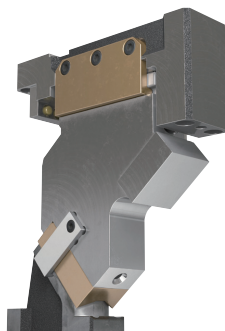


Product Information

- Mount face width 65 mm.
- Working angles from 35° to 80° in 5° increments.
- Coil or Gas Spring can be selected for pressure source.
- Option SH, which is to change shut height.
- Space saving.

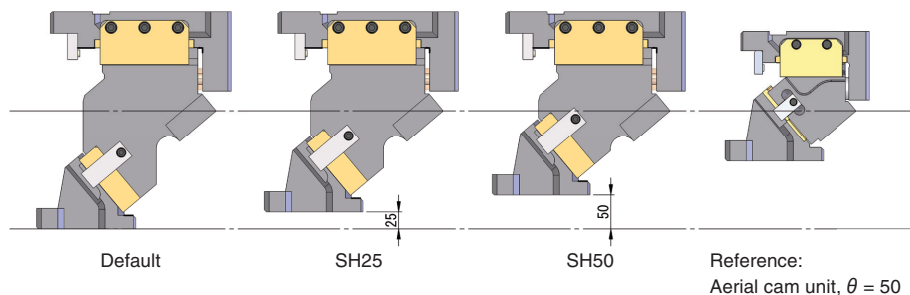


Features

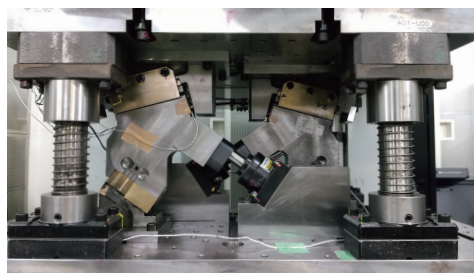
The lowered cam driver position provides no interference with the panel.

Option SH, which is to change shut height, provides optimal designing of the die.

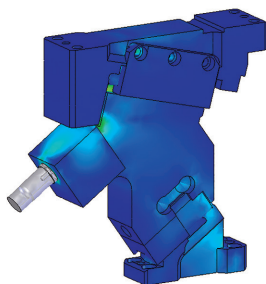
Rigid and durable cam unit confirmed by CAE analysis and in-house endurance test.



Endurance test

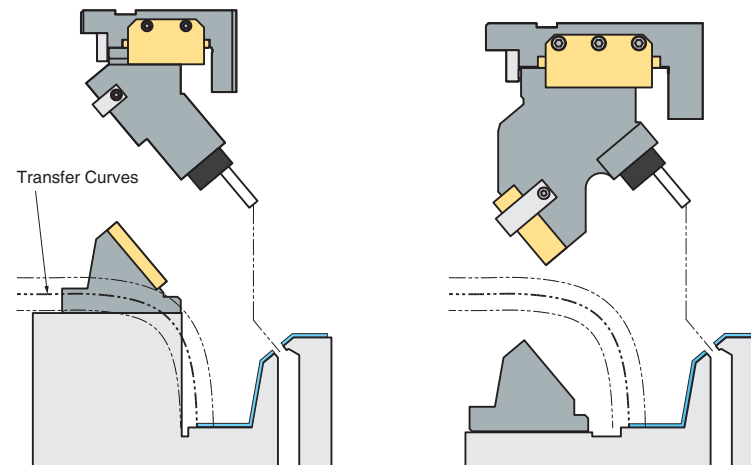


CAE analysis



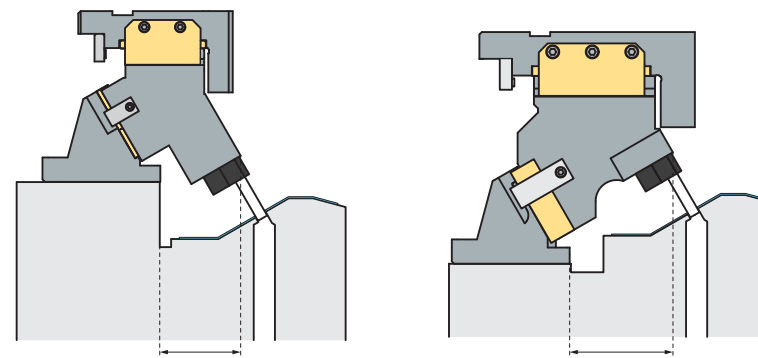
Usage Examples

① Panels with Height Differences



Eliminate Panel Transfer Interference

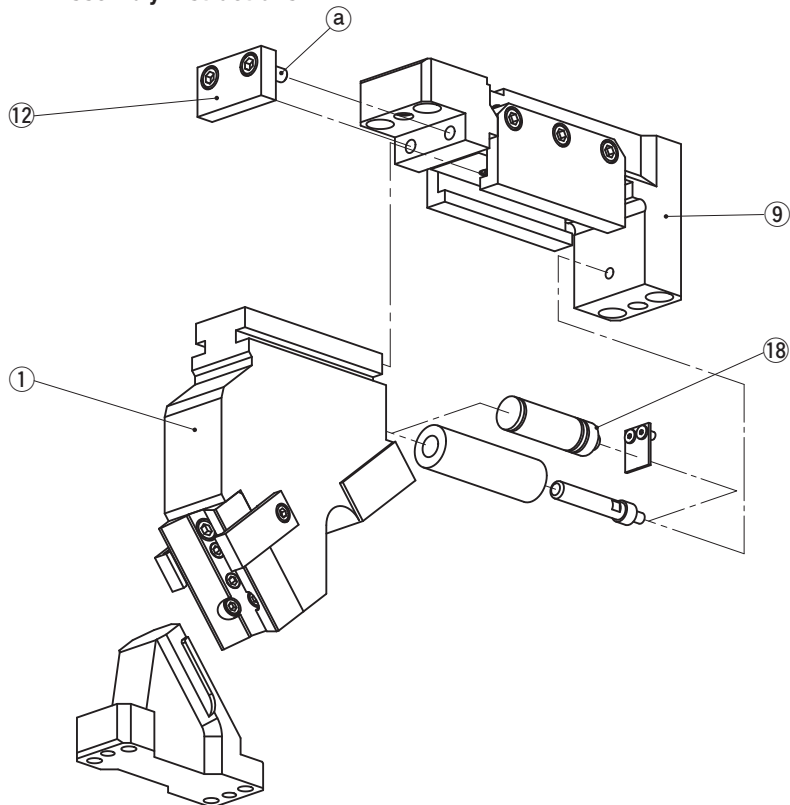
② Flat Panels



Ensuring Cam to Panel Clearance

Product Information

■ SACTFR Assembly Instructions



● Disassembly

1) Remove Hexagon Socket Head Bolts (a), to pull out Stopper Plate (12).

2) Pull out and remove Cam Slider (1) from Cam Holder (9) to the rear.

* Note that (18) Gas Spring is not fixed to Cam Slider.

● Assembly

Assembly is the reverse procedure of disassembly.

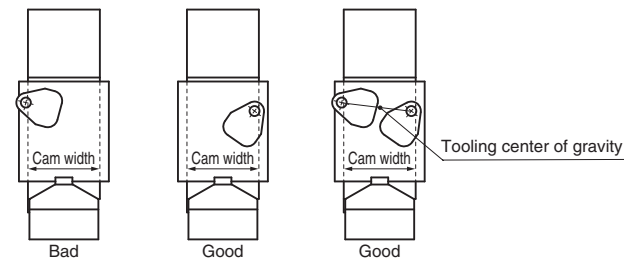
- Ensure that all parts are clean, particularly the sliding components to which a small amount of lubricant is applied and is then placed in position.
- Take care that the respective tolerances are observed when assembling Cam Slider and Cam Holder, which also should be identified by the same serial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

■ Installation range of piercing punch

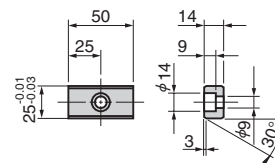
Make sure to mount a tool not to stick out of the cam unit and to keep tooling center of gravity within cam slider width 58 mm.



■ Option

● Key Specification (—K)

LKU25-50 (A M8 Bolt is included.)



■ Thrust Pad Installation

When the unit is used for trimming, it is recommended a thrust pad be included so an extreme lateral load is eliminated from trimming line to the unit.

■ Do not use for restriking

The cam unit would break.

■ Coil Spring life expectancy

Coil Spring life expectancy is approximately 300,000 cycles.
Note that 300,000 cycles is a manufacturer guideline, not a guarantee.
It may break earlier than the life expectancy depending on usage conditions.

NEW

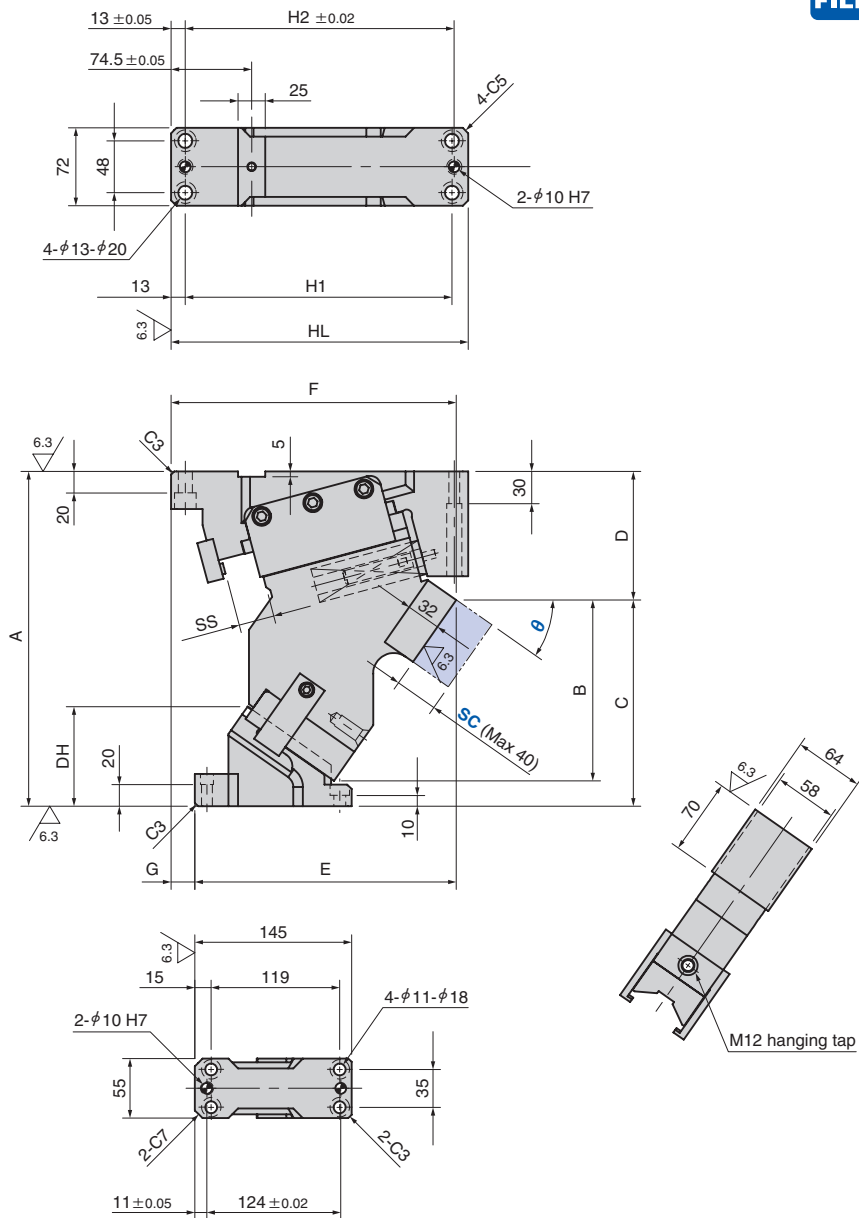
LONG LEG CAM

Panel Avoidance Cam

Aerial Cam Unit

For Pierce

SACTFR64-35~50



Working Force [kN (tonf)] 1,000,000 strokes	Catalog No.	W	θ	Spring Type PS
28.4 (2.9)	SACTFR	64	35~50 (5° increments)	No Code (Coil Spring) GK NGK GD NGD

No Code: Coil Spring GK: Gas Spring (KALLER) GD: Gas Spring (DADCO)
NGK/NGD: Without Gas Spring Parts for spring assembly are included.

Order	Catalog No.	W	θ	Option SH	PS	Option
	SACTFR	64	35	SH50		
	SACTFR	64	50	SH50	GK	NF-K

Option Code	Specification
NF	Nitrogen gas not charged.
SC	Mount face is extended from 1 to 40 mm in increments of 1 mm.
K	Key attached.

Option Code SH	Specification
SH25	Make shut height 25 mm shorter by cutting cam slider.
SH50	Make shut height 50 mm shorter by cutting cam slider.

θ	SS	Option Code SH	A	B	C	D	E	F	G	DH	HL	H1	H2
35		—	310	167.38	190.85								
		SH25	285	142.38	165.85	119.15	242.00	264.00	-22	92.2			
		SH50	260	117.38	140.85							275	247
40		—	310	160.50	184.22								
		SH25	285	135.50	159.22	125.78	248.21	258.21	-10	99.2			
		SH50	260	110.50	134.22								
45	33	—	310	154.26	179.93								
		SH25	285	129.26	154.93	130.07	254.20	250.20	4	107.3	270	242	244
		SH50	260	104.26	129.93								
50		—	320	149.7	174								
		SH25	295	124.7	149	146	263	243	20	111.4	265	237	239
		SH50	270	99.7	124								

Special Cam Units

SACTFR 64

Refer to page 569 for Table of Components.

NEW

LONG LEG CAM

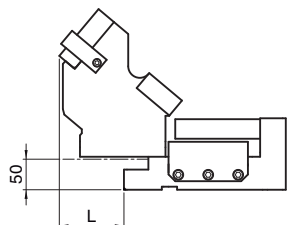
Panel Avoidance Cam

For Pierce

Aerial Cam Unit

SACTFR64-35~50

■Rear Removal Space



θ	L
35	74.1
40	84.7
45	95.3
50	105.8

■Spring Force

●Coil Spring

θ	SS	Initial Load		Final Load		Return Force		Spring Model
		N	kgf	N	kgf	N	kgf	
35	33	260.8	26.6	2950.3	301.1	3910.1	399.0	TJH32-139
40		260.8	26.6	2950.3	301.1	3897.6	397.7	TJH32-139
45		260.8	26.6	2950.3	301.1	3884.6	396.4	TJH32-139
50		260.8	26.6	2950.3	301.1	3871.1	395.0	TJH32-139

●Gas Spring: GK

θ	SS	Final Load		Return Force		Spring Model
		N	kgf	N	kgf	
35	33	2886.9	294.6	3826.9	390.5	M2-38.1-Yellow
40		2886.9	294.6	3814.0	389.2	M2-38.1-Yellow
45		2886.9	294.6	3800.7	387.8	M2-38.1-Yellow
50		2886.9	294.6	3786.8	386.4	M2-38.1-Yellow

Gas filling pressure: 18 MPa

●Gas Spring: GD

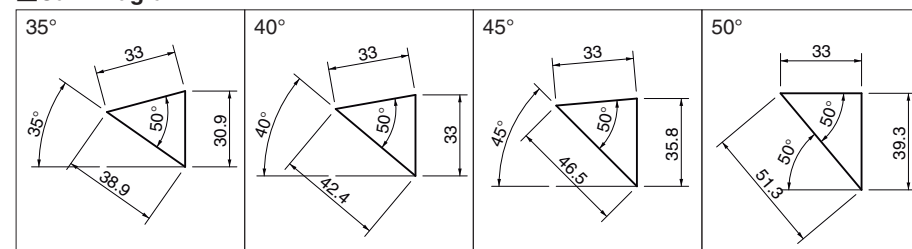
θ	SS	Final Load		Return Force		Spring Model
		N	kgf	N	kgf	
35	33	2648.4	270.2	3512.1	358.4	C.180.038.YW
40		2648.4	270.2	3499.2	357.1	C.180.038.YW
45		2648.4	270.2	3485.9	355.7	C.180.038.YW
50		2648.4	270.2	3472.1	354.3	C.180.038.YW

Gas filling pressure: 18 MPa

■Weight

θ	Option Code SH	Slider Weight kg	Total Weight kg	Tool installation weight kg
35	—	11.4	23.1	3.0
	SH25	10.2	21.9	
40	SH50	9.0	20.7	3.0
	—	11.6	23.0	
45	SH25	10.4	21.8	3.0
	SH50	9.2	20.6	
50	—	11.7	22.6	3.0
	SH25	10.6	21.5	
50	SH50	9.4	20.3	3.0
	—	12.0	23.3	
50	SH25	10.9	22.2	3.0
	SH50	9.7	21.0	

■Cam Diagram



Special Cam Units

NEW

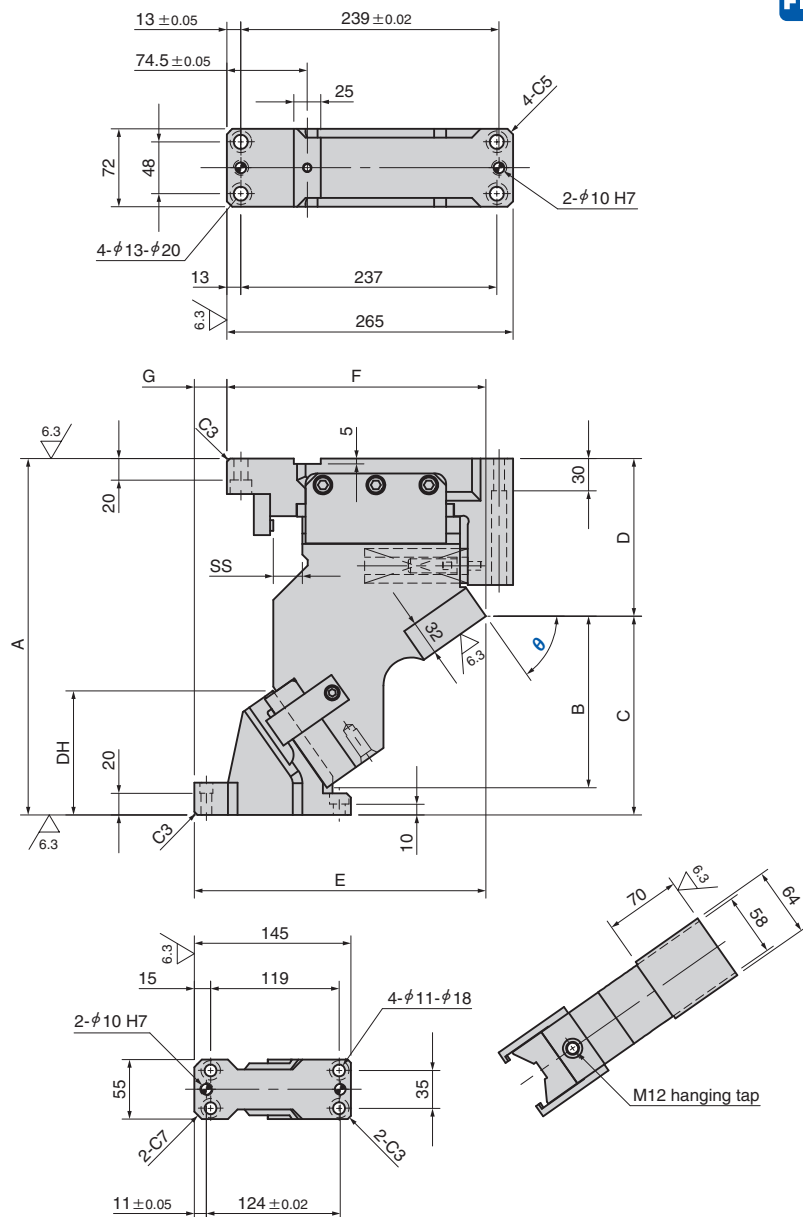
LONG LEG CAM

Panel Avoidance Cam

Aerial Cam Unit

For Pierce

SACTFR64-55~80



Working Force [kN (tonf)] 1,000,000 strokes	Catalog No.	W	θ	Spring Type PS
28.4 (2.9)	SACTFR	64	55~80 (5° increments)	No Code (Coil Spring) GK NGK GD NGD

No Code: Coil Spring GK: Gas Spring (KALLER) GD: Gas Spring (DADCO)
NGK/NGD: Without Gas Spring Parts for spring assembly are included.



Catalog No.	W	θ	Option SH	PS	Option
SACTFR	64	55	SH50		
SACTFR	64	80	SH50	GK	NF-K



Option Code	Specification
NF	Nitrogen gas not charged.
K	Key attached.

Option Code SH	Specification
SH25	Make shut height 25 mm shorter by cutting cam slider.
SH50	Make shut height 50 mm shorter by cutting cam slider.

θ	SS	Option Code SH	A	B	C	D	E	F	G	DH
55	27	—	330	158.7	184	146	270	240	30	114.8
		SH25	305	133.7	159					
		SH50	280	108.7	134					
60	24	—	335	161.5	187	148	272	238	34	119.1
		SH25	310	136.5	162					
		SH50	285	111.5	137					
65	21	—	335	161.2	186	149	274	235	39	121.6
		SH25	310	136.2	161					
		SH50	285	111.2	136					
70	18	—	335	159.8	185	150	285	232	53	124.6
		SH25	310	134.8	160					
		SH50	285	109.8	135					
75	14	—	330	154.2	180	150	291	229	62	127.0
		SH25	305	129.2	155					
		SH50	280	104.2	130					
80	11	—	330	153.2	179	151	300	226	74	133.0
		SH25	305	128.2	154					
		SH50	280	103.2	129					

Refer to page 569 for Table of Components.

NEW

LONG LEG CAM

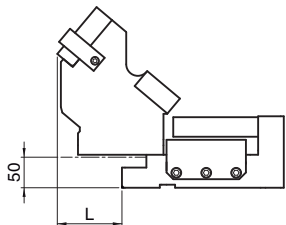
Panel Avoidance Cam

Aerial Cam Unit

For Pierce

SACTFR64-55~80

■Rear Removal Space



θ	L
55	112.8
60	110.3
65	110.7
70	119.6
75	122.7
80	128.7

■Spring Force

● Coil Spring

θ	SS	Initial Load		Final Load		Return Force		Spring Model
		N	kgf	N	kgf	N	kgf	
55	27	401.4	41.0	2809.8	286.7	4011.0	409.3	TJH32-127
60	24	394.4	40.2	2760.8	281.7	4354.7	444.4	TJH32-115
65	21	388.9	39.7	2722.0	277.8	4841.3	494.0	TJH32-102
70	18	381.9	39.0	2673.3	272.8	5497.9	561.0	TJH32-89
75	14	447.3	45.6	2534.7	258.6	6234.5	636.2	TJH32-76
80	11	442.8	45.2	2390.9	244.0	7383.3	753.4	TJH32-64

● Gas Spring: GK

θ	SS	Final Load		Return Force		Spring Model
		N	kgf	N	kgf	
55	27	2715.2	277.1	3872.7	395.2	M2-38.1-Yellow
60	24	2950.4	301.1	4655.0	475.0	M2-25-Yellow
65	21	2820.8	287.8	5017.7	512.0	M2-25-Yellow
70	18	2691.2	274.6	5535.0	564.8	M2-25-Yellow
75	14	2856.0	291.4	7030.0	717.3	M2-15-Yellow
80	11	2758.3	281.5	8526.2	870.0	M2-12.7-Yellow

Gas filling pressure: 18 MPa

● Gas Spring: GD

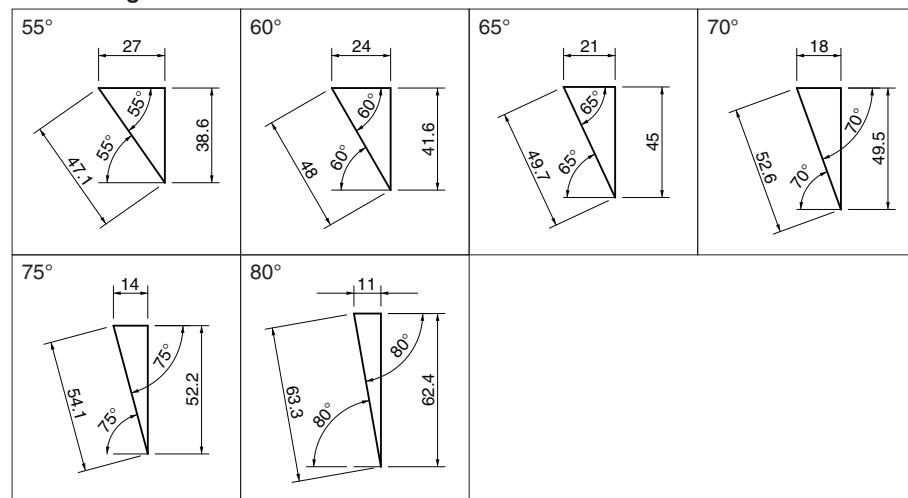
θ	SS	Final Load		Return Force		Spring Model
		N	kgf	N	kgf	
55	27	2522.1	257.4	3595.4	366.9	C.180.038.YW
60	24	2704.0	275.9	4263.8	435.1	C.180.025.YW
65	21	2608.0	266.1	4636.7	473.1	C.180.025.YW
70	18	2512.0	256.3	5164.0	526.9	C.180.025.YW
75	14	2640.0	269.4	6495.0	662.8	C.180.015.YW
80	11	2566.9	261.9	7930.7	809.3	C.180.013.YW

Gas filling pressure: 18 MPa

■Weight

θ	Option Code SH	Slider Weight kg	Total Weight kg	Tool installation weight kg
55	—	12.3	23.8	3.0
	SH25	11.2	22.7	
60	SH50	10.1	21.6	3.0
	—	12.4	23.8	
65	SH25	11.4	22.8	3.0
	SH50	10.4	21.8	
70	—	12.3	23.8	3.0
	SH25	11.3	22.8	
75	SH50	10.3	21.8	3.0
	—	12.2	23.8	
80	SH25	11.2	22.8	3.0
	SH50	10.2	21.8	
80	—	12.2	23.8	3.0
	SH25	11.2	22.8	
80	SH50	10.2	21.8	3.0
	—	12.4	24.2	
80	SH25	11.5	23.3	3.0
	SH50	10.5	22.3	

■Cam Diagram



Special Cam Units

SACTFR 64

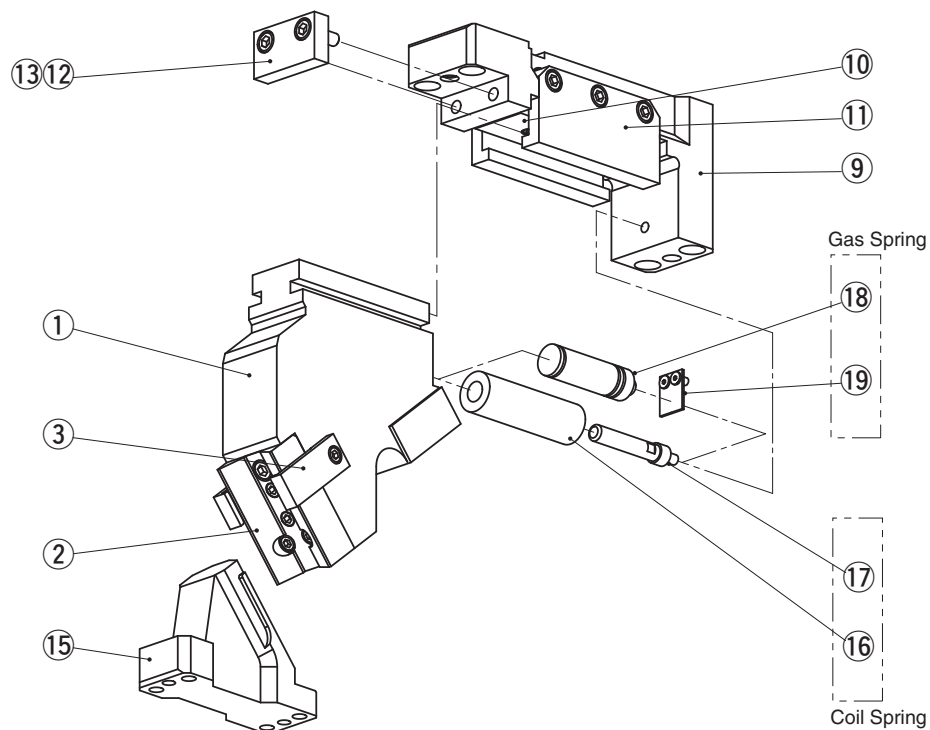
NEW

LONG LEG CAM [Table of Components]

Panel Avoidance Cam

For Pierce

Aerial Cam Unit



No.	Description	Qty	
		Coil Spring	Gas Spring
1	Cam Slider	1	
2	Cam Bottom Slide Plate	1	
3	Positive Return Follower	2	
9	Cam Holder	1	
10	Wear Plate	1	
11	Slide Keeper	2	
12	Stopper Plate	1	
13	Stopper	3	
15	Cam Driver	1	
16	Coil Spring	1	—
17	Spring Guide Pin	1	—
18	Gas Spring	—	1
19	Spring Plate	—	1

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

Special Cam Units