



Screwdriving technology

Automation

Air motors

Air tools

DEPRAG

**Handheld Screwdriver
pneumatic**

MICROMAT-F / MINIMAT-F SCREWDRIVING SYSTEM

The screwdriving system with additional function control

- Handheld screwdriver
- Multi function control
- Pneumatic control

The handheld screwdrivers in connection with the function controller and the pneumatic control offer a complete solution for the process reliability of your manual assemblies.



fc20 function control

pc20 pneumatic control



fc11 function control

pc11 pneumatic control



The screwdriving system in connection with fc11 function control and pc11 pneumatic control



- counts screwdriving cycles - supervises assembly times
- only shuts-off when the preset torque is reached
- recognizes change of parts
- controls itself - 100 %
- design selection of the screwdriver according to application (inline, pistolgrip, angle-head)
- eliminates a costly follow-up check

After detecting the start signal from the screwdriver (operator push down or start trigger), the air supply to the driver is enabled via the new multi function control combined with the pneumatic control.

When reaching the preset torque value, the screwdriver stops by way of the extremely accurate shut-off clutch.

In connection with the pneumatic control and a sensor in the screwdriver (MICROMAT-F/MINIMAT-F) the multi function control is able to confirm the correct screw assembly sequence. The screw tightening time is compared to a minimum/maximum preprogrammed time window. If the screw tightening time is too short (cross thread) or too long (stripped screw) the operator is alerted by a failure message. In addition an onboard sensor confirms that the screwdriver is enabled until the clutch mechanism is disengaged insuring that the cycle was not terminated as a result of the operator lifting the screwdriver prematurely. This confirms that the tightening process was carried out properly without material failures or influence by the operator.

In addition, the number of screw assembly operations per part can be controlled. No screw will be forgotten!

Reliable pass/fail process monitoring is only guaranteed with the use of a non reversible screwdriver. In order to assure best possible process quality, we recommend to apply right-hand rotation drivers wherever possible.

In short, the screwdriver with multi function control monitors itself and assures a 100% integrity of your assembly.

The MICROMAT-F / MINIMAT-F screwdriver incorporates the well-known advantages of the DEPRAG MICROMAT / MINIMAT screwdriver series and also oilfree operation is possible.

When connected to an automatic screwfeeder, the feeding of the screw is controlled by the multi function control. The controller is connected to the screwfeeder using an optionally available SZG-connection set.

The screwdriving system in connection with fc20 function control and pc20 pneumatic control

- **highest process reliability: controls itself up to 100%**
- **counts screwdriving cycles - supervises assembly times**
- **only shuts-off when the preset torque is reached**
- **recognizes change of parts**
- **allows the connection of up to 3 different screwdrivers**
- **design selection of the screwdrivers according to application (inline, pistolgrip, angle-head)**
- **individual screw-process configuration through free programmability**
- **integrated torque measuring function, diagnostics and evaluation**
- **comprehensive documentation possibility**
- **highest operator friendliness through graphical touch screen**



This controller can also manage up to three different screwdriver model connections of the series MICROMAT-F and MINIMAT-F.

The function control fc20 distinguishes itself through an exceedingly high process reliability, individual screw-process configuration by the free programmability, integrated torque measuring function, extensive diagnostics- and analysis possibilities, as well as comprehensive documentation possibility and comfortable operator guidance.

Highest process reliability: controls itself up to 100%.

The quality criteria connected with the screwdriving process are automatically supervised and analyzed. In case of a faulty screw assembly cycle, for example due to mishandling of the screwdriver, faulty assembly materials or an interrupted screw assembly cycle, the failure can be reset by the operator or if preferred by a qualified specialist when utilizing the available password protection function. The positive shut-off function of the clutch is monitored via an internal sensor also the minimum/maximum screw assembly time per screw and the number of good screw joints per production part are compared to the preset values in the controller. Only the positive feedback of all individual signals allows a change of the part - 100% process reliability.

Individual screw-process configuration through free programmability

For maximal 7 sequences each sequence consisting of up to 99 programs, any screwdriving process can be individually generated. The new fc20 contains freely usable power outputs. So, it is easy to integrate a part-lock feature into the assembly process. The Operator can also program additional processing steps by himself. The new function control recognizes up to three part sensors and so guarantees a reliable presence- and positioning control of even multi-level parts.

Torque measuring functions, comprehensive diagnostics- and evaluation possibilities

Comprehensive diagnostics possibilities round-off the wide application spectrum of the screwdriving control fc20. By the use of an optional external rotary transducer, the operator is able to control the - on the screwdriver preset torque, directly on the part to be assembled, which is a big relief for maintenance and quality management. The integrated diagnostics functions are capable to test every in- and output of the control and additionally displays their operating status. An internal voltage control assures the continued functional safety of the fc20.

Comprehensive documentation possibility

For each products, the assemblies that took place are clearly assigned. An optional connected barcode-reader reads the barcode on any part to be assembled and then stores the final-values for each individual assembly together with this barcode. These final-values are stored for seven days and can be transmitted for the traceability of the production over the integrated serial port to a PC. That way, each program step is statistically retained. The number of good- and bad assemblies, as well as the average assembly time allow the control and optimization of the assembly process. The communication with a host controller (PLC or industrial PC) is possible through the integrated 24V I/O-port. The fc20 offers five power outputs.

Highest operator friendliness through graphical touch screen

An integrated graphical touch screen with a clear structure and a color-coded difference of the results, lead the operator intuitively to the desired submenus. The submenus allow the simple selection of assembly-sequences, programs and diagnostic functions.

SYSTEM COMPONENTS

MICROMAT-F Screwdriver, straight handle design		Motor Size 0			
Driver right rotation	Type	345F-308	345F-408	345F-708	345F-508
	Part no.	399400 A	399400 B	399400 C	399400 D
Screwdriver	Type	345FZ-308	345FZ-408	345FZ-708	345FZ-508
in combination with feeder	Part no.	399445 A	399445 B	399445 C	399445 D
Screws	up to	M3	M3	M3	M3
Torque min.	Ncm / in.oz	2 / 3	2 / 3	2 / 3	2 / 3
Torque max. (soft pull-up)	Ncm / in.oz	50 / 70	55 / 78	70 / 97	70 / 97
Torque max. (hard pull-up)	Ncm / in.oz	60 / 83	55 / 78	70 / 97	70 / 97
Speed, idling	rpm	1600	1100	600	350
Internal hex. drive DIN ISO 1173		B 3 (3 mm/.118")	B 3 (3 mm/.118")	B 3 (3 mm/.118")	B 3 (3 mm/.118")

Further technical details see leaflet D 3420 E.

MINIMAT-F Screwdriver, straight handle design		Motor Size 1				Motor Size 2			
Driver right rotation	Type	347F-218	347F-318	347F-518	347F-618	347F-228	347F-328	347F-428	347F-528
	Part no.	397061 A	397061 B	397061 C	397061 D	386365 A	386365 B	386365 D	386365 C
Screwdriver	Type	347FZ-218	347FZ-318	347FZ-518	347FZ-618	347FZ-228	347FZ-328	347FZ-428	347FZ-528
in combination with feeder	Part no.	397064 A	397064 B	397064 C	397064 D	390846 A	390846 B	390846 D	390846 C
Screws	up to	M3	M3	M3	M3	M4	M4	M4	M5
Torque min.	Nm / in.lbs	0.3 / 3	0.3 / 3	0.2 / 2	0.2 / 2	0.5 / 5	0.4 / 4	0.4 / 4	0.3 / 3
Torque max. (soft pull-up)	Nm / in.lbs	1 / 9	1.4 / 12	2 / 18	2 / 18	1.8 / 16	3 / 26	4 / 35	5 / 44
Torque max. (hard pull-up)	Nm / in.lbs	1 / 9	1.4 / 12	2 / 18	2 / 18	2 / 18	3.2 / 28	4.5 / 40	5 / 44
Speed, idling	rpm	1900	1300	900	600	4000	1550	1000	680
Internal hex. drive DIN ISO 1173		F 6.3 (1/4")	F 6.3 (1/4")	F 6.3 (1/4")	F 6.3 (1/4")	F 6.3 (1/4")	F 6.3 (1/4")	F 6.3 (1/4")	F 6.3 (1/4")

MICROMAT-F Screwdriver, straight handle design		Motor Size 2.5			Motor Size 3			
Driver right rotation	Type	345F-7258	345F-3258	345F-4258	346F-238	346F-738	346F-338	346F-438
	Part no.	401537 A	401537 B	401537 C	396359 B	396359 C	396359 D	396359 E
		These types are also available in combination with feeder.			These types are also available in combination with feeder.			
Screws	up to	M5	M6	M6	M5	M6	M6	M8
Torque min.	Nm / in.lbs	1 / 9	1 / 9	1 / 9	2 / 18	2 / 18	2 / 18	2 / 18
Torque max. (soft pull-up)	Nm / in.lbs	5 / 44	10 / 88	12 / 106	5 / 44	8 / 71	14 / 123	20 / 177
Torque max. (hard pull-up)	Nm / in.lbs	6 / 53	10 / 88	12 / 106	6 / 53	9 / 80	14 / 123	20 / 177
Speed, idling	rpm	1100	680	310	2500	1400	750	400
Internal hex. drive DIN ISO 1173		F 6.3 (1/4")	F 6.3 (1/4")	F 6.3 (1/4")	F 6.3 (1/4")	F 6.3 (1/4")	F 6.3 (1/4")	F 6.3 (1/4")

Incl. 3 m / 10 ft. air supply hose (lengths up to 5 m / 16.4 ft. available). Further technical details see leaflet D 3430 E.

MINIMAT-F Screwdriver, angle-head design		Motor Size 2			Motor Size 2.5	
Driver right rotation	Type	377F-321	377F-421	377F-521	376F-7251	376F-3251
	Part no.	389689 B	389689 D	389689 C	392061 A	392061 B
Screws	up to	M4	M5	M5	M6	M6
Torque min.	Nm / in.lbs	0.4 / 4	0.4 / 4	0.3 / 3	1.5 / 13	1.5 / 13
Torque max.	Nm / in.lbs	3.5 / 31	4.5 / 40	6.5 / 57	8 / 70	15 / 132
Speed, idling	rpm	820	530	450	810	410
External square drive DIN 3121		E 6.3 (1/4")	E 6.3 (1/4")	E 6.3 (1/4")	E 6.3 (1/4")	E 6.3 (1/4")

MINIMAT-F Screwdriver, angle-head design		Motor Size 3			Motor Size 4	
Driver right rotation	Type	377F-731	377F-331	377F-431	377F-941-E12.5	377F-741-E12.5
	Part no.	404085 C	404085 D	404085 E	204209 B	204209 C
Screws	up to	M6	M8	M10	M10	M12
Torque min.	Nm / in.lbs	4 / 35	4 / 35	4 / 35	8 / 70	8 / 70
Torque max.	Nm / in.lbs	13 / 115	23 / 204	33 / 292	32 / 283	46 / 408
Speed, idling	rpm	840	450	240	410	270
External square drive DIN 3121		E 12.5 (1/2")	E 12.5 (1/2")	E 12.5 (1/2")	E 12.5 (1/2")	E 12.5 (1/2")

Incl. 3 m / 10 ft. air supply hose (lengths up to 5 m / 16.4 ft. available). Further technical details see leaflet D 3450 E.

Remark:

Details on our feeding systems can be found in brochure D3820 E.

SYSTEM COMPONENTS

MINIMAT-F Screwdriver, pistolgrip		Motor Size 2					
Driver right rotation lower air-inlet	Type Part no.	347F-227 391735 A	347F-327 391735 B	347F-427 391735 D	347F-527 391735 C		
Driver right rotation upper air-inlet	Type Part no.	347F-227O 391473 A	347F-327O 391473 B	347F-427O 391473 D	347F-527O 391473 C		
Screws	up to	M3	M4	M4	M5		
Torque min.	Nm / in.lbs	0.4 / 4	0.4 / 4	0.4 / 4	0.3 / 3		
Torque max. (soft pull-up)	Nm / in.lbs	1.5 / 13	3 / 26	3.5 / 31	5 / 44		
Torque max. (hard pull-up)	Nm / in.lbs	1.8 / 16	3.2 / 28	4 / 35	5 / 44		
Speed, idling	rpm	4000	1550	1000	680		
Internal hex. drive DIN ISO 1173		F 6.3 (1/4")	F 6.3 (1/4")	F 6.3 (1/4")	F 6.3 (1/4")		
Driver reversible lower air-inlet	Type Part no.	347F-227U 395047 A	347F-327U 395047 B	347F-427U 395047 D	347F-527U 395047 C		
Driver reversible upper air-inlet	Type Part no.	347F-227OU 395052 A	347F-327OU 395052 B	347F-427OU 395052 D	347F-527OU 395052 C		
Screws	up to	M3	M4	M4	M5		
Torque min.	Nm / in.lbs	0.4 / 4	0.4 / 4	0.4 / 4	0.3 / 3		
Torque max. (soft pull-up)	Nm / in.lbs	1.5 / 13	3 / 26	3.5 / 31	5 / 44		
Torque max. (hard pull-up)	Nm / in.lbs	1.8 / 16	3.2 / 28	4 / 35	5 / 44		
Speed, idling	rpm	3000	1100	750	500		
Internal hex. drive DIN ISO 1173		F 6.3 (1/4")	F 6.3 (1/4")	F 6.3 (1/4")	F 6.3 (1/4")		
MINIMAT-F Screwdriver, pistolgrip		Motor Size 2.5			Motor Size 3 *)		
Driver right rotation	Type Part no.	345F-7257 394625 A	345F-3257 394625 B	345F-4257 394625 C	346F-737 400561 C	346F-337 400561 D	346F-437 400561 E
Screws	up to	M5	M6	M6	M6	M6	M8
Torque min.	Nm / in.lbs	1 / 9	1 / 9	1 / 9	2 / 18	2 / 18	2 / 18
Torque max. (soft pull-up)	Nm / in.lbs	5 / 44	10 / 88	12 / 106	8 / 71	14 / 124	20 / 177
Torque max. (hard pull-up)	Nm / in.lbs	6 / 53	10 / 88	12 / 106	9 / 80	14 / 124	20 / 177
Speed, idling	rpm	1025	525	270	1400	750	400
Internal hex. DIN ISO 1173		F 6.3 (1/4")	F 6.3 (1/4")	F 6.3 (1/4")	F 6.3 (1/4")	F 6.3 (1/4")	F 6.3 (1/4")
Driver reversible	Type Part no.				346F-737U 402845 C	346F-337U 402845 D	346F-437U 402845 E
Screws	up to				M6	M6	M8
Torque min.	Nm / in.lbs				2 / 18	2 / 18	2 / 18
Torque max. (soft pull-up)	Nm / in.lbs				7 / 62	12 / 106	20 / 177
Torque max. (hard pull-up)	Nm / in.lbs				8 / 71	12 / 106	20 / 177
Speed, idling	rpm				1200	650	320
Internal hex. drive DIN ISO 1173					F 6.3 (1/4")	F 6.3 (1/4")	F 6.3 (1/4")

Incl. 3 m / 10 ft. air supply hose (lengths up to 5 m / 16.4 ft. available).
Further technical details see leaflet D 3435 E.

*) lower air-inlet and upper air-inlet

Screwdriver Style	Suitable tool inserts and connecting components
Internal hex. drive DIN ISO 1173 - B 3 (3 mm)	with a drive as per DIN ISO 1173 - A 3 (3 mm)
Internal hex. drive DIN ISO 1173 - F 6.3 (1/4")	with a drive as per DIN ISO 1173 - E 6.3 (1/4")
External square drive DIN 3121 - E 6.3 (1/4")	with a drive as per DIN 3121 - G 6.3 (1/4")
External square drive DIN 3121 - E 12.5 (1/2")	with a drive as per DIN 3121 - G 12.5 (1/2")

Please also find suitable tool inserts in our brochure D3320E.



It is necessary to use a torque reaction support (e.g. stand, handgrip) for maximum torque: over 4 Nm for straight design, over 10 Nm for pistol grip and over 60 Nm for angle design. Suitable torque reaction supports can be found in our brochure D 3340 E.

SYSTEM COMPONENTS

Multi function controllers fc20 and fc11

Function control	Type	fc20	fc11
	Part no.	385523 A	385858 A
Amount of connectable drivers		3	1
Voltage	V / Hz	100 - 240 AC / 50 - 60	100 - 240 / 50/60
Power consumption	VA	18	30
Display and operation		TFT - graphic display 4.3" (480x272 pixel) with touch screen	LC-display alphanumeric 4-lines, 16 digits per line
Operation via		touch screen	keypad
RS232 interface		yes	no
PLC interface		yes	yes
Power output		yes (5 pieces)	-
Connection for part sensor		yes (3 pieces)	yes (on pc11)
Connection for in-line torque transducer		yes	-
Dimensions (W x H x D)	mm / in.	243 x 200 x 90 / 9.5 x 7.8 x 3.5	160 x 80 x 40 / 6.2 x 3.1 x 1.55
Weight	kg / lbs	2.9 / 6.4	0.52 / 1.1

Pneumatic controllers pc20 and pc11

Pneumatic control	Type	pc20	pc11
	Part no.	3875512A	3875513A
Supply air connection		1/4 " (Plugs nominal size 7.8)	1/4 " (Plugs nominal size 7.8)
Operation pressure	bar / PSI	5 - 6.3 / 71 - 90	5 - 6.3 / 71 - 90
Air flow	m ³ /min / cfm	0.1 - 0.96 / 3.5 - 33.9	0.1 - 0.96 / 3.5 - 33.9
Connection for screw feeder *)		yes	yes
Connection for part sensor		directly on fc20	yes
Connection for signal break		yes	Possible in connection with adapter
Dimensions (W x H x D)	mm / in.	160 x 90 x 160 / 6.2 x 3.5 x 6.2	160 x 90 x 160 / 6.2 x 3.5 x 6.2
Weight	kg / lbs.	1.2 / 2.6	1.2 / 2.6

OPTIONAL EQUIPMENT

Suitable for function control fc20 in connection with pneumatic control pc20

Suitable for	Type	fc20 / pc20
Proximity switch for parts control		
capacitive M18	Part no.	354841 F
capacitive M12	Part no.	354841 D
inductive M18	Part no.	354906 D
Screwfeeder connection set		
cable length 1 m (3.3 ft.) / 2 m (6.6 ft.) / 3 m (9.9 ft.)	Part no.	3568501C / 3568501D / 3568501E
Sensor (for signal break screw presenter)		
for SG1211	Part no.	399525 F
for SG0211	Part no.	399525 G
Touch Pen	Part no.	832190
Printer Type ND100	Part no.	823476
Connection cable (fc20 - ND100)	Part no.	349938 A
Table stand	Part no.	416760 A
In-line torque transducer (for torque measurement)		
0.2-2 Nm / 0.5-5 Nm / 1-10 Nm / 2-20 Nm	Part no.	385481 B / C / D / E
Connection cable for in-line torque transducer		
2 m (6.6 ft.) / 4 m (13.2 ft.) / 6 m (19.8 ft.)	Part no.	385486 A / B / C

Suitable for function control fc11 in connection with pneumatic control pc11

Suitable for	Type	fc11 / pc11
Proximity switch for parts control		
capacitive M18	Part no.	354841 E
inductive M18	Part no.	354906 A
Screwfeeder connection set		
cable length 1 m (3.3 ft.) / 2 m (6.6 ft.) / 3 m (9.9 ft.)	Part no.	3568501C / 3568501D / 3568501E
Sensor (for signal break screw presenter)		
for SG1211	Part no.	399525 A plus adapter 399526 A
for SG0211	Part no.	399525 B plus adapter 399526 A
Mounting angle for fc11 and pc11	Part no.	205905 A

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