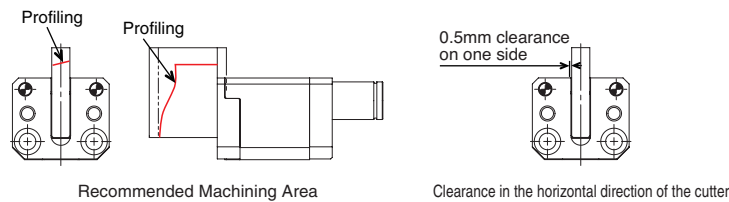
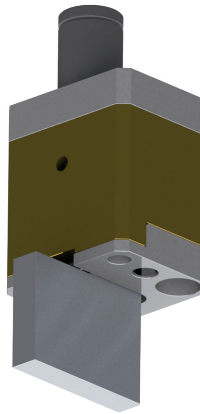


Floating Cutter [Overview]

Anti-burr / Anti-chip Cutting Unit

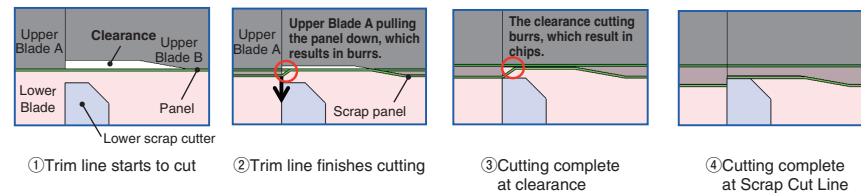
Panel Transfer Components

- Cutter Supplied as Blank
- Off-set Structure
- Easy Adjustment
- Compact Design
- 500,000 cycles under normal use.

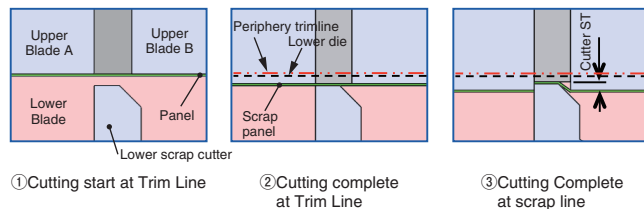


Comparison of NEW SUFC unit with the Current Method

The Current Method



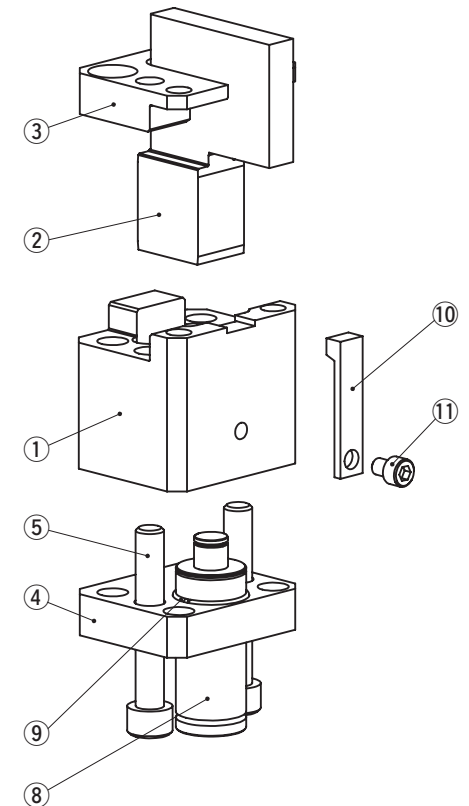
NEW Method with SUFC unit



Because there is no stretch on the panel at trimline and scrap cut line, burr and chip are dissolved.

SUFC Assembly Instruction

- Disassembly
 - Remove the Hexagonal Socket Head Bolts (⑤)
- Assembly
 - Assembly is the reverse procedure of disassembly.
 - Ensure that all parts are clean, particularly the sliding components to which a small amount of grease is applied and is then placed in position.
 - Take care that the respective tolerances are observed when assembling the holder (①) and cutter (②).
 - Make sure that all bolts are tightened to the recommended torque after assembly and disassembly.
 - Recommended Torque for Hexagon Socket Head Bolt (⑤) 61N·m



No.	Description	Qty	Material and Remark
1	Holder	1	Bronze
2	Cutter	1	Tool Steel
3	Plate A	1	Steel
4	Plate B	1	Steel
5	Hexagon Socket Head Bolt	2	M10-65
6	Hexagon Socket Head Bolt	2	M10-85
7	Dowel	2	φ 8-50
8	Gas Spring	1	Refer to the Spring Specification.
9	Snap (Retention) Ring	1	—
10	Locking Plate	1	Steel
11	Hexagon Socket Head Bolt	1	M6-8

⑥ and ⑦ supplied with unit.

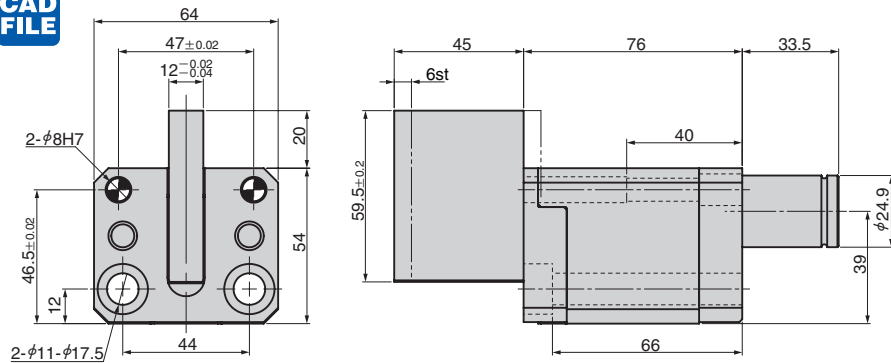
Floating Cutter

Anti-burr / Anti-chip Cutting Unit

Panel Transfer Components

SUFC

CAD
FILE



(Cutter Material) Flame Hardening Steel

Catalog No.	Cutter Width W	Travel ST	Cutter Material CMT	Spring Type PS	Working Force kN
SUFC	12	6	CMF	GK NGK GH NGH GD NGD	4.4

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

Spring Specification

Initial		Spring Model
Deflection [mm]	Load [kN]	
0.5	4.4	CU4 420-10 (KALLER) T4SC-420x10-V152 (HYSON) SC.00420.10 (DADCO)



Order

Catalog No.	W	ST	CMT	PS	PS Option
SUFC	12	6	CMF	GK	NF
SUFC	12	6	CMF	GH	
SUFC	12	6	CMF	NGK	

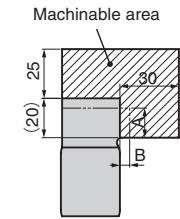


Option

Option Code	Specification
NF	Nitrogen gas not charged.

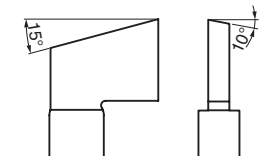
Operational Information

- Machinable Area**
Machine cross-hatched area as needed.
A minimum of 20 mm is required for Dimension A although A can be less than 20 mm as long as A > B.
It is recommended that profiles and shapes be machined together with the upper cutting edge.



Machinable area shown for regular use

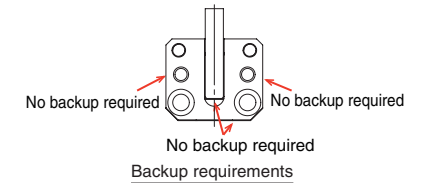
- Machine Limits**
Allowable angle: 15 degrees front to back and 10 degrees left to right.



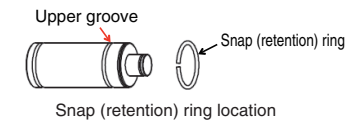
Allowable cutter max angle (upper)

- Cutter blade welding and surface treatment are the same as the cross-hatched areas, mentioned above.

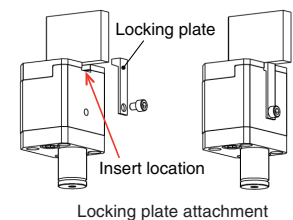
- Backup Requirements**
No reinforcements needed for holder and cutter.



- Replaceable Gas Spring**
Easily remove snap (retention) ring and apply it to upper groove of new spring.



- Retention of Cutter During Machining**
Ideal condition is to use both locking plate and gas spring to hold the cutter in place during profile machining.
Only a gas spring is sufficient if locking plate is missing.
There is no problem in use even if the shape is machined only with the initial load of Gas Spring.



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.