

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	141.1(14.4)	164.6(16.8)	VACYL	200	00~70 (5-degree increments)	ISO GK NGK GD NGD GS NGS
Pink	197.6(20.1)	230.5(23.5)	VACPL			

※ CENTER LOAD working forces
OFFSET LOADS : See working forces Distribution Diagram page 642

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	200	10	ISO	
VACPL	200	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	873	89.0	6872	701.2	9391	958.3
5	873	89.0	6872	701.2	9358	954.9
10	873	89.0	6872	701.2	9323	951.3
15	873	89.0	6872	701.2	9286	947.6
20	873	89.0	6872	701.2	9247	943.6
25	873	89.0	6872	701.2	9207	939.5
30	873	89.0	6872	701.2	9166	935.3
35	873	89.0	6872	701.2	9124	931.0
40	873	89.0	6872	701.2	9082	926.7
45	873	89.0	6872	701.2	9039	922.4
50	873	89.0	6872	701.2	8997	918.1
55	873	89.0	6872	701.2	9786	998.6
60	873	89.0	6872	701.2	10823	1104.4
65	873	89.0	6326	645.5	11227	1145.6
70	702	71.6	6455	658.7	13242	1351.3

- Gas spring specification
Yellow, Pink

Spring force		Return force	
Final load			
N	kgf	N	kgf
13914	1420	18686	1906.8
13914	1420	18653	1903.4
13914	1420	18618	1899.8
13914	1420	18581	1896.0
13914	1420	18542	1892.0
13914	1420	18502	1888.0
13914	1420	18461	1883.7
13914	1420	18419	1879.5
13914	1420	18376	1875.1
13914	1420	18334	1870.8
13914	1420	18292	1866.5
13914	1420	19898	2030.5
13914	1420	22004	2245.3
13478	1375	24030	2452.1
12692	1295	26155	2668.9

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

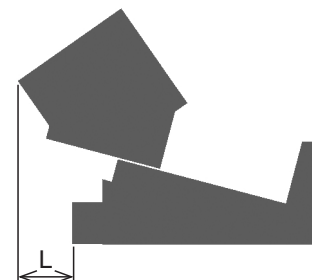
Weight

Angle	Total weight kg	Cam slider weight kg	Tool weight kg
00	89	37.2	24.8
05	89	37.2	24.9
10	89	37.2	25.3
15	88	37.2	26.5
20	87	37.2	26.8
25	85	37.2	28.1
30	85	37.2	29.7
35	84	37.2	31.6
40	85	37.2	34.1
45	87	37.2	37.2
50	86	37.2	37.2
55	90	38.1	36.3
60	89	36.8	37.6
65	91	37.7	36.7
70	95	40.6	33.8

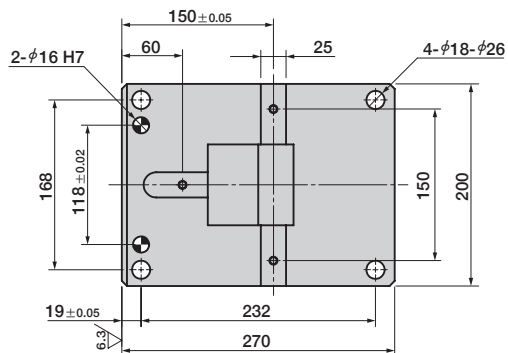
※ Tool weight is estimated value. Allowable tool weight varies depending on press speed.

Rear removal space

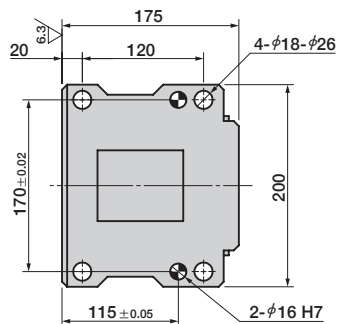
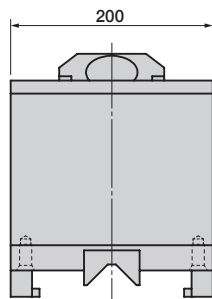
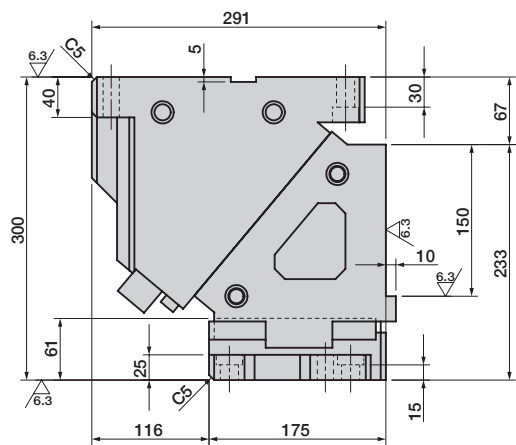
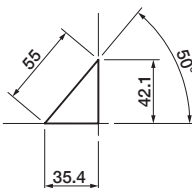
Angle	L mm
00	45.5
05	55.3
10	63.8
15	71.8
20	84.2
25	96.5
30	106
35	120
40	132
45	144
50	153
55	162
60	162
65	159
70	154



VACYL200-00 VACPL200-00

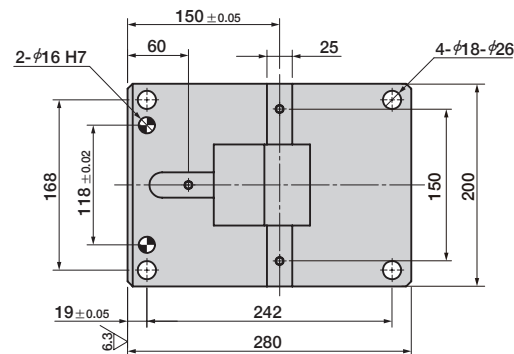


■ Cam Diagram

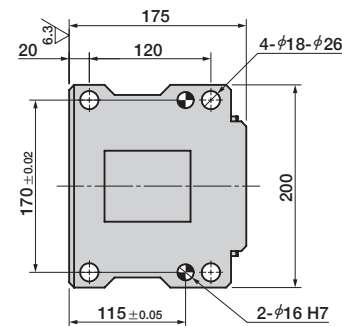
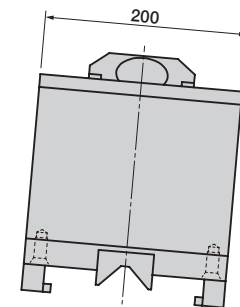
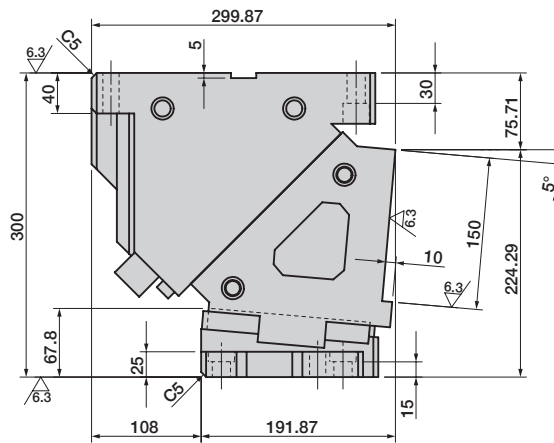
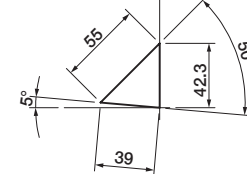


Refer to page 418 for the parts list.

VACYL200-05 VACPL200-05

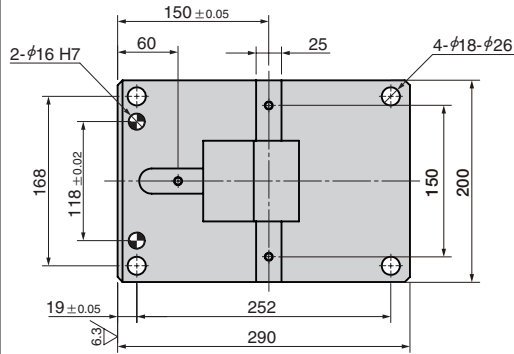


■ Cam Diagram

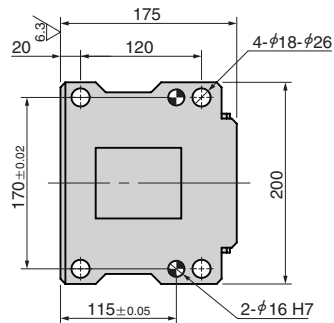
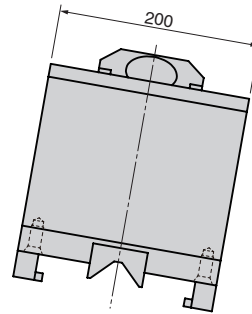
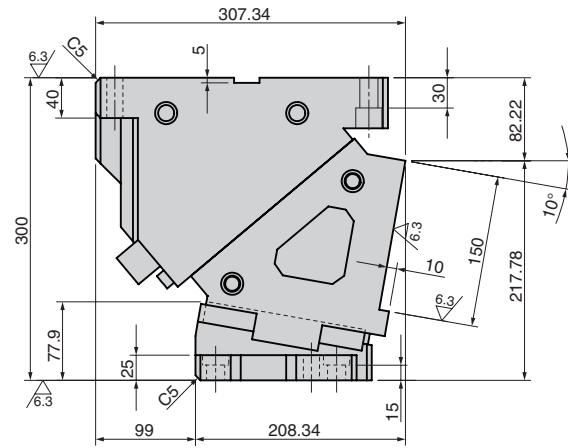
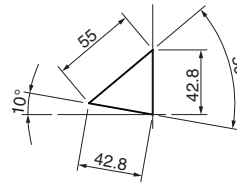


Refer to page 418 for the parts list.

VACYL200-10 VACPL200-10

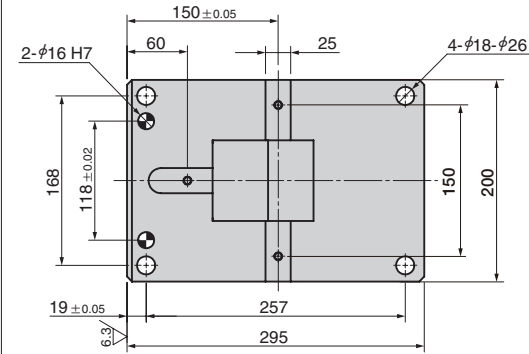


■ Cam Diagram

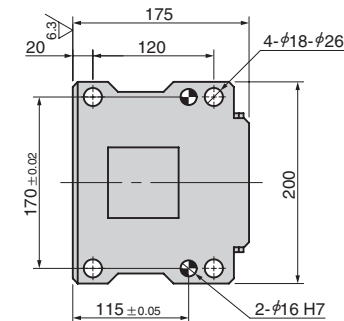
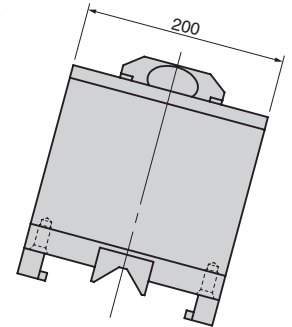
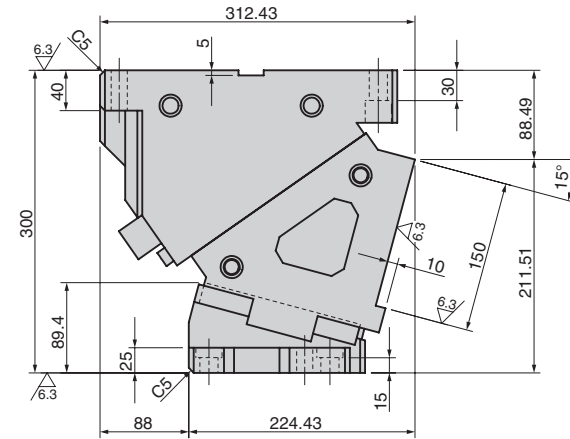
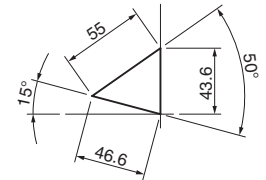


Refer to page 418 for the parts list.

VACYL200-15 VACPL200-15

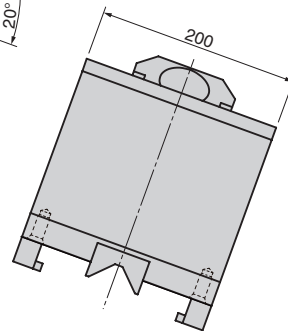
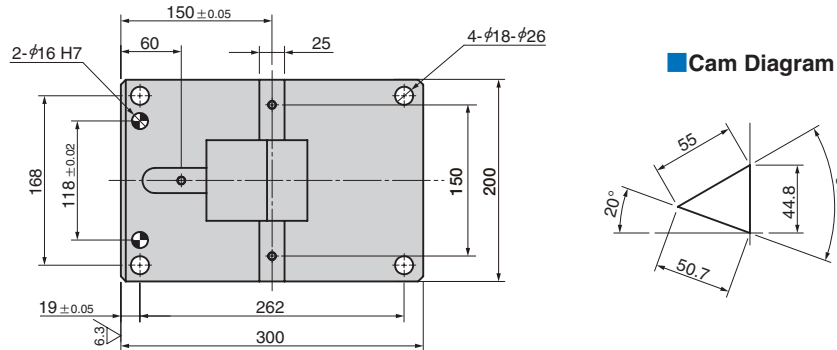


■ Cam Diagram

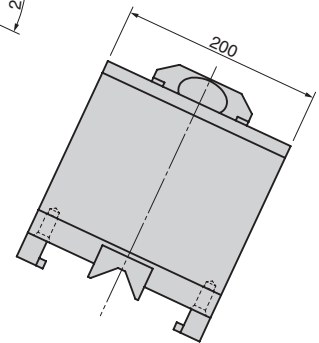
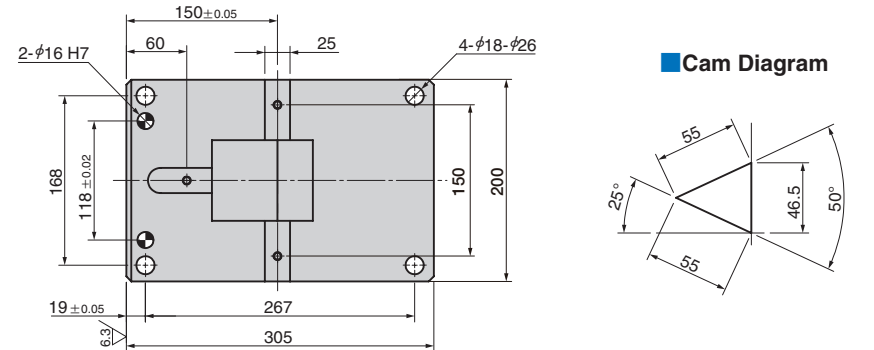


Refer to page 418 for the parts list.

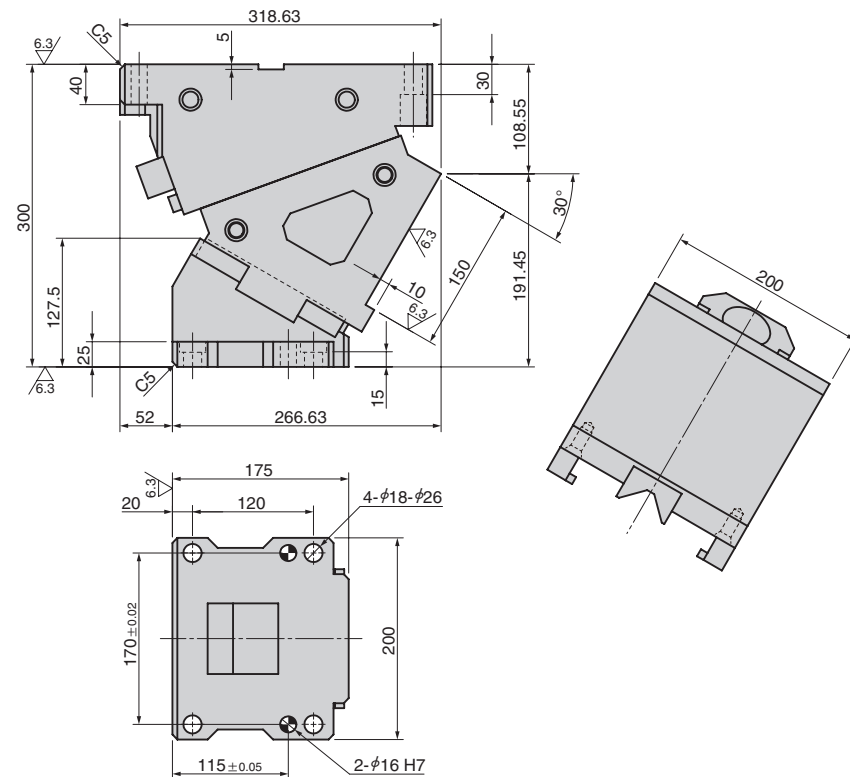
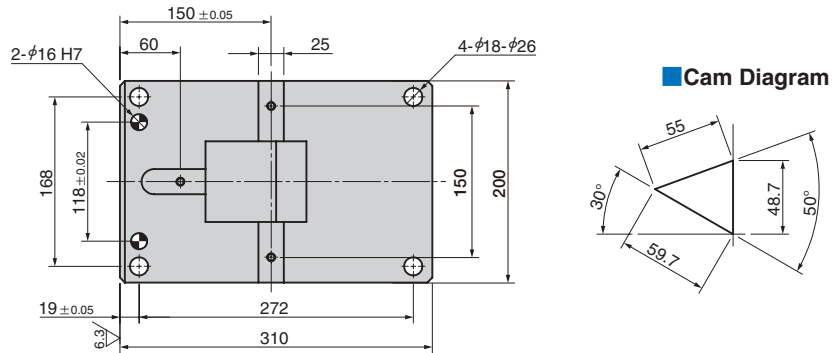
VACYL200-20 VACPL200-20



VACYL200-25 VACPL200-25

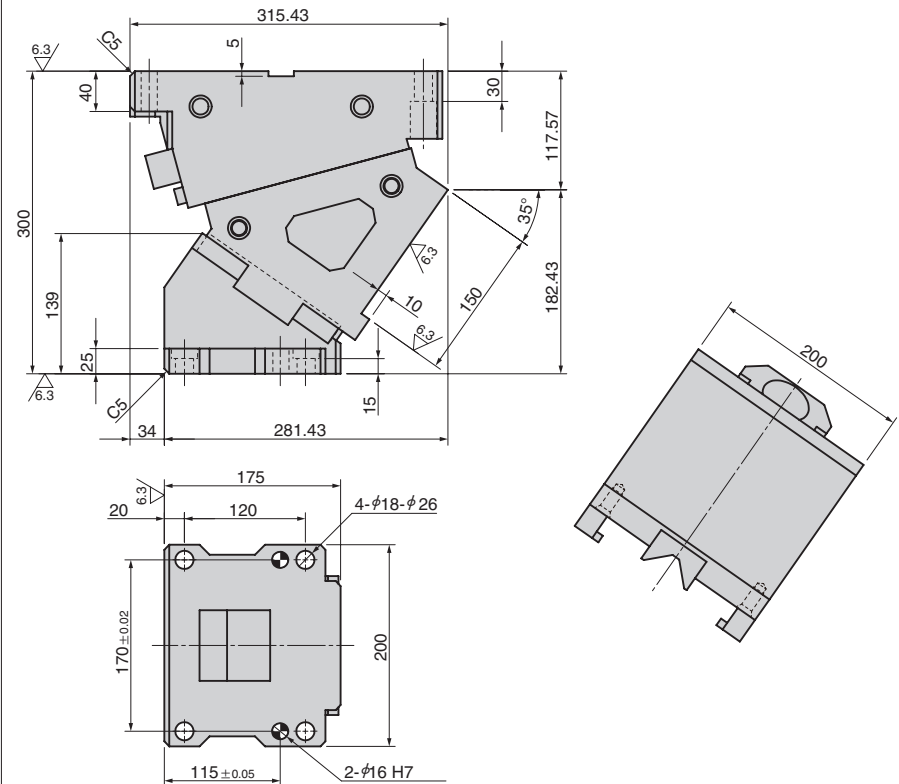
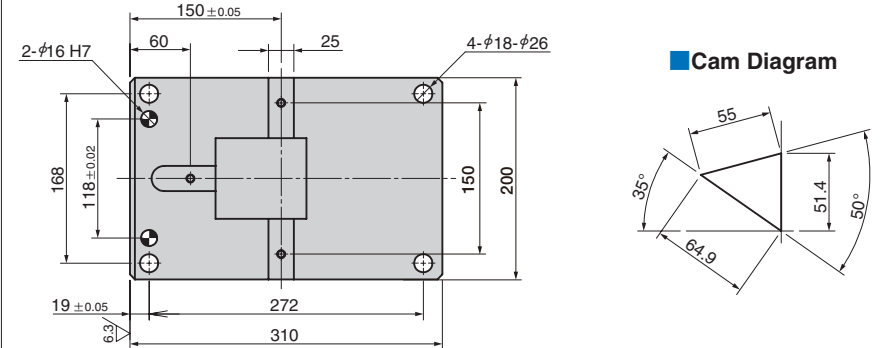


VACYL200-30 VACPL200-30



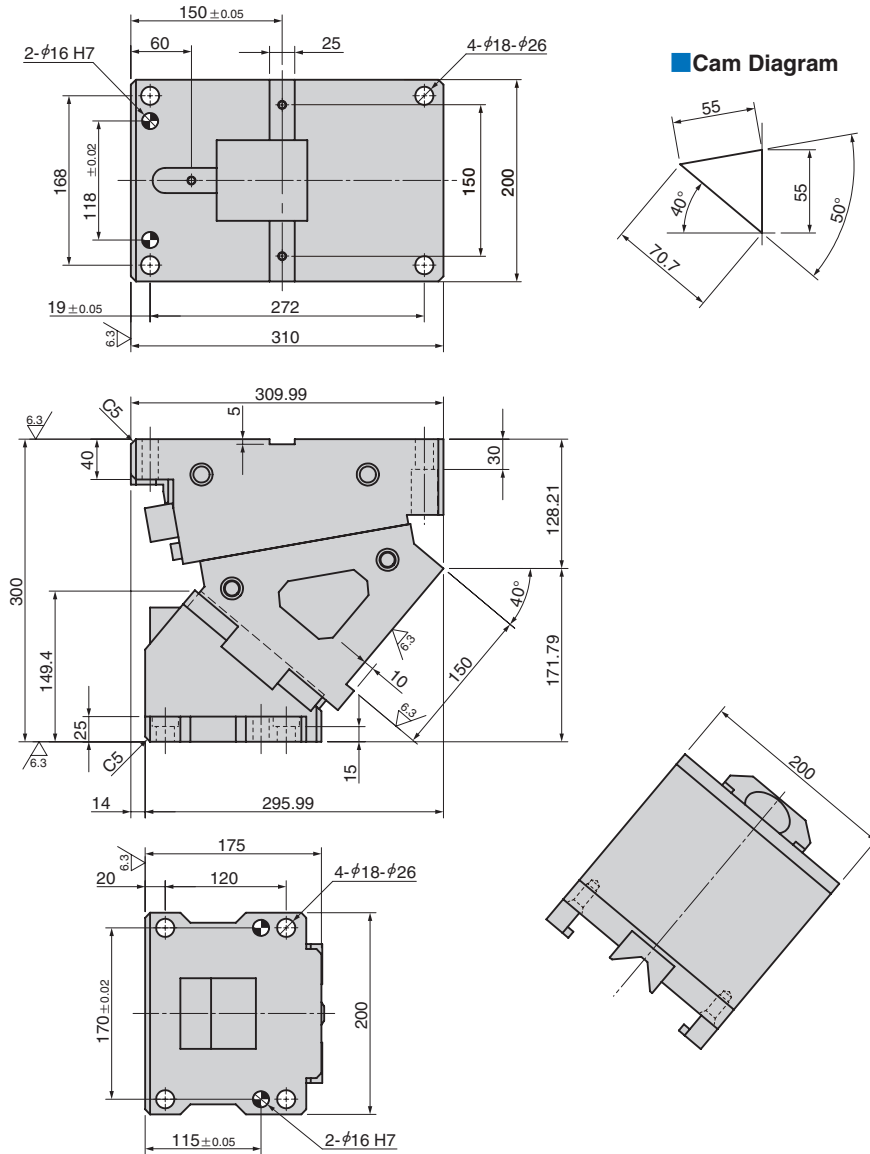
Refer to page 418 for the parts list.

VACYL200-35 VACPL200-35



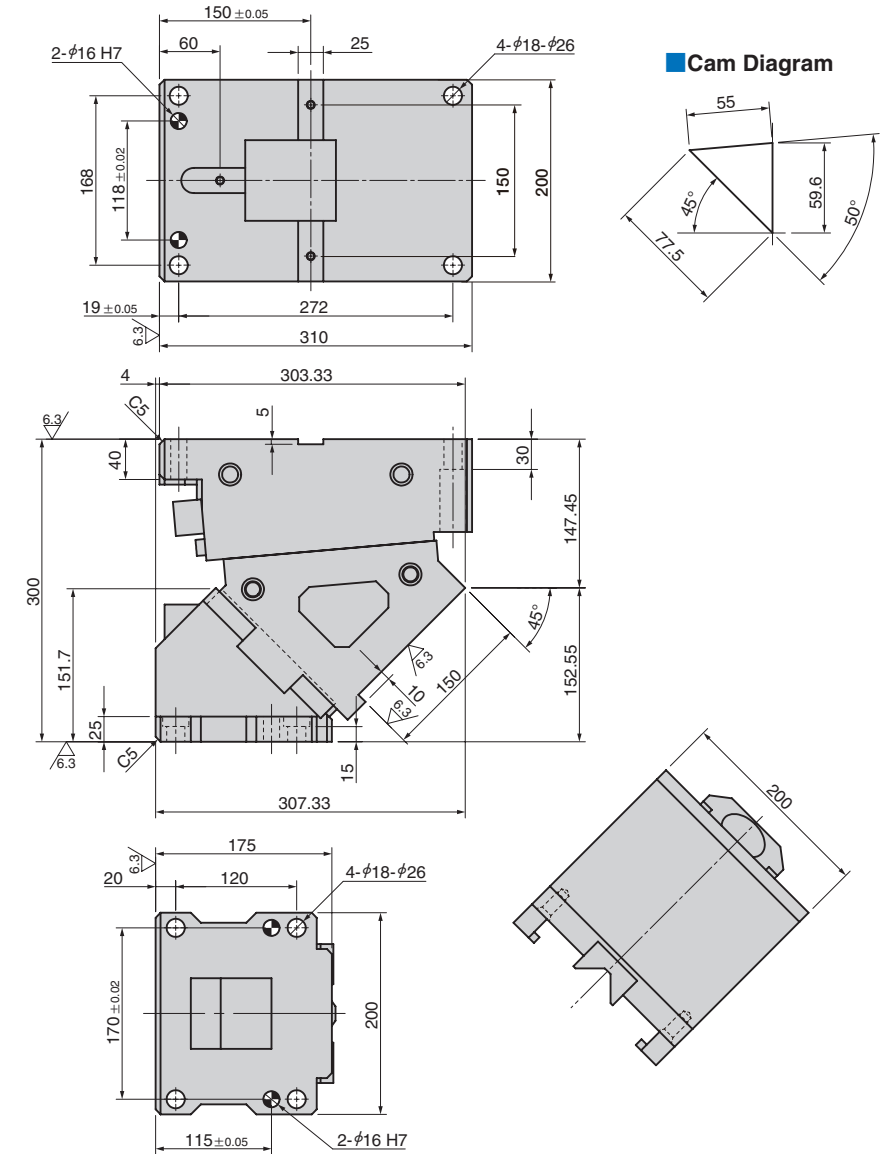
Refer to page 418 for the parts list.

VACYL200-40 VACPL200-40



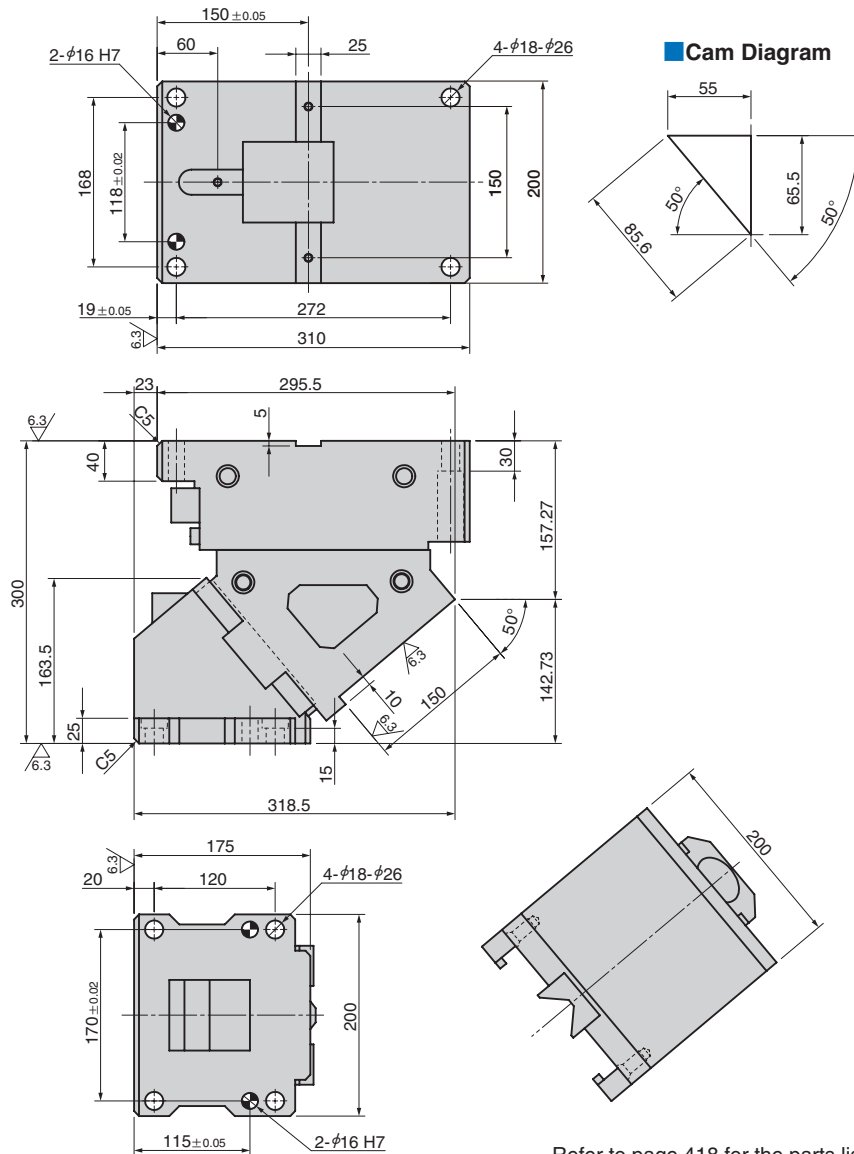
Refer to page 418 for the parts list.

VACYL200-45 VACPL200-45



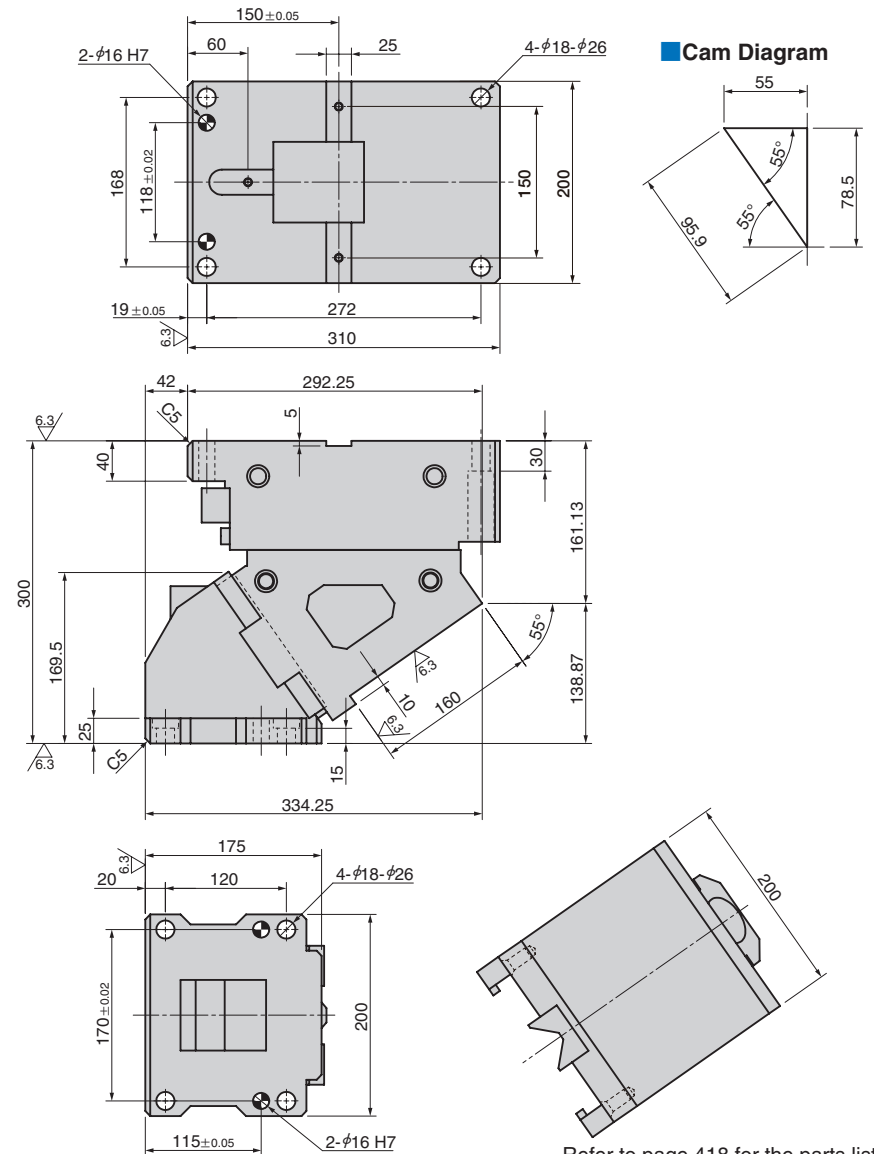
Refer to page 418 for the parts list.

VACYL200-50
VACPL200-50



Refer to page 418 for the parts list.

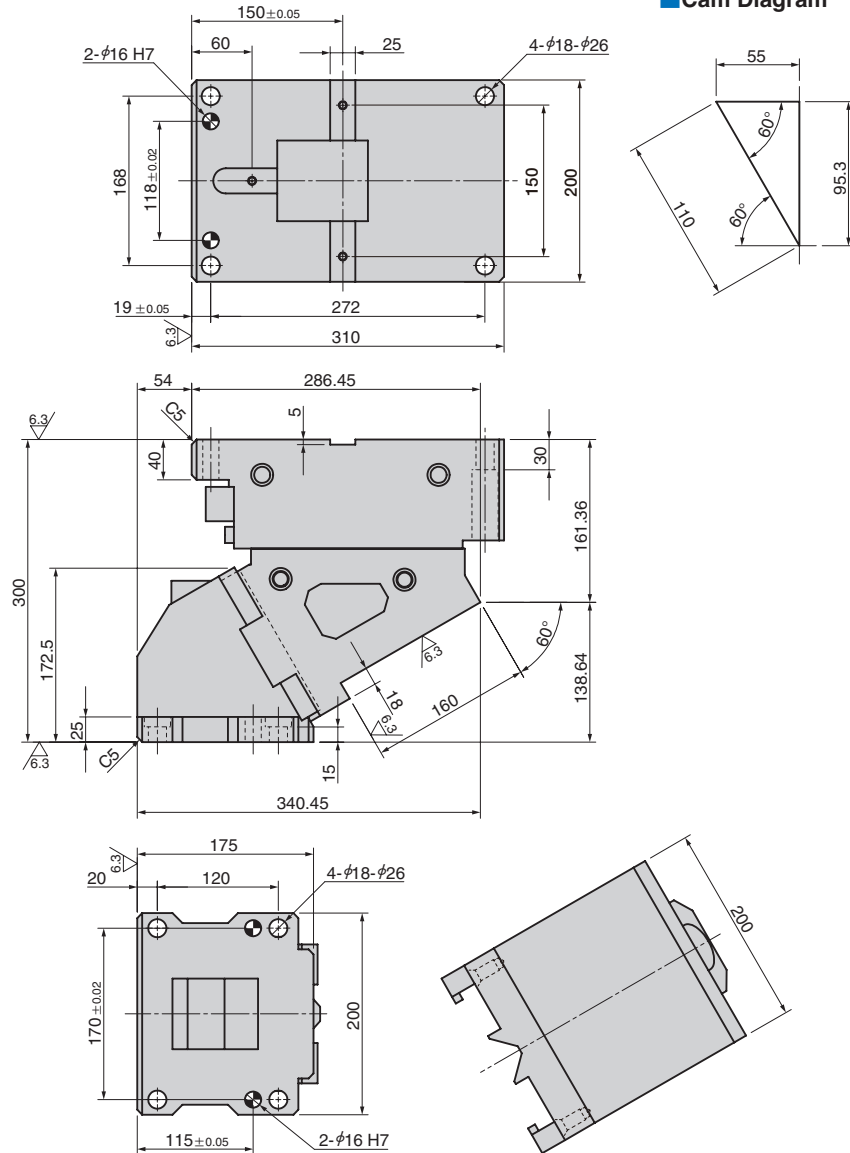
VACYL200-55
VACPL200-55



Refer to page 418 for the parts list.

VACYL200-60
VACPL200-60

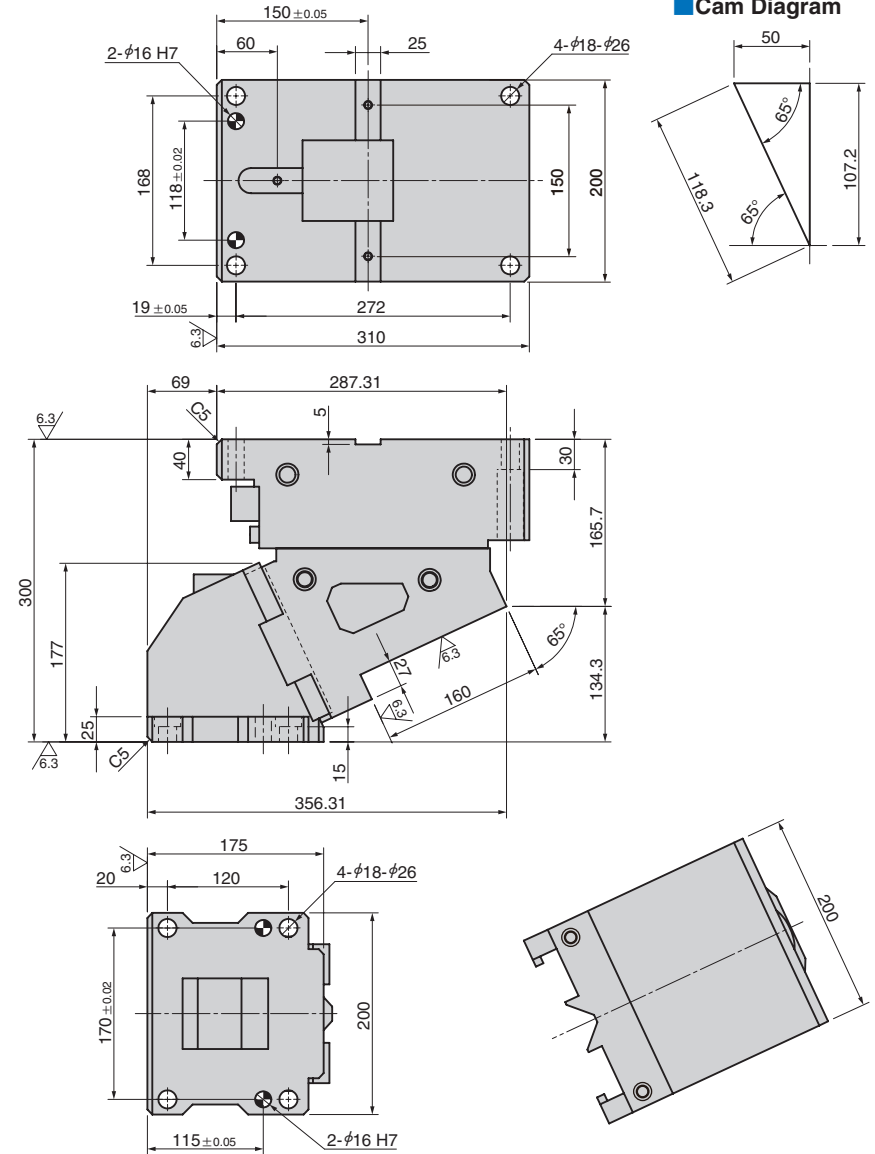
■ Cam Diagram



Refer to page 418 for the parts list.

VACYL200-65
VACPL200-65

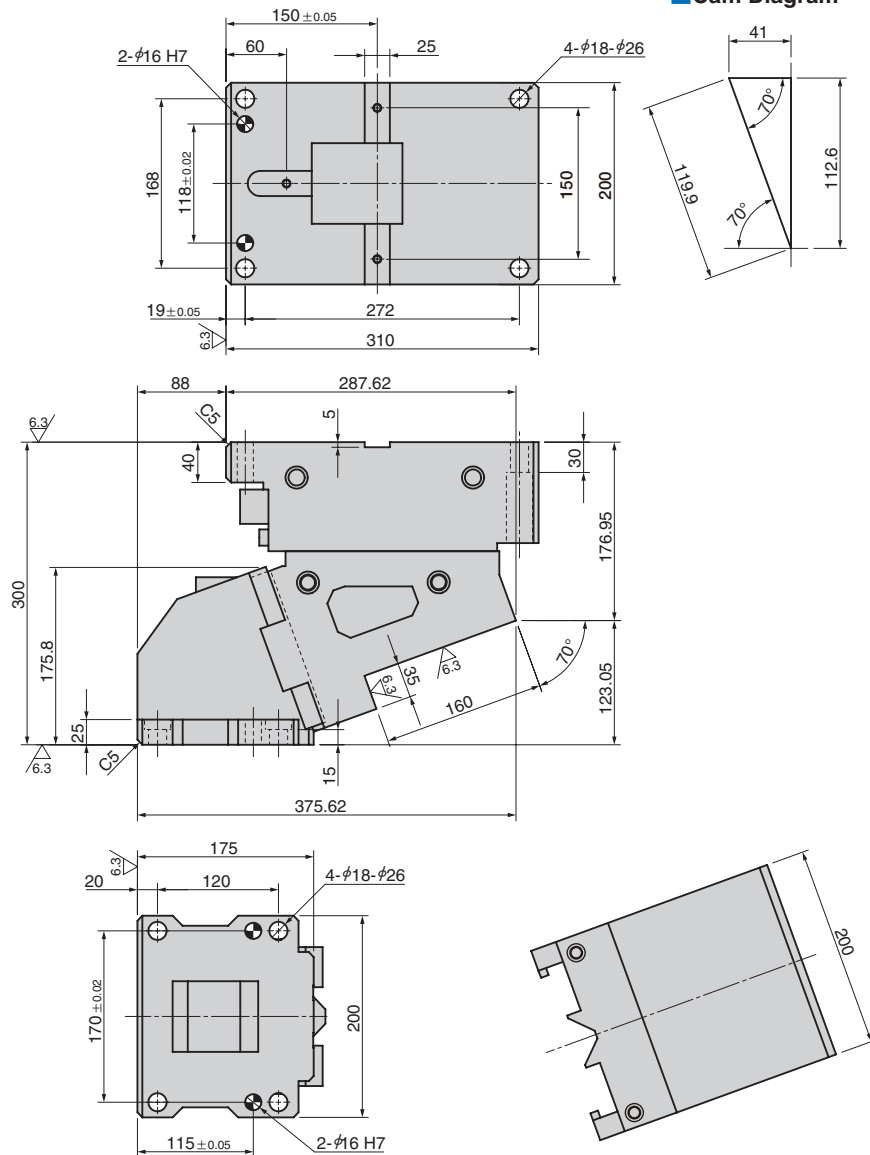
■ Cam Diagram



Refer to page 418 for the parts list.

VACYL200-70
VACPL200-70

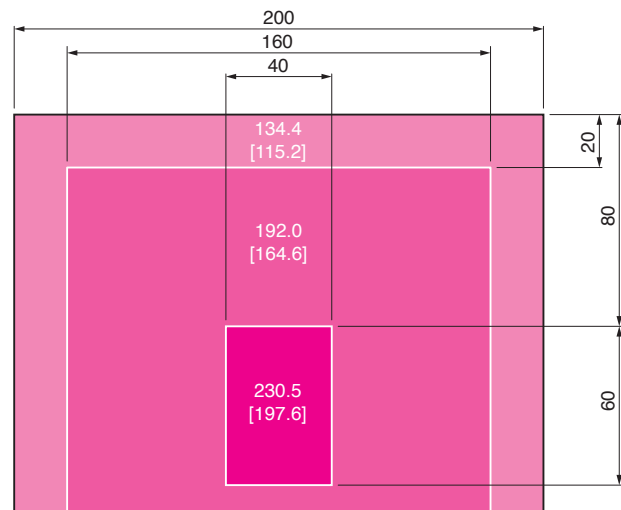
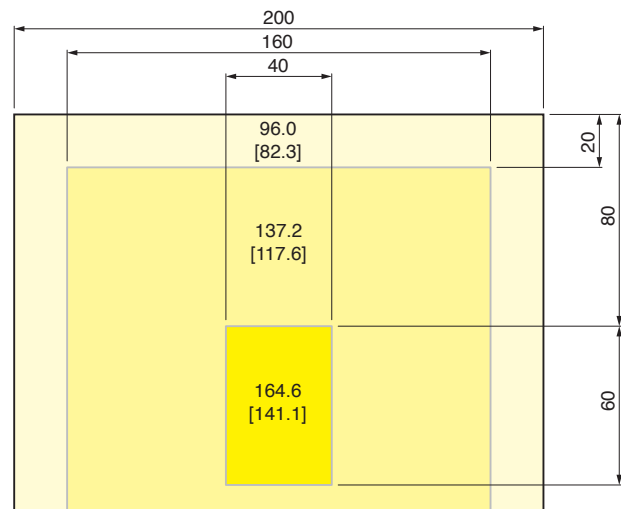
Cam Diagram



Refer to page 418 for the parts list.

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