

AERIAL CAM UNIT

Grade	Working force [kN (tonf)]		Catalog No.	Cam width W	Angle θ	Spring Type PS
	1,000,000 strokes	300,000 strokes				
Yellow	225.4(23.0)	254.8(26.0)	VACYL	300	00~70 (5-degree increments)	ISO GK NGK GD NGD GS NGS
Pink	315.6(30.2)	356.7(36.4)	VACPL			

※ CENTER LOAD working forces
 OFFSET LOADS : See working forces Distribution Diagram page 660

ISO : Coil spring
 GK : Gas spring (KALLER)
 GD : Gas spring (DADCO)
 GS : Gas spring (SDT)
 NGK, NGD, NGS: without gas spring



Option

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



For key specification, refer to page 412.



Order

Catalog No.	W	θ	PS	Option
VACYL	300	10	ISO	
VACPL	300	10	GK	NF - K

Spring force & Return force

- Coil spring specification
Yellow, Pink

Angle	Spring force				Return force	
	Initial load		Final load			
	N	kgf	N	kgf	N	kgf
0	1396	142.5	10996	1122.0	15067	1537.4
5	1396	142.5	10996	1122.0	15010	1531.6
10	1396	142.5	10996	1122.0	14949	1525.4
15	1396	142.5	10996	1122.0	14885	1518.9
20	1396	142.5	10996	1122.0	14819	1512.1
25	1396	142.5	10996	1122.0	14750	1505.1
30	1396	142.5	10996	1122.0	14679	1497.8
35	1396	142.5	10996	1122.0	14607	1490.5
40	1396	142.5	10996	1122.0	14534	1483.0
45	1396	142.5	10996	1122.0	14461	1475.6
50	1396	142.5	10996	1122.0	14388	1468.2
55	1396	142.5	10996	1122.0	15647	1596.6
60	1396	142.5	10996	1122.0	17302	1765.6
65	1396	142.5	10123	1033.0	17945	1831.1
70	1123	114.6	10328	1053.9	21159	2159.0

- Gas spring specification
Yellow, Pink

Spring force		Return force	
Final load			
N	kgf	N	kgf
22800	2327	30646	3127.1
22800	2327	30589	3121.3
22800	2327	30528	3115.1
22800	2327	30464	3108.6
22800	2327	30398	3101.8
22800	2327	30329	3094.8
22800	2327	30258	3087.5
22800	2327	30186	3080.2
22800	2327	30113	3072.7
22800	2327	30040	3065.3
22800	2327	29967	3057.9
22800	2327	32596	3326.1
22800	2327	36042	3677.8
22078	2253	39347	4015.0
20778	2120	42795	4366.9

Cam Stroke

Angle	Stroke mm
00	35.4
05	39.0
10	42.8
15	46.6
20	50.7
25	55.0
30	59.7
35	64.9
40	70.7
45	77.5
50	85.6
55	95.9
60	110.0
65	118.3
70	119.9

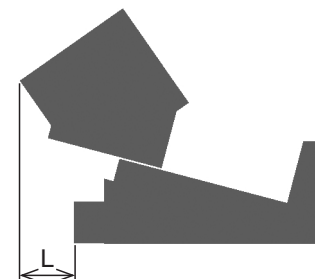
Weight

Angle	Total weight kg	Cam slider weight kg	Tool weight kg
00	152	64	42
05	152	64	42
10	152	64	43
15	152	64	45
20	150	64	46
25	149	64	48
30	148	64	50
35	147	64	54
40	149	64	58
45	151	64	63
50	155	64	63
55	158	67	60
60	158	66	61
65	162	68	59
70	168	74	53

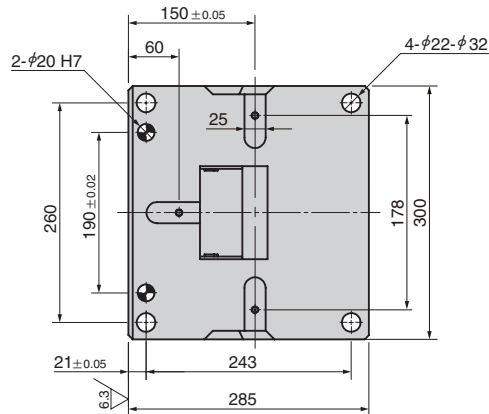
※ Tool weight is estimated value. Allowable tool weight varies depending on press speed.

Rear removal space

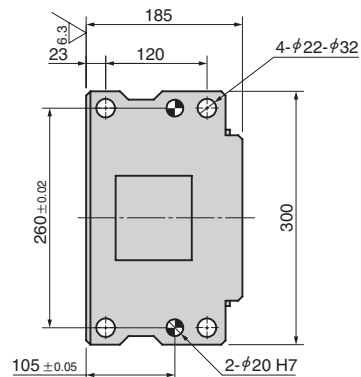
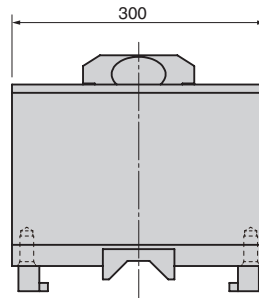
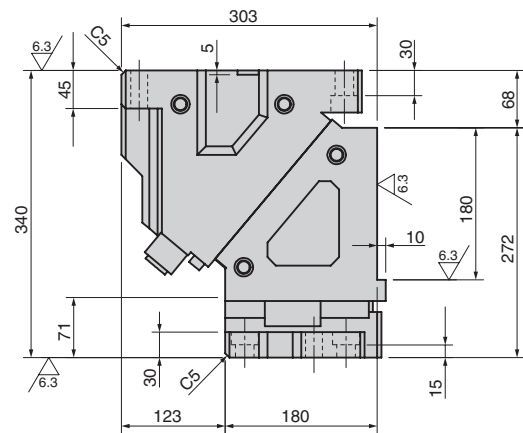
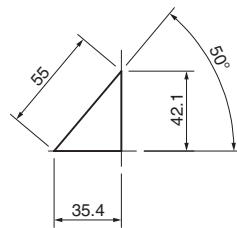
Angle	L mm
00	46.9
05	55.7
10	63
15	70.7
20	82.9
25	98.6
30	113.6
35	128.5
40	143.1
45	158.4
50	169.2
55	184.3
60	187.1
65	181.2
70	178.1



VACYL300-00
VACPL300-00

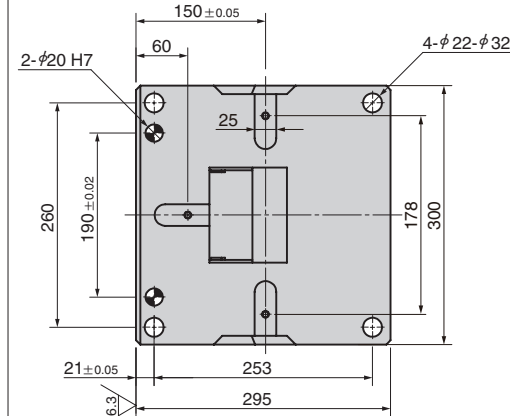


Cam Diagram

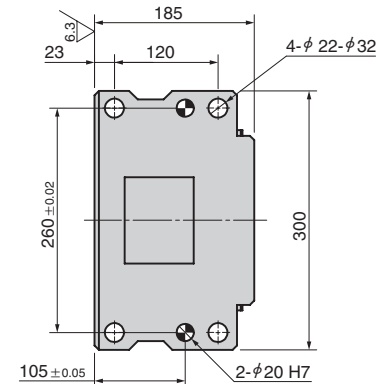
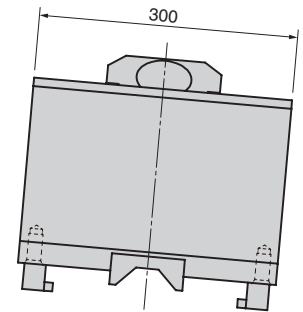
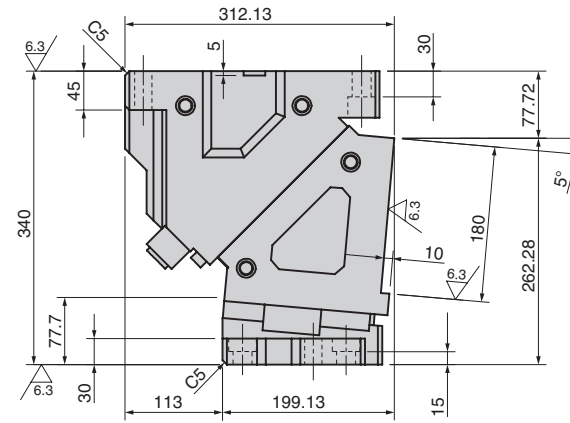
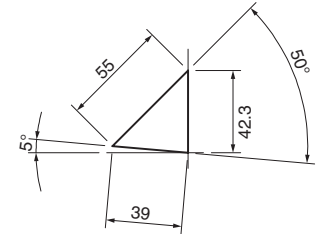


Refer to page 418 for the parts list.

VACYL300-05
VACPL300-05

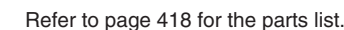


Cam Diagram

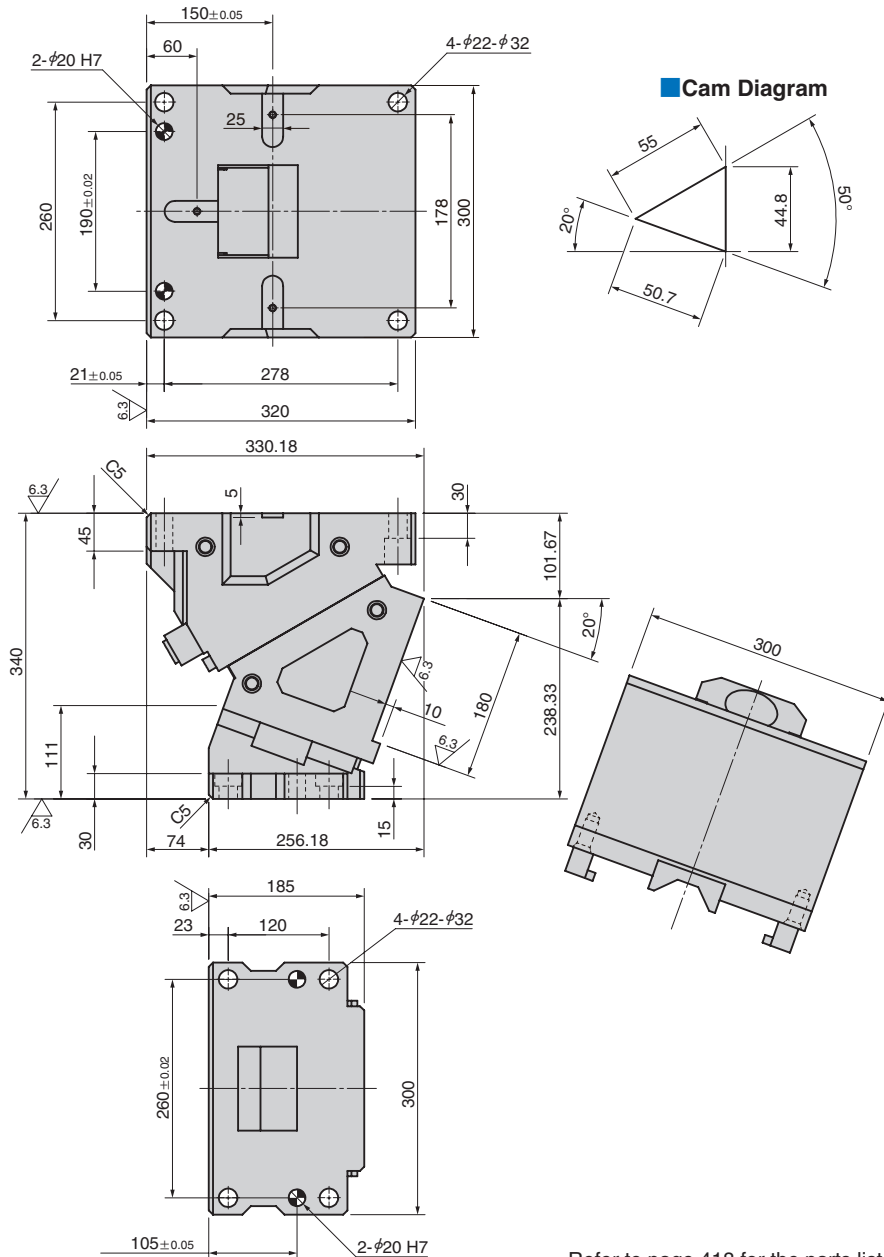


Refer to page 418 for the parts list.

VACYL300-15
VACPL300-15

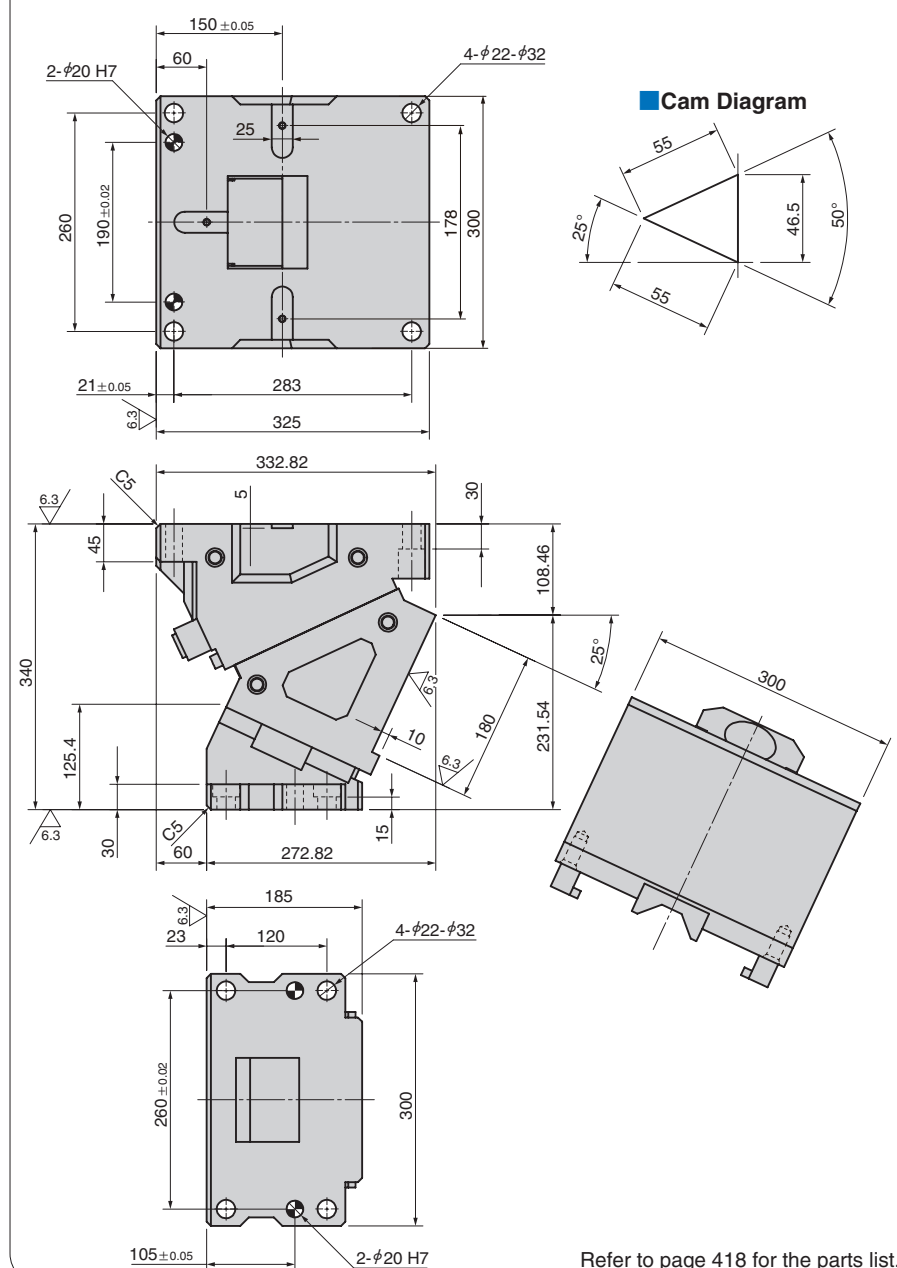


VACYL300-20 VACPL300-20



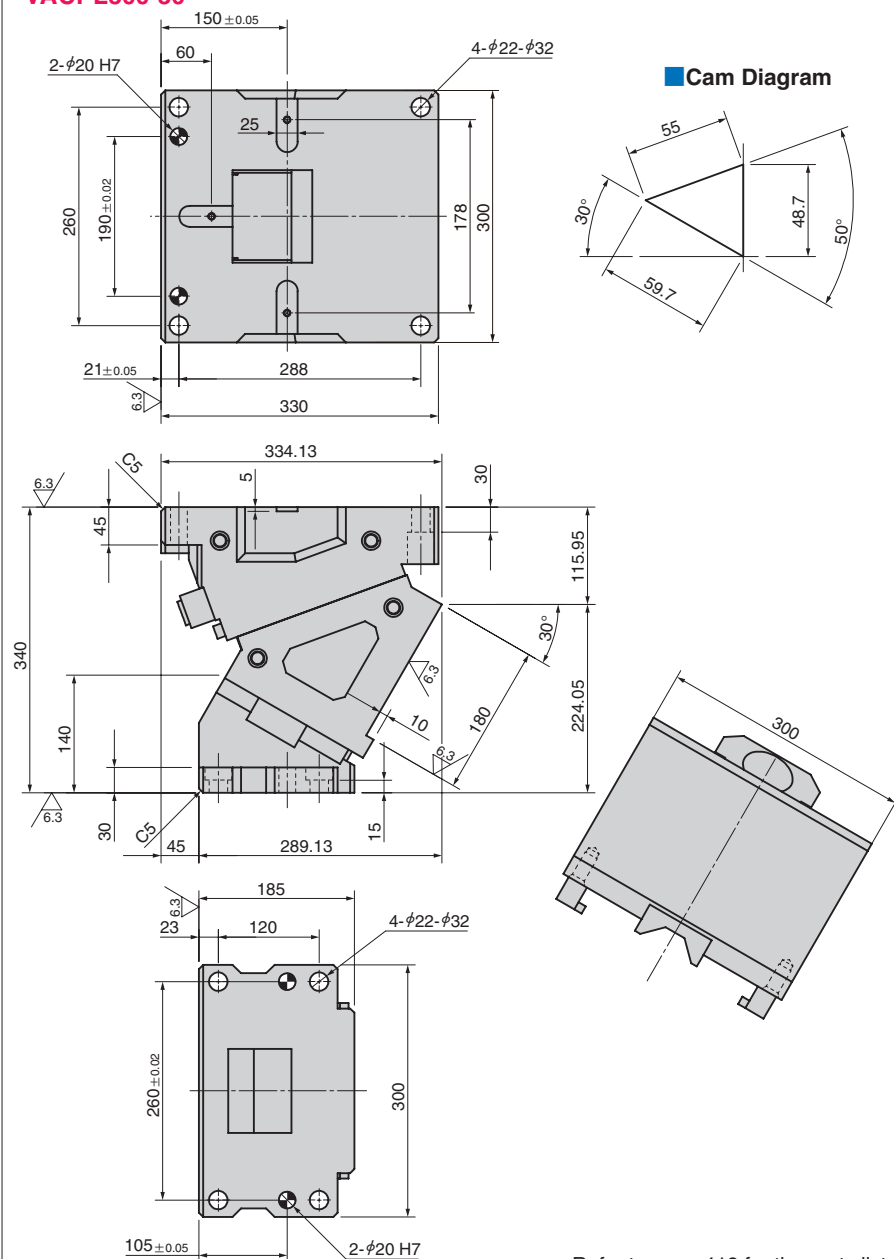
Refer to page 418 for the parts list.

VACYL300-25 VACPL300-25



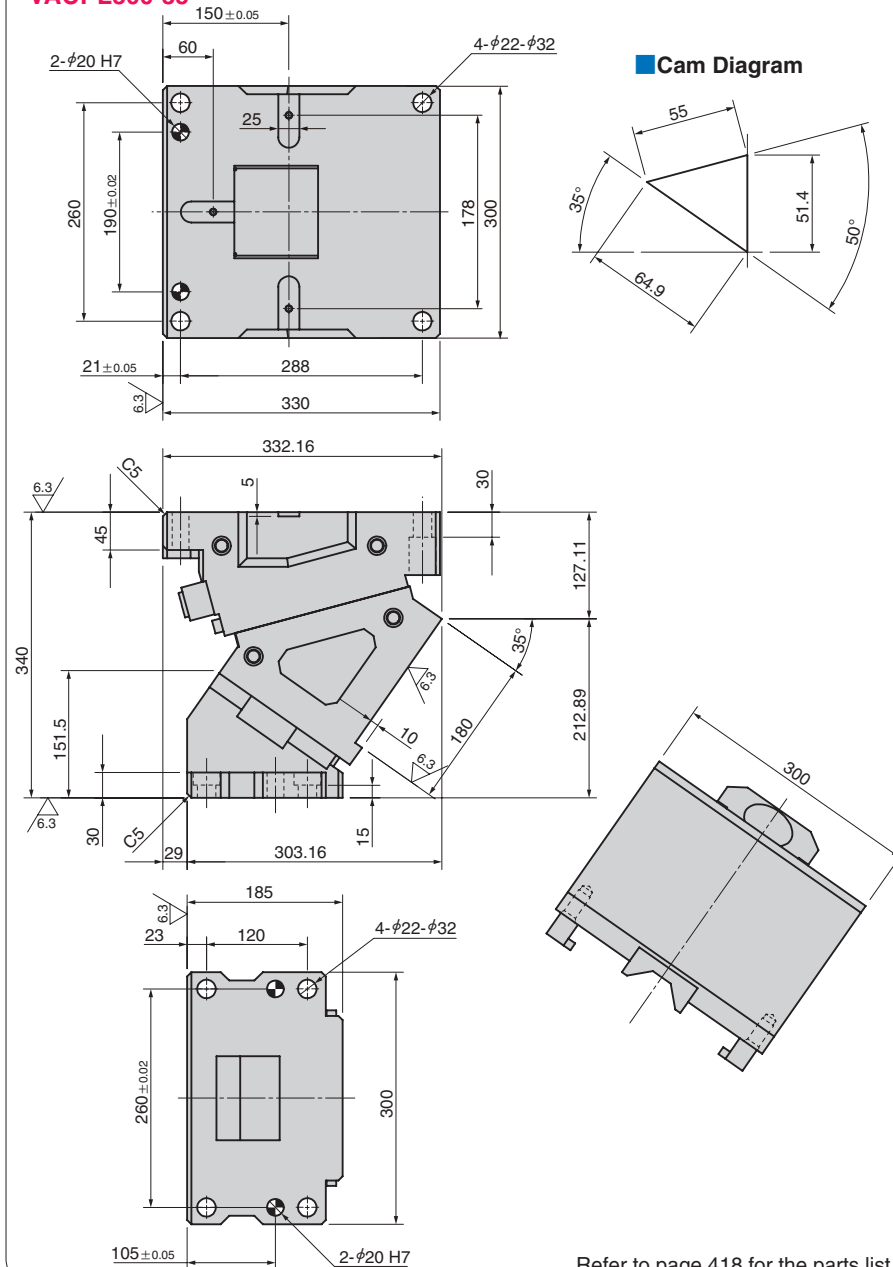
Refer to page 418 for the parts list.

VACYL300-30 VACPL300-30



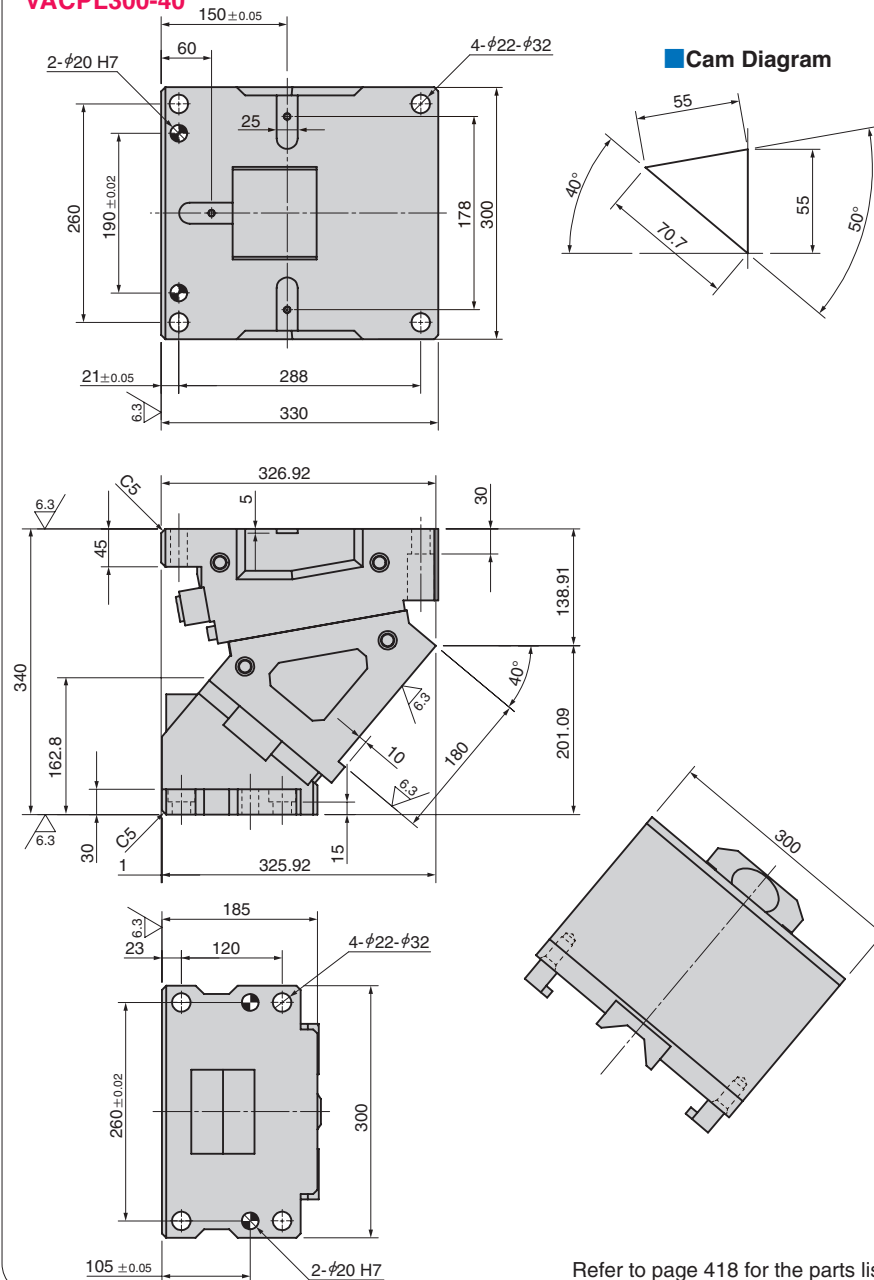
Refer to page 418 for the parts list.

VACYL300-35 VACPL300-35

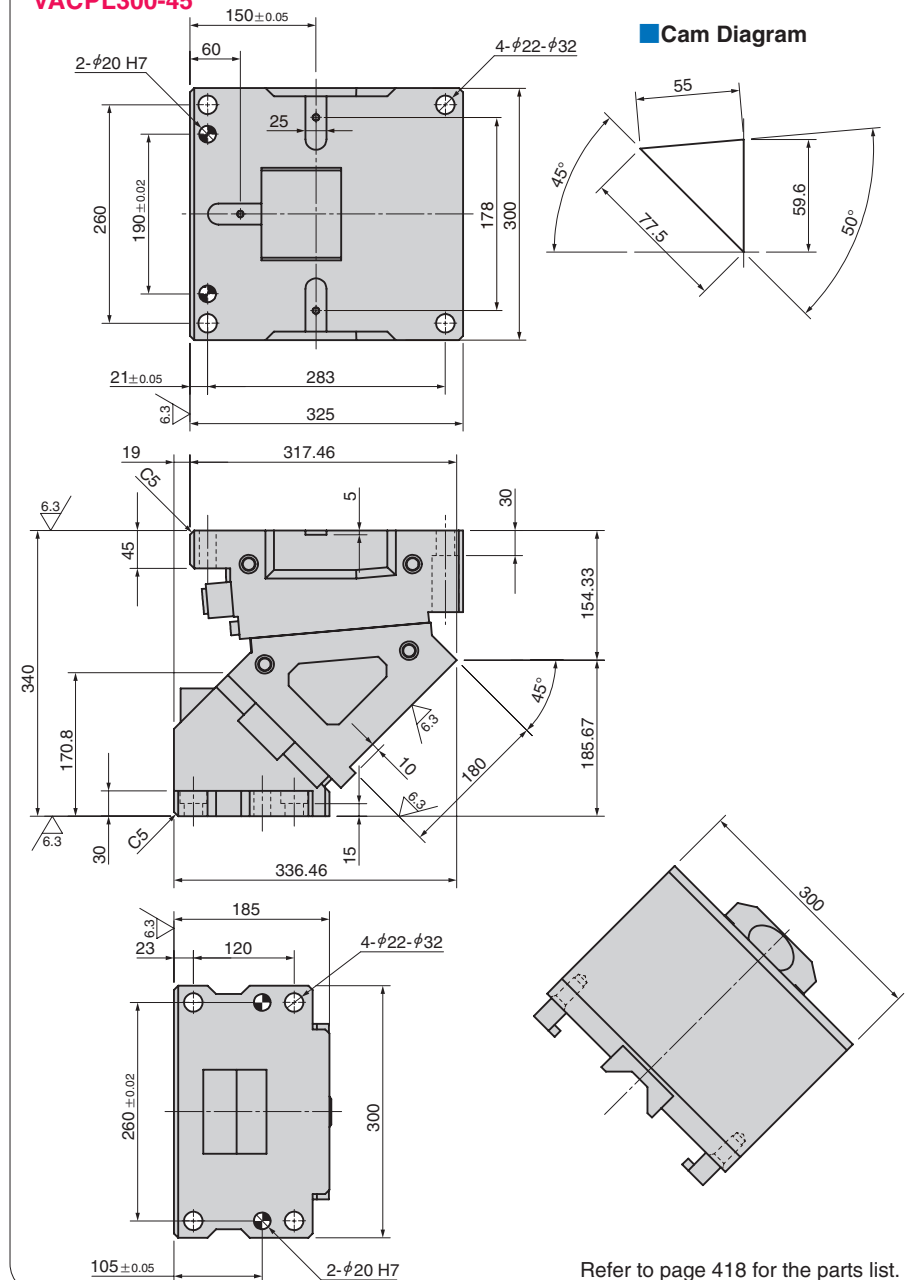


Refer to page 418 for the parts list.

VACYL300-40 VACPL300-40

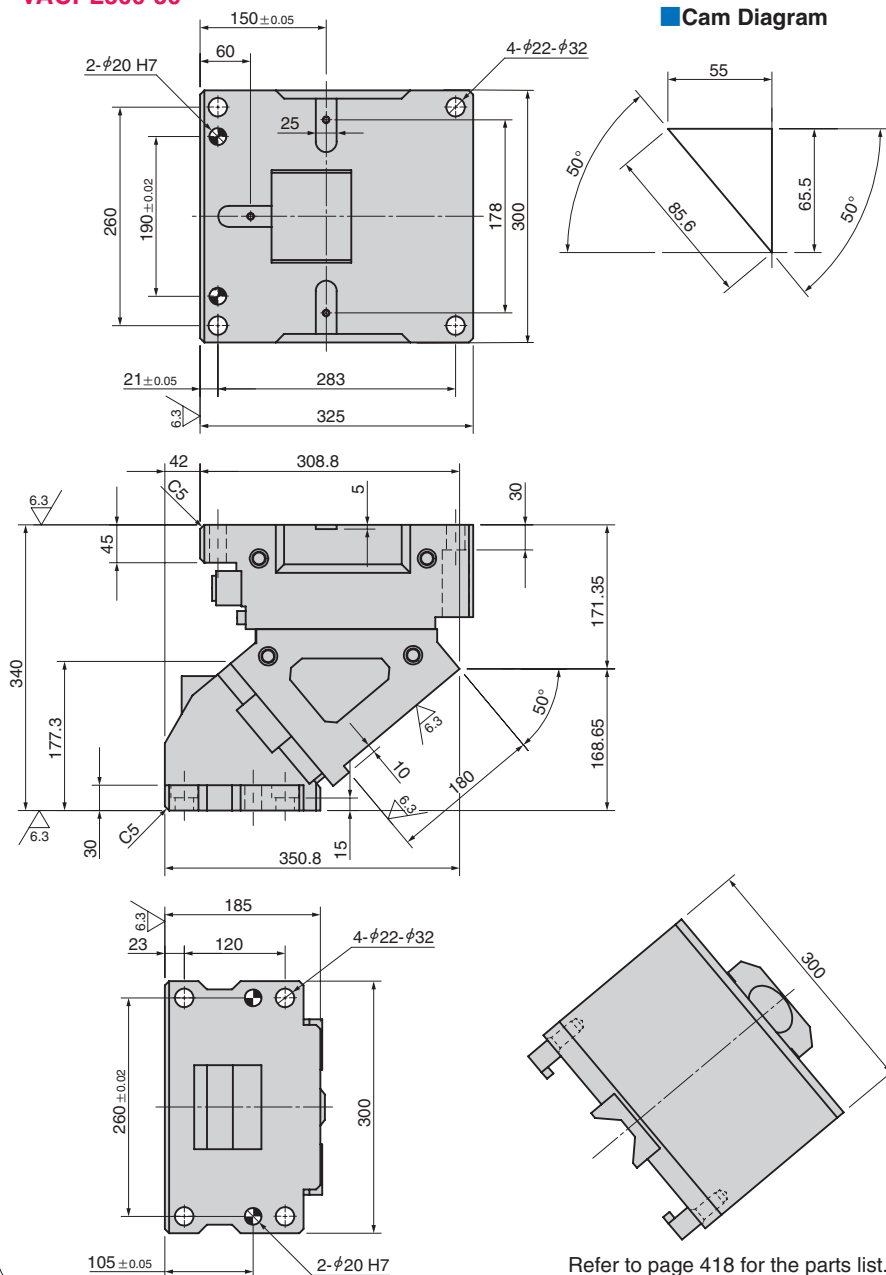


VACYL300-45 VACPL300-45



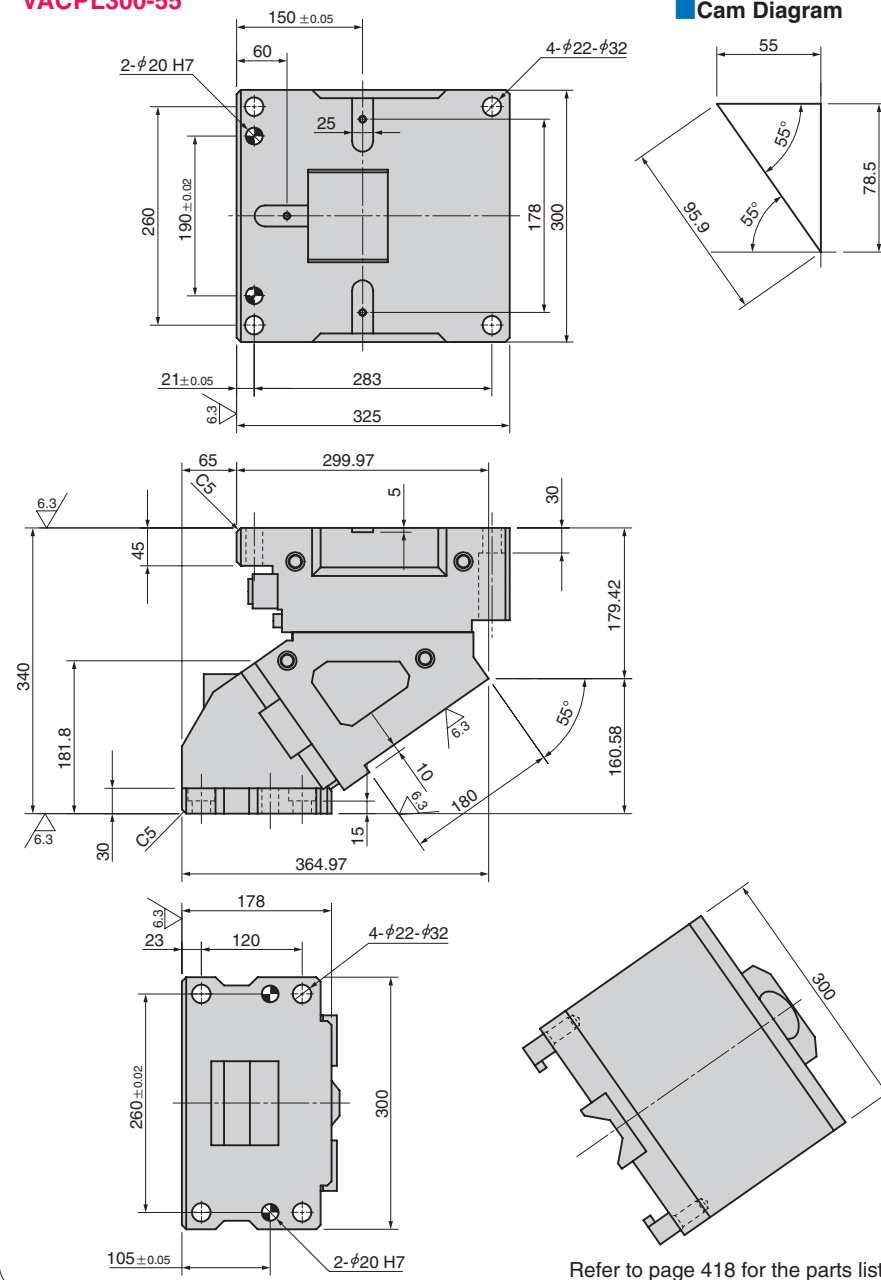
VACYL300-50 VACPL300-50

Cam Diagram

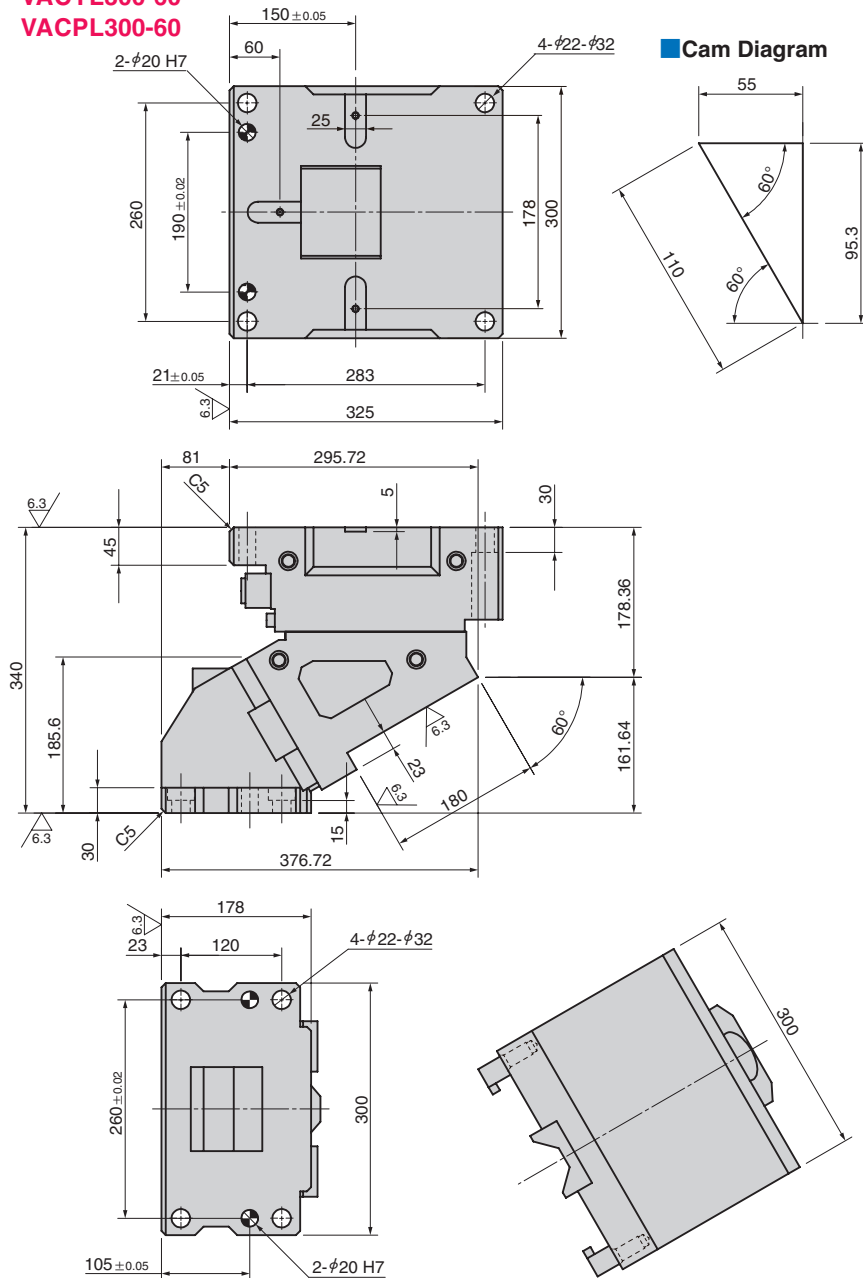


VACYL300-55 VACPL300-55

Cam Diagram

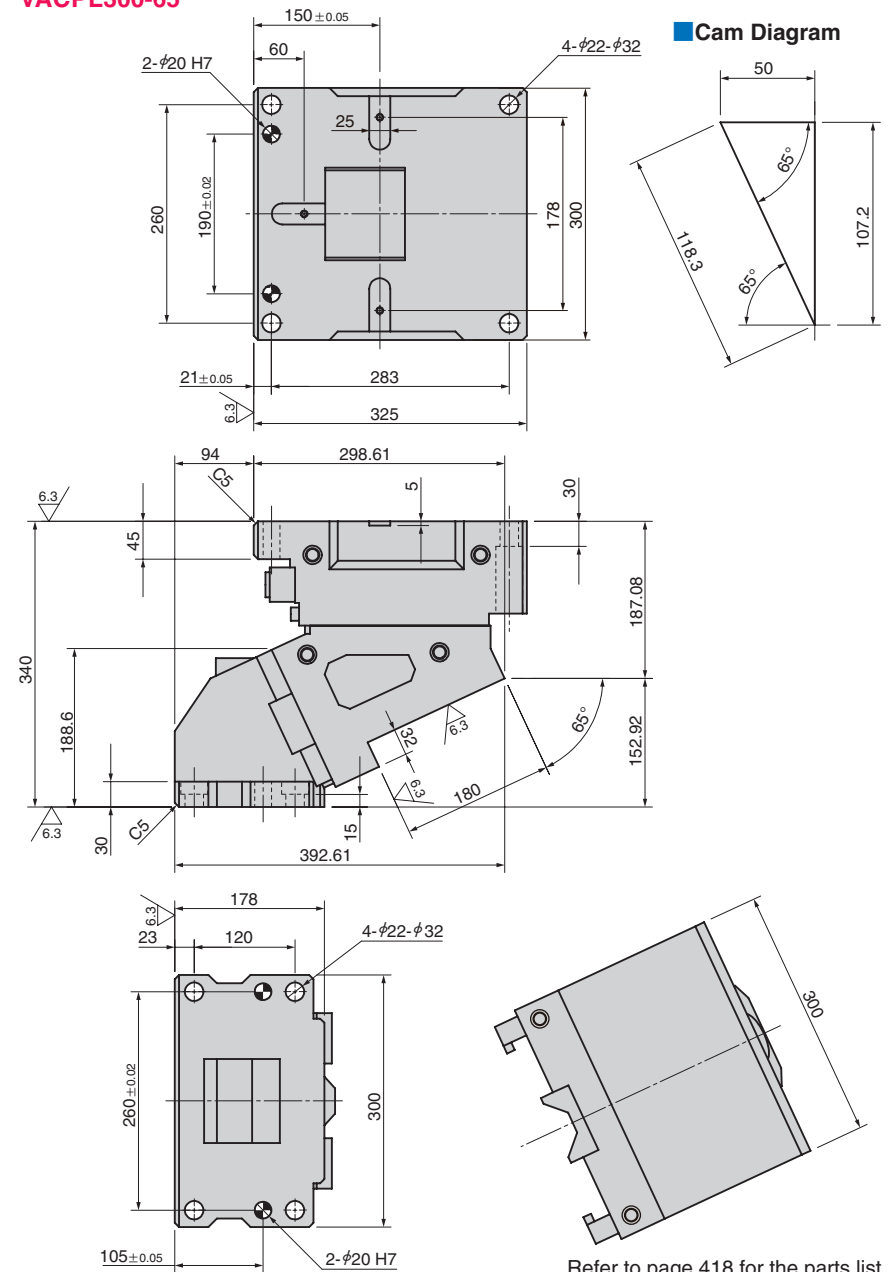


VACYL300-60 VACPL300-60



Refer to page 418 for the parts list.

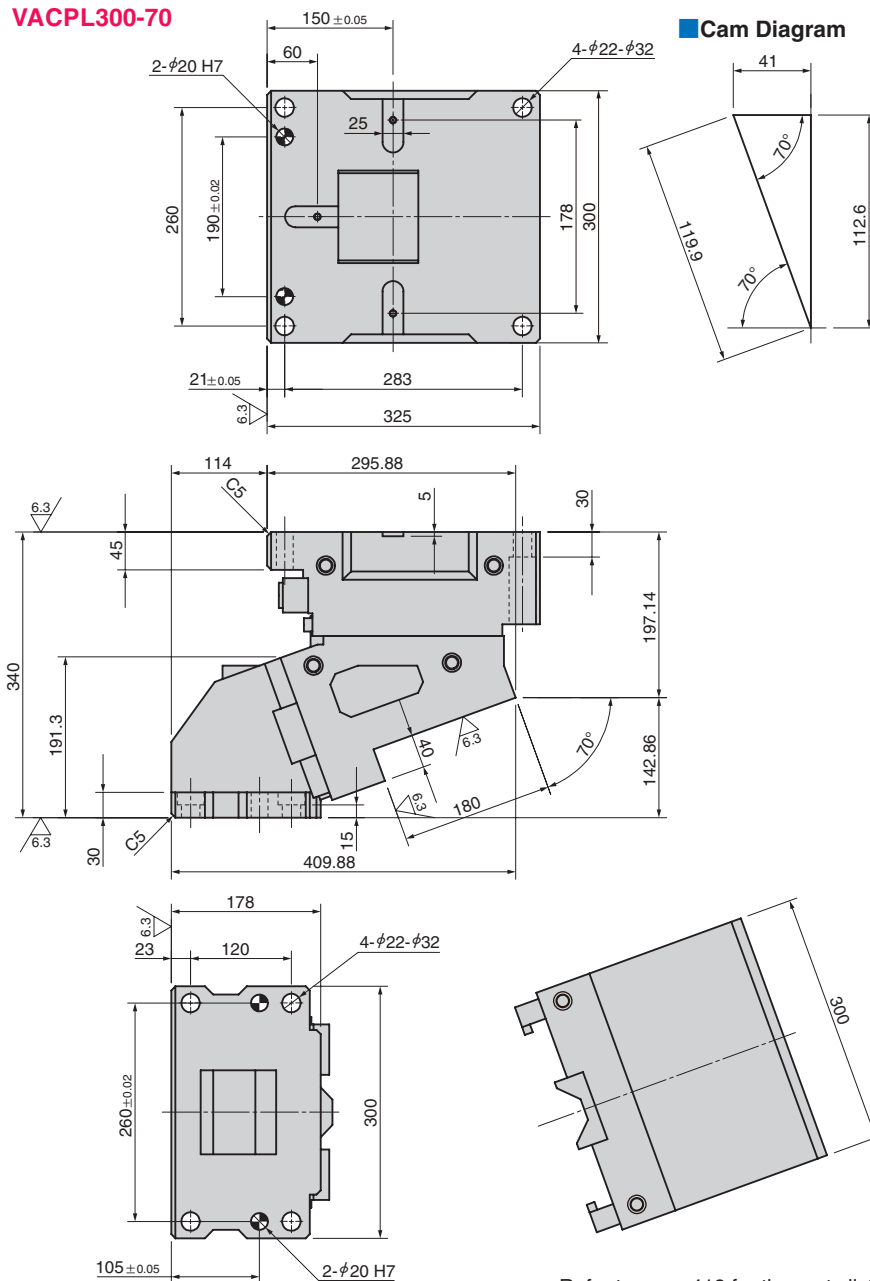
VACYL300-65 VACPL300-65



Refer to page 418 for the parts list.

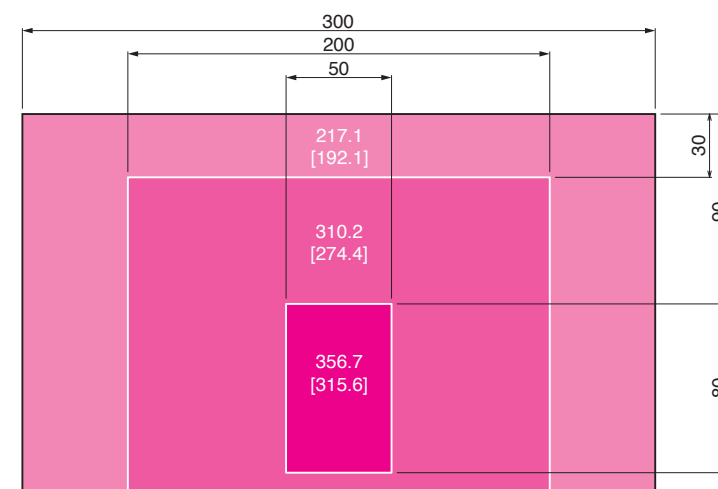
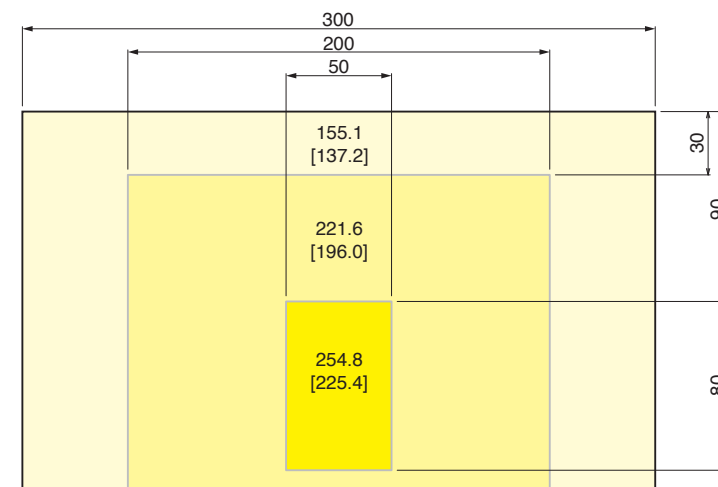
VACYL300-70 VACPL300-70

Cam Diagram



Working Force Distribution Diagram

The working forces indicated in the cam 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 300,000 strokes
[] : Working force (kN) allowed for up to 1,000,000 strokes