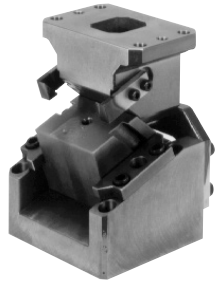


Die Mounted Cam Unit SKCA

Die Mounted Cam Unit

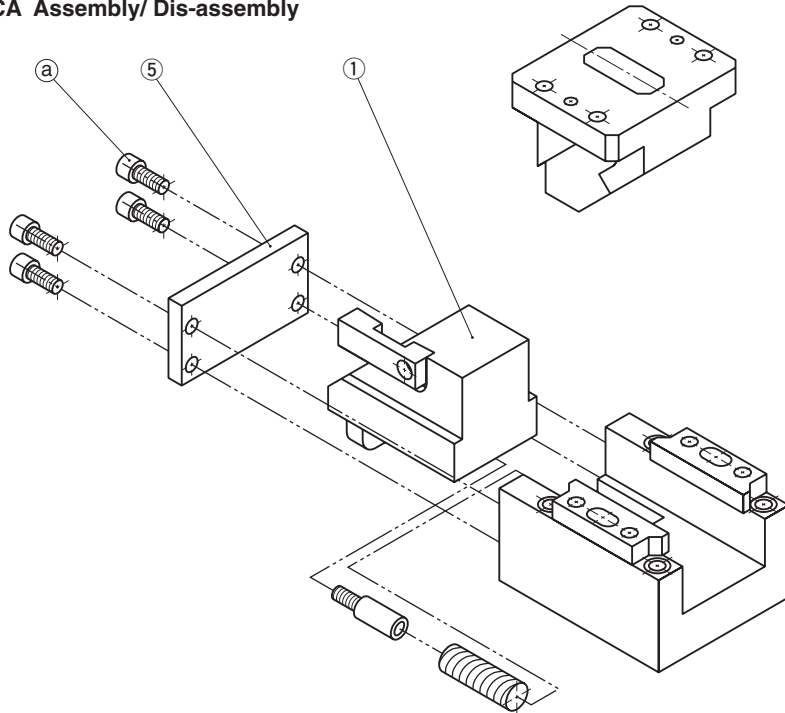


- Mounting surface widths 52, 65, 100, 150, 200, 200, 250, 300 mm
- Working angles from 0° to 20° in 5° increments for the mounting surface widths 65 to 150 mm
- The Box-type holder provides high rigidity

⚠ Gas Spring:

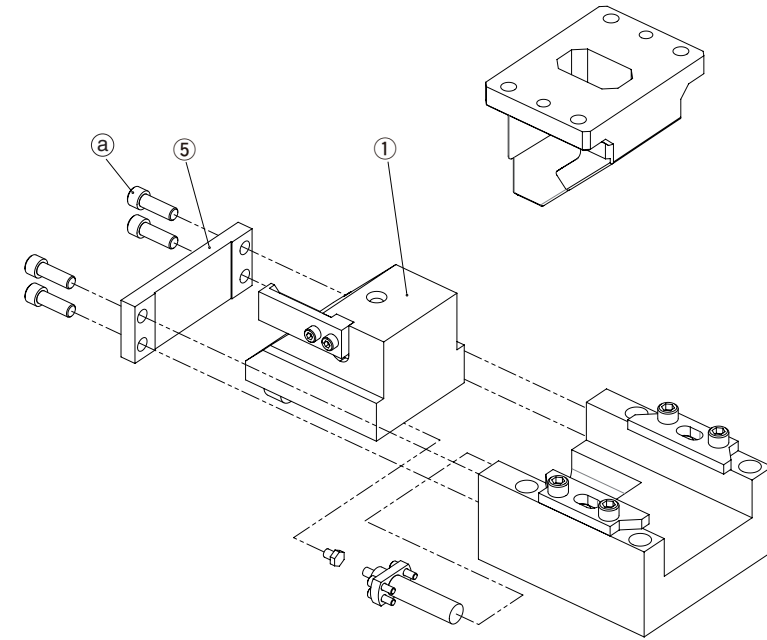
Please contact your local sales representative, if you prefer to use a gas spring not specified in our catalog. For use and maintenance of gas spring, please contact the manufacturer directly.

■ 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:

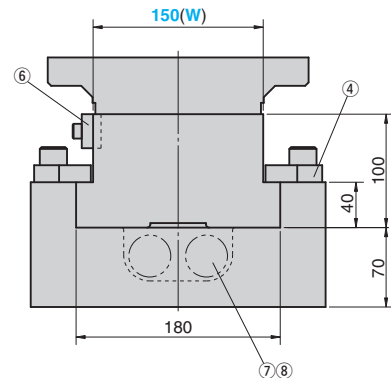
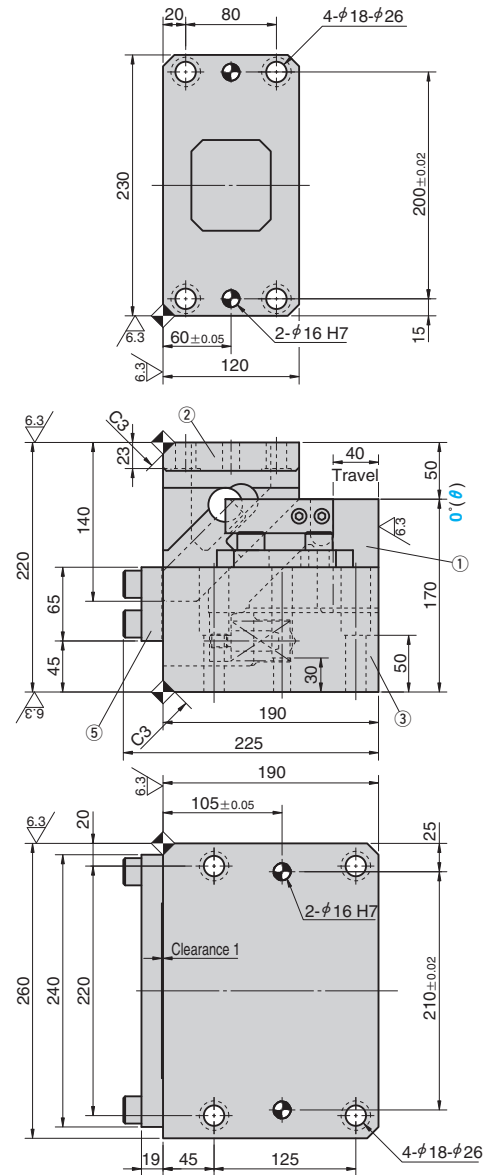
- Ensure that all parts are clean, particularly the sliding components, to which a small amount of grease is applied and is then placed in position.
- Take care that the respective tolerances are observed when assembling the Cam Slider and Cam Holder, which also should be identified by the same serial number.
- All bolts shall be tightened to the recommended torque after assembly and dis-assembly.

Die Mounted Cam Unit

FOR PIERCE AND FLANGE

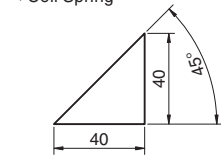
Addition **CAD FILE**

SKCA150-00-40

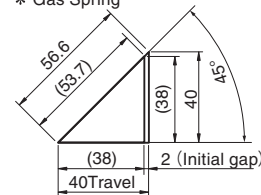


Cam Diagram

*Coil Spring



* Gas Spring



Working Force kN(tonf) 1,000,000 strokes	Spring Force N(kgf) 300,000 strokes	Initial Load		Slider Weight kg	Total Weight kg	Catalog No.	W	θ	Travel S	Spring Type PS
		306.9 (31.4)	1841.3 (188.2)							
58.8 (6.0)	88.2 (9.0)	-	2051 (209.3)	14.3	63.0	SKCA	150	00	40	No code (Coil Spring) GK *NGK GD *NGD GS *NGS

* Parts for spring assembly are included.



Order

Catalog No.	W	θ	S	PS	Option
SKCA	150	00	40	GK	
SKCA	150	00	40	NGK	
SKCA	150	00	40	GK	NF

...Without gas spring.



Option

Option Code	Specification
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	-	TF35-100	2	Coil Spring
	GK	M2-50-Red	1	Gas Spring (KALLER)
	GD	C.180.050.BK.135	1	Gas Spring (DADCO)
	GS	SFNA.150.50	1	Gas Spring (SDT)

*Gas filling pressure : 13.5MPa

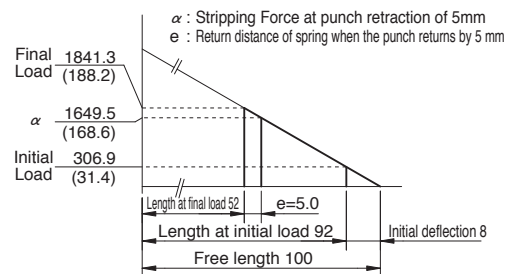
Table of Components

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	φ18×60 Coil Spring specification only
⑦	Mounting Plate	1	Gas Spring specification only
⑧	Spring	-	Refer to the Spring Specification table.
⑩	Stop Pin	1	Gas Spring specification only

Spring Diagram

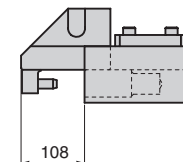
(Stripping Force at punch retraction of 5mm)

- Spring used TF35-100 (2 pieces)
- Spring constant 19.18N/mm (1.96kgf/mm)
- Spring life expectancy 300,000 strokes



Bolts for assembly are not indicated.

Space for removing

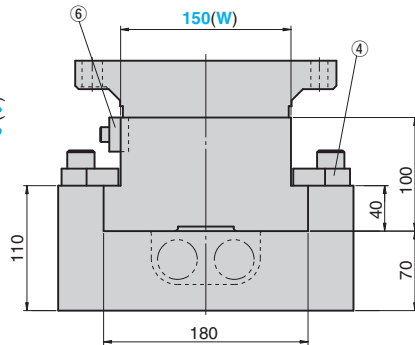
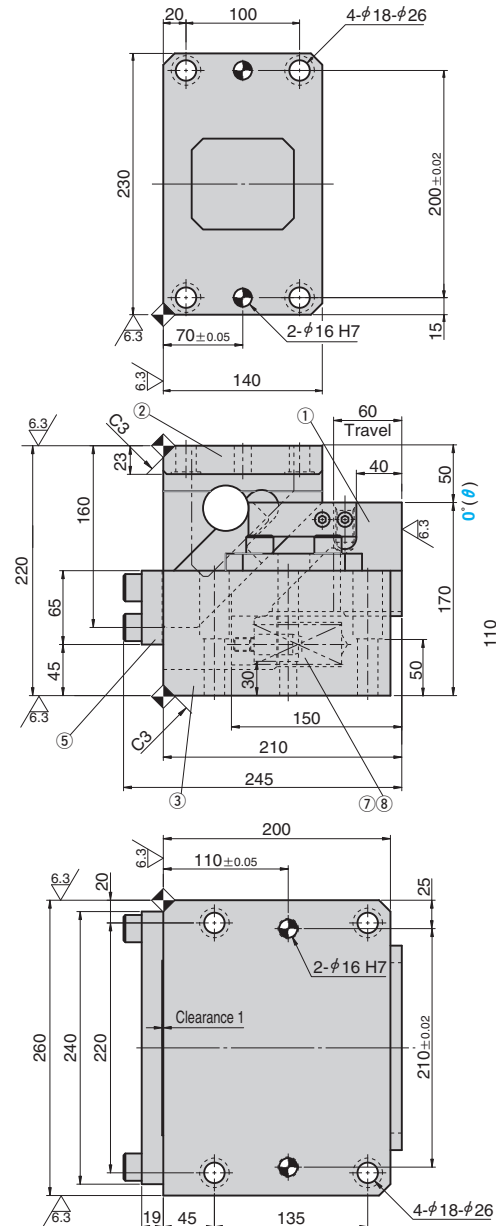


Die Mounted Cam Unit

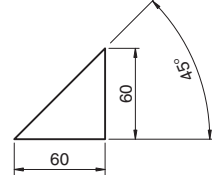
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FILE

SKCA150 - 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						
58.8 (6.0)	88.2 (9.0)	332.5 (33.8)	14.3	69.0	SKCA	150	00	60



Order

Catalog No.	W	θ	S
SKCA	150	00	60



Option

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	φ18×60
⑧	Coil Spring	2	TF35-150

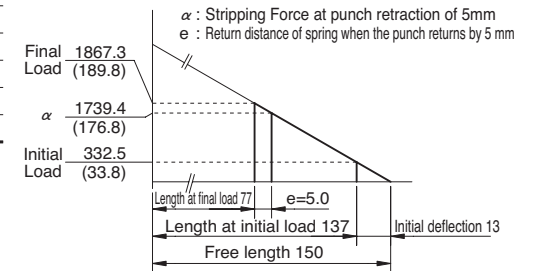


Bolts for assembly are not indicated.

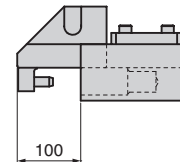
Spring Diagram

(Stripping Force at punch retraction of 5mm)

- Spring used TF35-150 (2 pieces)
- Spring constant 12.79N/mm (1.30kgf/mm)
- Spring life expectancy 300,000 strokes



Space for removing

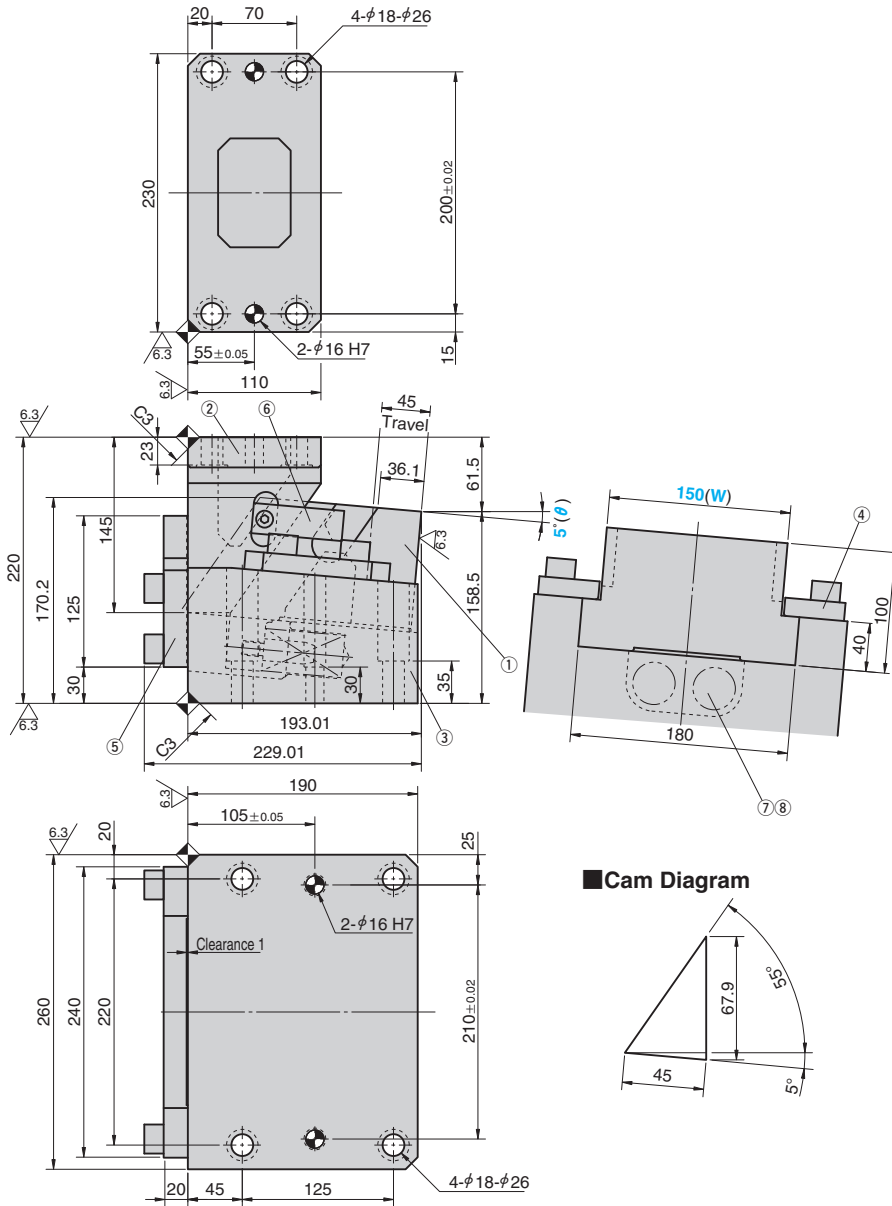


Die Mounted Cam Unit

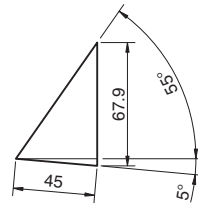
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FILE

SKCA150 - 05 - 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
64.7 (6.6)	98.0 (10.0)	429.5 (43.7)	1810.1 (184.1)	16.0	62.0	SKCA	150	05	45



Order

Catalog No.	W	θ	S
SKCA	150	05	45



Option

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	φ18×60
⑧	Coil Spring	2	TF35-125

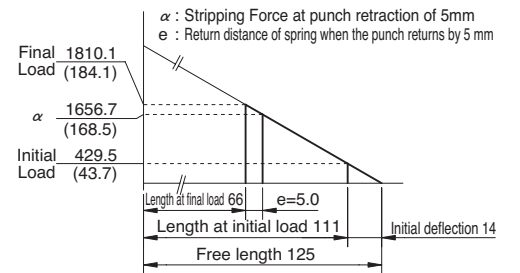


Bolts for assembly are not indicated.

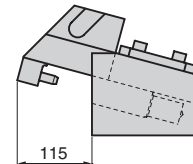
Spring Diagram

(Stripping Force at punch retraction of 5mm)

- Spring used TF35-125 (2 pieces)
- Spring constant 15.34N/mm (1.56kgf/mm)
- Spring life expectancy 300,000 strokes



Space for removing

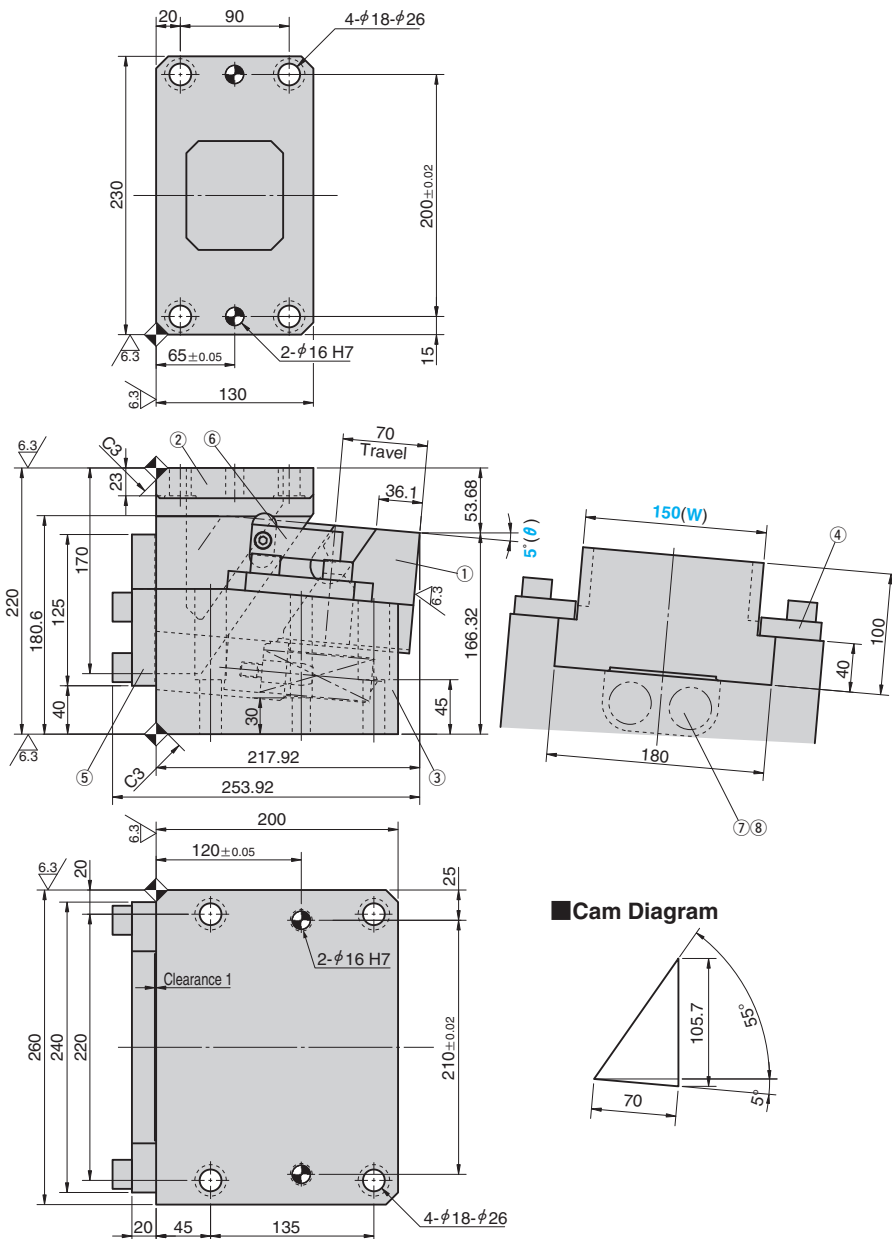


Die Mounted Cam Unit

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SKCA150 - 05 - 70



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						
64.7 (6.6)	98.0 (10.0)	306.9 (31.4)	1841.3 (188.2)	16.0	73.0	SKCA	150	05	70

Order **Catalog No.** SKCA **W** 150 **θ** 05 **S** 70

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

Table of Components

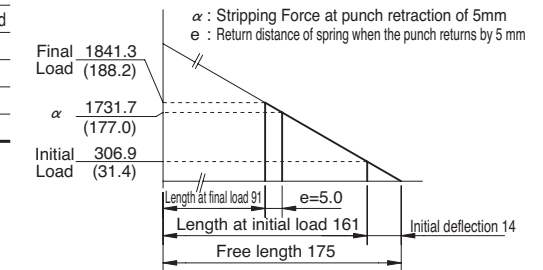
No.	Description	Qty	Material and Remark
①	Cam Slider	1	FC250 with Graphite
②	Cam Driver	1	FC250 with Graphite
③	Cam Holder	1	FC250
④	Upper Plate	2	S45C Copper Powder Sintered
⑤	Stopper Plate	1	SS400(1020)
⑥	Positive Return Follower	2	S45C(1045)
⑦	Spring Guide Pin	2	φ18×60
⑧	Coil Spring	2	TF35-175

⚠ Bolts for assembly are not indicated.

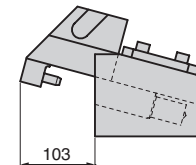
Spring Diagram

(Stripping Force at punch retraction of 5mm)

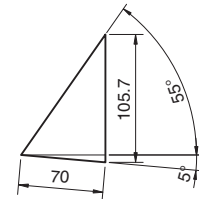
- Spring used TF35-175 (2 pieces)
- Spring constant 10.96N/mm (1.12kgf/mm)
- Spring life expectancy 300,000 strokes



Space for removing



Cam Diagram

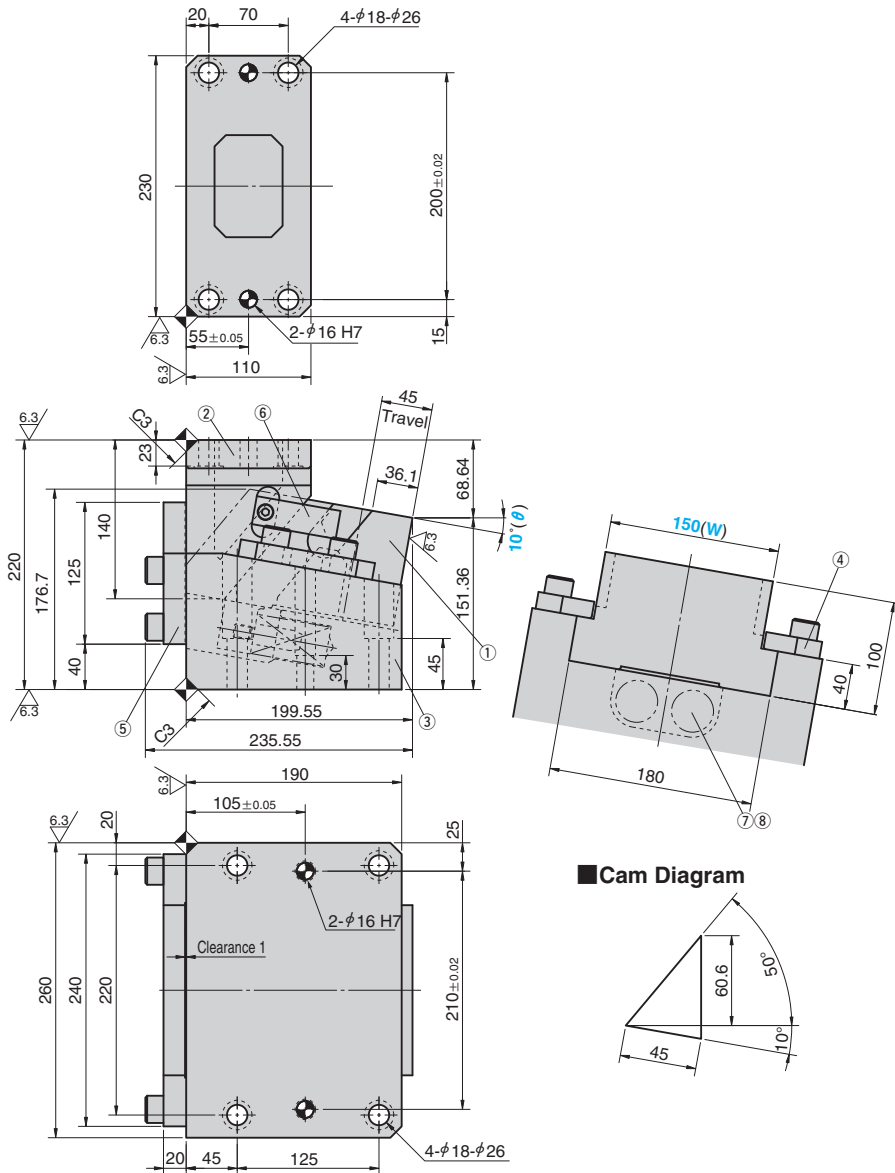


Die Mounted Cam Unit

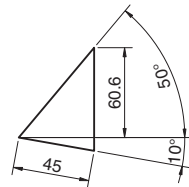
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CAD FILE

SKCA150 - 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						
64.7 (6.6)	98.0 (10.0)	429.5 (43.7)	1810.1 (184.1)	16.0	63.0	SKCA	150	10	45



Order

Catalog No.	W	θ	S
SKCA	150	10	45



Option

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	φ18×60
⑧	Coil Spring	2	TF35-125

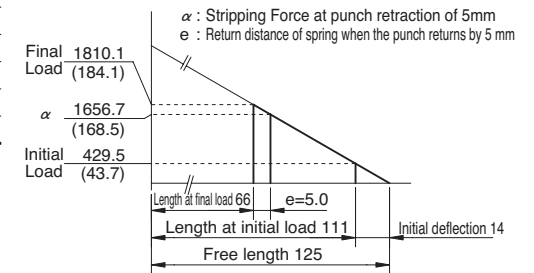


Bolts for assembly are not indicated.

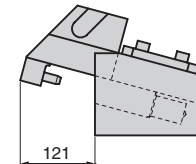
Spring Diagram

(Stripping Force at punch retraction of 5mm)

- Spring used TF35-125 (2 pieces)
- Spring constant 15.34N/mm (1.56kgf/mm)
- Spring life expectancy 300,000 strokes



Space for removing

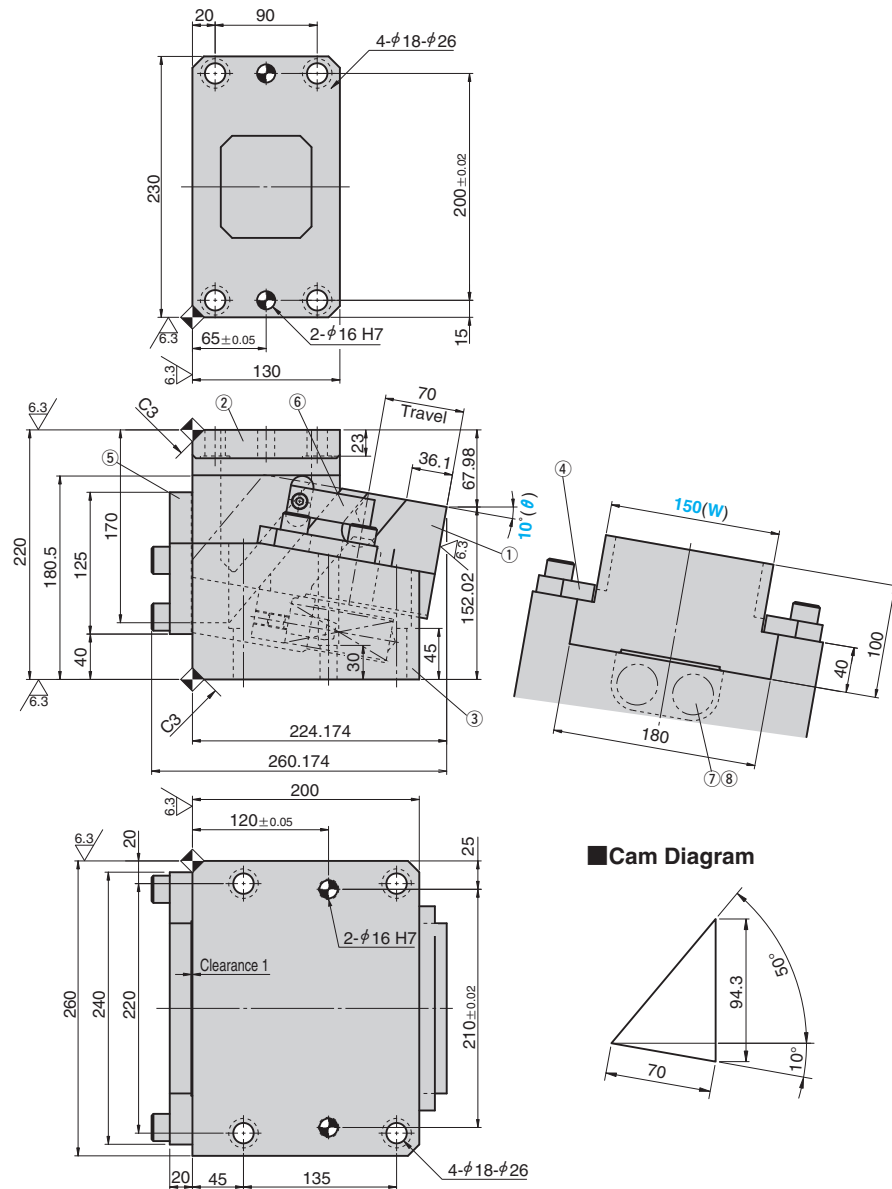


Die Mounted Cam Unit

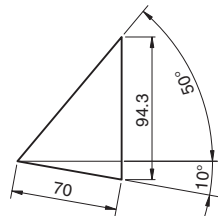
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FILE

SKCA150 - 10 - 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						
64.7 (6.6)	98.0 (10.0)	306.9 (31.4)	1841.3 (188.2)	16.0	73.0	SKCA	150	10	70



Order

Catalog No.	W	θ	S
SKCA	150	10	70



Option

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	φ18×60
⑧	Coil Spring	2	TF35-175

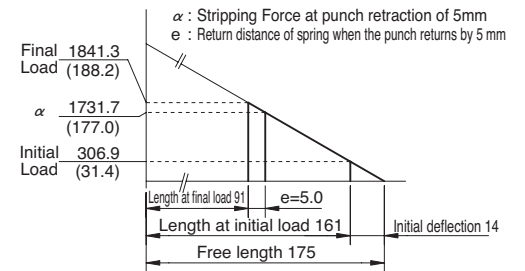


Bolts for assembly are not indicated.

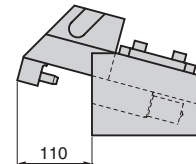
Spring Diagram

(Stripping Force at punch retraction of 5mm)

- Spring used TF35-175 (2 pieces)
- Spring constant 10.96N/mm (1.12kgf/mm)
- Spring life expectancy 300,000 strokes



Space for removing

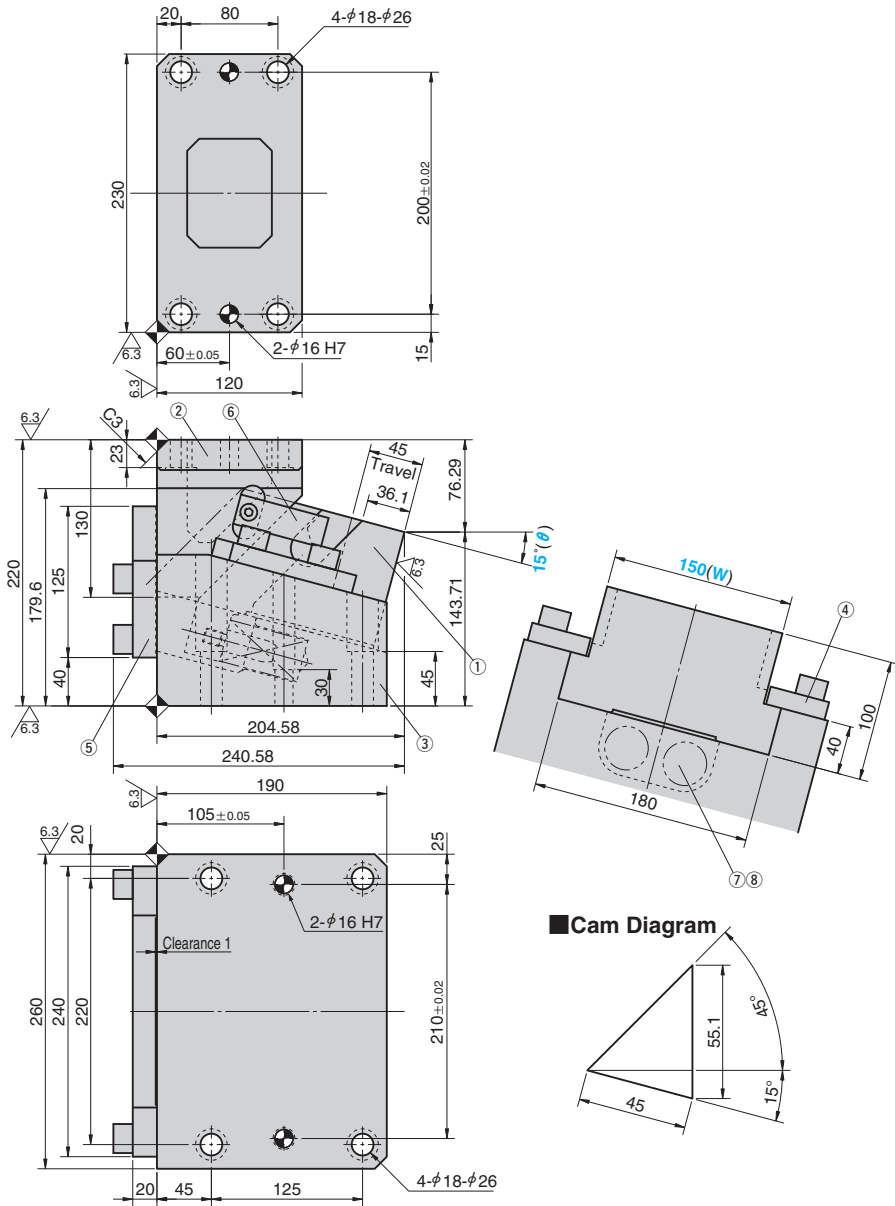


Die Mounted Cam Unit

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CAD FILE

SKCA150 - 15 - 45



Working Force kN(tonf) 1,000,000 strokes	Spring Force N(kgf) 300,000 strokes	Initial Load		Slider Weight kg	Total Weight kg	Catalog No.	W	θ	Travel S
		Initial Load	Final Load						
64.7 (6.6)	98.0 (10.0)	429.5 (43.7)	1810.1 (184.1)	16.0	65.0	SKCA	150	15	45

Order **Catalog No.** SKCA **W** 150 **θ** 15 **S** 45

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

Table of Components

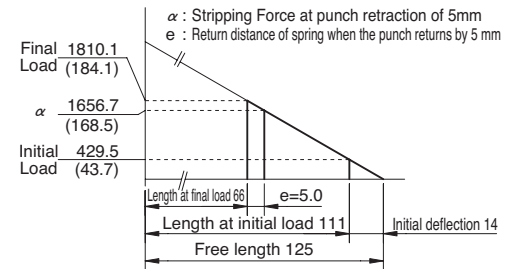
No.	Description	Qty	Material and Remark
①	Cam Slider	1	FC250 with Graphite
②	Cam Driver	1	FC250 with Graphite
③	Cam Holder	1	FC250
④	Upper Plate	2	S45C Copper Powder Sintered
⑤	Stopper Plate	1	SS400(1020)
⑥	Positive Return Follower	2	S45C(1045)
⑦	Spring Guide Pin	2	φ18×60
⑧	Coil Spring	2	TF35-125

⚠ Bolts for assembly are not indicated.

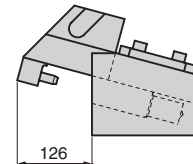
Spring Diagram

(Stripping Force at punch retraction of 5mm)

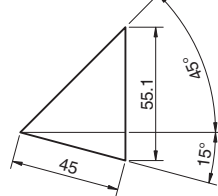
- Spring used TF35-125 (2 pieces)
- Spring constant 15.34N/mm (1.56kgf/mm)
- Spring life expectancy 300,000 strokes



Space for removing



Cam Diagram

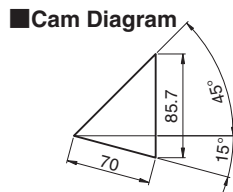
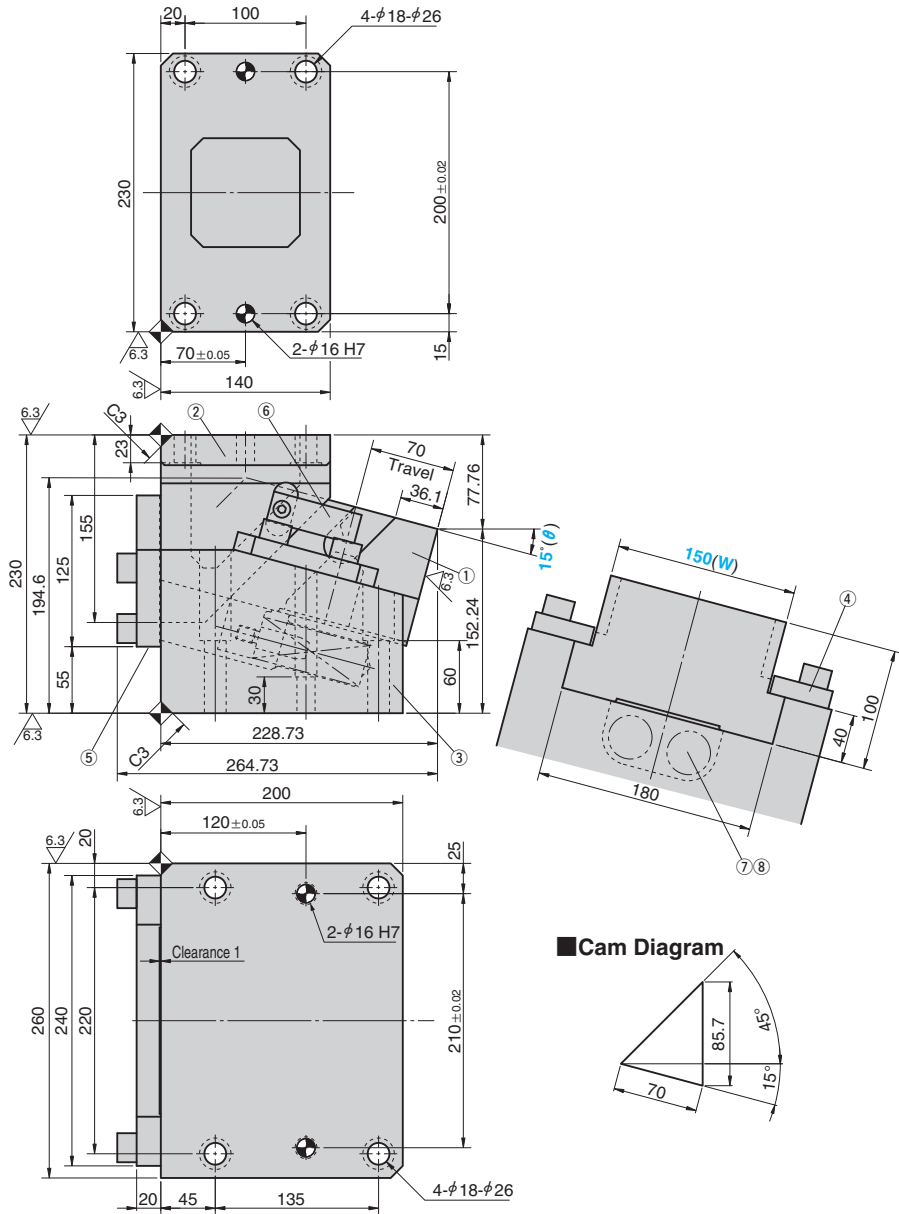


Die Mounted Cam Unit

FOR PIERCE AND FLANGE

CAD
FILE

SKCA150 - 15 - 70



Working Force kN(tonf) 1,000,000 strokes	Spring Force N(kgf) 300,000 strokes	Slider		Total Weight kg	Catalog No.	W	θ	Travel S	
		Initial Load	Final Load						
64.7 (6.6)	98.0 (10.0)	306.9 (31.4)	1841.3 (188.2)	16.0	77.0	SKCA	150	15	70



Order

Catalog No. **SKCA** W **150** - θ **15** - S **70**



Option

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	φ18×60
⑧	Coil Spring	2	TF35-175

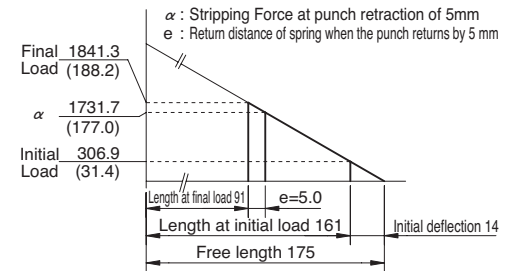


Bolts for assembly are not indicated.

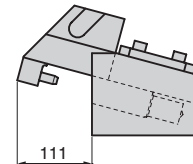
■ Spring Diagram

(Stripping Force at punch retraction of 5mm)

- Spring used TF35-175 (2 pieces)
- Spring constant 10.96N/mm (1.12kgf/mm)
- Spring life expectancy 300,000 strokes



■ Space for removing

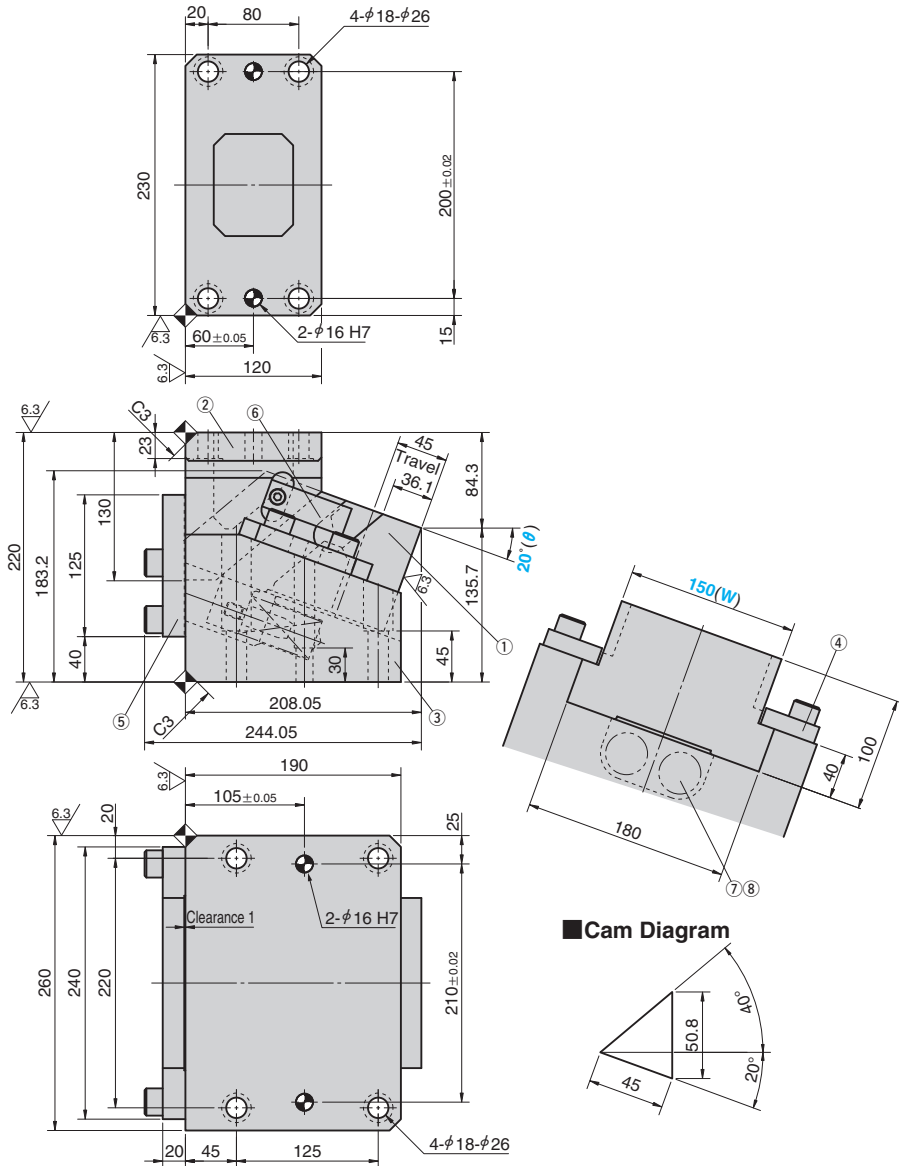


Die Mounted Cam Unit

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CAD
FILE

SKCA150-20-45



Working Force kN(tonf) 1,000,000 strokes	Spring Force N(kgf) 300,000 strokes	Spring Force N(kgf)		Slider Weight kg	Total Weight kg	Catalog No.	W	θ	Travel S
		Initial Load	Final Load						
64.7 (6.6)	98.0 (10.0)	429.5 (43.7)	1810.1 (184.1)	16.0	66.0	SKCA	150	20	45

Order **Catalog No.** SKCA **W** 150 **θ** 20 **S** 45

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

Table of Components

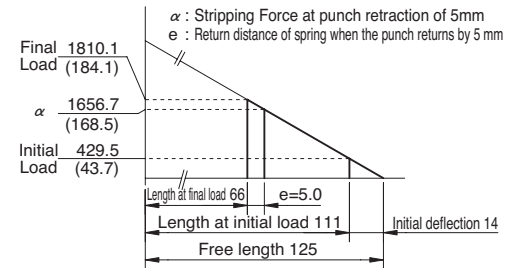
No.	Description	Qty	Material and Remark
①	Cam Slider	1	FC250 with Graphite
②	Cam Driver	1	FC250 with Graphite
③	Cam Holder	1	FC250
④	Upper Plate	2	S45C Copper Powder Sintered
⑤	Stopper Plate	1	SS400(1020)
⑥	Positive Return Follower	2	S45C(1045)
⑦	Spring Guide Pin	2	φ18×60
⑧	Coil Spring	2	TF35-125

⚠ Bolts for assembly are not indicated.

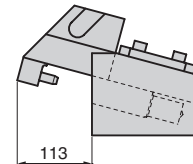
Spring Diagram

(Stripping Force at punch retraction of 5mm)

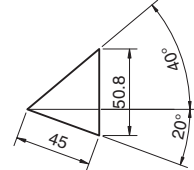
- Spring used TF35-125 (2 pieces)
- Spring constant 15.34N/mm (1.56kgf/mm)
- Spring life expectancy 300,000 strokes



Space for removing



Cam Diagram

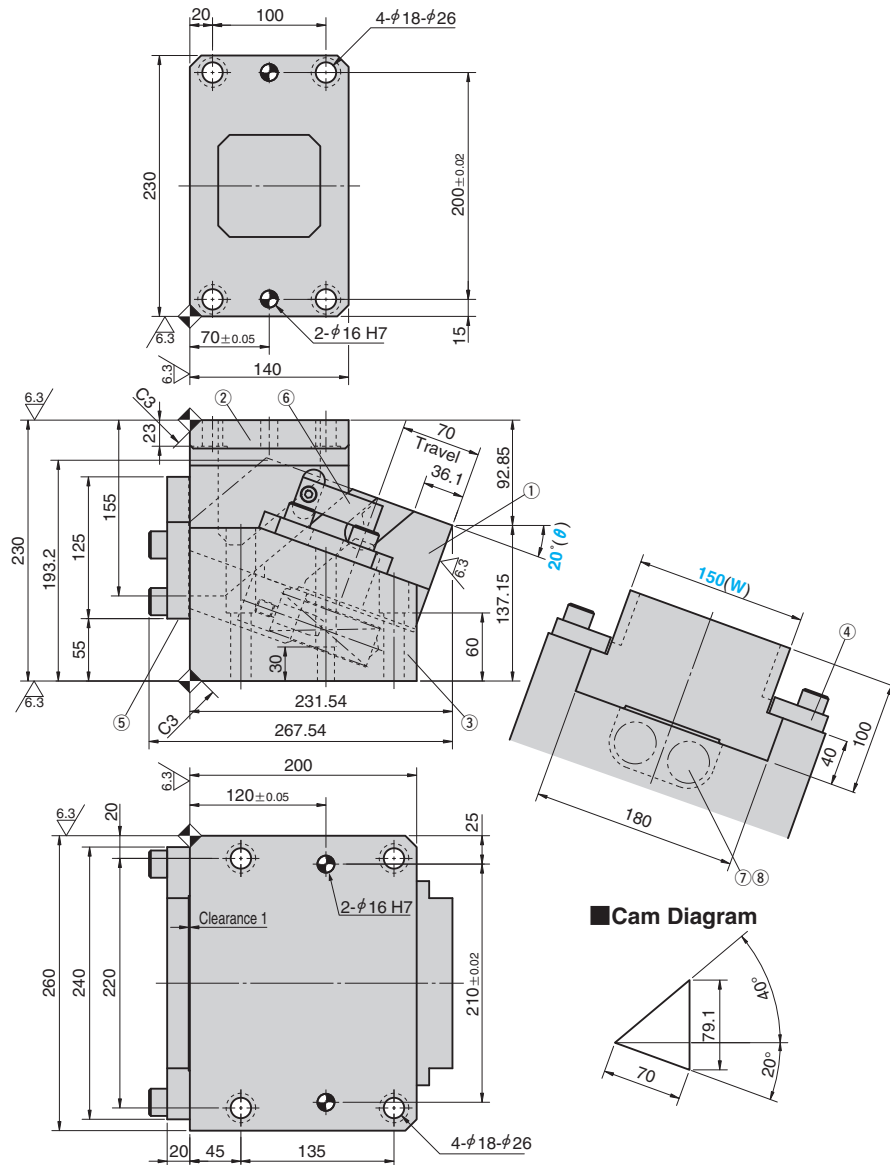


Die Mounted Cam Unit

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CAD
FILE

SKCA150 - 20 - 70



Cam Diagram

Working Force kN(tonf) 1,000,000 strokes	Spring Force N(kgf) 300,000 strokes	Slider		Total Weight kg	Catalog No.	W	θ	Travel S	
		Initial Load	Final Load						
64.7 (6.6)	98.0 (10.0)	306.9 (31.4)	1841.3 (188.2)	16.0	75.0	SKCA	150	20	70



Order

Catalog No.	W	θ	S
SKCA	150	20	70



Option

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	φ18×60
⑧	Coil Spring	2	TF35-175

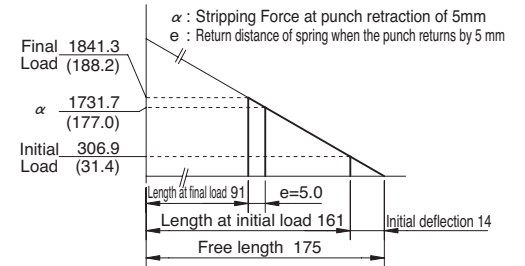


Bolts for assembly are not indicated.

Spring Diagram

(Stripping Force at punch retraction of 5mm)

- Spring used TF35-175 (2 pieces)
- Spring constant 10.96N/mm (1.12kgf/mm)
- Spring life expectancy 300,000 strokes



Space for removing

