

DANLY

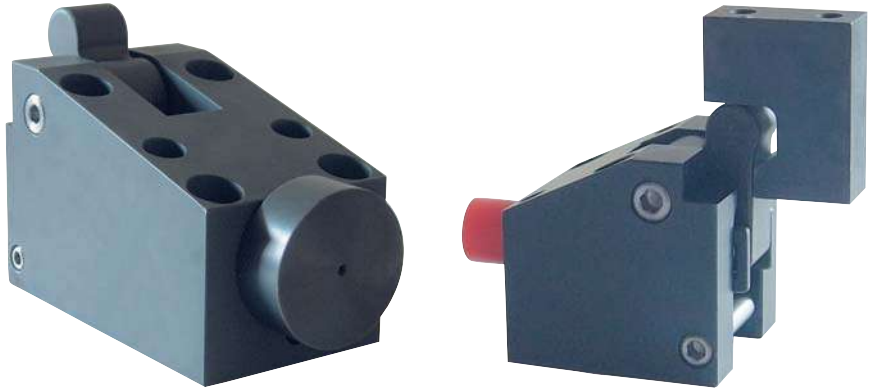
CAMDRIVE®

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:

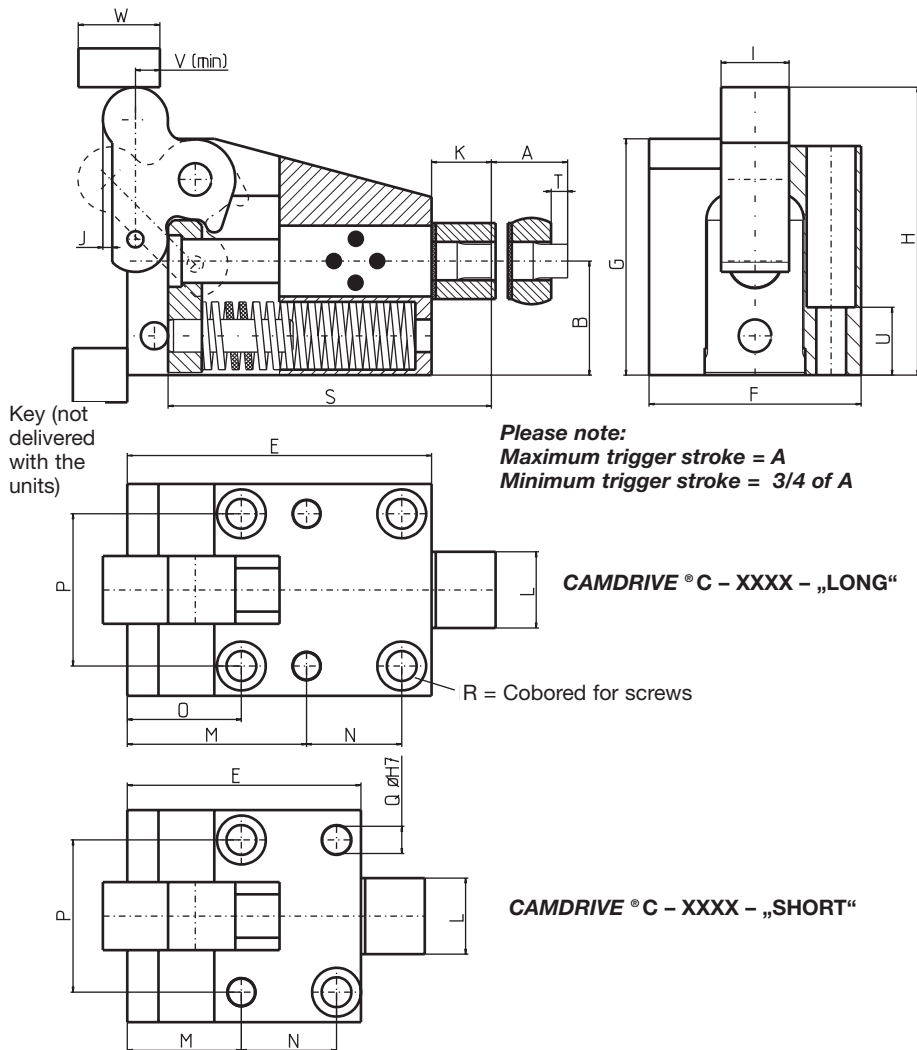
- Low cost, versatile design
- Fits in smallest die space
- Fast delivery ... even for options
- Interchangeable tolerances, metric
- Hardened components, high production
- All units are equipped with a mechanical die spring return ... a DANLY Spring

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



Please note:
Maximum trigger stroke = A
Minimum trigger stroke = 3/4 of 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

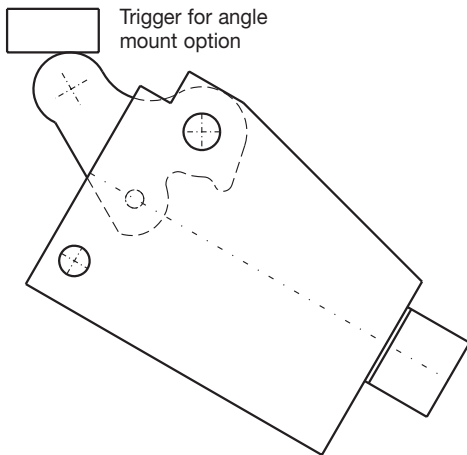
1. Shaped punch option:

- Round punch blank with flat on head supplied with this option.
- Rappel is equipped with with a matching flat tangent to punch body diameter (C).
- Rappel also is guided in CAMDRIVE® body for precision.
- Special shaped punches according to drawing available, longer delivery time and at extra charge.

DANLY recommend sharpening a punch no more than twice during the course of its life.
Special ejector style punches also available upon request.
Refer to the chart for dimensional data.

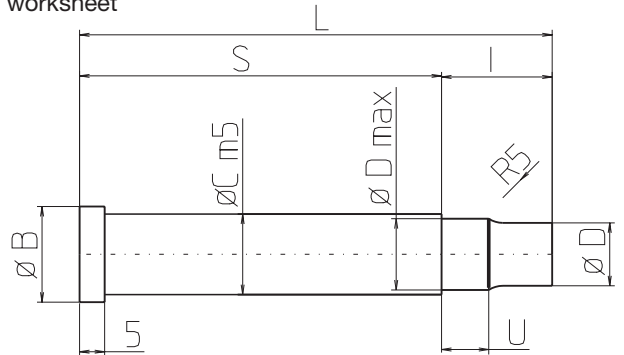
2. Angle mount option:

- Used when mounting at $\pm 15^\circ - 30^\circ$ (max.).
- Unit comes with trigger for angle mount.
- Positive Return option is not always available when angle mounting. Call DANLY for details.



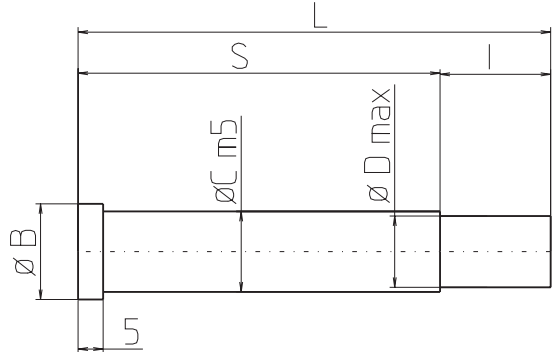
CAMDRIVE® Punch (pointed to order)

see worksheet



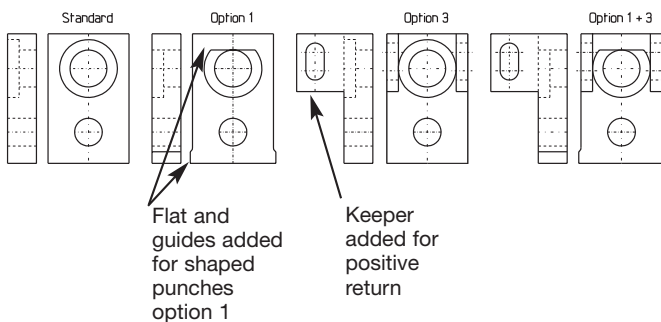
Model	Unit	C	D _{max.}	I	U
250	MM	6	4,7	22	9,4
375	MM	10	7,9	22	9,4
500	MM	13	11	22	9,4
625	MM	16	14,2	22	9,4
1000	MM	25	22,4	28,5	12,7
1500	MM	38	31	41,5	19

CAMDRIVE® Punch Blank



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.



Model	Unit	B	C	D	I	L	S
250-11	MM	9	6	4,7	22	63	41
250-12	MM	9	6	4,7	22	88	66
375-11	MM	13	10	7,9	22	75	53
375-12	MM	13	10	7,9	22	102	80
500-11	MM	16	13	11	22	85,5	63,5
500-12	MM	16	13	11	22	107,5	85,5
625-11	MM	19	16	14,2	22	94	72
625-12	MM	19	16	14,2	22	119	97
1000-12	MM	28	25	22,4	28,5	139,5	111
1000-13	MM	28	25	22,4	28,5	171,5	143
1500-12	MM	41	38	31	41,5	190,5	149
1500-13	MM	41	38	31	41,5	253,5	212

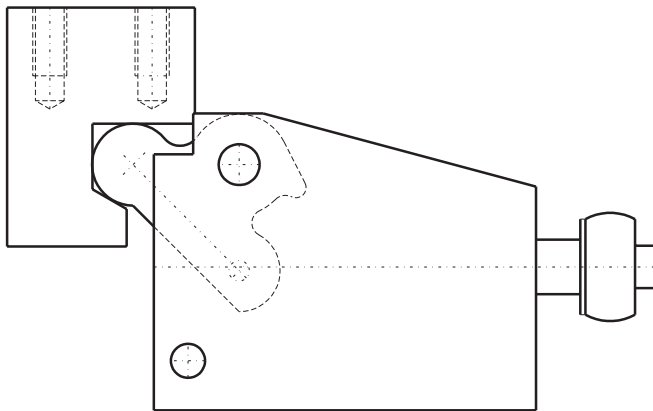
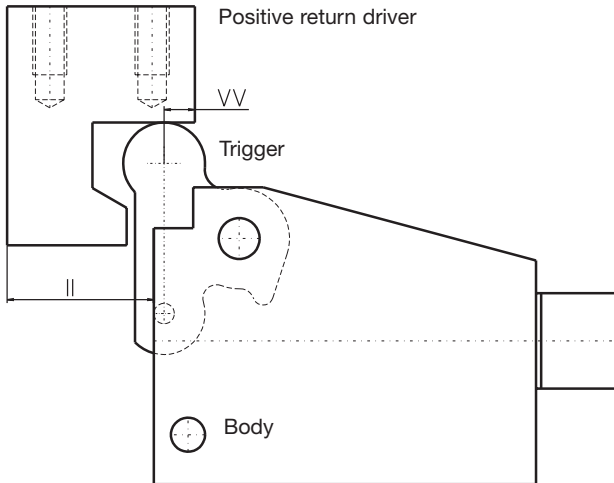
Popular options

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.

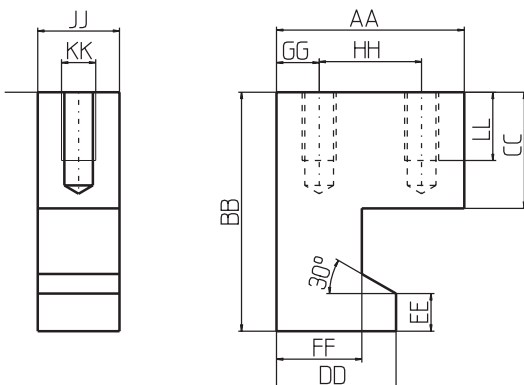
Why risk die damage!

How the positive return works ...



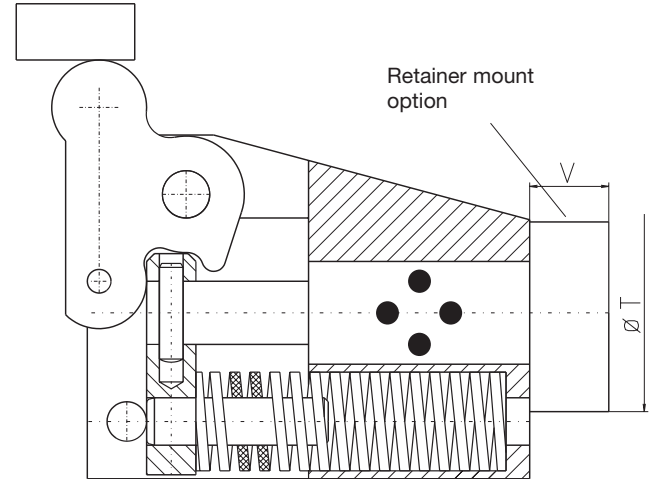
As die opens driver lifts trigger creating a positive return.

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
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Telephone: 0121 585 7171 · Facsimile: 0121 585 7272 · E-mail: sales@danlyuk.com

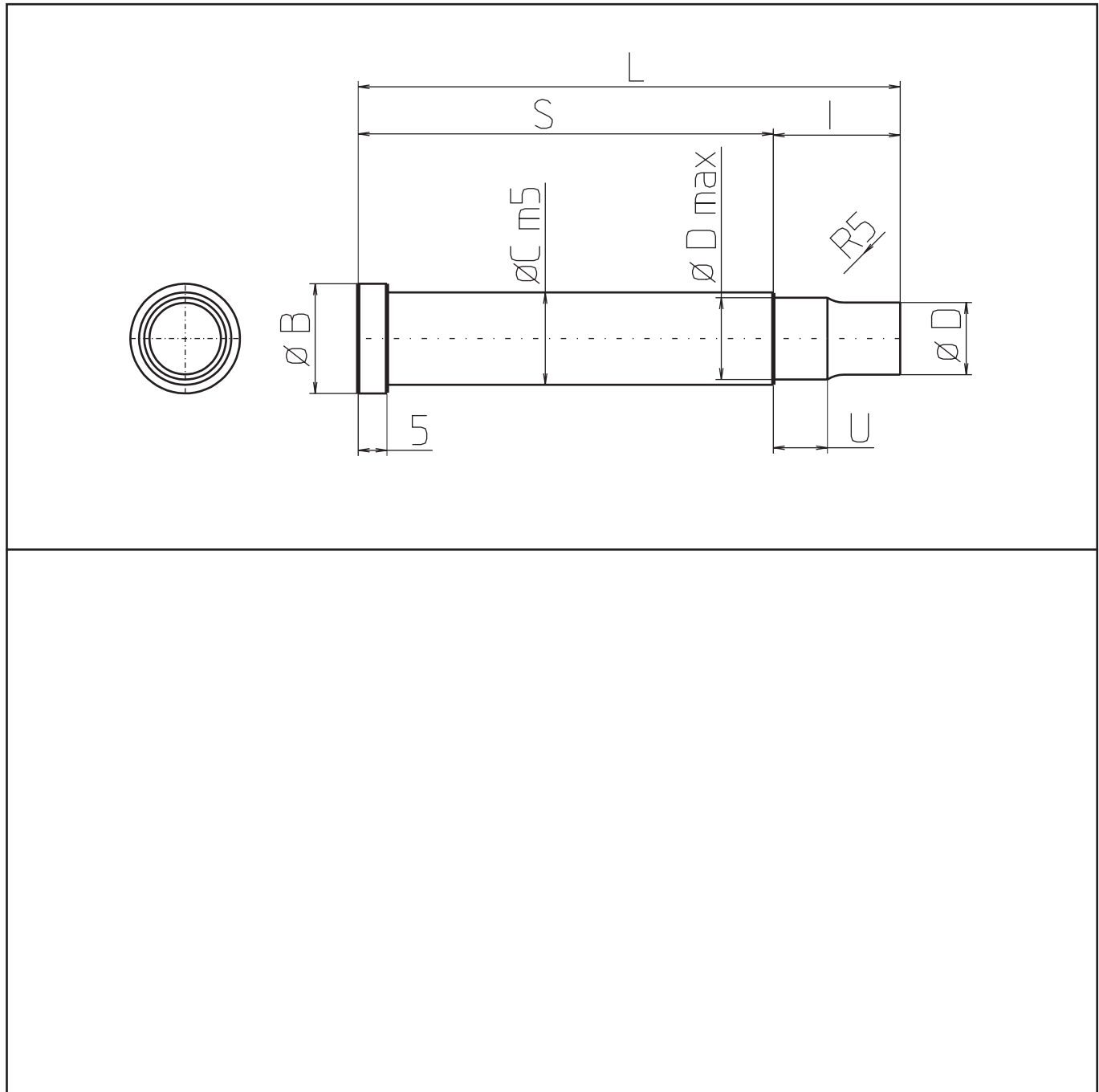
Worksheet and ordersheet for CAMDRIVE® piercing units

<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:



Please place your inquiries and orders at:
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