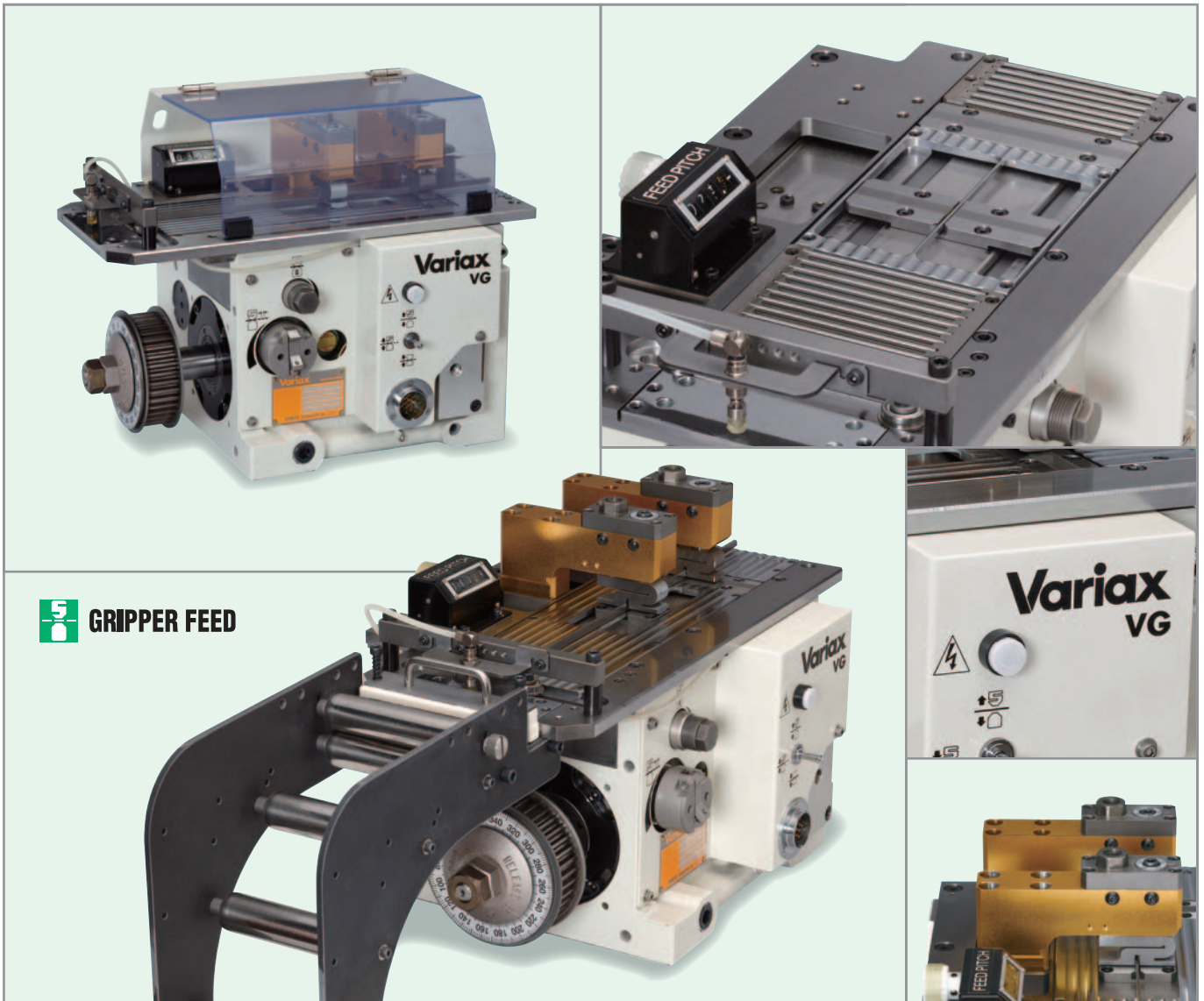
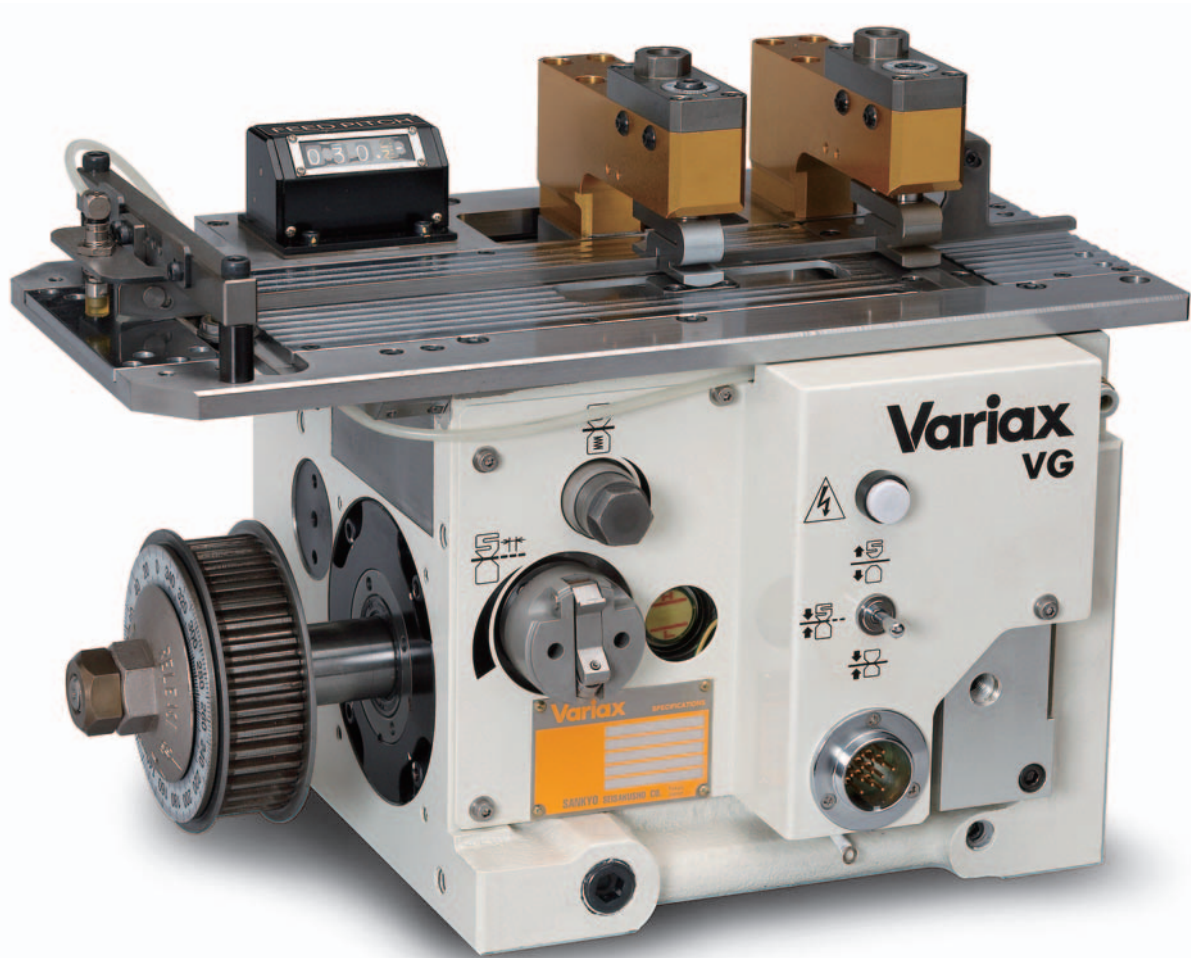


PRECISION ADJUSTABLE FEED

Variax VG Series



**Fine feed with a soft touch. Reliable,
high-speed gripper gives good results.**

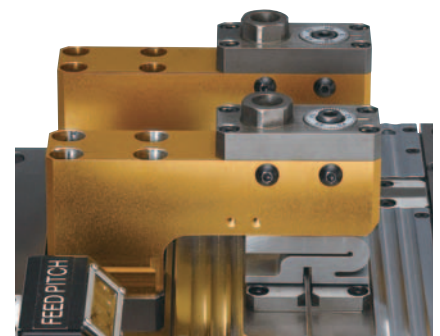


Variax **VG Series** VG15H/20H
VG25/50/75/100/120W

Features

- Various types of models are available to match your feeding conditions.
- Available feed up to 3,600 min⁻¹ ultra fast.(VG15H)
- Combination of the gripper and the clamber is suitable for secondary processing and Materials with different shapes.

This unit feeds materials by gripping them. The combination of four cam mechanisms provides high speed, high precision, and high reliability. Unlike roll feeders that feed materials by rotating the rollers, a gripper feed uses the coefficient of friction to grip materials. Therefore, a gripper feed makes it possible to feeding materials with different shapes and also soft materials. It will not create pressure scars or flaws on materials, feeds in fine increments if desired and can feed at super-high speed. It can also be used as a secondary processing feed. Various types of gripper feeders are available to match your feeding conditions.



Material thickness can be set by adjusting the dial
(VG25T/50T/75T)

Outline and Specifications

Specifications

Size	Units	High speed type		Genera-purpose Type				Wide width type
		VG15H	VG20H	VG25(T)	VG50(T)	VG75(T)	VG100(T)	VG120W
Feed Length	mm	0 to 15	0 to 20	0 to 25	0 to 50	0 to 75	0 to 100	0 to 120
Adjustment Units for Feed Pitch	mm	0.02	0.02	0.02	0.02	0.02	0.02	0.001
Material Thickness*1 *2	mm	0 to 0.5	0 to 2	0 to 2	0 to 2	0 to 2	0 to 2	0 to 1
Grip Force	N	400 to 1,200	400 to 1,200	400 to 1,200	400 to 1,200	400 to 1,200	300 to 3,000	600 to 2,400
Material Width	mm	8 to 50	8 to 50	8 to 100	8 to 100	8 to 100	12 to 120	20 to 250
Max. Strokes	min ⁻¹	3,600	1,800	1,200	1,000	700	500	250
Max. Feeding Speed	m/min	30	30	25	30	30	30	30
Feed Angle	deg	156	164	165	165	165	165	160
Repeat Accuracy*3	mm	±0.035	±0.025	±0.025	±0.025	±0.025	±0.025	±0.05
Pilot release	deg	Approx. 72	Approx. 51	Approx. 49	Approx. 49	Approx. 49	Approx. 54	Approx. 49
Input Shaft Drive Ratio (Input: Stroke)		1:3	1:2	1:1	1:1	1:1	1:1	1:2
Operating air pressure*4	kPa	490 to 690	490 to 690	490 to 690	490 to 690	490 to 690	490 to 690	490 to 690
Lubrication System		Forced lubrication	Forced lubrication	Oil bath/Forced lubrication	Oil bath/Forced lubrication	Oil bath/Forced lubrication	Oil bath/Forced lubrication	Forced lubrication
Operating power supply		100 VAC single phase, 50/60 Hz (115 VAC 50/60 Hz, 24 VDC)						
Weight	kg	60	60	60	60	60	150	290

*1 A material thickness adjustment dial is furnished on the high-speed type, some general-purpose types (VG__T), and the wide width type. For all other general-purpose types, material thickness is adjusted by shims.

*2 Contact Sankyo for material thicknesses of more than 1mm.

*3 The values listed here are Sankyo internal testing standards. Repeatability varies according to actual operating conditions.

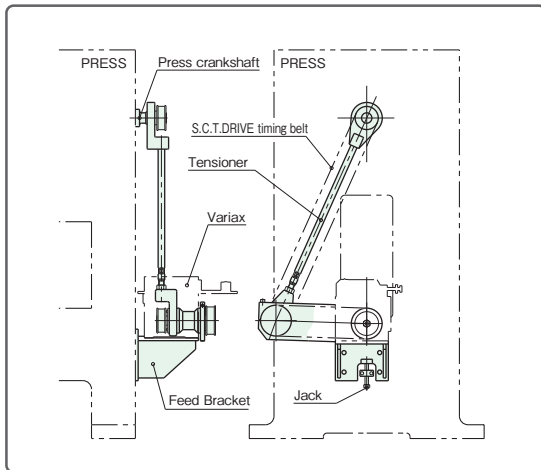
*4 Compressed air with a high moisture content can lead to equipment failure. Furnish an air dryer or mist separator to prevent moisture (condensation).

Use an air filter with a porosity grade of 5 μm or less.

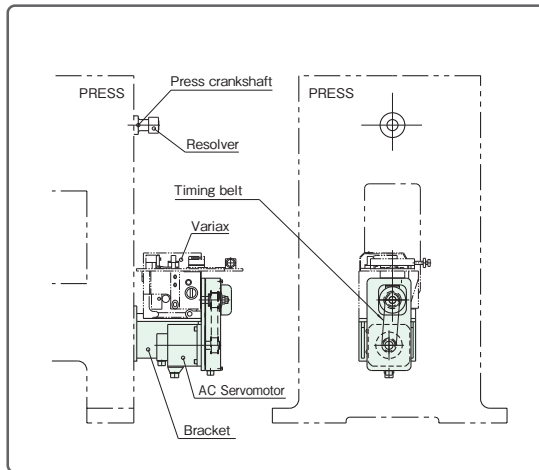
Make sure the air supply is at the specified pressure. Insufficient pressure may cause the release action to fail.

Drive method

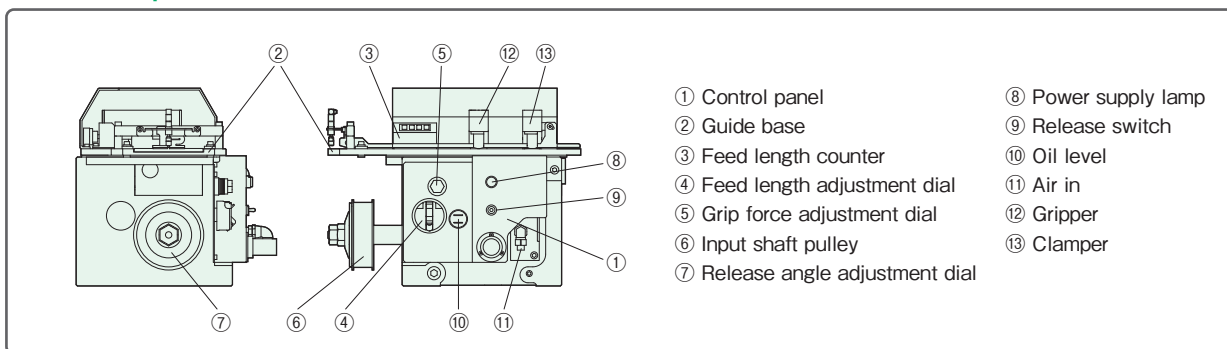
Self-Compensating Tensioning drives (S.C.T)



Variax Servo Drive system (V.S.D)



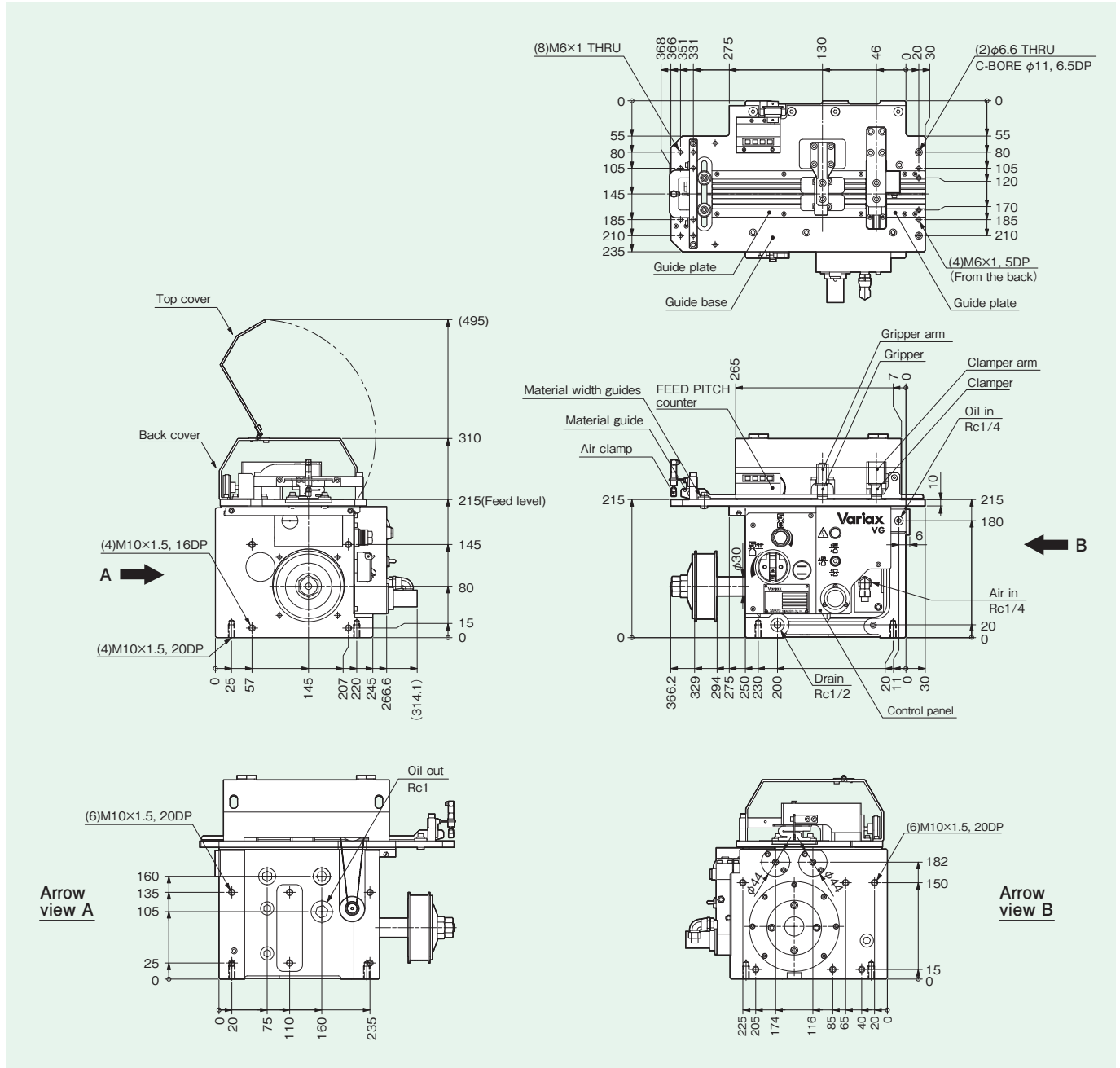
Feed components



VG15H

Dimensions

[Unit:mm]



Specification table

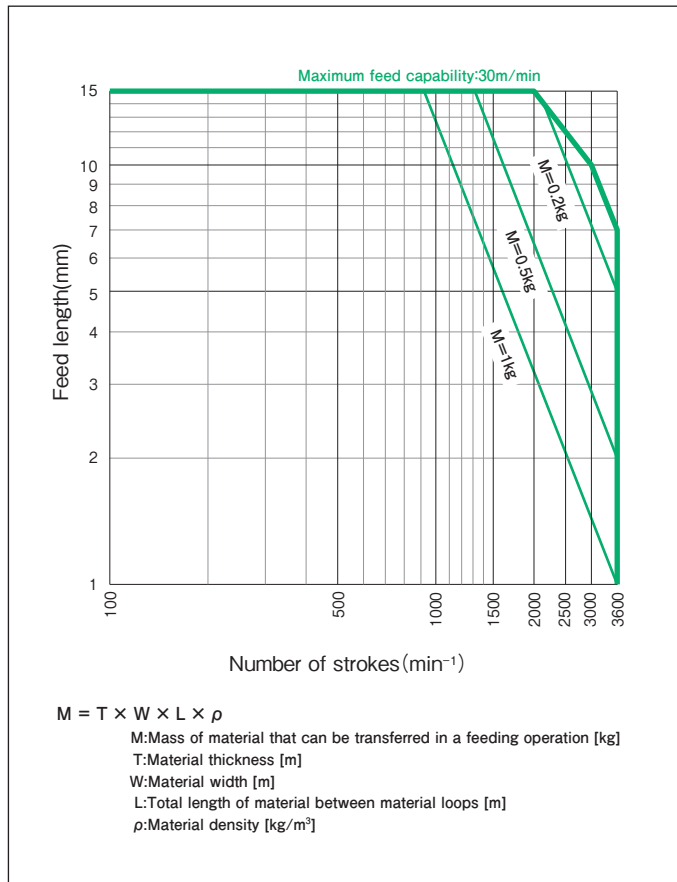
Characteristic	Data
Feed length	0 to 15 [mm]
Adjustment Units for Feed Pitch	0.02 [mm]
Material thickness	0 to 0.5 [mm]
Gripping force	400 to 1,200 [N]
Material width	8 to 50 [mm]
Maximum number of strokes	3,600 [min ⁻¹]
Maximum feed speed	30 [m/min]
Feed Angle	156 [deg]
Repeatability	±0.035 [mm]
Pilot Release	Approx. 72 [deg]
Air Release	Full adjustable
Input Shaft Drive Ratio (Input: Stroke)	1:3*

Characteristic	Data
Operating air pressure	490 to 690 [kPa]
Operating power supply	100 VAC single phase [V]
Product weight	60 [kg]
Recommended lubrication oil	Shell Omala S2 G 150
Lubrication system	Forced lubrication
Amount of internal oil for oil bath lubrication	—
Amount of oil supplied for forced lubrication	0.4 [ℓ/min]
Housing color	2.5Y9/02
Operation panel color	2.5Y9/02

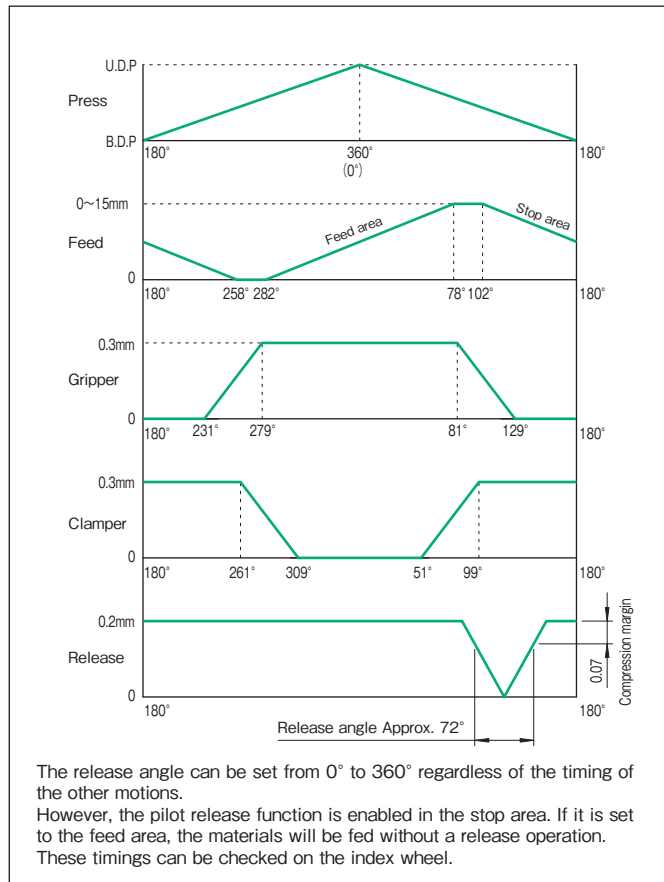
1 [N·m] ≒ 0.102 [kgf·m]

*The VG15H performs three feed operations per turn of the input shaft, reducing the input shaft drive speed to 1/3 of normal.

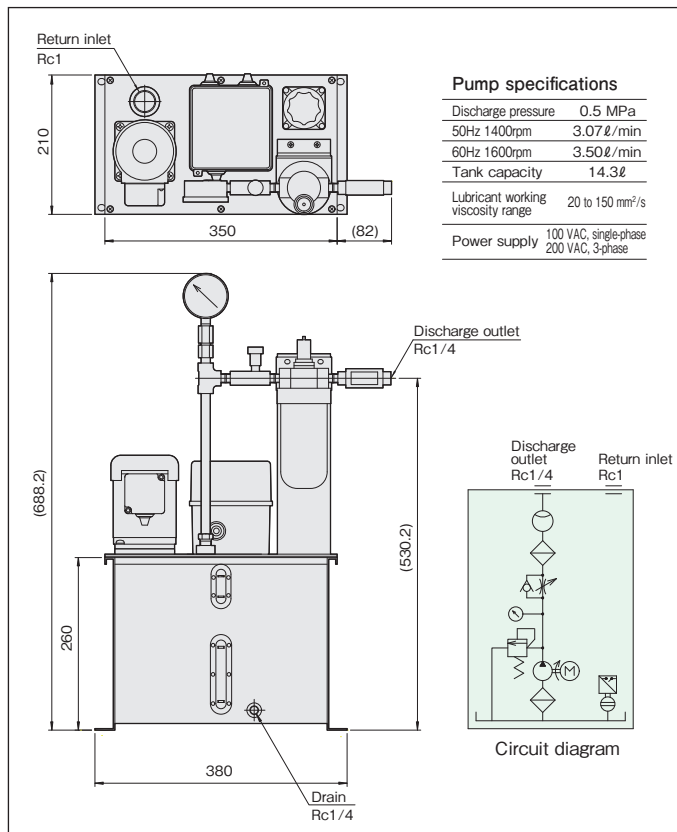
Maximum feed capability chart



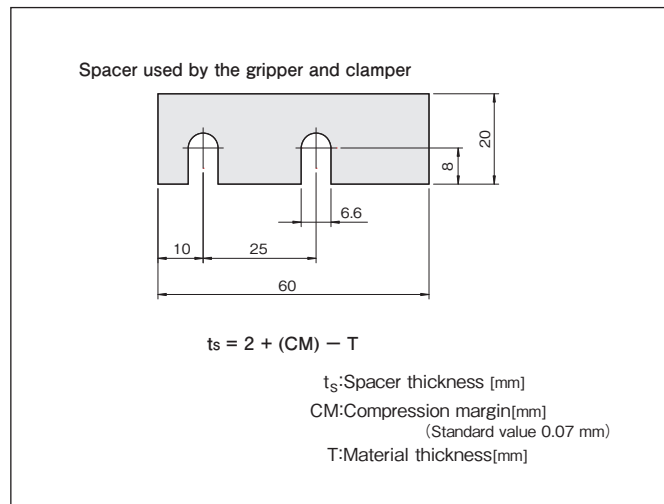
Timing chart



Oil pump

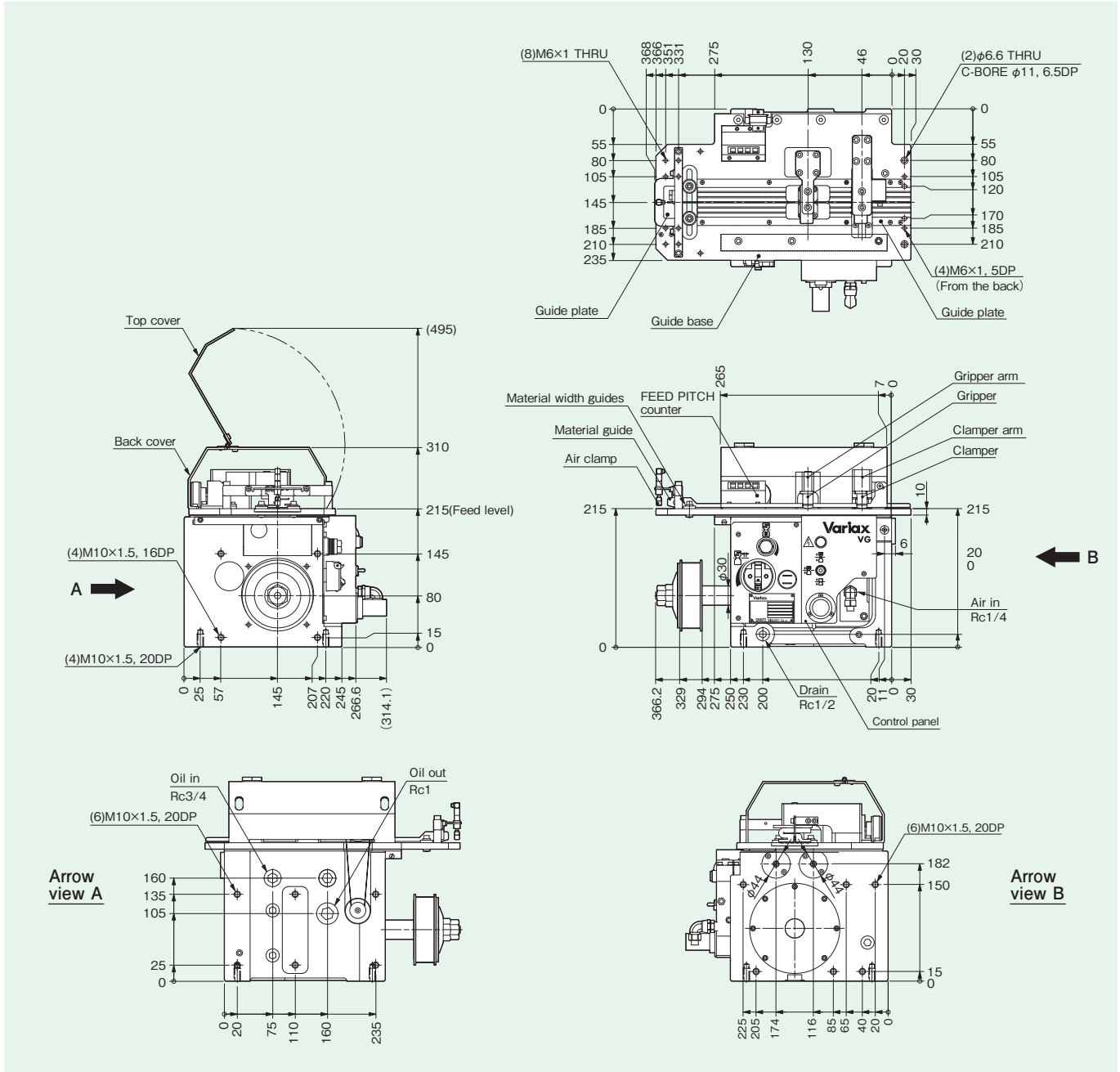


Spacer for plate thickness adjustment



Dimensions

[Unit:mm]



Specification table

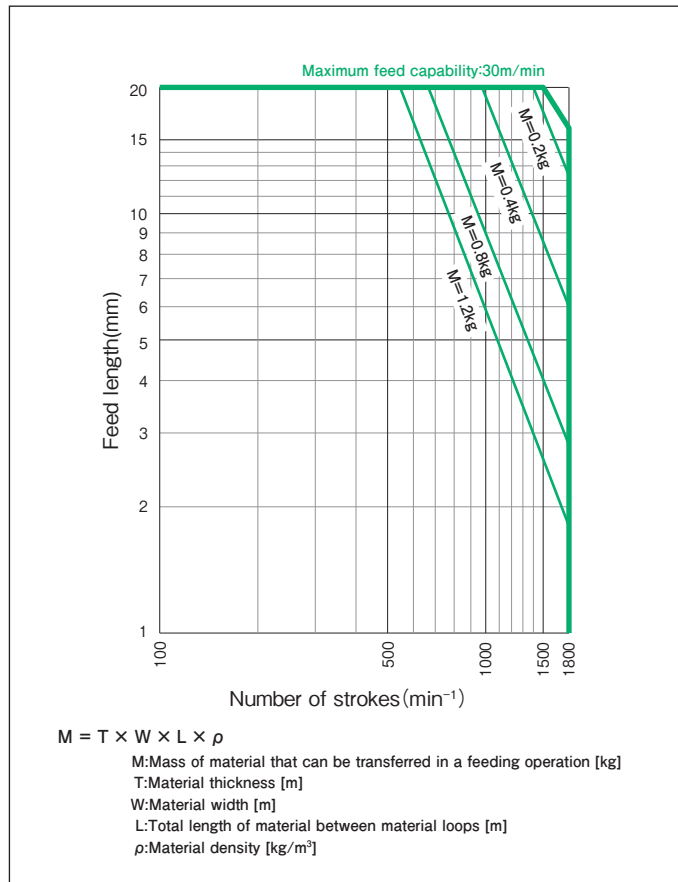
Characteristic	Data
Feed length	0 to 20 [mm]
Adjustment Units for Feed Pitch	0.02 [mm]
Material thickness	0 to 2 [mm]
Gripping force	400 to 1,200 [N]
Material width	8 to 50 [mm]
Maximum number of strokes	1,800 [min ⁻¹]
Maximum feed speed	30 [m/min]
Feed Angle	164 [deg]
Repeatability	±0.025 [mm]
Pilot Release	Approx. 51 [deg]
Air Release	Full adjustable
Input Shaft Drive Ratio (Input: Stroke)	1:2*

Characteristic	Data
Operating air pressure	490 to 690 [kPa]
Operating power supply	100 VAC single phase [V]
Product weight	60 [kg]
Recommended lubrication oil	Shell Omala S2 G 150
Lubrication system	Forced lubrication
Amount of internal oil for oil bath lubrication	—
Amount of oil supplied for forced lubrication	0.4 [ℓ/min]
Housing color	2.5Y9/02
Operation panel color	2.5Y9/02

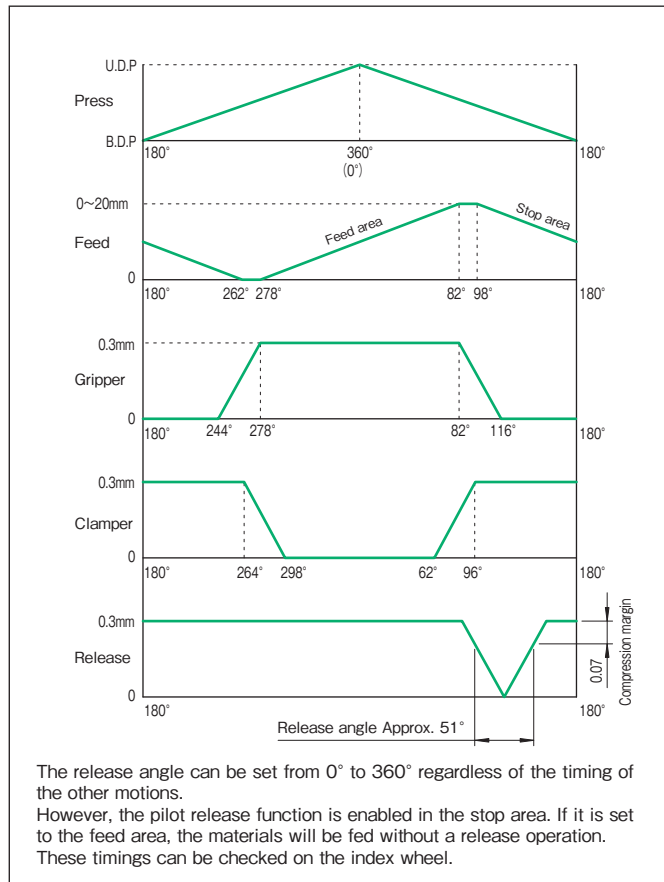
1 [N·m] ≅ 0.102 [kgf·m]

*The VG20H performs two feed operations per turn of the input shaft, reducing the input shaft drive speed to 1/2 of normal.

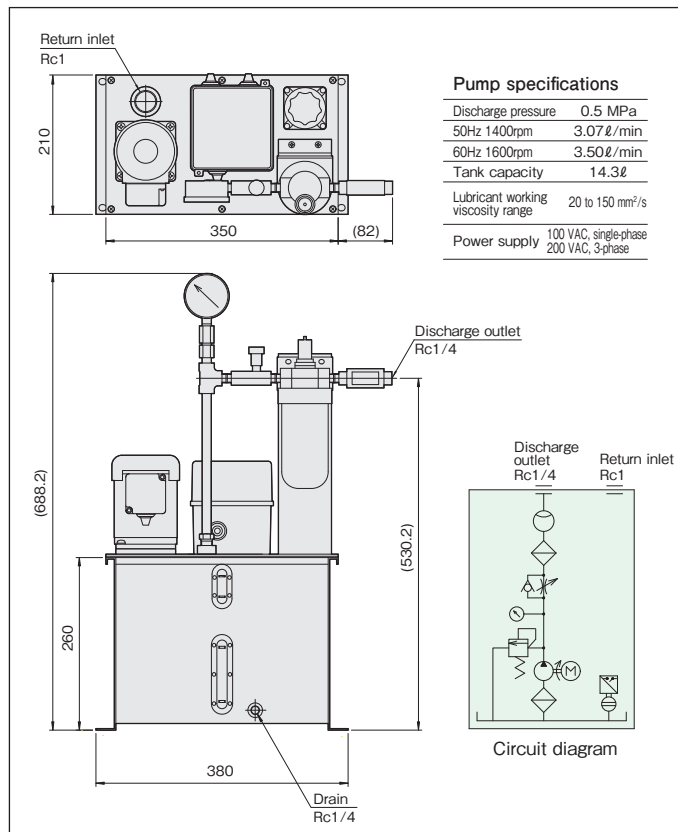
Maximum feed capability chart



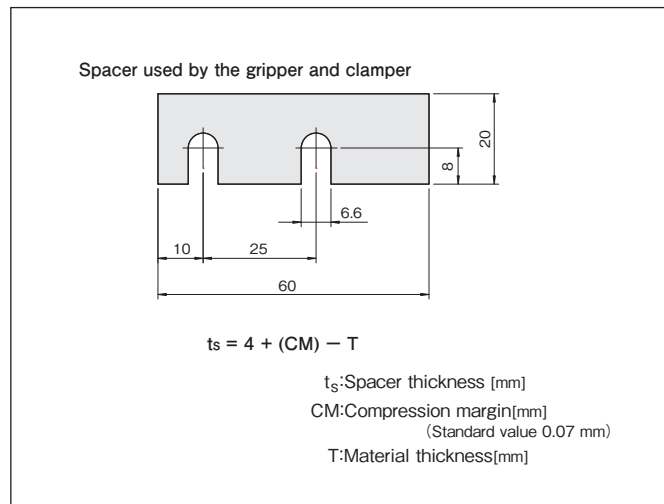
Timing chart



Oil pump



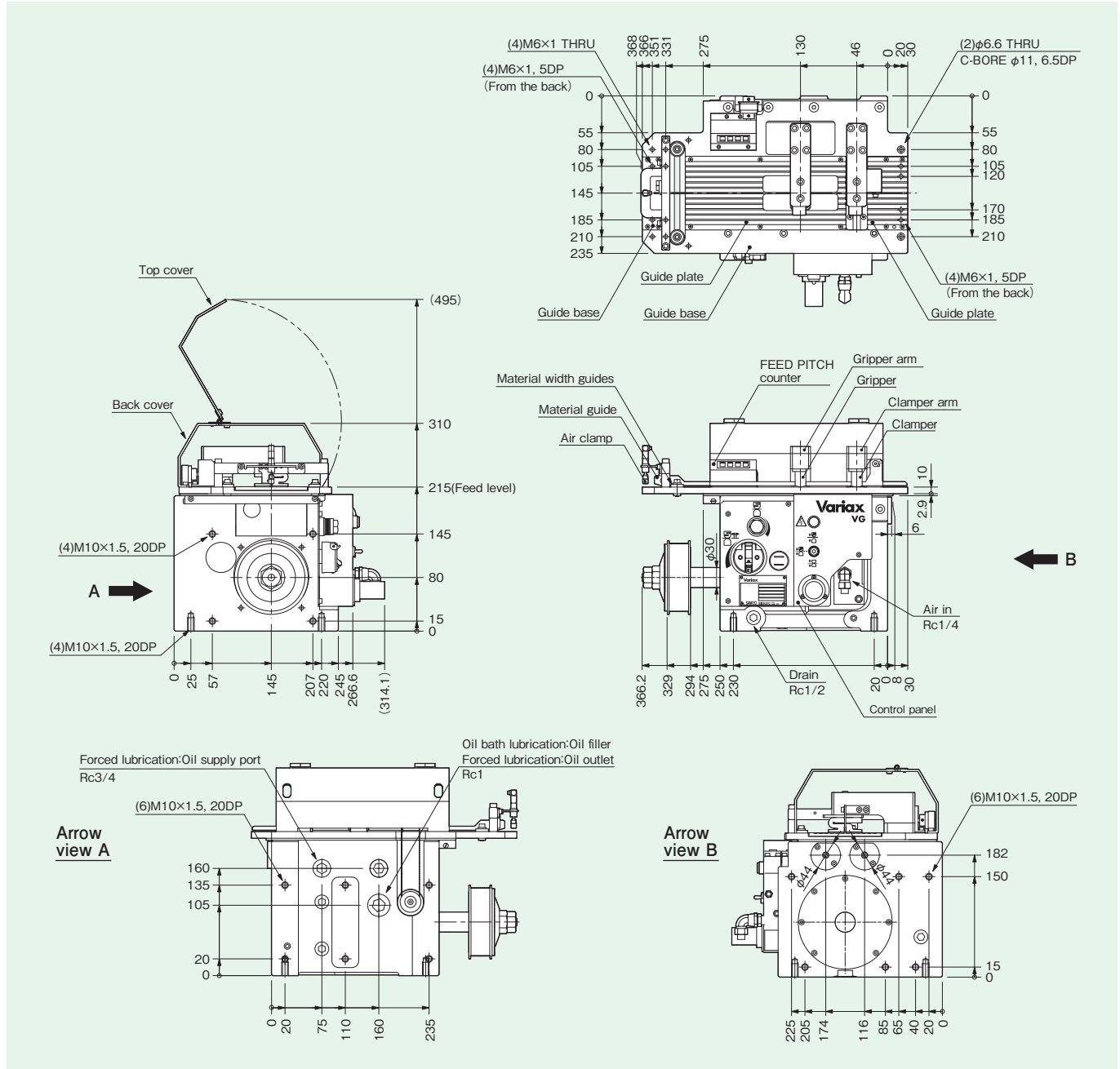
Spacer for plate thickness adjustment



VG25/VG25T

Dimensions

[Unit:mm]



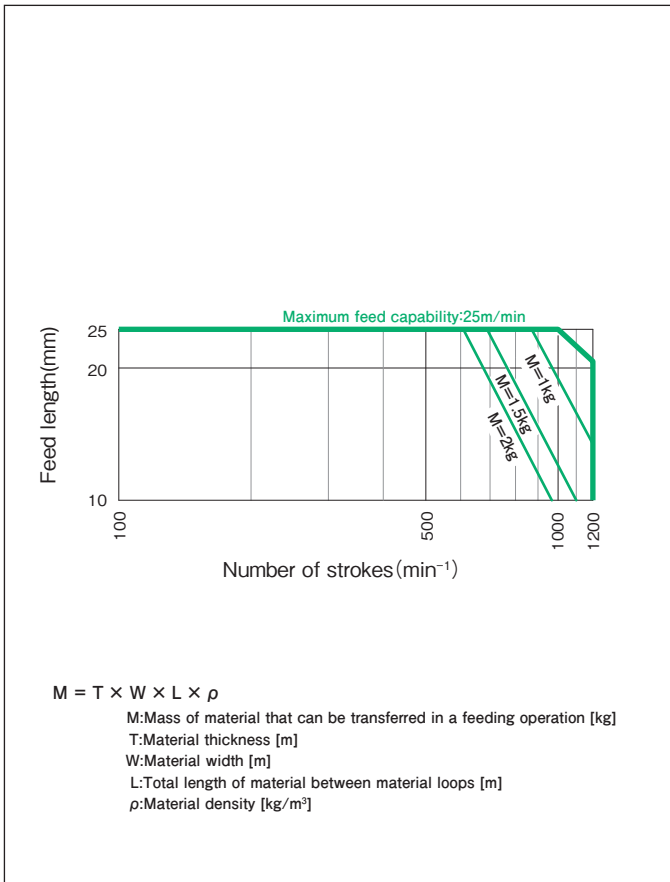
Specification table

Characteristic	Data
Feed length	0 to 25 [mm]
Adjustment Units for Feed Pitch	0.02 [mm]
Material thickness	0 to 2 [mm]
Gripping force	400 to 1,200 [N]
Material width	8 to 100 [mm]
Maximum number of strokes	1,200 [min ⁻¹]
Maximum feed speed	25 [m/min]
Feed Angle	165 [deg]
Repeatability	±0.025 [mm]
Pilot Release	Approx. 49 [deg]
Air Release	Full adjustable
Input Shaft Drive Ratio (Input: Stroke)	1:1

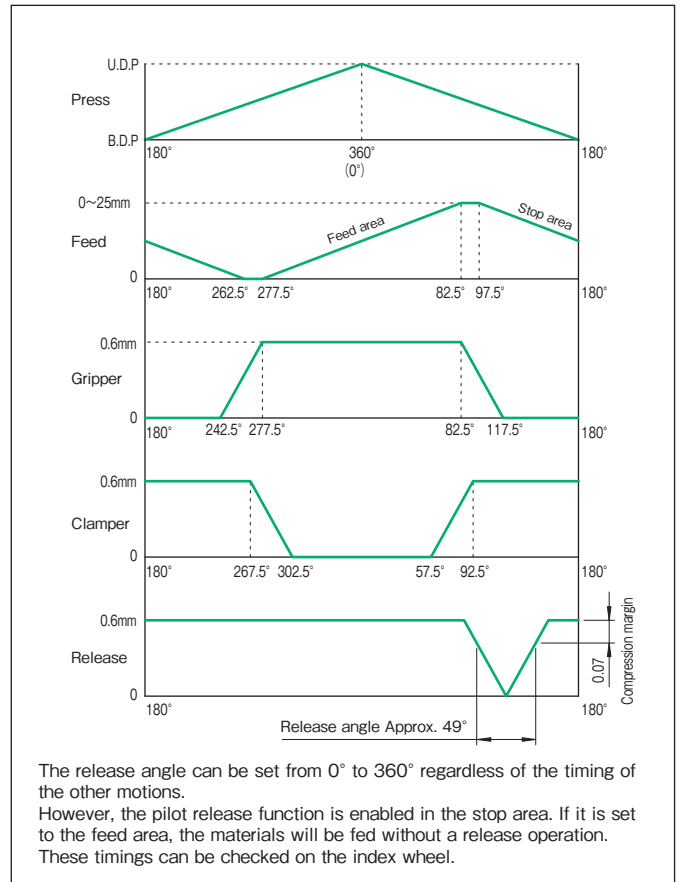
Characteristic	Data
Operating air pressure	490 to 690 [kPa]
Operating power supply	100 VAC single phase [V]
Product weight	60 [kg]
Recommended lubrication oil	Shell Omala S2 G 150
Lubrication system	Oil bath/Forced lubrication
Amount of internal oil for oil bath lubrication	1.4 [ℓ]
Amount of oil supplied for forced lubrication	0.4 [ℓ/min]
Housing color	2.5Y9/02
Operation panel color	2.5Y9/02

1[N·m] ≅ 0.102[kgf·m]

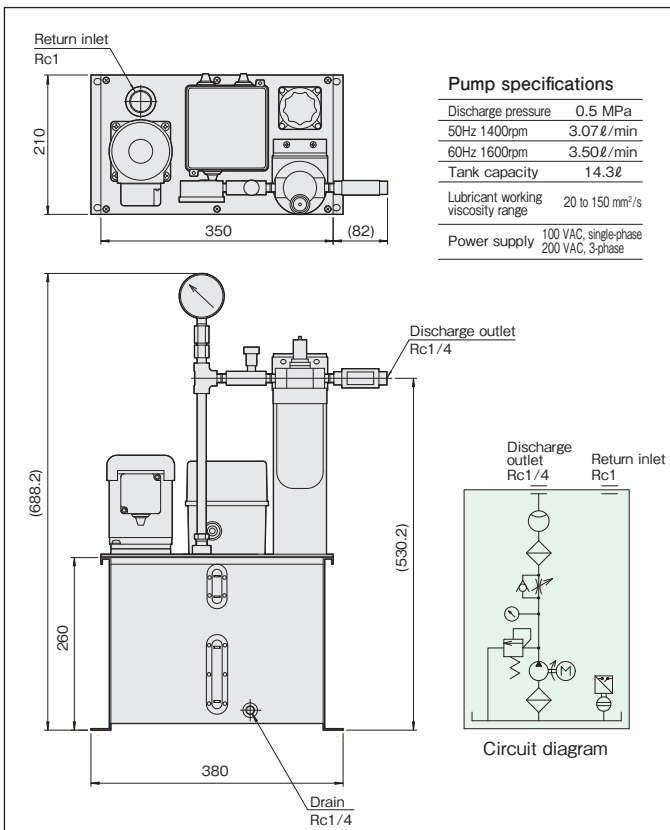
Maximum feed capability chart



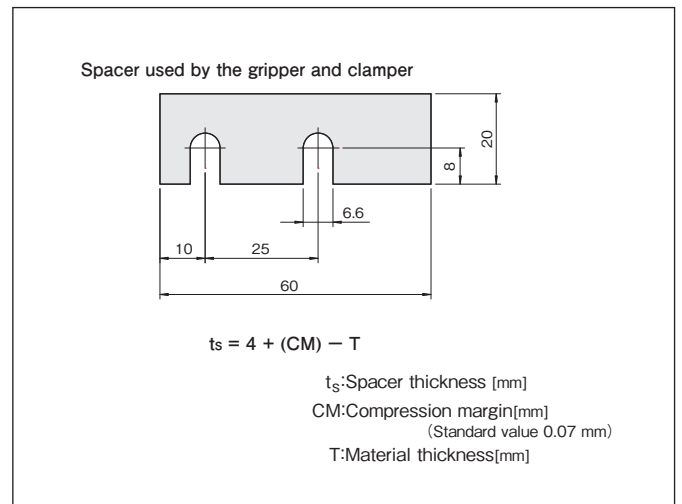
Timing chart



Oil pump



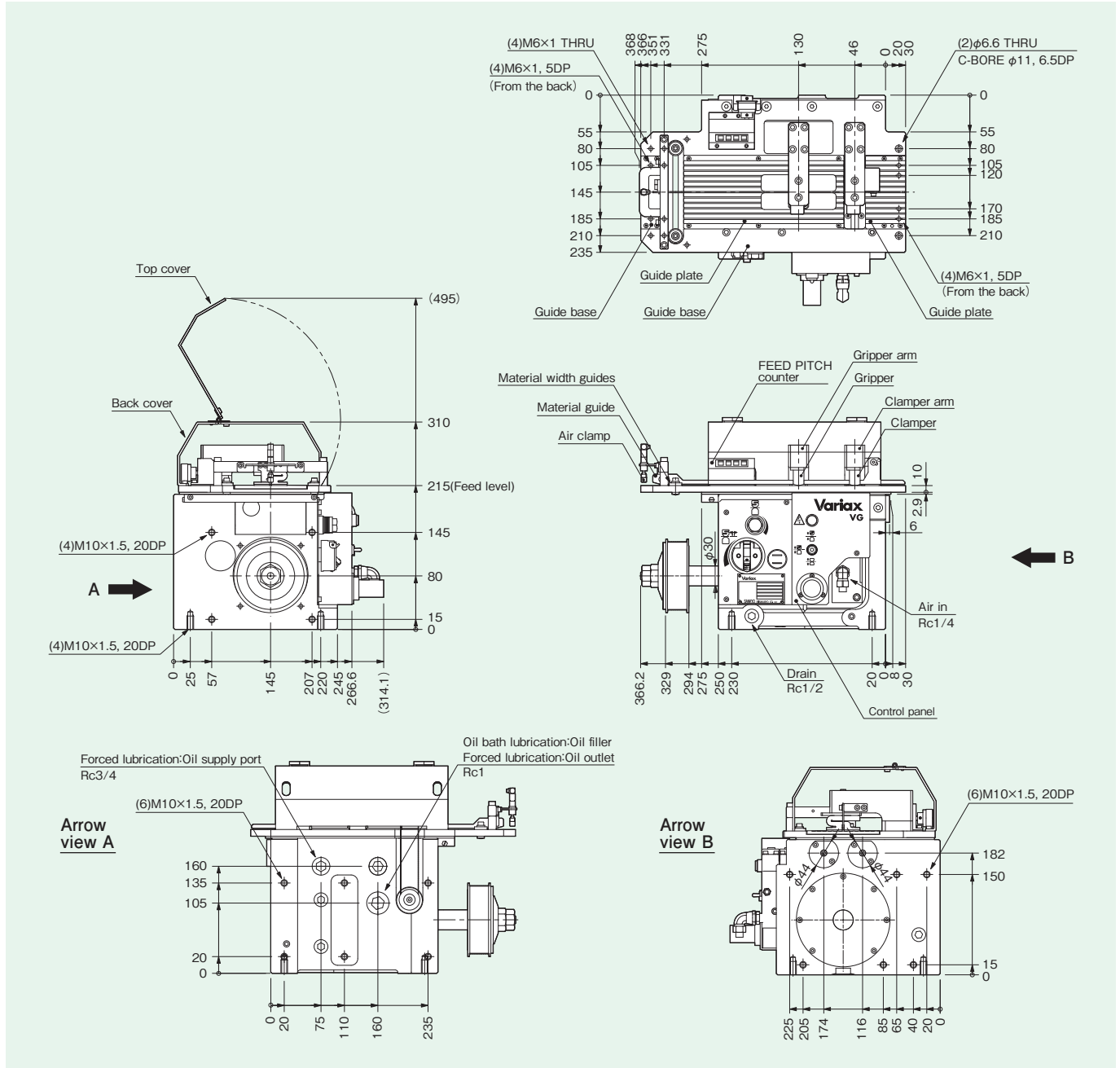
Spacer for plate thickness adjustment



VG50/VG50T

Dimensions

[Unit:mm]



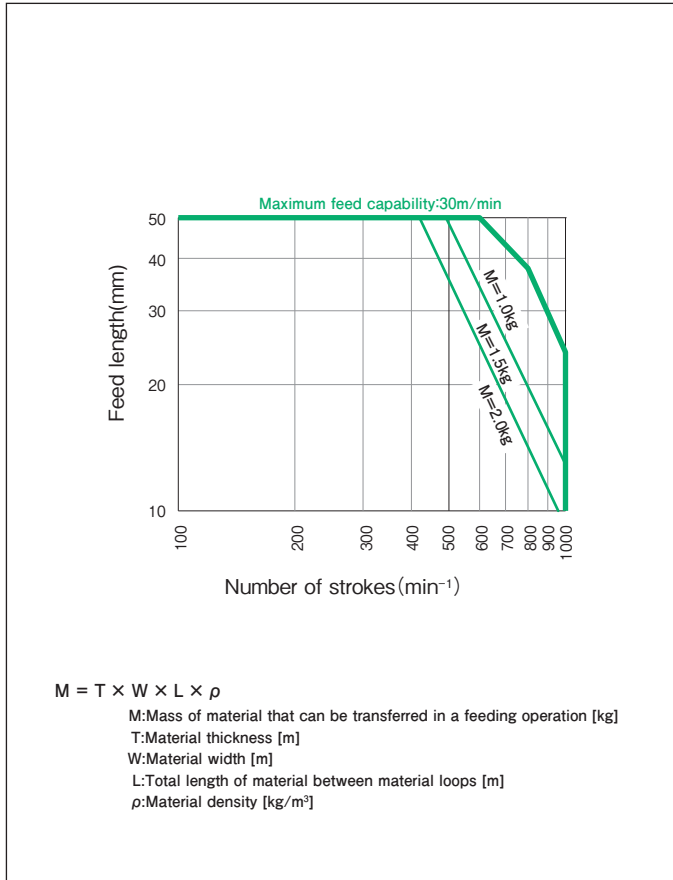
Specification table

Characteristic	Data
Feed length	0 to 50 [mm]
Adjustment Units for Feed Pitch	0.02 [mm]
Material thickness	0 to 2 [mm]
Gripping force	400 to 1,200 [N]
Material width	8 to 100 [mm]
Maximum number of strokes	1,000 [min ⁻¹]
Maximum feed speed	30 [m/min]
Feed Angle	165 [deg]
Repeatability	±0.025 [mm]
Pilot Release	Approx. 49 [deg]
Air Release	Full adjustable
Input Shaft Drive Ratio (Input: Stroke)	1:1

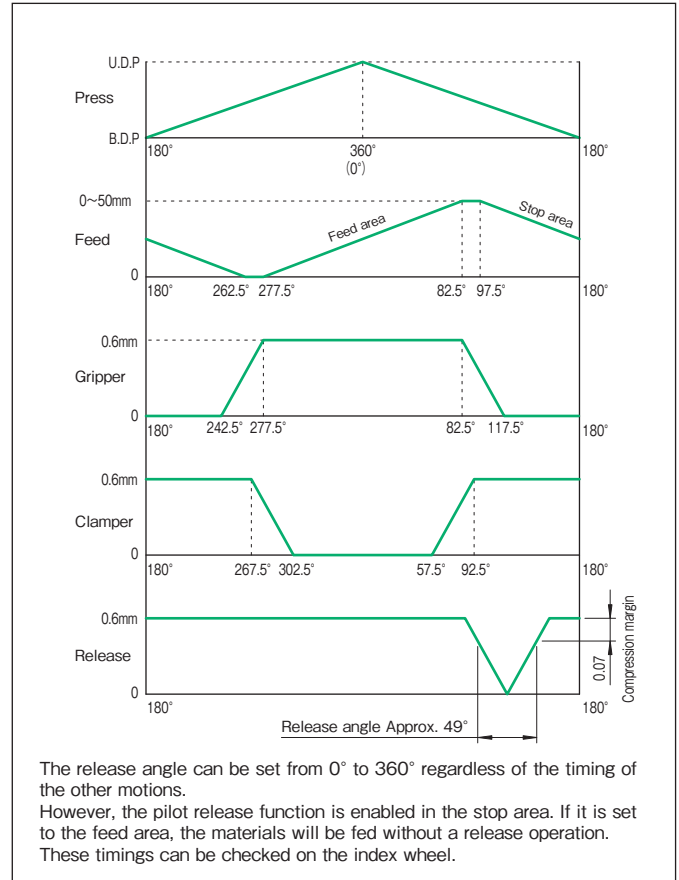
Characteristic	Data
Operating air pressure	490 to 690 [kPa]
Operating power supply	100 VAC single phase [V]
Product weight	60 [kg]
Recommended lubrication oil	Shell Omala S2 G 150
Lubrication system	Oil bath/Forced lubrication
Amount of internal oil for oil bath lubrication	1.4 [ℓ]
Amount of oil supplied for forced lubrication	0.4 [ℓ/min]
Housing color	2.5Y9/02
Operation panel color	2.5Y9/02

1[N·m] ≅ 0.102[kgf·m]

Maximum feed capability chart

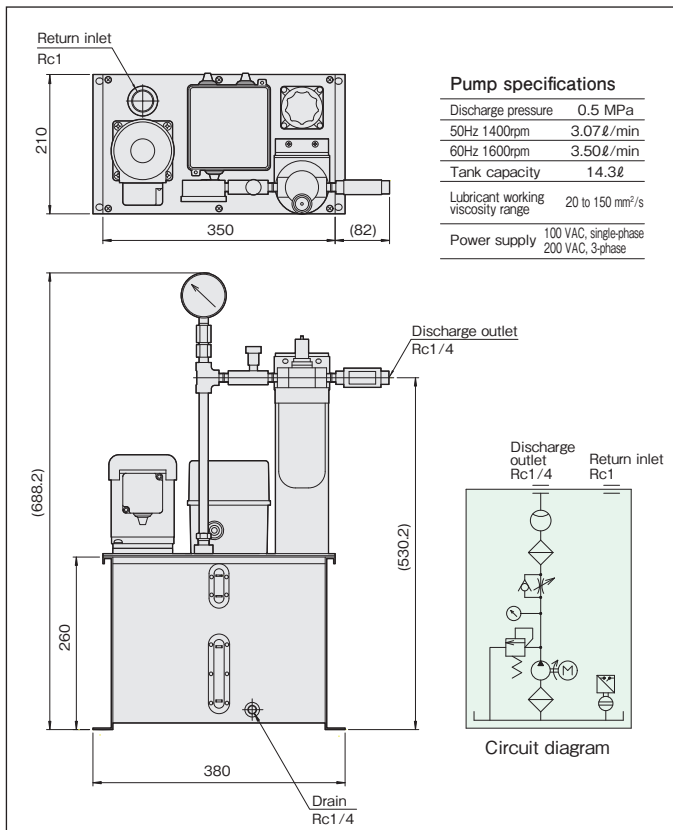


Timing chart

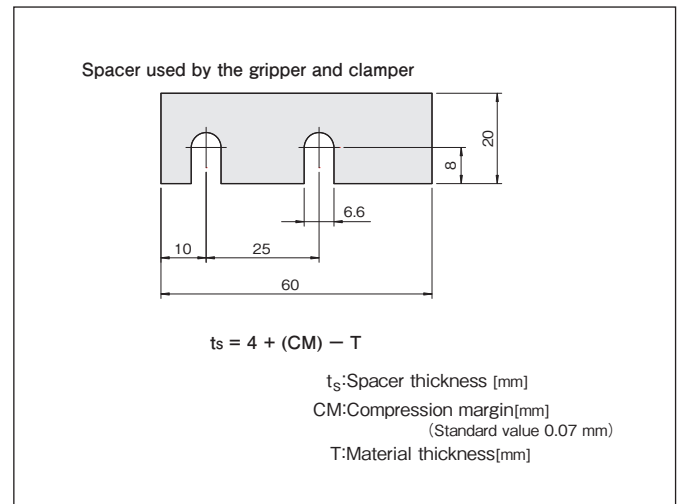


The release angle can be set from 0° to 360° regardless of the timing of the other motions. However, the pilot release function is enabled in the stop area. If it is set to the feed area, the materials will be fed without a release operation. These timings can be checked on the index wheel.

Oil pump



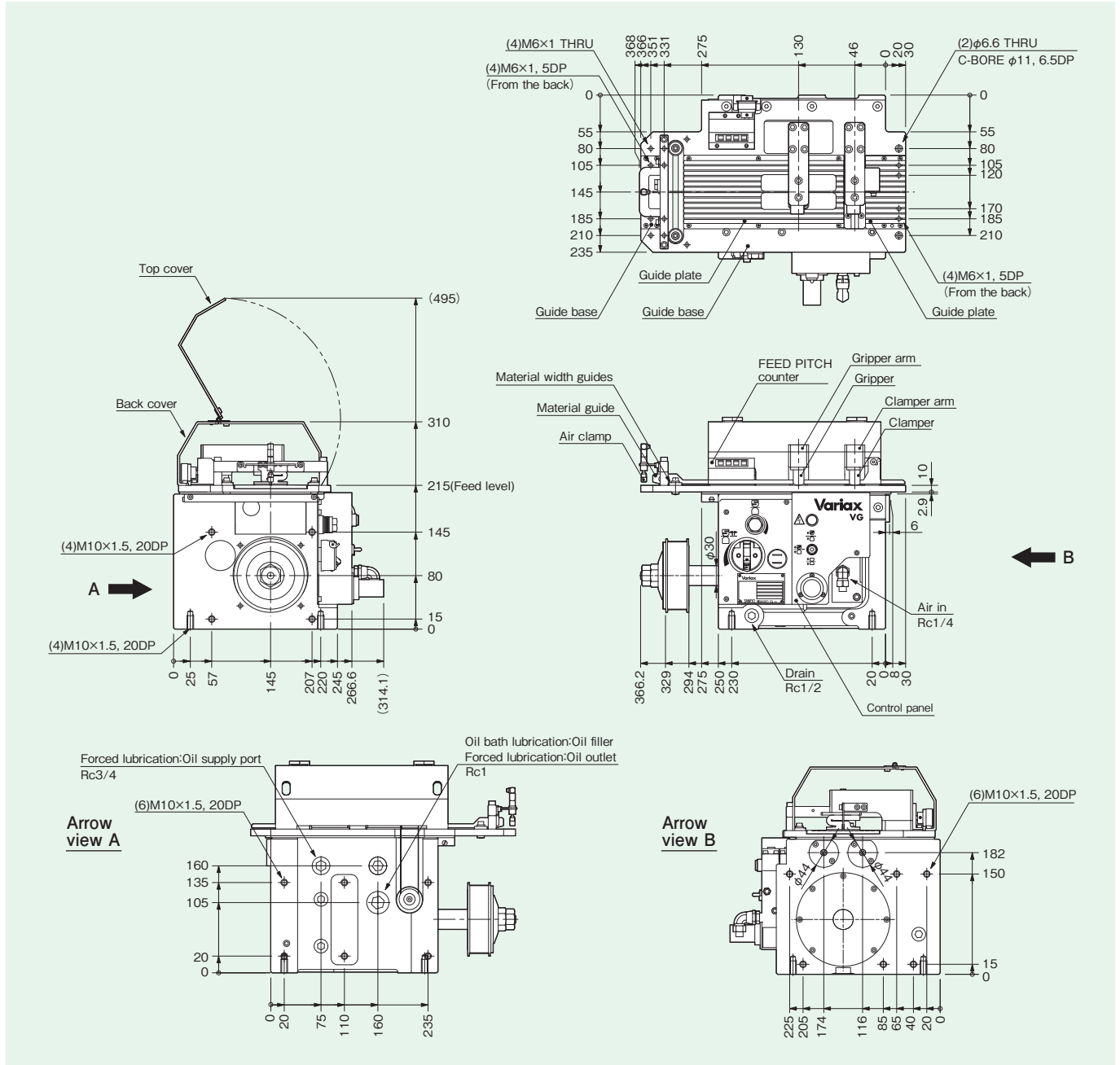
Spacer for plate thickness adjustment



VG75/VG75T

Dimensions

[Unit:mm]



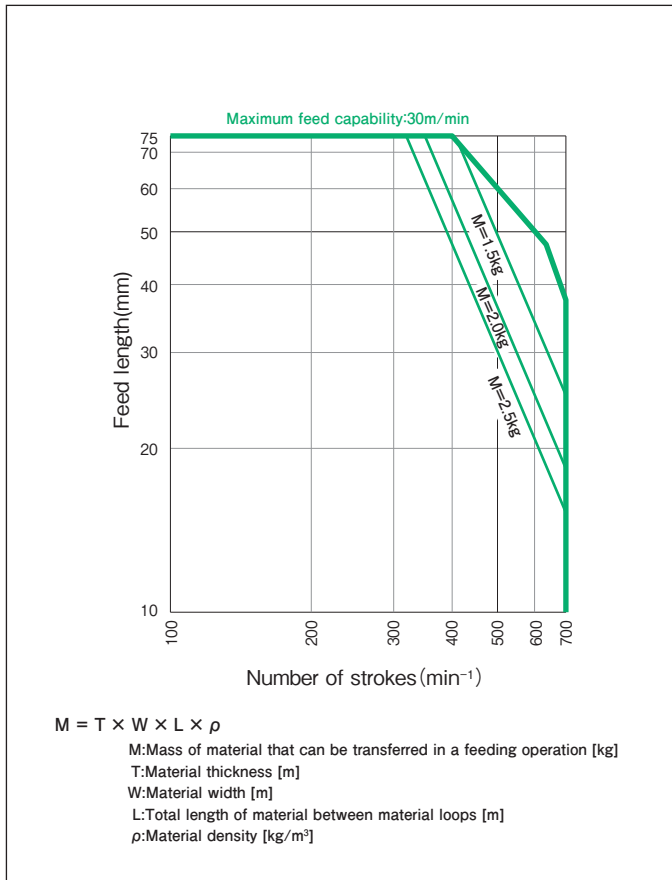
Specification table

Characteristic	Data
Feed length	0 to 75 [mm]
Adjustment Units for Feed Pitch	0.02 [mm]
Material thickness	0 to 2 [mm]
Gripping force	400 to 1,200 [N]
Material width	8 to 100 [mm]
Maximum number of strokes	700 [min ⁻¹]
Maximum feed speed	30 [m/min]
Feed Angle	165 [deg]
Repeatability	±0.025 [mm]
Pilot Release	Approx. 49 [deg]
Air Release	Full adjustable
Input Shaft Drive Ratio (Input: Stroke)	1:1

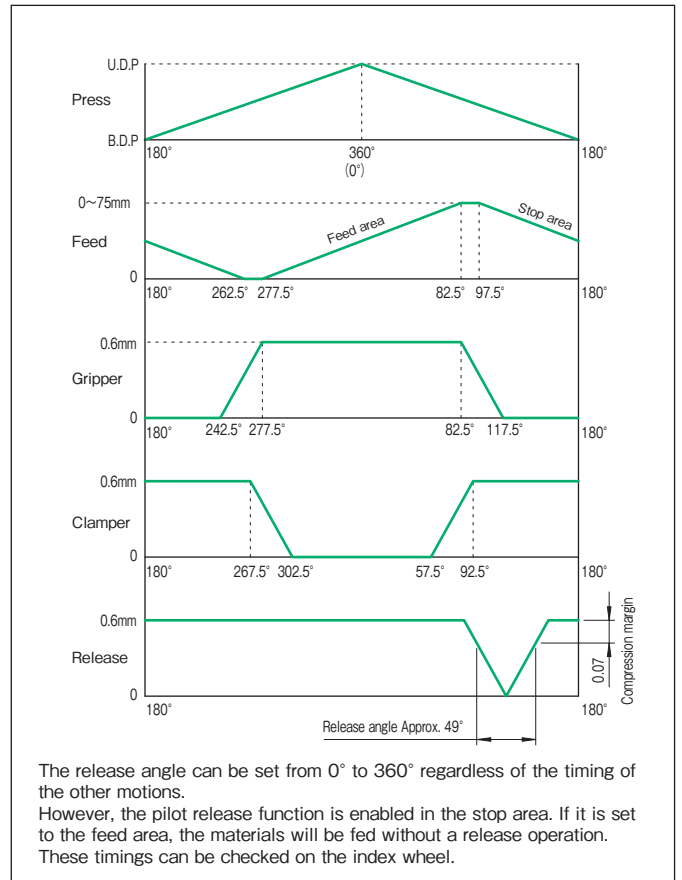
Characteristic	Data
Operating air pressure	490 to 690 [kPa]
Operating power supply	100 VAC single phase [V]
Product weight	60 [kg]
Recommended lubrication oil	Shell Omala S2 G 150
Lubrication system	Oil bath/Forced lubrication
Amount of internal oil for oil bath lubrication	1.4 [ℓ]
Amount of oil supplied for forced lubrication	0.4 [ℓ/min]
Housing color	2.5Y9/02
Operation panel color	2.5Y9/02

1[N·m] ≅ 0.102[kgf·m]

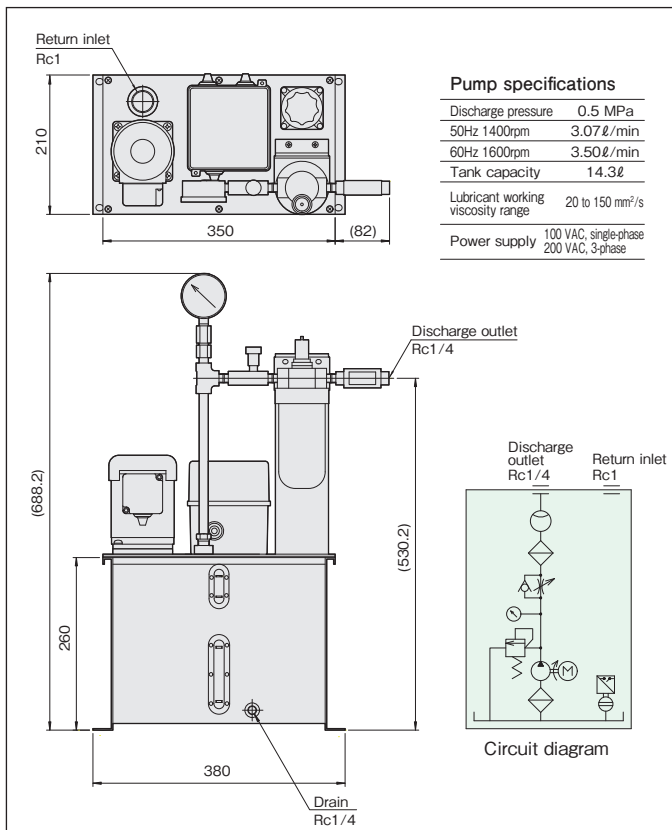
Maximum feed capability chart



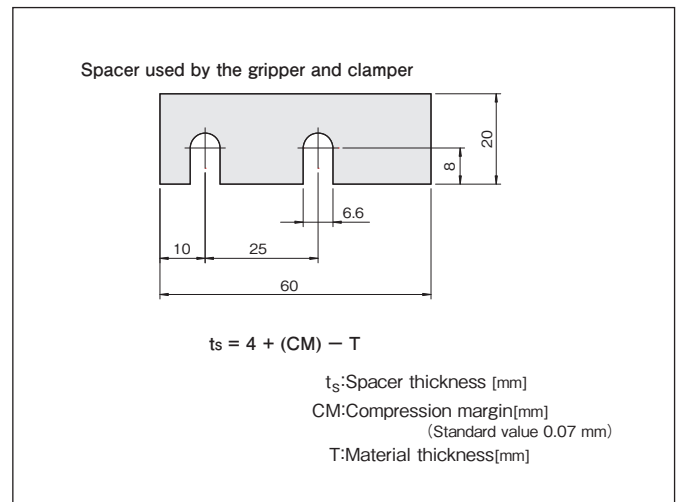
Timing chart



Oil pump



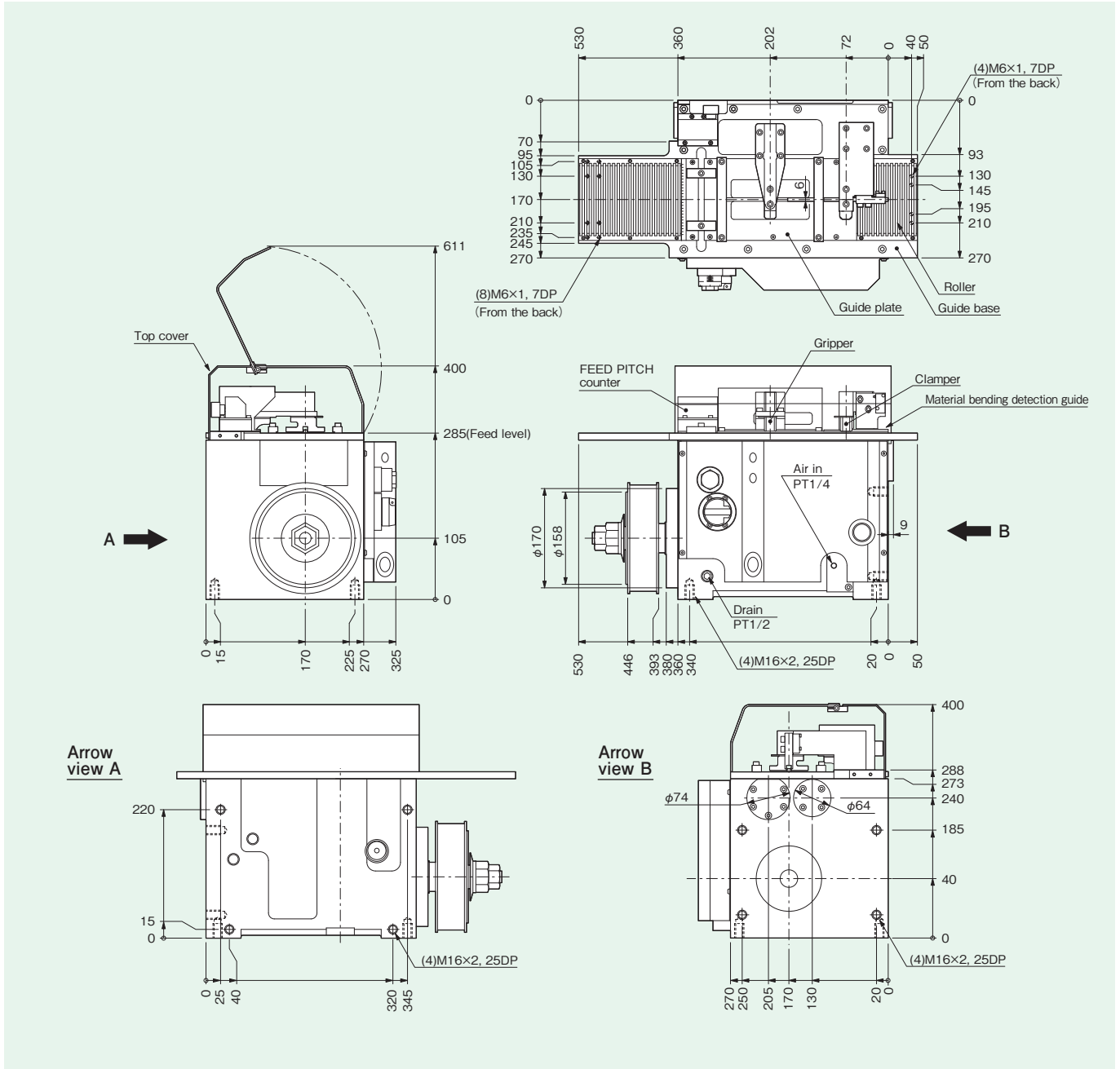
Spacer for plate thickness adjustment



VG100/VG100T

Dimensions

[Unit:mm]



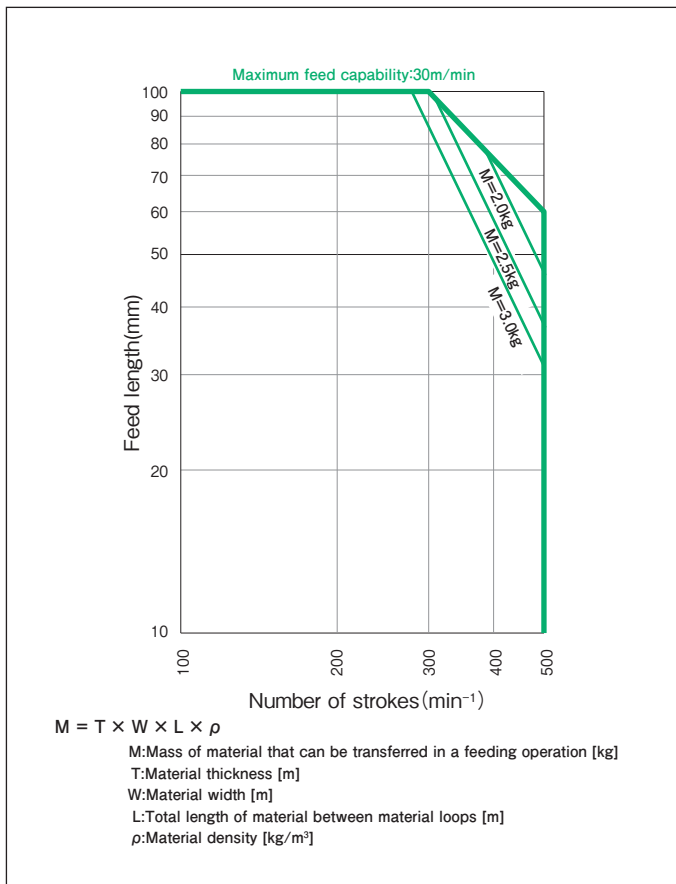
Specification table

Characteristic	Data
Feed length	0 to 100 [mm]
Adjustment Units for Feed Pitch	0.02 [mm]
Material thickness	0 to 2 [mm]
Gripping force	300 to 3,000 [N]
Material width	12 to 120 [mm]
Maximum number of strokes	500 [min ⁻¹]
Maximum feed speed	30 [m/min]
Feed Angle	165 [deg]
Repeatability	±0.025 [mm]
Pilot Release	Approx. 54 [deg]
Air Release	Full adjustable
Input Shaft Drive Ratio (Input: Stroke)	1:1

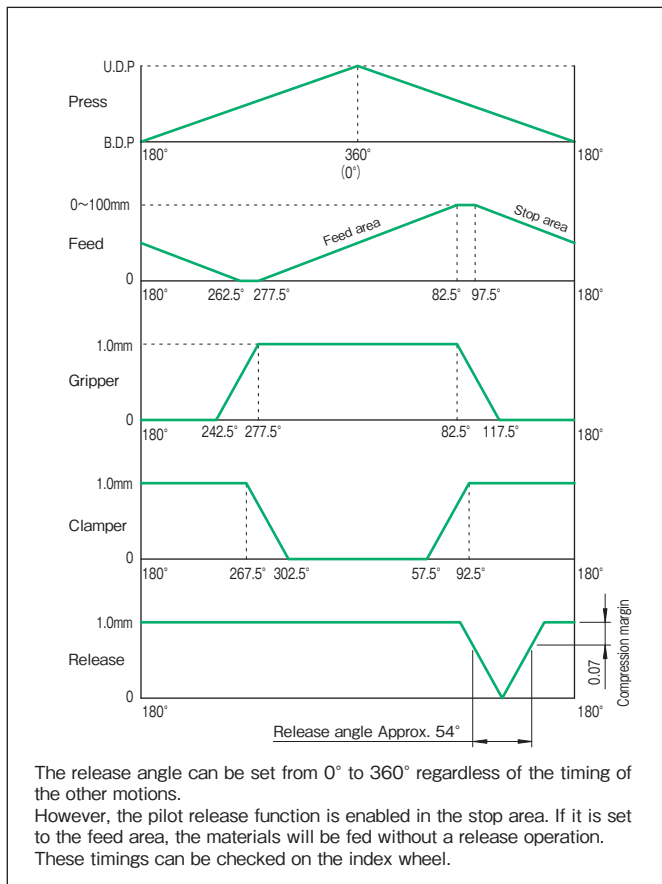
Characteristic	Data
Operating air pressure	490 to 690 [kPa]
Operating power supply	100 VAC single phase [V]
Product weight	150 [kg]
Recommended lubrication oil	Shell Omala S2 G 150
Lubrication system	Oil bath
Amount of internal oil for oil bath lubrication	1.4 [ℓ]
Amount of oil supplied for forced lubrication	— [ℓ/min]
Housing color	2.5Y9/02
Operation panel color	2.5Y9/02

1[N·m] ≒ 0.102[kgf·m]

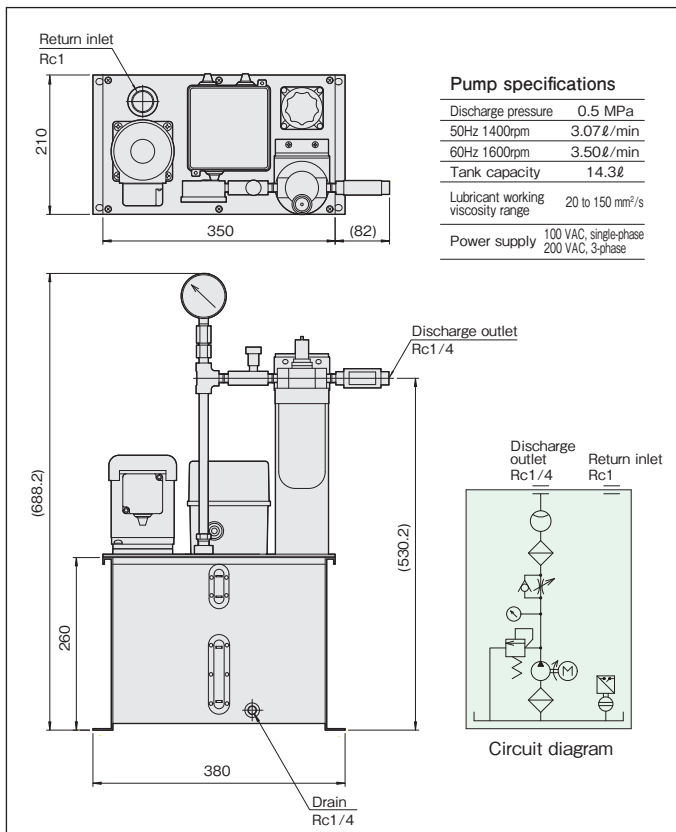
Maximum feed capability chart



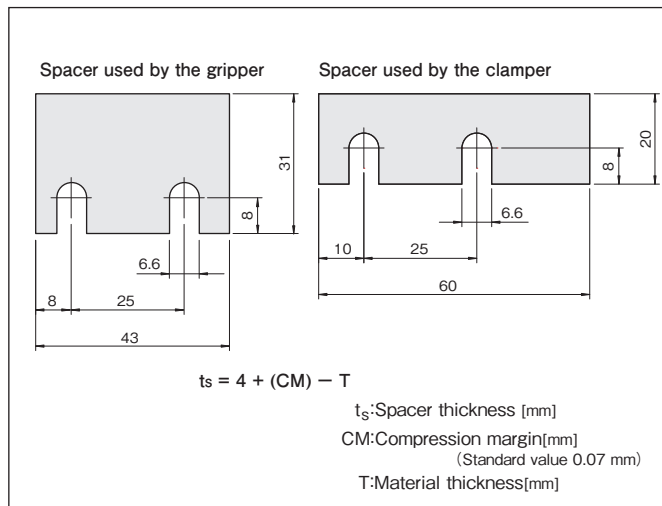
Timing chart



Oil pump

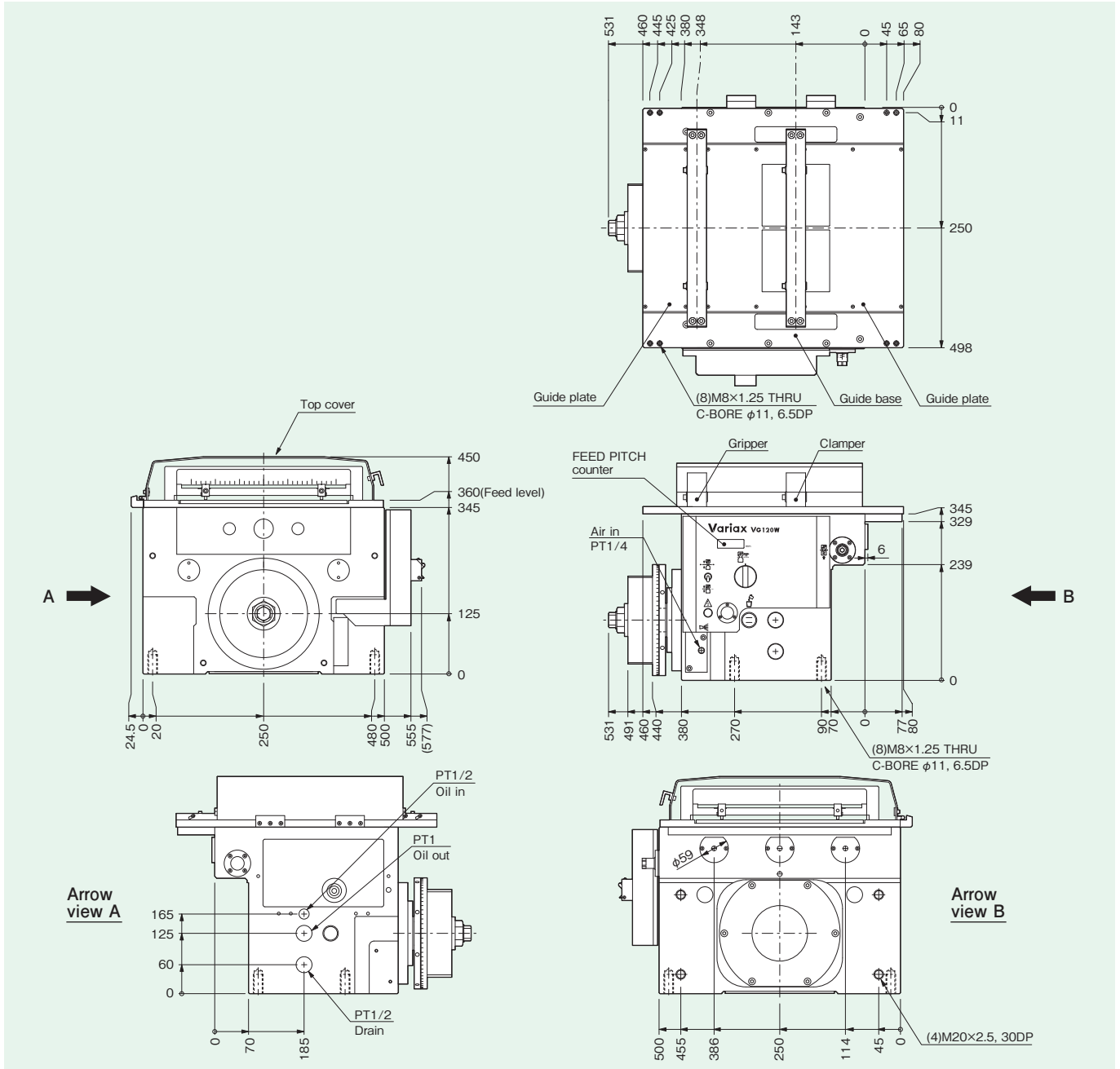


Spacer for plate thickness adjustment



Dimensions

[Unit:mm]



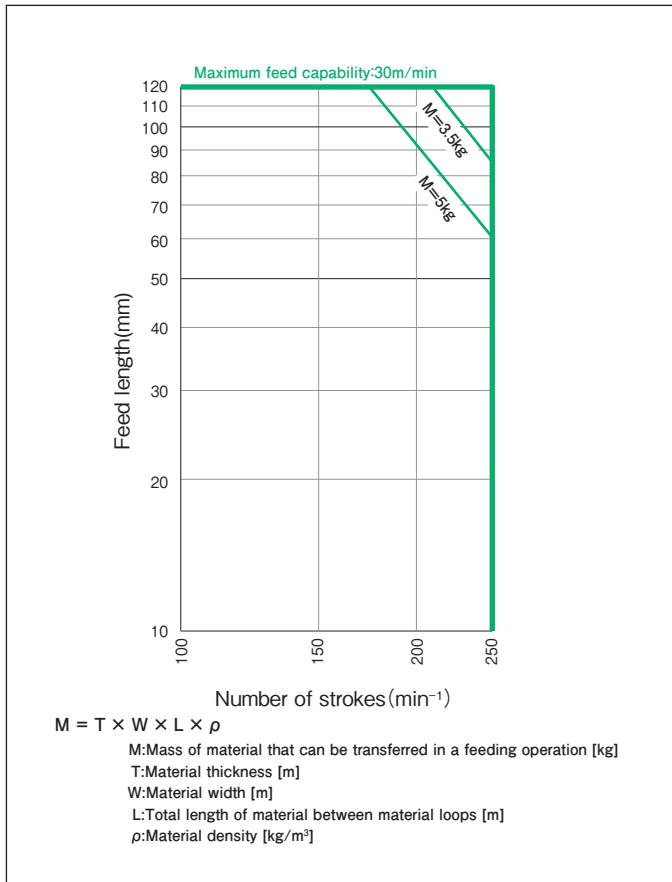
Specification table

Characteristic	Data
Feed length	0 to 120 [mm]
Adjustment Units for Feed Pitch	0.001 [mm]
Material thickness	0 to 1 [mm]
Gripping force	600 to 2,400 [N]
Material width	20 to 250 [mm]
Maximum number of strokes	250 [min ⁻¹]
Maximum feed speed	30 [m/min]
Feed Angle	160 [deg]
Repeatability	±0.05 [mm]
Pilot Release	Approx. 49 [deg]
Air Release	Full adjustable
Input Shaft Drive Ratio (Input: Stroke)	1:2

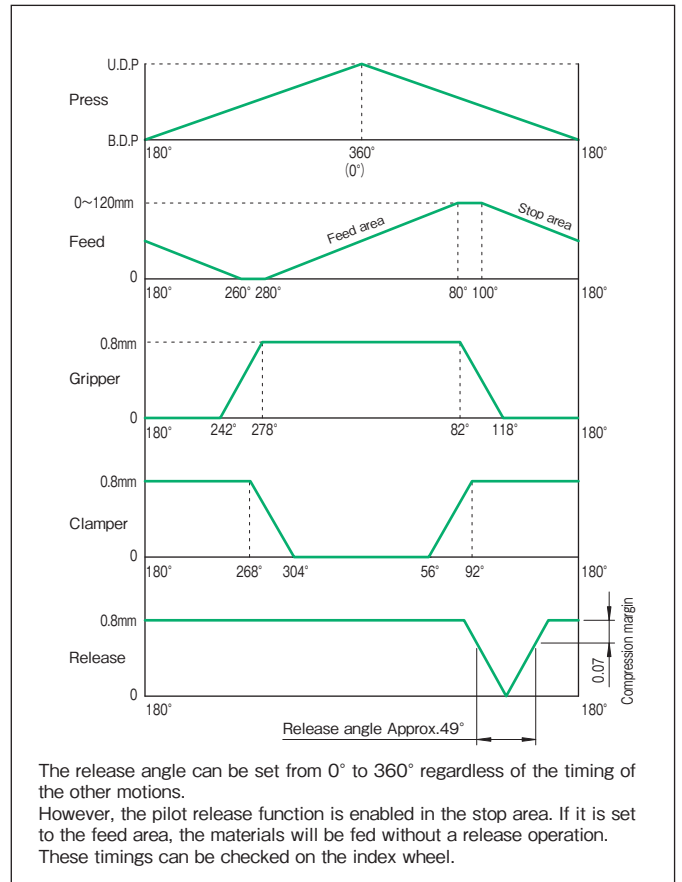
Characteristic	Data
Operating air pressure	490 to 690 [kPa]
Operating power supply	100 VAC single phase [V]
Product weight	290 [kg]
Recommended lubrication oil	Shell Omala S2 G 150
Lubrication system	Forced lubrication
Amount of internal oil for oil bath lubrication	— [ℓ]
Amount of oil supplied for forced lubrication	0.4 [ℓ/min]
Housing color	2.5Y9/02
Operation panel color	2.5Y9/02

1[N·m] ≒ 0.102[kgf·m]

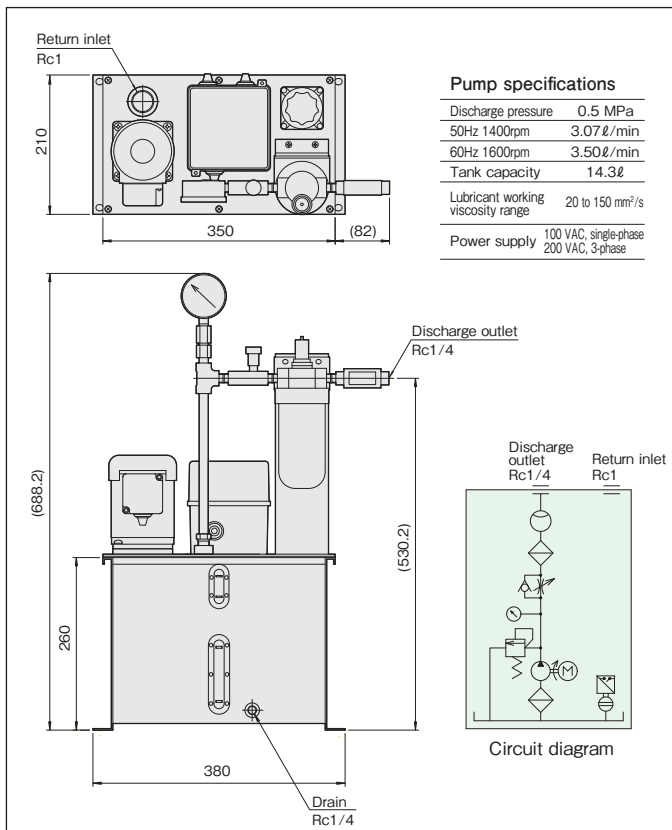
Maximum feed capability chart



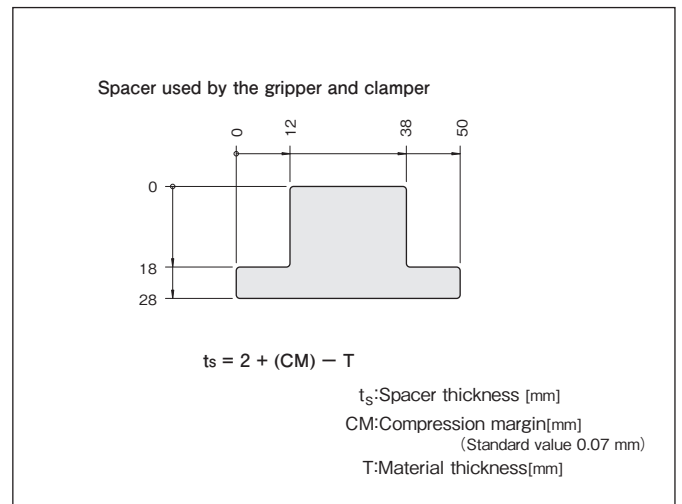
Timing chart



Oil pump



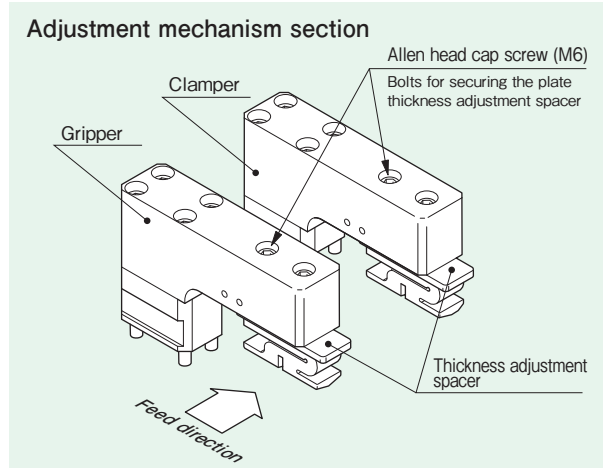
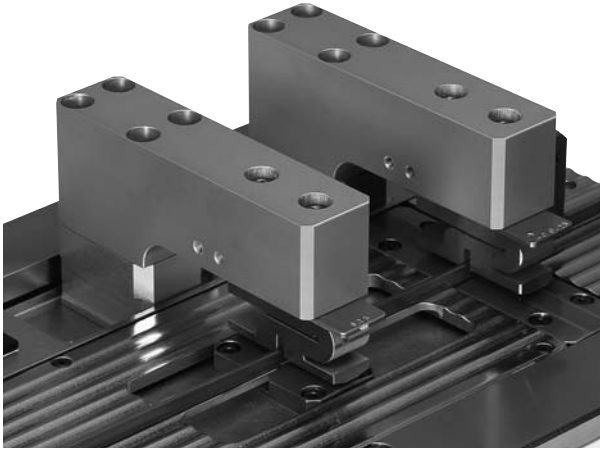
Spacer for plate thickness adjustment



Material thickness adjustment mechanism

Spacer swap type

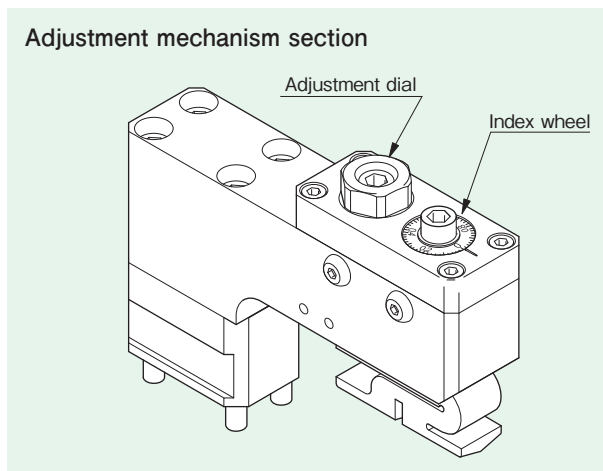
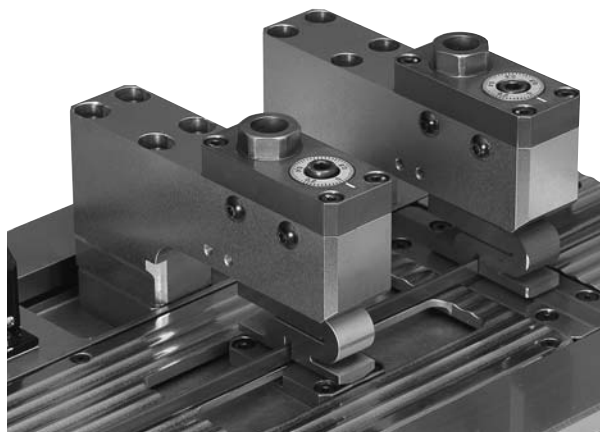
- Applicable models:VG15H, VG20H, VG25, VG50, VG75, VG100, VG120W



The material thickness can be adjusted by using a different plate thickness adjustment spacer. This spacer can be manufactured by the customer or prepared by us. When manufacturing it yourself, refer to the dimension drawings of the plate thickness adjustment spacer for each product. For details about how to replace the plate thickness adjustment spacer and details of the spacer thickness adjustment swapping mechanism, refer to the instruction manual attached to each model.

Adjustable screw type, with attached index wheel

- Applicable models:VG25T, VG50T, VG75T, VG100T



The material thickness can be easily adjusted by turning the Allen head adjustment screw. Also, the mechanism does not require any clamping after making the adjustment, reducing the time and effort in making adjustments. The minimum division on the index wheel is 0.02 mm. However, since you can make stepless adjustments, you can set the appropriate conditions when working with uneven thickness materials or to make fine adjustments of the compression margin. This lets you improve work efficiency because you can feed the material by adjusting the operation to the optimum conditions. For details about the adjustable material thickness adjustment mechanism with an index wheel, refer to the instruction manual attached to each model.

Gripper/clamper variations

Mobile type



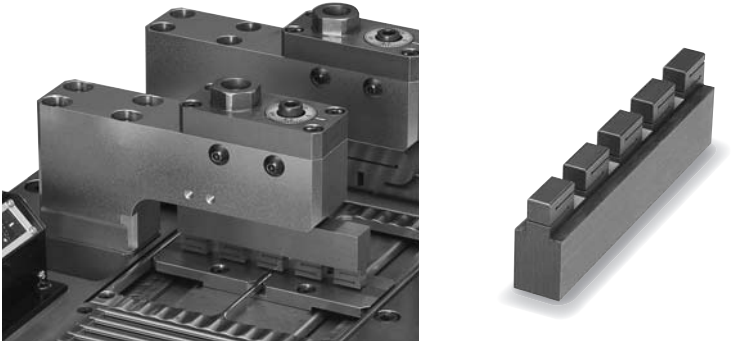
This type allows the position of the gripper's upper part (gripper jaw) to be adjusted arbitrarily. This type is useful when the material to be fed interferes with the standard gripper jaws or you want to avoid contact with the material. The gripper jaws are divided in two along the material width direction. The depth of each gripper jaw can be adjusted individually within the movable range of the guide. The gripper jaws are secured with bolts.

Wide width type



This type has a wider gripper jaw than the standard type. This is especially effective when you want to grip the entire width of the material all at once, in order to feed thin material without creating wrinkles. The working width of the gripper jaw of this specification will be the maximum material width of each model. (Please refer to the specifications for each model)

Wire materials type



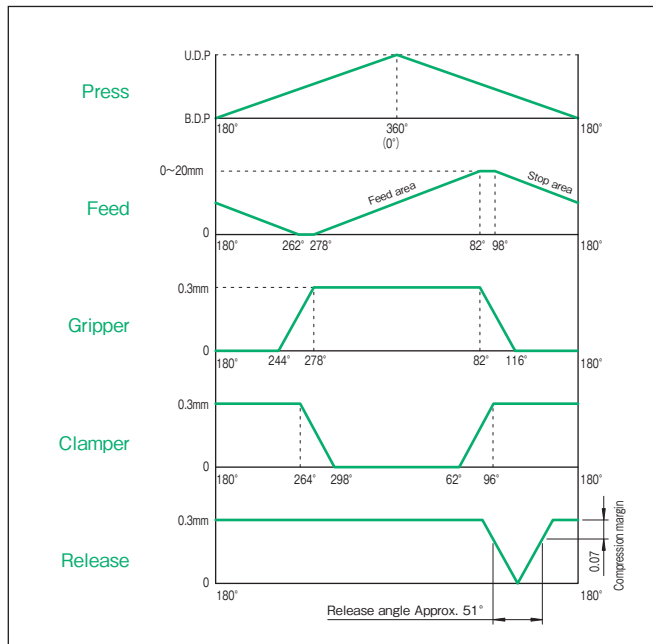
This type has a toothed gripper jaw. Each gripper jaw has spring properties, so you can grip and feed multiple pieces of material at the same time. Mainly suitable for feeding wire rods and multiple rows of wire rods. We can build custom grippers and clampers with shapes suited for feeding square or irregularly shaped materials. Please check the specifications of the materials to be fed and the conditions for feeding them. Then contact us.

Compatibility table

Model	Mobile type	Wide width type	Wire materials type
VG15H·20H	×	×	○
VG25·50·75	○	○	○
VG25T·50T·75T	○	○	○
VG100	△	△	○
VG120W	Standard specifications	×	○

○ : Available as an option
 △ : Produced on request (custom ordered products)
 × : Cannot be installed

Variax operation timing



Variax machines feed material using the combined operation of four cams: a roller gear cam for feeding and plate cams for gripping, clamping, and releasing.

The timing of the feed operation includes dwell areas in both the feed area and the stop area. The grip and the clamp operations feed the material in the timing dwell areas.

The release operation timing can be set to any timing regardless of other operations. However, when the release operation is set during the feed area of the feed operation, the material release is not performed and the operation will be non-release operation.

These operation timings can be confirmed on the index wheel mounted on the input shaft.

Notes on feed angle timing

The Variax feed angle has an excellent balance of feed and return movements in the swing motion mechanism of the gripper, and uses an angle suitable for high-speed feeding.

If the press to be used is a link motion press or there is a long pilot pin in the die, before ordering please review the specifications to determine whether the material sent to the press will interfere with the surroundings. (Since some specifications have a narrow feed area, please contact us if there is a risk of interference.)

Release angle setting

If you use pilot pins in your die, you will need to coordinate the release operation of your Variax with the timing of your pilot pins.

Since the timing of the release operation can be changed easily with a simple operation, you can set up your required specifications quickly. For details about the adjustment method, refer to the operation manual included with the product.

Note that the release operation area changes, depending on the amount of compression margin (described later).

The amount of change is shown in the pilot release diagram, so check it before making adjustments.

The pilot release diagram is included in the specifications we will send you before you order.

(Some specifications have a wide release area)

About compression margin (CM)

When the material is fed by the feeding device, generally, the material is grasped and fed by the rollers and grippers arranged above and below it. In this gripping operation, if the material thickness that the feeder is set for is much smaller than the actual material thickness, the gripping force of the roller or gripper may distort the material.

On the other hand, if the setting for the material to be fed is too thick, you cannot get sufficient friction force between the upper and lower rollers (or grippers) and the amount of material fed, and the feed capacity of the Variax will drop.

Therefore, the distance between the upper and lower rollers (or grippers) must be set properly.

In order to improve the feeding ability, it is necessary to increase the gripping force as much as possible without crushing the material to be fed. Variax has a mechanism that keeps the gap between the upper and lower rollers (or grippers) constant even if the gripping force is changed, so that the material can be reliably gripped within the elastic range of the material to be fed.

The gripping margin of material in the elastic range is called the compression margin (CM).

Formula for calculating the compression margin (CM)
 $CM = \text{feed material thickness} - \text{distance between upper and lower rollers (or grippers)}$

If the compression margin is within the elastic range of the material to be fed, the feed material will not be distorted.

Variax machines can use a high-speed feed because they can add sufficient gripping force without damaging the feed material.

Adjusting the compression margin

Adjust the compression margin according to the characteristics of the material to be fed.

As mentioned above, adjust the compression margin so that there is sufficient gripping force within the range of the material's longitudinal elastic modulus.

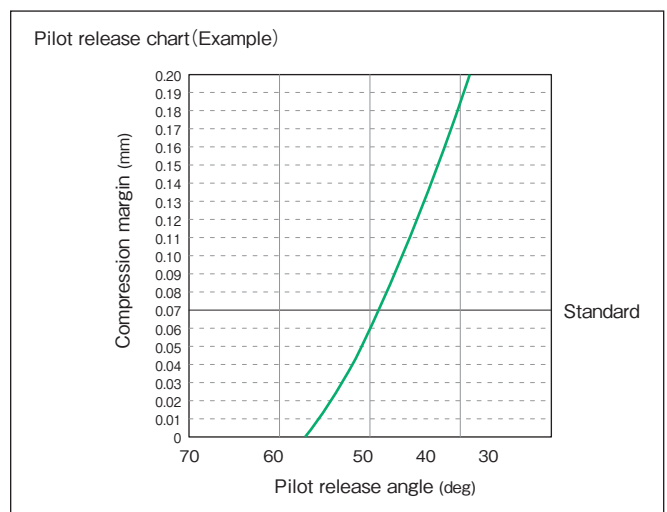
Also, if the material thickness of the feed material has large variations, it may cause a malfunction. Therefore, select a material that has a variation within the tolerances shown in the table below.

All VG models	
Feed material thickness tolerances	-0.02 to +0.05 mm

Changes in the compression margin affects the pilot release angle.

In general, increasing the compression margin delays the timing at which the feed material to be fed is freed from the roller (gripper), and thus reduces the pilot release angle.

The pilot release angle specified in the specifications of each model assumes that the compression margin is the standard value (0.07 mm). Therefore, if you change the compression margin, adjust the pilot release angle while referring to the pilot release angle diagram shown in the specification you will be sent before you order.



How to read the feeding capacity diagram.

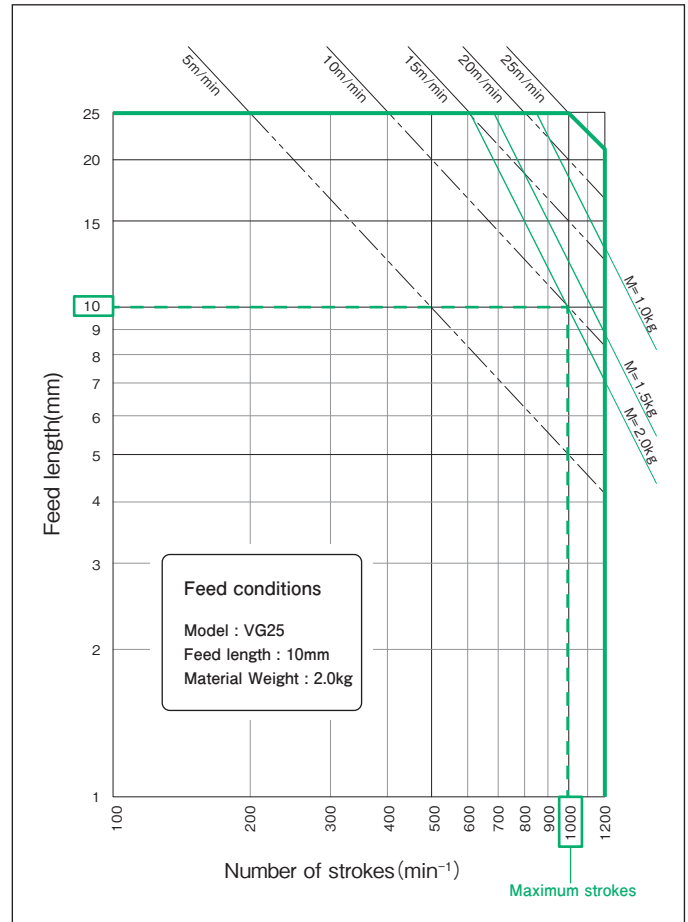
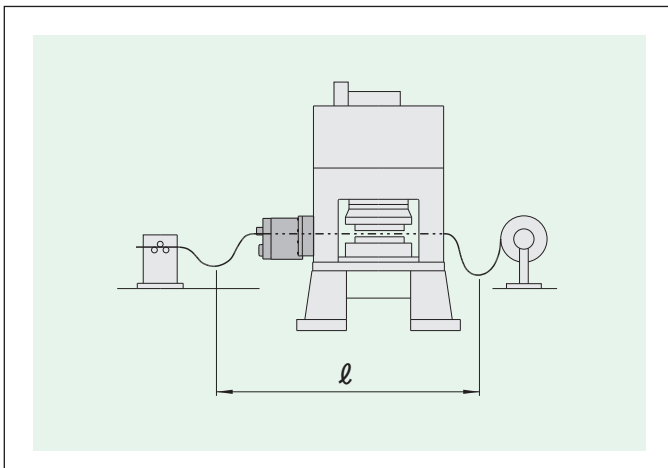
The Variax feeding capacity is set for each model according to the material speed and mass.

In the case of the press layout shown on the right, the material mass M that is intermittently transferred is calculated by M [kg] = Material thickness [m] \times Material width [m] \times Length ℓ [m] \times Density [kg/m³].

Use the graph of the maximum feed capacity for each model according to the material mass M and feed length to find the number of strokes and press rotation speed.

The press rotation speed shown does not include friction between the material and the guides, or any other loads such as resistance caused by flapping material. As a general guide, set the production speed to about 80% of this speed.

If the rotation speed shown is not possible in actual operation due to various conditions such as friction between the rollers and the material, friction between the material and the guides, the actual load, or to resistance due to flapping material, reduce the rotation speed.



Related products (Variax VGT Series)

Wide material feeder employing twin feeders

When handling delicate wide materials, they will be handled and transported carefully by grasping both sides of the material gently.

The VGT series is a revolutionary cam type variable feeder that applies the idea of grasping wide material on both sides.

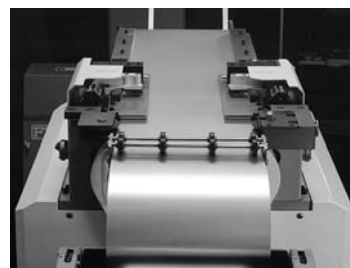
In order to gently and firmly grasp both sides of the wide material, place a Variax VG on each side of the material. The wide material will be conveyed by synchronizing the grasping and the feeding operations of the two machines.

Variax VG's unique gripping method and feed length adjustment mechanism enable accurate linear feeding, which is difficult to achieve with conventional roller drives.

As a result, the squareness of the material fed into the die can be maintained, leading to improved precision of molded products.

In addition, as a consideration when making fine adjustments, the SCT drive system does not require a tension adjustment of the drive belt, even when the feeders are moved in the width direction. This reduces the man-hours required for setup.

Please contact us for product details.





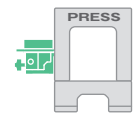
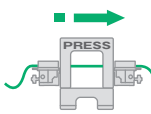
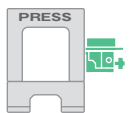

Model code

Feed model code

1 **VG25** - 2 **CW** - 3 **A** - 4 **LR** - 5 **100** - 6 **/X**

1	2	3	4	5	6
Model name	Rotation direction	Mounting position	Feed direction	Input power	Identifies this as a custom order
VG15H VG20H VG25 VG50 VG75 VG25T VG50T VG75T VG100 VG120W	CW CCW	A B	LR RL	100	/X

Model name	Maximum feed length (mm)	Material thickness adjustment mechanism	Rotation direction	
VG15H VG20H VG25 VG50 VG75 VG100 VG120W	15 20 25 50 75 100 120	Plate thickness spacer swapping type	CW	The shaft rotates clockwise when viewed from the input shaft side. 
VG25T VG50T VG75T	25 50 75	Adjustable dial type	CCW	The shaft rotates counterclockwise when viewed from the input shaft side. 

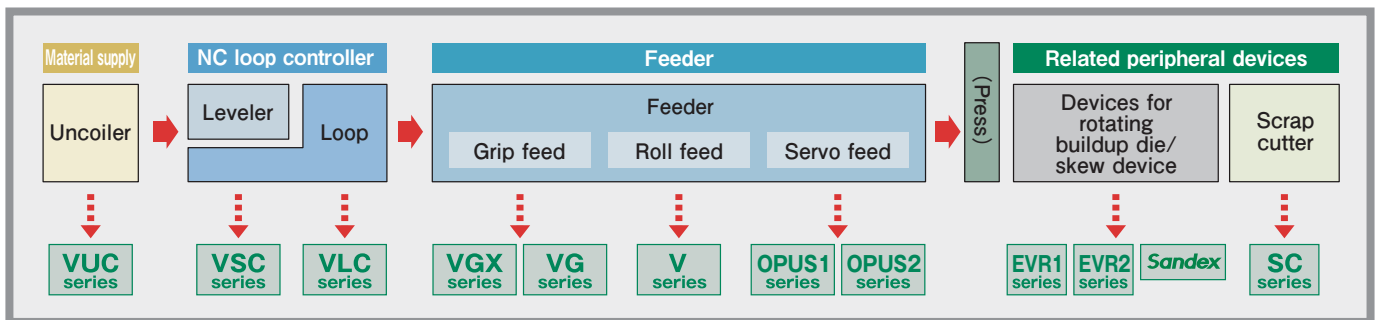
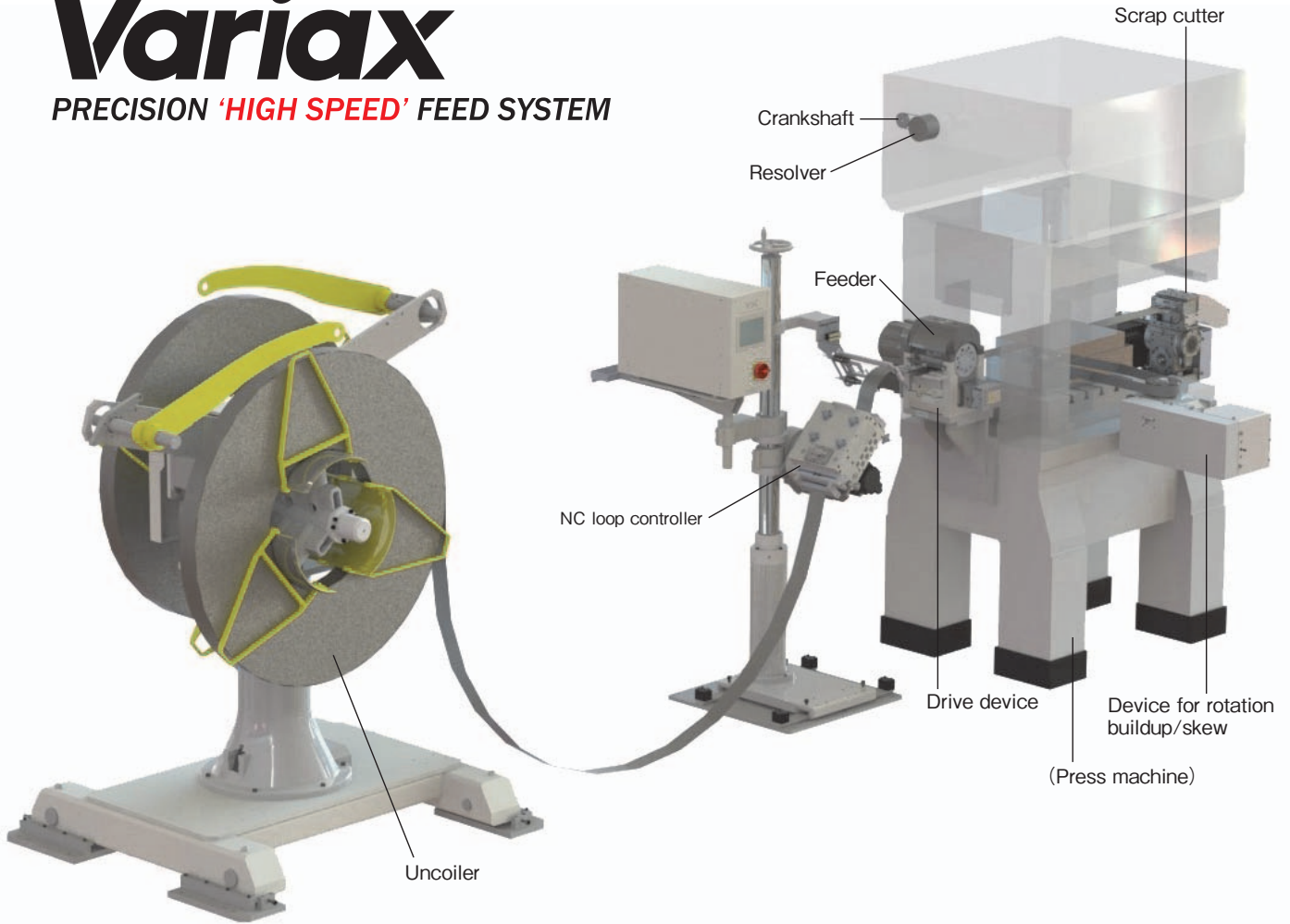
Mounting position *1		Feed direction *1	
A	 <p>Installed on the left side of a press</p>	LR	 <p>Left → right feed Left mounting: Push and feed Right side mounting: Pull and feed</p>
B	 <p>Installed on the right side of a press</p>	RL	 <p>Right → left feed Left mounting: Pull and feed Right side mounting: Push and feed</p>

*1 The mounting position and the left and right feed directions are when viewed from the front of the operator side of the press.
 *2 The display language is the language shown on the operation control panel.

Input power supply	Identifies this as a custom order
100 AC100V	/X Custom order

Variax

PRECISION 'HIGH SPEED' FEED SYSTEM



VSC/VLC series

A loop controller that can create stable, well-formed loops, even at high speeds, to speed up press lines.



VGX series

A cam type gripper feeder that makes work easy and reduces setup time by enhancing various adjustment functions.



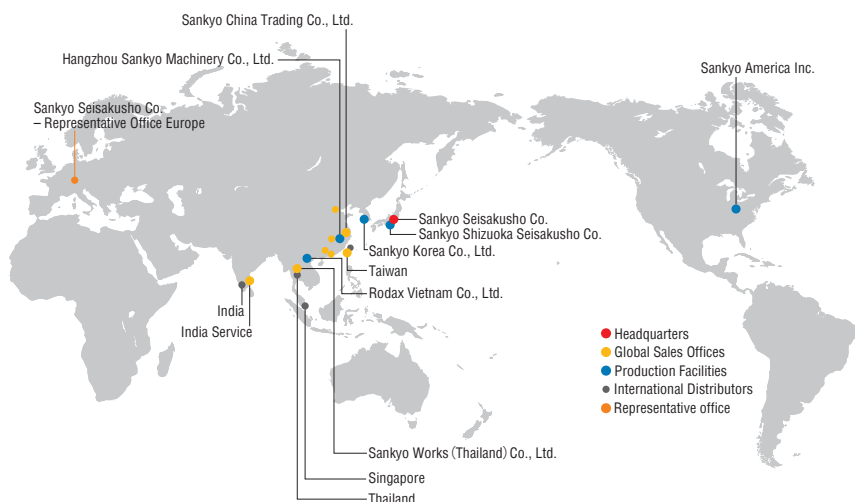
V series

A proven cam type roller feeder that has been used for many years at many press work sites, enables faster and more accurate material feeding.



OPUS1 series

High-performance servo feeder for upper and lower roll drive with IoT compatibility.



Group Companies

Sankyo America Inc.
 10655 State Route 47 Sidney, Ohio, 45365 U.S.A.
 Phone: +1-(0)937-498-4901 Fax: +1-(0)937-498-9403
 Email: sales@sankyoautomation.com

Sankyo Korea Co., Ltd.
 1449-48 Seobu-ro, Gwonseon-gu, Gyeonggi-do, 16643 Korea
 Phone: +82-(0)31-895-5991 Fax: +82-(0)21-895-6607
 Email: kr-sales@rollerdrive.com

Sankyo China Trading Co., Ltd.
 [Shanghai Sales Office]
 Room 101, Unit 2, No.159 Tianzhou Road, Shanghai 200233, China
 Phone: +86-(0)21-5445-2813 Fax: +86-(0)21-5445-2340
 Email: sales@sankyochina-trading.com

[Shenzhen Sales Office]
 Unit 19j, Tower B, Neo Building, No.6009 Shennan Avenue, Futian District, Shenzhen China
 Phone: +86-(0)755-8230-0270 Fax: +86-(0)755-8236-4605

[Tianjin Sales Office]
 Room 1905, Pengzhanfeiwu Building A, Crossing Yale Road Yaolin Road, Xiqing District, Tianjin 300380 China
 Phone: +86-(0)22-2312-1005 Fax: +86-(0)22-2312-1007

[Guangzhou Sales Office]
 Room 913, Xing Pu Building, No.12 Guan Hong Road, Guangzhou Economic Development Zone, Huang Pu, Guang Zhou 510670 China
 Phone: +86-(0)20-8985-1846 Fax: +86-(0)20-8225-7346

[Wuhan Sales Office]
 Room 2301, Taihe Square, No.134 Wusheng Road, Wuhan, Hubei Province China
 Phone: +86-(0)27-8568-5818 Fax: +86-(0)27-8568-2818

Hangzhou Sankyo Machinery Co., Ltd.
 No.2518 Jiang Dong 2 Road, Hangzhou Jiang Dong Industrial Park, Xiaoshan Zone, Hangzhou, Zhejiang, China
 Phone: +86-(0)571-8283-3311 Fax: +86-(0)571-8283-1133

Rodax Vietnam Co., Ltd.
 Plot No. M1, Thang Long Industrial Park li Di Su, My Hao, Hung Yen, Viet Nam
 Phone: +84-(0)221-3-589701 Fax: +84-(0)221-3-589708

Sankyo Works (Thailand) Co., Ltd.
 9/31 Moo 5, Phaholyotin Road, Klongnueng, Klong Luang, Patumthani 12120 Thailand
 Phone: +66-(0)2-516-5355 Fax: +66-(0)2-068-0931
 Email: sales@sankyo-works.co.th

Sankyo Seisakusho Co. - Representative Office Europe
 Flughafenstraße 59, 70629 Stuttgart Germany
 Phone: +49 (711) 490 52 -170
 Email: o.heinlin@sankyo-europe.com
 URL: https://www.sankyo-europe.com

■ **India: Variax Agent Galaxy Techniques**
 5/78A, K.N. Palayam, Pogalur, Annur, Coimbatore 641 697
 Phone: +91-(0)98430-48930
 Email: info@galaxytechniques.com
 URL: http://www.galaxytechniques.com

Contact us

Mon–Fri AM8:30–12:00 PM13:00–17:30 UTC + 09:00 (JST) (Except public holidays and company holidays)

■ **Headquarters (International Sales Division)**
 3-37-3 Tabatashinmachi, Kita-ku, Tokyo, Japan 114-8538
 Phone: +81-(0)3-3800-3305
 Fax: +81-(0)3-3800-3378
 Email: overseas@sankyo-seisakusho.co.jp
 URL: https://www.sankyo-seisakusho.co.jp

■ **Taiwan Sales Office**
 No.21, Ln.152, Jianxing Rd., Sanhe Vil., Daya Dist., Taichung City 42876, Taiwan (R.O.C.)
 Phone: +886-(0)4-2359-4048
 Fax: +886-(0)4-2359-4720
 Email: tw-sales@rollerdrive.com



<https://www.sankyo-seisakusho.co.jp>

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