

# Unità *a camme sospese*

*Aerial cam unit*

*Oben hängende Schieber*



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# INDICE - INDEX - INHALTSVERZEICHNIS

## Unità a camme sospese Aerial cam unit Oben hängende Schieber



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Code	Work force (kN)	Space for punch mount Length (mm)	Width (mm)
CHD050.015.00._			
CHD050.015.05._			
CHD050.015.10._			
CHD050.017.15._			
CHD050.018.20._			
CHD050.018.25._			
CHD050.017.30._	14,7	65	50
CHD050.018.35._			
CHD050.020.40._			
CHD050.022.45._			
CHD050.023.50._			
CHD050.026.55._			
CHD050.031.60._			
CHD050.036.65._			



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Code	Work force (kN)	Space for punch mount Length (mm)	Width (mm)
CHD080.030.00._			
CHD080.030.05._			
CHD080.031.10._			
CHD080.033.15._			
CHD080.032.20._			
CHD080.035.25._			
CHD080.034.30._	39,2	88	80
CHD080.037.35._			
CHD080.039.40._			
CHD080.043.45._			
CHD080.046.50._			
CHD080.053.55._			
CHD080.061.60._			
CHD080.070.65._			



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Code	Working force (kN)	Space for punch mount Length (mm)	Width (mm)
CHD150.028.00._			
CHD150.032.05._			
CHD150.035.10._			
CHD150.039.15._			
CHD150.043.20._			
CHD150.047.25._			
CHD150.052.30._	117,6	120	150
CHD150.057.35._			
CHD150.063.40._			
CHD150.069.45._			
CHD150.077.50._			
CHD150.087.55._			
CHD150.099.60._			
CHD150.116.65._			



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Code	Work force (kN)	Space for punch mount Length (mm)	Width (mm)
CHD180.028.00._			
CHD180.032.05._			
CHD180.035.10._			
CHD180.039.15._			
CHD180.043.20._			
CHD180.047.25._			
CHD180.052.30._	147	120	180
CHD180.057.35._			
CHD180.063.40._			
CHD180.069.45._			
CHD180.077.50._			
CHD180.087.55._			
CHD180.099.60._			
CHD180.116.65._			



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# INDICE - INDEX - INHALTSVERZEICHNIS



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Code	Work force (kN)	Space for punch mount Length (mm)	Width (mm)
CHD200.028.00._			
CHD200.032.05._			
CHD200.035.10._			
CHD200.039.15._			
CHD200.043.20._			
CHD200.047.25._			
CHD200.052.30._	147	120	200
CHD200.057.35._			
CHD200.063.40._			
CHD200.069.45._			
CHD200.077.50._			
CHD200.087.55._			
CHD200.099.60._			
CHD200.116.65._			



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Code	Work force (kN)	Space for punch mount Length (mm)	Width (mm)
CHD250.028.00._			
CHD250.032.05._			
CHD250.035.10._			
CHD250.039.15._			
CHD250.043.20._			
CHD250.047.25._			
CHD250.052.30._	294	160	250
CHD250.057.35._			
CHD250.063.40._			
CHD250.069.45._			
CHD250.077.50._			
CHD250.087.55._			
CHD250.099.60._			
CHD250.116.65._			



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Code	Work force (kN)	Space for punch mount Length (mm)	Width (mm)
CHD300.028.00._			
CHD300.032.05._			
CHD300.035.10._			
CHD300.039.15._			
CHD300.043.20._			
CHD300.047.25._			
CHD300.052.30._	294	160	300
CHD300.057.35._			
CHD300.063.40._			
CHD300.069.45._			
CHD300.077.50._			
CHD300.087.55._			
CHD300.099.60._			
CHD300.116.65._			

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**NOTE TECNICHE**  
**TECHNICAL NOTICE**  
**TECHNISCHE INFORMATIONEN**

Example for order:

Cam heavy duty	<b>CHD</b>
Mounting face width	<b>180</b>
Slide stroke	<b>063</b>
Shearing angle	<b>40</b>
Standard key M; Optional key W	<b>M</b>

CODE

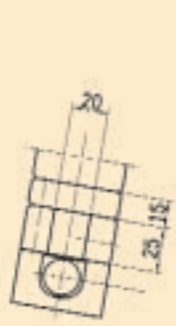
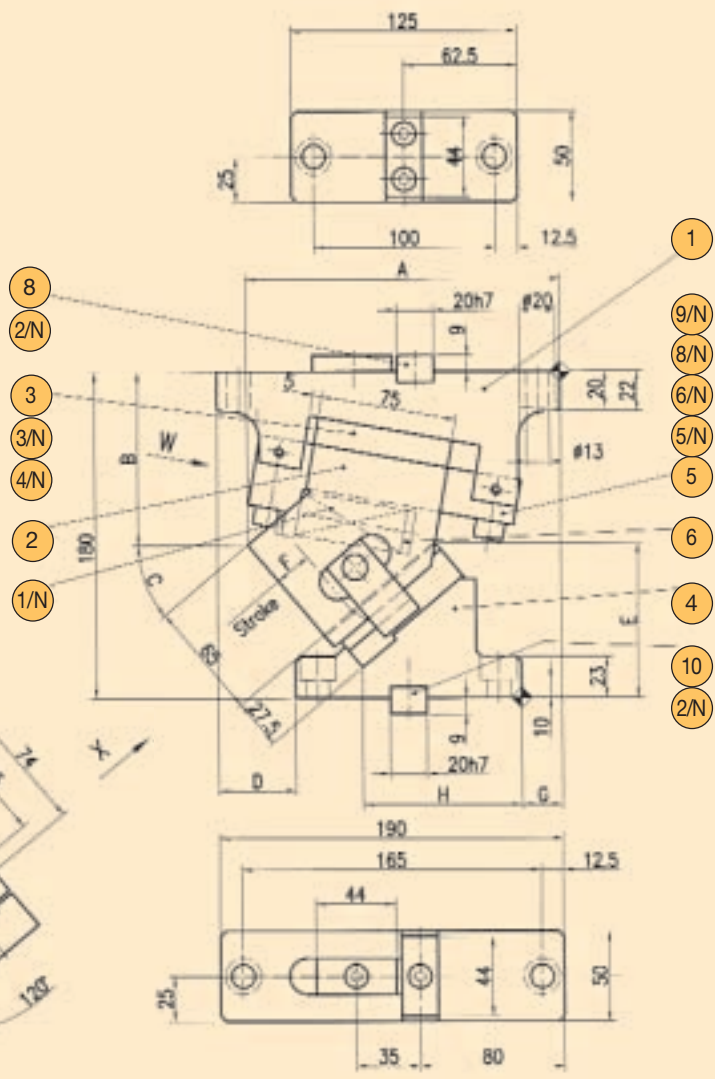
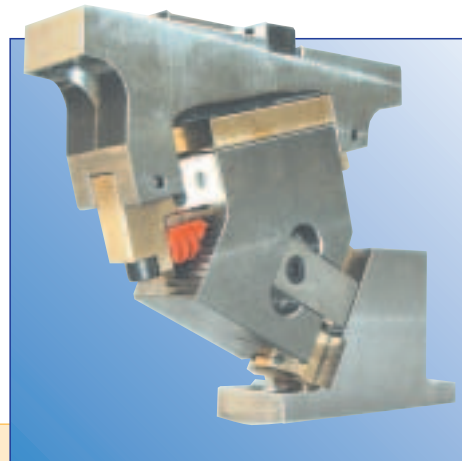
**CHD180.063.40.M**



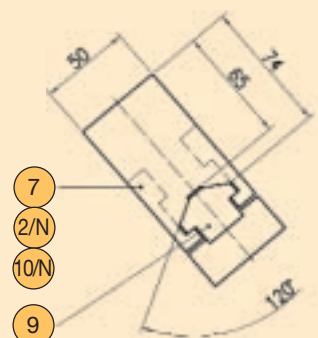
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Unità a camme sospese  
*Aerial cam unit*  
 Oben hängende Schieber

**CHD 050**



View W



View X

- 7
- 2/N
- 10/N
- 9
- 7/N
- 9/N



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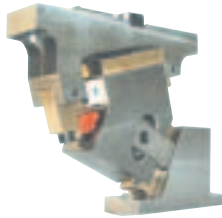
Pos.	Description	Q.ty	Material
01	Upper base	1	CK45
02	Slider	1	EN-GJL-250
03	Plate	1	GZ-CuZn25A15
04	Driver	1	CK45
05	Guide bar	1	GZ-CuZn25A15
06	Spacer	1	CK45
07	Positive return LH/RH	1+1	42CrMo4
08	Upper key	2	CK45
09	Male "V" Driver	1	GZ-CuZn25A15
10	Lower key	1	CK45

Pos.	Standard	Q.ty	Dimension
01/N	Spring "Special Springs"	1	
02/N	Hexagon socket head cap screw DIN 912	6	M8 x 16
03/N	Hexagon socket head cap screw DIN 912	4	M8 x 20
04/N	Dowel pin DIN 7979	2	Ø 8 x 30
05/N	Hexagon socket head cap screw DIN 912	1	M10 x 45
06/N	Hexagon socket head cap screw DIN 912	1	M10 x 55
07/N	Hexagon socket set screw with dog point DIN 915	2	M6 x 15
08/N	Hexagon socket head cap screw DIN 912	2	M10 x 30
09/N	Schnorr washer	4	Ø 10
10/N	Schnorr washer	2	Ø 8

Code	A	B	C	D	E	F	G	H
CHD050.015.00	185	67,5	0°	-15	46,4	15	80	100
CHD050.015.05	188,04	68,29	5°	-10	52,8	15,6	75	100
CHD050.015.10	185,99	69,77	10°	0	59	15,6	65	100
CHD050.017.15	188,77	71,95	15°	0	64,9	17	65	95
CHD050.018.20	186,34	74,79	20°	10	70,5	18,4	55	95
CHD050.018.25	181,62	80,28	25°	24	73,6	18	41	97
CHD050.017.30	180,58	85,39	30°	25	77,4	17,4	40	90
CHD050.018.35	177,15	90,1	35°	40	81,6	18,9	25	95
CHD050.020.40	173,29	95,35	40°	42,5	85,4	20,6	22,5	87,5
CHD050.022.45	169,94	98,13	45°	55	91,7	22,5	10	91
CHD050.023.50	164,07	99,37	50°	60	99,4	23,3	5	85
CHD050.026.55	158,64	111,04	55°	80	96,6	26,1	-15	95
CHD050.031.60	152,61	118,08	60°	90	98,2	31,5	-25	95
CHD050.036.65	145,95	125,44	65°	100	99,1	36,6	-35	95

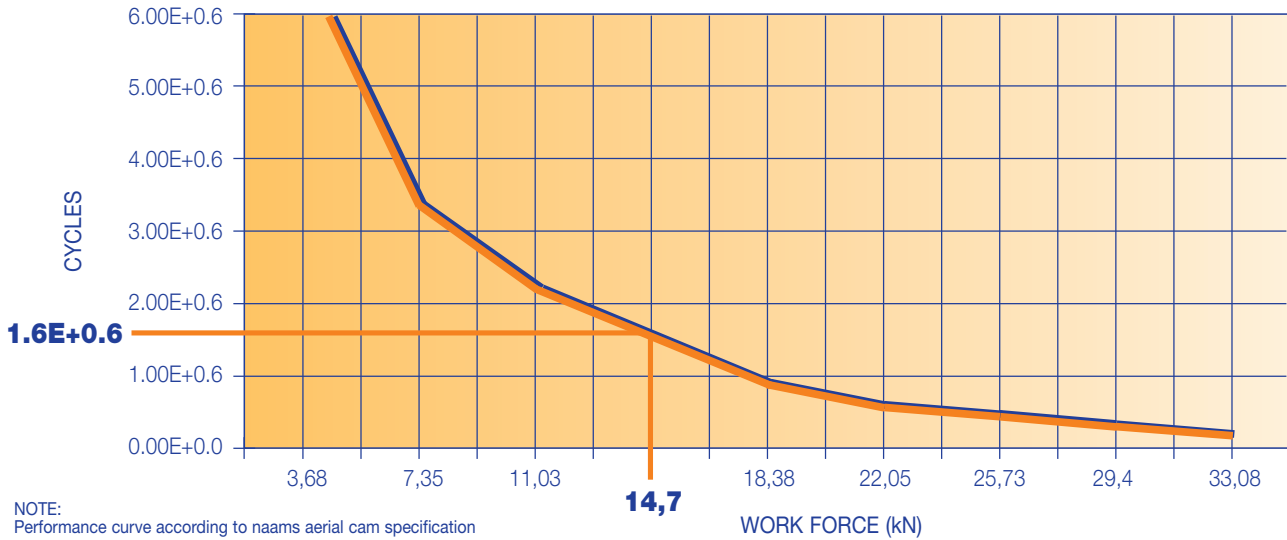


# Unità a camme sospese Aerial cam unit Oben hängende Schieber



## CHD 050

### CAM PERFORMANCE



### SERIES CHD SPECIFICATION SUMMARY

Code	Stroke (mm)	Angle	Work force (kN)	Space for punch mount		Return spring (N)		Dimensions in working conditions			Weight (kg)						
				Length (mm)	Width (mm)	Initial	Final	Length (mm)	Width (mm)	Height (mm)							
CHD050.015.00	15,0	0°	14,7	65	50	101	1277	205	190	50	180	10,6					
CHD050.015.05	15,6	5°				151	1262	200				10,3					
CHD050.015.10	15,6	10°				101	1111	179				1134	205	190	50	180	9,9
CHD050.017.15	17,0	15°															9,7
CHD050.018.20	18,4	20°				9,4											
CHD050.018.25	18,0	25°				9,4											
CHD050.017.30	17,4	30°				9,2											
CHD050.018.35	18,9	35°				9,2											
CHD050.020.40	20,6	40°				239	1134	205				190	50	180	9,1		
CHD050.022.45	22,5	45°													9,1		
CHD050.023.50	23,3	50°				179	1134	215				190	50	180	9,1		
CHD050.026.55	26,1	55°													9,5		
CHD050.031.60	31,5	60°				179	1134	225				190	50	180	9,7		
CHD050.036.65	36,6	65°													10,1		

### SPRING SPECIFICATION

Angle	Length (mm)		Dimensions (mm)	
	Initial	Final	Free length	Outside o
0°	87	63,7	89	20
5°	86	64		
10°-15°-20°	87	67		
25°	73	55	76	
30°-35°-40°-45°		57		
50°-55°	72			
60°-65°	73			

### KEY SIZE (mm)

Standard (M) 20x50

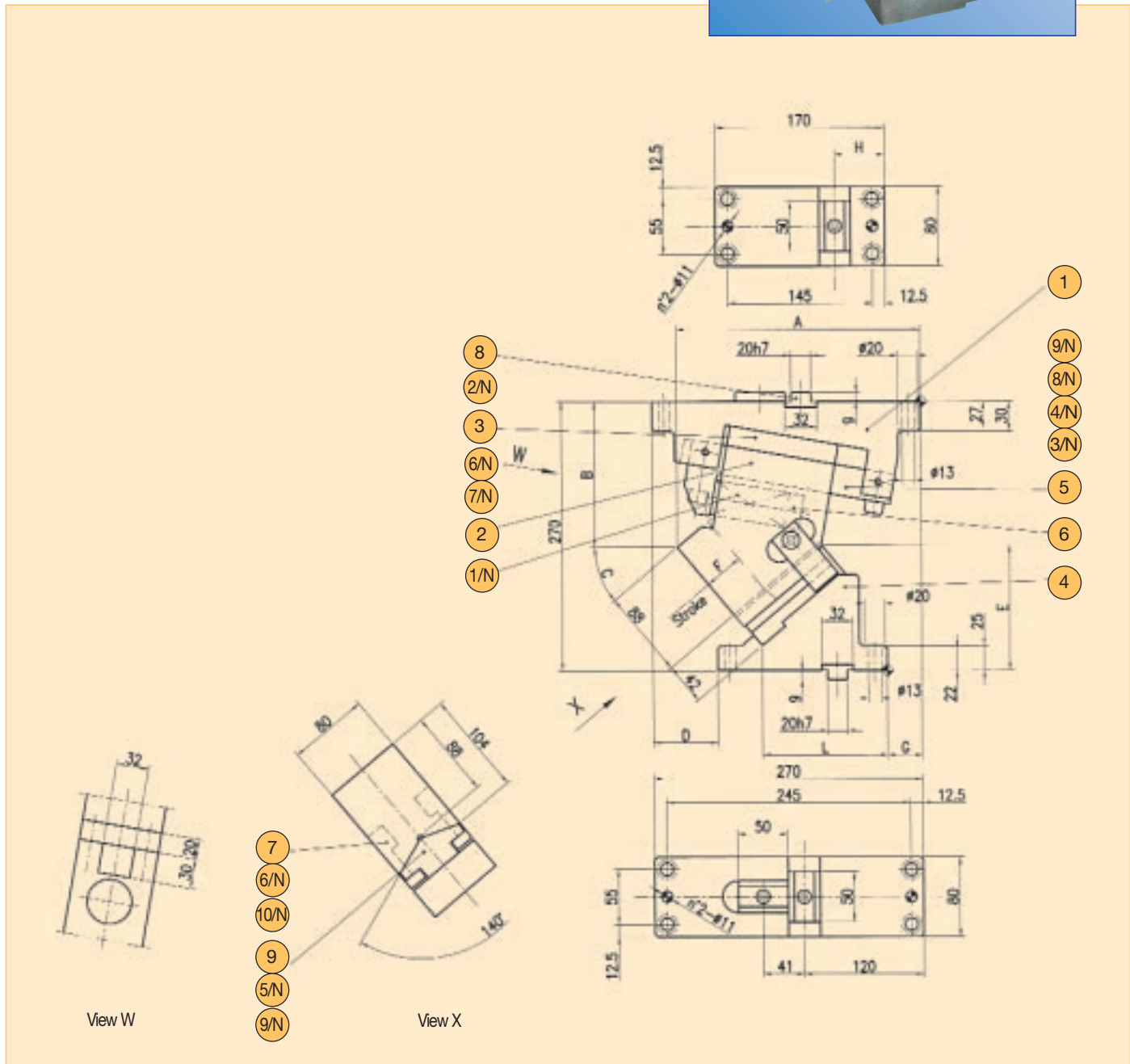
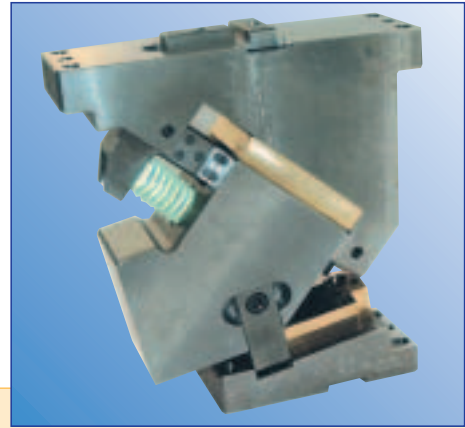
Optional (W) 25,4x44



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Unità a camme sospese  
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 Oben hängende Schieber

**CHD 080**



Pos.	Description	Q.ty	Material
01	Upper base	1	EN-GJL-250
02	Slider	1	EN-GJL-250
03	Plate	1	GZ-CuZn25A15
04	Driver	1	EN-GJL-250
05	Guide bar	1	CK45
06	Spacer	1	CK45
07	Positive return	2	42CrMo4
08	Key upper/lower	3	CK45
09	Male "V" driver	1	GZ-CuZn25A15

Pos.	Standard	Q.ty	Dimension
01/N	Spring "Special Springs"	1	
02/N	Hexagon socket head cap screw DIN 912	3	M8 x 15
03/N	Hexagon socket head cap screw DIN 912	1	M12 x 50
04/N	Hexagon socket head cap screw DIN 912	1	M12 x 70
05/N	Hexagon socket head cap screw DIN 912	2	M12 x 40
06/N	Hexagon socket head cap screw DIN 912	4+2	M10 x 25
07/N	Dowel pin DIN 7979	2	Ø 8 x 30
08/N	Hexagon socket set screw with dog point DIN 915	2	M8 x 20
09/N	Schnorr washer	4	Ø 12
10/N	Schnorr washer	2	Ø 8

Code	A	B	C	D	E	F	G	H	L
CHD080.030.00	277	110	0°	-35	68,9	30,2	135	65	140
CHD080.030.05	278,32	115,67	5°	-25	73,3	30,5	125	65	140
CHD080.031.10	274,54	117,32	10°	-10	82,4	31,1	110	65	140
CHD080.033.15	277,58	119,95	15°	-5	91,1	33,9	105	55	137
CHD080.032.20	273,34	123,52	20°	-5	99,2	32,3	95	55	132
CHD080.035.25	268,75	128,03	25°	20	106,8	35	80	55	132
CHD080.034.30	261,73	133,42	30°	35	113,7	34,7	65	60	130
CHD080.037.35	258,2	139,66	35°	45	120	37,7	55	60	127
CHD080.039.40	245,09	146,70	40°	65	125,5	39,9	35	50	125
CHD080.043.45	245,34	154,49	45°	70	130,3	43,7	30	50	122
CHD080.046.50	255,87	162,97	50°	95	134,3	46,7	5	50	120
CHD080.053.55	229,64	172,07	55°	100	137,4	53,8	0	60	122
CHD080.061.60	208,58	181,73	60°	120	139,7	61,1	-20	50	115
CHD080.070.65	203,67	191,87	65°	130	141,1	70,9	-30	50	115



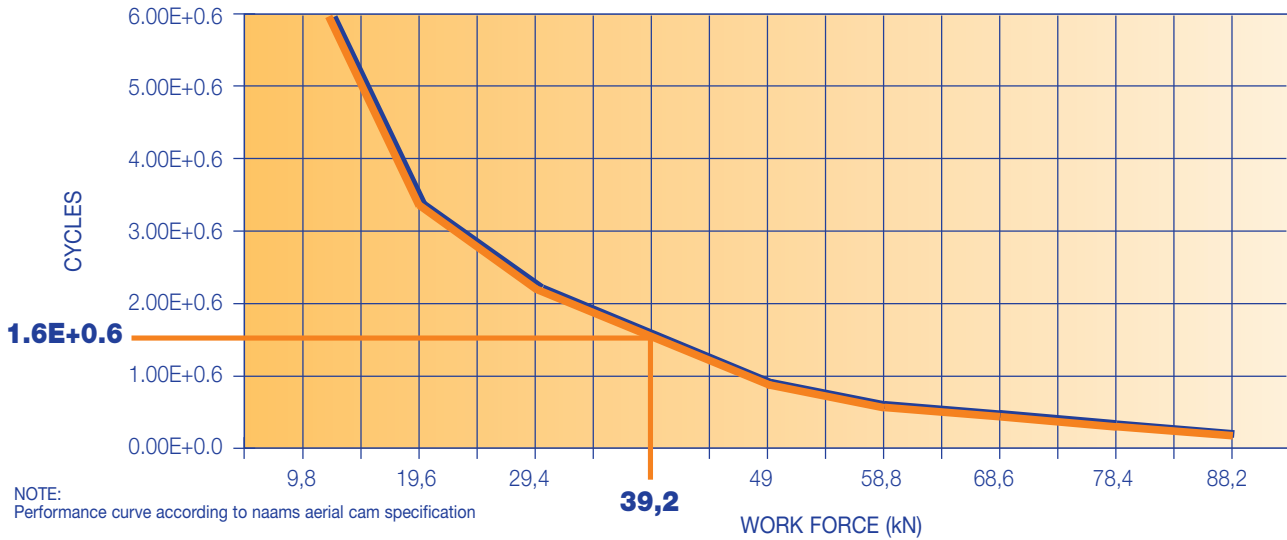


# Unità a camme sospese Aerial cam unit Oben hängende Schieber



## CHD 080

### CAM PERFORMANCE



### SERIES CHD SPECIFICATION SUMMARY

Code	Stroke (mm)	Angle	Work force (kN)	Space for punch mount		Return spring (N)		Dimensions in working conditions			Weight (kg)
				Length (mm)	Width (mm)	Initial	Final	Length (mm)	Width (mm)	Height (mm)	
CHD080.030.00	30,2	0°	39,2	88	80	265	764	305	80	270	34
CHD080.030.05	30,5	5°				308		295			32
CHD080.031.10	31,1	10°				340		280			32
CHD080.033.15	33,9	15°				340	277,6	32			
CHD080.032.20	32,3	20°				331	273,3	32			
CHD080.035.25	35,0	25°				331	270	30			
CHD080.034.30	34,7	30°				369		30			
CHD080.037.35	37,7	35°				369		30			
CHD080.039.40	39,9	40°				381	775	29			
CHD080.043.45	43,7	45°				381		29			
CHD080.046.50	46,7	50°				394		30			
CHD080.053.55	53,8	55°				381	290	30			
CHD080.061.60	61,1	60°						31			
CHD080.070.65	70,9	65°						32			

### SPRING SPECIFICATION

Angle	Length (mm)		Dimensions (mm)	
	Initial	Final	Free length	Outside ø
0°	127	80	152	32
5°	123			
10°-15°	120			
20°-25°	101	66	127	
30°-35°	98			
40°-45°	97			
50°	96			
55°-60°-65°	97			

### KEY SIZE (mm)

Standard (M)	20x50
Optional (W)	25,4x50



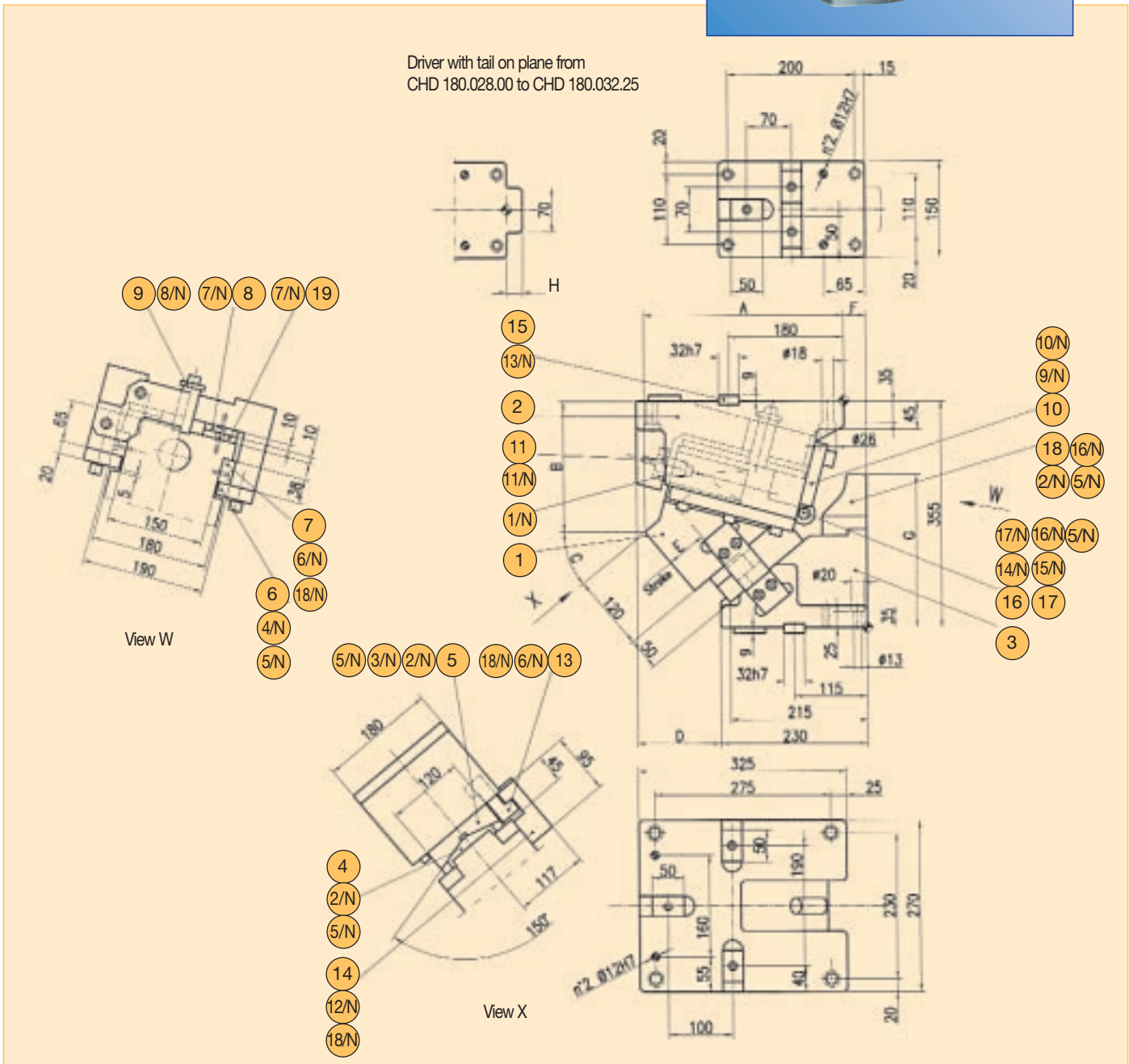
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Unità a camme sospese  
*Aerial cam unit*  
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**CHD 180**



Driver with tail on plane from  
 CHD 180.028.00 to CHD 180.032.25



Pos.	Description	Q.ty	Material
01	Slider	1	EN-GJL-250
02	Upper base	1	EN-GJL-300
03	Driver	1	EN-GJL-300
04	Male "V" driver	1	CK45
05	Female "V" driver	1	GZ-CuZn25A15
06	Plate	2	CK45
07	Slide plate left	1	GZ-CuZn25A15
08	Plate	2	GZ-CuZn25A15
09	Safety pin	1	CK45
10	Stopper plate	1	St52
11	Spring guide pin	1	CK45
12	Slide plate right	1	GZ-CuZn25A15
13	Positive return "A"	1	GZ-CuZn25A15
14	Positive return "B"	1	42CrMo4
15	Key	6	CK45
16	Shaft	1	CK45
17	Roller bracket	1	CK45
18	Accelerator	1	CK45
19	Plate	4	CK45

Pos.	Standard	Q.ty	Dimension
01/N	Spring "Special Springs"	1	V50-203
02/N	Hexagon socket head cap screw DIN 912	6	M12 x 30
03/N	Dowel pin DIN 7979	2	Ø 10 x 30
04/N	Hexagon socket head cap screw DIN 912	6	M12 x 45
05/N	Schnorr washer	16	Ø 12
06/N	Hexagon socket head cap screw DIN 912	6	M10 x 25
07/N	Hexagon socket head cap screw DIN 912	8	M10 x 20
08/N	Hexagon socket head cap screw DIN 912	1	M12 x 90
09/N	Hexagon socket head cap screw DIN 912	4	M16 x 50
10/N	Schnorr washer	4	Ø 16
11/N	Hexagon socket head cap screw DIN 912	1	M12 x 70
12/N	Hexagon socket head cap screw DIN 912	2	M10 x 45
13/N	Hexagon socket head cap screw DIN 912	6	M8 x 20
14/N	External retaining ring DIN 471	2	E15
15/N	Hexagon socket set screw with dog point DIN 915	1	M6 x 8
16/N	Hexagon socket head cap screw DIN 912	2	M12 x 40
17/N	Roller "INA"	1	NATR15PP
18/N	Schnorr washer	8	Ø 10

Code	A	B	C	D	E	F	G	H
CHD180.028.00	325	130	0°	15	28,7	80	105	25
CHD180.032.05	319,7	133,26	5°	35	32,3	60	125	25
CHD180.035.10	319,06	137,79	10°	50	35,9	45	145	25
CHD180.039.15	322,98	143,56	15°	60	39,7	35	160	20
CHD180.043.20	326,33	150,51	20°	70	43,6	25	180	15
CHD180.047.25	329,03	158,61	25°	80	47,8	15	200	10
CHD180.052.30	325,98	167,78	30°	95	52,3	0	215	0
CHD180.057.35	322,08	192,95	35°	110	57,4	-15	220	0
CHD180.063.40	312,26	204,06	40°	130	63	-35	240	0
CHD180.069.45	306,42	216,01	45°	145	69,6	-50	260	0
CHD180.077.50	294,51	228,71	50°	165	77,5	-70	280	0
CHD180.087.55	281,46	242,07	55°	185	87,2	-90	295	0
CHD180.099.60	272,22	255,98	60°	200	99,6	-105	315	0
CHD180.116.65	261,75	270,34	65°	215	116,5	-120	340	0

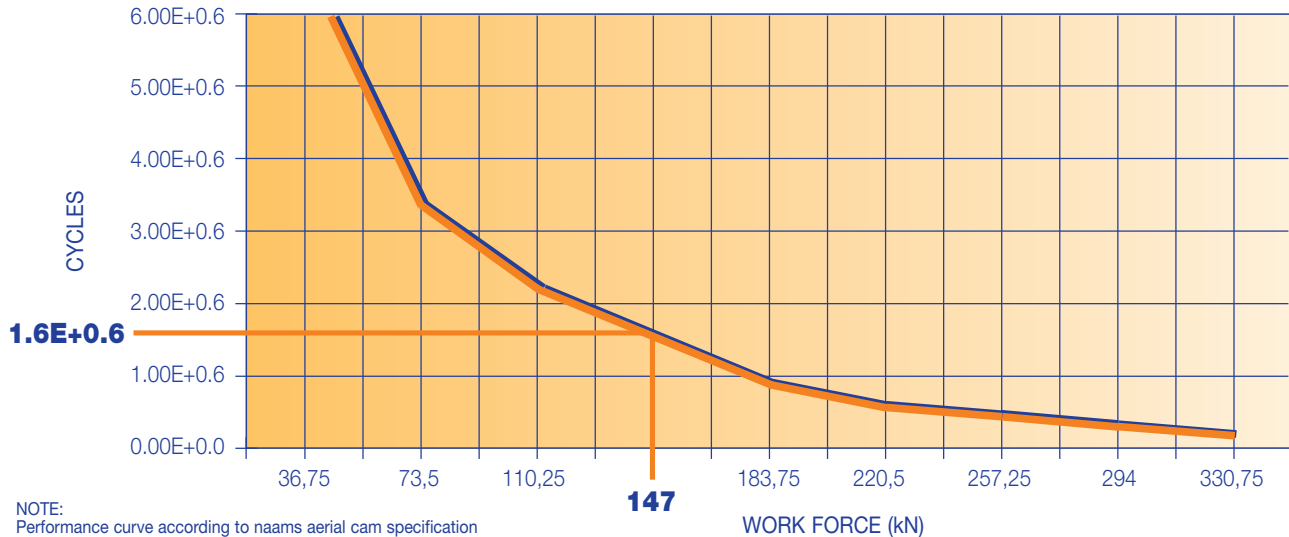


# Unità a camme sospese Aerial cam unit Oben hängende Schieber



## CHD 180

### CAM PERFORMANCE



### SERIES CHD SPECIFICATION SUMMARY

Code	Stroke (mm)	Angle	Work force (kN)	Space for punch mount		Return spring (N)		Dimensions in working conditions			Weight (kg)
				Length (mm)	Width (mm)	Initial	Final	Length (mm)	Width (mm)	Height (mm)	
CHD180.028.00	28,7	0°	147	120	180	572	2772	325	270	355	130
CHD180.032.05	32,3	5°									128
CHD180.035.10	35,9	10°									125
CHD180.039.15	39,7	15°									125
CHD180.043.20	43,6	20°									123
CHD180.047.25	47,8	25°									122
CHD180.052.30	52,3	30°									122
CHD180.057.35	57,4	35°									125
CHD180.063.40	63,0	40°									127
CHD180.069.45	69,6	45°									128
CHD180.077.50	77,5	50°									131
CHD180.087.55	87,2	55°									134
CHD180.099.60	99,6	60°									133
CHD180.116.65	116,5	65°									137

### SPRING SPECIFICATION

Angle	Length (mm)		Dimensions (mm)	
	Initial	Final	Free length	Outside ø
0°÷65°	190	140	203	50

### KEY SIZE (mm)

Standard (M)	32x50
Optional (W)	25,4x50





Pos.	Description	Q.ty	Material
01	Slider	1	EN-GJL-250
02	Upper base	1	EN-GJL-300
03	Driver	1	EN-GJL-300
04	Male "V" driver	1	CK45
05	Female "V" driver	1	GZ-CuZn25A15
06	Plate	2	CK45
07	Slide plate left	1	GZ-CuZn25A15
08	Plate	2	GZ-CuZn25A15
09	Safety pin	1	CK45
10	Stopper plate	1	St52
11	Spring guide pin	1	CK45
12	Slide plate right	1	GZ-CuZn25A15
13	Positive return driver "A" LH/RH	1+1	GZ-CuZn25A15
14	Positive return follower "B" LH/RH	1+1	42CrMo4
15	Key	6	CK45
16	Shaft	1	CK45
17	Roller bracket	1	CK45
18	Accelerator	1	CK45
19	Plate	2	CK45
20	Plate	4	CK45
21	Plate	2	GZ-CuZn25A15

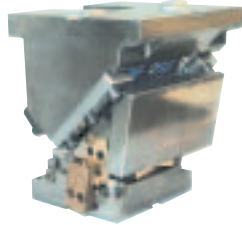
Pos.	Standard	Q.ty	Dimension
01/N	Spring "Special Springs"	2	B50-203
02/N	Hexagon socket head cap screw DIN 912	6	M12 x 30
03/N	Dowel pin DIN 7979	2	Ø 10 x 30
04/N	Hexagon socket head cap screw DIN 912	6	M16 x 55
05/N	Schnorr washer	10	Ø 12
06/N	Hexagon socket head cap screw DIN 912	16	M10 x 25
07/N	Hexagon socket head cap screw DIN 7984	24	M10 x 20
08/N	Hexagon socket head cap screw DIN 912	1	M12 x 90
09/N	Hexagon socket head cap screw DIN 912	6	M16 x 50
10/N	Schnorr washer	12	Ø 16
11/N	Hexagon socket head cap screw DIN 912	2	M12 x 70
12/N	Hexagon socket head cap screw DIN 912	4	M10 x 45
13/N	Hexagon socket head cap screw DIN 912	6	M8 x 20
14/N	External retaining ring DIN 471	2	E15
15/N	Hexagon socket set screw with dog point DIN 915	1	M6 x 8
16/N	Hexagon socket head cap screw DIN 912	4	M12 x 40
17/N	Roller "INA"	1	NATR15PP
18/N	Schnorr washer	20	Ø 10

Code	A	B	C	D	E	F	G	H
CHD250.028.00	325	90	0°	15	28,7	80	105	25
CHD250.032.05	323,19	93,41	5°	35	32,3	60	125	25
CHD250.035.10	326,01	98,40	10°	50	35,9	45	145	25
CHD250.039.15	333,33	104,92	15°	60	39,7	35	160	20
CHD250.043.20	340,02	112,93	20°	70	43,6	25	180	15
CHD250.047.25	345,94	122,35	25°	80	47,8	15	200	10
CHD250.052.30	345,98	133,14	30°	95	52,3	0	215	0
CHD250.057.35	345,03	160,19	35°	110	57,4	-15	220	0
CHD250.063.40	337,97	173,42	40°	130	63	-35	240	0
CHD250.069.45	334,71	187,72	45°	145	69,6	-50	260	0
CHD250.077.50	325,15	202,99	50°	165	77,5	-70	280	0
CHD250.087.55	314,23	219,12	55°	185	87,2	-90	295	0
CHD250.099.60	306,86	235,98	60°	200	99,6	-105	315	0
CHD250.116.65	298	253,44	65°	215	116,5	-120	340	0

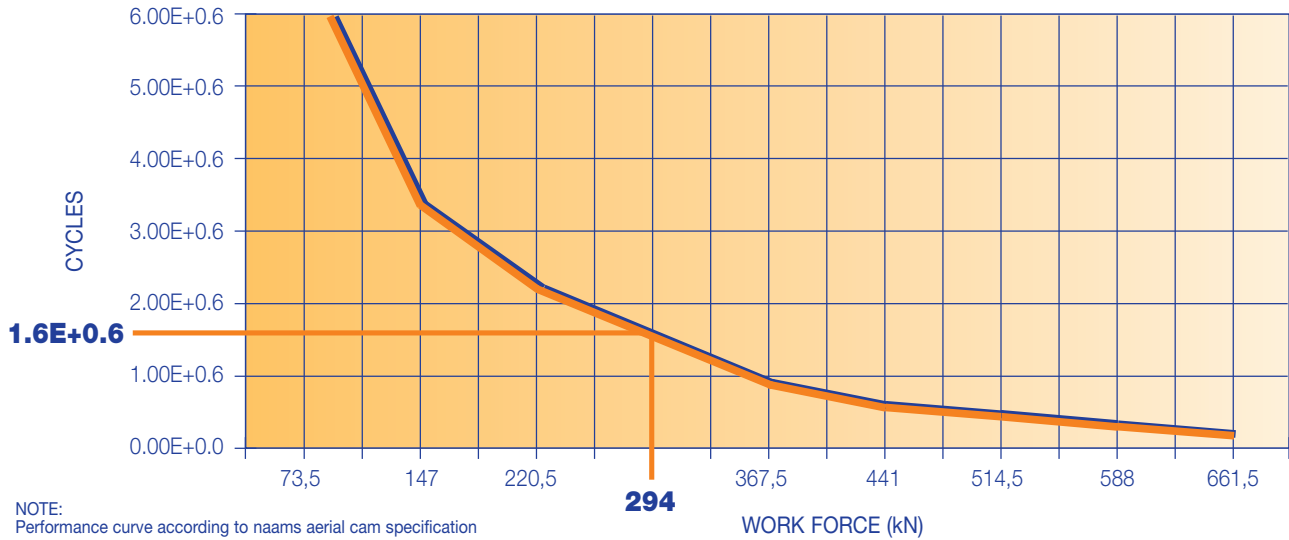


# Unità a camme sospese Aerial cam unit Oben hängende Schieber

## CHD 250



### CAM PERFORMANCE



### SERIES CHD SPECIFICATION SUMMARY

Code	Stroke (mm)	Angle	Work force (kN)	Space for punch mount		Return spring (N)		Dimensions in working conditions			Weight (kg)
				Length (mm)	Width (mm)	Initial	Final	Length (mm)	Width (mm)	Height (mm)	
CHD250.028.00	28,7	0°	294	160	250	1554,8	7534,8	325	340	355	215
CHD250.032.05	32,3	5°						325			210
CHD250.035.10	35,9	10°						326			204
CHD250.039.15	39,7	15°						333,30			199
CHD250.043.20	43,6	20°						340,01			199
CHD250.047.25	47,8	25°						345,94			196
CHD250.052.30	52,3	30°						345,98			207
CHD250.057.35	57,4	35°						360,02			201
CHD250.063.40	63,0	40°						372,97			213
CHD250.069.45	69,6	45°						384,71			209
CHD250.077.50	77,5	50°						395,15			209
CHD250.087.55	87,2	55°						415			223
CHD250.099.60	99,6	60°						430			224
CHD250.116.65	116,5	65°						445			234

### SPRING SPECIFICATION

Angle	Length (mm)		Dimensions (mm)	
	Initial	Final	Free length	Outside ø
0°÷65°	190	140	203	50

### KEY SIZE (mm)

Standard (M) 32x50

Optional (W) 25,4x50



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## NOTE TECNICHE

### APPLICAZIONE:

- La tranciatura deve avvenire oltre i 2/3 della corsa dello scorrevole, per garantire il miglior funzionamento dell'apparecchiatura.
- La molla di richiamo garantisce esclusivamente il ritorno dello scorrevole, e non l'estrazione del punzone dalla lamiera.
- Le basi inferiori e superiori, devono essere tassativamente montate con la reazione sulle chiavette in dotazione o sulla superficie d'origine, allo scopo di non sollecitare a taglio gli elementi di collegamento.
- Nelle camme dal cod. CHD150.028.00 al cod. CHD300.116.65, il fissaggio della guida d'acciaio Part. 4 sulla base inferiore Part. 3, deve essere eseguito al montaggio con spine Ø10, per consentire l'allineamento dell'apparecchiatura.
- Per la movimentazione delle camme dal cod. CHD150.028.00 al cod. CHD300.116.65 utilizzare esclusivamente i punti indicati nella fig. A
- Le coppie di serraggio da utilizzare per il fissaggio della viteria sono indicate in tab.1

## TECHNICAL NOTICE

### IMPLEMENTATION:

- *For best operation of the equipment, the blanking is to be performed beyond 2/3 of slider stroke.*
- *The return spring only ensures return of the slider, and not the extraction of the punch from the sheet.*
- *The driver and upper base must be specifically assembled with reaction on either the keys supplied, or the original surface so as not to stress the connection elements to slash.*
- *With CHD150.028.00 to CHD300.116.65 cams, Part. 4 male "V" driver must be fastened to Part. 3 driver, during assembling, by using Ø10 dowel pin, thus enabling alignment of the equipment.*
- *As for the handling of CHD150.028.00 to CHD300.116.65 cams, use only the lifting points as indicated by fig. A.*
- *Torque values for the fastening of bolts and screws: as indicated on table 1.*

## TECHNISCHE INFORMATIONEN

### ANWENDUNG:

- Das Schneiden muss nach 2/3 des Schieberhubs erfolgen, um den besten Funktionsablauf des Geräts zu gewährleisten.
- Die Rückholfeder gewährleistet nur die Rückholung des Schiebers und nicht das Herausziehen des Stempels aus dem Blech.
- Keilaufsatz und Treiber müssen unbedingt mit den mitgelieferten Passfedern oder mit Rückanschlag montiert werden, so dass die Verbindungselemente keine Querkräfte aufnehmen.
- Bei den Schiebern mit den Artikelnummern CHD150.028.00 bis CHD300.116.65 muss die Zentrierung der Stahlführung (Teil 4) bei der Montage auf dem Keilaufsatz (Teil 3) mit Zentrierstiften Ø10 ausgeführt werden, um eine Ausrichtung des Schiebers zu erzielen.
- Zur Bewegung der Schieber mit den Artikelnummern CHD150.028.00 bis CHD300.116.65 nur die bei Fig. A angegebenen Punkte verwenden.
- Die zur Befestigung der Schrauben anzuwendenden Anzugsmomente entnehmen Sie bitte Tabelle 1.

### CALCOLO DELLA FORZA DI TRANCIATURA

F = Forza di tranciatura  
R = Resistenza meccanica della lamiera  
Sp = Spessore lamiera  
L = Lunghezza profilo di tranciatura

### CALCULATION OF BLANKING FORCE

F = Blanking force  
R = Mechanical strength sheet  
Sp = Sheet thickness  
L = Length of blanking section

### BERECHNUNG DER KRÄFTE BEIM SCHNEIDEN

F = Schneidkraft  
R = Scherfestigkeit  
Sp = Blechdick  
L = Schneidumfang

$$F \text{ (kN)} = \frac{R \text{ (N/mm}^2\text{)} \times Sp \text{ (mm)} \times L \text{ (mm)}}{1000}$$

## LUBRIFICAZIONE

Lubrificare le parti in scorrimento della camma con olio a bassa o media viscosità ad inizio lavoro, dopo soste prolungate e dopo lavaggi dell'apparecchiatura. Una lubrificazione periodica ogni 100.000 cicli, aumenta la durata dell'apparecchiatura.

### NON UTILIZZARE GRASSO.

## LUBRICATION

*The sliding parts of the cam need lubrication with low/medium viscosity oil at the beginning of each task, after prolonged discontinuance and after cleansing. Proper lubrication every 100,000 cycles prolongs durability of the equipment.*

### DO NOT GREASE.

## SCHMIERUNG

Die beweglichen Teile des Schiebers zu Arbeitsbeginn, nach längerem Stillstand oder nach Säuberung des Werkzeugs mit Öl mit niedriger oder mittlerer Viskosität schmieren. Eine regelmäßige Schmierung alle 100.000 Zyklen erhöht die Lebensdauer des Schiebers.

### KEIN FETT VERWENDEN.

## Punti di sollevamento

### Lifting points

### Hebepunkte

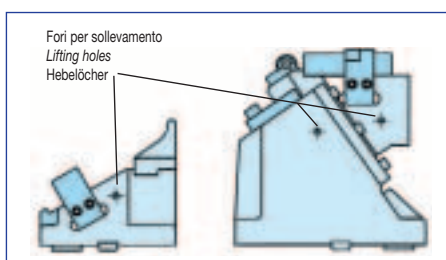


Fig. A

Filetto Thread Gewinde	Coppia di serraggio Nm (per viti cl. 8.8) Clamping torque Nm (for cl. 8.8 screws) Einschraubdrehmoment Nm (für Schrauben Kl. 8.8)
M6	10,3
M8	25,5
M10	50,01
M12	87,28
M16	210,8

Tab. 1

