

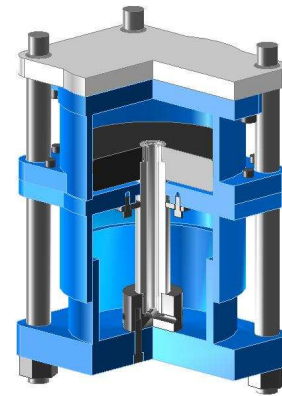
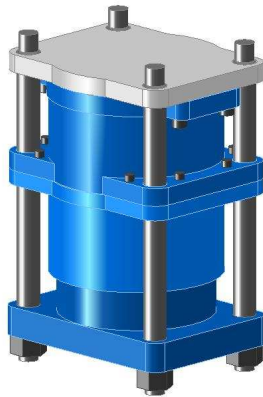


DAYTON DIE CUSHIONS

MODEL "HMC" PNEUMATIC DIE CUSHIONS

THE MOST POWERFUL PNEUMATIC DIE CUSHION AVAILABLE. This rugged, heavy duty unit produces extremely high R.H.F. within a given area, and is designed to withstand long, continuous heavy stamping operations including compound blanking and drawing.

The unique center stem, multiple piston and cylinder chambers coupled with a generous overlap between cylinder and piston walls, assures maximum resistance to off-center loading. This series is particularly adaptable to medium, large and very large presses.



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

FEATURES:

- ✓ Mounting may be made to bolster plate, to press frame or to the press superstructure with a large mounting plate to the mounting surface.
- ✓ Construction is of high grade wrought steel, welded and normalized with bronzed bearing surfaces for long wear.
- ✓ Extra overlap between cylinder and piston and the center stem assures excellent internal guiding. External guiding mechanism can be designed to eliminate off-center load damage.
- ✓ Custom pin pads with J.I.C. strips or pads can be designed. Common pin pads connecting two or more die cushions are available for large presses.
- ✓ This series has a dual chamber design and includes a booster pump as standard equipment resulting in extremely high R.H.F.
- ✓ An internal centralized lubrication system distributes lubricant by channeling through space provided between concentric tubes within the piston rod, thereby eliminating grease tubing. Eternal centralized fittings available at customer's option.
- ✓ This series has a dual chamber design and includes a booster pump as standard equipment resulting in extremely high R.H.F.
- ✓ All units are complete with standard or custom built pin pad, all necessary mounting structure, pressure regulator, gauge, booster pump, hoses, fittings, surge tank with safety pop-off-valve, drain cock, and Installation Service Manual.
- ✓ Each installation is warranted for one year from date of shipment.

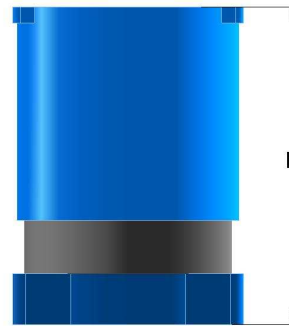
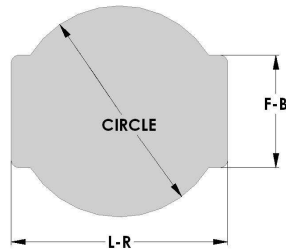


DAYTON DIE CUSHIONS

CUSHION SELECTION CHART

MODEL	TONS@ 100 P.S.I.	STANDARD PIN PADS			HEIGHT STD. DRAW	CUSHION DRAW	
		L-R	F-B	CIR.		STD**	MAX
HMC-8	10.0	12	8-3/4	9-3/4	20-1/2	3	CONSULT FACTORY
HMC-10	15.6	14-1/2	11	11-3/4	20-1/2	3	
HMC-12	22.8	16-1/4	12-1/4	13-1/2	20-1/2	3	
HMC-14	30.8	17-5/8	13-3/8	16	28-1/4	4	
HMC-16	40.0	20-1/4	15-1/2	18	28-1/4	4	
HMC-18	50.8	22-1/2	20-1/2	20	33-5/8	5	
HMC-20	62.8	24-3/4	22-1/4	22-1/4	33-5/8	5	
HMC-22	76.0	27	24-1/4	24-1/4	39	6	
HMC-24	90.0	28-7/8	26-1/4	26-1/4	40-1/4	6	
HMC-26 THRU HMC-36	106.0 204.0	CUSTOM TO SPECIFIC APPLICATION CONSULT FACTORY					

* Height for standard draw only. Does not include pin pad mounting plate thickness nor mounting structure thickness.



MOUNTING ROD SPECIFICATIONS FOR STANDARD BOLSTER MOUNTED DIE CUSHIONS

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



**DRILL/TAP FOUR HOLES
IN BOLSTER PLATE TO
ACCEPT THREAD/HEIGHT**

