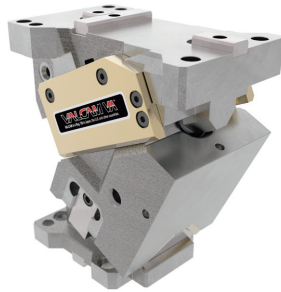


Product Information

- Complies with VDI.
- Compact design.
- High working forces.
- Suitable for high speed production.
- Bronze with solid lubricants wear plates.

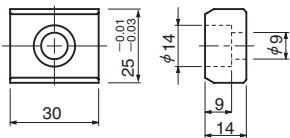


Mount face width	Working Force [kN] 1,000,000 strokes	Working Angle (5° increments)	Catalog No.	Spring Type
65	117	0°~75°	VACBV65	
85	162	0°~75°	VACBV85	
110	206	0°~75°	VACBV110	
165	323	0°~75°	VACBV165	
200	515	0°~75°	VACBV200	
260	603	0°~75°	VACBV260	
330	735	0°~75°	VACBV330	
400	882	0°~75°	VACBV400	

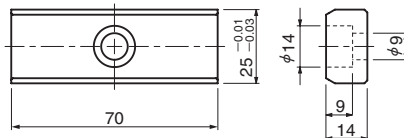
* Mount face widths 200, 260, 300, and 400 mm available in June 2024.

Key specifications

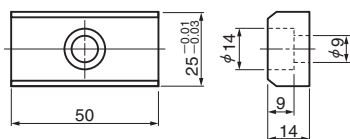
- Cam width 65, 85, 110, 165
(A M8 bolt is included.)



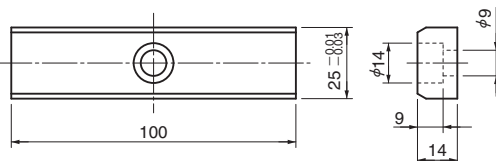
- Cam width 110
(A M8 bolt is included.)



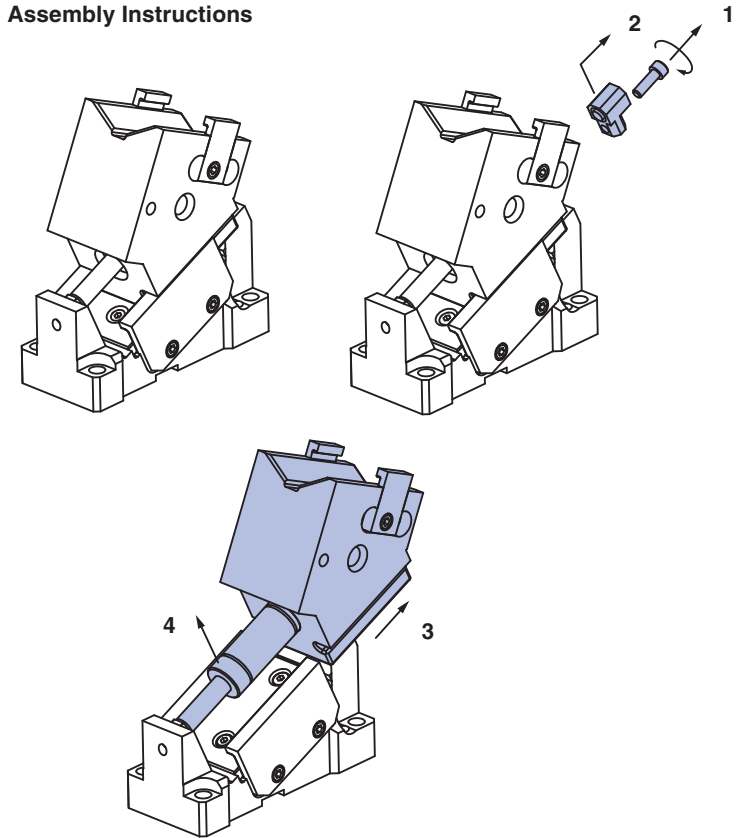
- Cam width 65, 85, 110, 165, 200, 260, 330, 400
LKU25-50 (A M8 bolt is included.)



- Cam width 165
LKU25-100 (A M8 bolt is included.)



VACBV65-85 Assembly Instructions



- Disassembly
 - 1) Remove Hexagon Socket Head Bolts.
 - 2) Pull out Stopper Plate.
 - 3) Remove Cam Slider to the rear. (until Gas Spring is removable.)
 - 4) Remove Gas Spring.

- Assembly

Assembly is the reverse procedure of disassembly.

 - Ensure that all parts are clean, particularly the sliding components to which a small amount of lubricant is applied and is then placed in position.
 - Take care that the respective tolerances are observed when assembling Cam Slider and Cam Holder, which also should be identified by the same serial number.
 - Make sure that all bolts are tighten to the recommended torque after assembly and disassembly.

- ⚠ Gas Spring

Please contact your local sales representative if you prefer to use a gas spring not specified in our catalog. For use and maintenance of gas spring, please contact the manufacturer directly.

Aerial Cam Unit

Working Force [kN] 1,000,000 strokes	Catalog No.	W	θ	Spring Type PS
117	VACBV	65	00~75 (5° increments)	GK NGK GD NGD

GK: Gas Spring (KALLER) GD: Gas Spring (DADCO)
NGK/NGD: Without Gas Spring Parts for spring assembly are included.

Order	Catalog No.	W	θ	PS	Option
	VACBV	65	10	GK	
	VACBV	65	10	GK	NF

Option Code	Specification
NF	Nitrogen gas not charged.

Spring Specification

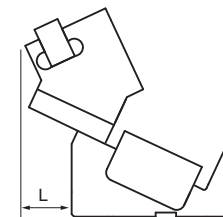
θ	GK			GD		
	Final Load kN	Return Force kN	Spring Model	Final Load kN	Return Force kN	Spring Model
00		6.7			6.5	
05		6.7			6.5	
10		6.7			6.5	
15		6.7			6.5	
20	5.0	6.7	X320-50	4.9	6.5	U.0325.050
25		6.7			6.5	
30		6.7			6.5	
35		6.7			6.5	
40		6.7			6.5	
45	5.0	6.6	X320-50	4.9	6.4	U.0325.050
50	4.8	6.4	X320-50	4.7	6.2	U.0325.050
55	5.0	7.2	X320-38	4.9	7.0	U.0325.038
60	4.8	7.6	X320-38	4.7	7.4	U.0325.038
65	4.5	8.1	X320-38	4.4	7.9	U.0325.038
70	4.7	9.8	X320-25	4.7	9.7	U.0325.025
75	4.6	11.4	X320-19	4.6	11.4	U.0325.019

Weight

θ	Total Weight kg	Cam Slider Weight kg	Max. Tool Length mm	Max. Tool Weight*1 kg
00	15.8			
05	15.6			
10	15.5			
15	15.2			
20	15.2			
25	15.0	5.4		
30	15.0			
35	15.0		100	4.0
40	15.0			
45	15.1			
50	15.1			
55	15.3	5.5		
60	15.5	5.5		
65	15.7	5.7		
70	16.0	6.0		
75	16.3	6.2		

Rear Removal Space

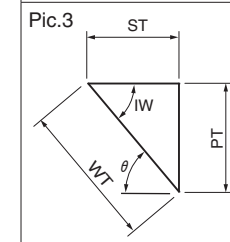
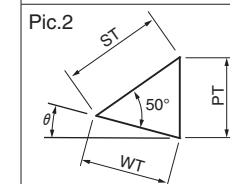
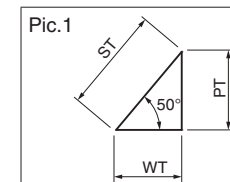
θ	L mm
00	10
05	19
10	26
15	34
20	40
25	51
30	60
35	69
40	78
45	87
50	99
55	101
60	105
65	110
70	115
75	120



*1 Tool weight is estimated value. Allowable tool weight varies depending on press speed.

Cam Diagram

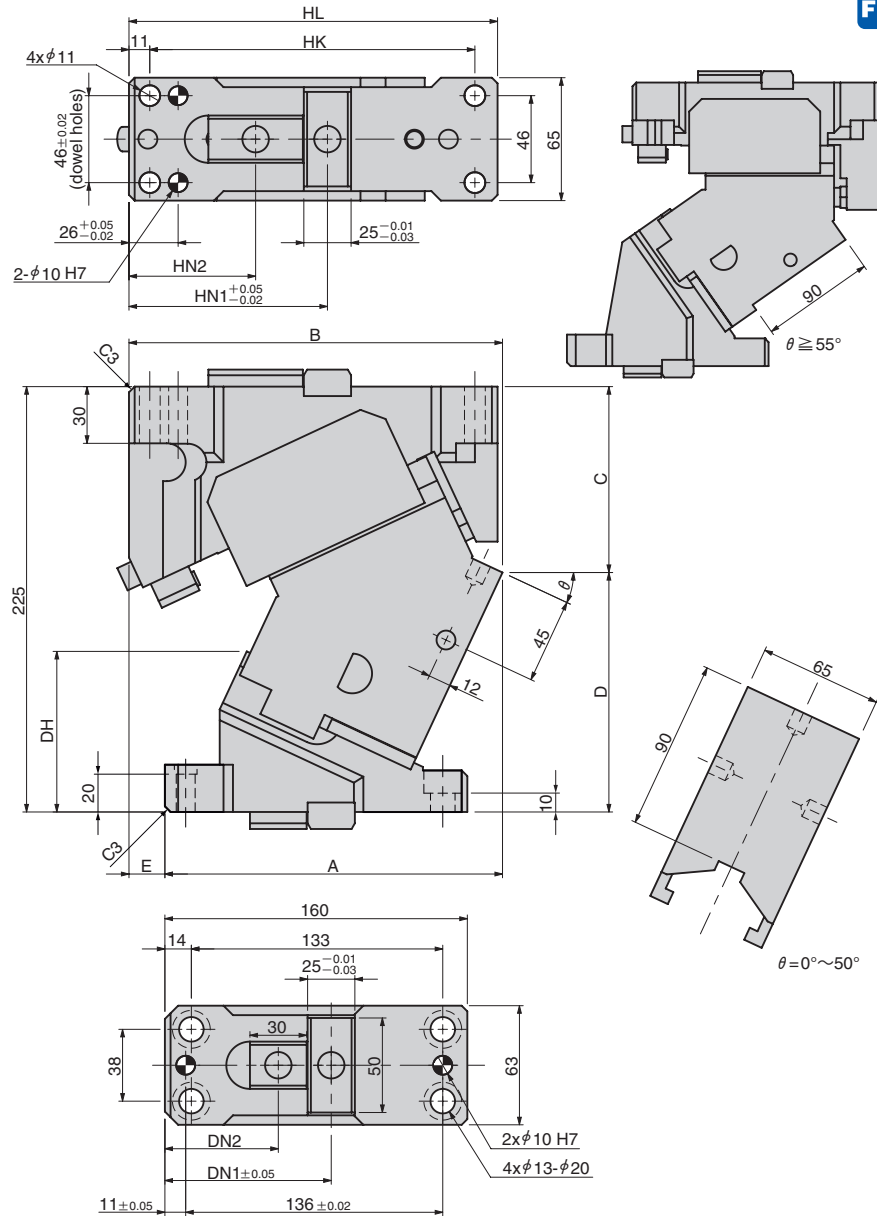
θ	WT	PT	ST	IW	Pic.
00	28.9	34.5			1
05	31.9	34.6			
10	35.0	35.0			
15	38.2	35.7			
20	41.5	36.7	45		
25	45.0	38.0			2
30	48.8	39.8			
35	53.1	42.1			
40	57.9	45.0			
45	62.0	47.7	44		
50	62.2	47.7	40	50	
55	59.3	48.6	34	55	
60	60.0	52.0	30	60	
65	59.2	53.6	25	65	3
70	58.5	55.0	20	70	
75	58.0	56.0	15	75	



Aerial Cam Unit

VACBV65

CAD FILE

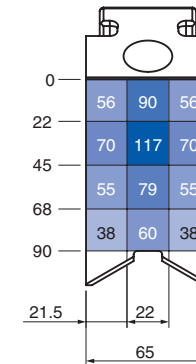


θ	A	B	C	D	E	HL	HK	HN1	HN2	DH	DN1	DN2
00	135.00	196.00	76.00	149.00	61	180	157			54.0	96	68
05	143.50	197.50	81.38	143.62	54	185	162			58.1	94	66
10	152.80	199.80	85.62	139.38	47	190	167	105	67	64.1	93	65
15	161.90	198.90	89.70	135.30	37	190	167			70.7	91	63
20	169.84	198.84	94.61	130.39	29	195	172			77.0		
25	178.61	197.61	98.33	126.67	19	195	172			84.9		
30	186.25	196.25	102.86	122.14	10	200	177	110	72	92.4		
35	194.76	193.76	107.17	117.83	-1	200	177			100.2		
40	202.16	189.16	112.25	112.75	-13	200	177			107.5		
45	208.49	182.49	118.11	106.89	-26	200	177			114.0	88	60
50	213.74	170.74	122.73	102.27	-43					121.6		
55	221.10	169.10	124.75	100.25	-52			115	77	124.8		
60	228.14	167.14	126.71	98.29	-61	195	172			128.9		
65	236.29	165.29	129.48	95.52	-71					132.4		
70	244.62	162.62	131.24	93.76	-82					134.9		
75	252.90	159.90	133.78	91.22	-93					136.9		

Working Force Distribution Diagram

The working forces indicated in the mount face distribution diagram are reached by putting the tooling center of gravity within each area for the following pictures.

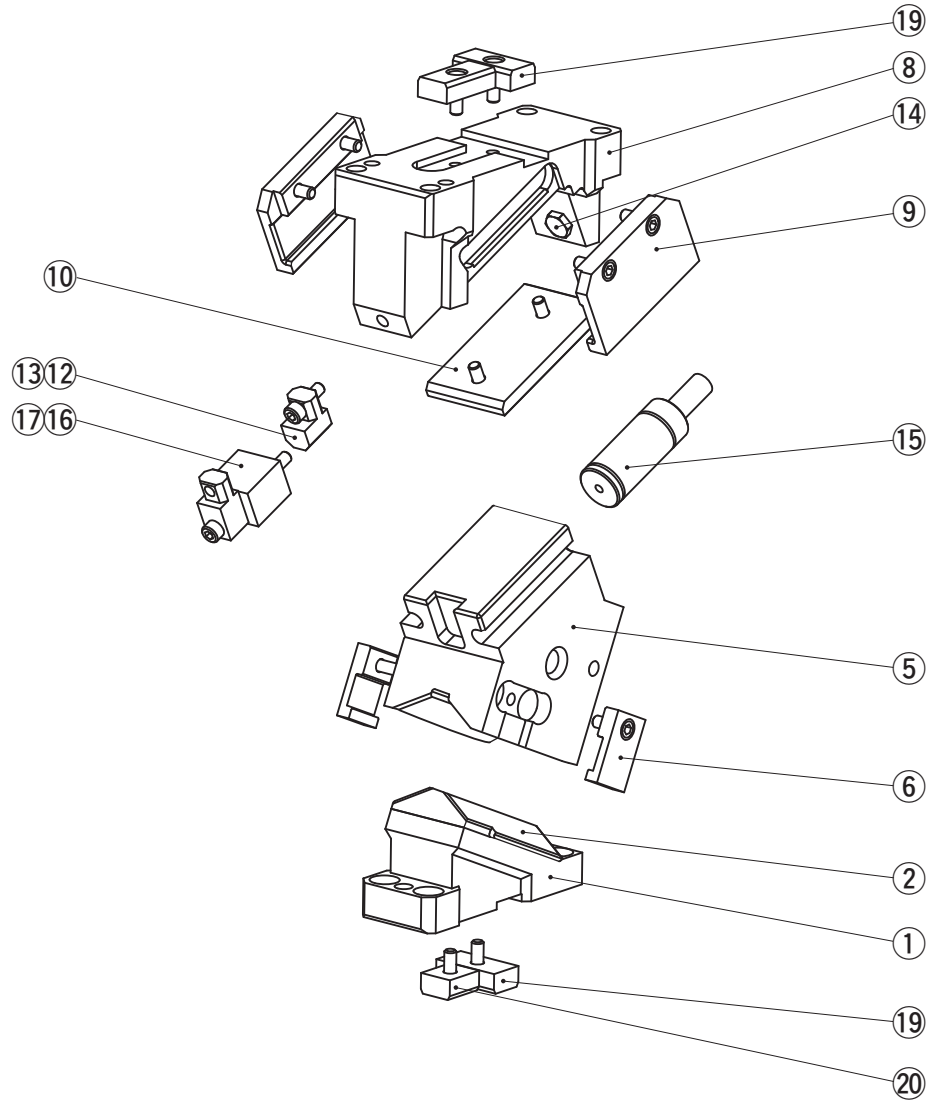
Working force (kN) allowed for up to 1,000,000 strokes



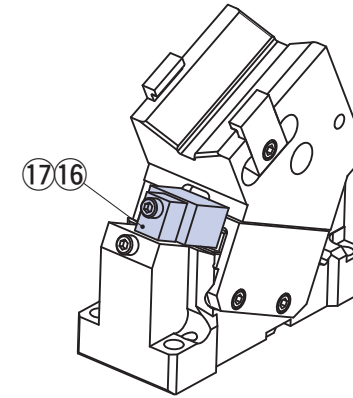
Refer to page 513 for Table of Components.

Aerial Cam Unit

VACBV65-85



● Lock System



No.	Description	Qty	Material and Remark
1	Cam Driver	1	Cast Iron
2	Cam Slide Guide	1	Bronze with Graphite
5	Cam Slider	1	Steel
6	Positive Return	2	Steel
8	Cam Holder	1	Cast Iron
9	Slide Keeper	2	Bronze with Graphite
10	Wear Plate	1	Bronze with Graphite
12	Stopper Plate	1	Steel
13	Stopper	1	—
14	Stop Pin	1	Steel
15	Gas Spring	1	Refer to the Spring Specification.
16	Lock Plate 01	1	Steel
17	Lock Plate 02	1	Steel
19	Key	3	LKU25-50
20	Key Holder	1	Steel

Bolts, nuts, dowels, and washers for assembly are not indicated.