

1240 Recommended Minimum Board Depth



Recommended minimum board depth or thickness values for the 1240 will change depending on both the substrate material used as well as the joint angle and axis of connection.

Minimum recommended measurements shown below are categorized according to two distinct groups of board material which share broadly similar connector retention properties.



Fig 1



Fig 2

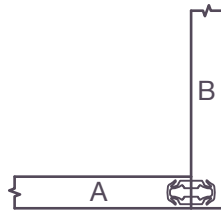


Fig 3

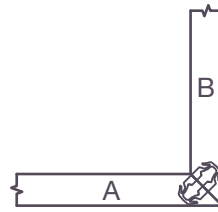


Fig 4

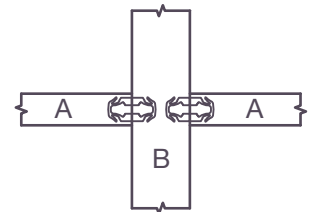


Fig 5

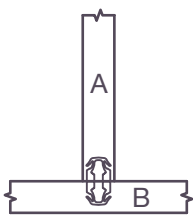


Fig 6

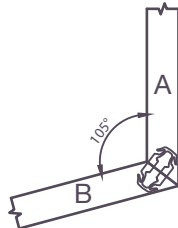


Fig 7

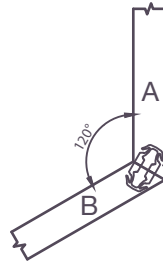


Fig 8

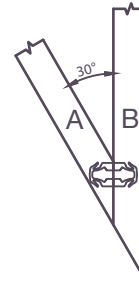


Fig 9

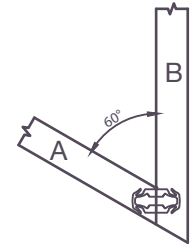


Fig 10

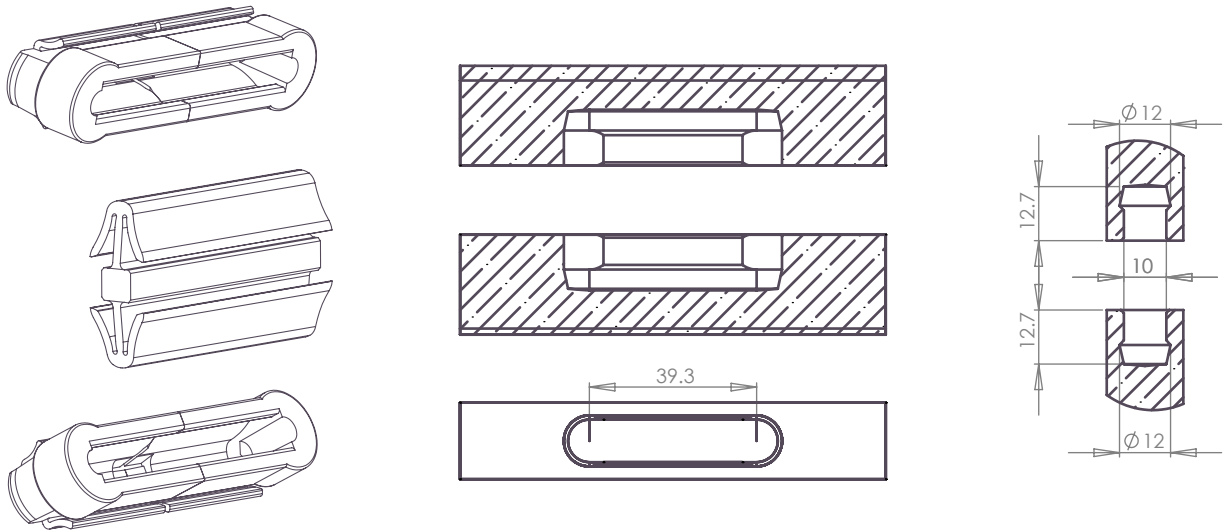
HPL/Composite, Solid Surface, Hardwoods, Birch Plywood		
	A	B
Fig 1	16mm	16mm
Fig 2	15mm	15mm
Fig 3	18mm	18mm
Fig 4	18mm	18mm
Fig 5	15mm	28mm
Fig 6	18mm	15mm
Fig 7	18mm	18mm
Fig 8	18mm	18mm
Fig 9	18mm	15mm
Fig 10	18mm	15mm

Particle/Chipboard, Softwoods/MDF		
	A	B
Fig 1	18mm	18mm
Fig 2	15mm	15mm
Fig 3	18mm	15mm
Fig 4	18mm	18mm
Fig 5	18mm	28mm
Fig 6	18mm	15mm
Fig 7	18mm	18mm
Fig 8	18mm	18mm
Fig 9	18mm	15mm
Fig 10	18mm	15mm

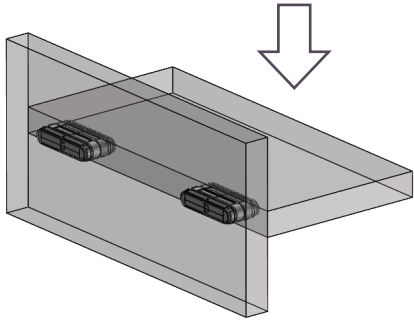

These are guidelines only and OVVO® recommends trial connections be made before going into full production.

OVVO® Permanent 1240

Shear & Tensile



The OVVO® Permanent Connection Set is an ideal solution for connecting materials together permanently.

Shear	Tensile
 <p>PH1240 (dual test shear)</p> <p>Chipboard = 600 N</p> <p>MDF = 700 N</p> <p>Beech = 1000 N</p>	 <p>PH1240 (component test tensile)</p> <p>Per Component = 500 N</p>

PERMANENT SET FITTING INSTRUCTIONS



2 x PH 1240 = PERMANENT HOUSING
1 x PC 1240 = PERMANENT CONNECTOR

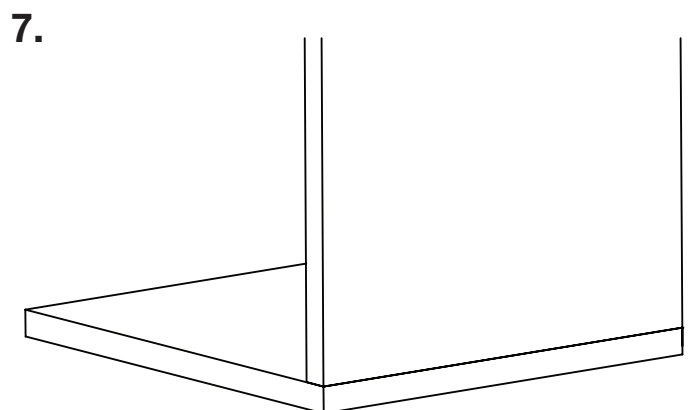
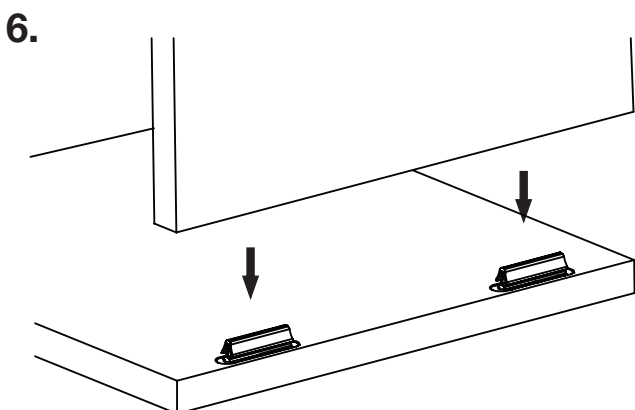
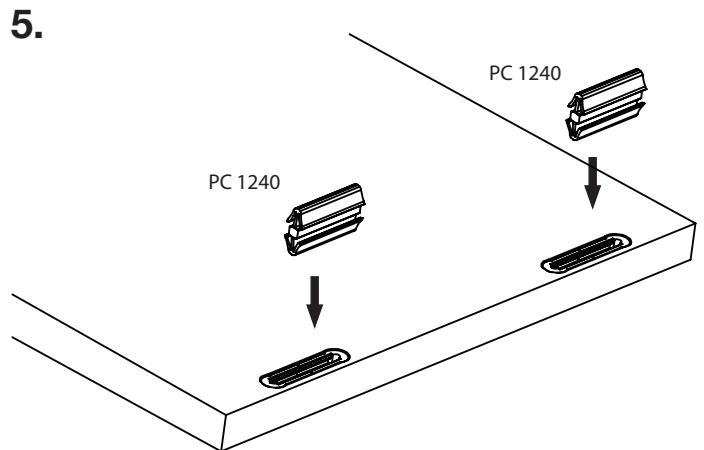
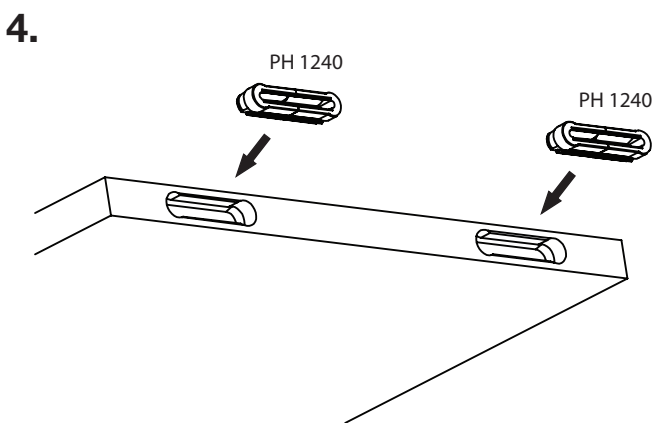
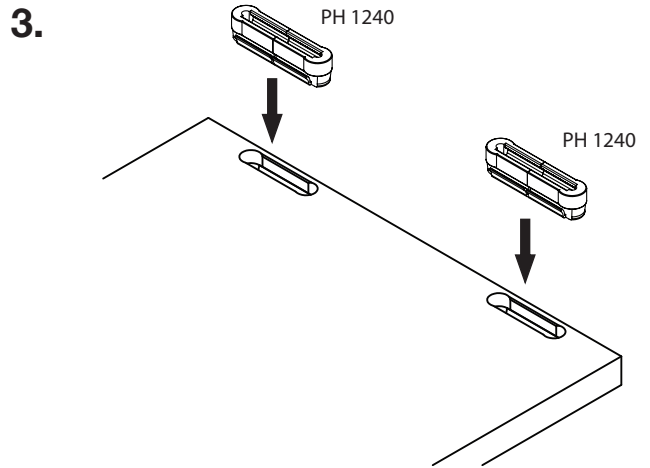
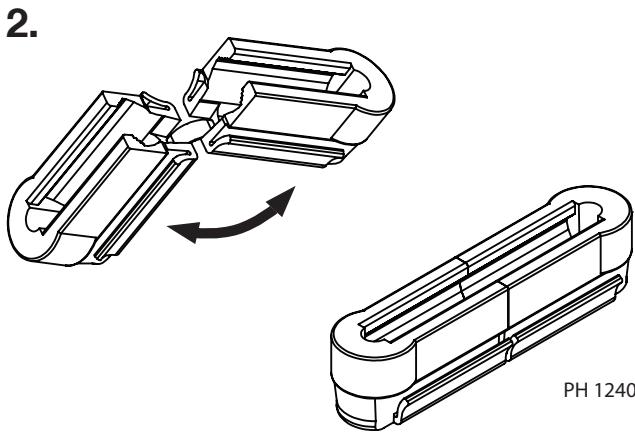
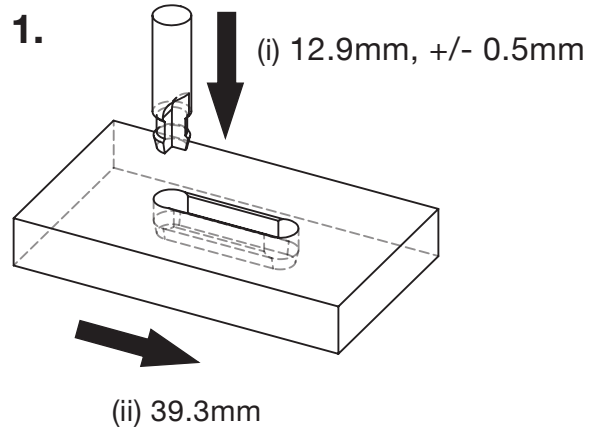
Milling

- (i) Plunge Depth: 12.9mm, +/- 0.5mm
- (ii) Travel (Centre to Centre): 39.3mm
- Out to Out: 51.3mm

CNC Speeds

- Plunge: 2.5 Metres
- Travel: 5 Metres - 7.5 Metres
- Rotation: 18,000 Revolutions

Speeds vary with different materials.



Important! Set Depth Correctly

OVVO® 1240 Connection System

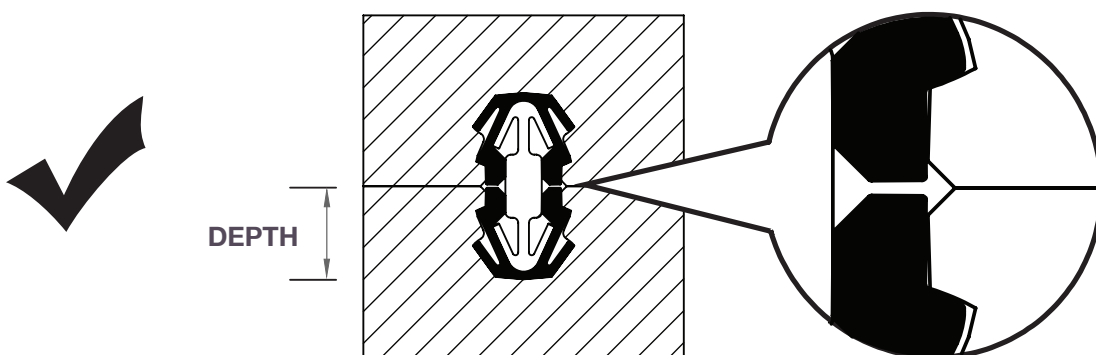


IMPORTANT! MAKE A TEST
WICHTIG! MACHEN SIE EINEN TEST
IMPORTANT! FAIRE UN TEST
IMPORTANTE! FARE UN TEST
IMPORTANTE! HACER UNA PRUEBA

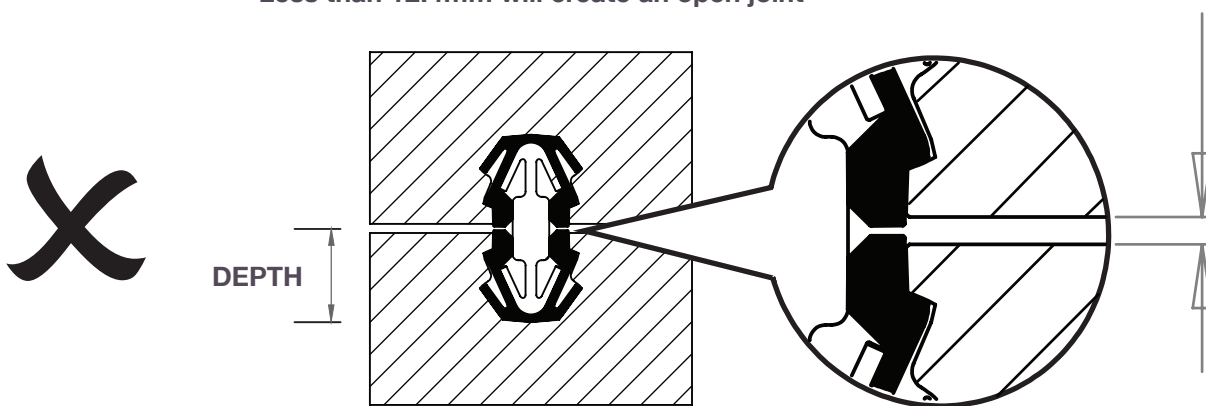
RECOMMENDED DEPTH TOLERANCES

1240	12.9mm, +/- 0.5mm
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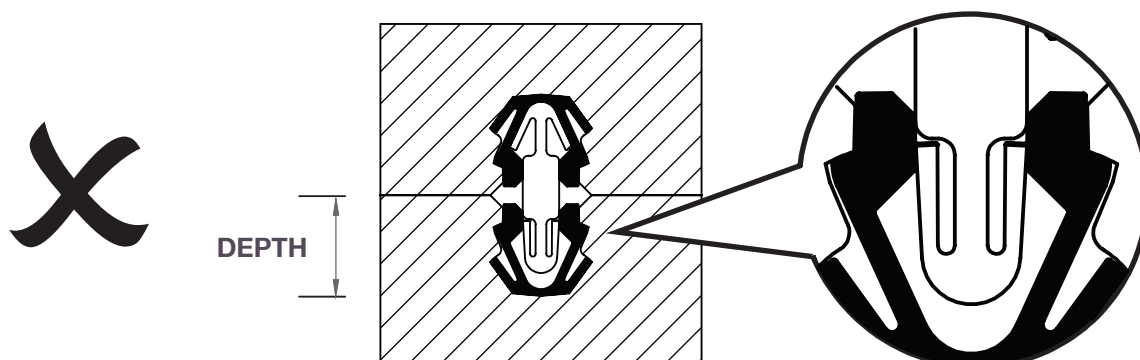
Set the depth tolerance to 12.9mm and adjust +/- 0.5mm if required



Less than 12.4mm will create an open joint



Greater than 13.4mm connector wing can not lock

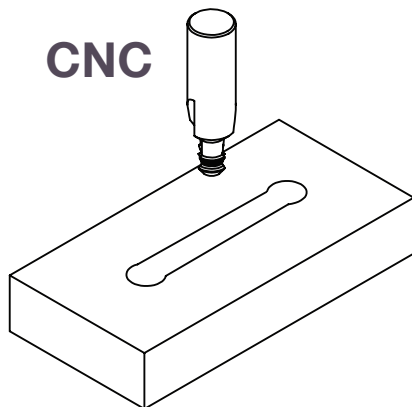


Depth Setting Guide

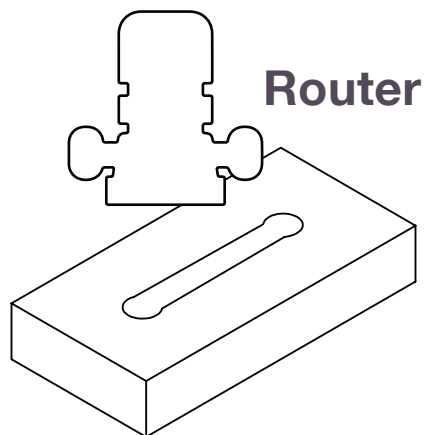
OVVO® 1240 Connection System



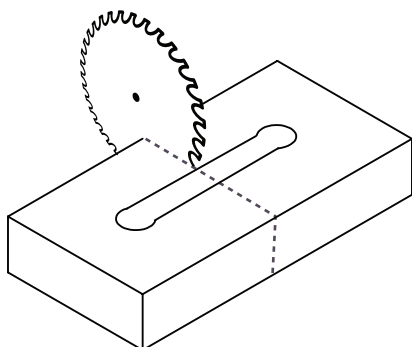
- 1.** Make a long cut with your tooling. Approximately 200mm long and 12.9mm depth



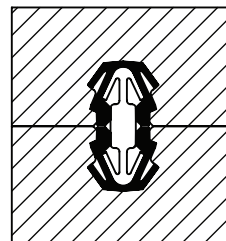
or



- 2.** Cut in half

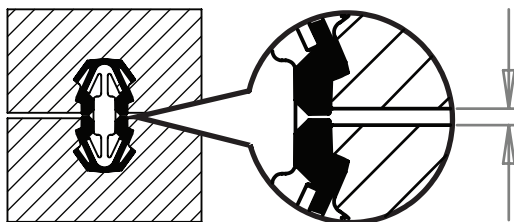


- 3.** Insert Connection Set and check depth.

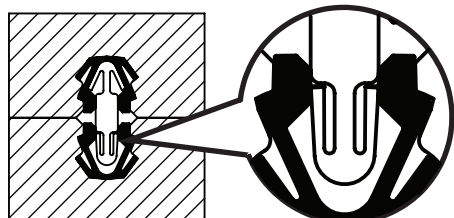


X Depth incorrect

Open joint?
Increase depth.



Wings not locking?
Reduce depth.



✓ Depth correct

