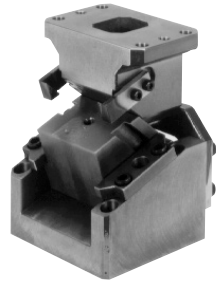


Die Mounted Cam Unit SKCA

Die Mounted Cam Unit

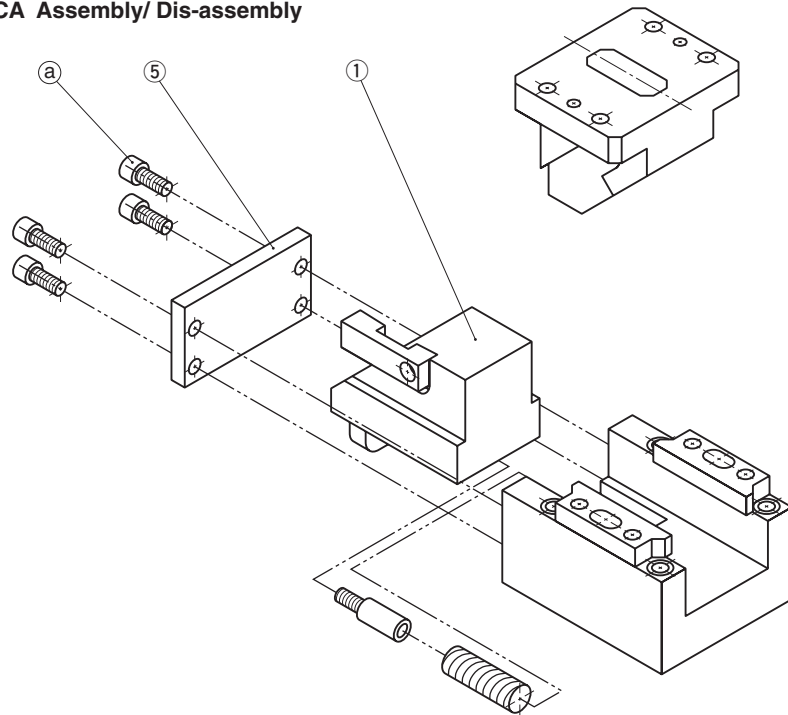


- Mounting surface widths 52, 65, 100, 150, 200, 200, 250, 300 mm
- Working angles from 0° to 20° in 5° increments for the mounting surface widths 65 to 150 mm
- The Box-type holder provides high rigidity

⚠ Gas Spring:

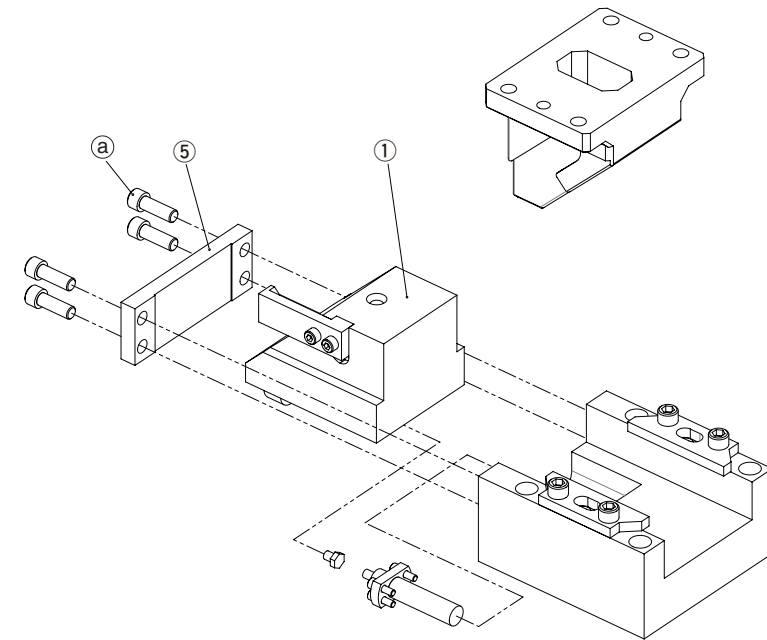
Please contact your local sales representative, if you prefer to use a gas spring not specified in our catalog. For use and maintenance of gas spring, please contact the manufacturer directly.

■ SKCA Assembly/ Dis-assembly



Coil Spring Specification

Technical Information



Gas Spring Specification

●Disassembling SKCA

- 1) Remove Hexagon Socket Head Bolts (a) and Stopper Plate (5).
- 2) Pull out Cam Slider from Cam Holder.

●Re-assembly

Reassembly is the reverse procedure of disassembly.

NOTES:

- 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 Cam Slider and Cam Holder, which also should be identified by the same serial number.
- All bolts shall be tightened to the recommended torque after assembly and dis-assembly.

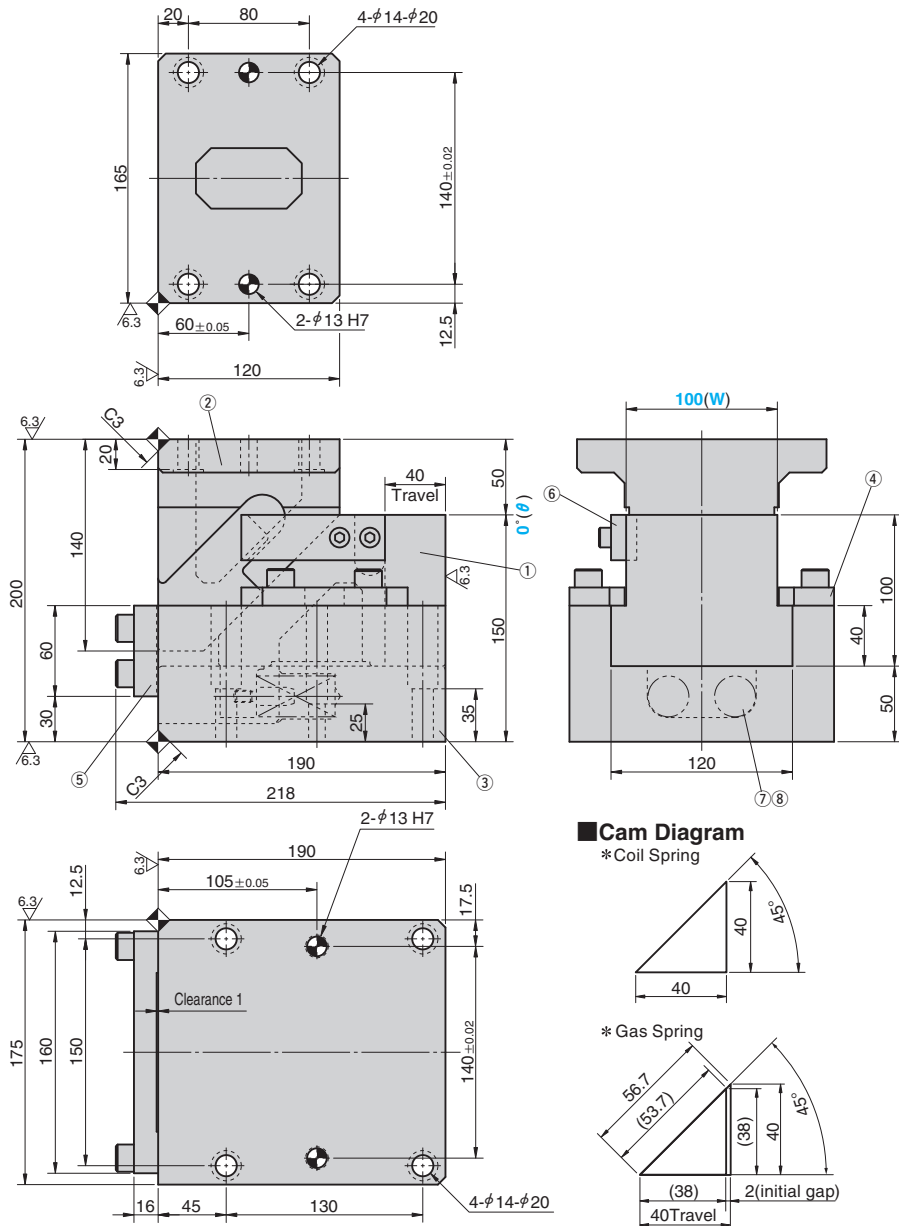
Die Mounted Cam Unit

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Addition

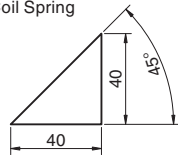
CAD FILE

SKCA100-00-40

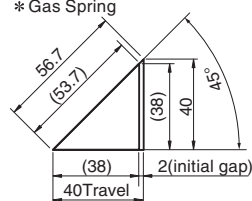


Cam Diagram

*Coil Spring



*Gas Spring



Working Force kN(tonf)		Spring Force N(kgf)		Slider Weight kg	Total Weight kg	Catalog No.	W	θ	Travel S	Spring Type PS
1,000,000 strokes	300,000 strokes	Initial Load	Final Load							
29.4 (3.0)	58.8 (6.0)	188.5 (19.2)	1130.9 (115.2)	10.5	37.0	SKCA	100	00	40	No code (Coil Spring)
		-	1111 (113.4)							GK *NGK
										GD *NGD
										GS *NGS

* Parts for spring assembly are included.



Order

Catalog No.	W	θ	S	PS	Option
SKCA	100	00	40	GK	
SKCA	100	00	40	NGK	
SKCA	100	00	40	GK	NF

...Without gas spring.



Option

Option Code	Specification
N12	φ12mm dowel holes provided on holder.
NF	Nitrogen gas not charged.

See page 389 for specifications of tapped and dowel pin holes for mounting a retainer.

Spring Specification

No.	PS	Spring Model	Qty	Remark
⑧	-	TF27-100	2	Coil Spring
	GK	R19-50-Yellow	1	Gas Spring (KALLER)
	GD	C.090.050.YW	1	Gas Spring (DADCO)
	GS	SFL.90.50	1	Gas Spring (SDT)

*Gas filling pressure : 18MPa

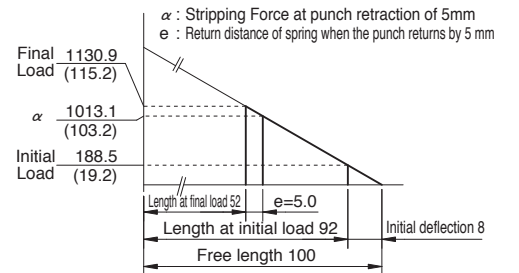
Table of Components

No.	Description	Qty	Material and Remark
①	Cam Slider	1	FC250 with Graphite
②	Cam Driver	1	FC250 with Graphite
③	Cam Holder	1	FC250
④	Upper Plate	2	S45C Copper Powder Sintered
⑤	Stopper Plate	1	SS400(1020)
⑥	Positive Return Follower	1	S45C(1045)
⑦	Spring Guide Pin	2	φ12X40 Coil Spring specification only
⑦	Mounting Plate	1	Gas Spring specification only
⑧	Spring	-	Refer to the Spring Specification table.
⑪	Stop Pin	1	Gas Spring specification only

Spring Diagram

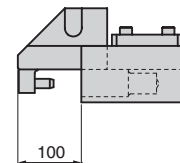
(Stripping Force at punch retraction of 5mm)

- Spring used TF27-100 (2 pieces)
- Spring constant 11.78N/mm (1.20kgf/mm)
- Spring life expectancy 300,000 strokes



⚠ Bolts for assembly are not indicated.

Space for removing

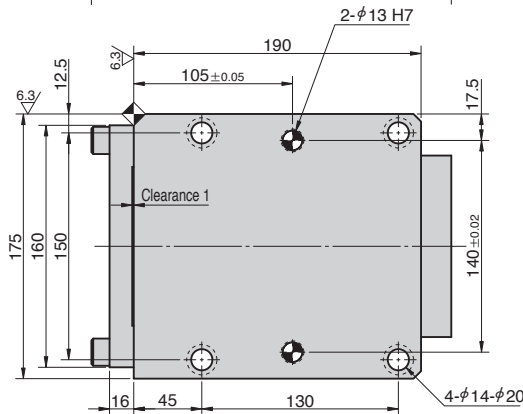
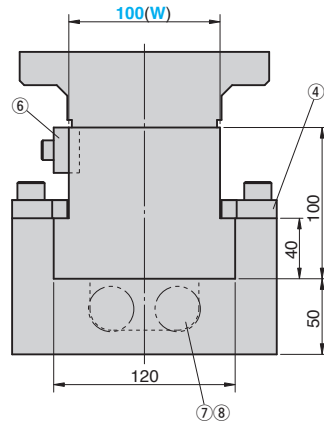
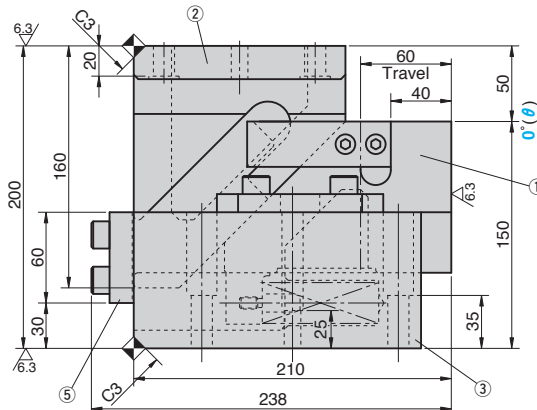
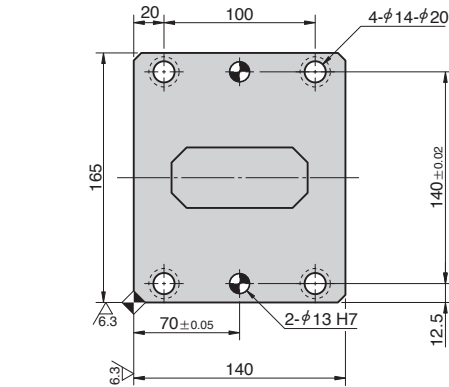


Die Mounted Cam Unit

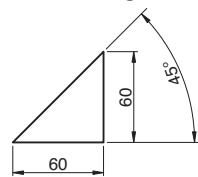
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SKCA100 - 00 - 60



Cam Diagram



Working Force kN(tonf)		Spring Force N(kgf)		Slider Weight kg	Total Weight kg	Catalog No.	W	θ	Travel S
1,000,000 strokes	300,000 strokes	Initial Load	Final Load						
29.4 (3.0)	58.8 (6.0)	204.1 (20.8)	1146.1 (116.8)	10.5	38.0	SKCA	100	00	60



Order

Catalog No.	W	θ	S
SKCA	100	00	60



Option

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

See page 389 for specifications of tapped and dowel pin holes for mounting a retainer.

Table of Components

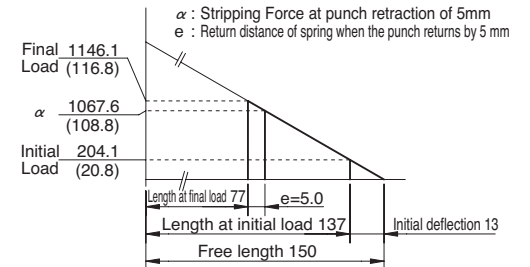
No.	Description	Qty	Material and Remark
①	Cam Slider	1	FC250 with Graphite
②	Cam Driver	1	FC250 with Graphite
③	Cam Holder	1	FC250
④	Upper Plate	2	S45C Copper Powder Sintered
⑤	Stopper Plate	1	SS400(1020)
⑥	Positive Return Follower	1	S45C(1045)
⑦	Spring Guide Pin	2	φ 12×40
⑧	Coil Spring	2	TF27-150

Bolts for assembly are not indicated.

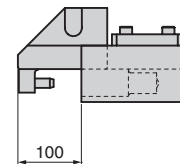
Spring Diagram

(Stripping Force at punch retraction of 5mm)

- Spring used TF27-150 (2 pieces)
- Spring constant 7.85N/mm (0.80kgf/mm)
- Spring life expectancy 300,000 strokes



Space for removing

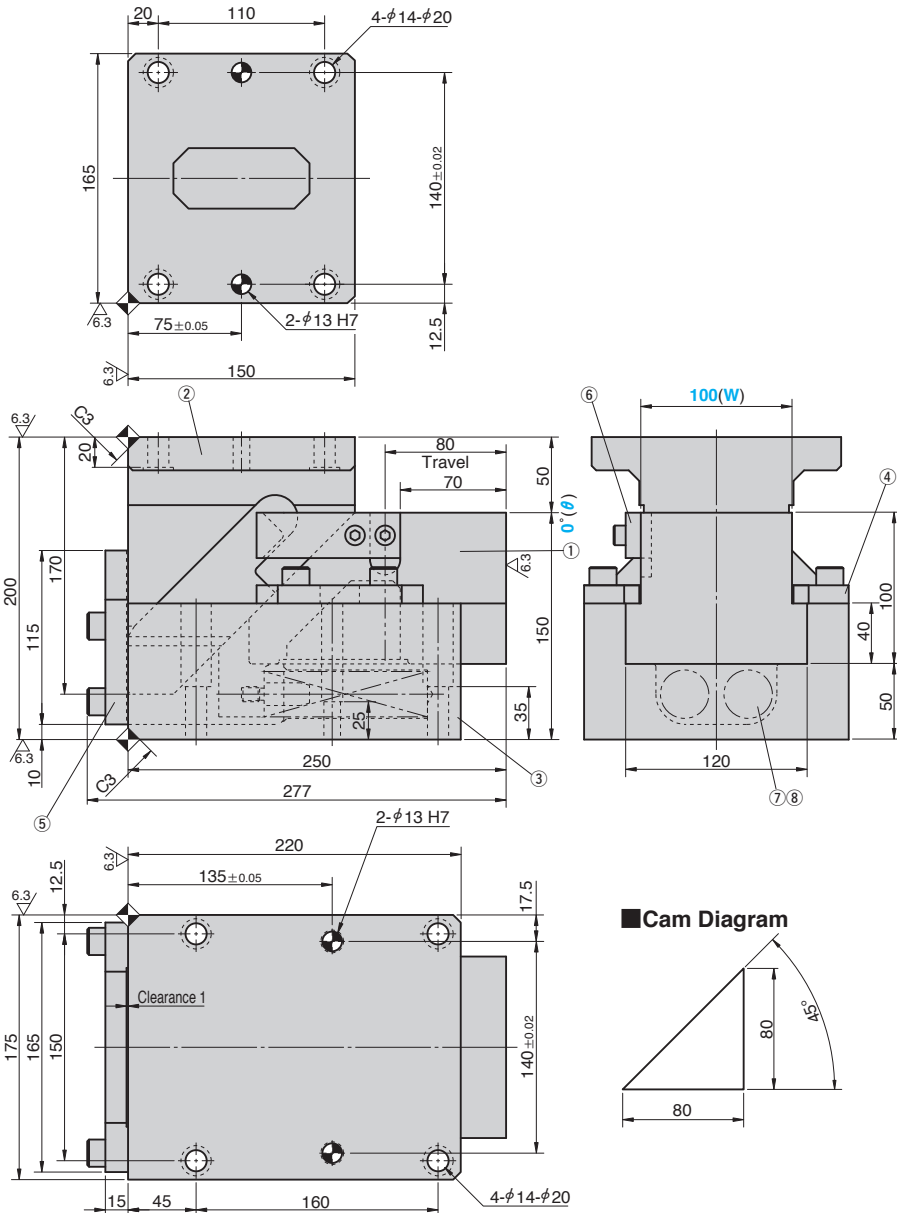


Die Mounted Cam Unit

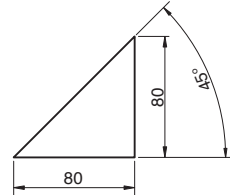
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FILE

SKCA100 - 00 - 80



Cam Diagram



Working Force kN(tonf)		Spring Force N(kgf)		Slider Weight kg	Total Weight kg	Catalog No.	W	θ	Travel S
1,000,000 strokes	300,000 strokes	Initial Load	Final Load						
29.4 (3.0)	58.8 (6.0)	169.9 (17.3)	1302.7 (132.5)	11.9	44.0	SKCA	100	00	80



Order

Catalog No.	W	θ	S
SKCA	100	00	80



Option

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

See page 389 for specifications of tapped and dowel pin holes for mounting a retainer.

Table of Components

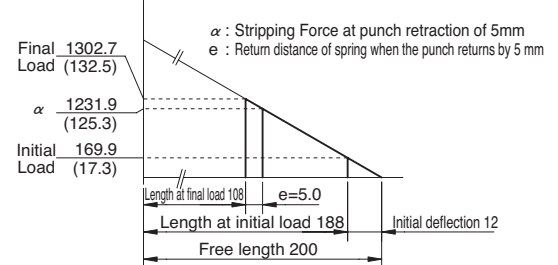
No.	Description	Qty	Material and Remark
①	Cam Slider	1	FC250 with Graphite
②	Cam Driver	1	FC250 with Graphite
③	Cam Holder	1	FC250
④	Upper Plate	2	S45C Copper Powder Sintered
⑤	Stopper Plate	1	SS400(1020)
⑥	Positive Return Follower	1	S45C(1045)
⑦	Spring Guide Pin	2	φ 15×45
⑧	Coil Spring	2	TF30-200

Bolts for assembly are not indicated.

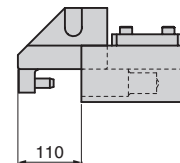
Spring Diagram

(Stripping Force at punch retraction of 5mm)

- Spring used TF30-200 (2 pieces)
- Spring constant 7.08N/mm (0.72kgf/mm)
- Spring life expectancy 300,000 strokes



Space for removing

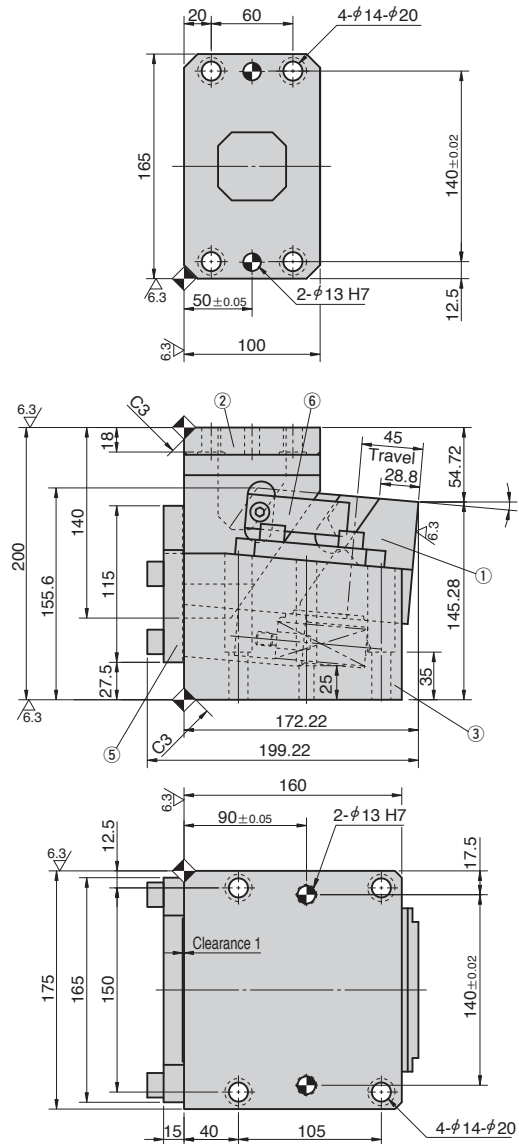


Die Mounted Cam Unit

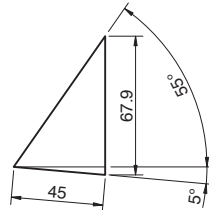
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Cam Diagram



Working Force kN(tonf)		Spring Force N(kgf)		Slider Weight kg	Total Weight kg	Catalog No.	W	θ	Travel S
1,000,000 strokes	300,000 strokes	Initial Load	Final Load						
39.2 (4.0)	78.4 (8.0)	263.8 (26.9)	1111.6 (113.3)	7.2	33.0	SKCA	100	05	45



Order

Catalog No.	W	θ	S
SKCA	100	05	45



Option

Option Code	Specification
N12	φ12mm dowel holes provided on holder.

See page 389 for specifications of tapped and dowel pin holes for mounting a retainer.

Table of Components

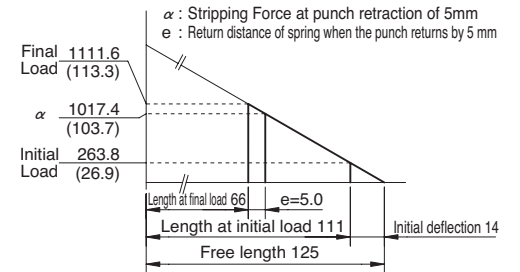
No.	Description	Qty	Material and Remark
①	Cam Slider	1	FC250 with Graphite
②	Cam Driver	1	FC250 with Graphite
③	Cam Holder	1	FC250
④	Upper Plate	2	S45C Copper Powder Sintered
⑤	Stopper Plate	1	SS400(1020)
⑥	Positive Return Follower	2	S45C(1045)
⑦	Spring Guide Pin	2	φ12×40
⑧	Coil Spring	2	TF27-125

Bolts for assembly are not indicated.

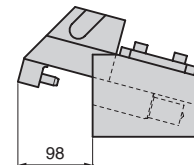
Spring Diagram

(Stripping Force at punch retraction of 5mm)

- Spring used TF27-125 (2 pieces)
- Spring constant 9.42N/mm (0.96kgf/mm)
- Spring life expectancy 300,000 strokes



Space for removing

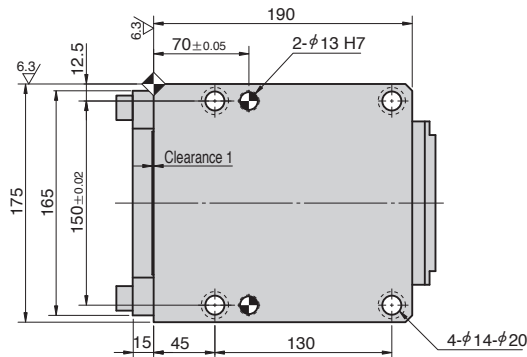
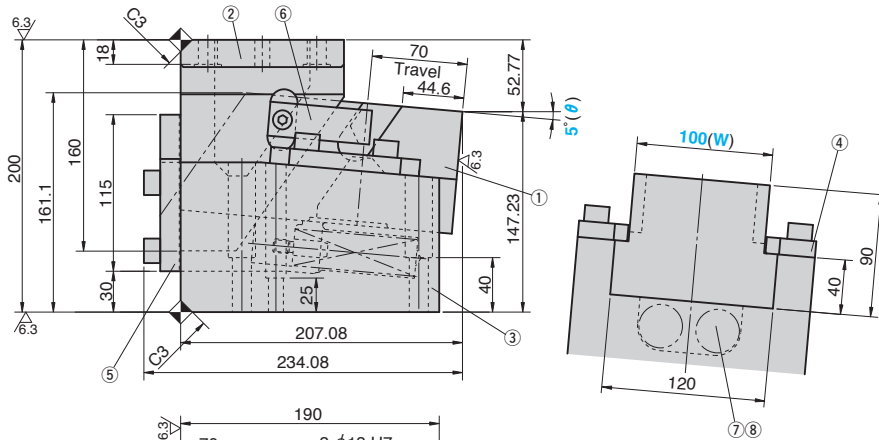
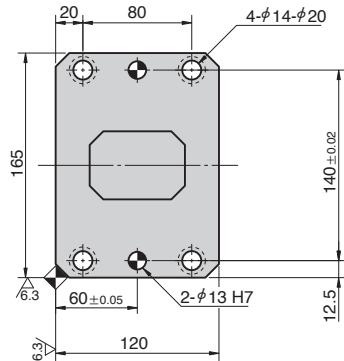


Die Mounted Cam Unit

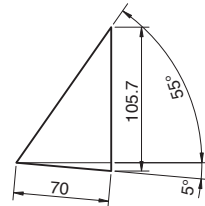
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Cam Diagram



Working Force kN(tonf)		Spring Force N(kgf)		Slider Weight kg	Total Weight kg	Catalog No.	W	θ	Travel S
1,000,000 strokes	300,000 strokes	Initial Load	Final Load						
39.2 (4.0)	78.4 (8.0)	195.2 (20.0)	1137.4 (116.6)	10.0	38.0	SKCA	100	05	70



Order

Catalog No.	W	θ	S
SKCA	100	05	70



Option

Option Code	Specification
N12	φ12mm dowel holes provided on holder.

See page 389 for specifications of tapped and dowel pin holes for mounting a retainer.

Table of Components

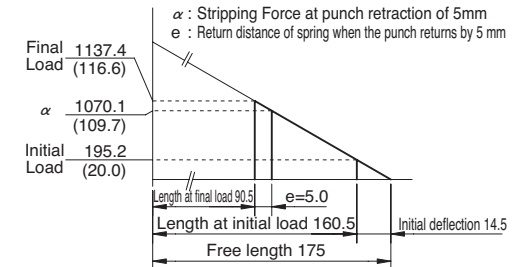
No.	Description	Qty	Material and Remark
①	Cam Slider	1	FC250 with Graphite
②	Cam Driver	1	FC250 with Graphite
③	Cam Holder	1	FC250
④	Upper Plate	2	S45C Copper Powder Sintered
⑤	Stopper Plate	1	SS400(1020)
⑥	Positive Return Follower	2	S45C(1045)
⑦	Spring Guide Pin	2	φ12×40
⑧	Coil Spring	2	TF27-175

Bolts for assembly are not indicated.

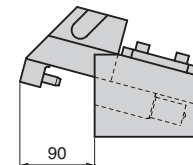
Spring Diagram

(Stripping Force at punch retraction of 5mm)

- Spring used TF27-175 (2 pieces)
- Spring constant 6.73N/mm (0.69kgf/mm)
- Spring life expectancy 300,000 strokes



Space for removing

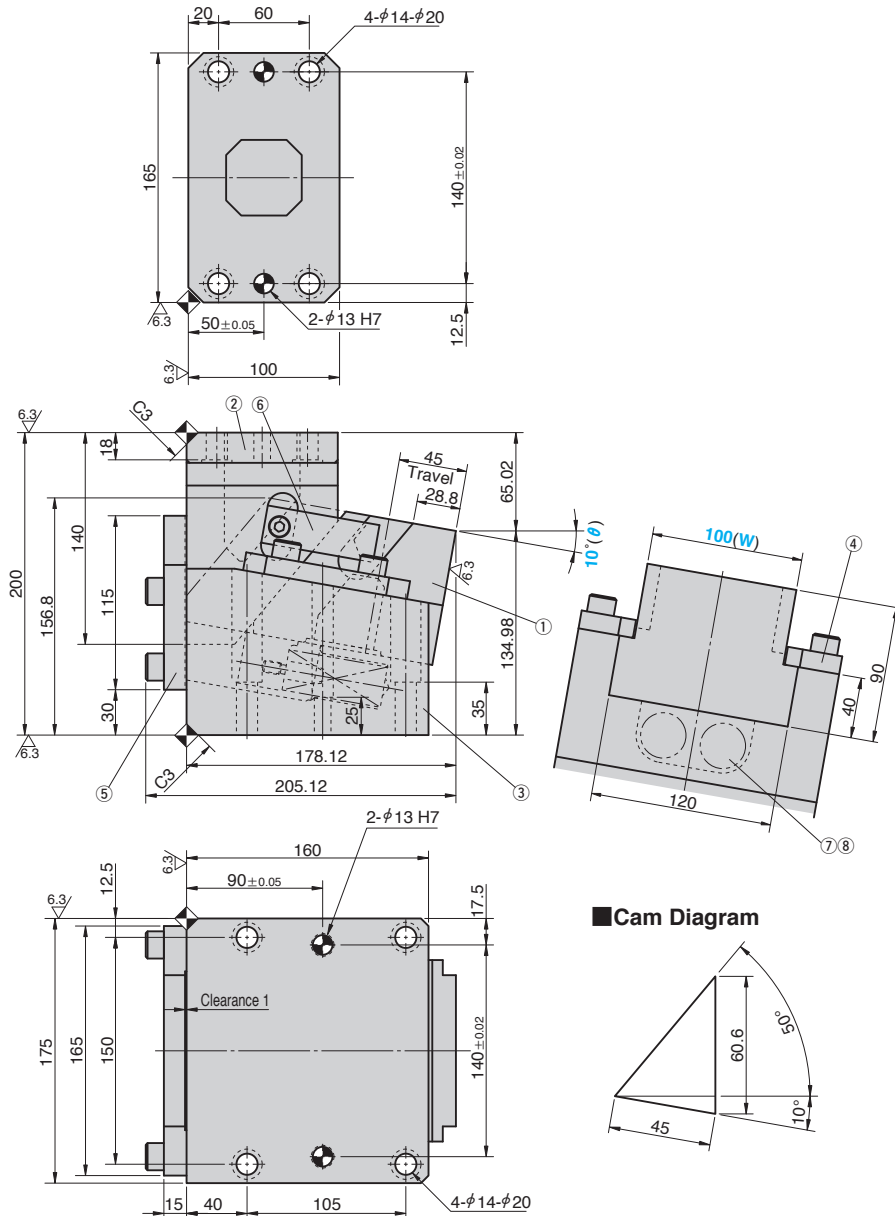


Die Mounted Cam Unit

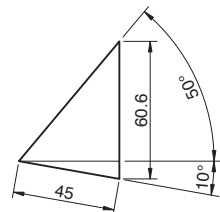
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SKCA100 - 10 - 45



Cam Diagram



Working Force kN(tonf)		Spring Force N(kgf)		Slider Weight kg	Total Weight kg	Catalog No.	W	θ	Travel S
1,000,000 strokes	300,000 strokes	Initial Load	Final Load						
39.2 (4.0)	78.4 (8.0)	263.8 (26.9)	1111.6 (113.3)	7.0	33.0	SKCA	100	10	45



Order

Catalog No.	W	θ	S
SKCA	100	10	45



Option

Option Code	Specification
N12	φ12mm dowel holes provided on holder.

See page 389 for specifications of tapped and dowel pin holes for mounting a retainer.

Table of Components

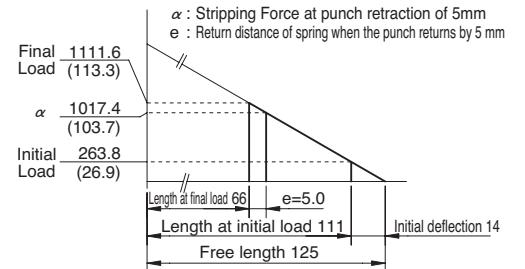
No.	Description	Qty	Material and Remark
①	Cam Slider	1	FC250 with Graphite
②	Cam Driver	1	FC250 with Graphite
③	Cam Holder	1	FC250
④	Upper Plate	2	S45C Copper Powder Sintered
⑤	Stopper Plate	1	SS400(1020)
⑥	Positive Return Follower	2	S45C(1045)
⑦	Spring Guide Pin	2	φ12×40
⑧	Coil Spring	2	TF27-125

Bolts for assembly are not indicated.

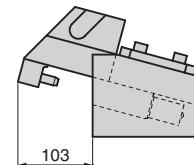
Spring Diagram

(Stripping Force at punch retraction of 5mm)

- Spring used TF27-125 (2 pieces)
- Spring constant 9.42N/mm (0.96kgf/mm)
- Spring life expectancy 300,000 strokes



Space for removing

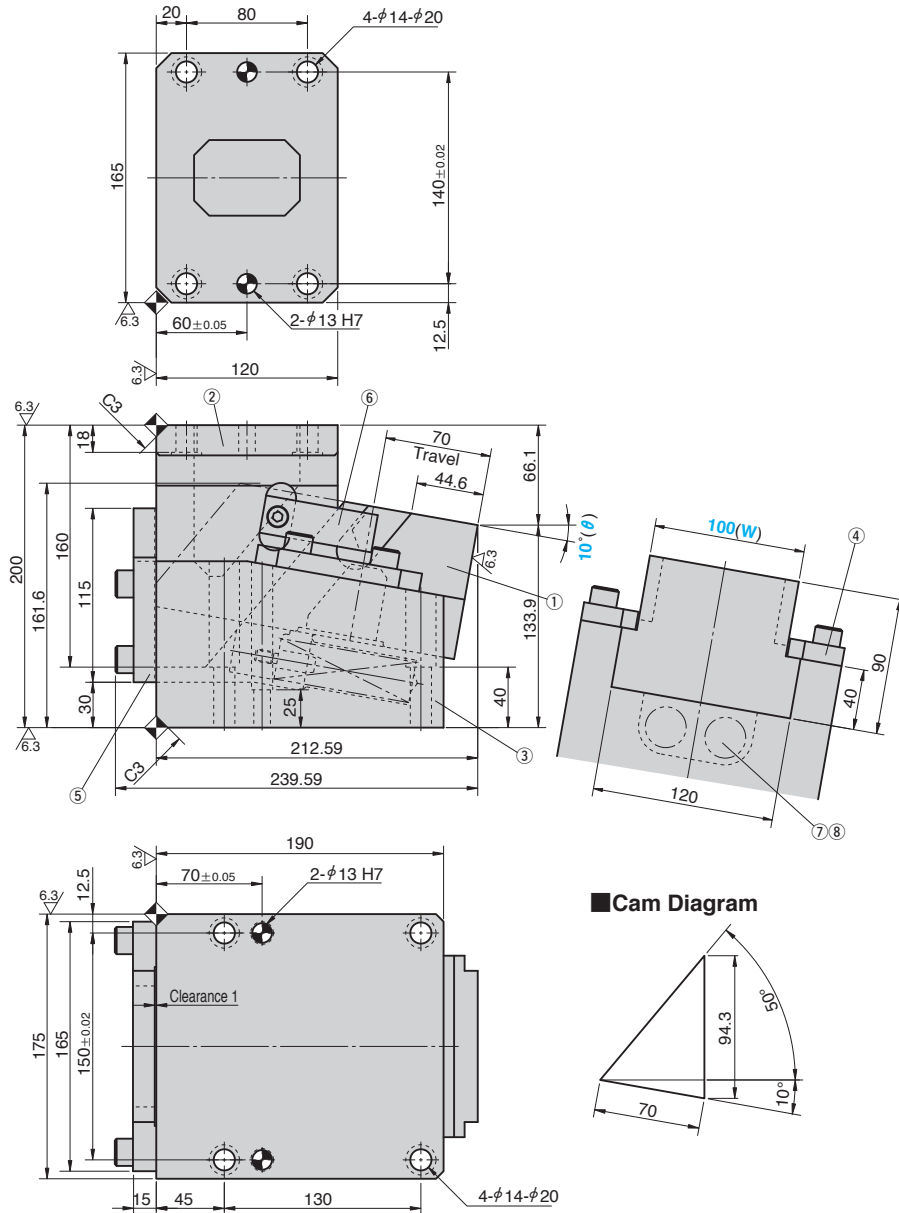


Die Mounted Cam Unit

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Cam Diagram

Working Force kN(tonf)		Spring Force N(kgf)		Slider Weight kg	Total Weight kg	Catalog No.	W	θ	Travel S
1,000,000 strokes	300,000 strokes	Initial Load	Final Load						
39.2 (4.0)	78.4 (8.0)	195.2 (20.0)	1137.4 (116.6)	10.0	38.0	SKCA	100	10	70



Order

Catalog No.	W	θ	S
SKCA	100	10	70



Option

Option Code	Specification
N12	φ12mm dowel holes provided on holder.

See page 389 for specifications of tapped and dowel pin holes for mounting a retainer.

Table of Components

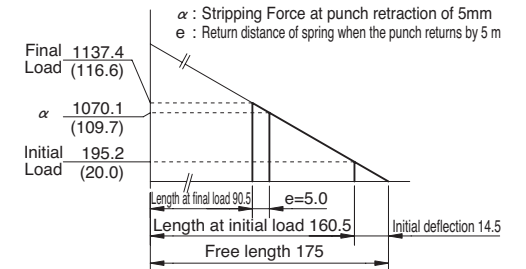
No.	Description	Qty	Material and Remark
①	Cam Slider	1	FC250 with Graphite
②	Cam Driver	1	FC250 with Graphite
③	Cam Holder	1	FC250
④	Upper Plate	2	S45C Copper Powder Sintered
⑤	Stopper Plate	1	SS400(1020)
⑥	Positive Return Follower	2	S45C(1045)
⑦	Spring Guide Pin	2	φ12×40
⑧	Coil Spring	2	TF27-175

Bolts for assembly are not indicated.

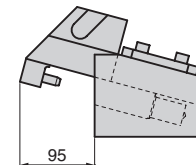
Spring Diagram

(Stripping Force at punch retraction of 5mm)

- Spring used TF27-175 (2 pieces)
- Spring constant 6.73N/mm (0.69kgf/mm)
- Spring life expectancy 300,000 strokes



Space for removing

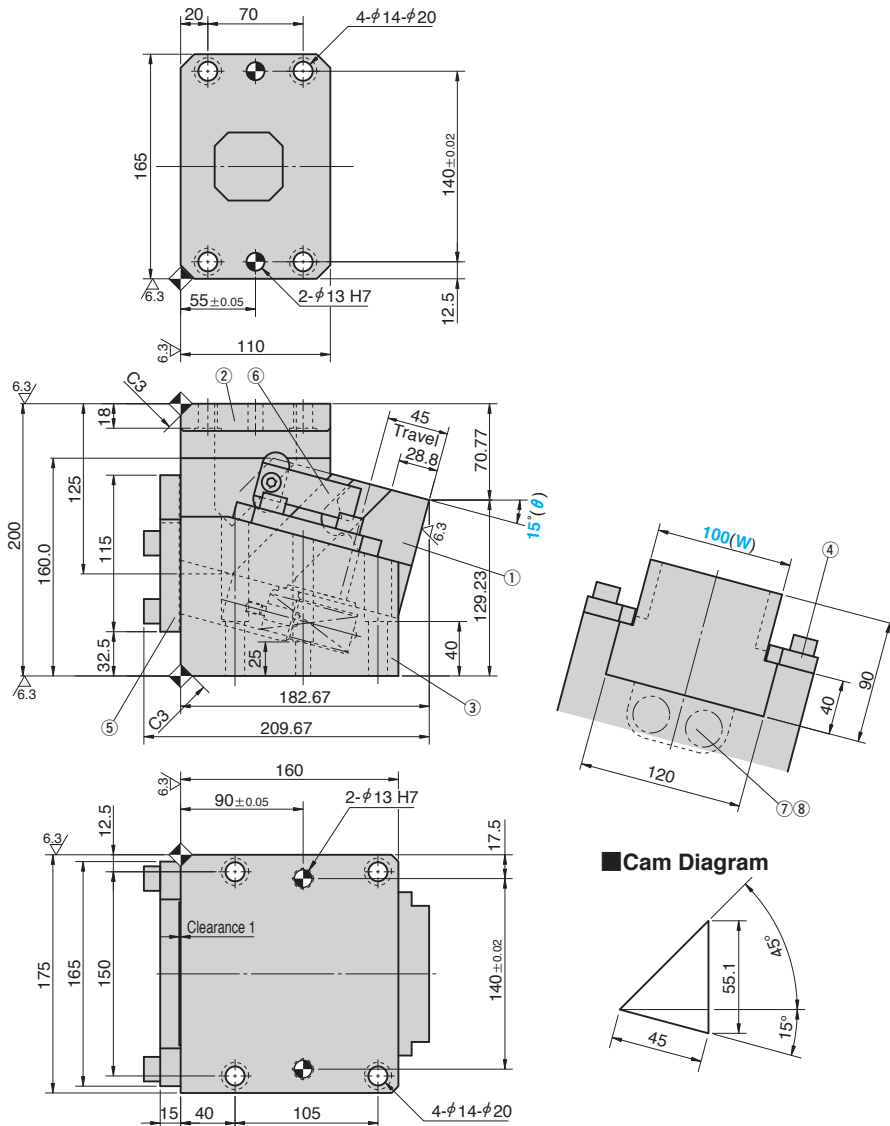


Die Mounted Cam Unit

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Cam Diagram

Working Force kN(tonf)		Spring Force N(kgf)		Slider Weight kg	Total Weight kg	Catalog No.	W	θ	Travel S
1,000,000 strokes	300,000 strokes	Initial Load	Final Load						
39.2 (4.0)	78.4 (8.0)	263.8 (26.9)	1111.6 (113.3)	7.0	33.0	SKCA	100	15	45



Order

Catalog No.	W	θ	S
SKCA	100	15	45



Option

Option Code	Specification
N12	φ12mm dowel holes provided on holder.

See page 389 for specifications of tapped and dowel pin holes for mounting a retainer.

Table of Components

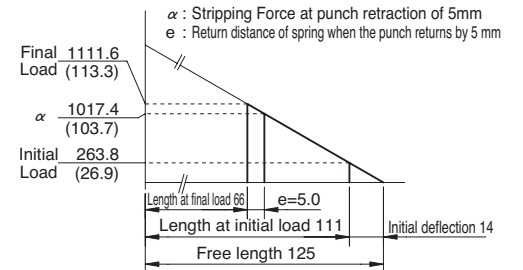
No.	Description	Qty	Material and Remark
①	Cam Slider	1	FC250 with Graphite
②	Cam Driver	1	FC250 with Graphite
③	Cam Holder	1	FC250
④	Upper Plate	2	S45C Copper Powder Sintered
⑤	Stopper Plate	1	SS400(1020)
⑥	Positive Return Follower	2	S45C(1045)
⑦	Spring Guide Pin	2	φ12×40
⑧	Coil Spring	2	TF27-125

Bolts for assembly are not indicated.

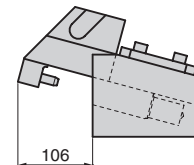
Spring Diagram

(Stripping Force at punch retraction of 5mm)

- Spring used TF27-125 (2 pieces)
- Spring constant 9.42N/mm (0.96kgf/mm)
- Spring life expectancy 300,000 strokes



Space for removing

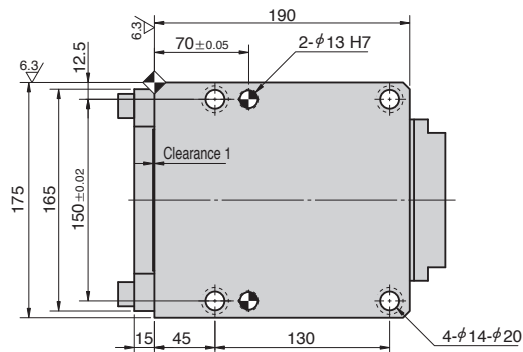
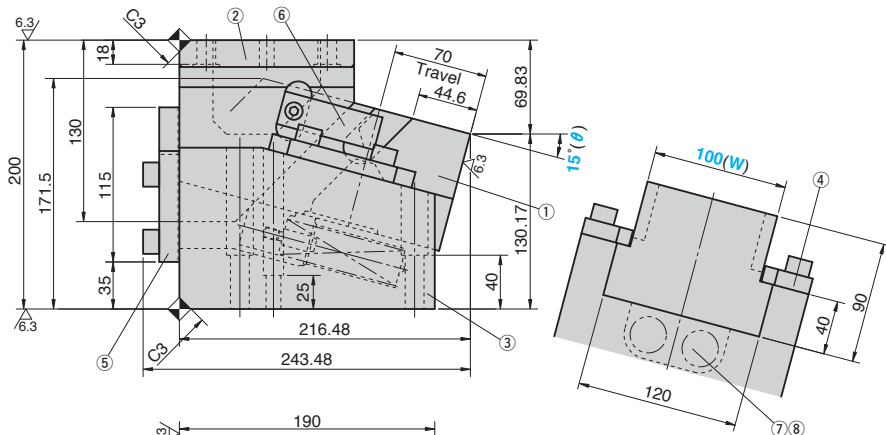
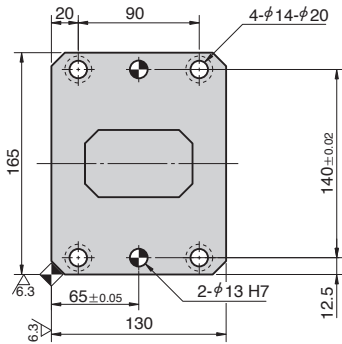


Die Mounted Cam Unit

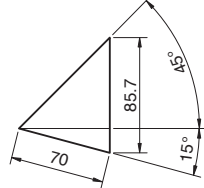
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SKCA100 - 15 - 70



Cam Diagram



Working Force kN(tonf)		Spring Force N(kgf)		Slider Weight kg	Total Weight kg	Catalog No.	W	θ	Travel S
1,000,000 strokes	300,000 strokes	Initial Load	Final Load						
39.2 (4.0)	78.4 (8.0)	195.2 (20.0)	1137.4 (116.6)	10.0	38.0	SKCA	100	15	70



Order

Catalog No.	W	θ	S
SKCA	100	15	70



Option

Option Code	Specification
N12	φ12mm dowel holes provided on holder.

See page 389 for specifications of tapped and dowel pin holes for mounting a retainer.

Table of Components

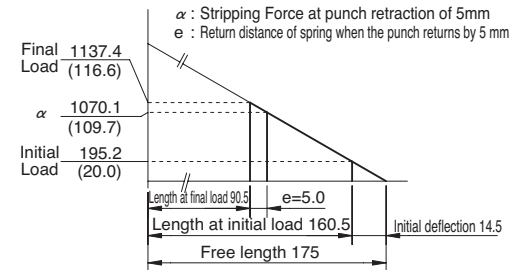
No.	Description	Qty	Material and Remark
①	Cam Slider	1	FC250 with Graphite
②	Cam Driver	1	FC250 with Graphite
③	Cam Holder	1	FC250
④	Upper Plate	2	S45C Copper Powder Sintered
⑤	Stopper Plate	1	SS400(1020)
⑥	Positive Return Follower	2	S45C(1045)
⑦	Spring Guide Pin	2	φ12×40
⑧	Coil Spring	2	TF27-175

Bolts for assembly are not indicated.

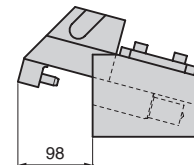
Spring Diagram

(Stripping Force at punch retraction of 5mm)

- Spring used TF27-175 (2 pieces)
- Spring constant 6.73N/mm (0.69kgf/mm)
- Spring life expectancy 300,000 strokes



Space for removing

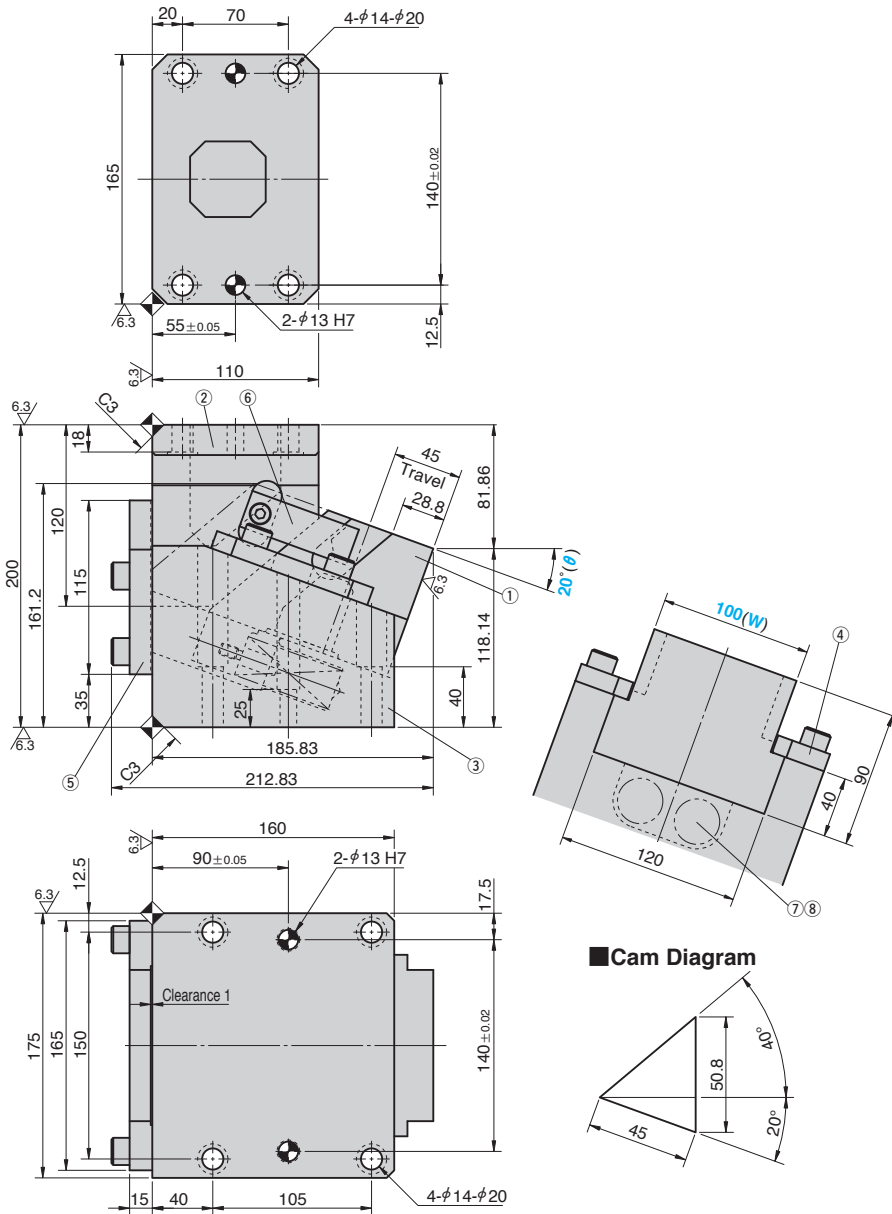


Die Mounted Cam Unit

FOR PIERCE AND FLANGE

CAD
FILE

SKCA100 - 20 - 45



Working Force kN(tonf)		Spring Force N(kgf)		Slider Weight kg	Total Weight kg	Catalog No.	W	θ	Travel S
1,000,000 strokes	300,000 strokes	Initial Load	Final Load						
39.2 (4.0)	78.4 (8.0)	263.8 (26.9)	1111.6 (113.3)	7.0	32.0	SKCA	100	20	45

Order **Catalog No.** SKCA **W** 100 **θ** 20 **S** 45

Option **Option Code** N12 **Specification** φ12mm dowel holes provided on holder.

See page 389 for specifications of tapped and dowel pin holes for mounting a retainer.

Table of Components

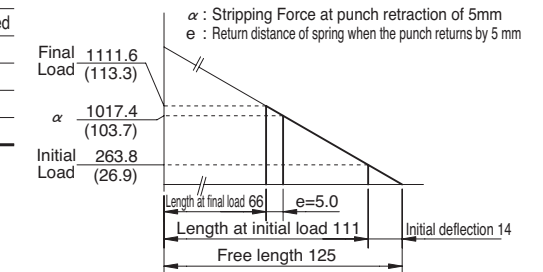
No.	Description	Qty	Material and Remark
①	Cam Slider	1	FC250 with Graphite
②	Cam Driver	1	FC250 with Graphite
③	Cam Holder	1	FC250
④	Upper Plate	2	S45C Copper Powder Sintered
⑤	Stopper Plate	1	SS400(1020)
⑥	Positive Return Follower	2	S45C(1045)
⑦	Spring Guide Pin	2	φ12×40
⑧	Coil Spring	2	TF27-125

Bolts for assembly are not indicated.

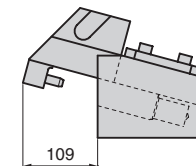
Spring Diagram

(Stripping Force at punch retraction of 5mm)

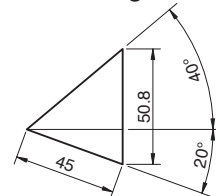
- Spring used TF27-125 (2 pieces)
- Spring constant 9.42N/mm (0.96kgf/mm)
- Spring life expectancy 300,000 strokes



Space for removing



Cam Diagram

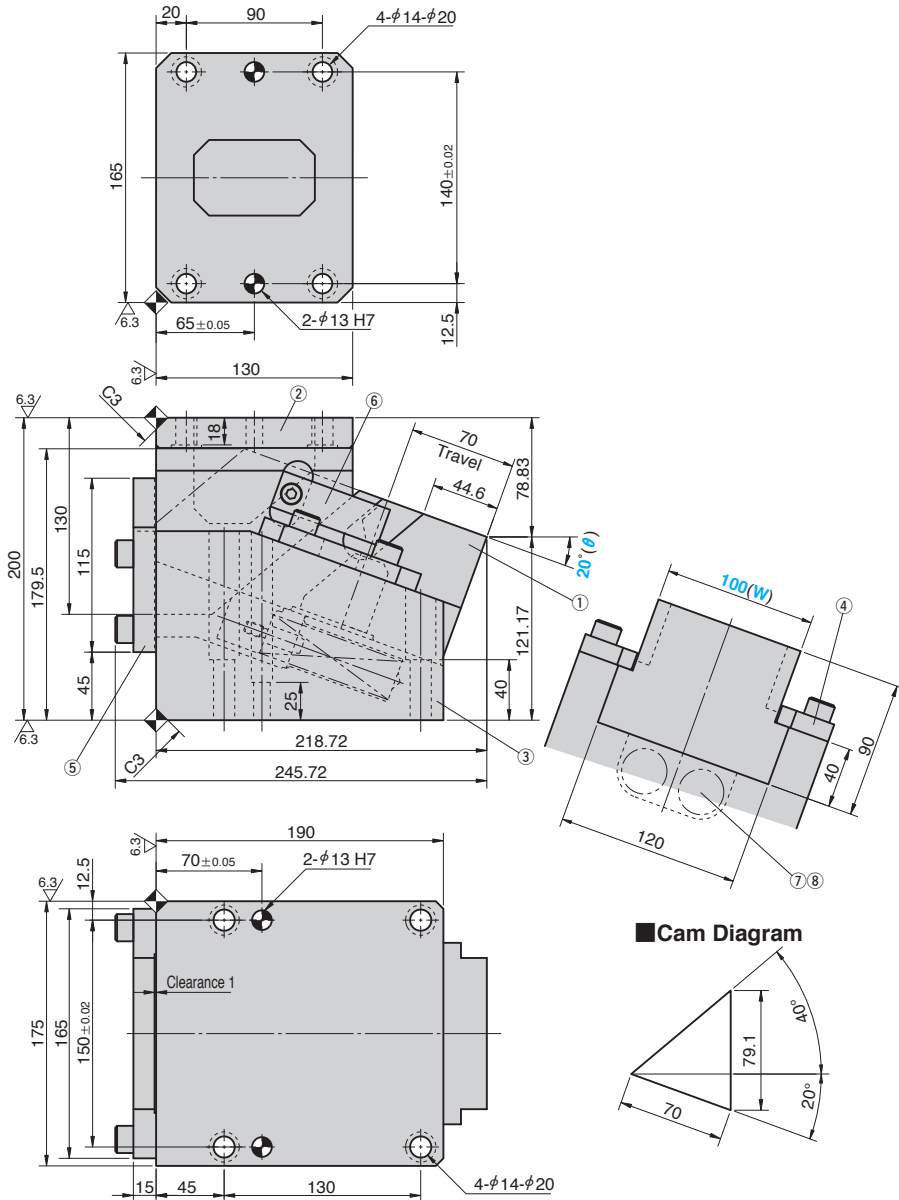


Die Mounted Cam Unit

FOR PIERCE AND FLANGE

CAD
FILE

SKCA100 - 20 - 70



Cam Diagram

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



Order

Catalog No.	W	θ	S
SKCA	100	20	70



Option

Option Code	Specification
N12	φ12mm dowel holes provided on holder.

See page 389 for specifications of tapped and dowel pin holes for mounting a retainer.

Table of Components

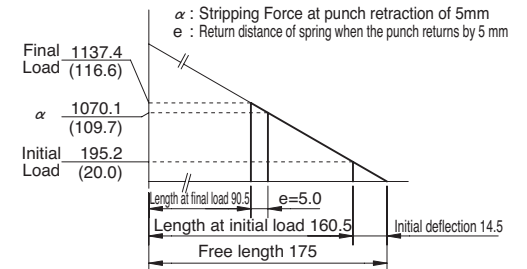
No.	Description	Qty	Material and Remark
①	Cam Slider	1	FC250 with Graphite
②	Cam Driver	1	FC250 with Graphite
③	Cam Holder	1	FC250
④	Upper Plate	2	S45C Copper Powder Sintered
⑤	Stopper Plate	1	SS400(1020)
⑥	Positive Return Follower	2	S45C(1045)
⑦	Spring Guide Pin	2	φ12×40
⑧	Coil Spring	2	TF27-175

Bolts for assembly are not indicated.

Spring Diagram

(Stripping Force at punch retraction of 5mm)

- Spring used TF27-175 (2 pieces)
- Spring constant 6.73N/mm (0.69kgf/mm)
- Spring life expectancy 300,000 strokes



Space for removing

