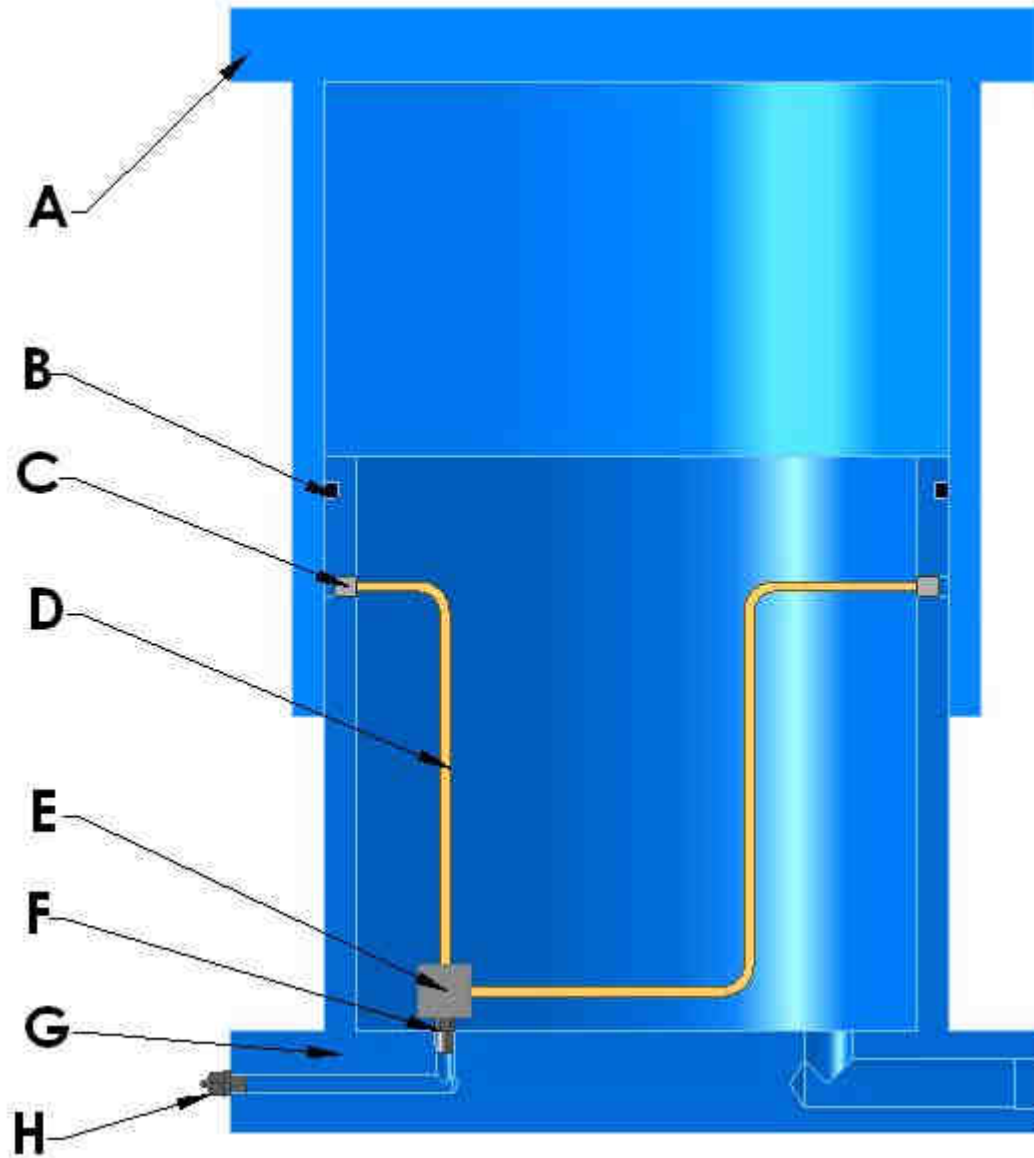


Model HC Parts List

IMPORTANT: When ordering repair parts, be sure to indicate cushion model and size, serial number and part number on purchase order to avoid errors.



Model HC Parts List

Description		Cushion Diameter and Part Number								
		8"	10"	12"	14"	16"	18"	20"	22"	24"
Cushion Cylinder ^(a)	A	6629	6671	6622	6595	6323	6281	6509	6506	6289
Quad Ring	B	8335	8700	10109	9878	10110	10687	10688	10689	10690
Grease Fitting	C	15392	15392	15392	15392	15392	15392	15392	15392	15392
Flex. Hose	D	10140	10140	10140	10140	10140	10140	10140	10140	10140
Pipe Tee	-	10965	10965	10965	-	-	-	-	-	-
Lub. Distributor	E	-	-	-	6620	6620	6620	6620	6620	6620
Hex Nipple	F	14498	14498	14498	14498	14498	14498	14498	14498	14498
Cushion Piston ^(a)	G	6630	6672	6623	6596	6324	6282	6581	6507	6290
Lubrication Fitting	H	210	210	210	210	210	210	210	210	210

(a) When ordering cylinders and cushion pistons, order according to cushion model and serial number (Serial Number is located at the front, lower flange of the cushion unit)

Pneumatic Packings

Dayton Die Cushions Packings are of first quality material, thus assuring long wear and dependability under strenuous conditions. When ordering packings, please give model, size and serial number of cushion as well as part number of the packing.

There has been a **change in the type of packing** used on several models. Serial number higher than the one listed below for particular cushion model use quad packing instead of cup packing. Please refer to the tables below to check what type of packing your cushion uses.

Model HC Piston Packings				
	Piston Diameter	Cup Packing Part Number	Quad Ring Part Number	Cushion Serial Number *
HC-8	8"	169	8335	24997
HC-10	10"	490	8700	19626
HC-12	12"	492	10109	20115
HC-14	14"	179	9878	19343
HC-16	16"	168	10110	19253
HC-18	18"	650	10687	20056
HC-20	20"	970	10688	20009
HC-22	22"	1104	10689	19639
HC-24	24"	798	10690	19743
HC-30	30"	8650	10761	19974
HC-40	40"		10699	19600
HC-48	48"		10698	19560

* Quad Ring Packings used after this Serial Number.

Installation Instructions

Cup Packings

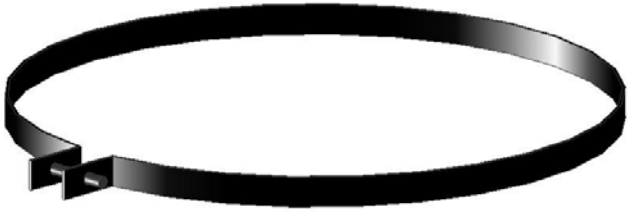


Fig. 15 Clamping band

PRECAUTION: When installing a cup packing, be careful not to damage or turn back the lip. This can be avoided by making a clamping band as shown in Fig. 15 from 16-gauge band iron, 1/2" to 1/8" wide. The ends of this band iron with two holes pierced to receive an ordinary stove bolt should be bent so that the circumference is a little less from bend to bend than the circumference of the piston of the pneumatic die cushion unit on which it is to be use.

	Description
A	Cushion Cylinder
B	Cup Packing
C	Clamping Band
D	1/4" Lockwasher (Part No. 438)
E	Cup Packing Ring
F	1/4"-20 x 3/4" Allen Cap Screw (Part No. 441)
G	Cushion Piston

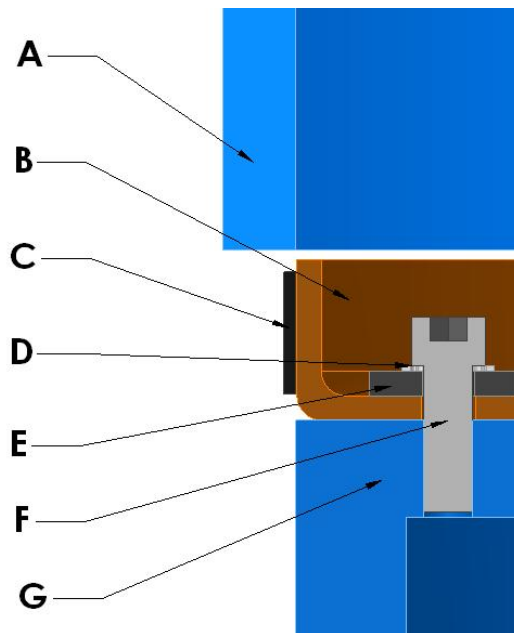


Fig. 16 Cup Packing Installation

Installation Instructions

Quad Packings

When installing quad packings it is advisable to grease the packing and groove thoroughly before cylinder is installed. Cylinder should be eased over packing to prevent shearing or gouging during installation.

CAUTION: It is advisable to check the 3/16" metal greasing tubes while the cushion unit is disassembled, because severe vibration may cause them to fracture at times. The lubrication instructions given on Page 17 will explain the procedure to follow in checking the lubrication system.

	Description
A	Cushion Cylinder
B	Quad Packing
C	Lubrication Tubing
D	Cushion Piston

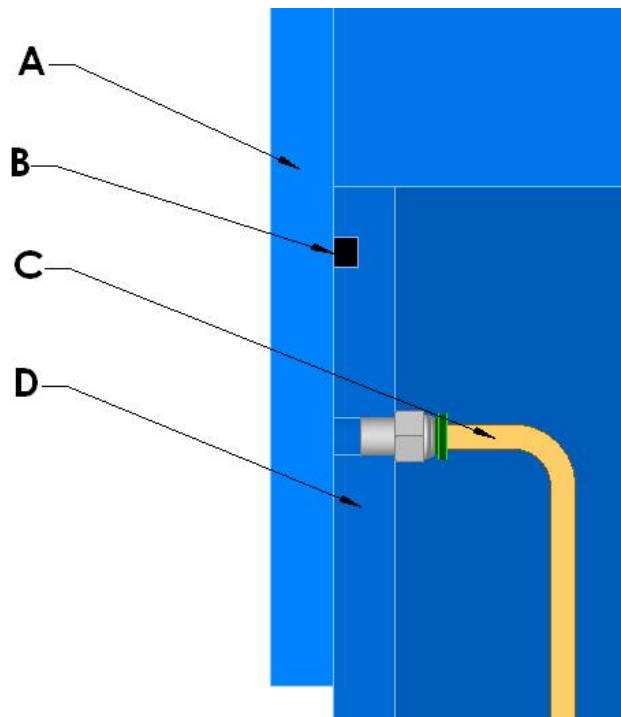


Fig. 17 Quad Ring Installation