

DANLY

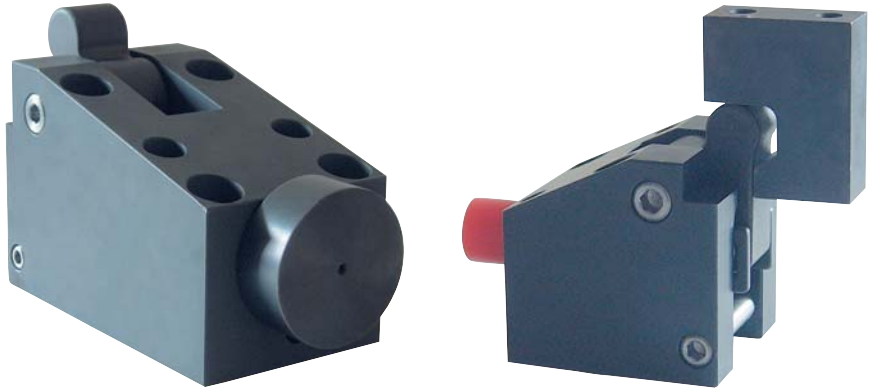
CAMDRIVE®

Interchangeable, in stock and loaded with options



CAMDRIVE® – The compact cam with “interchangeable precision”

One design, easily adaptable for a wide range of special needs. Versatility and precision by interchangeable internal components.



Why build & repair cams?

CAMDRIVE® benefits:

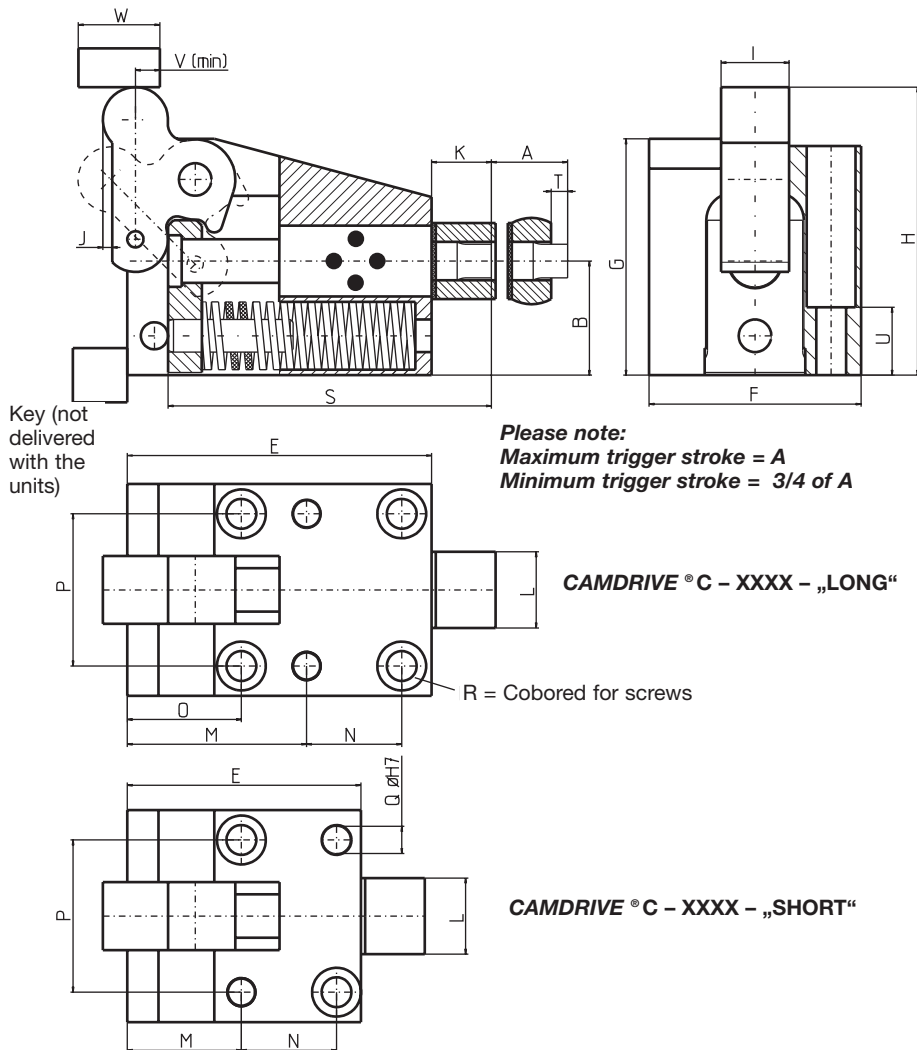
- Low cost, versatile design
- Fits in smallest die space
- Fast delivery ... even for options
- Interchangeable tolerances, metric
- Hardened components, high production
- All units are equipped with a mechanical die spring return ... a DANLY Spring

How to select the right unit:

- Calculate the piercing tonnage and stripping force needed.
- Determine point size (D) and stroke (A) needed.
- Select the right CAMDRIVE® that fits your specific needs.
- Specify point size on standards.
- PLEASE NOTE : options on page 3 and 4 are available from stock.

CAMDRIVE® Do's & Don't's:

- DO:** key in back of unit to resist force.
- DO:** effect piercing in last quarter of max stroke A.
- DO:** remember punch stroke equals press stroke (1 : 1 ratio).
- DO:** design die clearance more than 10% per side min.
- DON'T:** mount CAMDRIVE® greater than ± 15° without using angle mount option trigger.
Note: ±30° max angle with option. For positive return on angle mounts, call DANLY.
- DON'T:** overstroke the unit.
Max trigger stroke = A



Self Lubricating Bronze Bushing

- Eliminates the need for a grease fitting.
- Requires virtually no maintenance and increases life.
- Ideal for automotive dies.
- Meets automotive standards.

CAMDRIVE®

Catalogue reference	Unit	C-0250-		C-0375-		C-0500-		C-0625-		C-1000-		C-1500-	
		-11	-12	-11	-12	-11	-12	-11	-12	-12	-13	-12	-13
Tonne (t)		1		2		3		5		10		18	
MAX. stripping force (daN)		170		200		210		320		510		560	
Point D	MM	1,5 ... 4,7		3,2 ... 7,9		4,7 ... 11		9,5 ... 14,2		14,3 ... 22,4		22,5 ... 31	
E	MM	51	76	64	91	76	98	87	112	126	158	168	231
Stroke A	MM	9,5	19	13	22	16	25	19	28	32	50	38	63
B	MM	22±0,02		32±0,02		36±0,02		42±0,02		48±0,02		67±0,02	
C	MM	6		10		13		16		25		38	
F	MM	51		64		68		78		92		105	
G	MM	47		63		75		87		106		146	
H	MM	59		75		91		106		129		180	
I	MM	15		19		22		24		28		41	
J	MM	6		5		6.5		9		15		24	
K	MM	22		22		22		22		28.5		41.5	
L	MM	18		21		23		28		45		63	
M	MM	26	50	32	57	38	59	42	66	77	110	105	168
N	MM	18		23		30		35		35		45	
O	MM	-	26	-	32	-	38	-	42	50		62	
P	MM	37±0,02		46±0,02		50±0,02		56±0,02		66±0,02		79±0,02	
Q	MM	6		8		8		10		16		16	
R	MM	M 6		M 8		M 8		M 10		M 14		M 14	
S	MM	63	88	75	102	84,5	107,5	94	119	139,5	171,5	190,5	253,5
T	MM	6		6		6		6		9		9	
U	MM	15		20		25		25		30		40	
V	MM	6		6		6		6		5		8	
W	MM	19		19		25		30		33		50	

All dimensions are nominal unless tolerance is stated. (1 daN = 1,02 kg)

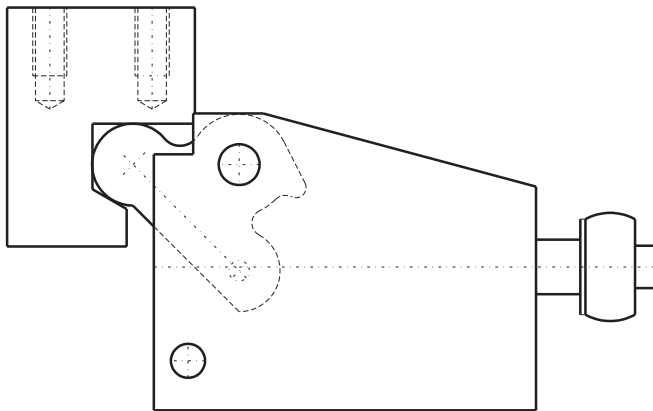
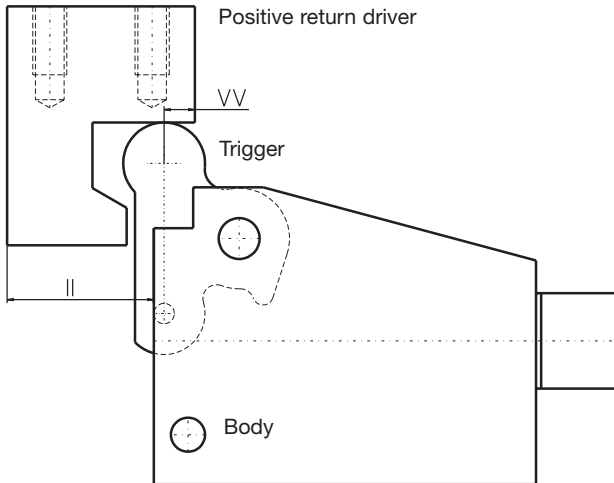
Popular options

3. Positive return option:

- Available on all units.
- To use it with angle mount options, call DANLY.
- Can be used when mounting at angles of $\pm 15^\circ$.
- Conversion kit contains driver and appropriate rappel.

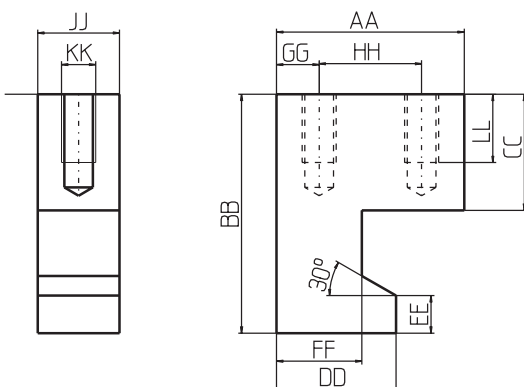
Why risk die damage!

How the positive return works ...



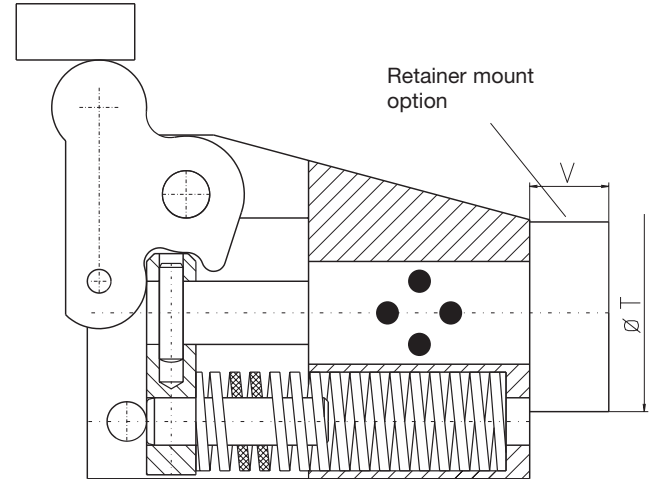
As die opens driver lifts trigger creating a positive return.

Positive return driver



4. Retainer mount option:

- Mount standard retainers to machinable face.
- Use the standard or special tooling you select.
- This option available only on:
C-0625-11/-12, C-1000-12/-13 und C-1500-12/-13
- Positive Return option available, special rappel.
- Locating flat for easy punch alignment.



Retainer mount dimensions

Cat. Reference	Unit	C - 0625 - 11 C - 0625 - 12	C - 1000 - 12 C - 1000 - 13	C - 1500 - 12 C - 1500 - 13
C	MM	6 - 8 - 10 - 13	8 - 10 - 13 - 16	20 25
T	MM	50	64	80 89,5
V	MM	20	25	30 30

Positive return driver dimensions

Cat.-Ref.	Unit	C-0250	C-0375	C-0500	C-0625	C-1000	C-1500
A A	MM	30	40	50	55	58	82
B B	MM	45	50	60	70	85	115
C C	MM	21	25	29	34	40	50
D D	MM	17	27	33	35	37	48
E E	MM	8	9	10	11	13	15
F F	MM	11	21	25	25	25	32
G G	MM	6	8	10	12,5	14	20
H H	MM	18	24	30	30	30	42
I I	MM	24	34	41	46	53	74
J J	MM	15	19	22	24	28	41
K K	MM	M6	M6	M8	M10	M12	M16
L L	MM	16	16	20	20	25	32
V V	MM	6	6	6	6	5	8

CAMDRIVE® rappel/Positive return driver

The rappel is an internal component that differs with each available option.

A rappel can always be changed to a different configuration later providing maximum user flexibility.



Worksheet and ordersheet for CAMDRIVE® piercing units

<input type="checkbox"/> Inquiry Your inquiry-no.:	<input type="checkbox"/> Order Your order-no.:	Date: Number of pages:
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Company: Phone:

Street: Fax:

Postal Code/Town: Contact Person:

Catalogue Reference	Tonne [t]	max. stroke [mm]	Basic unit	Punch diameter \varnothing (D) [mm]	Option 1	Option 2	Option 3	Option 4	Qty. [part]
			(without options Diameter D = D _{max})		(with shaped punch, with flat head)	(for angle mounting between 15° - 30°)	(with Positive Return)	(with Retainer mount option)	
C 0250-11	1	9,5	<input type="checkbox"/> (D _{max} = 4,7 mm)	D =	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	--
C 0250-12	1	19,0	<input type="checkbox"/> (D _{max} = 4,7 mm)	D =	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	--
C 0375-11	2	13,0	<input type="checkbox"/> (D _{max} = 7,9 mm)	D =	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	--
C 0375-12	2	22,0	<input type="checkbox"/> (D _{max} = 7,9 mm)	D =	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	--
C 0500-11	3	16,0	<input type="checkbox"/> (D _{max} = 11,0 mm)	D =	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	--
C 0500-12	3	25,0	<input type="checkbox"/> (D _{max} = 11,0 mm)	D =	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	--
C 0625-11	5	19,0	<input type="checkbox"/> (D _{max} = 14,2 mm)	D =	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/> (T = 50,0)
C 0625-12	5	28,0	<input type="checkbox"/> (D _{max} = 14,2 mm)	D =	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/> (T = 50,0)
C 1000-12	10	32,0	<input type="checkbox"/> (D _{max} = 22,4 mm)	D =	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/> (T = 64,0)
C 1000-13	10	50,0	<input type="checkbox"/> (D _{max} = 22,4 mm)	D =	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/> (T = 64,0)
C 1500-12	18	38,0	<input type="checkbox"/> (D _{max} = 31,0 mm)	D =	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/> (T = 80,0)
C 1500-13	18	63,0	<input type="checkbox"/> (D _{max} = 31,0 mm)	D =	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/> (T = 80,0)

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Note:

- If not specified, the units are delivered as basics with a mounted blank punch- $\varnothing = D_{max}$.
- For your application, specify the round shape punch diameter and needed options with our worksheet and/or sketches.
- For option 1 we need a sketch for these punches.
- In case of several CAMDRIVE® with the same number but different options, please take a separate work- or ordersheet.

Please place your inquiries and orders at:
DANLY UK Limited · Unit 1 · Mucklow Hill 1 Trading Estate
Mucklow Hill · Halesowen · West Midlands · B62 8DF
Telephone: 0121 585 7171 · Facsimile: 0121 585 7272 · E-mail: sales@danlyuk.com

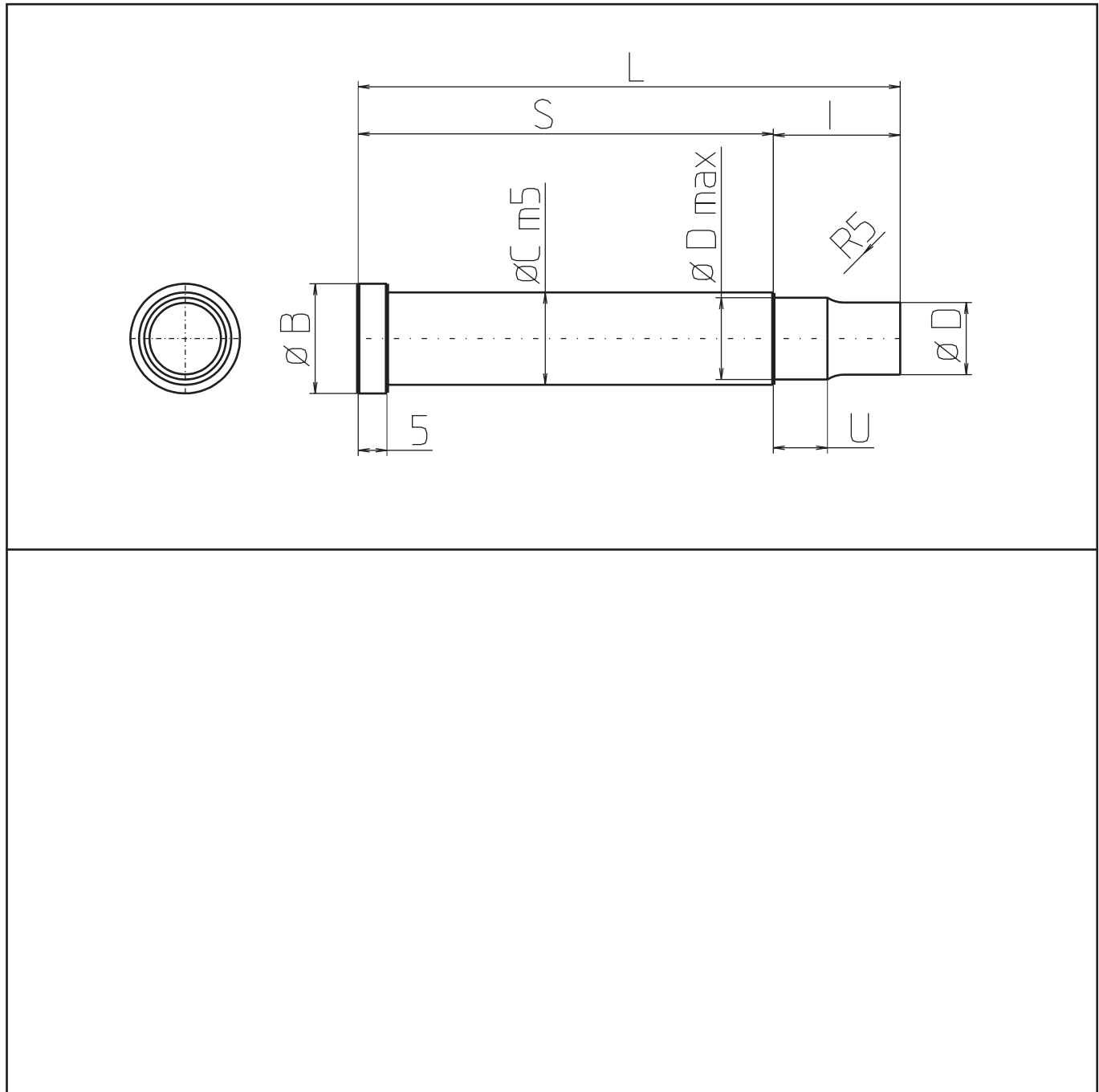
Worksheet and ordersheet for CAMDRIVE® piercing units

<input type="checkbox"/> Inquiry Your inquiry-no.:	<input type="checkbox"/> Order Your order-no.:	Date: Number of pages:
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Company: Phone:

Street: Fax:

Postal Code/Town: Contact Person:



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