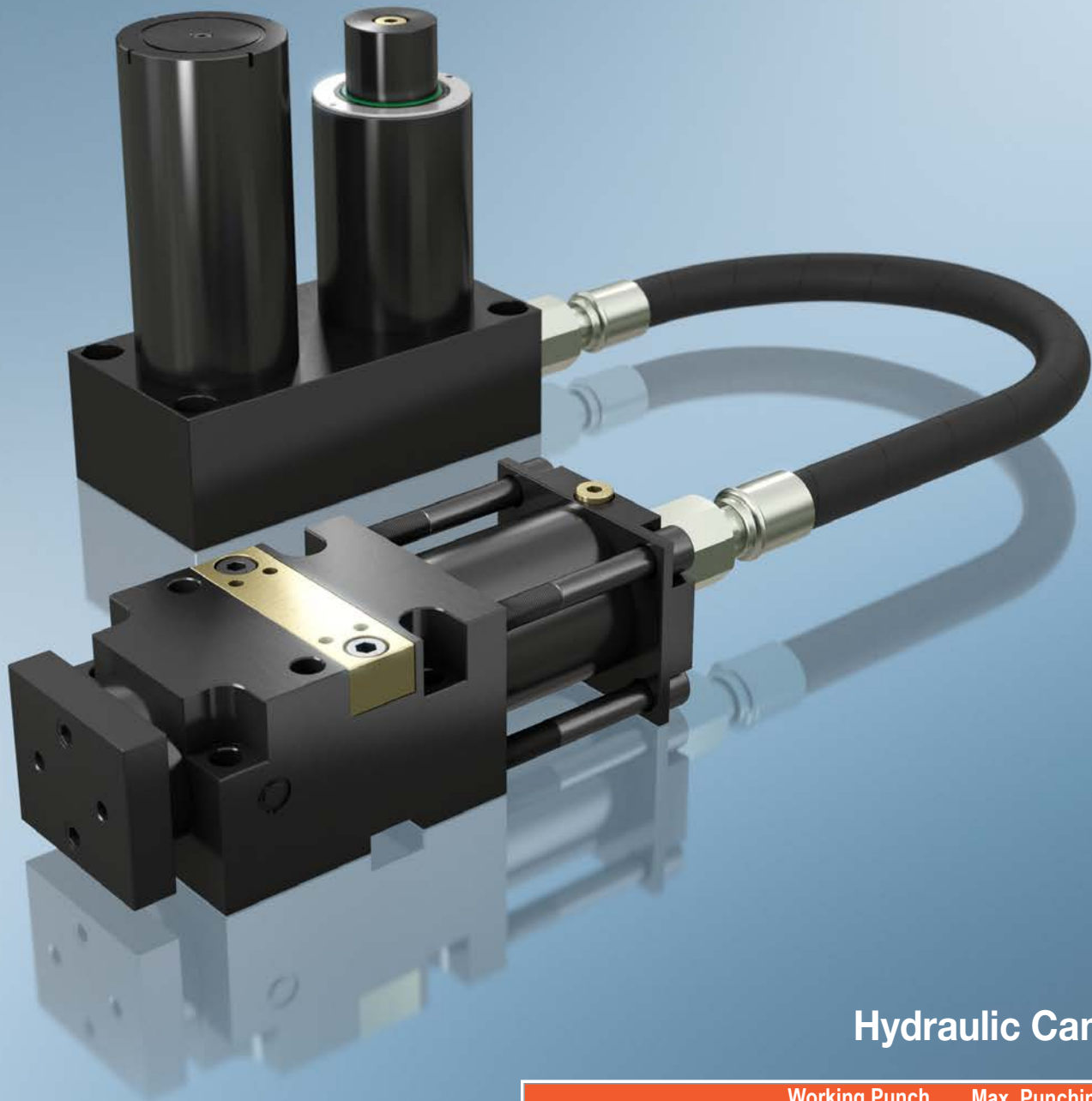


READY

THE INNOVATOR OF OUR INDUSTRY®

Introducing Our New Line of
Hydraulic Cams® - The RTCH Series

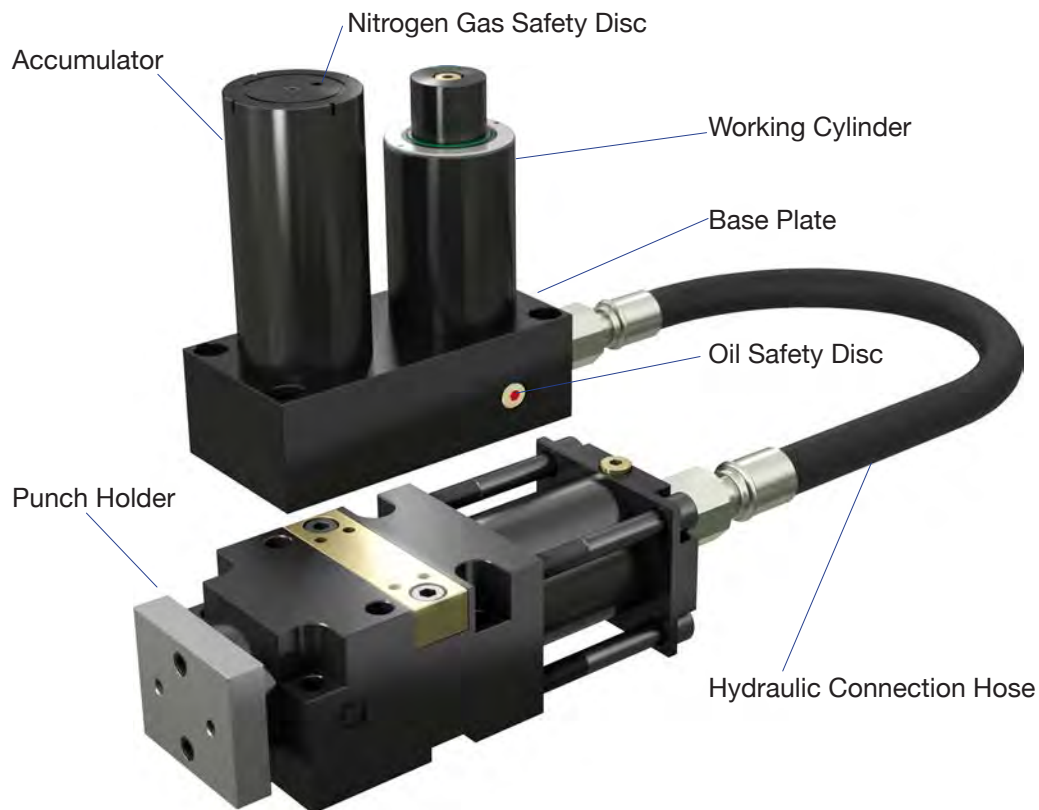


Hydraulic Cams

Code	Working Punch Stroke mm	Max. Punching Force daN
RTCH 3000 - <i>page 6</i>	25, 50, 80	3000
RTCH 7500 - <i>page 8</i>	25, 50, 80	7500
RTCH 12000 - <i>page 10</i>	25, 50, 63	12000

Description

Hydraulic cams can freely operate in any position and at any angle in space for stamping, folding, punching operations, etc.. thanks to the flexible distribution of forces.



Drive Unit

The drive unit supplies the working pressure by means of oil. It consists of the following elements:

- Working cylinder
- Pressure accumulator
- Manifold plate

The accumulator is capable of absorbing all the volume displaced by the working cylinder if the cam stroke is blocked.

Working Cam

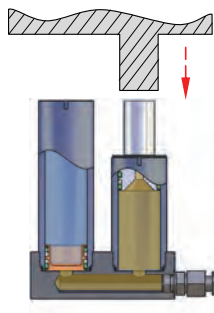
The working cam is controlled through the drive unit. It has a gas spring that produces the recoil force.

It is suitable for working applications with both round punches and punches with other shapes, thanks to its anti-turning device.

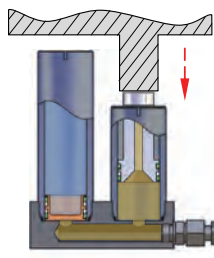
Hydraulic Connection Hose

There is a high pressure hose that connects the drive unit with the working cam. Fittings with O-rings are used to guarantee a perfect fit of the elements to avoid leaking.

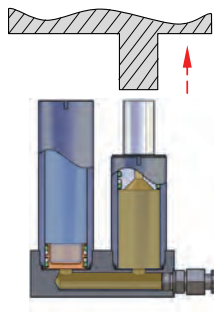
Operation



The working cylinder is made to work by the movement of the press, moving the hydraulic volume from the drive unit to the working cam through the hoses.

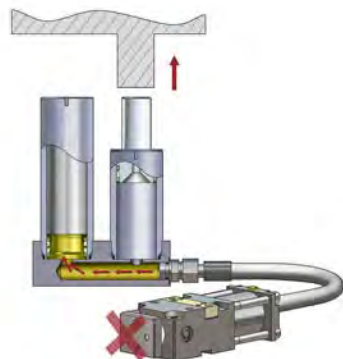


As soon as the hydraulic pressure exceeds the counterforce exerted by the gas spring, the cam starts its working stroke. At the end of the cam working stroke, the system pressure increases to equal the pressure of the nitrogen gas pressure accumulator. The gas spring has an extra 15mm overstroke capacity to ensure an identical pressure increase in each cycle. The excess volume of oil produced by the overstroke is absorbed by the pressure accumulator.



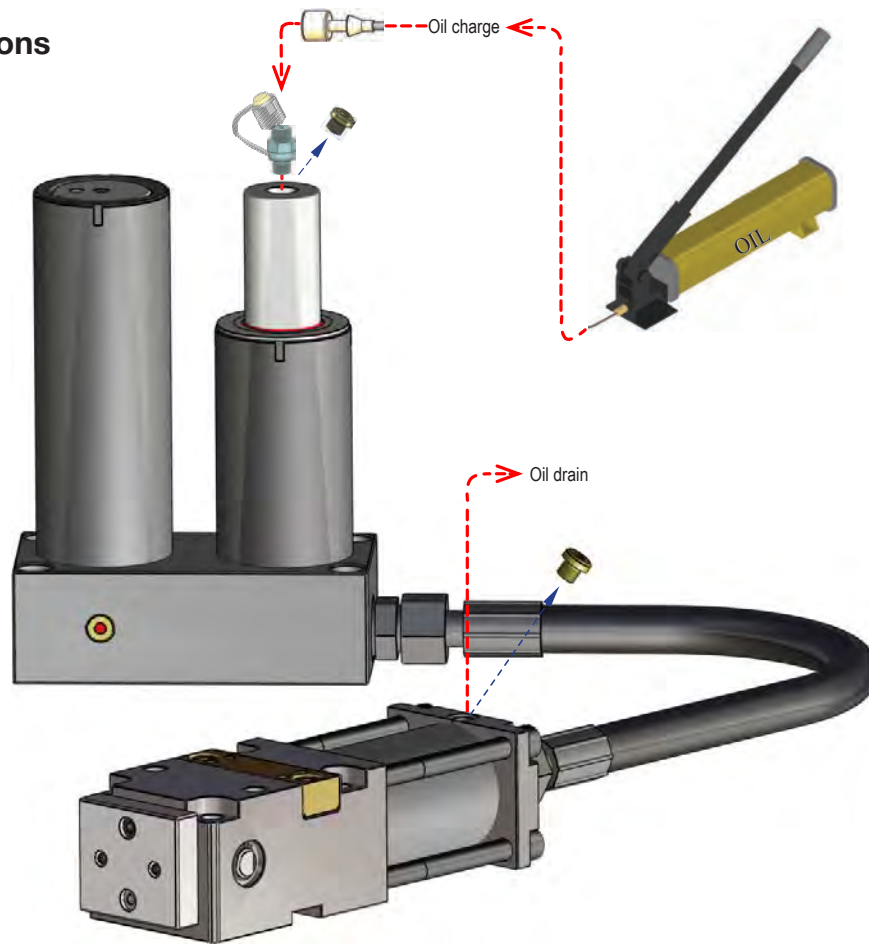
When the press stops acting on the working gas spring of the drive unit, the cam returns to its initial position thanks to the recoil of the gas spring.

Safety Function



In the event that the cam working stroke is partially or completely hindered, the accumulator can completely absorb the displaced oil thereby avoiding any risk of breakage or explosion.

Assembly Instructions



Installation Instructions

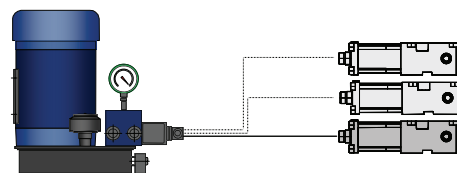
Once the assembly of all components has been completed, proceed as follows:

1. Remove the cap from the oil filler hole.
2. Remove the cap from the oil drain hole.
3. Connect the oil pump minimess hose terminal to the oil filling hole.
4. Charge with oil by making it circulate throughout the system, until it is free of air bubbles, by purging such air bubbles through the outlet.
5. Remove the oil filler items and close the oil charging and oil draining holes with the corresponding safety screws.
6. The system is now ready for operation.

How To Order

RTCH 3000	x	50	
<i>Code</i>		<i>Stroke</i>	25mm 50mm 63mm (only RTCH 12000) 80mm (only RTCH 3000 & RTCH 7500)

Alternative Drawer



As an alternative to normal operation in presses, working cams also can be made to work by means of a hydraulic group that sends pressurized oil to the cams.

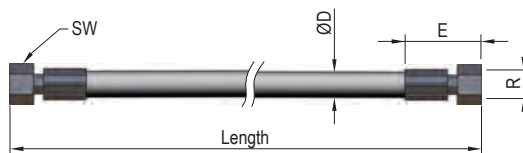
Hoses

Connection Hose - RTRR

How to Order

RTRR.01 - 500

Code Length



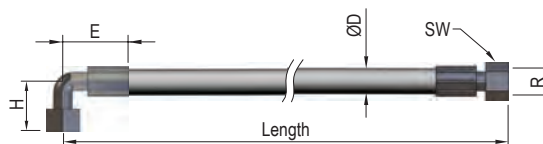
Code	RTCH Model	ØD mm	E mm	R	SW mm
RTRR.01	RTCH 3000	21.2	≈63.5	M24x1.5	30
RTRR.02	RTCH 7500	28.2	≈76.5	M30x2	36
RTRR.03	RTCH 12000	36.1	≈100.5	M42x2	50

Connection Hose - RTRC

How to Order

RTRC.03 - 750

Code Length



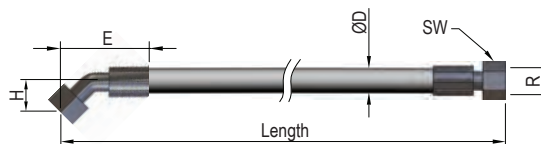
Code	RTCH Model	ØD mm	E mm	R	SW mm
RTRC.01	RTCH 3000	21.2	≈ 49	M24x1.5	30
RTRC.02	RTCH 7500	28.2	≈ 63	M30x2	36
RTRC.03	RTCH 12000	36.1	≈ 79.5	M42x2	50

Connection Hose - RTCC

How to Order

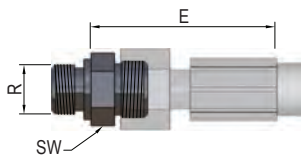
RTCC.02 - 325

Code Length



Code	RTCH Model	ØD mm	E mm	R	SW mm
RTCC.01	RTCH 3000	21.2	≈ 24	M24x1.5	30
RTCC.02	RTCH 7500	28.2	≈ 31	M30x2	36
RTCC.03	RTCH 12000	36.1	≈ 35	M42x2	50

Connection Record - RTTF



Code	RTCH Model	E mm	R	SW mm
RTTF.01	RTCH 3000	≈ 37	1/2"	27
RTTF.02	RTCH 7500	≈ 42	3/4"	32
RTTF.03	RTCH 12000	≈ 46	1"	46

RTTF Hose



Code	RTCH Model	ØD mm	Min. Curvature Radius mm	Working Pressure Bar	Breakage Pressure Bar
RT...01	RTCH 3000	21.2	90	345	1380
RT...02	RTCH 7500	28.2	160	280	1120
RT...03	RTCH 12000	36.1	210	200	950