

**DELIVERS AN ACCURATE STROKE WITH NO LUBRICATION REQUIRED**

**OVERVIEW**

The AP-Series Black and Webster Air Press is a highly accurate air press for assembly operations. These units have a rugged cast iron frame with standard features that include a non-rotation ram guide, adjustable stroke, angled frame for easy part access, a precise and highly repeatable stroke and require no lubrication.

**WHAT MAKES US BETTER?**

Unlike a lot of air presses, these Black & Webster Air Presses are made in the US and built to last. With a robust design and a non-lubricating air cylinder, these units are an excellent choice for small assembly operations in high production environments or in cleaner, more controlled environments that need an accurate stroke with no lubrication required.

**ADVANTAGES**

- Highly Accurate and Repeatable Stroke
- No Lubrication Required
- Rugged Design with Minimal Deflection
- Environmentally Friendly
- Manufactured in the US

**APPLICATIONS**

Pressing, Riveting, Crimping, Swaging, Staking and Forming of Parts



**Black & Webster**  
 Assembly Equipment Division

**SPECIFICATIONS**

Description	AP-150	AP-400	AP-1200	AP-1900/D*
Press Force at 100 PSI	150 lbs.	400 lbs.	1200 lbs.	1900 lbs.
Ram Size	1" Square	1-3/16" Diameter Keyed	1-3/4" Diameter Keyed	1-3/4" Square
Adjustable Stroke	0 to 1-3/4"	0 to 2"	0 to 2"	0 to 2"
Ram Return	Spring	Spring	Spring	Spring or Air Models Available
Ram to Base (Daylight)	4"	5"	6"	6"
Ram Tool Hole	0.5625" x 1-1/2"	0.5625" x 1-1/2"	0.8125" x 1-1/2"	0.8125" x 1-1/2"
Machine Weight	22.5 lbs.	28 lbs.	100 lbs.	132 lbs.

\*NOTE: "D" denotes the Air Return Model

## STANDARD FEATURES

- Positive Stroke Adjustment
- Spring Return or Air Return Units
- Non-Rotating Ram
- Angled Base for Easy Part Access
- Ram Tool Mounting with Set Screw

## AVAILABLE OPTIONS

- **Straight Base:** As opposed to 45 degree angled base (*not available on AP150*)
- **Riser Blocks:** To provide increased daylight opening (*ram to base*)
- **Bolster Plates:** Available blank or machined to your specs
- **Electric or Pneumatic:** two-hand non-tie down control packages
- **Load Cell Monitoring Package :** measure peak force on press cycle
- **Tooling:** Air-Hydraulics can design tooling to meet your needs

## AP-SERIES MODELS

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.



Model AP-150 with  
Custom Timer Return  
Control Package



MODEL AP-400  
with DP-1 Controls



Model AP-1200  
with EDP-1  
Control and TQM  
Force Monitor



Model AP-1900  
with EDP-1  
Controls

## AP-SERIES AIR PRESS CONTROL PACKAGE OPTIONS

**EDP = Electric Logic**  
(110v electricity required)

**DP = Pneumatic Logic**  
(No electricity required)

**EDP-1 or DP-1:** Basic two-hand non-tie down control package with single regulator  
Operator initiates and maintains both actuators at the same time to advance the press stroke. Once the operator releases one or both actuators, the ram returns to home position.

**EP-1-NP or DP-1-NP:** Two-hand non-tie down control package with jog control (AP1900D only)  
Operator initiates and maintains both actuators at the same time to advance the press stroke. If the operator releases one of both actuators during the downward stroke, the ram stops downward motion. The operator can either proceed with the downward cycle by re-initiating the actuators until the auto ram return option is met (see auto ram return options), or the operator can manually retract the ram to home position by pressing the manual ram return button  
(Note: includes P-TD or E-TD Pressure with Timer Return as the standard auto ram return option)

**EDP-2-SA1:** Modular (all in one) two-hand non-tie down unit with pressure initiated / adjustable timer delay ram return  
(Only available on the AP150 & AP400 Air Presses)  
Operator initiates and maintains both actuators at the same time to advance the press stroke. Once pre-set pressure is achieved, an adjustable timer is initiated. Once the timer is complete, the ram retracts.

**EDP-2-SA2:** Modular (all in one) two-hand non-tie down unit with pressure initiated / adjustable timer delay ram return  
(Only available on the AP1200 & AP1900 Air Presses)  
Operator initiates and maintains both actuators at the same time to advance the press stroke. Once pre-set pressure is achieved, an adjustable timer is initiated. Once the timer is complete, the ram retracts.

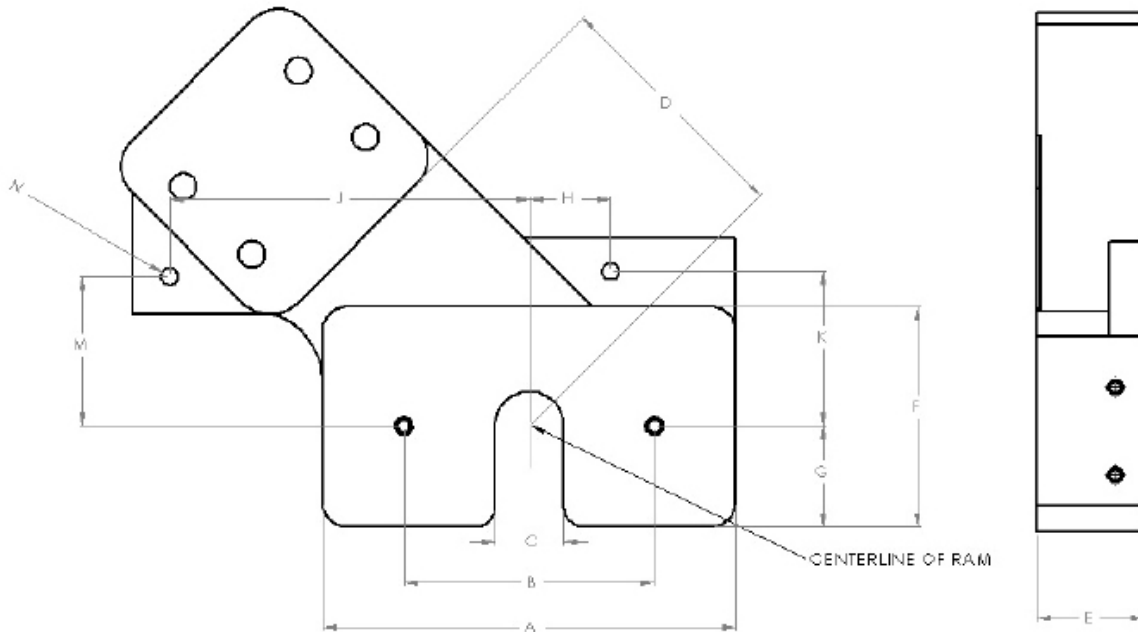
### **Auto Ram Return Options:**

Only available with the EDP-1 or DP-1 control package)

E = Electric Logic / P= Pneumatic Logic

**E-TD1 or P-TD1:** Pressure with Timer Return:  
Pressure sensor initiates an adjustable press dwell timer which returns the ram

**E-PSR1 or P-PSR1:** Pressure Only Return  
Pressure sensor only initiates the return of the ram

**AP-SERIES AIR PRESS DIMENSIONS**

<b>DIM CLAVE</b>	<b>Descripción (U.S. Inches)</b>	<b>AP150</b>	<b>AP400</b>	<b>AP1200</b>	<b>AP1900/D</b>
<b>A</b>	Platen from Left to Right	6.00	6.50	8.25	8.25
<b>B</b>	Mounting Hole Width	5.00	5.00	5.00	5.00
<b>C</b>	Slot Width	1.00	1.00	1.38	1.38
<b>D</b>	Ram Centerline to Column	2.75	5.00	5.00	5.00
<b>E</b>	Base Height	1.25	1.50	2.12	2.12
<b>F</b>	Platen Front to Back	3.50	3.75	4.38	4.38
<b>G</b>	Centerline Mtg. Hole to Frt. of Base	1.56	2.00	2.00	2.00
<b>H</b>	Right Foot Mtg. Hole to Centerline	2.62	1.38	1.62	1.62
<b>J</b>	Left Foot Mtg. Hole to Centerline	3.88	5.50	7.12	7.12
<b>K</b>	Right Foot Mtg. Hole to Centerline	1.56	2.50	3.06	3.06
<b>M</b>	Left Foot Mtg. Hole to Centerline	1.56	2.25	2.75	2.75
<b>N</b>	Mtg. Hole Diameter	.34 DIA.	.34 DIA.	.34 DIA.	.34 DIA.
<b>*</b>	Daylight (Standard)	4.00	5.00	6.00	6.00
<b>*</b>	Optional Daylight, 1 to 8 Inch Additional in Whole Inch Increments.	Riser Blocks 1 or 2 Inch Heights	Riser Blocks 1 or 2 Inch Heights	Riser Blocks 1 or 2 Inch Heights	Riser Blocks 1 or 2 Inch Heights

**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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