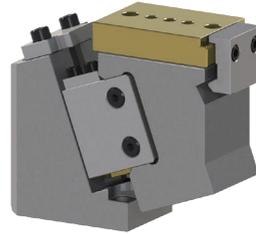


Product Information

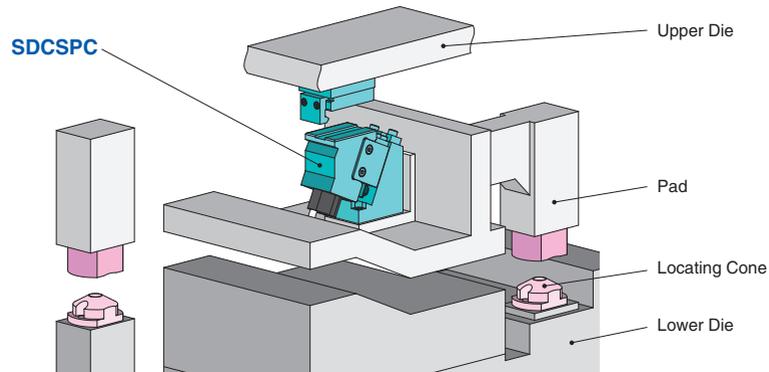
- Install the cam unit inside the pad.
- Contributes to die compactness, weight reduction, and process shortening.
- Avoidance of interference during panel transport.



Features

Install the cam unit inside the pad

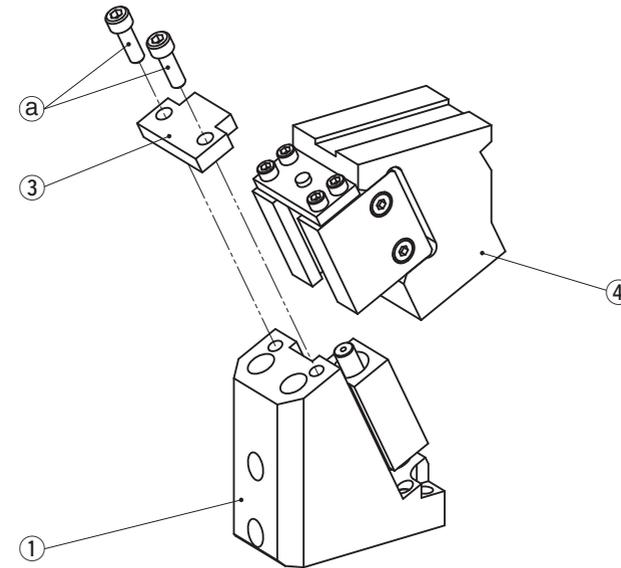
Piercing applications in the center of the panel were difficult with conventional cam are now possible.



Operational Instructions

- Locating Cones must be used to prevent damage to piercing equipment.
- Back up cam holders.
- Grease sliding surfaces regularly.
- When a Cam is subject to an uneven load when processing ultra-high-tensile materials add cast-in support for back-up.

SDCSPC Assembly Instructions



Disassembly

- 1) Remove Hexagon Socket Head Bolts (a), to pull out Stopper Plate (3).
- 2) Pull out and remove Cam Slider (4) from Cam Holder (1).

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.

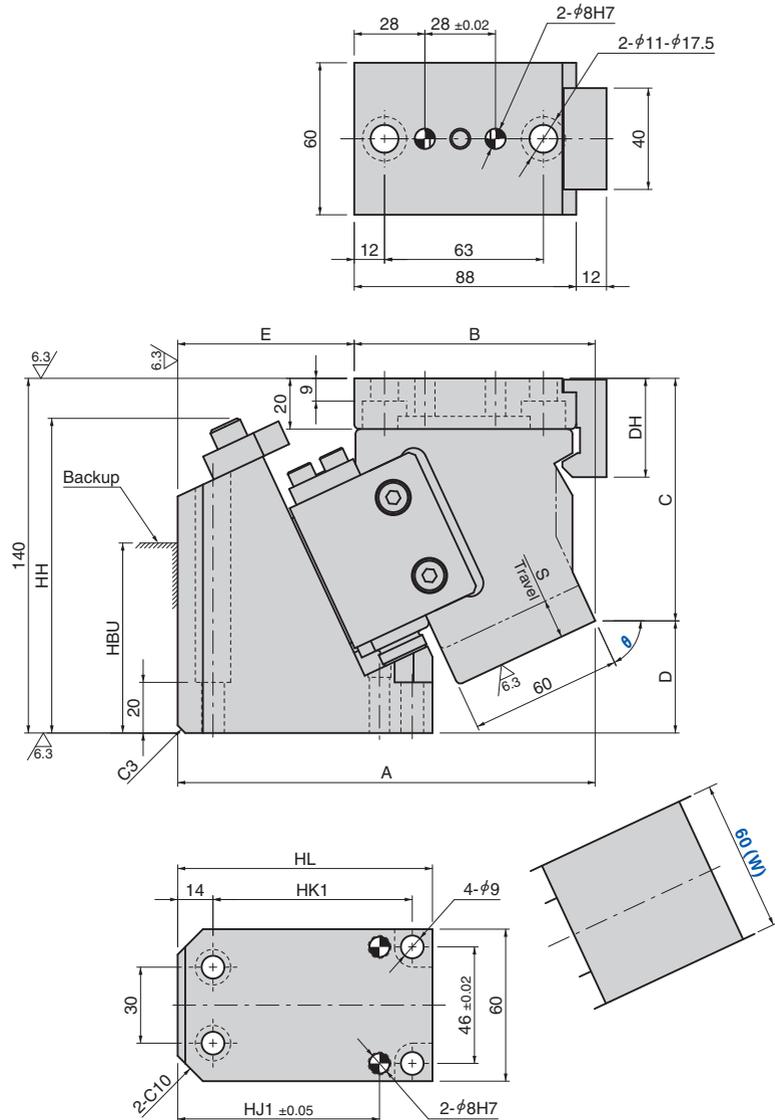
NEW Pad Mounted Cam Unit

For Pierce

Pad Mounted Cam Unit

SDCSPC60

CAD
FILE



Working Force [kN (tonf)] 1,000,000 strokes	Catalog No.	W	θ 5° increments	Spring Type PS
29.4 (3.0)	SDCSPC	60	50	GK NGK GD NGD GSS NGSS
34.3 (3.5)			55	
39.2 (4.0)			60	
44.1 (4.5)			65	
44.1 (4.5)			70	
44.1 (4.5)			75	
44.1 (4.5)			80	
44.1 (4.5)			85	

GK: Gas Spring (KALLER) GD: Gas Spring (DADCO) GSS: Gas Spring (Special Springs)
NGK/NGD/NGSS: Without Gas Spring

Order	Catalog No.	W	θ	PS	Option
	SDCSPC	60	50	GK	
	SDCSPC	60	50	GK	NF

Option	Option Code	Specification
	NF	Nitrogen gas not charged.

θ	A	B	C	D	E	S	DH	HH	HL	HK1	HJ1	HBU
50	175.28	107.28	72.67	67.33	68	16	41.5	107.8	119	97	98	75
55	172.92	103.92	79.83	60.17	69	16	41.5	114.2	113	91	92	70
60	170.02	100.02	87.20	52.80	70	16	39.0	120.0	108	86	87	65
65	165.55	95.55	95.73	44.27	70	16	39.0	124.2	101	79	80	60
70	161.19	93.19	105.25	34.75	68	18	39.0	128.6	95	73	74	55
75	154.40	89.40	113.00	27.00	65	20	39.0	132.3	87	65	66	50
80	147.01	87.01	121.74	18.26	60	23	39.0	134.2	80	58	59	40
85	140.05	85.05	128.43	11.57	55	23	39.0	137.3	74	52	53	30

Refer to page 8 for Table of Components.

NEW Pad Mounted Cam Unit

For Pierce

Pad Mounted Cam Unit

Spring Force

● Gas Spring

θ	Spring Model	Final Load		Return Force	
	GK	N	kgf	N	kgf
50	X170-025	2247	229.3	2222	226.7
55	X170-025	2247	229.3	2220	226.5
60	X170-025	2247	229.3	2219	226.4
65	X170-025	2247	229.3	2216	226.1
70	X170-025	2345	239.3	2312	235.9
75	X170-025	2451	250.1	2417	246.6
80	X170-025	2630	268.4	2594	264.7
85	X170-025	2630	268.4	2594	264.7

Gas filling pressure: 18 Mpa

θ	Spring Model	Final Load		Return Force	
	GD	N	kgf	N	kgf
50	U.0175.025.TO.C	2268	231.4	2243	228.8
55	U.0175.025.TO.C	2268	231.4	2241	228.6
60	U.0175.025.TO.C	2268	231.4	2239	228.5
65	U.0175.025.TO.C	2268	231.4	2237	228.2
70	U.0175.025.TO.C	2368	241.6	2335	238.2
75	U.0175.025.TO.C	2477	252.7	2442	249.2
80	U.0175.025.TO.C	2660	271.4	2624	267.8
85	U.0175.025.TO.C	2660	271.4	2624	267.8

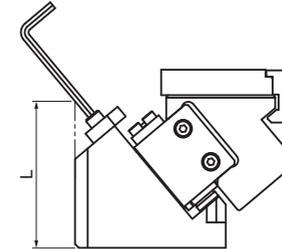
Gas filling pressure: 18 Mpa

θ	Spring Model	Final Load		Return Force	
	GSS	N	kgf	N	kgf
50	RV170-025-C	2347	239.5	2321	236.9
55	RV170-025-C	2347	239.5	2319	236.6
60	RV170-025-C	2347	239.5	2318	236.5
65	RV170-025-C	2347	239.5	2315	236.3
70	RV170-025-C	2468	251.8	2435	248.4
75	RV170-025-C	2602	265.5	2568	262.0
80	RV170-025-C	2833	289.1	2798	285.5
85	RV170-025-C	2833	289.1	2798	285.5

Gas filling pressure: 18 Mpa

Rear Removal Space

θ	L mm
50	113.7
55	124.9
60	138.3
65	152.0
70	172.1
75	199.5
80	250.2
85	413.3

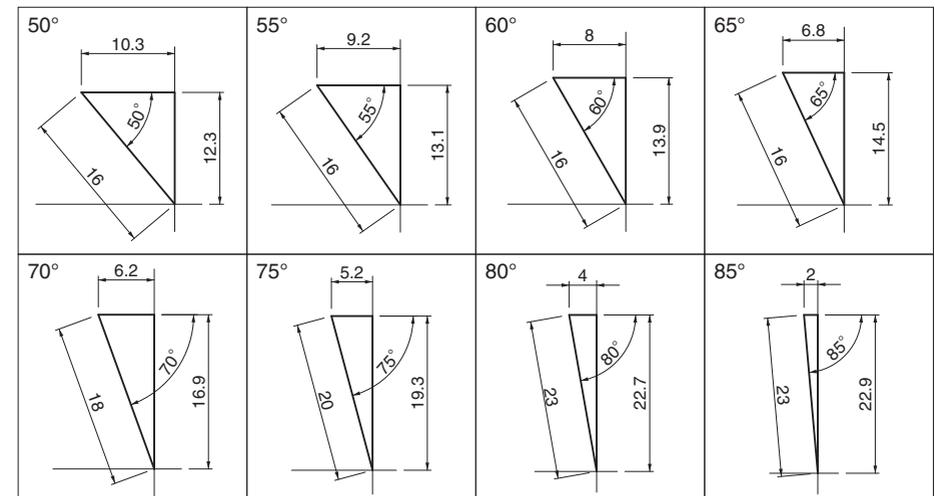


Weight

θ	Slider Weight kg	Total Weight kg	Tool installation Weight*1 kg
50	7.1	3.0	1.9
55	7.2	3.1	1.9
60	7.2	3.1	1.9
65	7.3	3.3	1.9
70	7.3	3.4	1.9
75	7.3	3.5	1.9
80	7.2	3.6	1.9
85	7.1	3.6	1.9

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

Cam Diagram

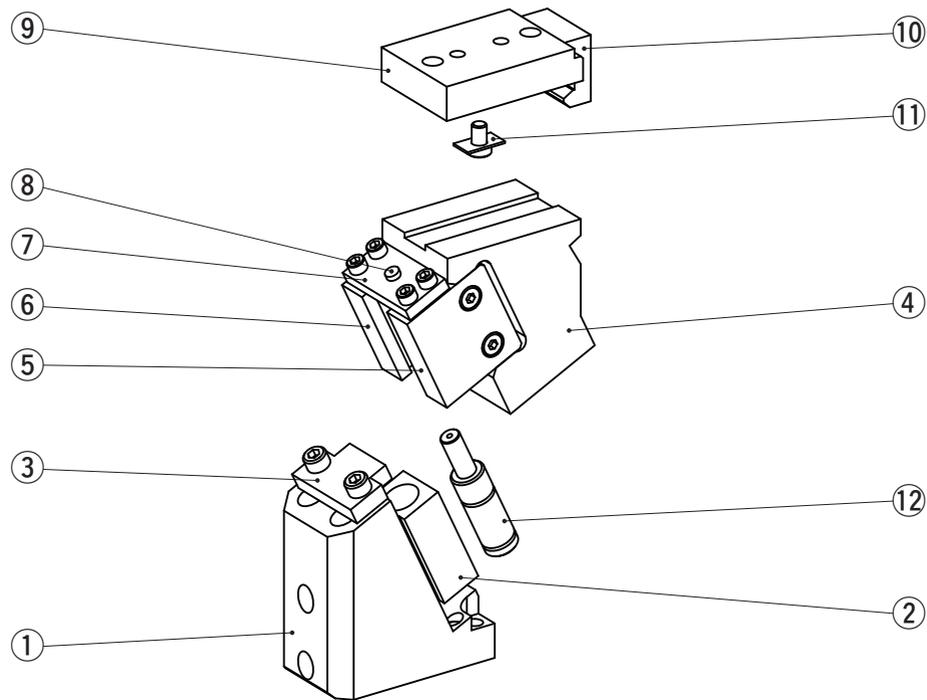


NEW SDCSPC [Table of Components]

For Pierce

Pad Mounted Cam Unit

SDCSPC60



No.	Description	Qty
1	Cam Holder	1
2	Guide Block	1
3	Stopper Plate	1
4	Cam Slider	1
5	Slide Keeper A	1
6	Slide Keeper B	1
7	Spring Stopper Plate	1
8	Stop Pin	1
9	Driver Plate	1
10	Positive Return Plate	1
11	Plate	1
12	Gas Spring	1

Bolts for assembly are not indicated.