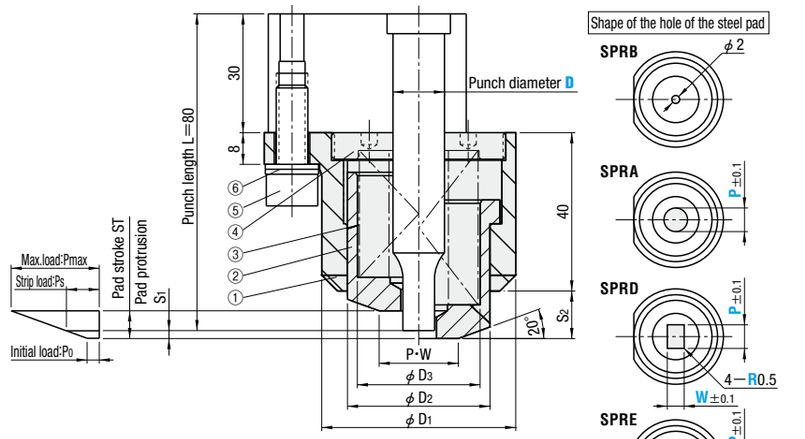
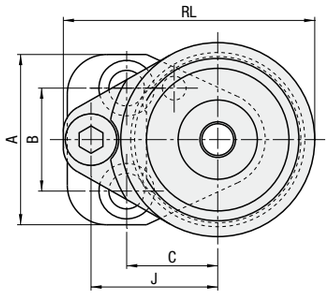
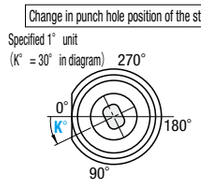
STEEL PAD UNIT







①Case
M S45C
S Black oxide
(Inside : Induction-hardened)
②Steel pad
M S45C
(S D16、20 Nitriding)
③Coil spring
M SWOSC-V
④Locating ring
M S45C
H 34 ～ 40HRC
S Black oxide
⑤Hexagon socket head cap screw CB8-22
⑥Loosening prevention washer NLDP8

Punch and retainer are separate sale.
Set the hole diameter P and W dimensions of the steel pad such that they are 1mm greater than the punch diameter.
The customers are requested to process the nose shape of the steel pad at their end.
Set the penetration length of the punch at or below 5mm.

Applicable punch D	D1	D2	D3	S1	S2	RL	Retainer A	Retainer B	Retainer C	Retainer J	Catalog No. Type	Catalog No. D	Load	0.1mm increments SPRA P	0.1mm increments SPRD·SPRE P·W	1°increments Pad hole position K° D·E type only	Base unit price 1～9sets SPRB (Blank)	Base unit price 1～9sets SPRA	Base unit price 1～9sets SPRD SPRE
10	40	28	16	2	12	56	37	20	21	29	SPRB SPRA SPRD SPRE	10	F L M H B G	3.0～11.0	3.0～11.0	0≦K≦359	Quotation		
13	49	36	20			63.5	43	26	23	32		13		3.0～14.0	3.0～14.0				
16	54	41	25			68	44	24	26	34		16		3.0～17.0	3.0～17.0				
20	57	45	25			71.5	48	28	27	36		20	(B)	3.0～21.0	3.0～21.0				

Determine the load based on the selected spring.
Use B of the dedicated spring for D20.

Order

Catalog No.				P		W		K
SPRA13	—	H	—	P9	—			
SPRE16	—	G	—	P11	—	W5	—	K20
SPRB10	—	G						

Days to Ship Quotation

P Price Quotation

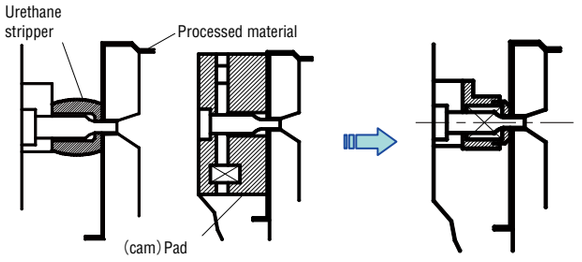
■ Load (N) of the pad stroke (mm) and coil spring

		F Stroke(mm)	F Load(N)	L Stroke(mm)	L Load(N)	M Stroke(mm)	M Load(N)	H Stroke(mm)	H Load(N)	B Stroke(mm)	B Load(N)	G Stroke(mm)	G Load(N)	Coil spring
D10	Initial	0	20	0	41	0	74	0	148	0	239	0	294	SWF22-40 SWL22-40 SWM22-40 SWH22-40 SWB22-40 SWG22-40
	When stripping	2	59	2	123	2	223	2	444	2	717	2	882	
	Life span (10,000 times) 100	10	216	10	451	9.2	758	6.6	1125	5.4	1530	5.4	1882	
	Life span (10,000 times) 50					10	817	7.6	1273	6.2	1721	6.2	2117	
	Life span (10,000 times) 30							8.6	1421	7	1912	7	2352	
D13	Initial	0	35	0	74	0	138	0	276	0	441	0	588	SWF30-40 SWL30-40 SWM30-40 SWH30-40 SWB30-40 SWG30-40
	When stripping	2	106	2	222	2	414	2	828	2	1323	2	1768	
	Life span (10,000 times) 100	10	388	10	815	9.2	1408	6.6	2098	5.4	2822	5.4	3763	
	Life span (10,000 times) 50					10	1518	7.6	2374	6.2	3175	6.2	4234	
	Life span (10,000 times) 30							8.6	2650	7	3528	7	4704	
D16	Initial	0	48	0	101	0	188	0	375	0	600	0	772	SWF35-40 SWL35-40 SWM35-40 SWH35-40 SWB35-40 SWG35-40
	When stripping	2	144	2	303	2	564	2	1125	2	1800	2	2316	
	Life span (10,000 times) 100	10	528	10	1111	9.2	1918	6.6	2850	5.4	3840	5.4	4941	
	Life span (10,000 times) 50					10	2068	7.6	3225	6.2	4320	6.2	5558	
	Life span (10,000 times) 30							8.6	3600	7	4800	7	6176	
D20	Initial									0	531			Exclusive SWB39-40
	When stripping									2	1593			
	Life span (10,000 times) 100									5.4	3398			
	Life span (10,000 times) 50									6.2	3823			
	Life span (10,000 times) 30									7	4248			

Note) The usage count of the coil spring is based on the 'Instruction and Precautions for the use of coil springs' on P.1397.
(These are reference values. Life-span will deteriorate if the coil spring is set diagonally or horizontally.)

■ Features
1) The coil spring can be installed into a Misumi standard retainer with just one bolt.
2) Suitable in processing of high tension materials as a high stripping load can be obtained by building in a deformed wire coil spring.
3) As each structural part (1-4) is integrated, the parts do not get dispersed making the mounting and demounting an easy process.

ex Example



Can be used as a substitute to (cam) pad, urethane stripper of the side pierce (when using base cam, hanging cam)

■ Applicable retainer

Catalog No.				Page
HDP—AP HDP—FP	HDPAR HDPFR	HDP—AN HDP—FN		P.736
DP—AP DP—FP	DP—AD DP—FD	DPAR DPFR	DP—AN DP—FN	P.741
CP—AP CP—FP	CP—AD CP—FD	CPAR CPFR	CP—AN CP—FN	P.742
AP—AP AP—FP	APAR APFR	AP—AN AP—FN		P.743
FP—AP FP—FP	FPAR FPFR	FP—AN FP—FN		P.744

■ Wrench for positioning ring

SPRAP

■ How to replace the coil spring
Insert the wrench in the wrench holes of the positioning ring and rotate to left. The positioning ring will come out and the coil spring can be replaced.

Order Catalog No. SPRAP

Days to Ship Quotation

P Price Quotation

RETAINERS