

Built-in impact units

Technical data sheet

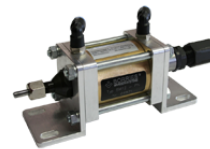
- Suitable for almost every plastic model deformable material
- Marking tools: steel types, engraved stamps or numbering heads
- Impact power is variable
- Big usable stroke (depending on the design from 22 up to 150 mm available)

Application area

Pneumatically controlled BORRIES built-in impact units are suitable amongst others for marking applications on transfer lines, rotary tables or testing stations. Because of the big usable stroke workpieces with different heights can be marked without any adjusting.

BM 12 PN

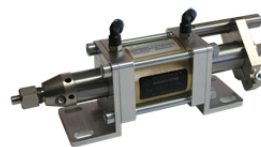
Smallest built-in impact unit with an impact power up to 6 kN.



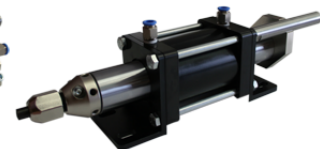
BM 12 PN

BM 22 PN / BM 25 PN

Slim and powerful built-in impact units with an impact power up to 18 kN (BM 22 PN) or 35 kN (BM 25 PN).



BM 22 PN



BM 25 PN

BM 21 PN

Built-in impact unit with an impact power up to 37 kN.



BM 21 PN

BM 35 PN

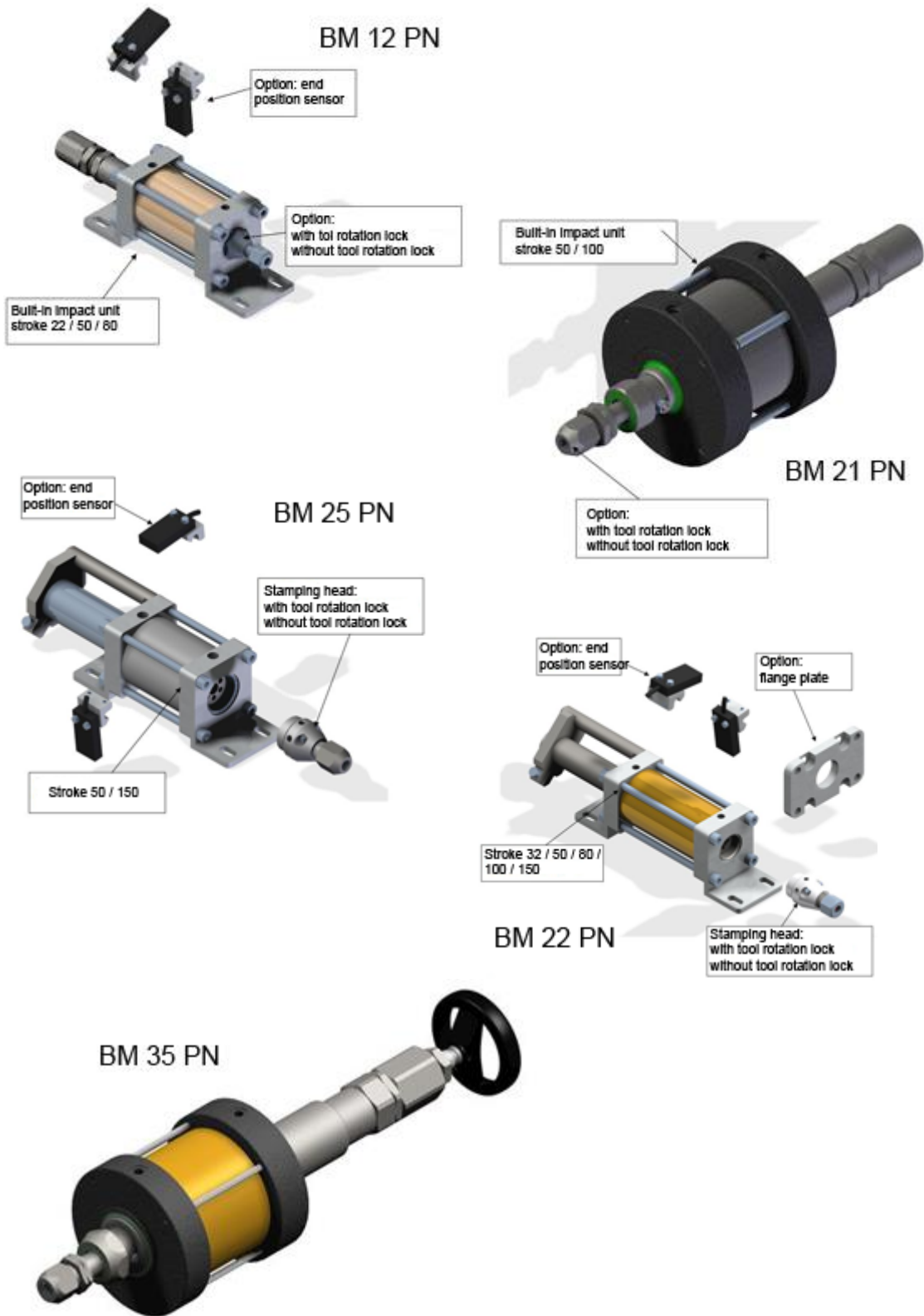
Powerful built-in impact unit with an impact power up to 113 kN.



BM 35 PN

No original sizes-/proportions.





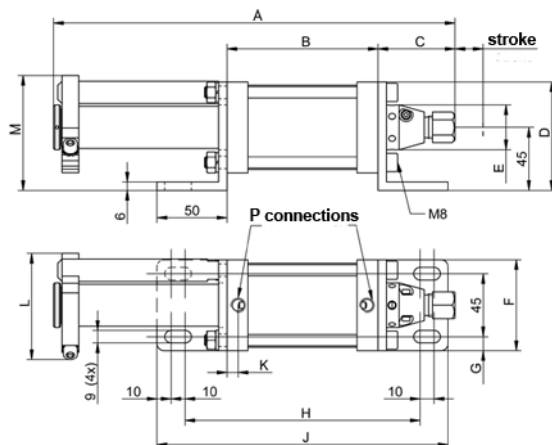
Technical data

	BM 12 PN	BM 22 PN	BM 21 PN	BM 25 PN	BM 35 PN
Dimensions of the tool holder*	Ø 8 mm 25 mm	Ø 10 mm 21 mm	Ø 10 mm 35 mm	Ø 10 mm 21 mm	Ø 16 mm 45 mm
Usable stroke	22 mm 50 mm 80 mm	32 mm 50 mm 80 mm 100 mm 150 mm	50 mm 100 mm	50 mm 150 mm	90 mm
Max. operating pressure	5 bar	6 bar	5 bar	6 bar	5 bar
Air consumption per lift approx.*	0,5 l (geölt)	0,9 l (32 mm) 1,2 l (50 mm) 1,7 l (80 mm) 2,2 l (100 mm) 3,2 l (150 mm)	0,7 l (oiled)	1,2 l (50 mm) 3,2 l (150 mm)	2,7 l (oiled)
Max. impact sequence per hour approx.	1.500	1.550	1.500	1.550	1.500
Impact power range approx.	2 kN to 6 kN**	18 kN	5 kN to 37 kN**	35 kN	30 kN to 113 kN**

* Stamps cannot be interchanged between the different built-in impact units.

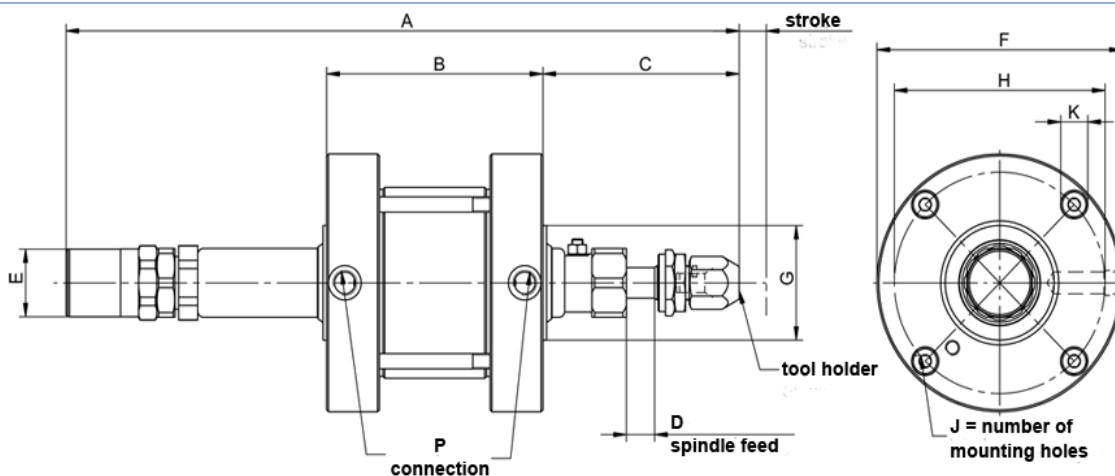
** Depending on the impact spring used and on the set impact force.

Dimensions



Type	A	B	C	D	E	F	G	H	J	K	L	M	P
BM 12 PN (22 mm stroke)	218	88	44	77,5	Ø 29,5	65	10	148	188	7	-	-	R 1/8
BM 22 PN (32 mm stroke)	251	90	55	77,5	Ø 32	65	10	150	190	8	74,5	82	R 1/8
BM 25 PN (50 mm stroke)	298	108	68	82,5	Ø 40	75	15	168	208	7,5	76,4	-	R 1/4





Type	A	B	C	D	E	F	G	H	J	K	P
BM 21 PN (50 mm stroke)	403	119	110	15	Ø 39	Ø 135	Ø 60	Ø 116	4	M 8	R ¼"
BM 35 PN (90 mm stroke)	700	194	130	25	Ø 124	Ø 184	Ø 90	Ø 90	4	M 8	R ¼"

Marking power (max. numbers of characters*) with using of BORRIES steel types and type holders

	BM 12 PN		BM 22 PN		BM 21 PN		BM 25 PN		BM 35 PN	
	Steel	Alu	Steel	Alu	Steel	Alu	Steel	Alu	Steel	Alu
Character height 1,0 mm	7	14	11	21	12	23	14	24	36	75
Character height 1,5 mm	6	13	10	20	11	22	13	23	30	70
Character height 2,0 mm	5	12	8	18	9	20	11	21	26	65
Character height 2,5 mm	4	10	7	16	8	18	10	19	19	60
Character height 3,0 mm	3	8	6	14	7	16	9	17	17	55
Character height 4,0 mm	2	6	5	11	6	12	8	14	15	50
Character height 5,0 mm	1	5	3	9	5	10	6	12	12	46

*) These details are rough standard values. Exact information can only be made after a sample marking with an original workpiece.

Technical details are subject to change.

