

**ADVANTAGES OVER LARGER MORE EXPENSIVE MECHANICAL PRESSES**

**OVERVIEW**

The Z-Series Air-Hydraulics Impact Hammer has a number of advantages over larger and more expensive mechanical presses, which are used to perform the same task. The operation is opposite to that of the mechanical press. With the impact hammer, the stroke is constant and impact pressure may be adjusted up to the press' capacity. This pressure then remains the same at any point along the stroke, so variations in stock thickness or improper positioning are eliminated by these features.

**OPERATIONS**

Before the impact stroke begins, equal air pressure is exerted on both sides of the piston in the cylinder. When the impact hammer is actuated, air is quickly exhausted from the bottom side of the air cylinder causing an "exploded" action on the top side of the piston, producing maximum impact at the constant specified stroke. Impact can be adjusted by lowering the cylinder head, thus shortening the stroke or adjusting the dump valve to restrict exhaust.

**APPLICATIONS**

Light Stamping, Forging, Trimming, Molding, Crimping, Coining, Riveting, Staking, Forming

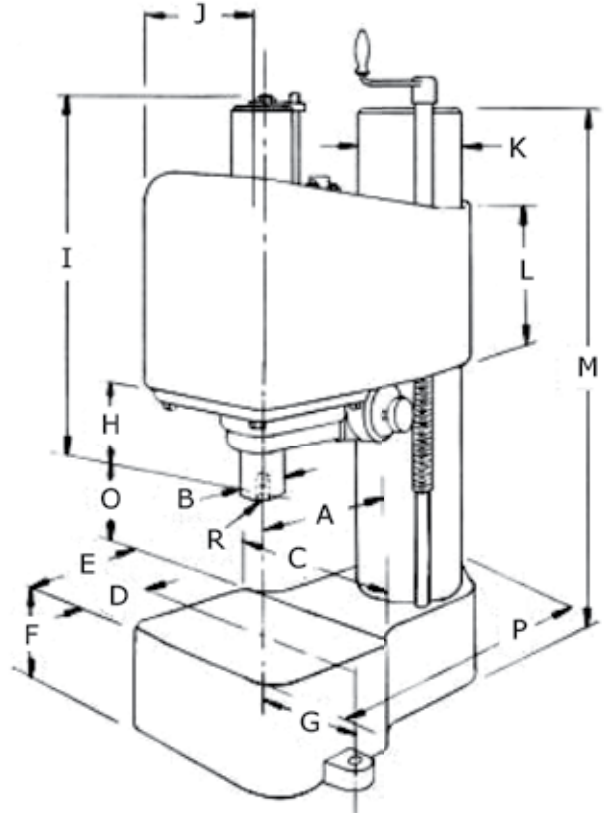


**SPECIFICATIONS**

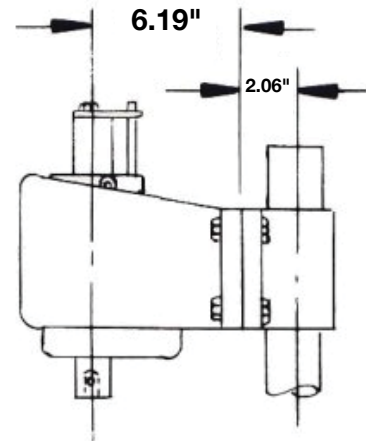
Description	Model Z-2 Impact Hammer	Model Z-6 Impact Hammer
Max. Impact In Tons With 100 PSI Air	6	20
Cylinder I.D.	3.50"	6"
Ram Diameter	1.50"	2.25"
Constant Stroke (For Max. Impact)	3"	4"
Overall Stroke	4"	5"
Open Height (Center of Ram to Column)	5"	11"
Throat Size (Center of Ram to Column)	6.78"	8"
Platen Area	10" x 8.75"	11" x 8"
Air Cushion at Bottom of Stroke After Max. Impact	Yes	Yes
Strokes per Cu. Ft. of 100 PSI Air	50	15
Strokes per Minute	60	60
Connecting Pipe Size	.375"	.500"
Shipping Weight in lbs.	210 lbs.	800 lbs.
Hole Size in End of Ram	.562" x 1.50"	.875" x 1.75"
Cubic Inch of Air per Cycle	29.096	111.01
Lift at End of Ram with 100 PSI Air	137 lbs.	369 lbs.

**Z-SERIES DIMENSIONS**

<b>DIMENSIONS</b> (U.S. Inches)		
<b>DIM KEY</b>	<b>Model Z-2</b>	<b>Model Z-6</b>
A	6.78	8.00
B	1.50	2.25
C	10.00	11.00
D	3.25	4.00
E	8.75	8.00
F	3.88	5.00
G	5.63	6.50
H	5.00	5.00
I	19.00	20.63
J	7.00	9.250
K	2.94	5.94
L	9.125	9.00
M	26.00	34.00
N	0.38	0.50
O	8.00	15.00
P	19.75	14.50
R	0.56	0.88
S	3.00	4.00
T	6.00	20.00
N = Connecting Pipe Size		
R = Hole in End of Ram		
S = Stroke for Best Results		
T = Max. Tons Impact		



**MODEL Z-2 ONLY**



**Z-SERIES FEATURES & OPTIONS**

Our objective is to offer you a solution to your assembly and forming needs. If our standard features or available options do not meet your application requirements, please consult our factory to see about us offering an affordable solution to meet your design needs.

**STANDARD FEATURES**

- All pneumatic operation
- Chromed cylinder tube and column
- Non-Rotating Ram
- Adjustable daylight opening
- Speed and pressure control
- Riser Screw Adjustment (Model Z-6 only)
- Two-Hand / Non-Tie Down Pneumatic Actuators
- Remote T-Stand for Actuators (Model Z-6 only)

**AVAILABLE OPTIONS**

- Increased Daylight Opening
- Impact Head Sold Separately (Model Z-2 only)
- Custom Designed Machine Base
- Impact Force Monitor Package
- Custom Designed Guarding

**MODEL Z-2 IMPACT HAMMER**

- Extended palm button brackets
- All pneumatic operation
- Adjustable daylight opening

**MODEL Z-6 IMPACT HAMMER**

- Remote T-Stand for Actuators
- Riser Screw Adjustment
- Two-Hand / Non-Tie Down Pneumatic Actuators

**ISO 9001 REGISTERED (WITH DESIGN)**

Air-Hydraulics is committed to delivering quality products on time to achieve customer satisfaction. Air-Hydraulics uses a process approach to achieve this policy in accordance with ISO 9001 and is committed to continually improve at this process.

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