICATIONS
Basic – economical, for self-contained workstations

100% CONTROL, 100% LOW-COST.

The basic solution is a straightforward and simple yet effective way to control processes. We recommend this complete package when you want process control with very low overall costs.

COMPONENTS IN THE BASIC SOLUTION:

- **ForceMaster 9110**
  Measuring instrument specially developed for manual presses, for press-insertion and joint monitoring
- **Load cells 8451/8552**
  Robust, easy to fit, mechanical overload protection
- **Displacement transducers 8712/8713**
  Durable, simple to mount, low-cost, precise

SIMPLe PROCESS CONTROL FOR MANY APPLICATIONS

- Press-fitting case lids, sealing plugs etc.
- Assembling gears
- Powder compaction
- Clearance checks for pumps
- Fitting watch hands
- Mounting shaft sealing rings

FEATURES OF THE BASIC SOLUTION WITH **ForceMaster 9110:**

- Unbeatably low-cost
  - Perfect control at entry-level price
  - Plug & Work cuts downtimes
- Simply fast
  - Plug & Work in 30 minutes
  - Autoconfig mode with automatic settings for evaluation tools
  - Automatic sensor recognition
  - Even inexperienced staff can set it up
- Impressively easy
  - Load cell is easy to attach to almost any standard manual press
  - Visual and acoustic signaling
- Practical, well-thought-out
  - Onboard part counter
  - Data logging on USB flash drive
  - Fast part changes with smart-card system
  - Optionally with force or force-displacement monitoring
  - Tamper-proof

Example applications:

- **AUTOMOTIVE SUPPLIERS**
  Pressing cast housings
- **ELECTRICAL ENGINEERING**
  Press-fitting IDC connectors
- **ENGINE PRODUCTION**
  Mounting shaft sealing rings
- **MEDICAL TECHNOLOGY**
  Fitting valves on infusion pumps
- **PLASTICS INDUSTRY**
  Joining plastic membranes in a metal housing

Please see our website for more product details.
**Comfort – flexible process monitoring**

100% CONTROL, 100% CONVENIENT.

**The comfort solution** is used wherever force-displacement curves need to be displayed. Enormous flexibility in measurement value acquisition, variable evaluation elements and a wide range of process dialogs render process control particularly convenient.

**COMPONENTS OF THE COMFORT SOLUTION:**

- **DIGIFORCE® 9311**
  Process controller with wide performance scope
- **Load cells 8451/8552**
  Robust, easy to fit, mechanical overload protection
- **Displacement transducers 8712/8713**
  Durable, simple to mount, low-cost, precise

**FEATURES OF THE COMFORT SOLUTION WITH DIGIFORCE® 9311:**

- **Impressively versatile**
  - Displays force-displacement curve
  - 16 measurement programs
  - Facility to combine window and envelope evaluation
  - View and analyze the last 50 measurements
  - Configurable function keys on touch display

- **Fast and powerful**
  - Live value display for force and displacement signals
  - Convenient measurement data logging with DigiControl PC software or on a USB flash drive

- **Can be integrated anywhere**
  - Equipped with all relevant fieldbus interfaces
  - Flexible start/stop conditions for the measurement phase

**CONVENIENT PROCESS CONTROL WITH PRECISE EVALUATION**

- Press-insertion of ball bearings
- Crimping sleeves and connectors
- Inserting balls to seal holes
- Assembly of electrical components

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**Example applications:**

**AUTOMOTIVE MANUFACTURERS**

- Riveting process on vehicle brake liners

**ELECTRIC MOTOR MANUFACTURE**

- Fitting shafts to electric motors

**DRIVE TECHNOLOGY**

- Random-sample testing in snap-disc production

Please see our website for more product details.
High-end – for complex measurement processes

The high-end solution is suitable for combining a large range and variance of components with control of complex processes. A huge range of individual measurement programs and diverse interfaces make the DIGIFORCE® 9307 a solution that meets the highest requirements for measurement and integration.

COMPONENTS IN THE HIGH-END SOLUTION:

- DIGIFORCE® 9307
  Process controller with outstanding measurement accuracy
- Load cells 8451/8552
  Robust, easy to fit, mechanical overload protection
- Precision tension and compression
  load cells 8431/8432
  High-precision, immune to interference, convenient load application
- Displacement transducers 8712/8713
  Durable, simple to mount, low-cost, precise

FEATURES OF THE HIGH-END SOLUTION WITH DIGIFORCE® 9307:

- Hugely versatile
  - 128 measurement programs for a large variance of components
  - Evaluations with graphical elements and mathematical functions
- Universal
  - For all standard sensor interfaces
  - Control and configuration via fieldbus
- Unsurpassed convenience
  - Large 5.7” high-quality color display
  - Numerical keypad
- Perfect control
  - Versatile, innovative evaluation and analysis elements
  - Intelligent signal detection for complex force-displacement curves
  - Comprehensive diagnostics and statistical analysis tools

COMPLEX PROCESS CONTROL FOR DEMANDING APPLICATIONS

- Spring testing with hysteresis monitoring
- Snap-fit assemblies

Example application:

AEROSPACE ENGINEERING
Hysteresis testing on safety switches

Please see our website for more product details.
Global control: any press anywhere
MONITORING MATTERS JUST AS MUCH AS THE PRESS.

JUST EASY-PeASY: Control any manual PRESS WITH THE RIGHT SOLUTION

All sorts of businesses use manual presses. Countless manual workstations are fitted with widely different models and designs of manual presses. They are an indispensable tool in the small to moderate-scale production and assembly of components. They also provide a vital service in goods-inwards inspection and random sample testing of springs and moving assemblies.

There are numerous national and international press manufacturers producing general-purpose presses for these tasks. These presses can be retrofitted quickly and require practically no maintenance. They offer unrivalled efficiency for a range of production processes and batch sizes.

We have the right monitoring solution for whatever press you use. You can use our monitoring systems to guarantee 100% quality control and avoid costly and easily preventable mistakes. This boosts your productivity and provides documented peace-of-mind for you and your customers.

Compatible press models
- Rack-and-pinion presses
- Toggle presses
- Hydraulic presses
- Pneumatic presses
- Electric presses
- Eccentric presses

Highlights
- Hand-lever presses can be easily retrofitted with force and displacement sensors as well as evaluation electronics
- Range of forces 0 ... 2.5 N to 0 ... 100 kN
- Force measurement precision to 0.2 % F.S.
- Direct force measurement in the direction of the press ram axis
- Various mounting options for the displacement sensors to suit task in hand
- Automatic sensor recognition

The standard setup is to fit the load cell as an extension of the press ram, so that it measures the applied force directly inside the axis (directly at the tool). The displacement transducer (optional) moves co-jointly with the travel of the press ram, travelling in parallel with the ram axis at the side of the press head. The mounting plate between press head and displacement transducer helps to align the axes exactly in parallel with each other. The clamp-on carrier, which is attached to the load cell, transfers the movement to the displacement sensor.

Our how-to-do video shows how to fit the load cell and displacement transducer to a manual press. It is available to download from: http://goo.gl/MBkWMN

Practical – load cells and transducers
FOR FORCE AND DISPLACEMENT MEASUREMENT.

PRESS LOAD CELL 8552
Features
- Measuring ranges from 0 ... 100 N to 0 ... 25 kN
- Mechanical overload protection
- Different diameters of pin and hole can be selected
- Compact overall height
- Simple mounting on press ram

For the following applications
- Forces when joining parts
- Press fittings
- Bending forces during deformation of materials
- Cutting forces
- Stamping forces
- Punching forces for blanks
- Breakaway forces in destructive testing

Options/Accessories
- Connecting cable in 3 m or 5 m length
- Linear bushing for particularly precise guidance

PRESS LOAD CELL 8451
Features
- Measuring ranges from 0 ... 0.5 kN to 0 ... 100 kN
- Measurement accuracy starting from 0.5 % F.S.
- Protection class IP67
- Rugged construction, works even under transverse forces
- Simple mounting on press ram

For the following applications
- Forces when joining parts
- Press fittings
- Bending forces during deformation of materials
- Cutting forces
- Stamping forces
- Punching forces for blanks
- Breakaway forces in destructive testing

Options/Accessories
- Connecting cable in 3 m or 5 m length
- Linear bushing for particularly precise guidance

PRECISION MINIATURE LOAD CELLS 8431/8432
Features
- Measuring ranges from 0 ... 2.5 N to 0 ... 500 N
- High measurement accuracy from 0.2 % F.S.
- Minimal sensitivity to lateral forces thanks to support diaphragms

Typical application areas
- Switch and haptic testing
- Precision engineering
- Watch industry
- Medical technology
- Instrument manufacture

Options/Accessories
- Centring and mounting adapters for press ram
- Overload protection
- Hermetically sealed version

POTENTIOMETRIC DISPLACEMENT TRANSDUCERS 8712/8713
Features
- Measuring ranges from 0 ... 10 mm to 0 ... 150 mm
- Non-linearity from ± 0.05 % F.S.
- Service life 10^8 movements
- Available with spring inside or outside

Typical application areas
- Measuring pressing depth, deformation, sag and breaking stresses
- Operating travel of switches and buttons

Options/Accessories
- Attachment parts for mounting
- Sensing tips for various different requirements
- 5-pin connecting plug (8712)
- Mating connector and connecting cable (8712)
- Integral connecting cable in 1 m or 3 m length (8713)

Please see our website for more product details.

© Pinion
We would be pleased to support you fitting reliable instrumentation to your existing manually operated presses. Our service offering ranges from analyzing your requirements and selecting the right products, to installation, training and calibration so that maximum availability is permanently maintained.

**Benefit from our tailored service packages for our 3-solution concept**

**SERVICE PACKAGE 1:**
Install sensors and connection of the controller on existing manual presses

**SERVICE PACKAGE 2:**
Startup of an equipped manual press and training on sensors and controllers

**SERVICE PACKAGE 3:**
Maintenance and calibration

**Complete retrofitting**
We can fit sensors and a process monitoring system to almost all standard manual presses. We offer you comprehensive support from connecting the instrumentation and initial operation to maintenance and calibration for your manual workstations.

**Comprehensive advice**
How large are the forces that actually occur? Can an existing press tool still be used? It is understandable that you have questions – we find the answers: Following a detailed consultation, send us test specimens on a no-obligation basis and we will calculate the forces that arise. Alternatively, after a detailed consultation, our service technicians can carry out test measurements on your premises.

Do you need test equipment for your existing manual press? Here too, we will be pleased to assist you. Just talk to us on a no-obligation basis.

Check online at www.burster.com to find your regional contact who will consult and support you individually.
Do you need to meet ISO 9001 requirements for test equipment monitoring? With our on-site calibration service, you avoid production downtime and do not need to dismantle your machinery. After consultation the option of on-site calibration can be considered when applicable. We specialize in calibrating 1 N to 200 kN load cells.

Our modular concept meets all quality standards and application-specific requirements, whether you are using burster products or third-party equipment.

Test and calibration certificate
- economical, fast and verifiable calibration on-site or in the lab.

Factory calibration
- in our laboratory or on-site additionally provides verifiable statements concerning measurement uncertainty.

DAkkS calibration
- satisfies the highest standards and requirements. We or our partners are accredited in accordance with DIN 17025.

Check online at www.burster.com to find your regional contact who will consult and support you individually.

TRANS CAL 7281 PRECISE CALIBRATION IN YOUR HAND

Our unique mobile high-precision calibrator and testing device is the smart, robust and traceable solution for your calibration requirements. With TRANS CAL 7281, you or our experts can perform mobile, on-site calibrations with high accuracy and without dismantling.

Performance profile
- Device test / strain gauge simulator
- Reference measurement chain
- Sensor test

Device test / strain gauge simulator
- Infinitely adjustable simulation values: up to ± 50 mV/V, up to 10 VDC
- Measurement: U_supply up to 10 VDC

Reference measurement chain
- in combination with a reference sensor

Sensor test
- R, R₀, Shunt, R_ISO

With our comprehensive service concept, not only can you find a manual press monitoring solution that is exactly tailored to your needs, you can also depend on us at all times. Modular components for planning, implementing and operating your manual press monitoring system cover all relevant aspects of your task – whether purchasing new equipment or retrofitting sensors to an existing press. From measuring physical properties to calibrating the finished system, from optimization to servicing and repairs.

KNOWLEDGEABLE APPLICATION SUPPORT
Our experts are happy to provide advice and help based on their experience gained over many years in production process monitoring and quality assurance.

OPTIMIZATION ADVICE
We make sure that you benefit from your measurement equipment while processes are running by continuously improving and optimizing your systems.

USER TRAINING
In structured and efficient training units designed for commissioning engineers, service staff and production personnel, your staff learn how to integrate and use our ForceMaster and DIGIFORCE® controllers and sensors smoothly and effectively. In these training sessions we look specifically at your application.

SYSTEM SETUP/COMMISSIONING
The clear operating structure of the ForceMaster and DIGIFORCE® controllers together with detailed fitting and mounting instructions and how-to-dos videos enable you to independently install, setup and/or retrofit your measurement system. In more complex system environments and for custom-modified applications, we can provide a service technician to assist with on-site integration, fieldbus connection, configuration and evaluation. We offer worldwide support.

CALIBRATION SERVICES
Our accredited calibration centre offers you optimum reliability and traceability for initial calibration and recalibration of your ForceMaster and DIGIFORCE® controllers and accompanying sensors. We can quickly provide German-accredited DAkkS or factory calibration certificates by appointment. After consultation with us also on-site calibration can be considered where applicable to avoid production down-times. Our experienced service engineers and service partners can provide support with detailed testing.

INTERNATIONAL ASSISTANCE & SUPPORT
ForceMaster and DIGIFORCE® systems run in applications worldwide. So you are right to expect also worldwide service. In cooperation with our international partner network we support you on-site exactly where our products work for you.

Check online at www.burster.com to find your regional contact who will consult and support you individually.
Manual rack-and-pinion or toggle presses usually have a circular or square press ram. It is important to choose the correct sensor type for these manual presses whether purchasing the full assembly new or retrofitting sensors to an existing press. The following handy tips on mechanical requirements, installation conditions and technical measurement issues are intended to help you select the right load cell and displacement transducer and to fit them quickly and easily to your manual press.

When using load cells 8451/8552 (different ram/bore diameters are available), these can usually be secured in the press ram using a grub screw. 

**This ensures that the load cell is fixed centrally with no possibility of movement or twisting.**

Please get in contact to discuss this or other fitting options. We can help you find a solution that makes both technical and economic sense.

**LOAD CELL**

**What is the correct measurement range for the load cell?**

The relevant figure here is the range needed to measure forces that occur during your joining process, not the compression force range of the manual press!

**How to attach the load cell to the press ram?**

**Example:** Manual press with an internal hole in the press ram

*Ram with internal bore and grub screw*  
*Load cell contact area, via which force is transmitted*

When using load cells 8451/8552 (different ram/bore diameters are available), these can usually be secured in the press ram using a grub screw. 

**This ensures that the load cell is fixed centrally with no possibility of movement or twisting.**

Please get in contact to discuss this or other fitting options. We can help you find a solution that makes both technical and economic sense.

**FAQs**

**HELPFUL AND USEFUL TIPS.**

**What are the most commonly used measurement procedures?**

**Simple force monitoring** to determine whether the force has reached and/or not exceeded the defined limits during press-insertion under identical time conditions.

**Detect and evaluate** tolerance deviations and correct alignment or misalignment of parts during the joining process, using various analysis tools.

**What happens if the load cell is overloaded?**

- The load cell may be destroyed and/or may have a much shorter service life
- The measurement properties will be impaired

**Load cells 8451/8552** with built-in mechanical overload protection (up to 10 times the upper range value)

**Protection against temporary static overloads.**

**Preventing external forces!**

**DISPLACEMENT TRANSDUCER**

Often it is not enough just to record the press-insertion force to obtain a meaningful assessment of a process. Factors such as special component geometries, a significant “feed-in length”, different insertion speeds or the need to evaluate the required blocking dimension often require the use of a displacement transducer in addition to a force sensor.

**What is the total travel of the manual press and what is the maximum pressing depth that needs to be detected and evaluated?**

For designing the measurement range of the displacement transducer, a useful measure is a value between the total travel of the manual press and the maximum insertion depth/press-fit distance.

**How to fit an additional displacement transducer to the manual press and what should be kept in mind?**

The main point to consider is: Determine first of all whether the displacement transducer should be fitted centrally or on the left-hand or right-hand side of the manual press.

- A mounting surface of about 70 x 47 mm is required when using the attachment kit
- By means of two fixing holes, this set is very simple to attach to all kinds of different manual press models
- Specially designed ridges mean there is no need for additional modification of the mounting surface
because progress needs vision.

burster, the specialist for measuring equipment and sensors, delivers the ideal solution that meets your requirements to a T. We offer you forward-looking products, system solutions and a comprehensive suite of services to supplement our product range. With personal commitment and an uncompromising focus on quality.

measuring technology with perspective.