

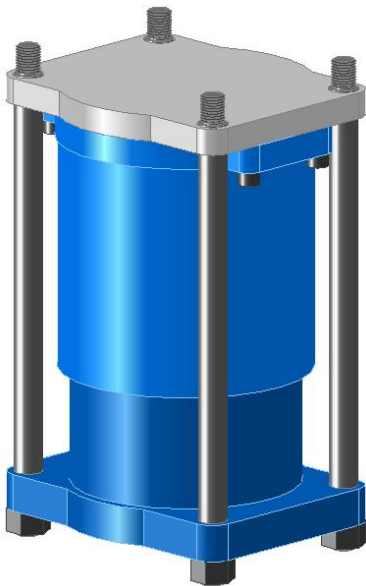


DAYTON DIE CUSHIONS

Model “HC” Pneumatic Die Cushions

The Model “HC” Heavy Duty Pneumatic Die Cushion produces very high R.H.F. within a given area. The unit is built to withstand extremely long, heavy stamping and forming operations such as compound blanking, piercing and drawing.

The DAYTON DIE CUSHION “HC” Die Cushion is particularly suitable for use with medium and larger presses and can be fitted singularly or in batteries for larger beds. Excellent internal or self-guiding is accomplished by extra overlap between the cylinder and piston, even at the top of the stroke. It is also collapsible whenever a cushion is not needed.



200 PSI MAX. INPUT PRESSURE
SHOWN IN BOLSTER MOUNTED OPTION

FEATURES:

- ✓ Operates at 200 psi. pressure with booster pump.
- ✓ Mounting may be made to the bolster plate, to the press frame, or to the bed superstructure.
- ✓ Construction is of wrought steel welded and normalized with bronzed bearing surface. Excellent internal guiding achieved by generous overlap between cylinder and piston, and external guiding mechanism can be designed to insure against off-center loading conditions.
- ✓ In batteries, common pin pads may be used. Special raised pin pads may be designed for use with presses with smaller than normal bed openings.
- ✓ Furnished complete with pin pad, mounting structure, regulator, gauge, hoses, fittings, surge tank with accessories and Installation and Service Manual.
- ✓ Each installation is warranted for one year from date of shipment.

Model “HC” Option Hydraulically Controlled Hold-Down

Allows the cylinder to be held at or near the bottom of the stroke, for a predetermined length of time, and then allowed to assume its normal extended position at any desired rate. The unit is completely versatile in that either one or both of these cycle phases can be quickly adjusted or omitted.

This type of installation is particularly useful in drawing operations where additional time is needed to remove the work, or on long draws where a rapid return might distort the part.

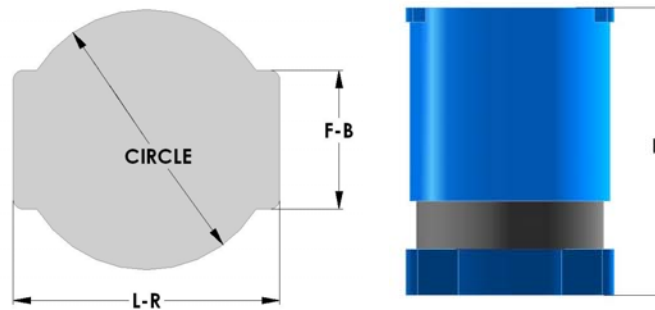


DAYTON DIE CUSHIONS

CUSHION SELECTION CHART

MODEL	TONS@ 200 P.S.I.	STANDARD PIN PADS			HEIGHT STD. DRAW	CUSHION DRAW	
		L-R	F-B	CIR.		STD**	MAX
HC-8	5.0	11-5/8	8-1/2	9-3/4	19-1/2	6	6
HC-10	7.8	13-11/16	10-1/4	11-3/4	21-5/8	6	6
HC-12	11.4	15-5/8	11-3/4	13-1/2	21-5/8	6	6
HC-14	15.4	17-5/8	13-3/8	16	23-1/8	6	10
HC-16	20.0	19-3/4	15	18	23-5/8	6	10
HC-18	25.4	22	16-3/4	20	24-5/8	6	12
HC-20	31.4	24-3/4	18-3/4	22-1/4	24-5/8	6	12
HC-22	38.0	26-1/4	20-1/4	24-1/4	26-1/8	6	12
HC-24	45.2	28-7/8	22-1/8	26-1/4	31-5/8	8	12
HC-30	70.0	CUSTOM TO SPECIFIC APPLICATION CONSULT FACTORY					
HC-36	102.0						
HC-40	125.0						
HC-48	180.0						

* Height for standard draw only. Does not include pin pad mounting plate thickness nor mounting rod/nut that extends beneath. Shorter than standard draws are available.



MOUNTING ROD SPECIFICATIONS FOR STANDARD BOLSTER MOUNTED DIE CUSHIONS

Model	L-R	F-B	H	Thread
HC-8	8-19/32	6-3/4	1	7/8 -9
HC-10	11-11/16	8-1/4	1-1/4	1 -8
HC-12	13-3/8	9-1/2	1-5/8	1-1/4 -7
HC-14	15-1/8	10-7/8	1-5/8	1-1/4 -7
HC-16	17	12-1/4	1-3/4	1-3/8 -6
HC-18	19	13-3/4	1-7/8	1-1/2 -6
HC-20	21-1/4	15-1/4	2	1-3/4 -5
HC-22	22-3/4	16-3/4	2	1-3/4 -5
HC-24	24-7/8	18-1/8	2-1/4	2 -4-1/2

