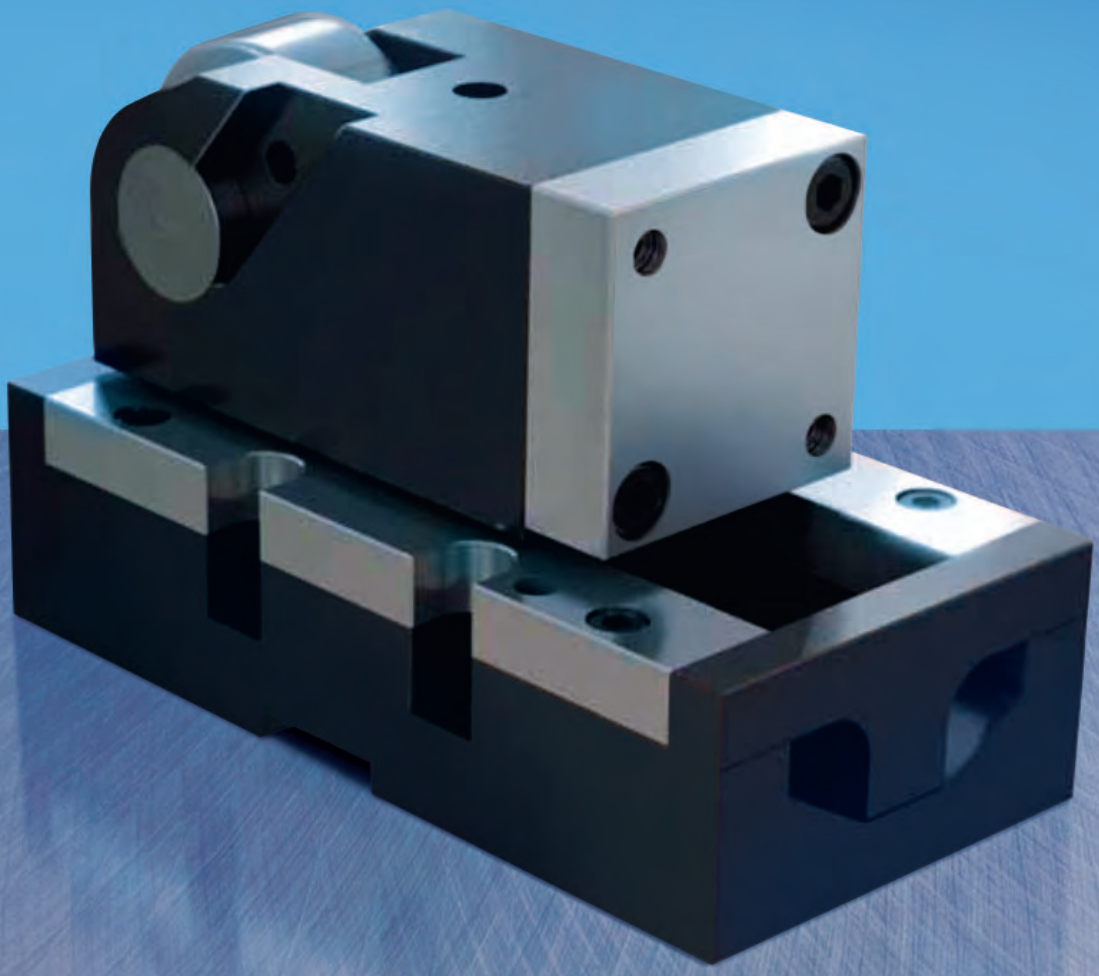
READY

THE INNOVATOR OF OUR INDUSTRY®

Introducing Our New Line of

Camdrive® Roller Cams

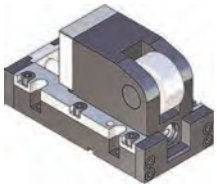


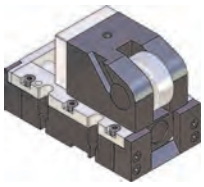
READY Roller Cams

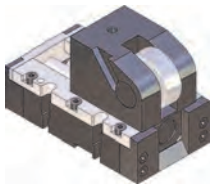
All cams are built with the finest materials and assembled with exact precision for product reliability and long life.

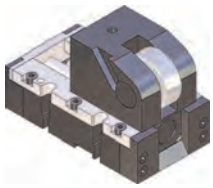
- 14 additional stroke lengths
- Special high production, high wear sliding plates
- Gas spring return

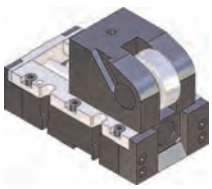
Six New Models





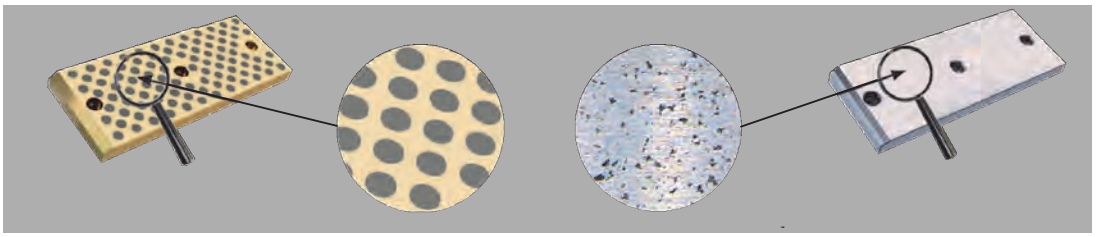






To satisfy the demand for modern tools, a new sintered steel material has been developed that combines lower rates of wear and tear in sliding plates with a long useful life and less maintenance.

This new generation of sliding elements is made of an iron-based porous sintered metal which provides the sliding element with a higher degree of solidity. This material is characterised by its solidity in medium-to-high speeds.



Traditional Bronze and Sintered Metal Comparison Chart

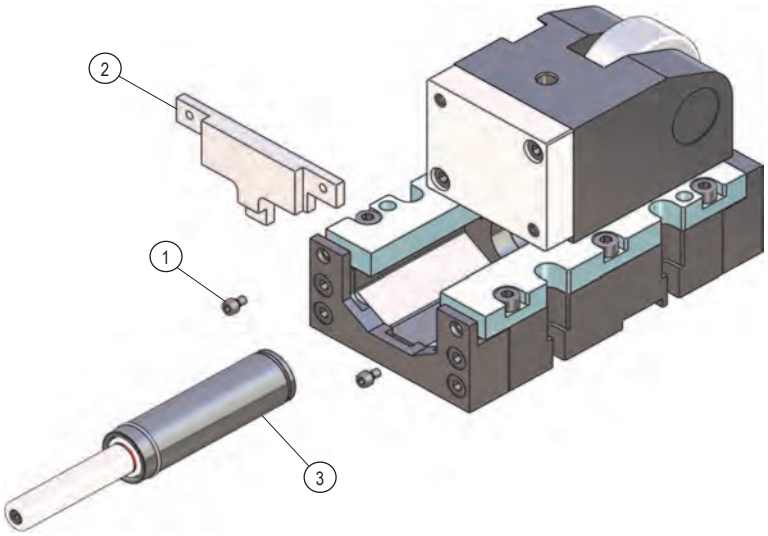
Characteristics	Bronze	Sintered Metal
Maximum sliding speed	15 m/min	70 m/min
Frictional coefficient	0,05 - 0,15	0,05 - 0,15
Surface pressure normal	35 N/mm^2	70 N/mm^2
Brinell hardness HB 10	190 - 220 HB S10/3000	-
Hardness of the sliding film	-	HRB60 - HRC20
Hardness of the base material	-	HRB80 - HRC40
Operating temperature	< 150 ºC	< 250 ºC
Max. unlubricated operating time	1000	3000
Integrated lubricant	Graphite	Fe + Cu + Graphite + MoS2
Portion of lubricant	20 - 35%	15 - 20%

Fe = Iron, Cu = Copper

Cylinder Extraction

Remove the screws (1) of the front plate and remove the gas spring stopper plate (2). The gas spring (3) is now free and can be removed from the cam.

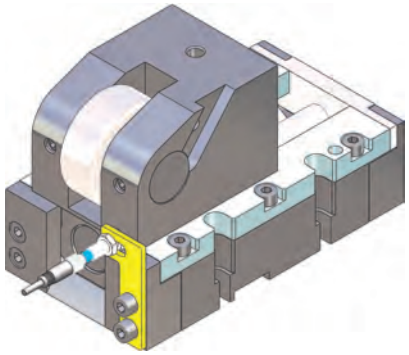
Once the gas spring has been extracted, the cam slide can be manually operated for adjustment operations. The slide will provide a sliding resistance on the baseplate of 20-40 daN.

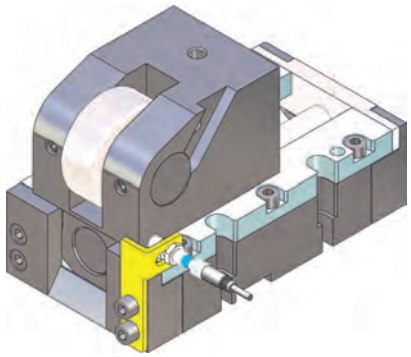


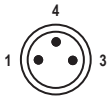
NOTE: Dismounting the gas spring allows for easier movement of the cam slide at the adjustement of the Roller cam units.

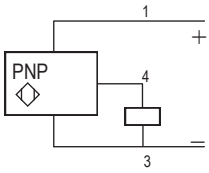
Passive Return Device (PRD)

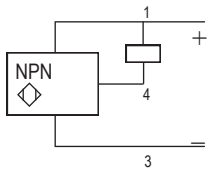
To insure that the roller cam has returned to its initial position, READY recommends the use of a PRD inductive sensor as a passive return device. Then if the gas spring fails and the cam does not return when the press ram goes back up, an alarm or a press shutdown can be activated.











Reference	Type	Function	Nominal sensing distance	Supply voltage	Switching capacity
PRD-1	PNP	NO	2mm	12...24VDC	200mA
PRD-2		NC			
PRD-3	NPN	NO			
PRD-4		NC			

How to order

PRD-1 - **R**

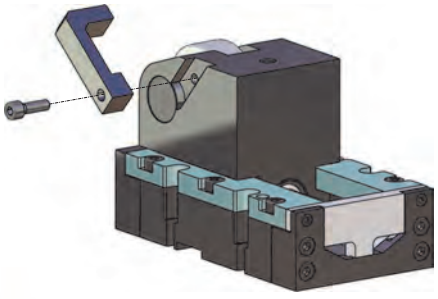
PRD-1: Model

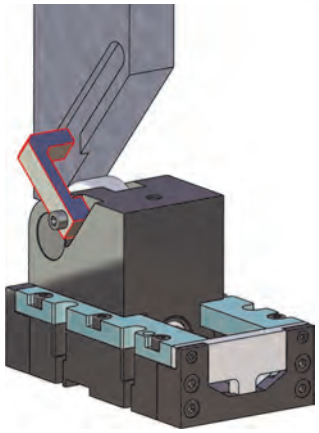
R: Connector

Active Return Device ARD 1

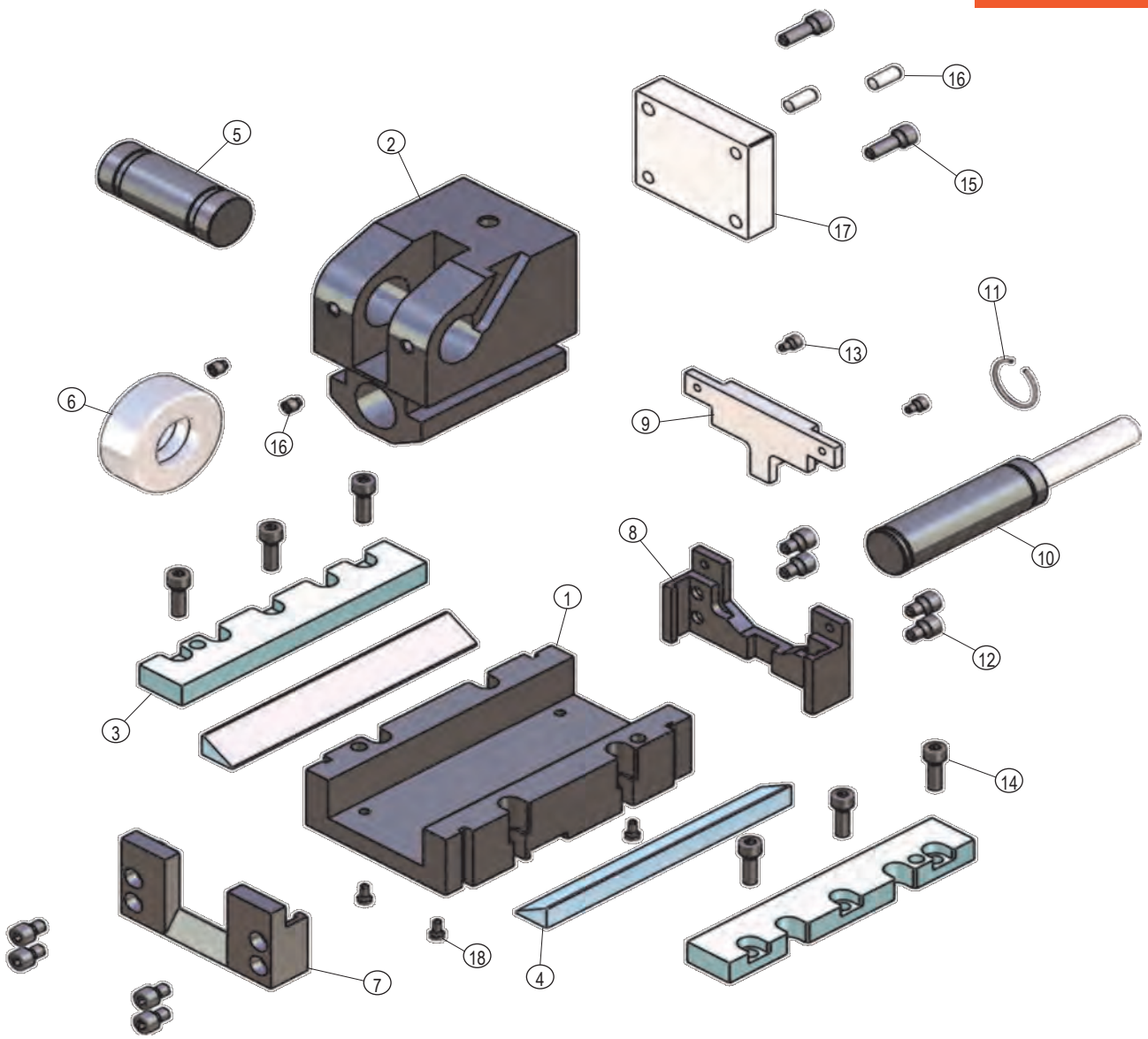
A gas spring is used to retract the cam. The force is adjusted in such a way that it is sufficient to slide the carriage back to its starting position. Depending on the operation, adding an active return can contribute to a higher degree of safety. For this purpose, the cam slide has a slot to accommodate an extractor hook for the active return, with which the cam slider is pulled backwards with higher separating forces, coming into operation in case of a gas spring failure.

The extractor hook is fitted in its housing and secured with a screw, as shown. The adjacent illustrates one option among a number of possible pusher designs. The customer is responsible for the construction of the pusher support. The extractor hook is available as an accessory at READY.



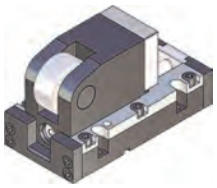


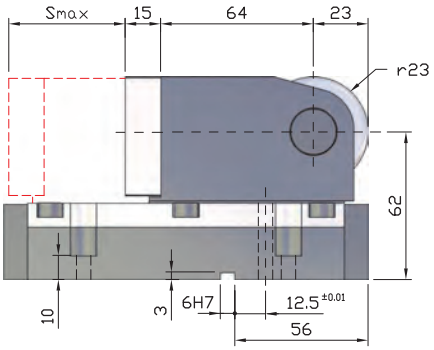
Reference	Cam Model
ARD-3-1	RTRC3000 / RTRCS3000
ARD-5-1	RTRC5000 / RTRCSS5000
ARD-15-1	RTRCS15000

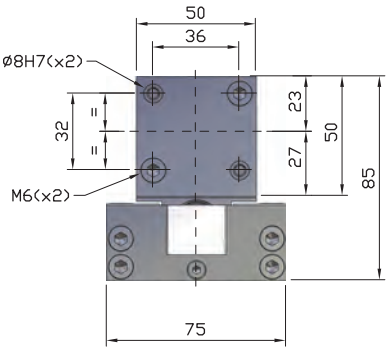


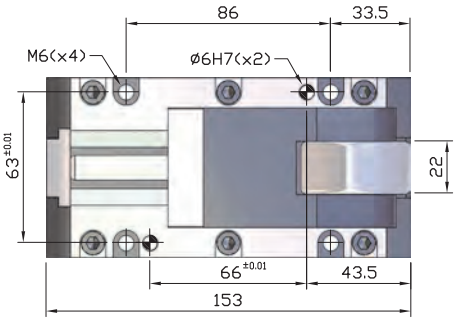
Part no.	Description	Quantity
1	Baseplate	1
2	Cam slide	1
3	Cover bar	2
4	Prismatic bar	2
5	Rod	1
6	Roll	1
7	Back limit plate	1
8	Limit plate in front	1
9	Insert pressure plate	1
10	Gas spring	1
11	Retainer ring	1
12	Screw ISO 4762	8
13	Screw ISO 7984	2
14	Screw ISO 4762	6
15	Screw ISO 4762	2
16	Dowel pin	2
17	Punch holder	1
18	Screw ISO 4762	4

RTRC 2000



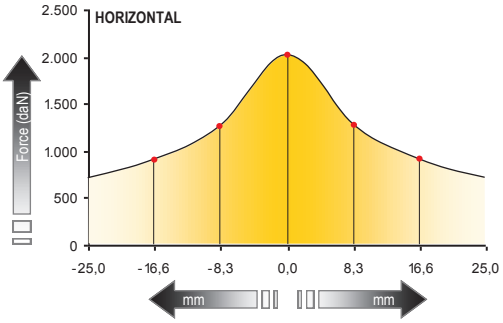


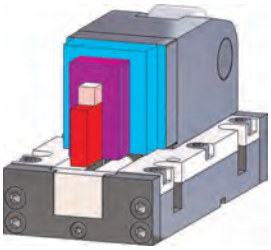


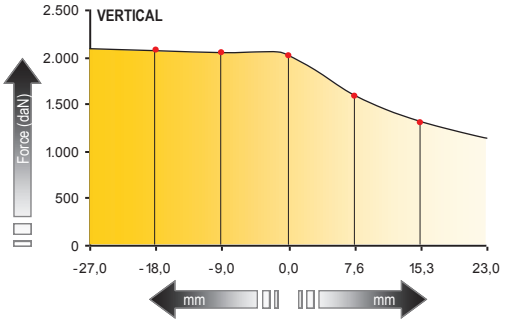


Model	mm	Max. punching force	Gas spring return force		Gas spring model	Max. working specifications		Max. width of driver	Kg
			Initial	Final		Velocity	Strokes / min		
RTRC 2000x50	50	2000 daN	140 daN	≈ 210 daN	MICRO 19x50	0,5 m/s	35	25 mm	3,95

Working Force Distribution

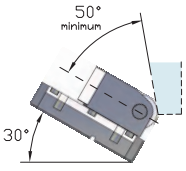


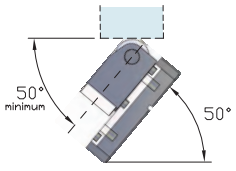




Maximum force that can be applied to the punch depending on eccentricity,
so that the stress in the assembly is the same as it was when the punch was completely centred.

Maximum Incline

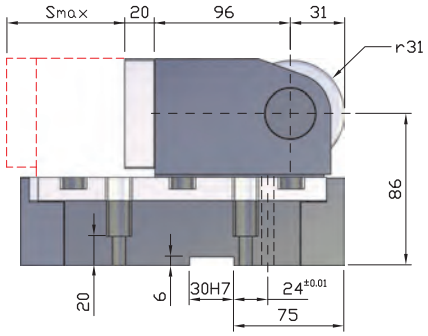


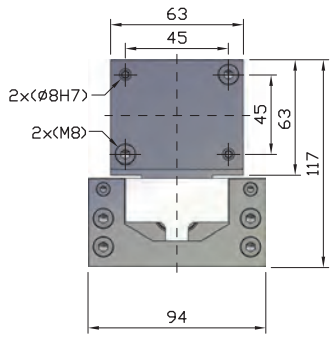


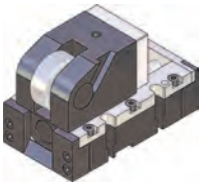
How to order

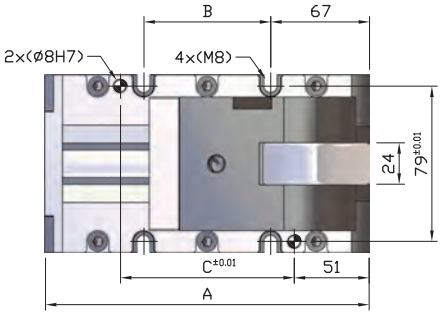
RTRC 2000 x 50

Model — Stroke





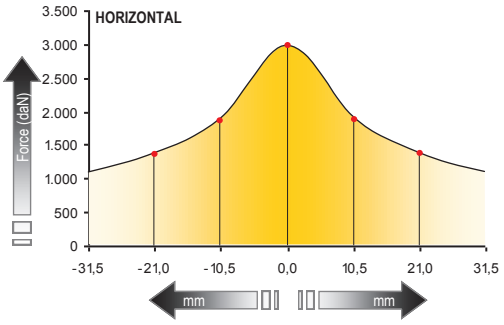


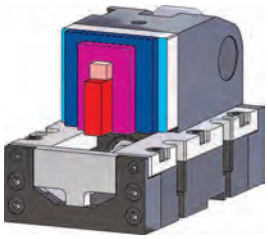


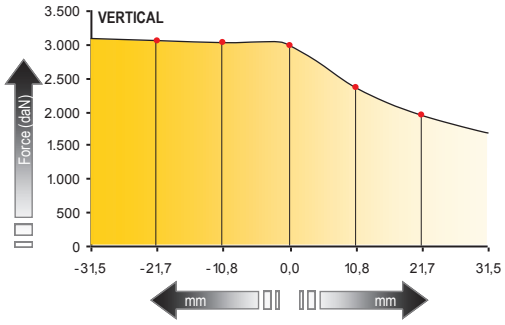
Model	A mm	B mm	C mm
RTRC 3000x50	190	56	88
RTRC 3000x80	220	86	118

Model	Smax mm	Max. punching force	Gas spring return force		Gas spring model	Max. working specifications		Max. width of driver	Kg
			Initial	Final		Velocity	Strokes / min		
RTRC 3000x50-1	50	3000 daN	400 daN	≈ 600 daN	TPK 32x50	0,5 m/s	40	35 mm	9,2
RTRC 3000x50-2			200 daN	≈ 270 daN	TPS 32x50				
RTRC 3000x80-1	80		400 daN	≈ 600 daN	TPK 32x80		35		10,0
RTRC 3000x80-2			200 daN	≈ 270 daN	TPS 32x80				

Working Force Distribution

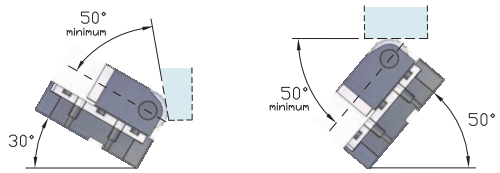






Maximum force that can be applied to the punch depending on eccentricity,
so that the stress in the assembly is the same as it was when the punch was completely centered.

Maximum Incline

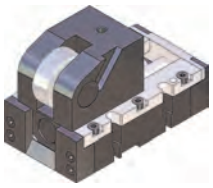


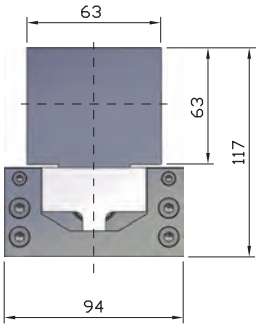
How to order

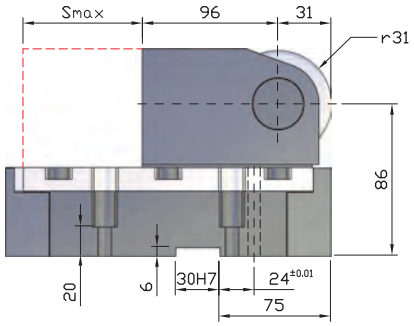
RTRC 3000 x 80 - 1

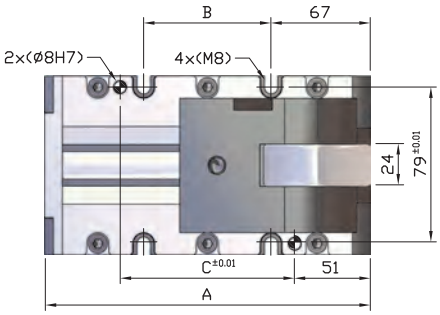
- RTRC 3000 — Model
- 80 — Stroke
- 1 — Gas spring model (1 - TPK series, 2 - TPS series)

RTRCS 3000





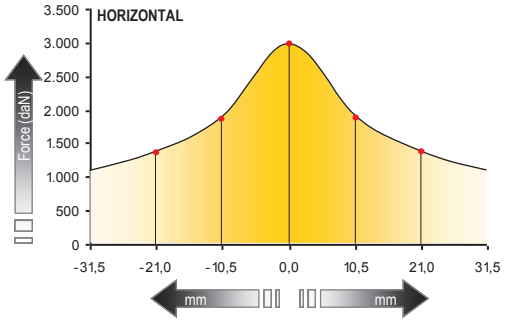


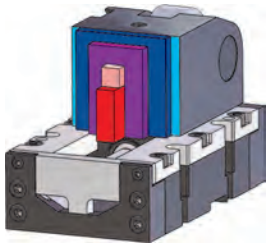


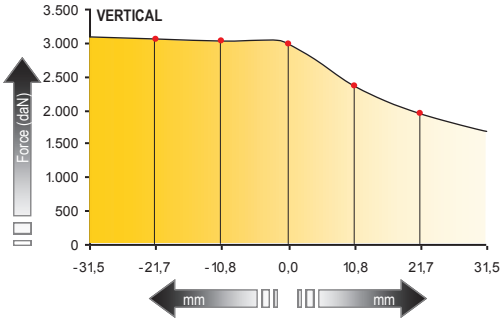
Model	A mm	B mm	C mm
RTRCS 3000x50	190	56	88
RTRCS 3000x80	220	86	118

Model	S max mm	Max. punching force	Gas spring return force		Gas spring model	Max. working specifications		Max. width of driver	Kg
			Initial	Final		Velocity	Strokes / min		
RTRCS 3000x50-1	50	3000 daN	400 daN	≈ 600 daN	TPK 32x50	0,5 m/s	40	35 mm	8,60
RTRCS 3000x50-2			200 daN	≈ 270 daN	TPS 32x50				
RTRCS 3000x80-1	80		400 daN	≈ 600 daN	TPK 32x80		35		9,40
RTRCS 3000x80-2			200 daN	≈ 270 daN	TPS 32x80				

Working Force Distribution

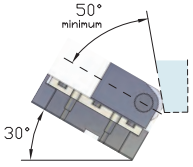


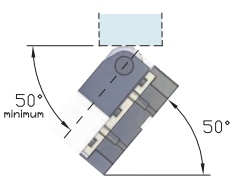




Maximum force that can be applied to the punch depending on eccentricity, so that the stress in the assembly is the same as it was when the punch was completely centred.

Maximum Incline

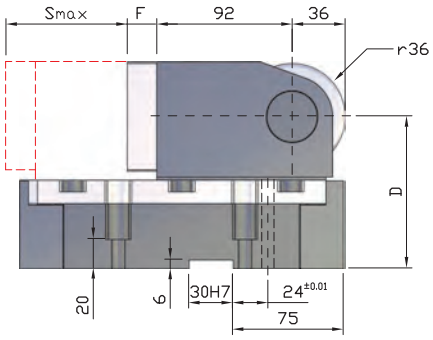


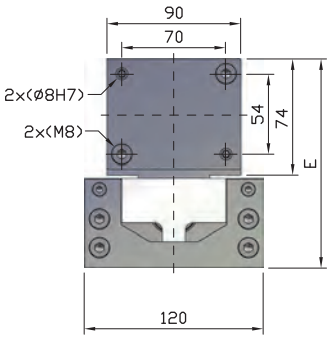


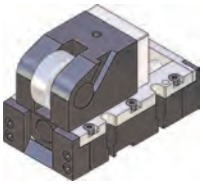
How to order

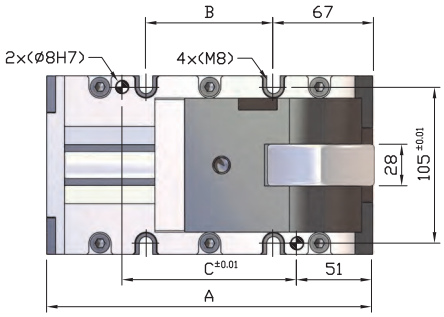
RTRCS 3000 x 50 - 1

- RTRCS 3000 — Model
- 50 — Stroke
- 1 — Gas spring model (1 - TPK series, 2 - TPS series ISO)





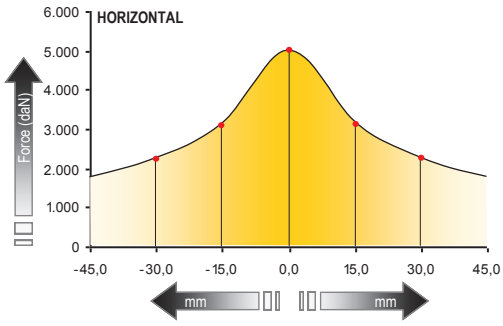


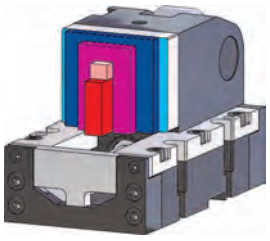


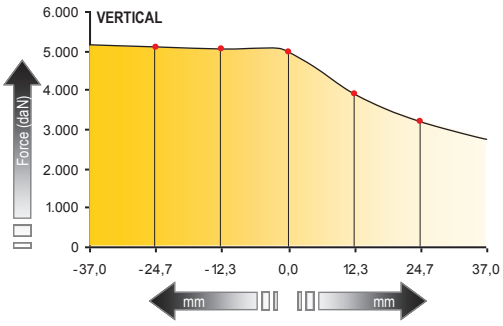
Model	A mm	B mm	C mm	D mm	E mm	F mm
RTRC 5000x50	190	56	88	103	140	20
RTRC 5000x80	220	86	118	103	140	20
RTRC 5000x100	260	126	158	120	157	30

Model	Smax mm	Max. punching force	Gas spring return force		Gas spring model	Max. working specifications		Max. width of driver	Kg
			Initial	Final		Velocity	Strokes / min		
RTRC 5000x50-1	50	5000 daN	400 daN	≈ 600 daN	TPK 32x50	0,5 m/s	40	40 mm	15,2
RTRC 5000x50-2			200 daN	≈ 270 daN	TPS 32x50				
RTRC 5000x80-1	80		400 daN	≈ 600 daN	TPK 32x80		35		16,0
RTRC 5000x80-2			200 daN	≈ 270 daN	TPS 32x80				
RTRC 5000x100-1	100		400 daN	≈ 600 daN	TPK 32x100		25		22,5
RTRC 5000x100-2			200 daN	≈ 270 daN	TPS 32x100				

Working Force Distribution

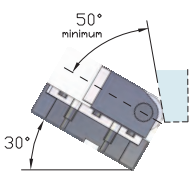


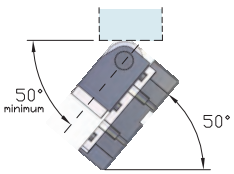




Maximum force that can be applied to the punch depending on eccentricity, so that the stress in the assembly is the same as it was when the punch was completely centered.

Maximum Incline





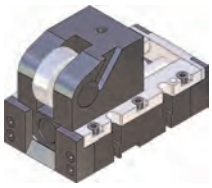
How to order

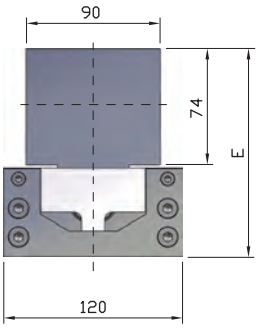
RTRC 5000 x 100 - 1

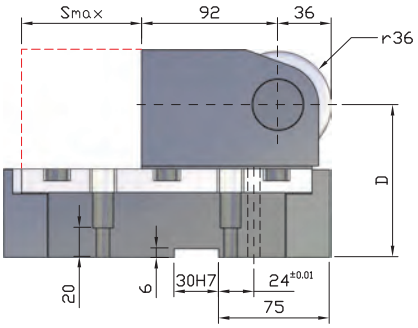
- RTRC 5000 — Model
- 100 — Stroke
- 1 — Gas spring model (1 - TPK series, 2 - TPS series)

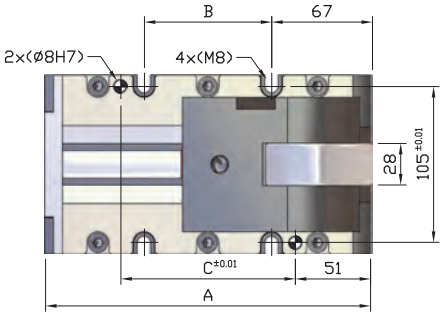
RTRCS 5000

READY





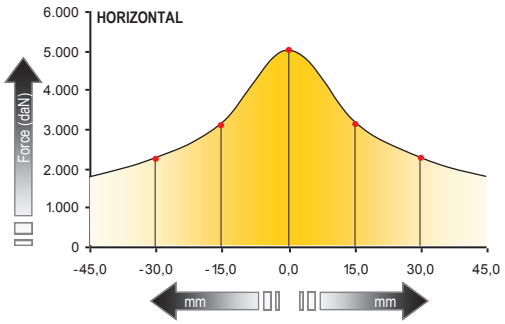


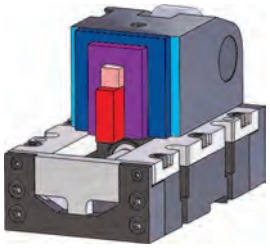


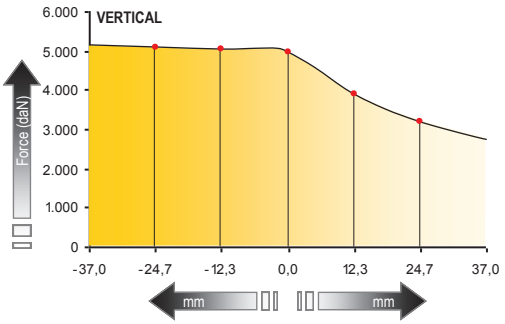
Model	A mm	B mm	C mm	D mm	E mm
RTRCS 5000x50	190	56	88	103	140
RTRCS 5000x80	220	86	118	103	140
RTRCS 5000x100	260	126	158	120	157

Model	S max mm	Max. punching force	Gas spring return force		Gas spring model	Max. working specifications		Max. width of driver	Kg
			Initial	Final		Velocity	Strokes / min		
RTRCS 5000x50-1	50	5000 daN	400 daN	≈ 600 daN	TPK 32x50	0,5 m/s	40	40 mm	14,20
RTRCS 5000x50-2			200 daN	≈ 270 daN	TPS 32x50				
RTRCS 5000x80-1	80		400 daN	≈ 600 daN	TPK 32x80		35		15,00
RTRCS 5000x80-2			200 daN	≈ 270 daN	TPS 32x80				
RTRCS 5000x100-1	100		400 daN	≈ 600 daN	TPK 32x100		25		21,00
RTRCS 5000x100-2			200 daN	≈ 270 daN	TPS 32x100				

Working Force Distribution

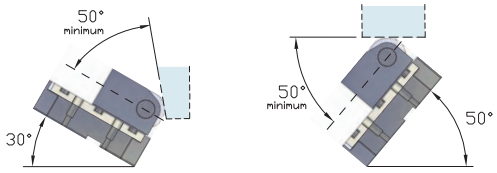






Maximum force that can be applied to the punch depending on eccentricity,
so that the stress in the assembly is the same as it was when the punch was completely centred.

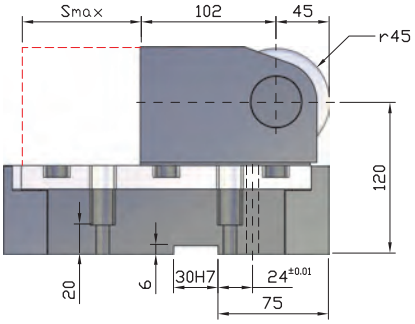
Maximum Incline

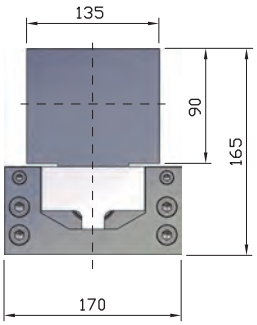


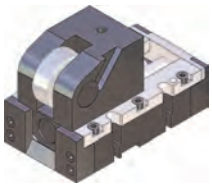
How to order

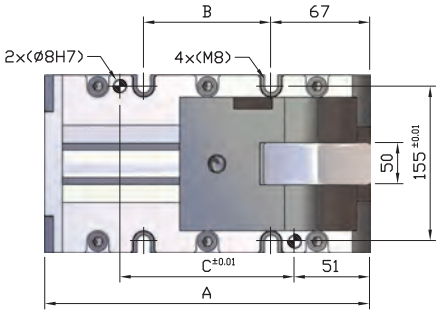
RTRCS 5000 x 80 - 2

Model | Stroke | Gas spring model (1 - TPK series, 2 - TPS series)





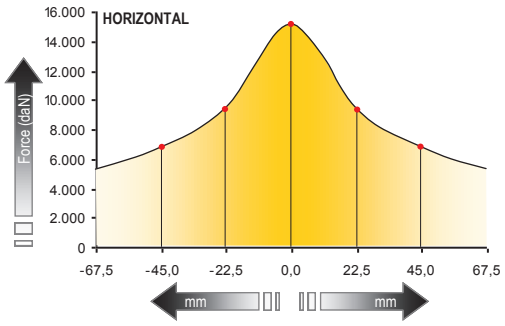


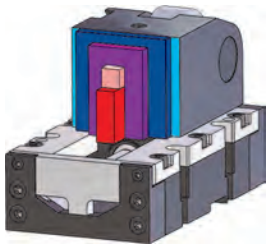


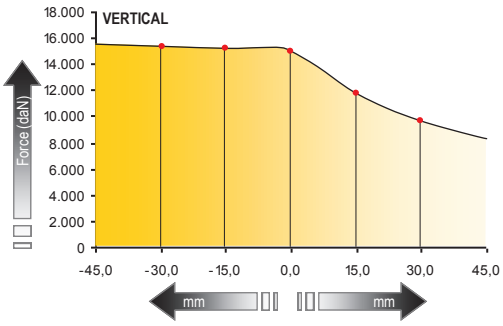
Model	A mm	B mm	C mm
RTRCS 15000x50	190	56	88
RTRCS 15000x80	220	86	118
RTRCS 15000x100	260	126	158

Model	S max mm	Max. punching force	Gas spring return force		Gas spring model	Max. working specifications		Max. width of driver	
			Initial	Final		Velocity	Strokes / min		
RTRCS 15000x50	50	15000 daN	400 daN	≈ 580 daN	2x TPC 25x50	0,5 m/s	35	65 mm	26,3
RTRCS 15000x80	80				2x TPC 25x80		25		27,6
RTRCS 15000x100	100				2x TPC 25x100		20		30,8

Working Force Distribution

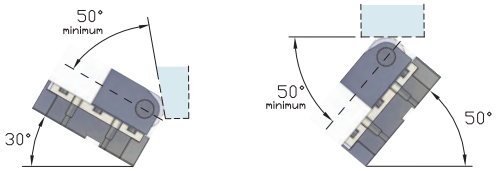






Maximum force that can be applied to the punch depending on eccentricity, so that the stress in the assembly is the same as it was when the punch was completely centered.

Maximum Incline



How to order

RTRCS 15000 x 100

Model — Stroke

The Innovator of Our Industry℠

Our factories and offices:

U.S.A. • U.K. • France • Belgium • Germany • Sweden • Netherlands • Singapore • India

READY TECHNOLOGY, INC.

333 Progress Rd. • Dayton, OH 45449
(800) 543-4355 • (937) 866-7200 • fax (937) 866-7226

www.readytechnology.com

CATALOG # 0613