SKCA [Overview]

Product Information

- Mount face widths 52, 65, 100, 150, 200, 250, and 300 mm.
- •Working angles from 0° to 20° in 5° increments for 65, 100, and 150 mm.
- Mount face widths of 52, 200, 250, and 300 mm are available with an angle of 0°.
- •Gas Spring is available in 65, 100, 150, and 200 mm width and 0°.
- The Box-type holder provides high rigidity.



■Gas Spring Specifications

Moun	t Face			Working For	ce [kN (tonf)]		
w	Н	Working Angle	Travel	Standard Working Force 1,000,000 strokes	Allowable Working Force 300,000 strokes	Spring Force N (kgf)	
65	70	00	38	19.6 (2.0)	39.2 (4.0)	667 (69.1)	
100	100	00	40	29.4 (3.0)	58.8 (6.0)	1111 (113.4)	
150	100	00	40	58.8 (6.0)	88.2 (9.0)	2051 (209.3)	
200	110	00	40	78.4 (8.0)	117.6 (12.0)	2733 (278.9)	

■Coil Spring Specifications

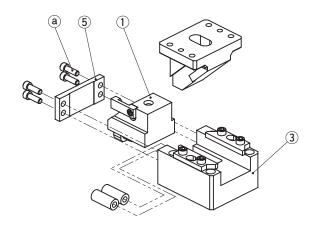
W H Angle Working Force Working Force	Moun	t Face			Working For		
52 65 00 40 14.7 (1.5) 29.4 (3.0) 00 60 40 60 60 60 60 60 60 60 60 60 60 60 60 60	W	н	Working Angle	Travel		Allowable Working Force 300,000 strokes	
60				25			
00	52	65	00	40	14.7 (1.5)	29.4 (3.0)	
00 60 60 05 45 70 10 45 19.6 (2.0) 39.2 (4.0) 15 45 10 10 10 10 10 15 70 10 15 15 70 10 10 15 70 10 10 15 70 15 15 70 10 10 10 10 10 10 10 10 10 10 10 10 10				60			
65 70 10 45 70 19.6 (2.0) 39.2 (4.0) 15 45 70 45 70 45 70 70 10 70 19.6 (2.0) 39.2 (4.0) 15 70 45 70 70 100 00 60 29.4 (3.0) 58.8 (6.0) 100 10 45 70 10 70 39.2 (4.0) 78.4 (8.0) 100 10 45 70 70 10 45 70 70 10 10 70 10 10 70 10 10 10 10 10 10 10 10 10 10 10 10 10			00	40			
65 70 10 70 19.6 (2.0) 39.2 (4.0) 15 70 19.6 (2.0) 39.2 (4.0) 15 70 10 45 70 100 10 45 70 100 10 45 70 15 70 100 10 45 70 100 10 45 70 100 10 45 70 100 10 45 10 70 100 10 45 10 70 100 10 45 10 70 100 10 45 10 100 10 45 10 100 10 10 45 10 100 10 10 10 10 10 10 10 10 10 10 10			00	60			
65 70 10 45 19.6 (2.0) 39.2 (4.0) 15 45 70 45 70 70 10 45 70 70 70 70 70 70 70 70 70 70 70 70 70			05	45			
65 70 10 70 19.6 (2.0) 39.2 (4.0) 15 45 70 40 40 40 40 40 40 40 40 40 40 40 40 40			05	70			
15	6E	70	10	45	10.6 (2.0)	20.2 (4.0)	
15 70 20 45 20 70 40 29.4 (3.0) 58.8 (6.0) 100 00 60 29.4 (3.0) 58.8 (6.0) 100 10 45 70 70 100 45 70 39.2 (4.0) 78.4 (8.0) 15 70 45 20 70 00 40 58.8 (6.0) 88.2 (9.0) 15 70 15 70 15 45 70 15 45 70 20 45 20 70 20 45 20 70 20 45 20 70 20 45 20 70 20 45 20 70 20 45 20 70 20 45 20 70 20 45 20 70 20 45 20 70 20 45 20 70 20 45 20 70 20 47 20 48 20 70 20 40 98.0 (10.0) 147.6 (12.0) 250 130 00 40 117.6 (12.0) 176.4 (18.0)	65	70	10	70	19.6 (2.0)	39.2 (4.0)	
100			45	45			
20			15	70			
100 00 60 29.4 (3.0) 58.8 (6.0) 100 05 70 100 10 70 39.2 (4.0) 78.4 (8.0) 15 70 20 45 05 70 00 60 58.8 (6.0) 88.2 (9.0) 150 100 10 70 150 45 20 45 20 45 20 45 20 45 20 45 20 45 20 70 20 45 20 70 20 45 20 70 20 45 20 70 20 45 20 70 20 45 20 70 20 45 20 70 20 45 20 70 20 45 20 70 20 45 20 70 20 46 20 70 20 47 20 48 20 70 20 47 20 48 20 70 20 40 98.0 (10.0) 117.6 (12.0) 250 130 00 40 98.0 (10.0) 147.0 (15.0)			200	45			
100 00 60 29.4 (3.0) 58.8 (6.0) 80 05 70 100 10 45 70 45 70 45 70 20 45 70 00 60 05 45 70 150 100 10 70 45 70 46 78.4 (8.0) 117.6 (12.0) 250 130 00 00 117.6 (12.0) 176.4 (18.0)			20	70			
100				40			
100 10 10 10 10 10 10 10 10 10		100	00	60	29.4 (3.0)	58.8 (6.0)	
100 10 10 10 10 10 10 10 10 15 15				80			
100 10 10 10 10 10 10 15 70 45 70 45 20 45 70 46 00 60 58.8 (6.0) 88.2 (9.0) 150 100 10 10 10 10 45 70 46 78.4 (8.0) 117.6 (12.0) 250 130 00 130 00 117.6 (12.0) 176.4 (18.0)			0.5	45			
90			05	70			
90	100		10	45			
15		00	10	70	20.0 (4.0)	70.4 (0.0)	
20		90	45	45	39.2 (4.0)	76.4 (6.0)	
20 70			15	70			
70 40 58.8 (6.0) 88.2 (9.0) 05 45 70 100 10 45 70 45 70 45 70 45 70 20 45 70 20 45 70 20 45 70 20 40 70 20 110 00 40 78.4 (8.0) 117.6 (12.0) 130 300 00 117.6 (12.0) 176.4 (18.0)			00	45			
00 60 58.8 (6.0) 88.2 (9.0) 05 45 70 100 10 45 15 70 20 45 20 70 200 110 00 60 78.4 (8.0) 117.6 (12.0) 250 00 60 98.0 (10.0) 147.0 (15.0) 300 00 117.6 (12.0) 176.4 (18.0)			20	70			
150 100 10 45 70 45 64.7 (6.6) 98.0 (10.0) 15 70 45 70 20 45 70 20 45 70 20 40 70 117.6 (12.0) 250 00 40 98.0 (10.0) 147.0 (15.0) 300 00 117.6 (12.0) 176.4 (18.0) 176.4 (18.0)			00	40	E0.0 (6.0)	99.2 (0.0)	
150 100 10 45 70 64.7 (6.6) 98.0 (10.0) 15 70 45 70 98.0 (10.0) 20 45 70 70 70 70 70 70 70 70 70 70 70 70 70			00	60	56.6 (6.0)	00.2 (9.0)	
150 100 10 45 64.7 (6.6) 98.0 (10.0) 15 45 70 20 45 20 70 200 110 00 60 78.4 (8.0) 117.6 (12.0) 250 00 60 98.0 (10.0) 147.0 (15.0) 300 00 117.6 (12.0) 176.4 (18.0)			0.5	45			
150 100 10 70 64.7 (6.6) 98.0 (10.0) 15 70 45 70 20 45 70 200 110 00 40 78.4 (8.0) 117.6 (12.0) 250 00 40 98.0 (10.0) 147.0 (15.0) 300 40 117.6 (12.0) 176.4 (18.0)			05	70			
200 110 00 40 78.4 (8.0) 117.6 (12.0) 250 00 40 98.0 (10.0) 130 40 117.6 (12.0) 176.4 (18.0)	150	100	10	45			
200 110 00 45 70 117.6 (12.0) 1250 00 40 98.0 (10.0) 147.0 (15.0) 130 40 117.6 (12.0) 176.4 (18.0)	150	100	10	70	647(66)	00.0 (10.0)	
20			45	45	64.7 (6.6)	98.0 (10.0)	
20 70 110 00 40 78.4 (8.0) 117.6 (12.0) 250 00 40 98.0 (10.0) 147.0 (15.0) 300 40 117.6 (12.0) 176.4 (18.0)			15	70			
200 110 00 40 78.4 (8.0) 117.6 (12.0) 250 00 40 98.0 (10.0) 147.0 (15.0) 300 40 117.6 (12.0) 176.4 (18.0)			00	45			
200 110 00 60 78.4 (8.0) 117.6 (12.0) 250 00 40 98.0 (10.0) 147.0 (15.0) 300 40 117.6 (12.0) 176.4 (18.0)			20	70			
250 00 40 98.0 (10.0) 147.0 (15.0) 300 40 117.6 (12.0) 176.4 (18.0)	200	110	00	40	79.4 / 9.0\	117.6 (10.0)	
250 00 60 98.0 (10.0) 147.0 (15.0) 300 40 117.6 (12.0) 176.4 (18.0)	200	110	00	60	76.4 (8.0)	117.6 (12.0)	
300 00 40 117.6 (12.0) 176.4 (18.0)	050		00	40	00.0 (40.0)	1470 (150)	
300 00 40 117.6 (12.0) 176.4 (18.0)	∠50	100	00	60	96.0 (10.0)	147.0 (15.0)	
60 117.6 (12.0) 176.4 (18.0)	200	130	00	40	1176 (10.0)	176 4 (10.0)	
	300		00	60	117.0 (12.0)	1/0.4 (18.0)	

SKCA

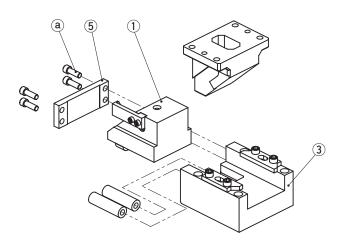
SKCA [Overview]

Product Information

■SKCA52, 65 Assembly Instructions

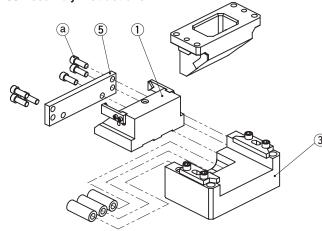


■SKCA100, 150 Assembly Instructions

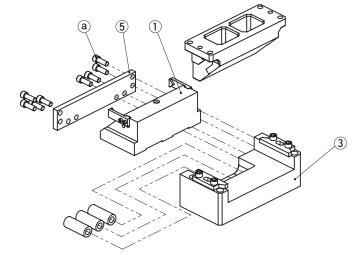


- 1) Remove Hexagon Socket Head Bolts (a), to pull out Stopper Plate (5).
- 2) Pull out and remove Cam Slider (1) from Cam Holder (3) to the rear.

■SKCA200, 250 Assembly Instructions



■SKCA300 Assembly Instructions



Assembly

Assembly is the reverse procedure of disassembly.

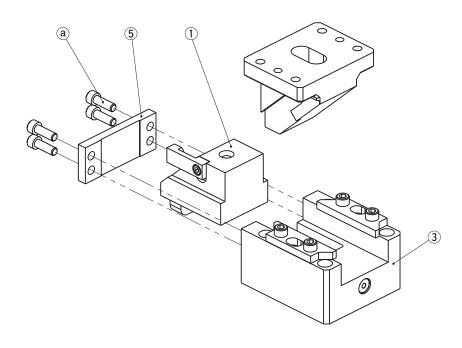
- · Ensure that all parts are clean, particularly the sliding components to which a small amount of lubricant is applied and is then placed in position.
- · Take care that the respective tolerances are observed when assembling Cam Slider and Cam Holder, which also should be identified by the same serial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



SKCA [Overview]

Product Information

SKCA65, 100, 150 Assembly Instructions (Gas Spring)



Disassembly

- 1) Remove Hexagon Socket Head Bolts (a), to pull out Stopper Plate (5).
- 2) Pull out and remove Cam Slider (1) from Cam Holder (3) to the rear.

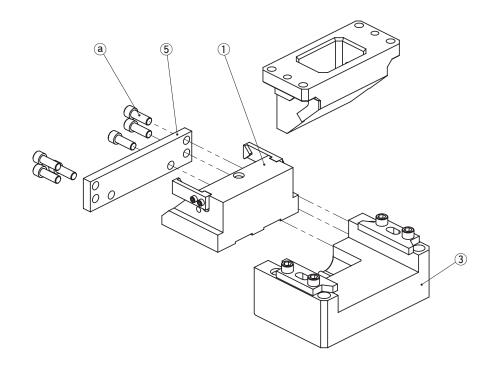
Assembly

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.

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.

■SKCA200 Assembly Instructions (Gas Spring)



Disassembly

- 1) Remove Hexagon Socket Head Bolts (a), to pull out Stopper Plate (5).
- 2) Pull out and remove Cam Slider (1) from Cam Holder (3) to the rear.

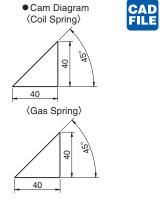
Assembly

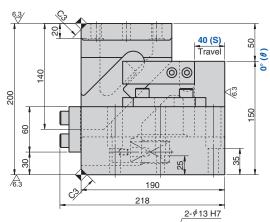
Assembly is the reverse procedure of disassembly.

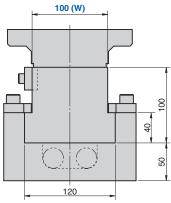
- Ensure that all parts are clean, particularly the sliding components to which a small amount of lubricant is applied and is then placed in position.
- Take care that the respective tolerances are observed when assembling Cam Slider and Cam Holder, which also should be identified by the same serial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

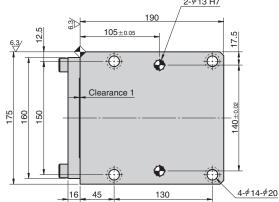
Please contact your local sales representative if you prefer to use a gas spring not specified in our catalog. For use and maintenance of gas spring, please contact the manufacturer directly.

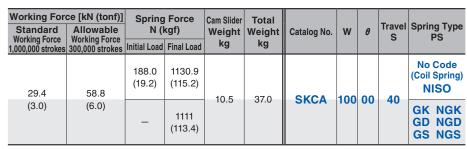
SKCA











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



Catalog No.	W]-	θ] –	S]-	PS	- Option
SKCA	100	_	00	_	40	_	GK	– NF



Option Code	Specification				
NF	Nitrogen gas not charged.				
N12	ϕ 12 mm dowel holes provided on holder.				

Refer to page 377 for the machining details of tapped holes and dowel holes for retainer mounting.

■Spring Specification

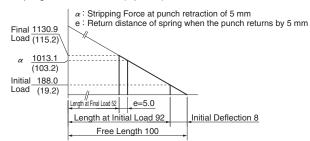
No.	PS	Spring Model	Qty	Remark
	No Code	TF27-100	2	Coil Spring 11.78 N/mm (1.20 kgf/mm)
8	GK	R19-50-Yellow	1	Gas Spring (KALLER)
0	GD	C.090.050.YW	1	Gas Spring (DADCO)
	GS	SFL.90.50	1	Gas Spring (SDT)

Gas filling pressure: 18 MPa

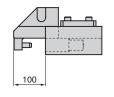
Life expectancy of Coil Spring is approximately 300,000 strokes.

■Spring Diagram

· Spring Model TF27-100 (2 pieces)



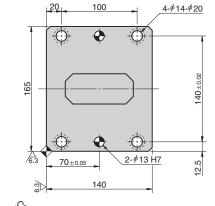
■Rear Removal Space

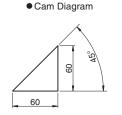


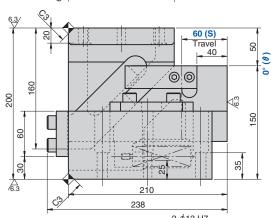
SKCA 100

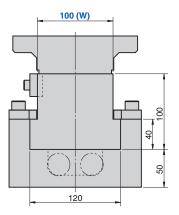
Refer to page 1011, 1012 for Table of Components.

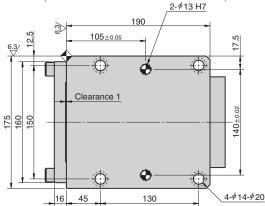












Working Ford	ce [kN (tonf)]	Spring	Force	Cam Slider	Total				
Standard	Allowable	N (I	kgf)	Weight	Weight	Catalog No.	W	θ	Travel S
Working Force 1,000,000 strokes	Working Force 300,000 strokes	Initial Load	Final Load	kg	kg				3
29.4	58.8	204.1	1146.1	10.5	38.0	SKCA	100	00	60
(3.0)	(6.0)	(20.8)	(116.8)	10.5	36.0	SKCA	100	UU	00



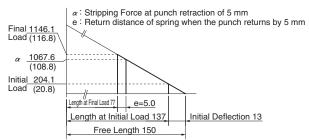
Catalog No.	W]-	θ	-	S
SKCA	100	_	00	_	60



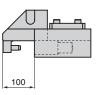
Option Code	Specification
N12	ϕ 12 mm dowel holes provided on holder.

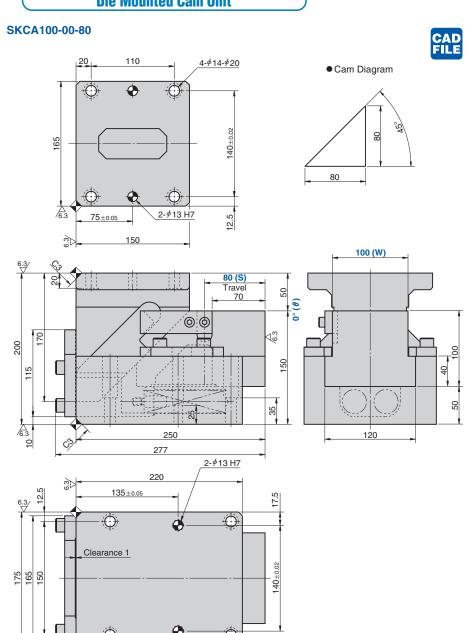
■Spring Diagram

- · Spring Model TF27-150 (2 pieces)
- · Spring constant 7.85 N/mm (0.80 kgf/mm)
- · Life expectancy of Coil Spring is approximately 300,000 strokes.



■Rear Removal Space





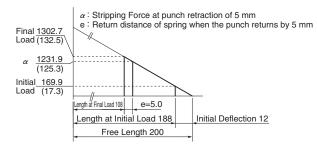
Standard	ce [kN (tonf)] Allowable	Opinig	Force (gf)	Cam Slider Weight	Total Weight	Catalog No.	w	θ	Travel S
Working Force 1,000,000 strokes	Working Force 300,000 strokes	Initial Load	Final Load	kg	kg				
29.4	58.8	169.9	1302.7	11.9	44.0	SKCA	100	00	80
(3.0)	(6.0)	(17.3)	(132.5)	11.9	44.0	SKCA	100	UU	00



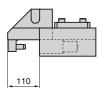
5	Option Code	Specification
Option	N12	ϕ 12 mm dowel holes provided on holder.

■Spring Diagram

- · Spring Model TF30-200 (2 pieces)
- · Spring constant 7.08 N/mm (0.72 kgf/mm)
- · Life expectancy of Coil Spring is approximately 300,000 strokes.



■Rear Removal Space



SKCA 100

Refer to page 1011 for Table of Components.

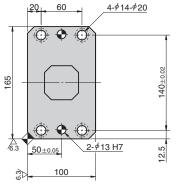
160

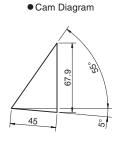
45

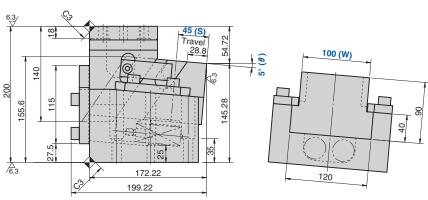
993

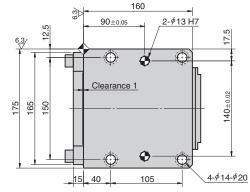
4-\$14-\$20











Standard	ce [kN (tonf)]	Opinig	Force kgf)	Cam Slider Weight	Total Weight	Catalog No.	w	θ	Travel S
Working Force 1,000,000 strokes	Working Force 300,000 strokes	Initial Load	Final Load	kg	kg				
39.2	78.4	263.8	1111.6	7.2	33.0	SKCA	100	05	45
(4.0)	(8.0)	(26.9)	(113.3)	1.2	33.0	SKCA	100	US	40



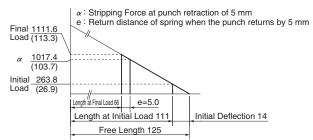
Catalog No.	W] —	θ	-	S
SKCA	100	_	05	_	45



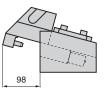
Option Code	Specification
N12	ϕ 12 mm dowel holes provided on holder.

■Spring Diagram

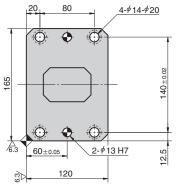
- · Spring Model TF27-125 (2 pieces)
- · Spring constant 9.42 N/mm (0.96 kgf/mm)
- · Life expectancy of Coil Spring is approximately 300,000 strokes.

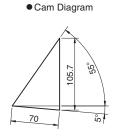


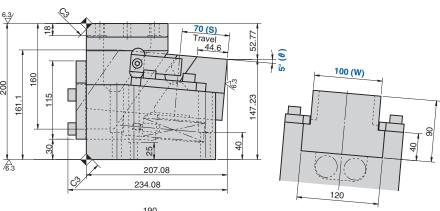
■Rear Removal Space

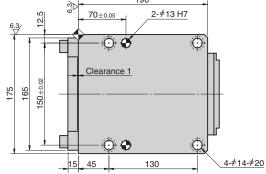












Standard	orking Force [kN (tonf)] Standard Allowable forking Force Working Force		ndard Allowable N (kgf)		Cam Slider Weight		Catalog No.	w	θ	Travel
1,000,000 strokes		Initial Load	Final Load	kg	kg					
39.2	78.4	195.2	1137.4	10.0	38.0	SKCA	100	05	70	
(4.0)	(8.0)	(20.0)	(116.6)	10.0	30.0	SKCA	100	US	70	



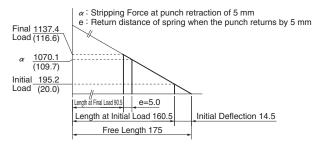
Catalog No.	W] —	θ	-	S
SKCA	100	_	05	_	70



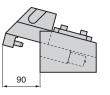
	Option Code	Specification
N12 \$\delta 12\$ mm dowel holes provided		ϕ 12 mm dowel holes provided on holder.

■Spring Diagram

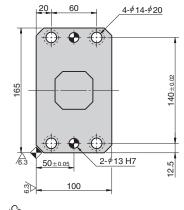
- · Spring Model TF27-175 (2 pieces)
- · Spring constant 6.73 N/mm (0.69 kgf/mm)
- · Life expectancy of Coil Spring is approximately 300,000 strokes.

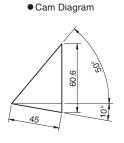


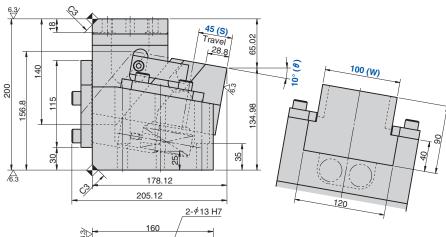
■Rear Removal Space











	205.12
	2-\psi 13 H7
6.3/	90±0.05
1 1	
175 165 150	Clearance 1 20 00 00 00 00 00 00 00 00 00 00 00 00
7 9 2	140
	15 40 105 4-\$\psi 14-\$\psi 20

Standard	Working Force [kN (tonf)] Standard Allowable Working Force Working Force		ard Allowable N (kgf)		Cam Slider Weight		Catalog No.	w	θ	Travel
1,000,000 strokes		Initial Load	Final Load	kg	kg					
39.2	78.4	263.8	1111.6	7.0	33.0	SKCA	100	10	45	
(4.0)	(8.0)	(26.9)	(113.3)	7.0	33.0	SKCA	100	10	45	



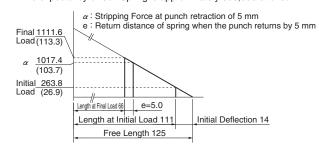
Catalog No.	W]-[θ	-	S
SKCA	100	_	10	_	45



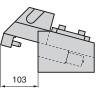
Option Code	Specification
N12	\$\phi_{12}\$ mm dowel holes provided on holder.

■Spring Diagram

- · Spring Model TF27-125 (2 pieces)
- · Spring constant 9.42 N/mm (0.96 kgf/mm)
- · Life expectancy of Coil Spring is approximately 300,000 strokes.



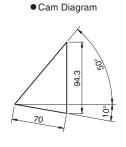
■Rear Removal Space

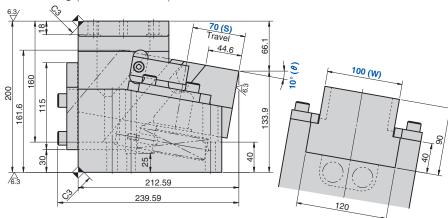


SKCA 100

1000

Refer to page 1011 for Table of Components.





6.3/	70±0.05	190 2-∮13 H7	-
	Clearance 1	((
175 165 150±0.02		·	
<u> [</u>	15 45	130	4-\$\psi 14-\$\psi 20

Working Force [kN (tonf)] Standard Allowable		Allowable N (kgf)		Cam Slider Total Weight Weight		Catalog No.	w	θ	Travel
Working Force 1,000,000 strokes	Working Force 300,000 strokes	Initial Load	Final Load	kg	kg				
39.2	78.4	195.2	1137.4	10.0	38.0	SKCA	100	10	70
(4.0)	(8.0)	(20.0)	(116.6)	10.0	30.0	SKCA	100	10	70



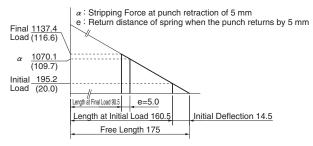
Catalog No.	W]-	θ	-	S
SKCA	100	_	10	_	70



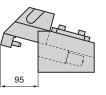
	Option Code	Specification
N12 \$\phi\$12 mm dov		ϕ 12 mm dowel holes provided on holder.

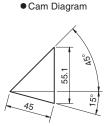
■Spring Diagram

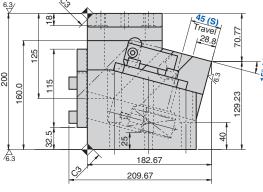
- · Spring Model TF27-175 (2 pieces)
- · Spring constant 6.73 N/mm (0.69 kgf/mm)
- · Life expectancy of Coil Spring is approximately 300,000 strokes.

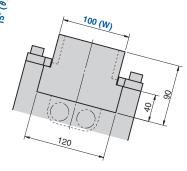


■Rear Removal Space









			13	-	16	0	-		
6.3	V	12.5	6.3	90	±0.05	1/	2-∮13	3 H7	17.5
T	7	-			<u>)</u> ;	<u>4</u> —	O		\equiv
175	165	150	-	Clear	ance 1				140±0.02
ļ	,	,		—(Ç) +	o —	0		
			15	40		105	Ī	4-\$1	4-∳20

	- 9
1	45°
	1.55.1
45	15°

Trave			Total	Cam Slider	opining i oroc		Standard Allowable	
$W \mid \theta \mid S$	W	Catalog No.	Weight	Weight	N (kgf)		Standard Allowable	
			kg	kg	Final Load	Initial Load	Working Force 300,000 strokes	Working Force 1,000,000 strokes
100 15 45	100	SKCA	33.0	7.0	1111.6	263.8	78.4	39.2
100 15 45	100	SKCA	33.0	7.0	(113.3)	(26.9)	(8.0)	(4.0)



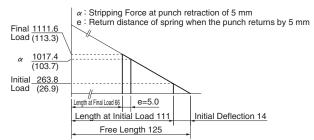
Catalog No.	W] —	θ	-	S
SKCA	100	_	15	_	45



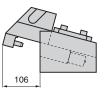
Option Code	Specification
N12	ϕ 12 mm dowel holes provided on holder.

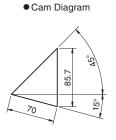
■Spring Diagram

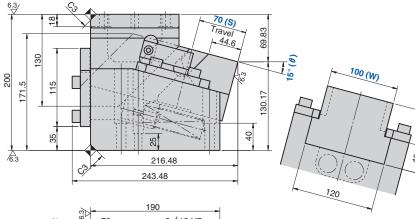
- · Spring Model TF27-125 (2 pieces)
- · Spring constant 9.42 N/mm (0.96 kgf/mm)
- · Life expectancy of Coil Spring is approximately 300,000 strokes.

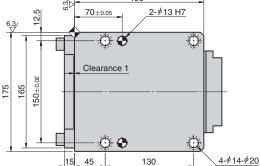


■Rear Removal Space









Standard	Vorking Force [kN (tonf)] Standard Allowable Working Force Working Force		Spring Force N (kgf)		Total Weight	Catalog No.	w	θ	Travel
1,000,000 strokes		Initial Load	Final Load kg kg				3		
39.2	78.4	195.2	1137.4	10.0	38.0	SKCA	100	15	70
(4.0)	(8.0)	(20.0)	(116.6)	10.0	30.0	SKCA	100	15	70



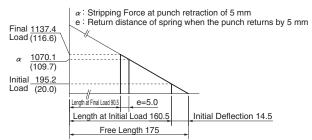
Catalog No.	W]-	θ	-	S
SKCA	100	_	15	_	70



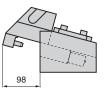
Option Code	Specification
N12	ϕ 12 mm dowel holes provided on holder.

■Spring Diagram

- · Spring Model TF27-175 (2 pieces)
- · Spring constant 6.73 N/mm (0.69 kgf/mm)
- · Life expectancy of Coil Spring is approximately 300,000 strokes.

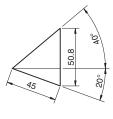


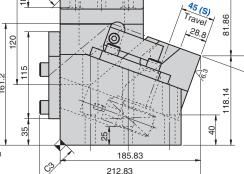
■Rear Removal Space

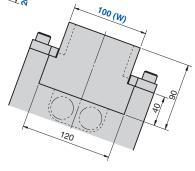


SKCA100-20-45









	à	n		160		1	
6.3/	o w		90±0.05	· /	2-\$13	H7	17.5
	0	C	learance	& -	<u></u>		2
175 165 150							140±0.02
<u> </u>	d			& -	0		
	_ 1	15 4	0	105		4-\$14	<i>-</i> ∮20

Standard	Working Force [kN (tonf)] Standard Allowable Working Force Working Force		N (kgf)			Catalog No.	w	θ	Travel
1,000,000 strokes		Initial Load	Final Load	kg	kg				
39.2	78.4	263.8	1111.6	7.0	32.0	SKCA	100	20	45
(4.0)	(8.0)	(26.9)	(113.3)	7.0	32.0	SKCA	100	20	45



Catalog No.	W] —	θ	-	S
SKCA	100	_	20	_	45

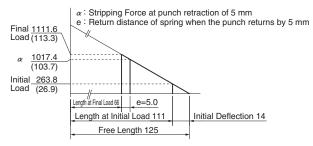


Option Code	Specification
N12	ϕ 12 mm dowel holes provided on holder.

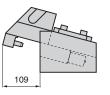
Refer to page 377 for the machining details of tapped holes and dowel holes for retainer mounting.

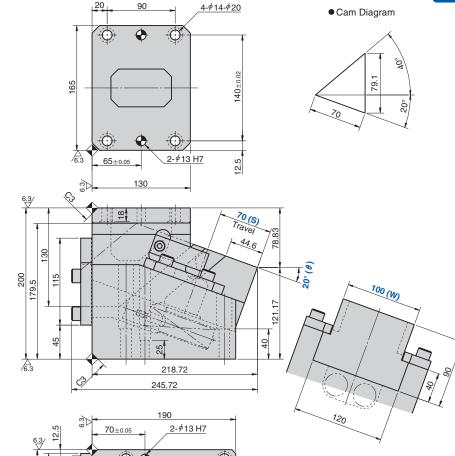
■Spring Diagram

- · Spring Model TF27-125 (2 pieces)
- · Spring constant 9.42 N/mm (0.96 kgf/mm)
- · Life expectancy of Coil Spring is approximately 300,000 strokes.



■Rear Removal Space





Working Force [kN (tonf)] Standard Allowable		Spring Force N (kgf)		Cam Slider Weight	Total Weight	Catalog No.	w	θ	Travel
Working Force 1,000,000 strokes	Working Force 300,000 strokes	Initial Load	Final Load	kg	kg				
39.2	78.4	195.2	1137.4	10.0	39.0	SKCA	100	20	70
(4.0)	(8.0)	(20.0)	(116.6)	10.0	39.0	SKCA	100	20	70



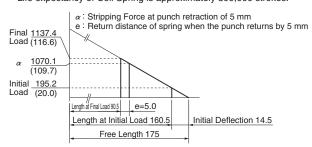
Catalog No.	W]-	θ	-	S
SKCA	100	_	20	_	70



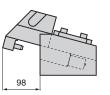
Option Code	Specification				
N12	ϕ 12 mm dowel holes provided on holder.				

■Spring Diagram

- · Spring Model TF27-175 (2 pieces)
- · Spring constant 6.73 N/mm (0.69 kgf/mm)
- · Life expectancy of Coil Spring is approximately 300,000 strokes.



■Rear Removal Space



SKCA 100

Refer to page 1011 for Table of Components.

1009

Clearance 1

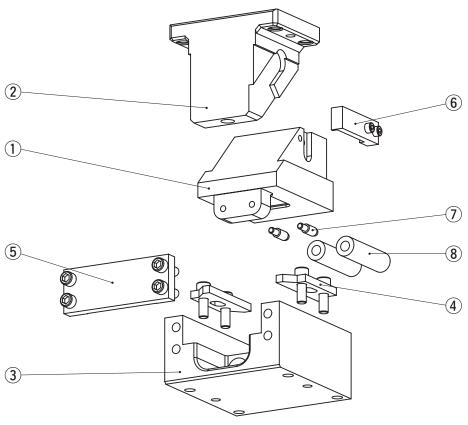
130

4-*\phi*14-*\phi*20

SKCA [Table of Components]

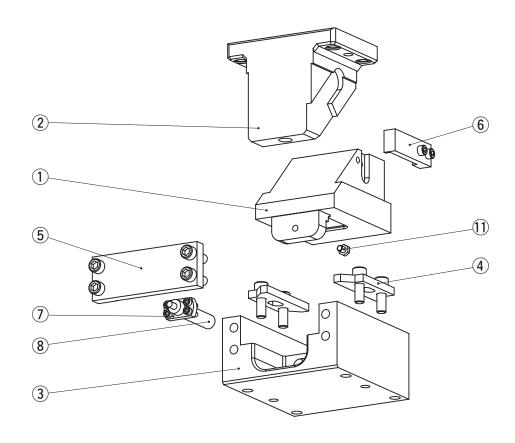
Die Mounted Cam Unit





No.	Description	Qty	Material and Remark
1	Cam Slider	1	Cast Iron with Graphite
2	Cam Driver	1	Cast Iron with Graphite
3	Cam Holder	1	Cast Iron
4	Upper Plate	2	Copper Powder Sintered
5	Stopper Plate	1	Steel
6	Positive Return Follower	1	Steel
7	Spring Guide Pin	2	∮12x40
8	Coil Spring	2	TF27-100 40st
8	Coil Spring	2	TF27-125 45st
8	Coil Spring	2	TF27-150 60st
8	Coil Spring	2	TF27-175 70st
8	Coil Spring	2	TF30-200 80st

SKCA100 (Gas Spring)



No.	Description		Material and Remark
1	Cam Slider	1	Cast Iron with Graphite
2	Cam Driver	1	Cast Iron with Graphite
3	Cam Holder	1	Cast Iron
4	Upper Plate	2	Copper Powder Sintered
5	Stopper Plate	1	Steel
6	Positive Return Follower	1	Steel
8	Spring	_	Refer to the Spring Specification.
11	Stop Pin	1	Gas Spring specification only

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

SKCA 100

1012

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

Cam Units [Overview]

Additional Machining

Information

■Tapped Hole and Dowel Hole (Prepared Hole, Finish) Machining for Retainer Mounting

Instruction method for machining

Indicate the tapped hole diameter and the dowel hole (or prepared hole) diameter with the XY coordinates.

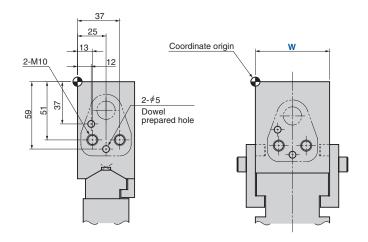
To indicate the coordinates

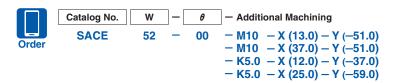
- The origin is positioned at the upper left corner of the mount face. (However, machining uses our machining datum as the reference.)
- · Indication symbol
- -M ··· Tapped hole, -N ··· Dowel prepared hole, -K ··· Dowel finish hole

Machining standard

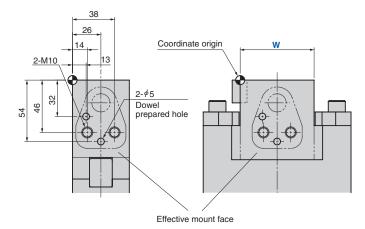
- · Tapped holes and dowel prepared holes are machined to general tolerances.
- The hole depth is 2.5 times the diameter for both tapped holes and dowel holes. The dowel pilot hole is processed for 2 times the diameter.
- \cdot The dowel hole spacing is machined to the tolerance of ± 0.02 . The hole tolerance is H7.

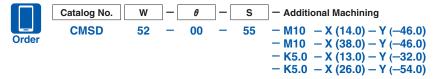
(Example of Aerial Cam Unit)





⟨Example of Die Mounted Cam Unit⟩





■Other machining

Please give instructions on a separate drawing for drilling or cutting other than tapped holes and dowel holes.