

High-performance servo feeder for stamping presses

# **Variax OPUS 1 Series**

*The Ultimate Servo Feeder*



# The Ultimate Servo Feeder



PAT.PEND.

## Variax OPUS 1 Series

The Variax OPUS1 series is a high-performance servo feeder that is optimal for use in motor core production lines for hybrid, PHEV, and EV car motors.

By integrating a high capacity servo motor and roll into one body, it achieves world-class performance. The driving servomotor is operated according to a unique cam curve. Servomotor and cam curves are also used to control vertical roll motion and the release mechanism, allowing the OPUS series to feed thin and soft materials.

The OPUS series control system is also equipped with a monitor function, diagnostic function, and a large monitor. Its communication function makes it possible to check the operation from a remote location. This combination greatly improves its operability.

### Features

- High-end model combining high speed, high precision and multiple functions
- The communication function allows you to check the status of the operation from a remote location
- Excellent operability with a security system
- Various display functions
- Global support for many languages, standards, and services
- Can feed wide, thin, and soft materials

#### Major Features:

Rapid stroke max. 1000min <sup>-1</sup>	High-speed feed more than 100m/min	Material width max. 650mm
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#### Applicable Material Shapes:

Thin plate	Materials with different shapes	Wire materials

## Product lines

High-performance servo feeder for stamping presses

### **Variax OPUS 1 Series**

**OPUS 1 -200**

**OPUS 1 -300**

**OPUS 1 -450**

**OPUS 1 -650**



### Peripheral equipment

An indexing/skewing drive system for rotating the motor cores used for electric motors in automobiles.

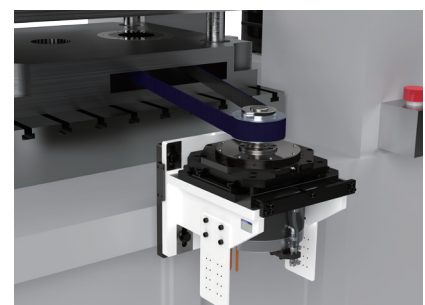
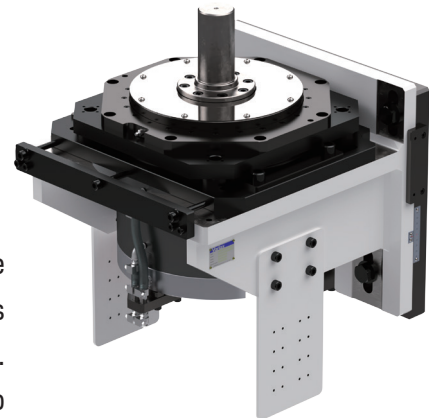
### **Servo-dex EVR1 Series**

**EVR1-230**

**EVR1-310**

The Servo-dex EVR1 series is an indexing or skewing drive system for rotating the motor core for production lines making motor cores for hybrid, PHEV, and EV car motors. By connecting a high-performance servo motor directly to the motor core, it can index core stacks with high-speed and high-torque, while allowing you to set the rotation angle freely.

With fusion of a servo motor and a cam motion curve, high speed and a variety rotational stacking build-ups are possible. This contributes to improved productivity of high-quality motor cores.



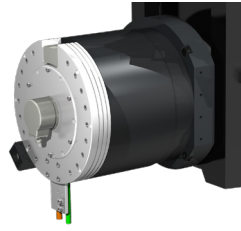
### Features

- High-end model combining high speed, high precision and multiple functions
- It also supports arbitrary rotation angle settings, and skew processing of the motor core
- The communication function allows you to check the status of the operation from a remote location
- Its high precision positioning increases mold life.
- The combination of a servo driven feeder and a servo-dex device results in maximum motor core line optimization

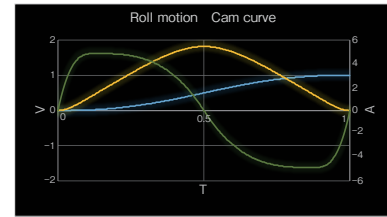
# Features

## Performance suitable for motor core press line making electric motors for automobiles

- By adopting a high-performance servomotor and unique cam curve, high-precision material feeding ( $\pm 0.03$  mm or less) is achieved at high speed (100 m / min or more)
- Contributes to productivity and improving yield



High-performance motor



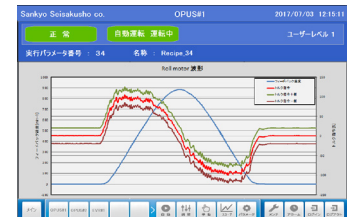
Original cam curve

## The communication function allows you to check the status of the operation from a remote location

- The OPUS1 status can be checked and the feed number can be switched by installing an optional CC-Link IE for communication.
- A safe system can be configured by combining this series with the optional press I/O device



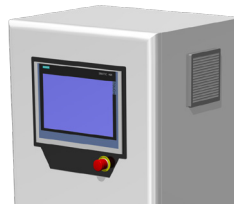
Automatic operation screen



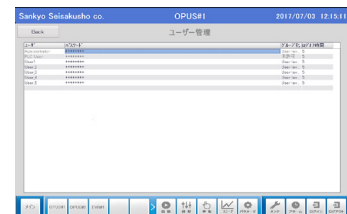
Motor torque waveform

## Safety system with excellent operability

- Comes with a 15 inch, large touch panel giving improved operability and visibility
- Management of 5 levels of user privileges, with passwords



15 inch touch panel



User management

## Exceptional quality and reliability

- Guaranteed reliable and stable operation due to our 40 years of experience with feeder development and the use of our proprietary technology
- Actual feed accuracy  $\pm 0.03$  mm
- Patented design to protect against press vibration (PAT.)
- Patented damping construction to protect the feed device (PAT.)

## Safety function

- When an emergency stop signal is input, this function instantly cuts off power to the motor and stops all operation
- Support to manual operations speed limit and hold-to run control switch
- Roll release function when jamming occurs (option)
- End-of-material detection signal output (optional)



Alarm screen



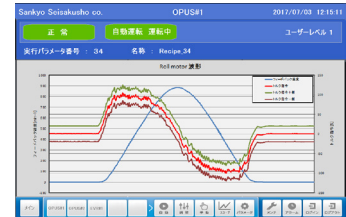
JOG screen

## Various display functions

- Displays the motor temperature and effective torque value
- Displays the feed length, feed angle, release angle, and gripping force
- Displays the feed range and release range of the feeder
- Displays the current angle or the speed of the press machine



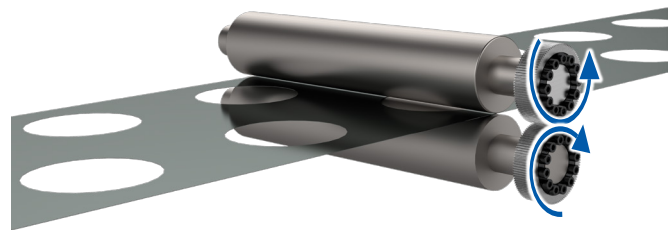
Automatic operation screen



Motor torque waveform

## Can feed wide, thin, and soft materials

- Due to the use of dual roll drives, it can reliably feed materials with a lower gripping force



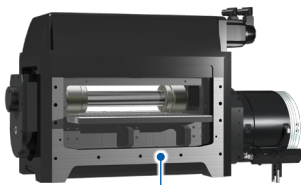
## Global support for many language, standards, and services

- Languages: Japanese, English, Chinese, Spanish, and Korean
- IEC standard, CE standard (option), UL standard (option)
- We have service people living in Japan, the USA, China, Korea, Thailand, and India



## Easy to install in a press

- Standardized side mounting and bracket mounting on presses
- The main body can be used for either left or right side mounting



Mounting face

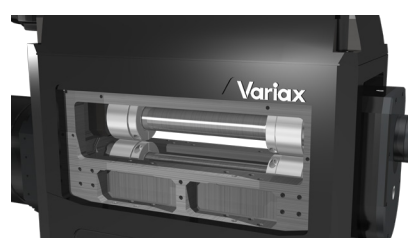


Side mounting plate (option)



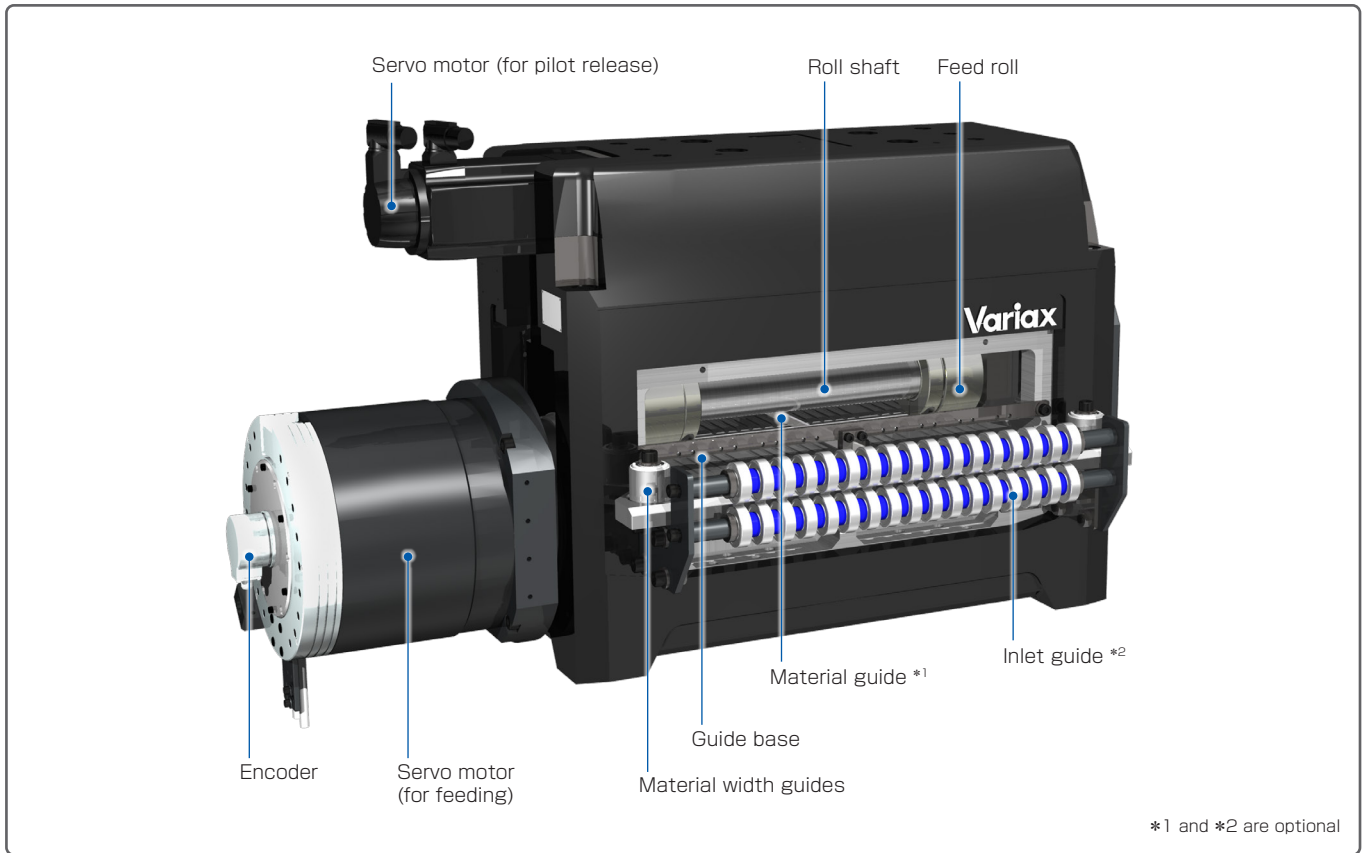
## Greatly improved roll cleaning ability

- Easy access to the rolls through the large opening



# Feeder specification

## Feed components



## Specification table

Model name	Unit	OPUS1-200	OPUS1-300	OPUS1-450	OPUS1-650
Feed length	mm	1 to 200(999)	1 to 300(999)	1 to 450(999)	1 to 650(999)
Material thickness	mm	max 2			
Gripping force	N	min 1,500 to max 3,000		min 3,000 to max 5,000	
Pilot release length	mm	0.1			
Roll opening dimension	mm	Max 2.5		Max 3	
Material width	mm	max 200	max 300	max 450	max 650
Maximum number of strokes	min <sup>-1</sup>	1,000		500	
Minimum pilot release angle	deg	90		50	
Maximum feed speed	m/min	Standard air-cooled motor: up to 70 m/min, Standard water-cooled motor: 70 m/min, or more Water-cooled high power motor: 80 m/min, or more		Standard air-cooled motor: up to 100 m/min, Standard water-cooled motor: 100 m/min, or more Water-cooled high power motor: 120 m/min, or more	
Repeat accuracy	mm	±0.03*3			
Air consumption	ℓ/min	200			
Operating air pressure	MPa	0.5 to 0.6			
Product weight	kg	220	240	415	480
Paint color		N1.5(Black)			

\*1 Please check the separate feed capacity diagram.

\*2 If the motor is water cooled, you will need to prepare your own cooling system (chiller) and hoses.

Use hoses with an inner diameter of  $\phi 9$  mm.

When you are making or purchasing a chiller, select a chiller with the following specifications.

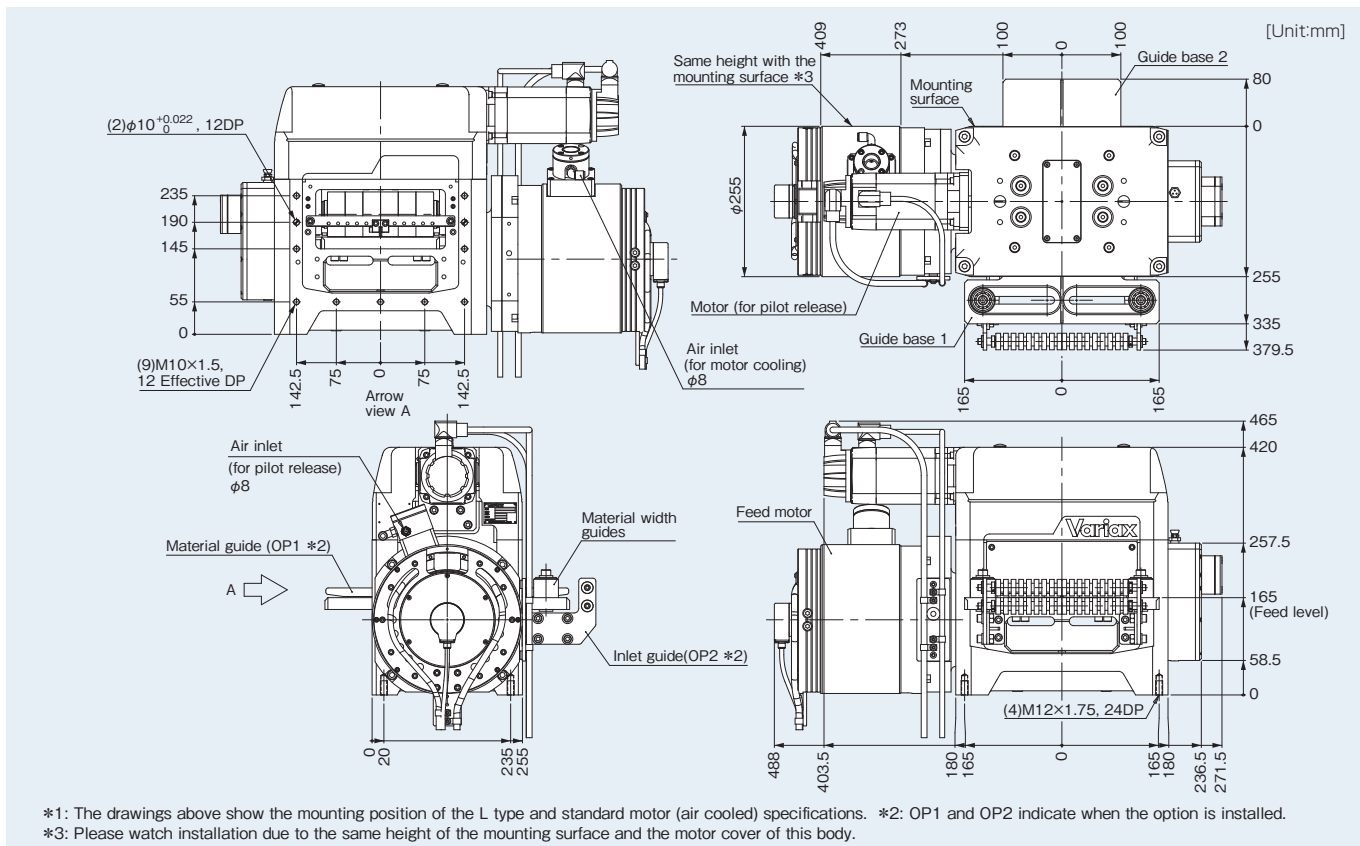
●Cooling capacity: You need a chiller for a standard 1.5 kw or higher capacity motor, and for a 4.2 kw or higher capacity motor.

●Minimum circulation rate: 7.0 L/min. ●Preset operating temperature maximum: 35°C ●Please choose a chiller and pipes that do not contain copper.

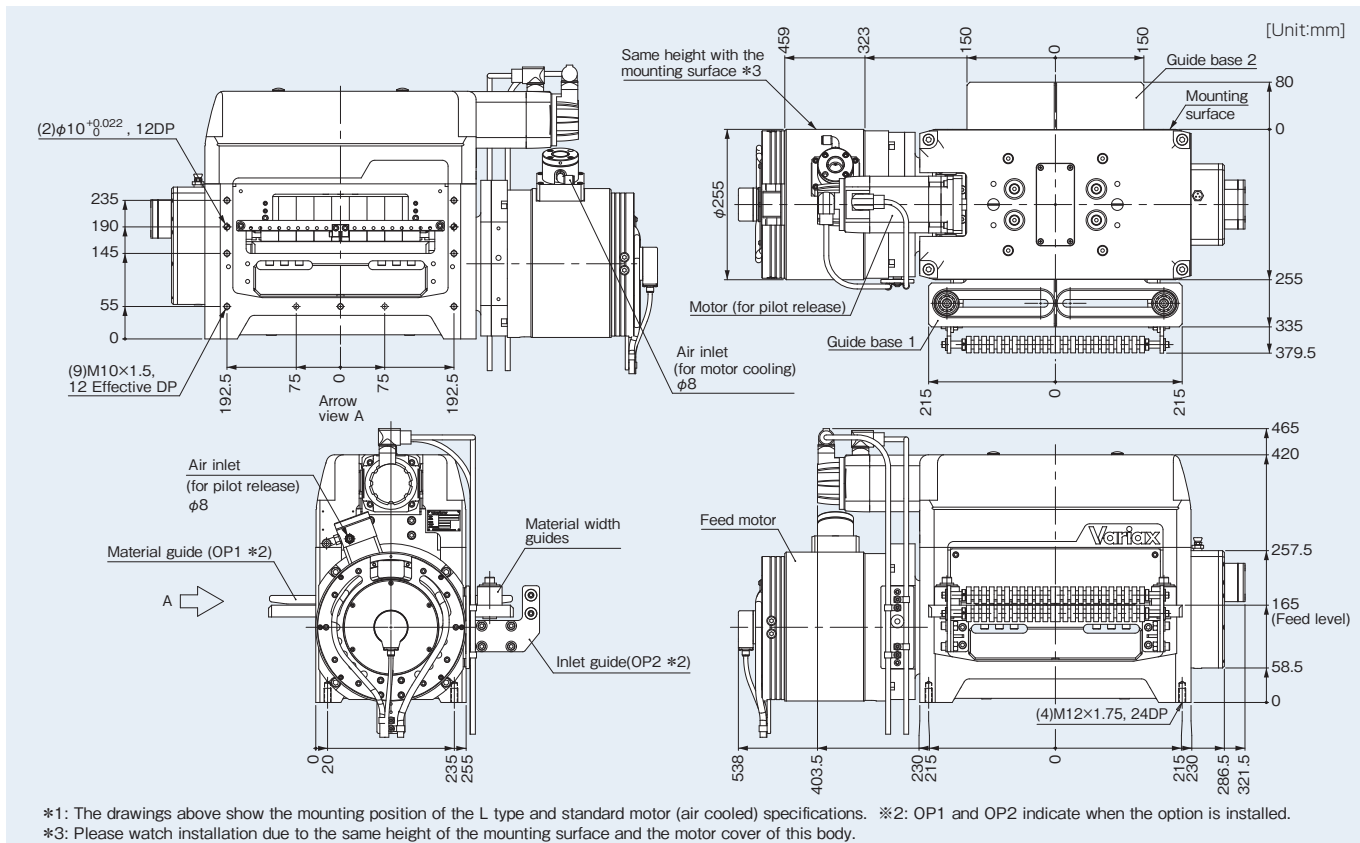
\*3 This is the amount of air used for cooling an air-cooled motor air. (The motor capacity depends on the volume of cooling air supplied.)

# Dimensional drawing OPUS1-200/300

## OPUS1-200

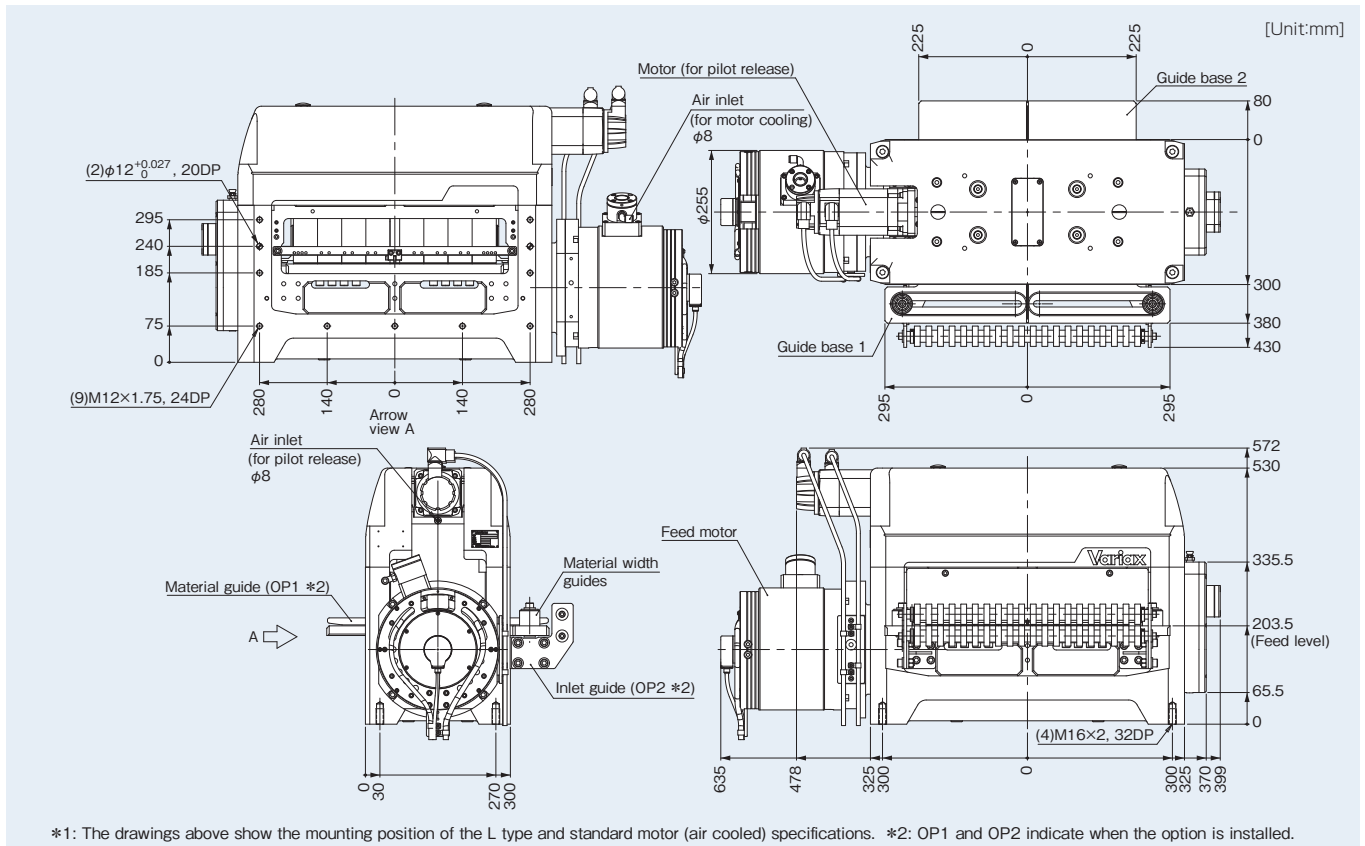


## OPUS1-300

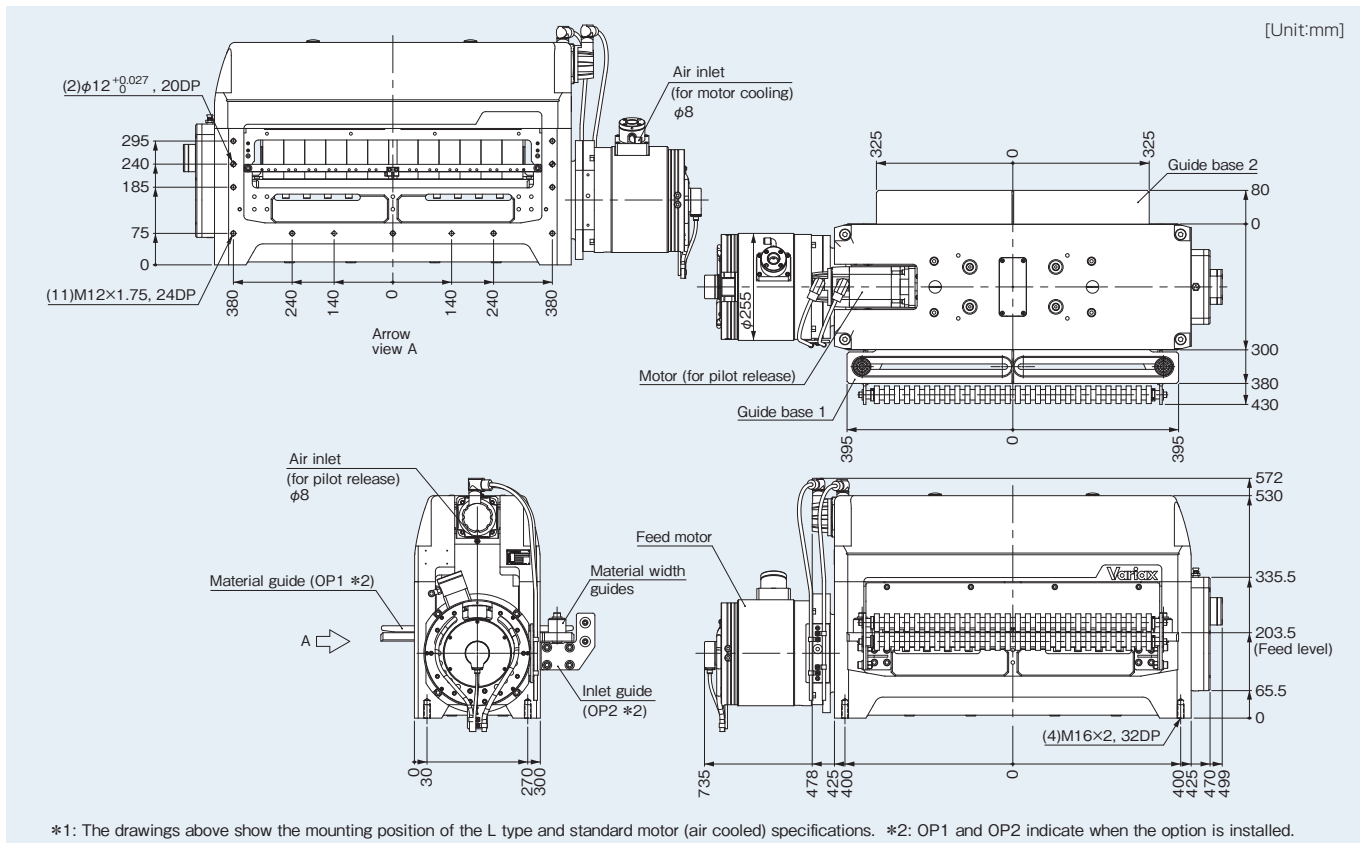


# Dimensional drawing OPUS 1-450/650

## OPUS 1-450



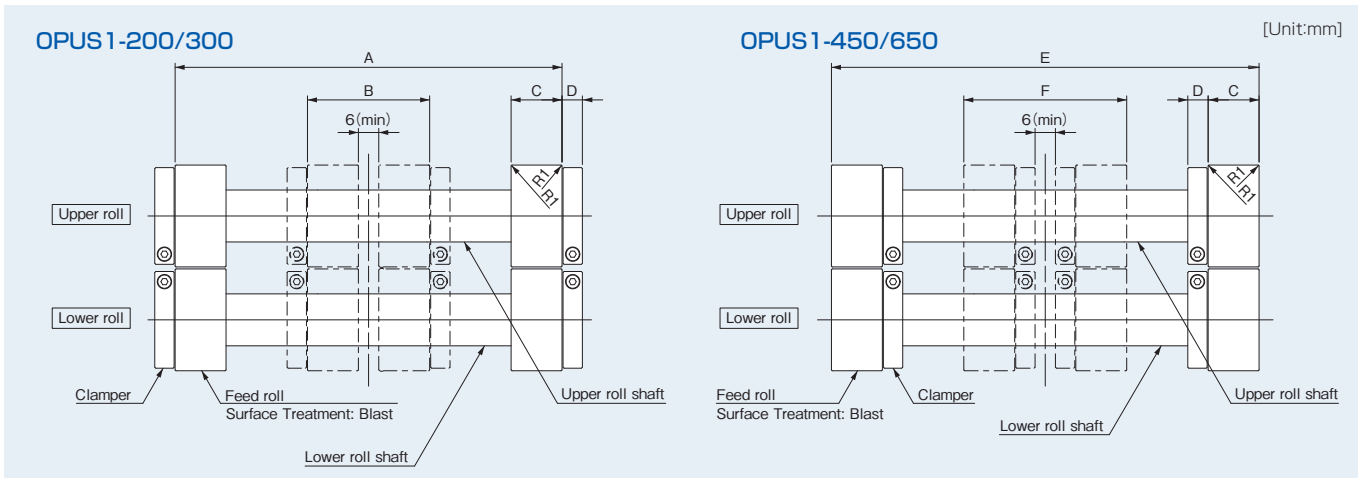
## OPUS 1-650



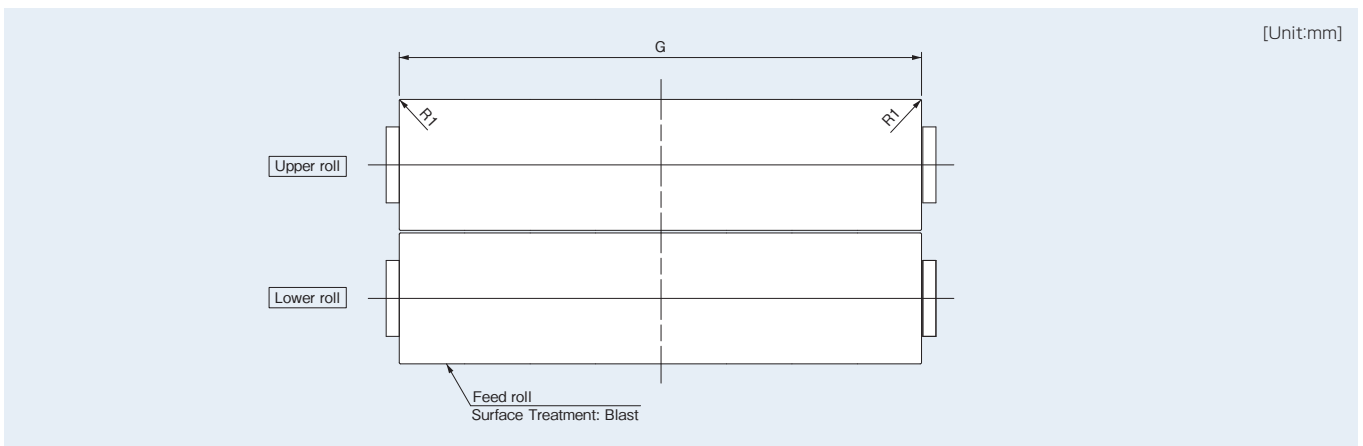


# Feed roll dimensional drawings

## Separate rolls (standard)



## Size of One-piece roll (option)

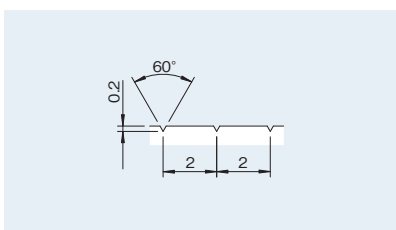


\*1: There are 3 types of surface specifications for a single roll (both separate and built-in rolls): sand blasted, V groove and flat rolls. For V groove roll details, please refer to the V groove detail drawings.

## Dimension table

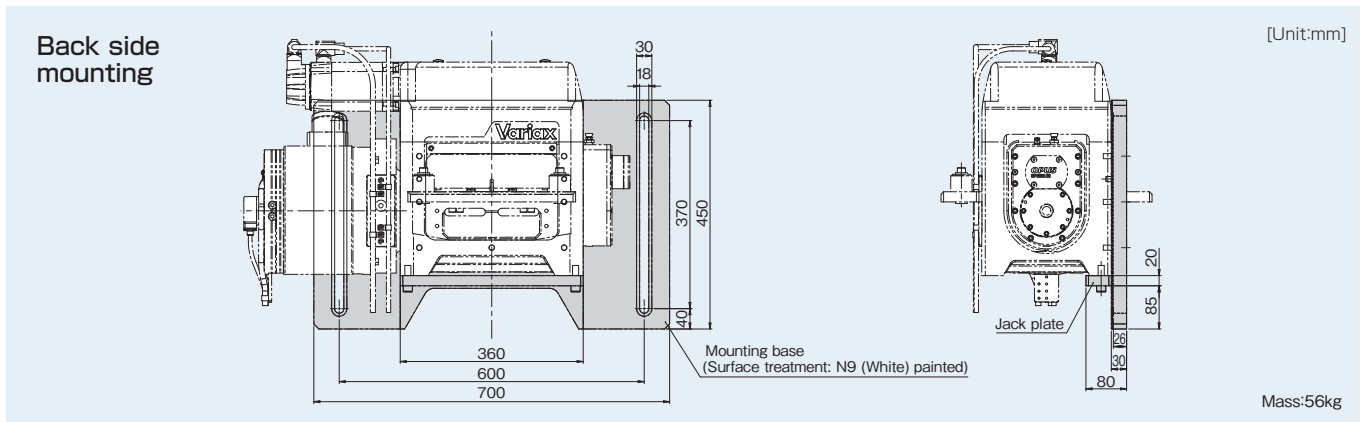
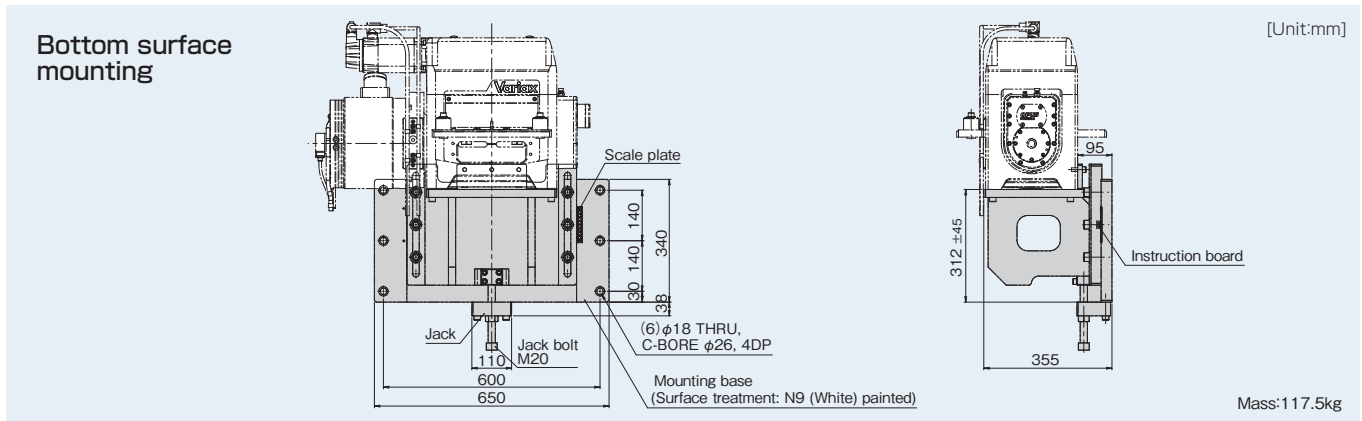
Size	A	B	C	D	E	F	G
OPUS1-200	159	66	30	16	–	–	180
OPUS1-300	259	66	30	16	–	–	270
OPUS1-450	–	–	50	20	420	146	420
OPUS1-650	–	–	50	20	620	146	620

## Detailed drawings of a V-groove roll

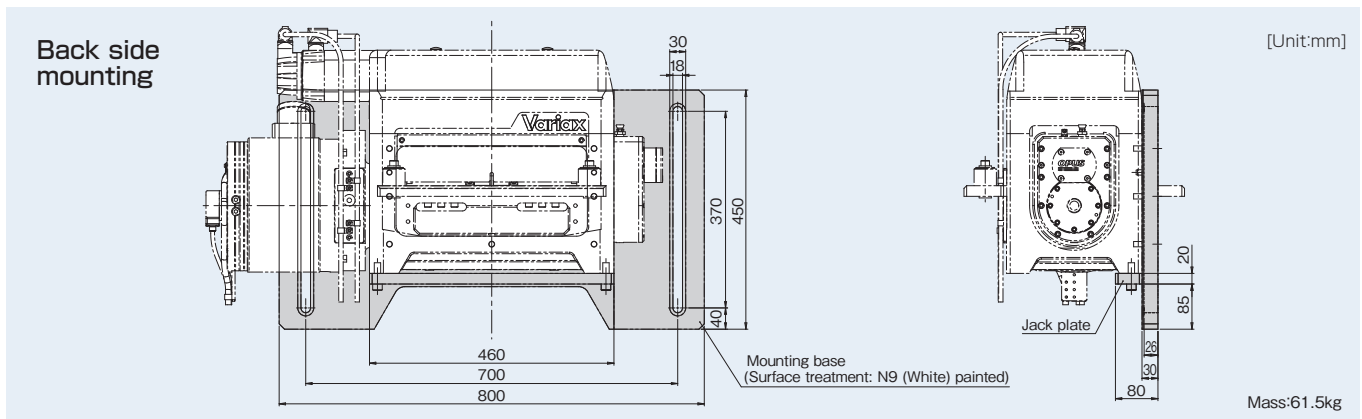
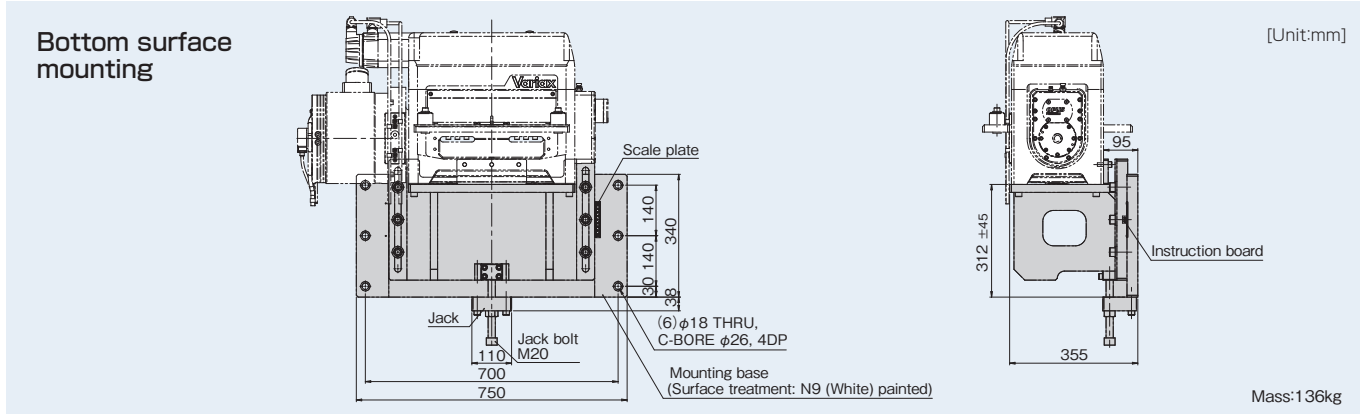


# Dimensions, mounting components (optional)

## OPUS1-200



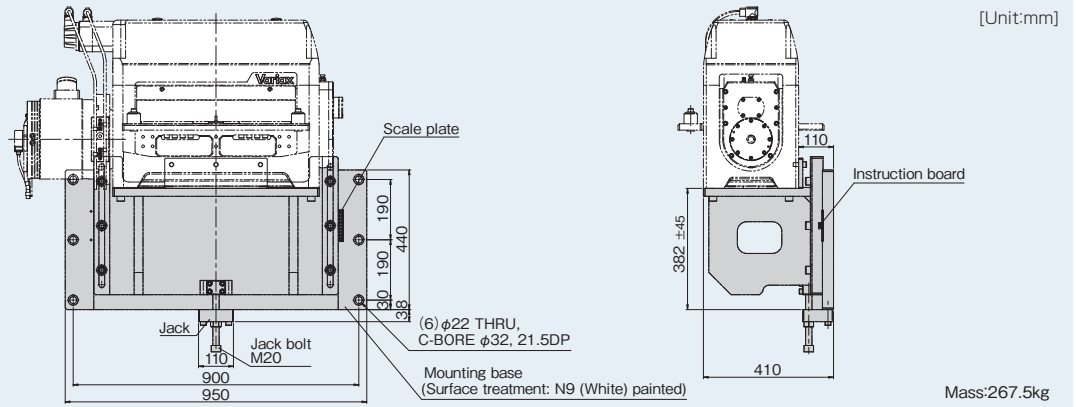
## OPUS1-300



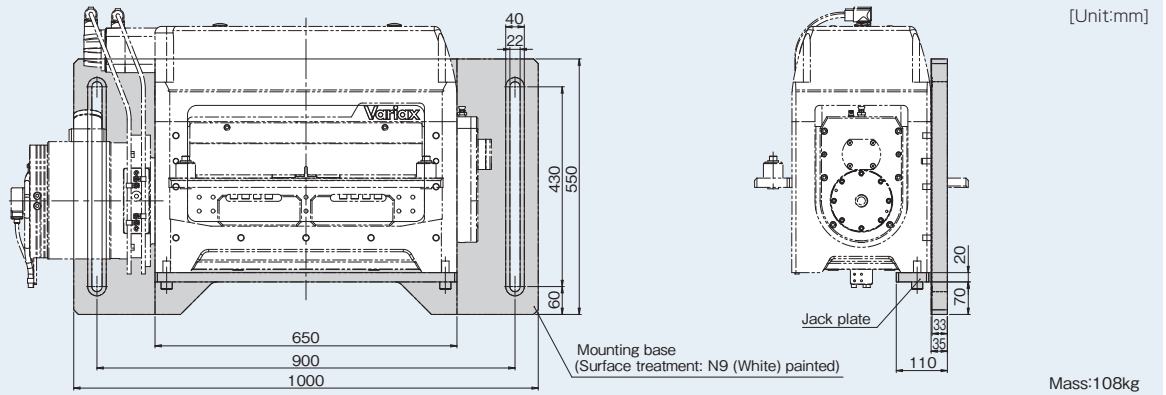
\*Please prepare your own jack parts

## OPUS1-450

### Bottom surface mounting

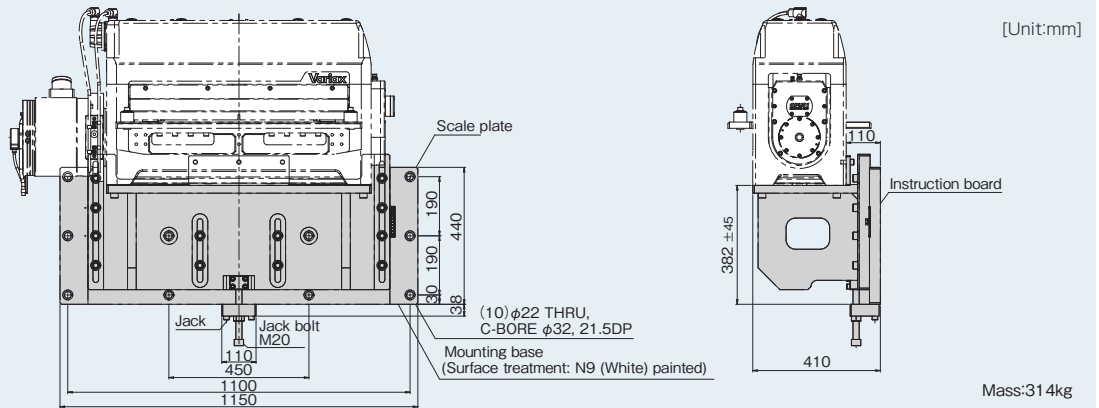


### Back side mounting

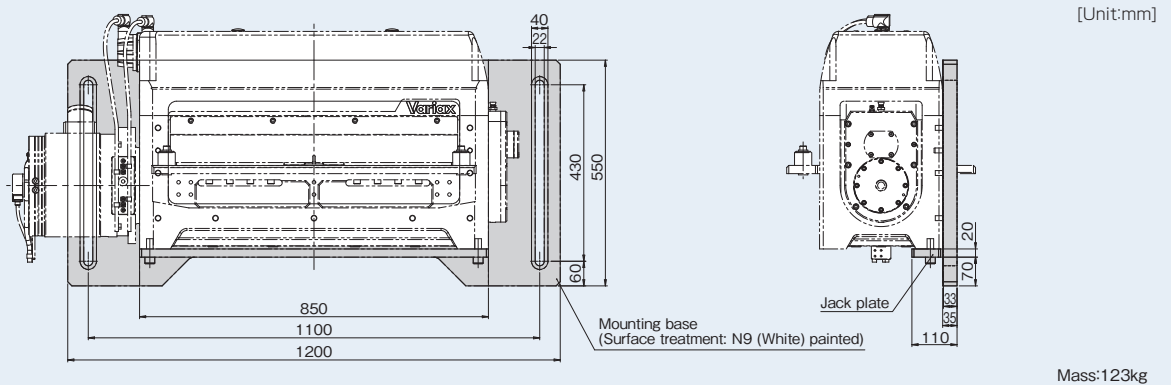


## OPUS1-650

### Bottom surface mounting



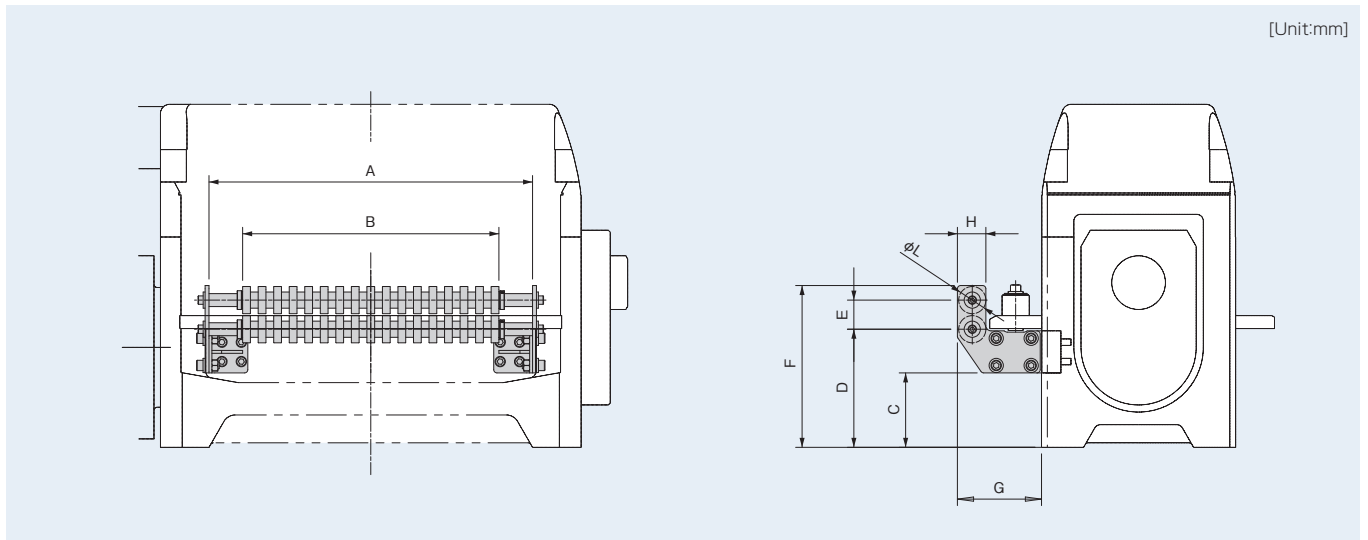
### Back side mounting



\*Please prepare your own jack parts

# Dimensional drawings, inlet guide (optional)

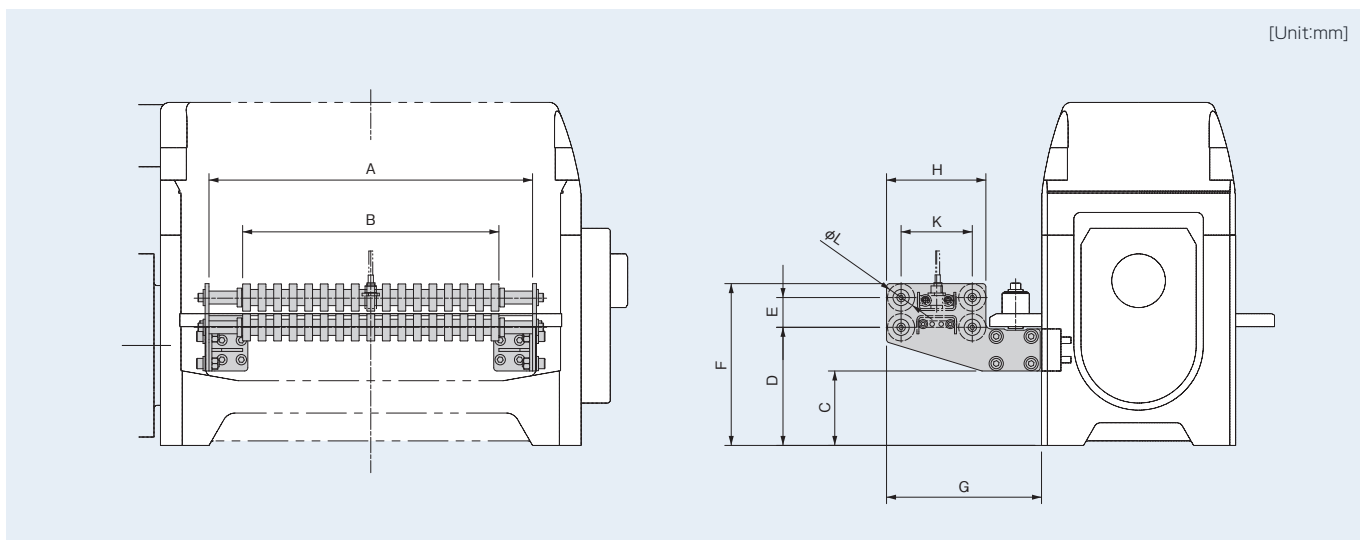
## Inlet guide dimensions: single row



## Dimension table

Size	A	B	C	D	E	F	G	H	L
OPUS1-200	255	224	86	151	31±2	198	124.5	29	28
OPUS1-300	355	302	86	151	31±2	198	124.5	29	28
OPUS1-450	500	468	115	182.5	45±2	250	130	44	42
OPUS1-650	700	660	115	182.5	45±2	250	130	44	42

## Inlet guide dimensions: double row

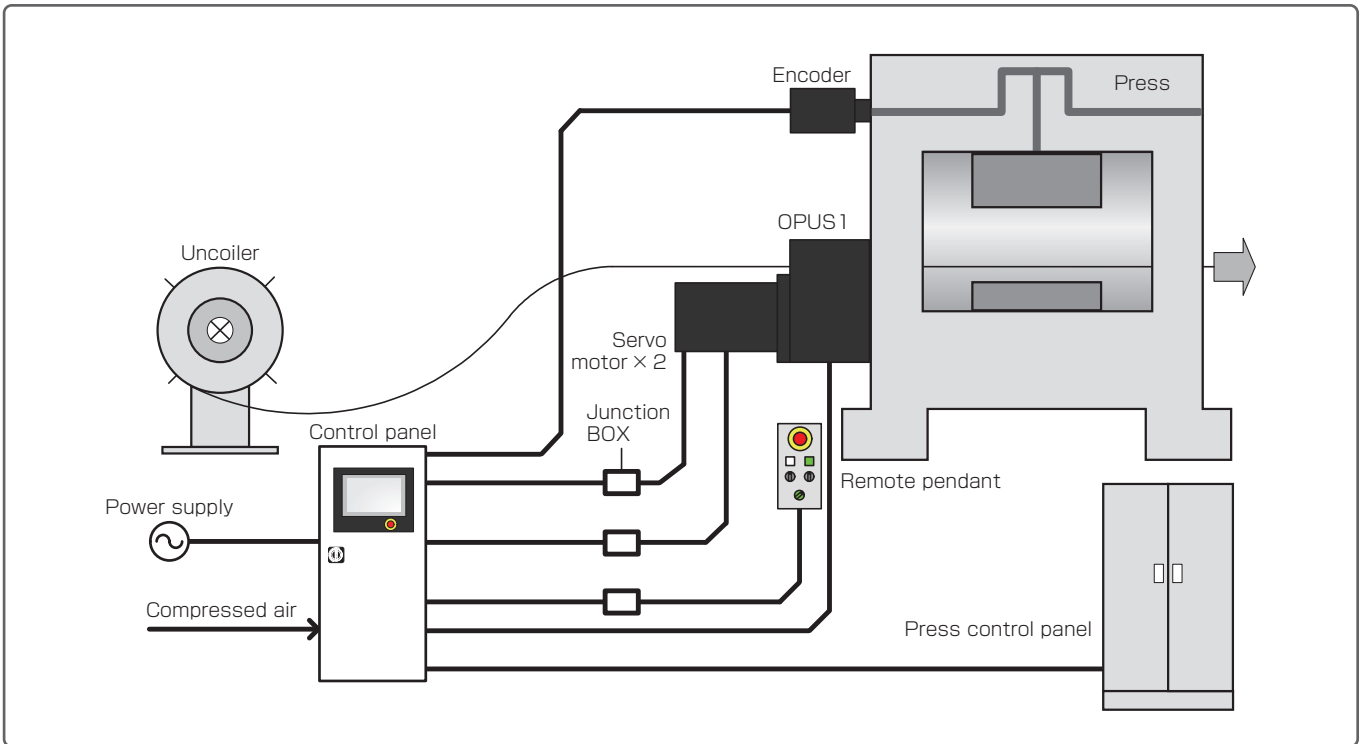


## Dimension table

Size	A	B	C	D	E	F	G	H	K	L
OPUS1-200	255	224	86	151	31±2	198	219.5	124	95	28
OPUS1-300	355	302	86	151	31±2	198	219.5	124	95	28
OPUS1-450	500	468	115	182.5	45±2	250	239.5	153.5	110	42
OPUS1-650	700	660	115	182.5	45±2	250	239.5	153.5	110	42

# Controller specifications

## Control configuration diagram



## Control specification table

Electrical specifications	Standard motor specifications	High power motor specification
Power supply *1	Three-phase four-wire system, 380 to 480 VAC ± 10%, 50/60 Hz	
Power capacity	20.78kVA 30A	48.5kVA 70A
Servomotor capacity	Feed motor: 14.5kW equivalent, release motor 1.4kW equivalent	Feed motor: 30kW equivalent, release motor 1.4kW equivalent

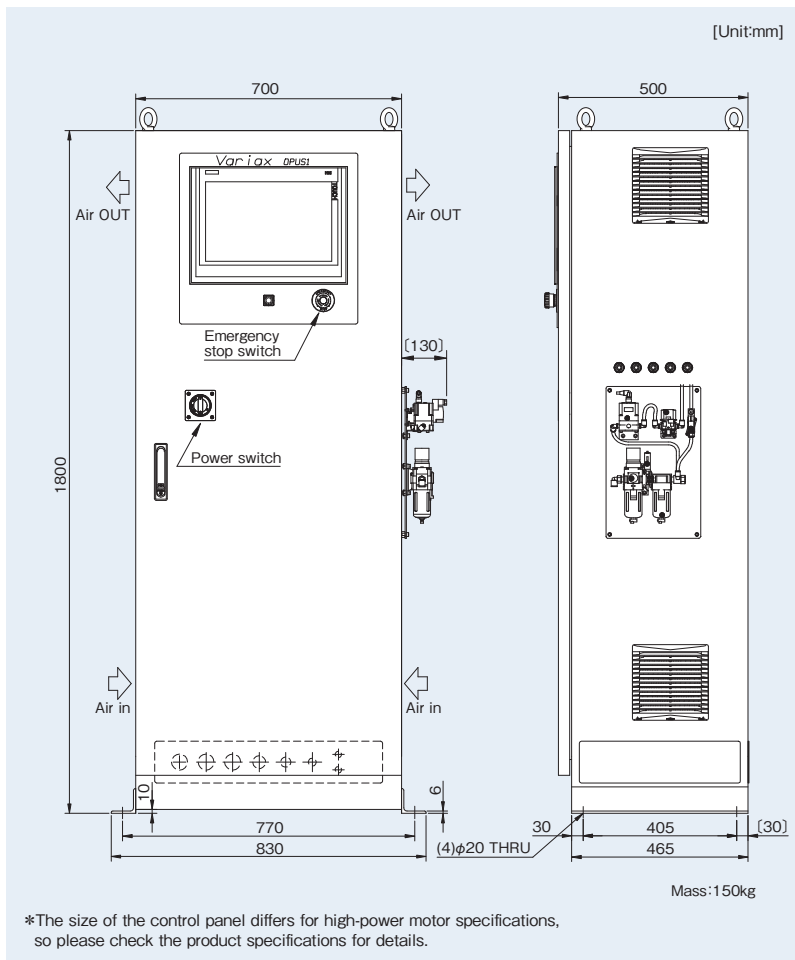
\*1 If the power supply is 200 VAC, or there is no N connector (Neutral), an optional external transformer is required.  
(Three-phase three-wire 200AC -> three-phase four-wire 400AC)

Control panel specifications	Standard motor specifications	High power motor specification
Size / Weight	H:1800mm W:700mm D:500mm / 150kg	H:1800mm W:900mm D:550mm / 220kg
Paint color	N9 (White)	N9 (White)
Standards	IEC / CE / UL	IEC / UL

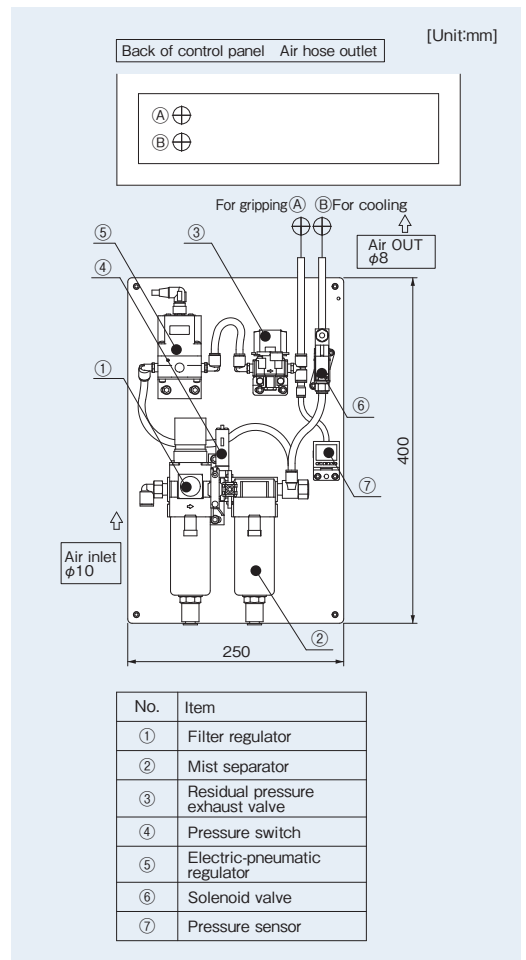
Main functions		
User interface	Touch panel (15 inch), Remote pendant	
Touch panel language	Japanese / English / Chinese / Spanish / Korean	
Number of saved job	200	
Driving operation mode	Automatic operation	You can start automatic operation by entering a job number.
	Manual operation	You can JOG and process feed at set speeds, as well as open or close the rolls.
	Parameters	Various parameters can be set.
Safety function	When an emergency stop signal is input, this function instantly cuts off power to the motor and stops all operation. The system provides safety integrity level 2 (SIL 2) safety category according to IEC 61508 and safety category 3 appropriate for sudden motor stops.	
Security functions	5 user levels (password management)	
Crankshaft encoder	1:1 installation (with vibration isolation mounting kit)	
Linking specification	Up to 5 presses (OPUS1:2+EVR1:2+SCR1:1)	

# Control panel dimensional drawings

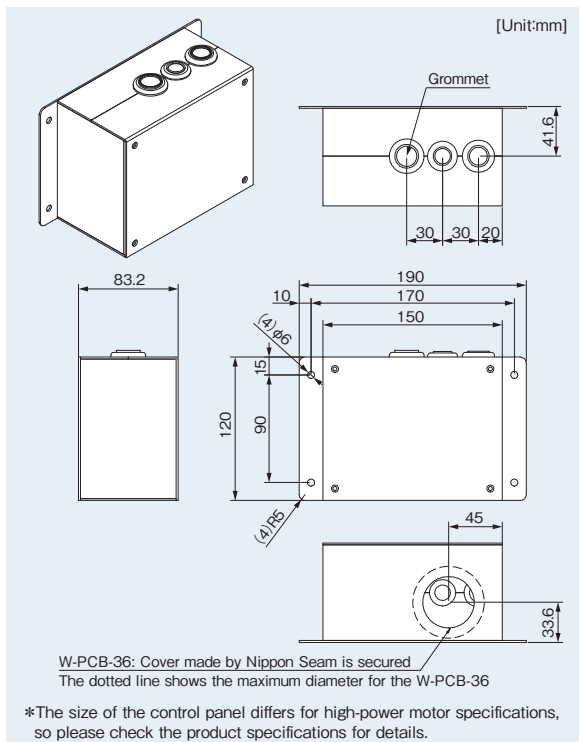
## Control panel dimensional drawings



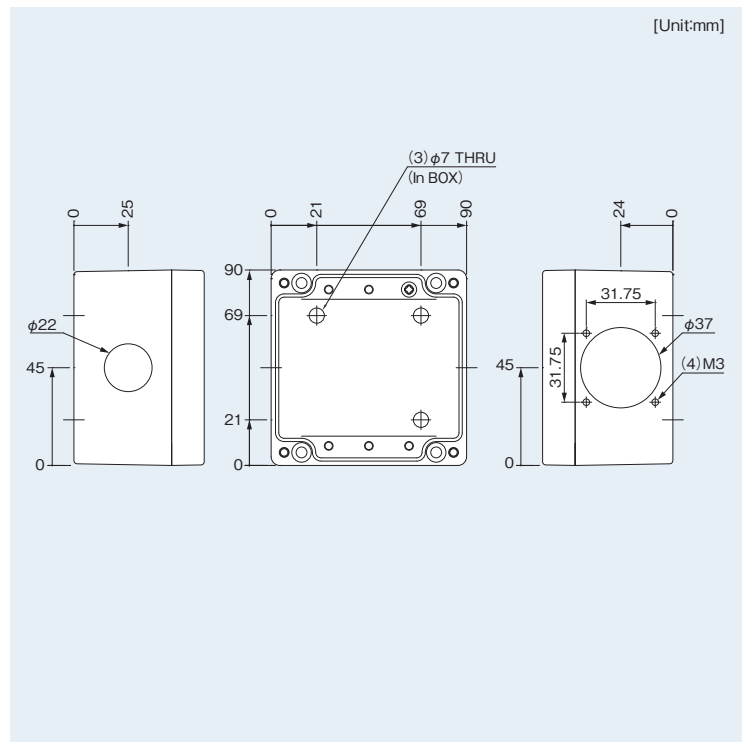
## Compressed air equipment



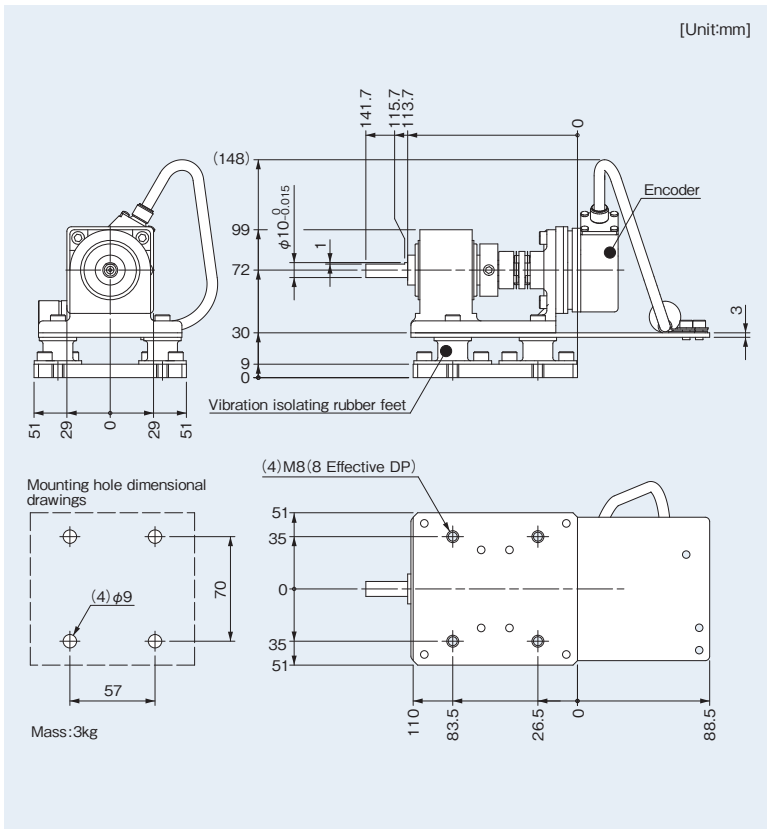
## Junction BOX(for motor, encoder cable)



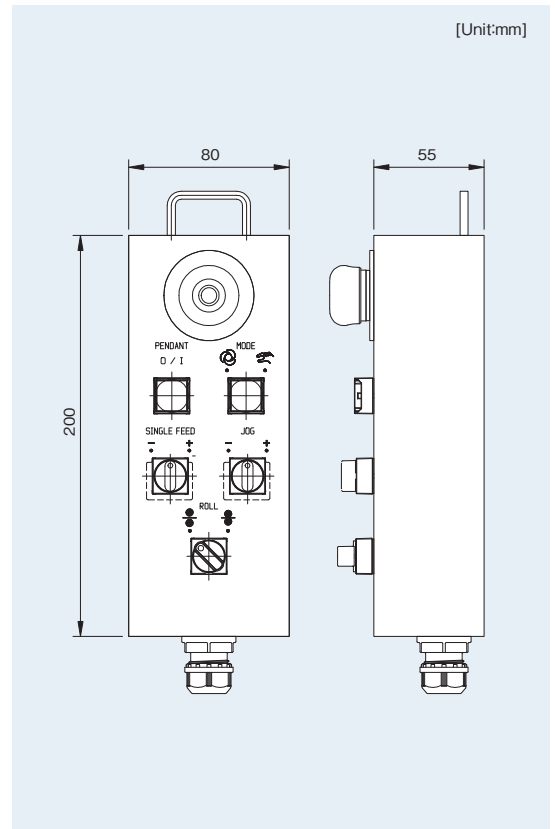
## Junction BOX(for remote pendant)



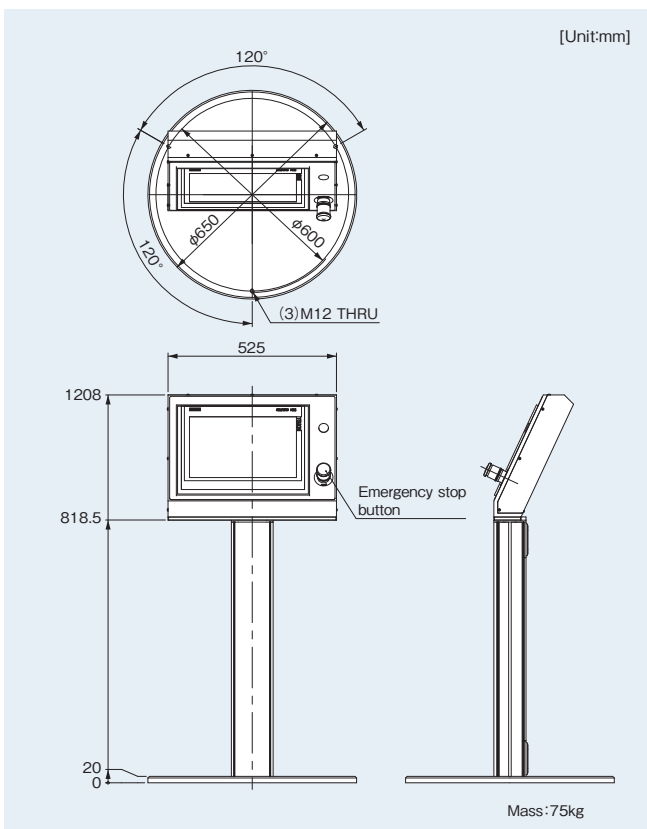
## Encoder unit (for press mounting)



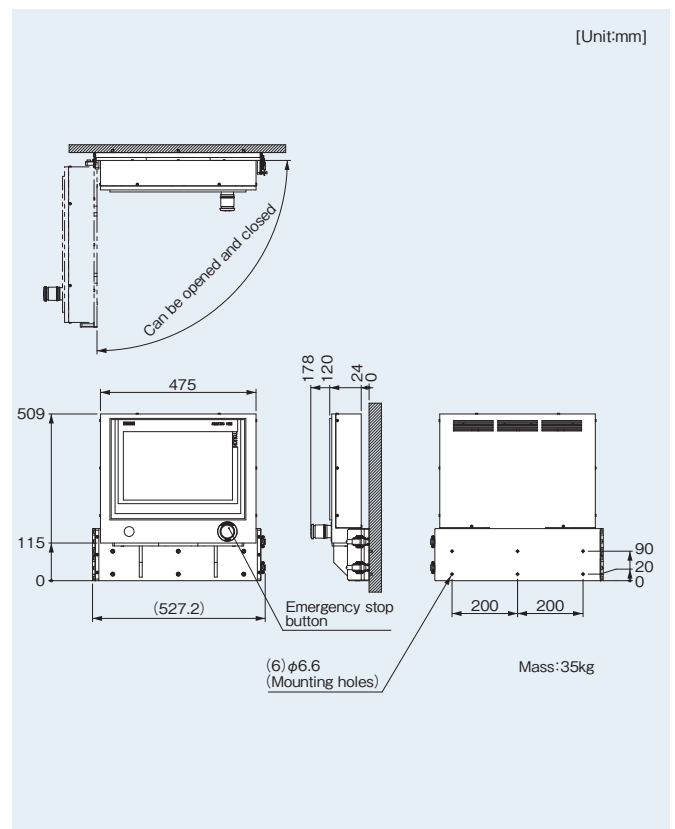
## Remote pendant



## Panel stand type (option)



## Wall hung panel (option)



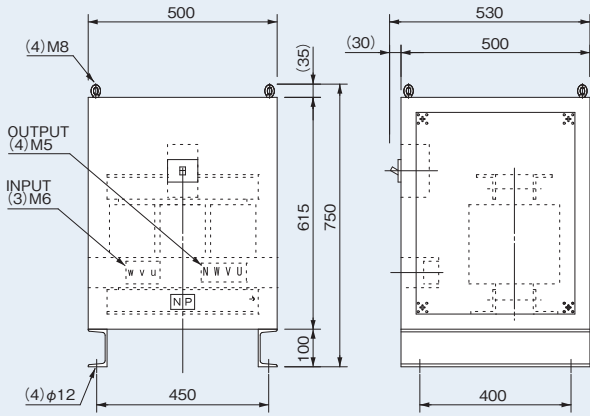
# Controller dimensional drawings

## External transformer (optional)

If the customer's power supply is 200 VAC or there is no N connector (Neutral), an optional external transformer is required.

### Control panel specifications for one standard motor

[Unit:mm]



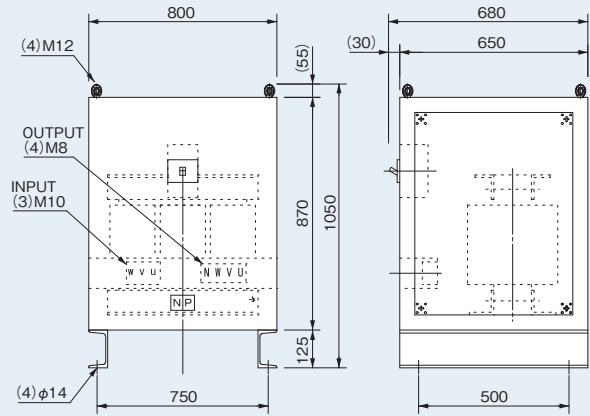
Mass : 165kg, Paint color : 5Y7/1 (semi-gloss)

External transformer specifications	
Number of phases	Three-phase, multiple windings
Frequency	50/60Hz
Rated capacity	20.784kVA
Primary voltage	AC200V
Secondary voltage	AC400V
Secondary current	30A
Primary side: Delta connection	Secondary side: Star connection (with an N connector)
Primary side	Has a breaker

\*The transformers that can be used vary, depending on the motor size and type. Please check the product specifications for details.

### Control panels specifications for 2 or 3 standard motors Control panel specifications for one high-power motor

[Unit:mm]

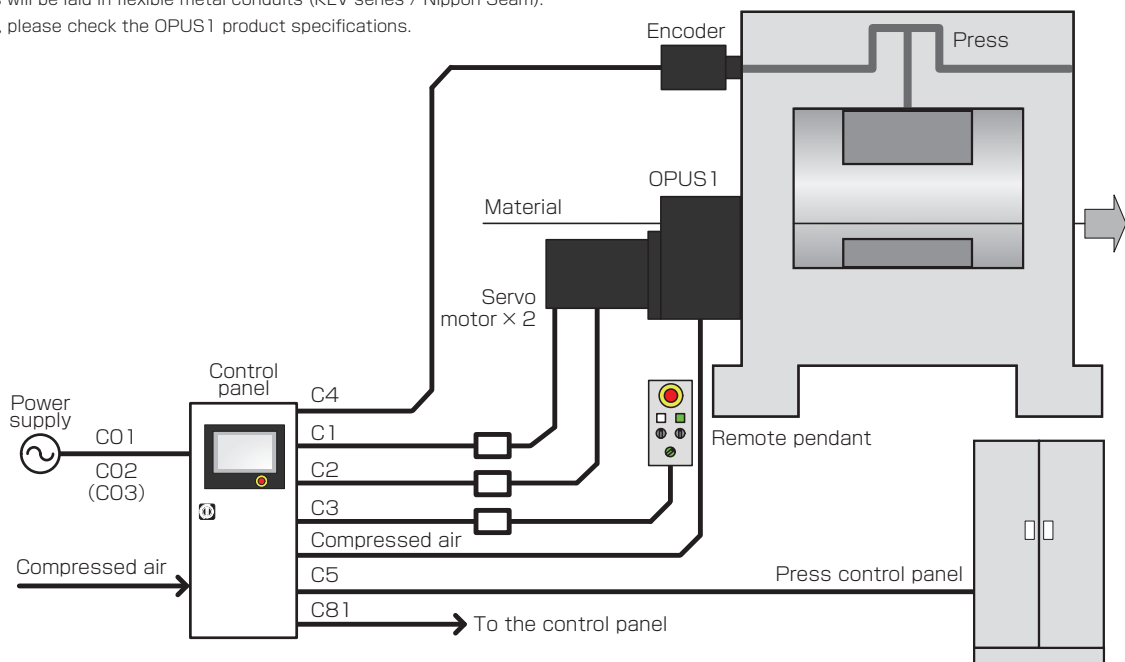


Mass : 440kg, Paint color : 5Y7/1 (semi-gloss)

External transformer specifications	
Number of phases	Three-phase, multiple windings
Frequency	50/60Hz
Rated capacity	69.28kVA
Primary voltage	AC200V
Secondary voltage	AC400V
Secondary current	100A
Primary side: Delta connection	Secondary side: Star connection (with an N connector)
Primary side	Has a breaker

## Tubing & Cables

- C01 is the power supply cable to the control panel. The customer must supply his own cable.
- C02 and C03 are the power cables to the control panel when an external transformer is used.
- The cables will be laid in flexible metal conduits (KLV series / Nippon Seam).
- For details, please check the OPUS1 product specifications.





# Model code for feed

## Feed model code

1	<b>OPS1-200</b>	2	<b>H</b>	–	3	<b>SB</b>	4	<b>150</b>	–	5	<b>L</b>
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1		2		3		4		5	
Model name		Motor specifications		Feed rolls		Maximum roll width [mm]*1		Motor mounting direction*2	
<b>OPS1-200</b>	OPUS1-200	<b>Blank</b>	Standard	<b>SB</b>	Separate, blast (standard)	<b>66~159</b>	OPUS1-200	<b>L</b>	Mounted on the left side of the housing
<b>OPS1-300</b>	OPUS1-300	<b>H</b>	High power motor	<b>SV</b>	Separate, V-groove (option)	<b>66~259</b>	OPUS1-300	<b>R</b>	Mounted on the right side of the housing
<b>OPS1-450</b>	OPUS1-450			<b>SF</b>	Separate, flat (option)	<b>146~420</b>	OPUS1-450		
<b>OPS1-650</b>	OPUS1-650			<b>LB</b>	One-piece blast (option)	<b>146~620</b>	OPUS1-650		
				<b>LV</b>	One-piece V-groove (option)				
				<b>LF</b>	One-piece flat (option)				

6	<b>A</b>	7	<b>FW</b>	–	8	<b>A</b>	9	<b>G</b>	10	<b>/X</b>
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6		7		8		9		10	
Motor cooling method*4		Guide base		Standards		Version*3		Standard / custom order	
<b>A</b>	Air cooled	<b>FW</b>	Flat (with a material width guide)	<b>A</b>	None (standard)	<b>G</b>	Design version code	<b>Blank</b>	Standard
<b>W</b>	Water cooled	<b>GW</b>	Vertical slot (with a material width guide)	<b>C</b>	CE standard (option)			<b>/X</b>	Custom order
		<b>FF</b>	Flat	<b>U</b>	UL standard (option)				
		<b>GF</b>	Vertical slot						

\*1: Specify the setting width only for the separate roll specifications. (In units of 1 mm)

If not specified, the minimum value will be used.

If you select an optional, one-piece roll, you do not need to specify the roll width.

\*2: The motor mounting directions mentioned above are when viewing the feeder housing from its front side.

\*3: The final number in the version code increases with each design change and may change without prior notice.

\*4: If a high-power motor is used, the motor will be water cooled.

## Optional codes for Feed (for mounting parts)

1	<b>OPS1-200</b>	–	2	<b>M</b>	–	3	<b>L001</b>
---	-----------------	---	---	----------	---	---	-------------

1		2		3	
Model name		Mounting parts		Mounting specifications	
<b>OPS1-200</b>	OPUS1-200	<b>M</b>	Mounting parts	<b>L001</b>	For bottom surface mounting
<b>OPS1-300</b>	OPUS1-300			<b>B001</b>	For back side mounting
<b>OPS1-450</b>	OPUS1-450				
<b>OPS1-650</b>	OPUS1-650				

# Model code for feed

## Optional codes for Feed(Material guide)

1 **OPS1-200** – 2 **U1**

1	
Model name	
<b>OPS1-200</b>	OPUS1-200
<b>OPS1-300</b>	OPUS1-300
<b>OPS1-450</b>	OPUS1-450
<b>OPS1-650</b>	OPUS1-650

2	
Material guide	
<b>U1</b>	For separate feed rolls (1 piece)
<b>U2</b>	For separate feed rolls (1 in the center, 2 on the sides)
<b>U3</b>	Full cover type
<b>U4</b>	Fully covered to the end of the guide base

## Material guide

		Entrance side	Exit side
<b>U1</b>			
		Center guides for a separate roll	
<b>U2</b>			
		Center guides for a separate roll	
		Side guides for separate rolls	
<b>U3</b>			
		Full cover guide	
<b>U4</b>			
		Full cover guide	

※Material width guides cannot be used.  
In the case of the PUSH/PULL specification, we recommend using the PULL side.

# Model code for feed

## Optional codes for Feed(inlet guide)

1	<b>OPS1-200</b>	-	2	<b>E1</b>	3	<b>A</b>
---	-----------------	---	---	-----------	---	----------

1	
Model name	
<b>OPS1-200</b>	OPUS1-200
<b>OPS1-300</b>	OPUS1-300
<b>OPS1-450</b>	OPUS1-450
<b>OPS1-650</b>	OPUS1-650

2		3	
Inlet guide		Sensor specifications*1	
<b>E1</b>	Roller type (1 row)	<b>Blank</b>	None
<b>E2</b>	Roller type (2 rows)	<b>A</b>	Type equipped with a proximity sensor (Sensor stay: M18×1 (fine thread))
		<b>B</b>	Type equipped with a photoelectric sensor

4	<b>A</b>	5	<b>/X</b>
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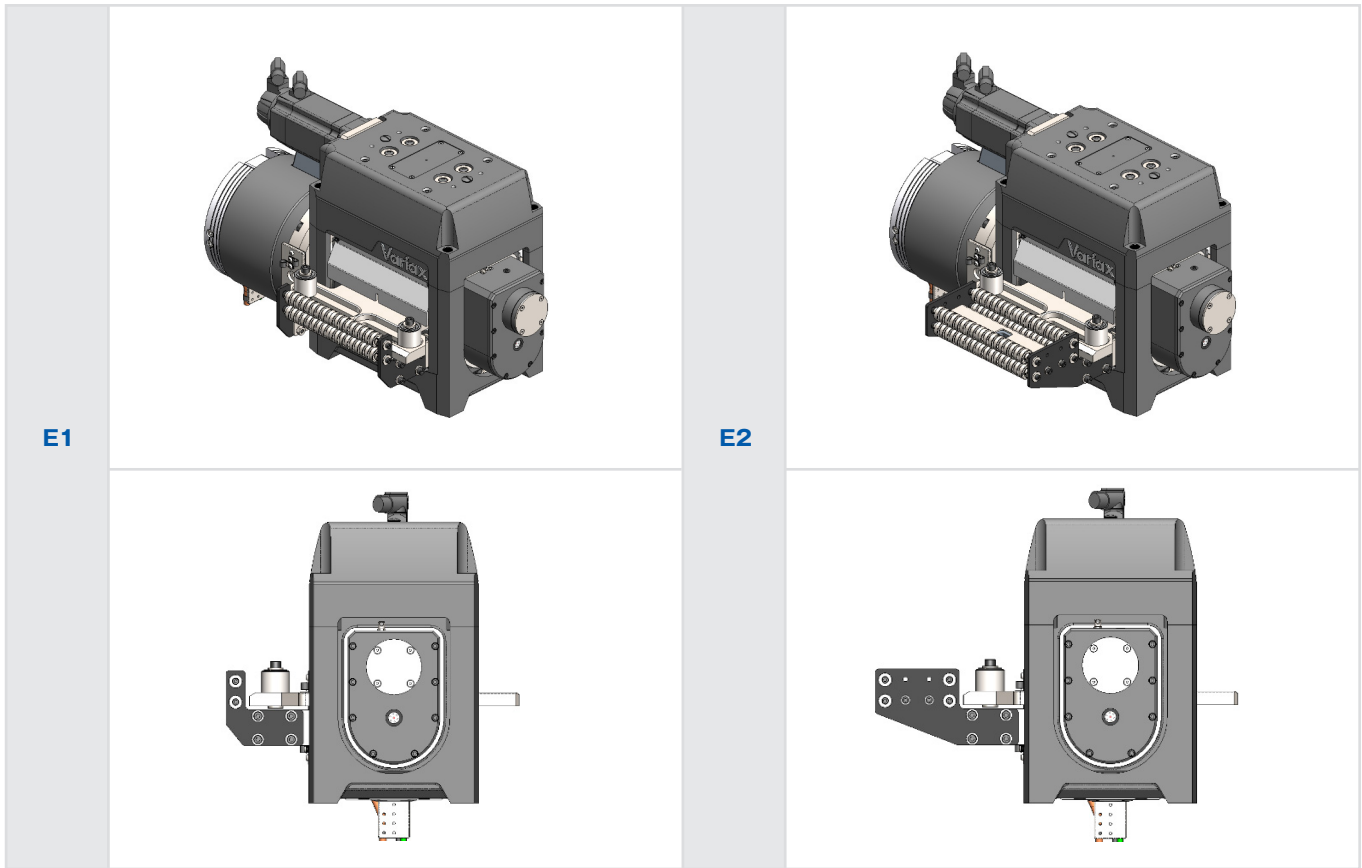
4		5
Sensor type*2		Standard / custom order
Sensor specifications: A (proximity sensor)	Sensor specifications: B (photoelectric sensor)	
<b>A</b> E2E-X5B1D18(OMRON-PNP)	<b>A</b> HP7-A14(azbil-PNP)	<b>Blank</b> Standard
<b>B</b> E2E-X5C118 (OMRON-NPN)	<b>B</b> HP7-A13(azbil-NPN)	<b>/X</b> Custom order

\*1: A sensor cannot be installed on a machine equipped with a single roller.

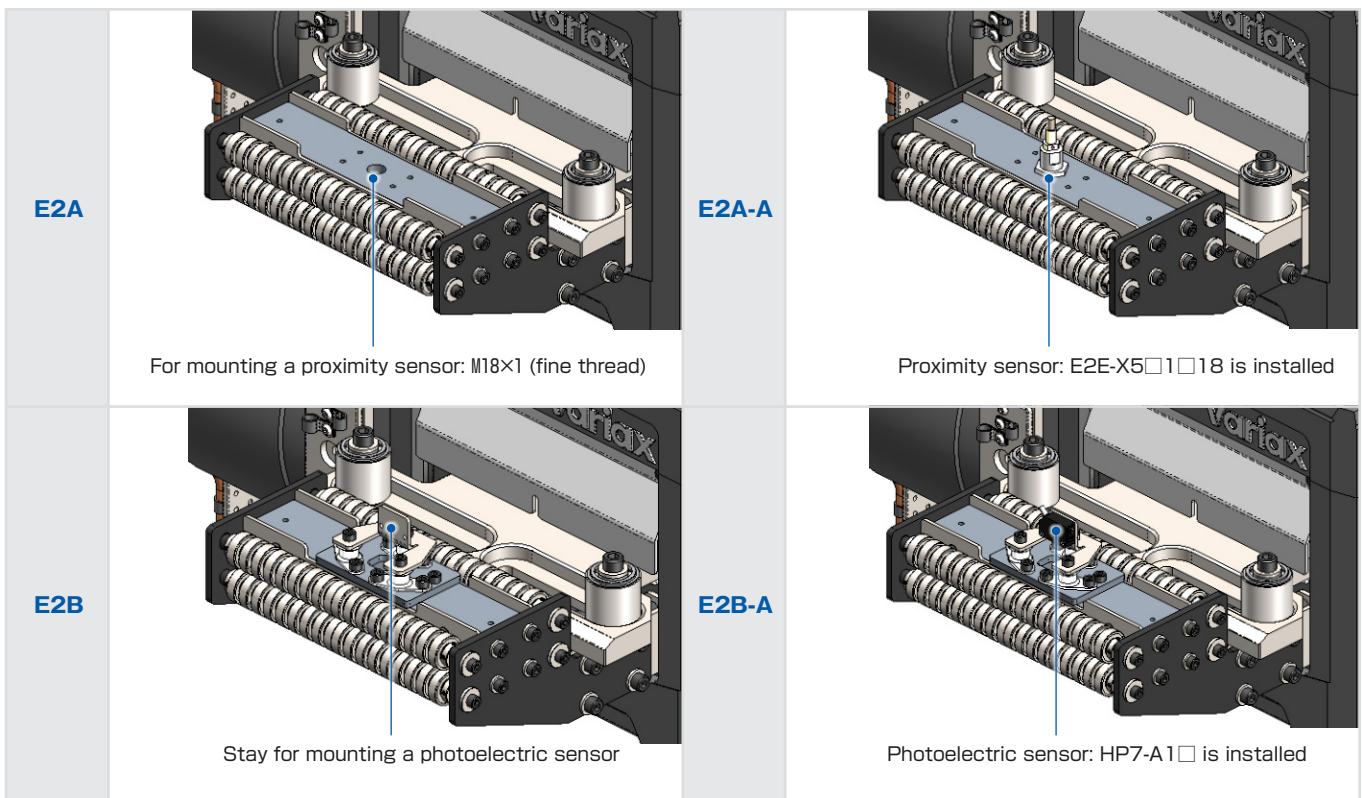
\*2: To use sensors on other models, please tell us the name of the sensor model you want to use when ordering a Variax.

# Model code for feed

## Inlet guide



## Sensor specifications



# Model code for controller

## Control code

1	<b>OPS14020E</b>	-	2	<b>A</b>	3	<b>A</b>
---	------------------	---	---	----------	---	----------

1	
Model name	
<b>OPS14020E</b>	OPUS1-200 AC400V
<b>OPS14030E</b>	OPUS1-300 AC400V
<b>OPS14045E</b>	OPUS1-450 AC400V
<b>OPS14065E</b>	OPUS1-650 AC400V
<b>OPS14420E</b>	OPUS1-200 AC440V
<b>OPS14430E</b>	OPUS1-300 AC440V
<b>OPS14445E</b>	OPUS1-450 AC440V
<b>OPS14465E</b>	OPUS1-650 AC440V

2	3
Operation panel position	Control panel cooling method
<b>A</b> Control panel (standard)	<b>A</b> Fan cooled (standard)
<b>B</b> Panel stand (option)	<b>B</b> Cooled by an air conditioner (option)
<b>C</b> Wall hung panel(option)	
<b>Z</b> Without a panel(option)*1	

4	<b>B</b>	5	<b>A</b>	6	<b>A</b>	7	<b>A</b>	8	<b>/X</b>
---	----------	---	----------	---	----------	---	----------	---	-----------

4	5	6	7	8
Cable exit position	Standards	Pneumatic equipment mounting position	Version	Standard / custom order
<b>B</b> Back(standard)	<b>A</b> IEC specification(standard)	<b>A</b> On the side of the control panel	<b>A</b> Design version code	<b>Blank</b> Standard
<b>R</b> Right(option)	<b>C</b> CE specification(option)	<b>B</b> On the front of the control panel		<b>/X</b> Custom order
<b>L</b> Left(option)	<b>U</b> UL specification(option)			
<b>U</b> Under(option)	<b>X</b> Custom order			

※ 1: Select this alternative when the control board does not have an integrated operation panel.

- The housing paint color is N9 (semi-glossy), and the plate for mounting electrical parts is galvanized.
- The mass (weight) of the standard motor control panel with FAN cooling specifications is 150 kg and it is 200 kg with air conditioner cooling specifications.
- The mass (weight) of the high-power motor control panel with FAN cooling specifications is 220 kg and it is 265 kg with air conditioner cooling specifications.
- When installing control panels side by side, leave a gap 500 mm or more between the panels.  
(For maintenance of the cooling air equipment, and to ensure adequate air intake and exhaust for cooling the control panel)
- The "40" and "44" in the product names OPS14020E and OPS14420E refer to the power supply voltage.  
"40" means 380 to 439VAC, and "44" refers to the 440 to 480VAC specification.  
If the voltage actually supplied is different from the product specification, the controller may not be able to start the motor properly.
- An example of a high-power motor specification is OPS14065HE.  
(This indicates that the OPUS1-650 will have 400VAC high-power motor). The control panel size will be specific for that for the high-power motor model.
- This product can combine multiple products in a single system. (See below for details.)  
Example: Two OPUS1 and two EVR units can be combined  
Example: Two OPUS1 units and one EVR1 unit can be combined.  
Example: Two OPUS1 units can be combined  
Example: Two EVR1 units cannot be combined  
Example: Three or four OPUS1 units cannot be combined.  
Example: Three or four EVR1 units cannot be combined.  
However, one operation panel and one crankshaft encoder is always required for each system.

# Model code for controller

## Control option code

1 **OPS14020E** – 2 **A0F1** – 3 **00**

1	
Model name	
<b>OPS14020E</b>	OPUS1-200 AC400V
<b>OPS14030E</b>	OPUS1-300 AC400V
<b>OPS14045E</b>	OPUS1-450 AC400V
<b>OPS14065E</b>	OPUS1-650 AC400V
<b>OPS14420E</b>	OPUS1-200 AC440V
<b>OPS14430E</b>	OPUS1-300 AC440V
<b>OPS14445E</b>	OPUS1-450 AC440V
<b>OPS14465E</b>	OPUS1-650 AC440V

2	
Function	
<b>A0F1</b>	Equipment installation front side (push) (standard)
<b>A0M</b> <input type="checkbox"/>	Equipment installation center front: 1 or 2
<b>A0D1</b>	Equipment installation rear side (pull)
<b>B001</b> - <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	JOG speed upper limit in manual operation
<b>B002</b> - <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	Step feed speed upper limit in manual operation
<b>B003</b>	Manual operation within the feed angle range
<b>B005</b>	Hold-to-run
<b>B006</b>	CC-Link IE communication with upstream devices
<b>B007</b>	Roll release for clearing jammed material
<b>B008</b>	End-of-material detection signal output
<b>B009</b>	Feed partial pitch after press stoppage (manual mode)

3	
Version*4	
<b>00</b>	Version

\*1: Please choose function A0F1, A0M , or A0D1.

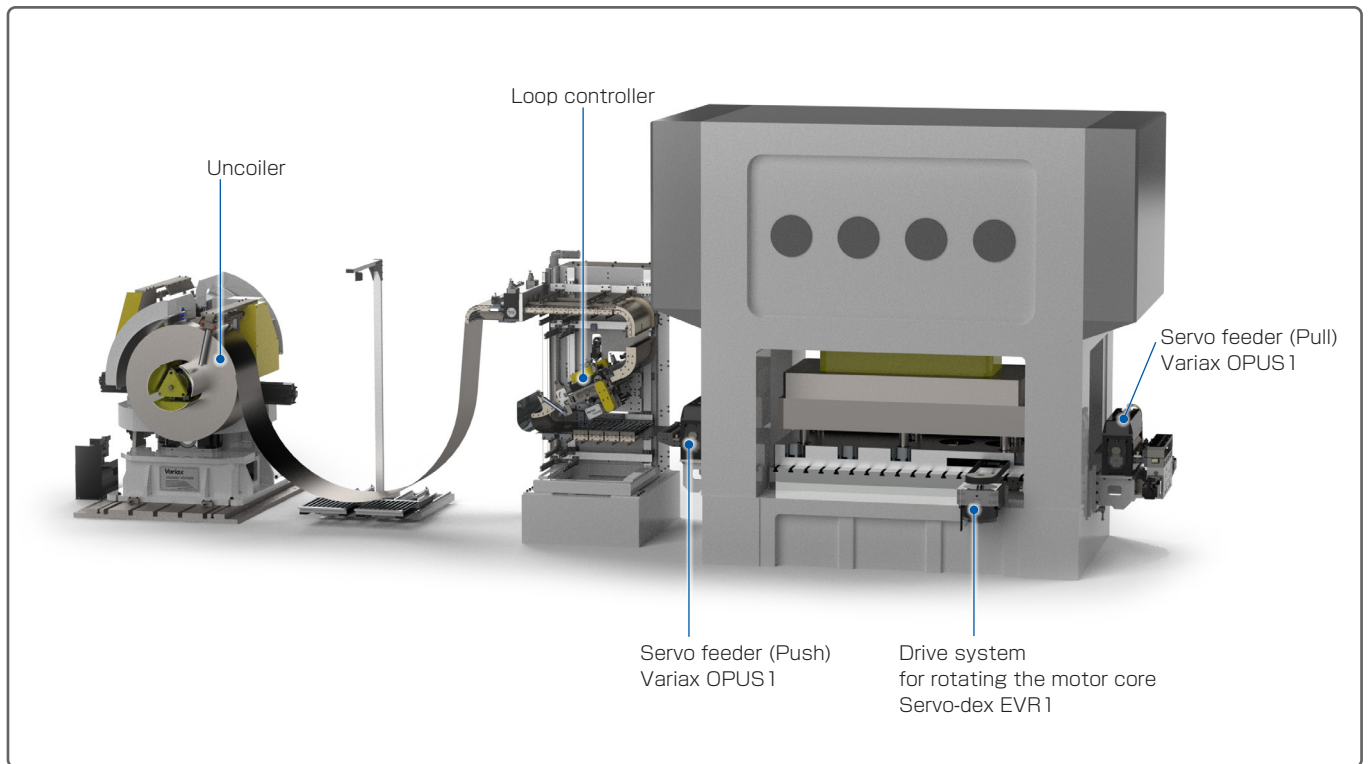
\*2: Starting at B001, please select the functions you need. (You can select as many as you like)

\*3: For control option details, refer to the product specifications.

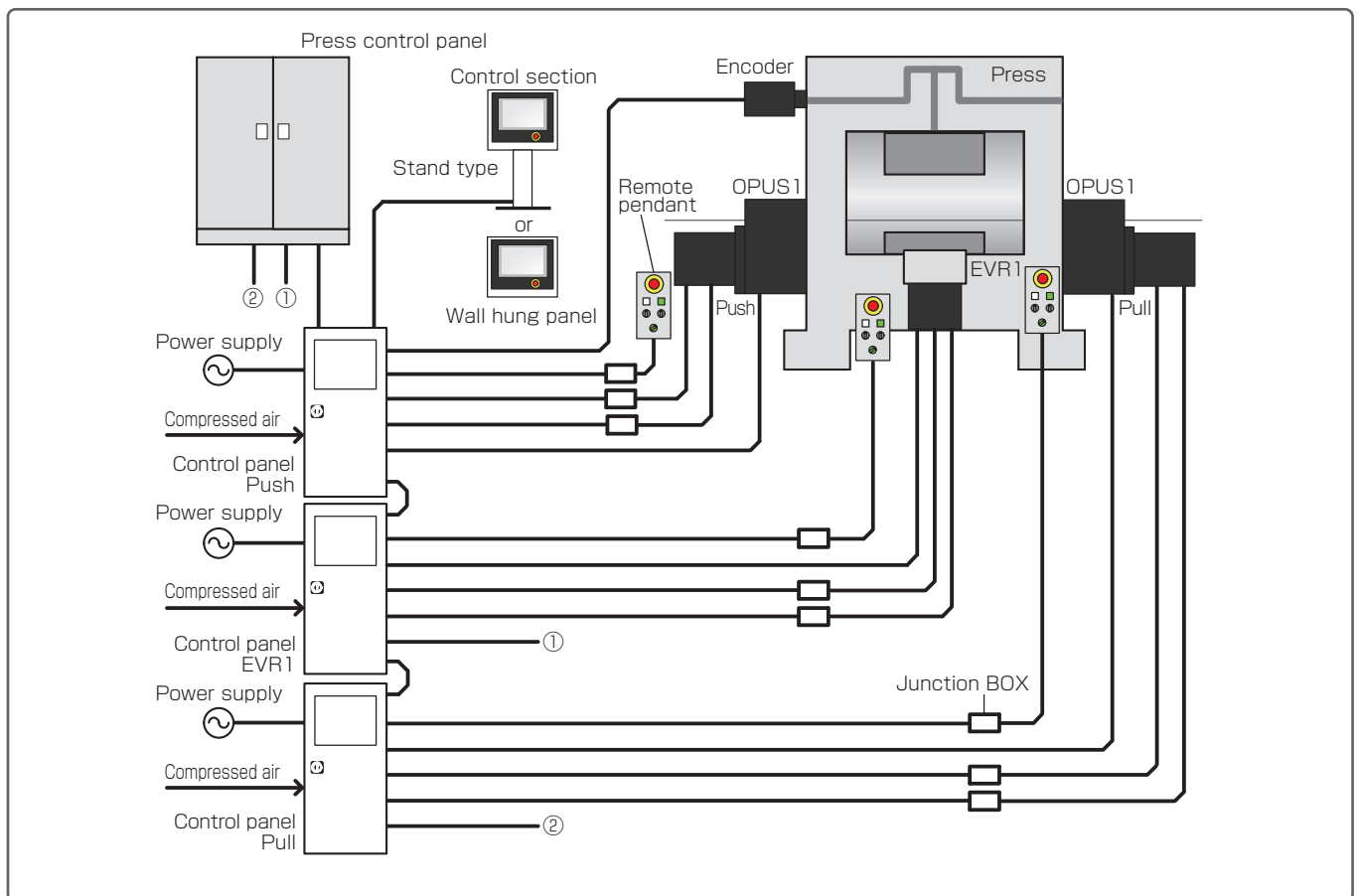
\*4: The final number in the version code increases with each design change and may change without prior notice.

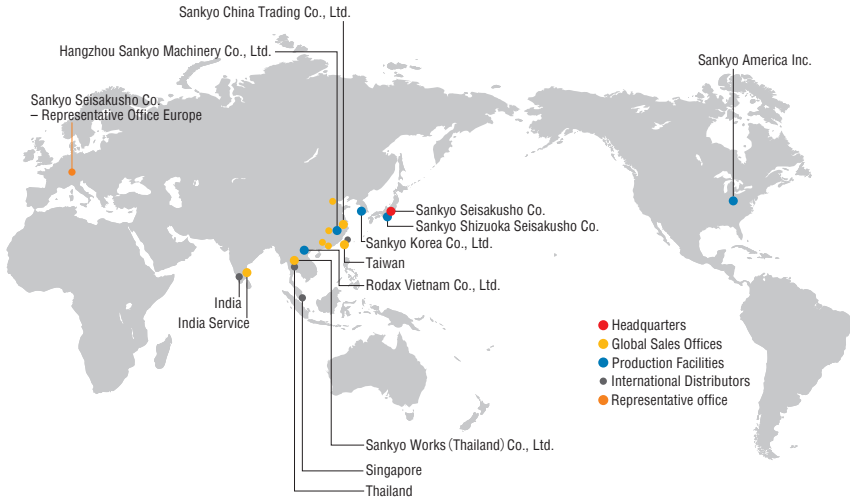
# Application

## Motor core line for electric motors used in automobiles (OPUS1x2, EVR1)



## Control configuration diagram(OPUS1x2, EVR1)





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