

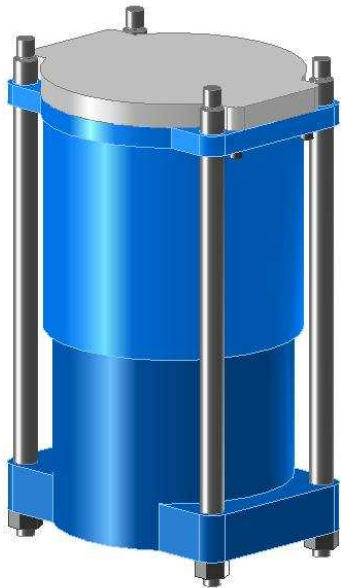


DAYTON DIE CUSHIONS

MODEL "C" PNEUMATIC DIE CUSHIONS

DAYTON DIE CUSHIONS most popular pneumatic Die Cushion is built to withstand long heavy duty stamping operations. The unit may be collapsed whenever it is not needed.

The Model "C" Series of Die Cushions is suitable for small to medium size presses when used singularly or for large presses when assembled in batteries. Excellent guiding is accomplished by adequate overlap between cylinder and piston walls.



**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, to the press frame, or to the bed-superstructure.
- ✓ Construction is of wrought iron steel cylinder and cast iron piston. 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.
- ✓ When used 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, Installation & Service Manual.
- ✓ Each installation is warranted for one year from date of shipment.

MODEL "C" OPTIONS AIR EXHAUST HOLD-DOWN

Air is exhausted at or near the bottom of its stroke, held-down 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.

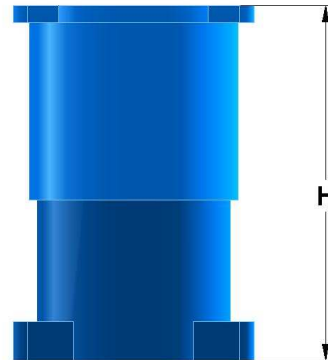
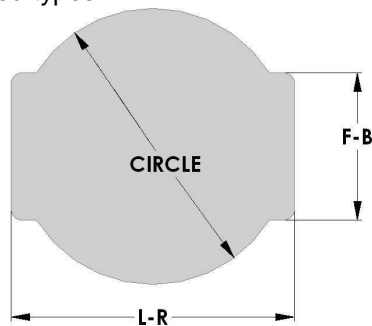


DAYTON DIE CUSHIONS

CUSHION SELECTION CHART

MODEL	TONS@ 100 P.S.I.	STANDARD PIN PADS			HEIGHT* STD. DRAW	CUSHION DRAW	
		L-R	F-B	CIR.		STD	MAX**
C-6	1.4	8-1/2	5-1/4	7	11-1/4	3	3
C-8	2.5	10	7	9	13-1/4	4	4
C-10	3.9	12-3/8	7-7/8	11	18-1/4	6	6
C-12	5.7	13-1/2	10	13-1/8	18-1/4	6	6
C-14	7.7	16-1/4	12-1/4	15-1/4	18-1/4	6	6
C-16	10	19	13-1/2	17-1/4	19-5/8	6	10
C-18	12.7	20-1/4	15-1/4	19-1/4	20-7/8	6	10
C-20	15.7	23-3/8	17-1/8	21-1/4	20-7/8	6	10
C-22	19	25-1/4	18-1/2	23-3/8	23	6	10
C-24	22.6	27-1/4	20	25-3/8	27	8	10

* Height for standard draw only. Does not include pin pad/mounting plate thickness nor mounting rod/nut that extends beneath. Shorter than standard draws available. Guide rods extend beneath cushion thru 16. size. No guide rods on bolster mounted types.



MOUNTING ROD SPECIFICATIONS FOR STANDARD BOLSTER MOUNTED DIE CUSHIONS

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



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

