

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	269.5(27.5)	294.0(30.0)	VACYL	400	00~70 (5-degree increments)	ISO GK NGK GD NGD GS NGS
Pink	377.3(38.5)	411.6(42.0)	VACPL			

※ CENTER LOAD working forces
 OFFSET LOADS : See working forces Distribution Diagram page 678

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	400	10	ISO	
VACPL	400	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	1745	178.1	13743	1402.4	18926	1931.3
5	1745	178.1	13743	1402.4	18846	1923.0
10	1745	178.1	13743	1402.4	18760	1914.3
15	1745	178.1	13743	1402.4	18669	1905.0
20	1745	178.1	13743	1402.4	18574	1895.3
25	1745	178.1	13743	1402.4	18476	1885.3
30	1745	178.1	13743	1402.4	18375	1875.0
35	1745	178.1	13743	1402.4	18272	1864.5
40	1745	178.1	13743	1402.4	18169	1854.0
45	1745	178.1	13743	1402.4	18065	1843.4
50	1745	178.1	13743	1402.4	17962	1832.8
55	1745	178.1	13743	1402.4	19533	1993.2
60	1745	178.1	13743	1402.4	21599	2204.0
65	1745	178.1	12653	1291.1	22394	2285.1
70	1403	143.2	12911	1317.4	26419	2695.8

● Gas spring specification
 Yellow, Pink

Angle	Spring force		Return force	
	Final load			
	N	kgf	N	kgf
0	27829	2840	37516	3828.2
5	27829	2840	37435	3819.9
10	27829	2840	37349	3811.2
15	27829	2840	37258	3801.9
20	27829	2840	37164	3792.2
25	27829	2840	37065	3782.2
30	27829	2840	36965	3771.9
35	27829	2840	36862	3761.4
40	27829	2840	36758	3750.9
45	27829	2840	36655	3740.3
50	27829	2840	36551	3729.7
55	27829	2840	39757	4056.9
60	27829	2840	43960	4485.7
65	26956	2751	48001	4898.0
70	25384	2590	52244	5331.1

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

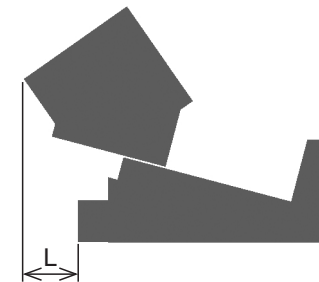
Weight

Angle	Total weight kg	Cam slider weight kg	Tool weight kg
00	205	91	59
05	205	91	59
10	204	91	60
15	203	91	63
20	201	91	64
25	199	91	67
30	198	91	71
35	198	91	76
40	200	91	82
45	203	91	89
50	208	91	89
55	212	95	85
60	213	94	86
65	219	98	82
70	227	103	77

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

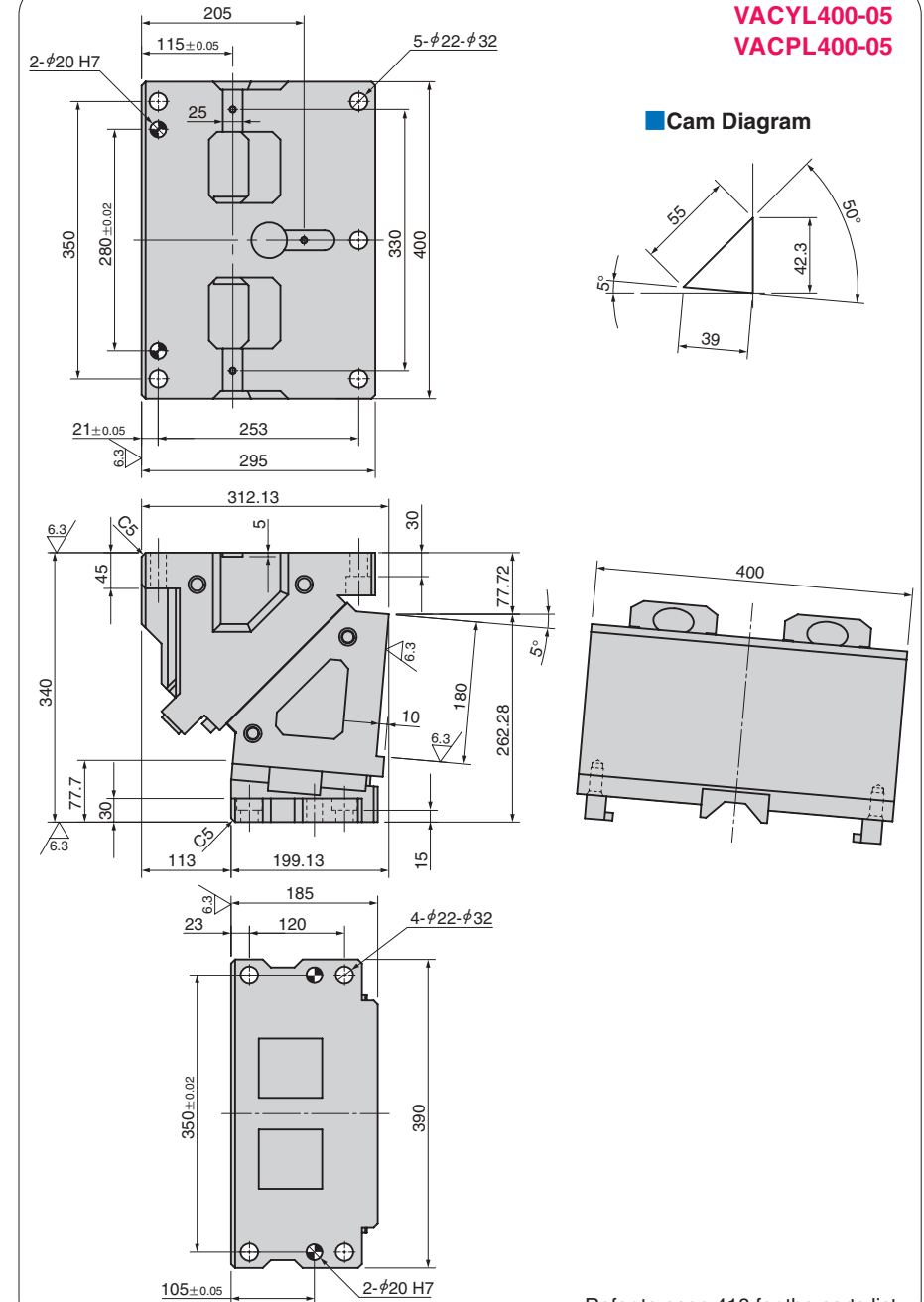
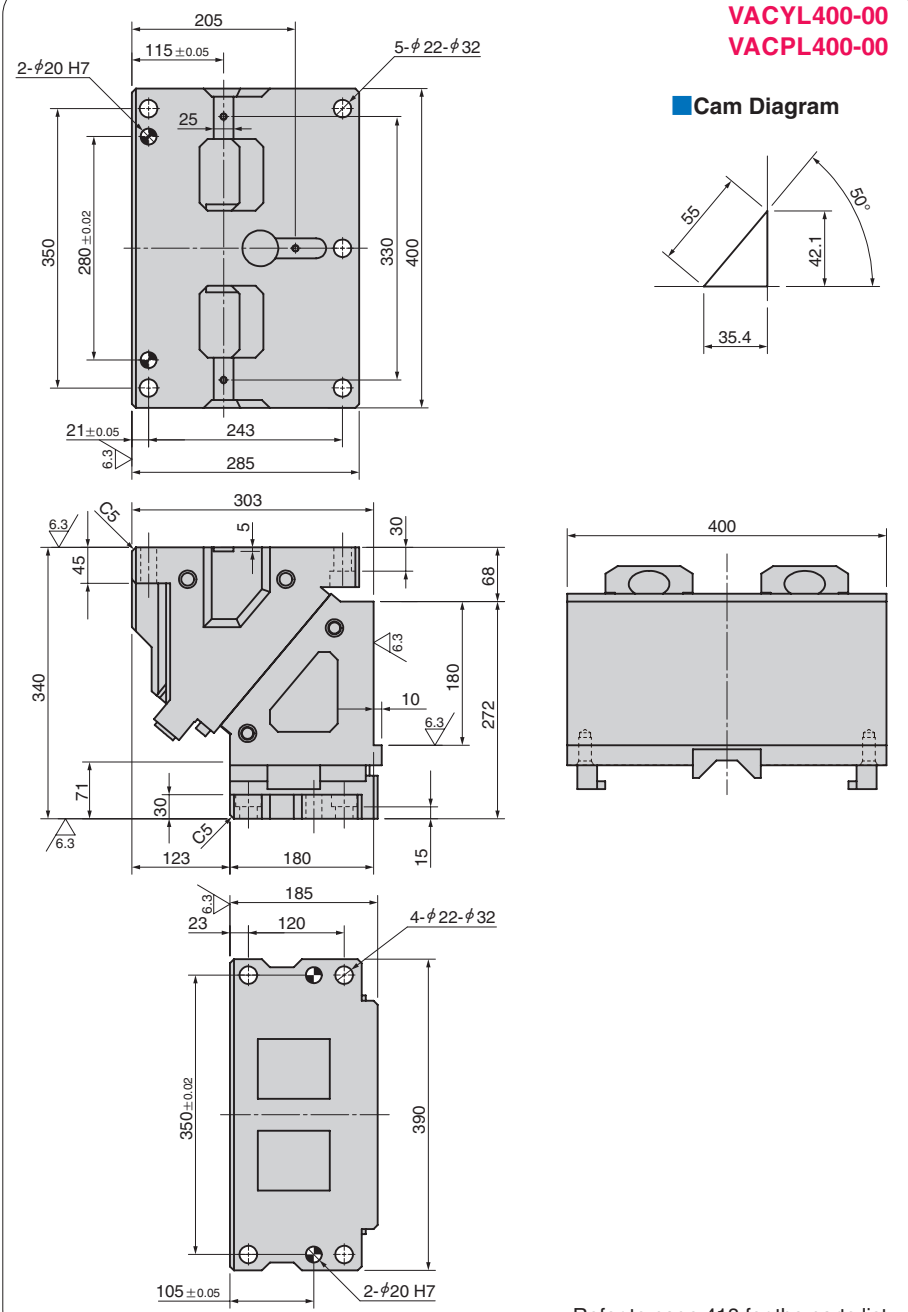
Rear removal space

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

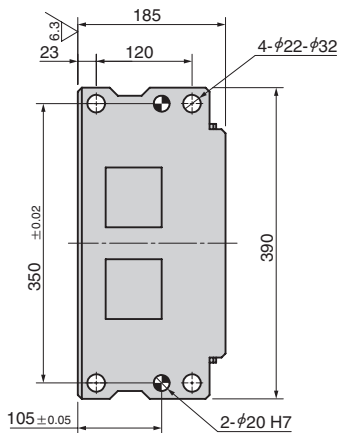
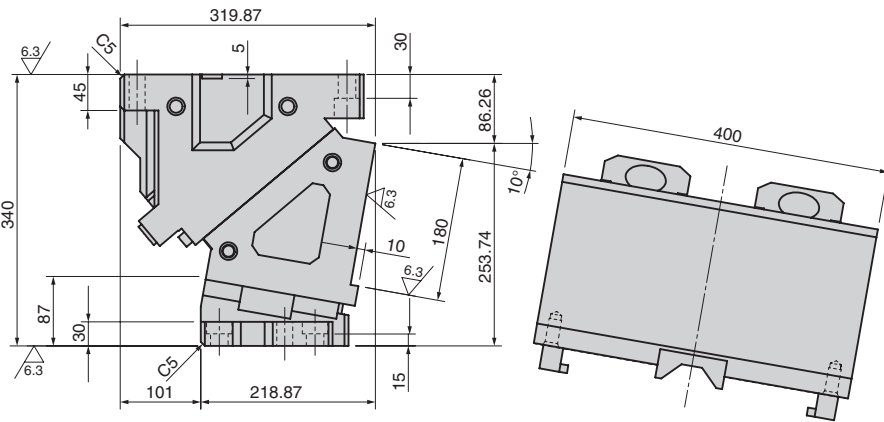
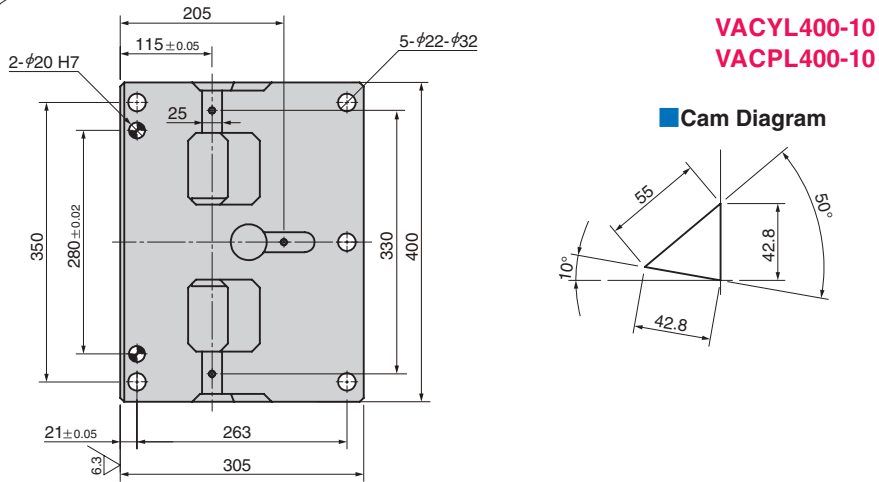


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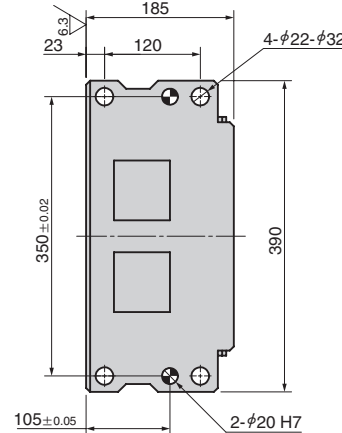
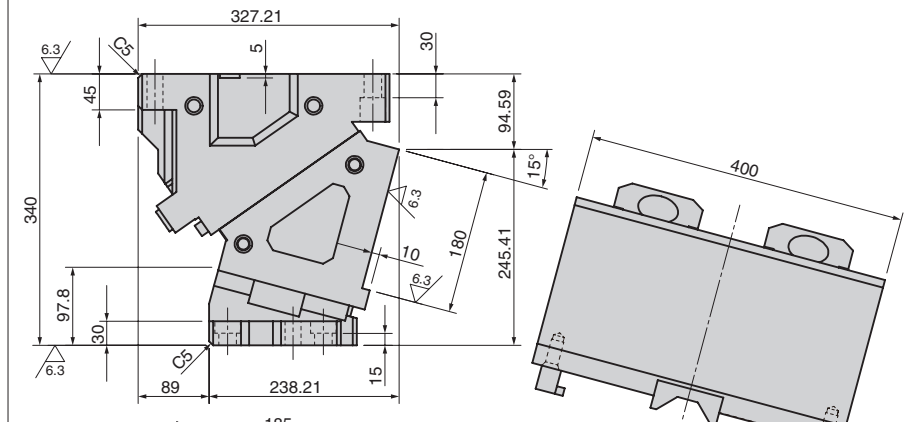
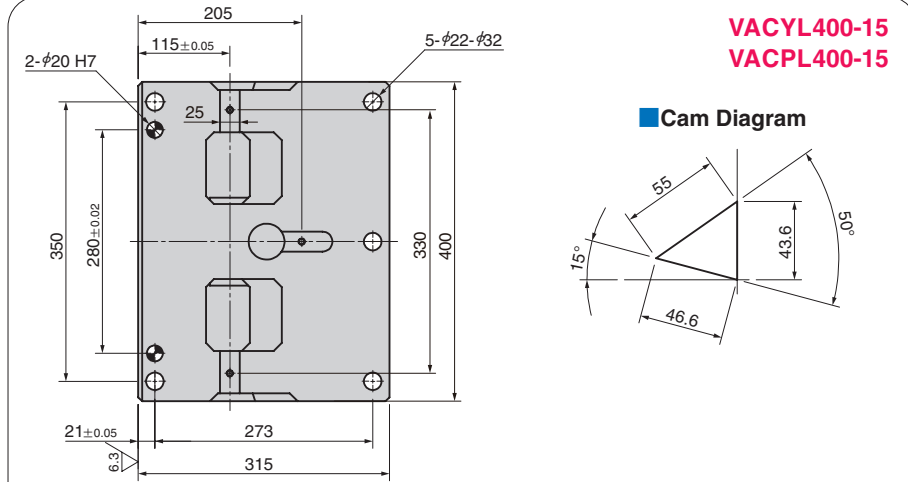
Cam Units



AERIAL CAM UNIT



Refer to page 418 for the parts list.

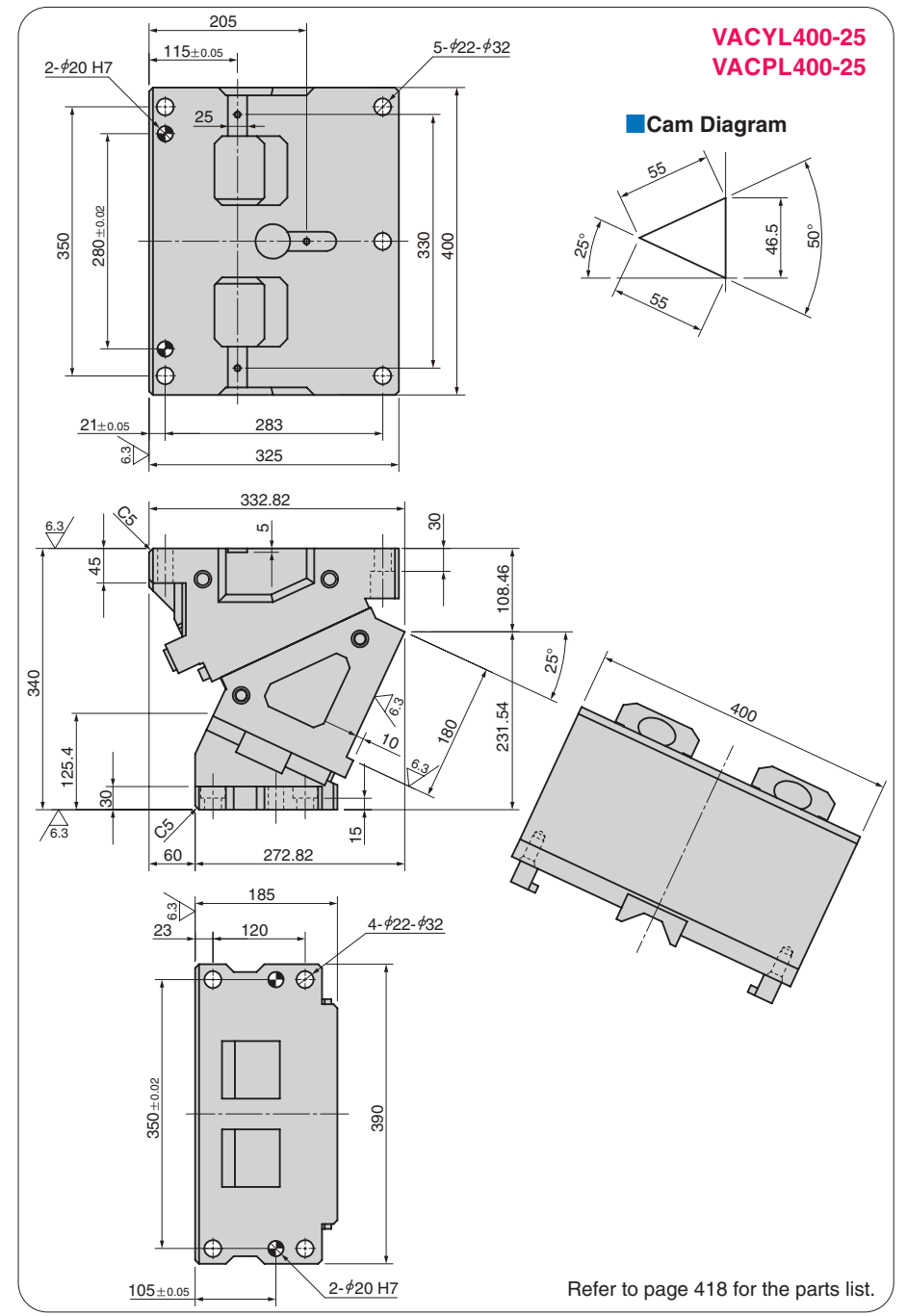
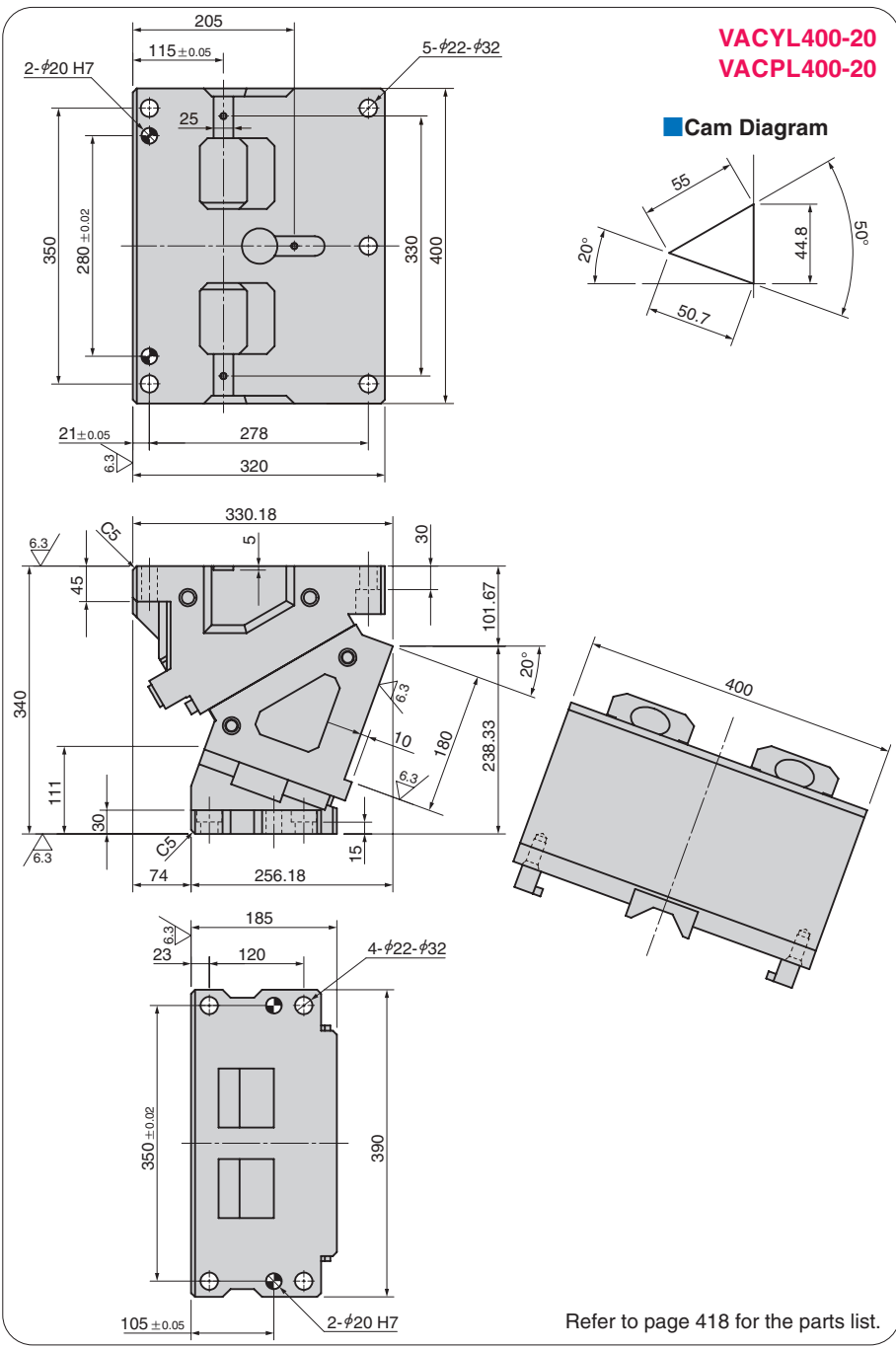


Refer to page 418 for the parts list.

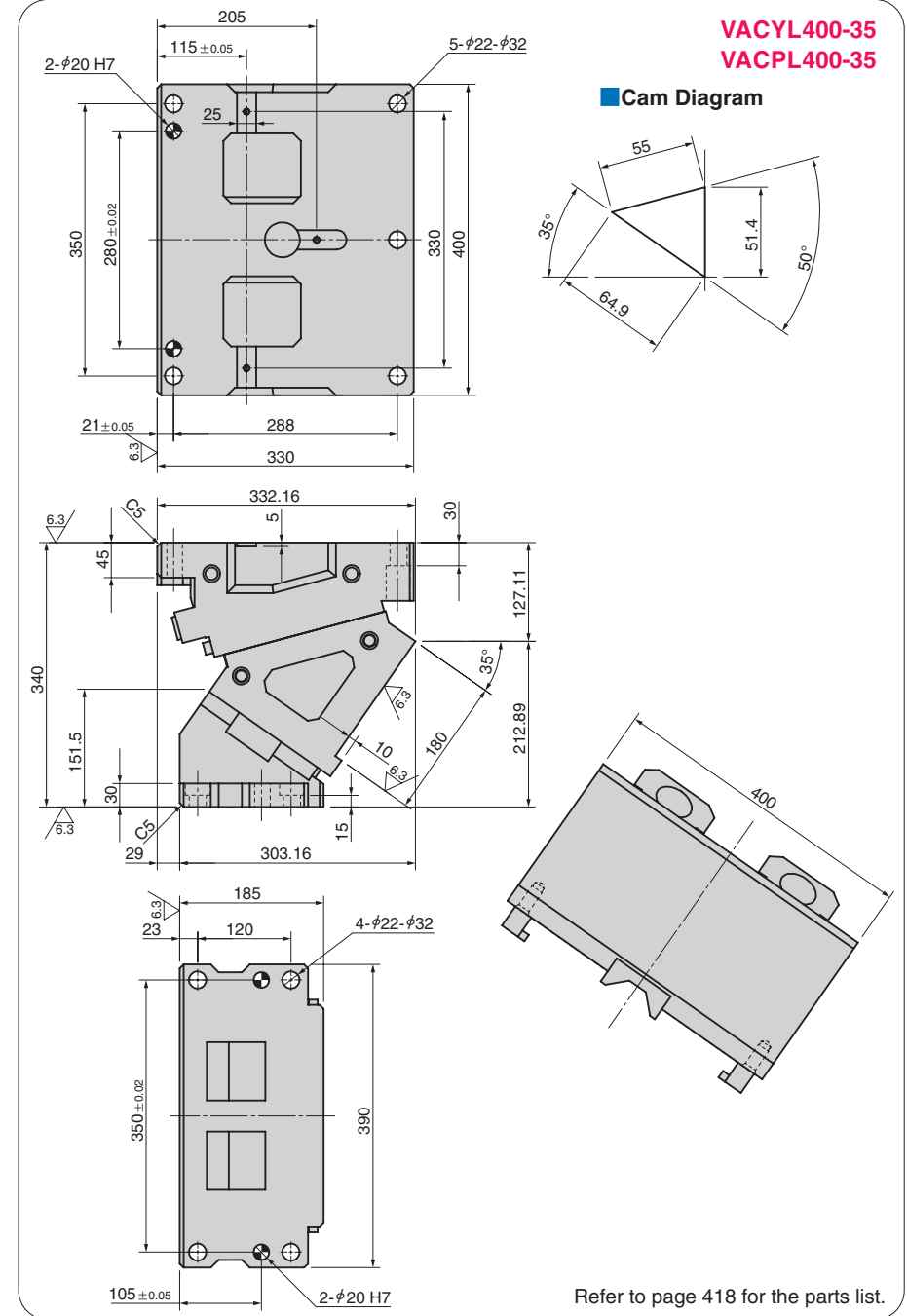
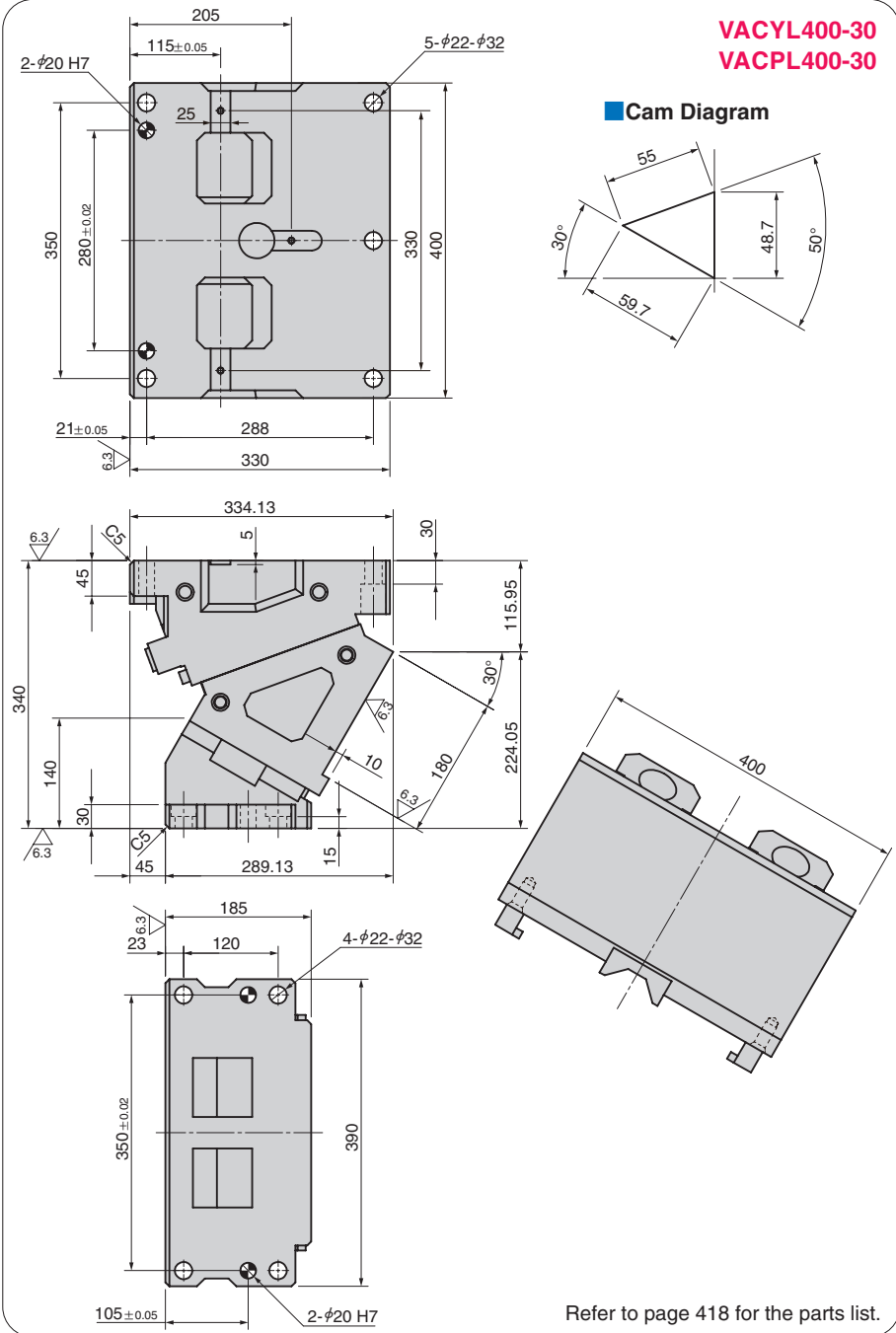
AERIAL CAM UNIT

NEW CAD FILE

Cam Units



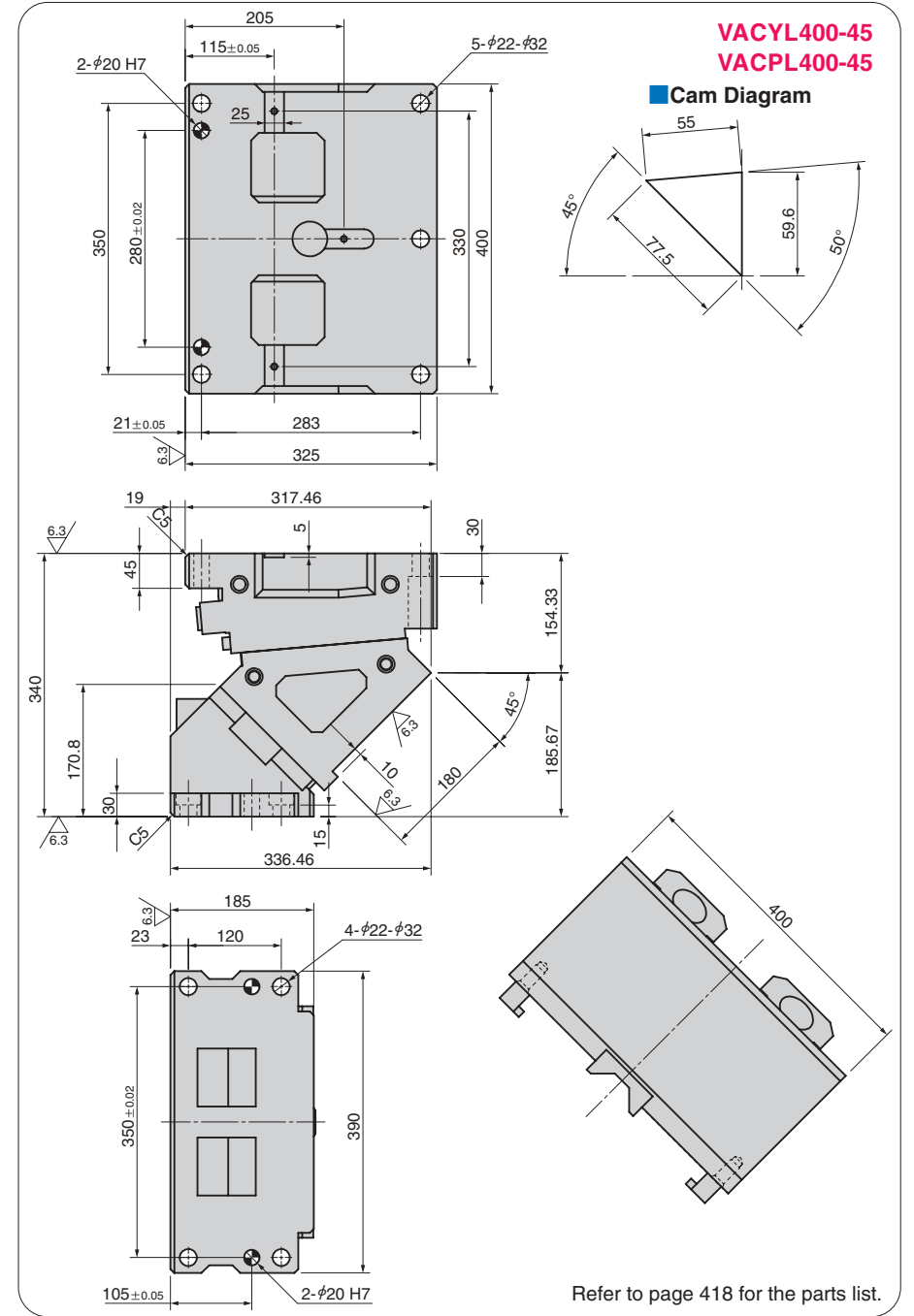
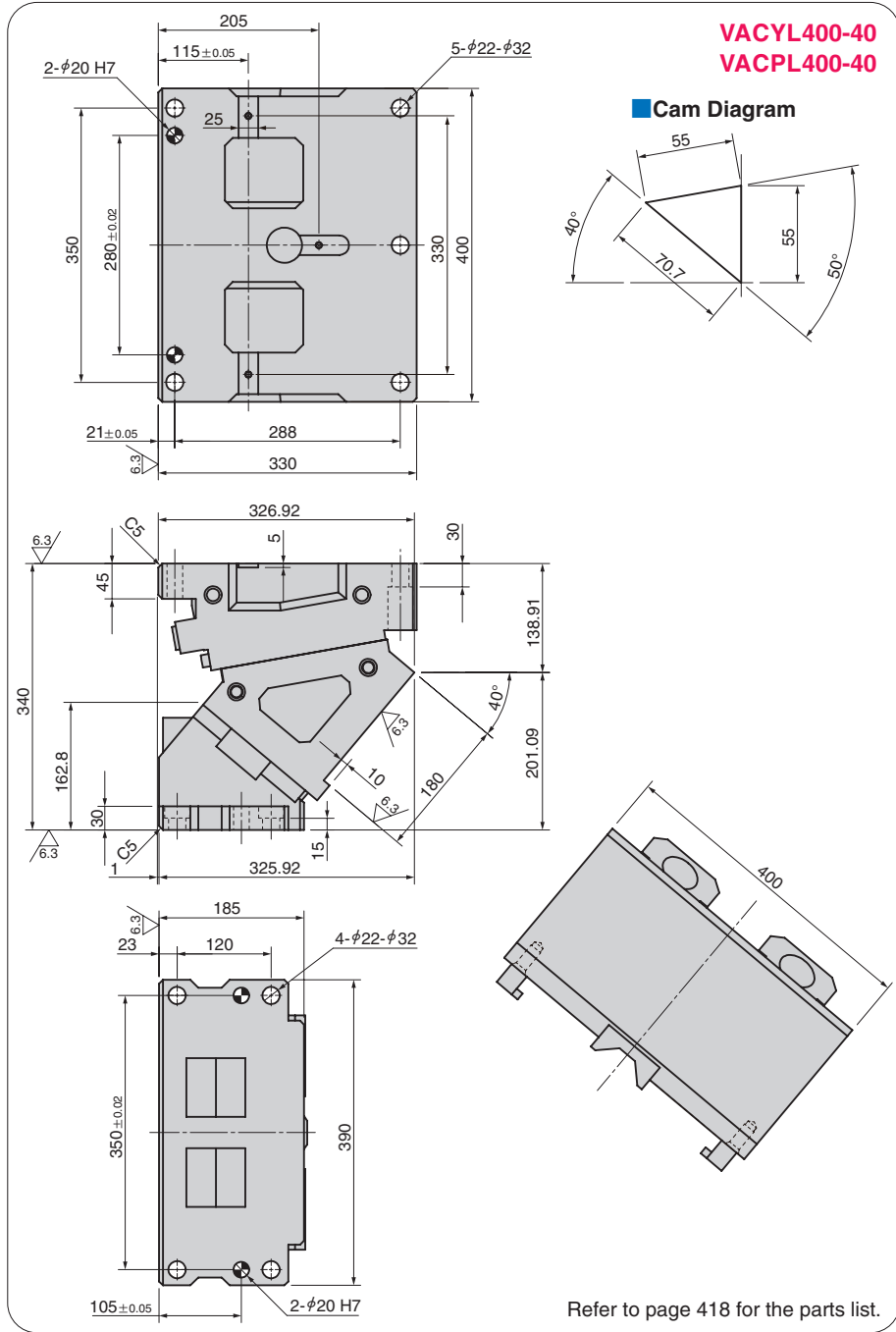
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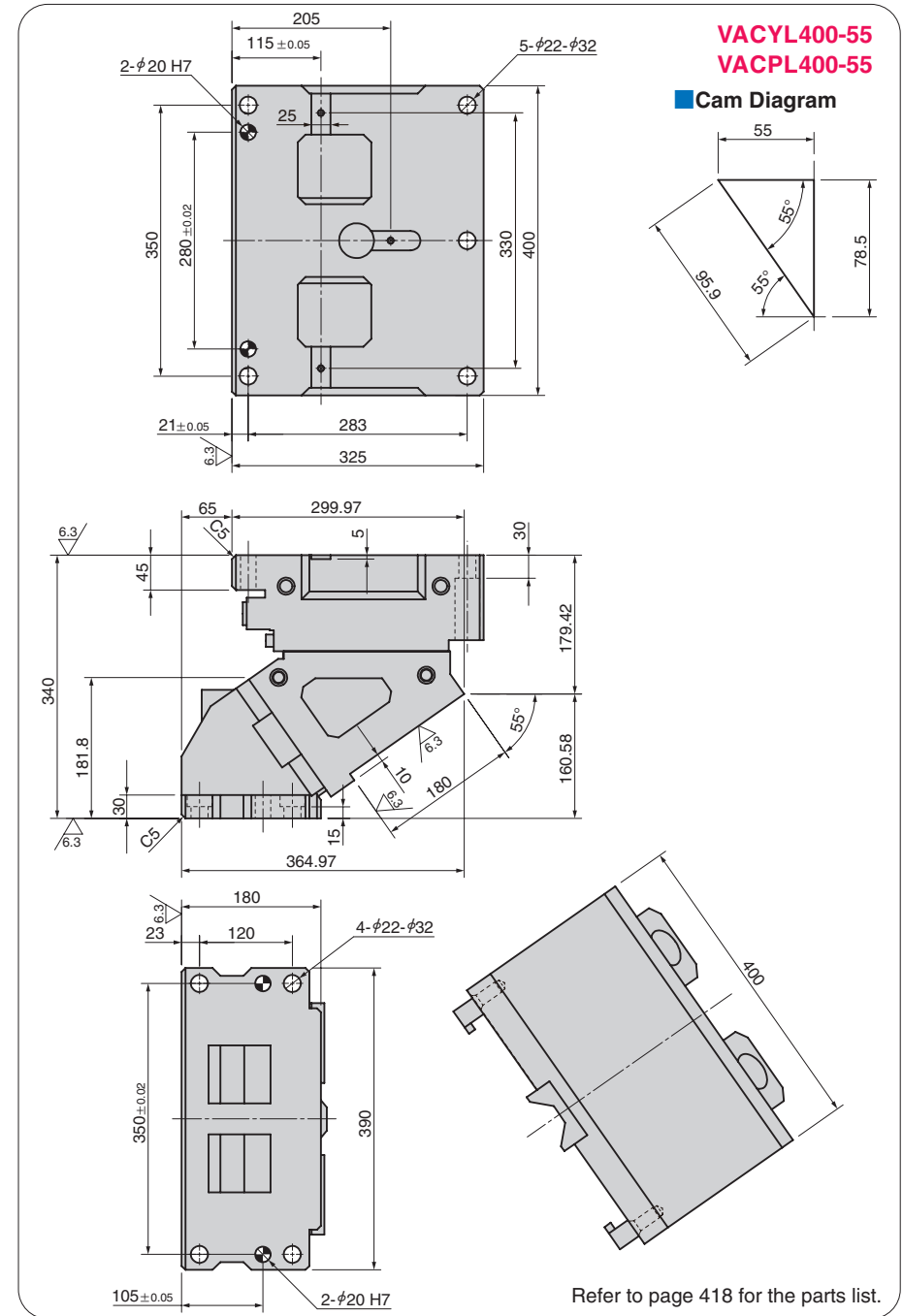
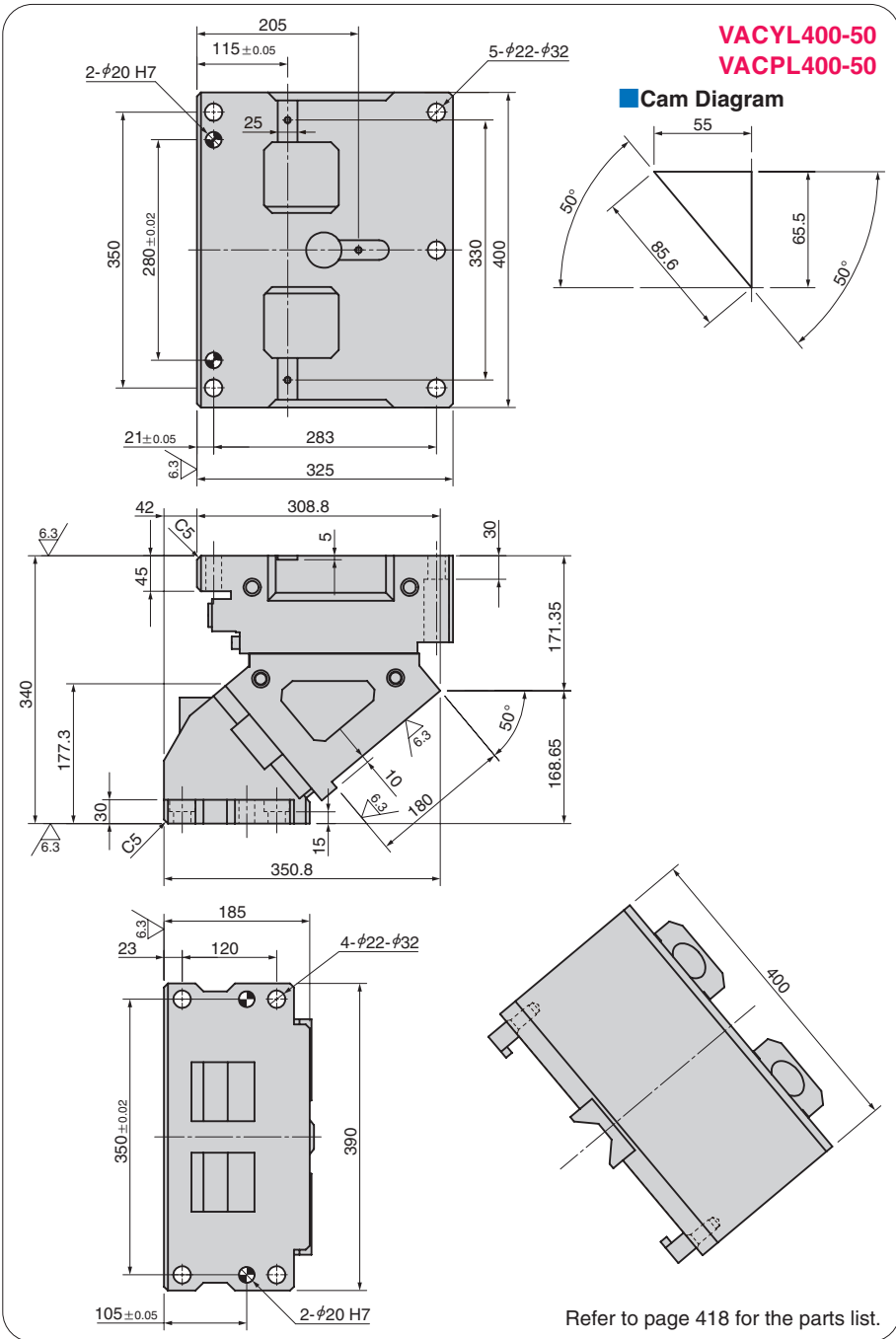


AERIAL CAM UNIT

NEW CAD FILE

Cam Units

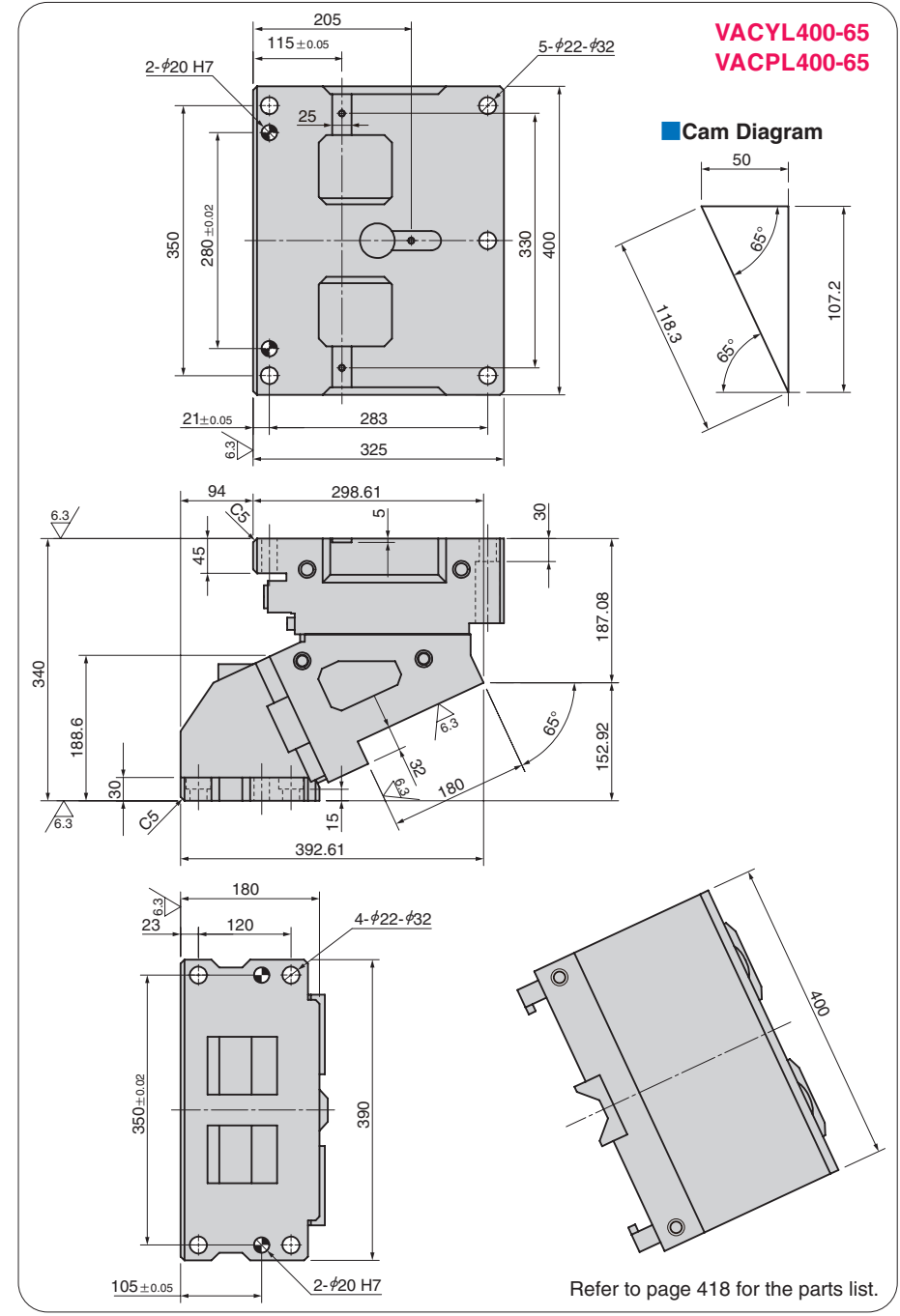
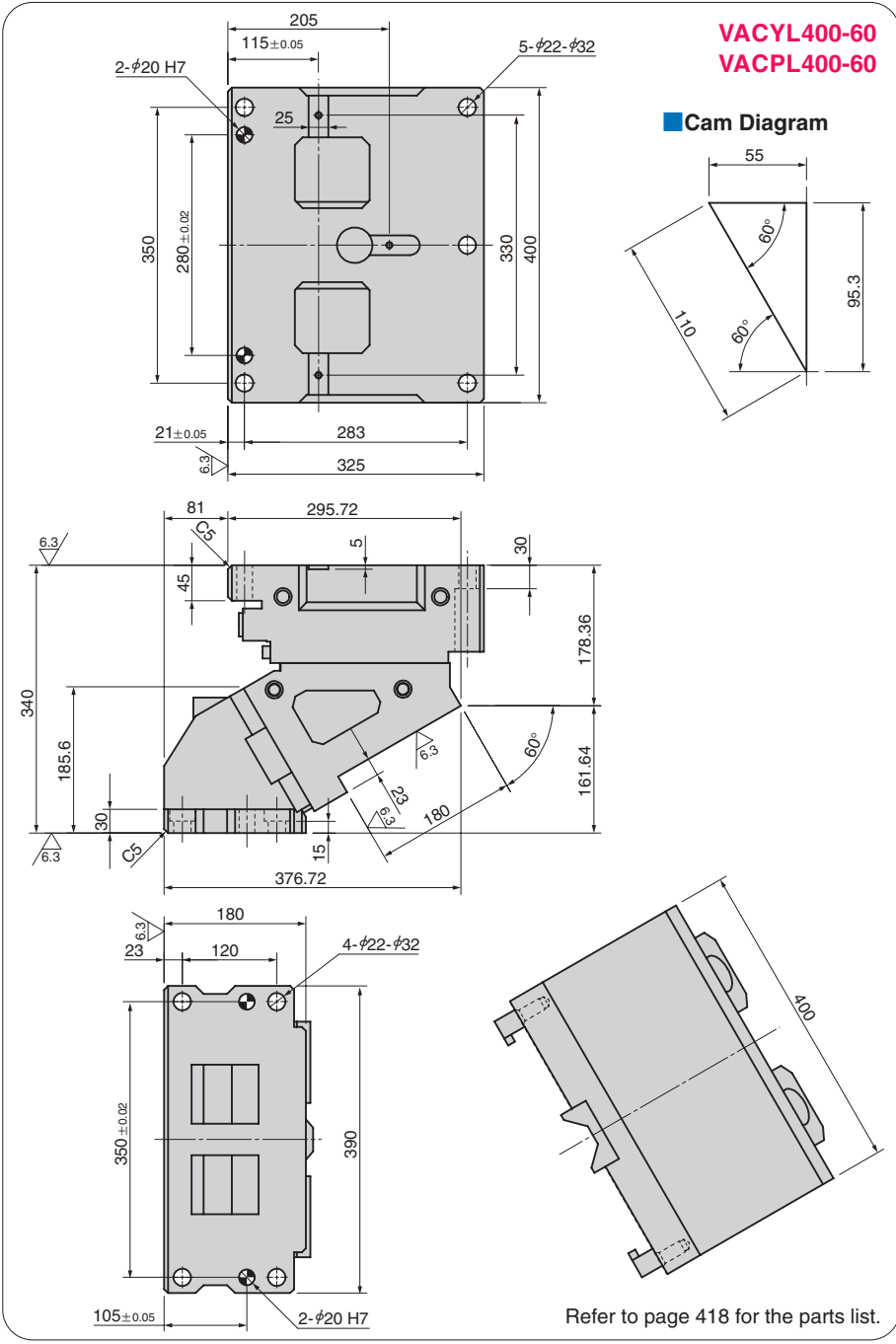


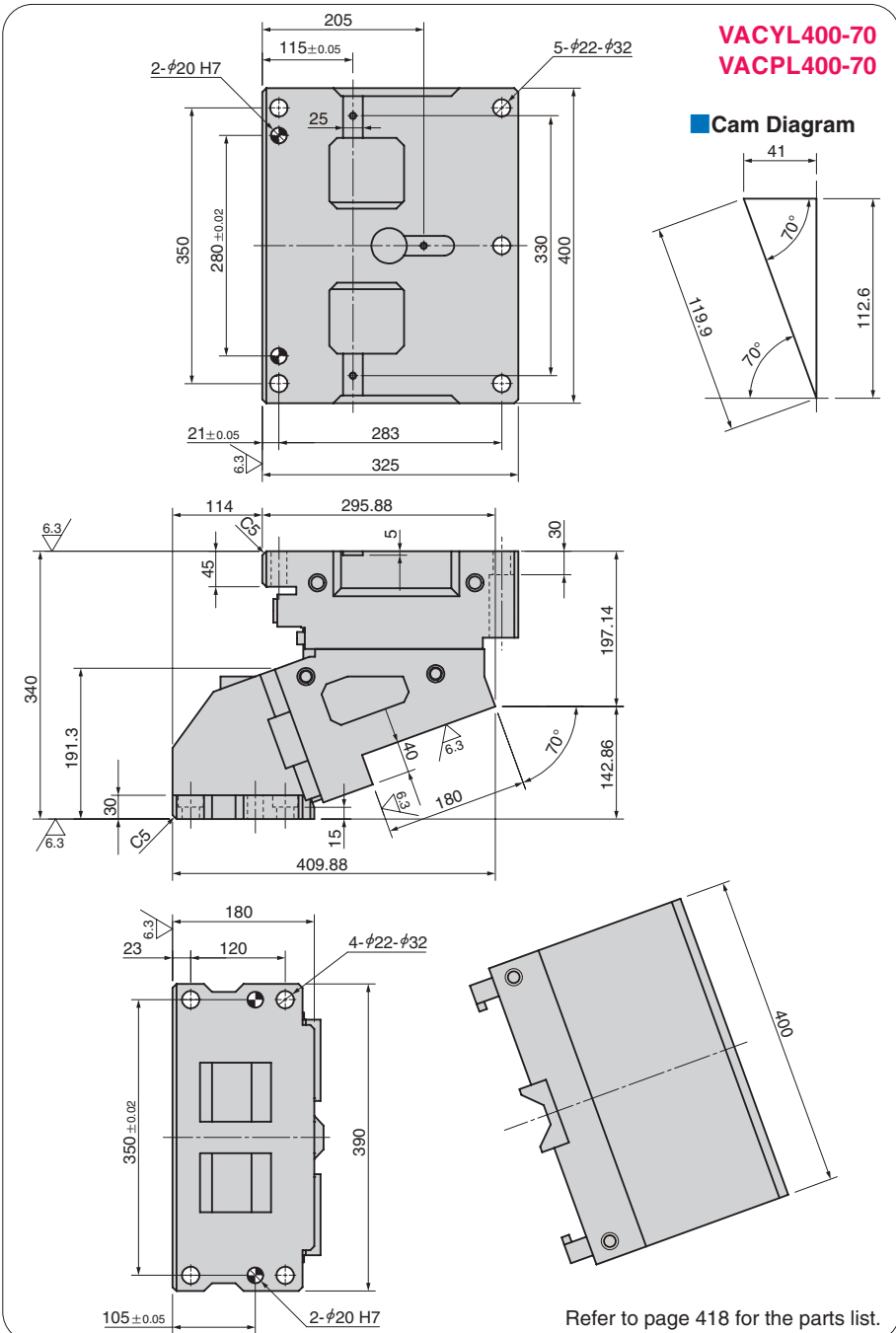


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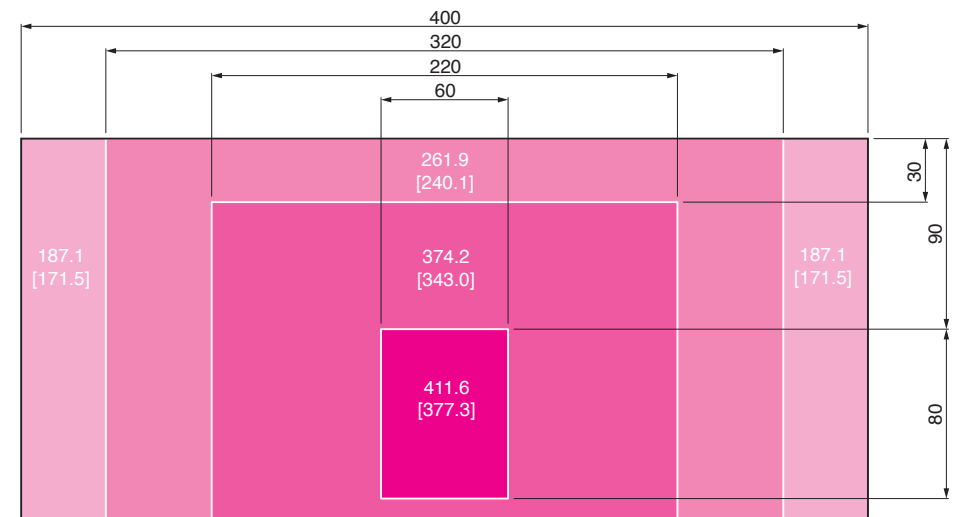
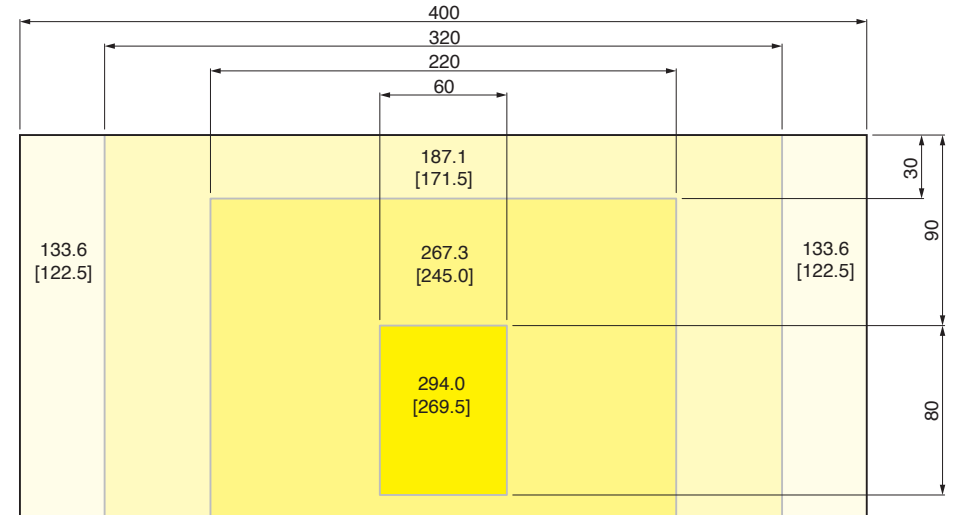
Cam Units





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