

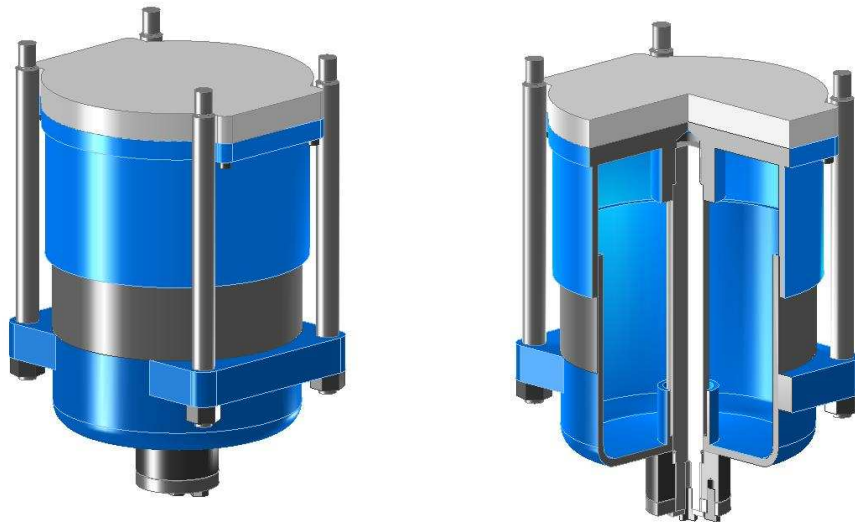


DAYTON DIE CUSHIONS

MODEL "D" ADJUSTABLE STROKE PNEUMATIC DIE CUSHIONS

The Model "D" Die Cushion has an exclusive adjustable stroke (draw) feature. This series is very popular with the shop that runs a wide variety of stamping jobs and must frequently change dies.

This self-contained unit features an adjustable nut at the bottom of the die cushion that provides stroke variations up to one inch. As a result, the operator may adjust the cushion draw rather than changing pressure pins (for length) when a new job is set-up.



**100 PSI MAX. INPUT PRESSURE
SHOWN IN BOLSTER MOUNTED OPTION**

FEATURES:

- ✓ Operates at normal shop air pressure. Booster pump is not required.
 - ✓ Mounting may be made to the bolster plate or to the press frame or bed superstructure.
 - ✓ Construction is of wrought steel cylinder, welded & normalized with a hard-chromed internal cylinder rod and a cast iron piston.
 - ✓ Standard pin pads are hardened and ground. Special pin pads are available in round, rectangular or square shapes to fit bed opening.
 - ✓ Lubrication fittings are positioned at the front of the lower flange on standard designs.
 - ✓ Raised pin pads can be provided to fit smaller than normal bed openings or to allow for slug removal by adding a hole in the pin pad with a slug chute. Requires that cushion be mounted to press frame.
 - ✓ The unit features excellent internal guiding by use of a cylinder rod, & generous cylinder to piston overlap.
 - ✓ Furnished complete with pin pad, mounting structure, regulator, gauge, hoses, fittings and Installation Service Manual. Surge tanks optional for increased die cushion draw strokes.
 - ✓ Each installation is warranted for one year from date of shipment.
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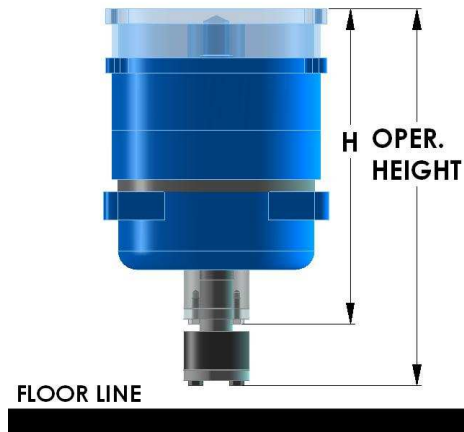
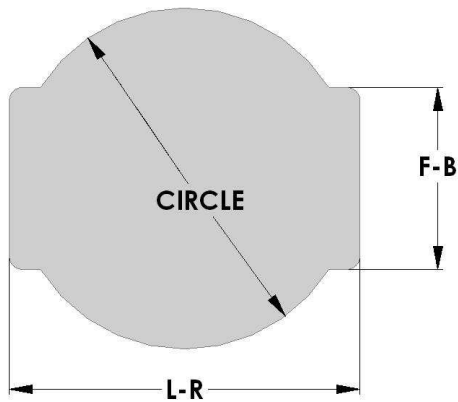
DAYTON DIE CUSHIONS

CUSHION SELECTION CHART

MODEL	TONS@ 100 P.S.I.	STANDARD PIN PADS			HEIGHT STD. DRAW	CUSHION DRAW		MAX ADJ.	OPER. HEIGHT STD. DRAW
		L-R	F-B	CIR.		STD**	MAX		
D-5	0.9	6-5/8	3	5-3/4	12-3/16	1-1/4	2-11/16	5/8	13-7/16
D-6	1.4	8-1/2	3-1/8	7	14-1/8	1-3/4	3-1/4	5/8	15-7/8
D-8	2.5	10	4-1/2	9	17-9/16	2	3-3/4	5/8	19-9/16
D-10	3.9	12-3/8	5-1/8	11	18-1/16	2	3-3/4	5/8	20-1/16
D-12	5.7	13-1/2	7	13-1/8	19-1/2	2	3-3/4	1/2	21-1/2
D-14	7.7	16-1/4	8-3/4	15-1/4	22-3/8	2-1/2	4-3/4	1/2	24-8/7
D-16	10	19	9	17-1/4	21-15/16	2-1/2	5-3/4	1	24-7/16

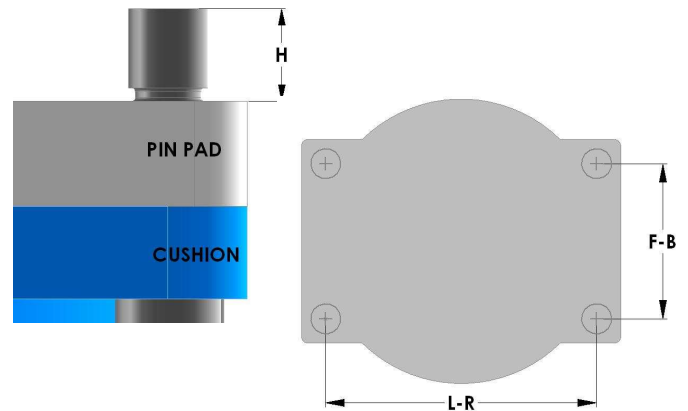
*Height for standard draw only and does not include pin pad nor mounting structure thickness.

** For stokes longer than standard, use surge tank.



MOUNTING ROD SPECIFICATIONS FOR STANDARD BOLSTER MOUNTED DIE CUSHIONS

Model	L-R	F-B	H	Thread
D-5	5-3/4	3-7/8	3/4	3/8 -16
D-6	7-1/4	4	3/4	1/2 -13
D-8	8-19/32	5-19/32	1	5/8 -11
D-10	10-7/8	6-3/8	1	3/4 -10
D-12	12	8-7/16	1-1/4	7/8 -9
D-14	14-1/4	10-1/4	1-3/8	1 -8
D-16	16-1/2	11	1-5/8	1-1/4 -7



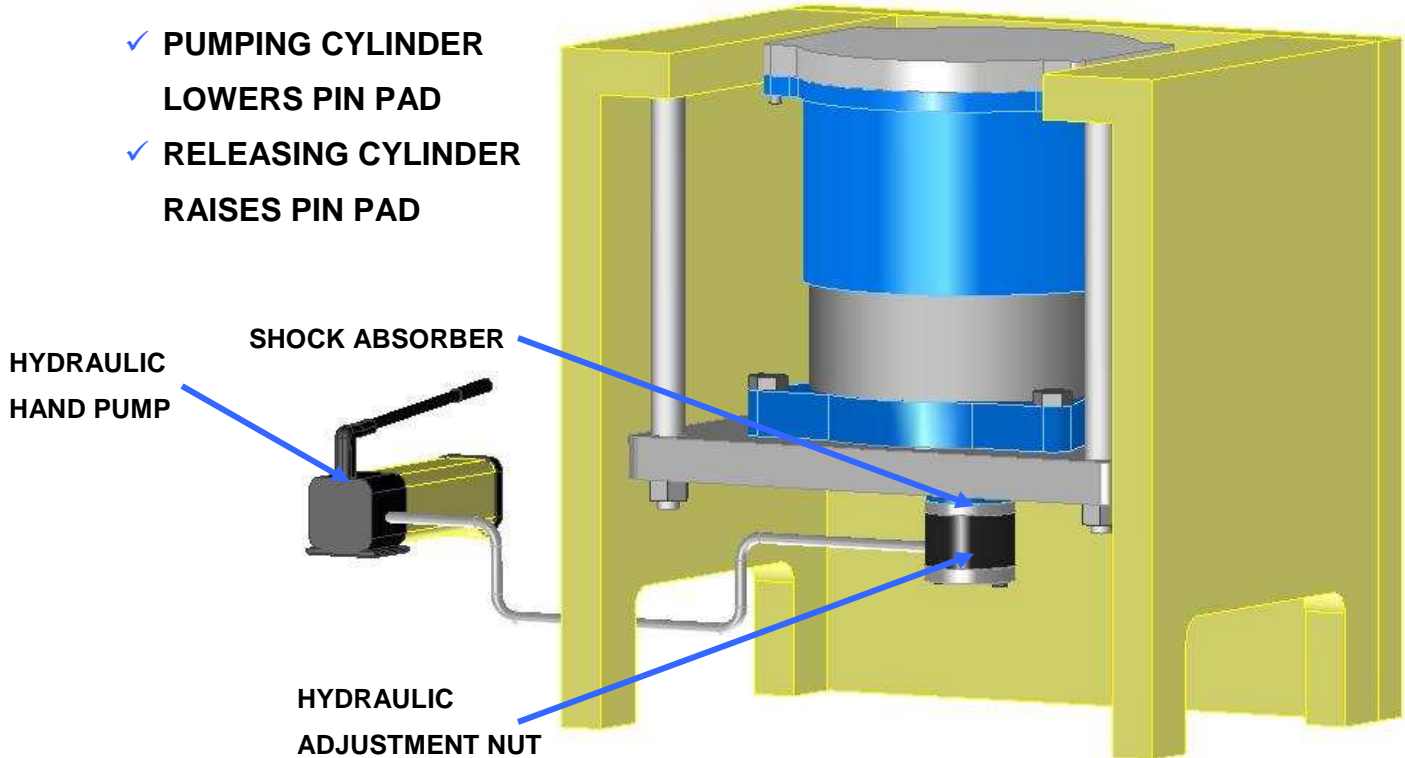
DRILL/TAP FOUR HOLES

IN BOLSTER PLATE TO ACCEPT THREAD/HEIGHT



DAYTON DIE CUSHIONS

INTRODUCE QUICK DIE CHANGE TECHNOLOGY TO YOUR DIE CUSHION OPERATIONS WITH THE HSA1



✓ **EFFICIENT**

Sharp reduction of set up time.

✓ **SAFE**

No hands under presses.

✓ **QUIET**

Reduces return shock.

✓ **SIMPLE INSTALLATION**

✓ **AFFORDABLE**

Once used exclusively in multimillion dollar transfer presses Dayton Die Cushions has made the efficiencies of hydraulic stroke adjustment affordable for smaller presses.

The **HSA1** is a heavy duty hydraulic stroke adjustment designed to retrofit onto **Dayton Die Cushions D Series** cushions. It allows the user to adjust the cushion stroke under full air pressure. All stroke adjustments are made using a simple manual pump outside the press. Heavy duty construction and superior sealing technology assure rock steady adjustments.
