



DAYTON DIE CUSHIONS

MODEL HD ADJUSTABLE PNEUMATIC DIE CUSHIONS

The Model “HD” Die Cushion is very popular with the stamper who has a wide variety of jobs and who must frequently change dies.

An adjustable nut at the bottom of the piston provides stroke variations up to 2”. Unit provides extremely high R.H.F. in a limited space by using an air booster pump. The unit has an exclusive adjustable stroke feature that allows the operator to adjust the die cushion draw rather than changing pressure pins for length when a different job is set-up.



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

FEATURES:

- ✓ Booster Pump supplied as standard equipment to double shop air pressure to achieve high ring holding forces.
 - ✓ Mounting may be made to bolster plate, to the press frame or to the bed superstructure.
 - ✓ Construction is of wrought steel, welded and normalized, with bronzed bearing surface.
 - ✓ Standard pin pads are soft, but hardened and ground. Types are available in round, rectangular or square shapes at customer option.
 - ✓ Raised pin pads (stools) can be supplied to fit small bed openings or to allow for slug removal by adding a hole in the pin pad with a slug chute (see page 11).
 - ✓ Lubrication fittings are positioned at the front of the lower flange on standard designs. An external centralized greasing system is available at customer option.
 - ✓ The unit features excellent guiding by use of an internal cylinder rod, and generous cylinder to piston overlap. An external guiding mechanism is available at customer option.
 - ✓ Furnished complete with pin pad, mounting structure, surge tank, regulator, gauge hoses, fittings, booster pump and Installation Service Manual.
 - ✓ Each installation is warranted for one year from date of shipment.
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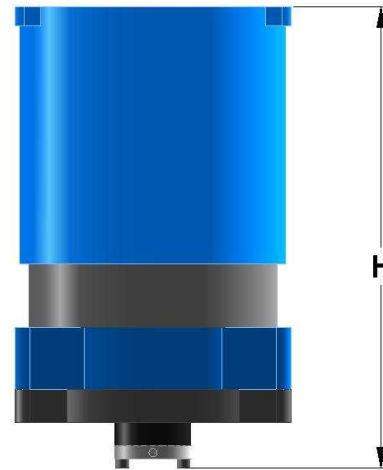
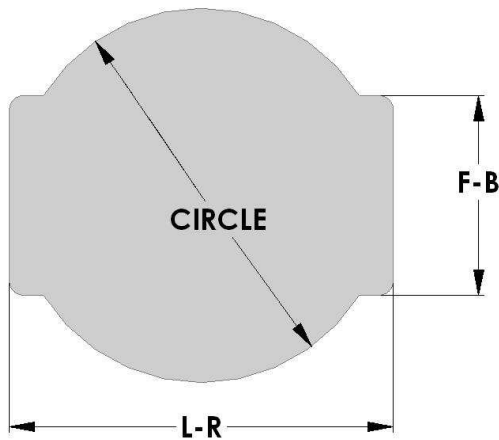
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CUSHION SELECTION CHART

MODEL	TONS@ 100 P.S.I.	STANDARD PIN PADS			HEIGHT STD. DRAW	CUSHION DRAW		MAX ADJ.
		L-R	F-B	CIR.		STD	MAX	
HD-10	7.8	13-11/16	10-1/4	11-3/4	22-3/8	3	6	2
HD-12	11.4	15-5/8	11-3/4	13-1/2	24-1/8	4	6	2
HD-14	15.4	17-5/8	13-3/8	16	25-5/8	4	6	2
HD-16	20.0	19-3/4	15	18	27-1/8	5	6	2

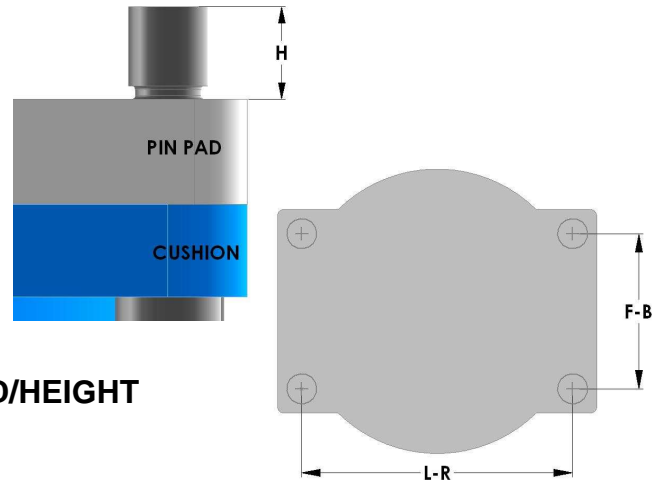
LARGER SIZES AVAILABLE: Designed for Customer Application - Consult Factory

* Height for standard draw only. Does not include pin pad or mounting structure thickness.



MOUNTING ROD SPECIFICATIONS FOR STANDARD BOLSTER MOUNTED DIE CUSHIONS

Model	L-R	F-B	H	Thread
HD-10	11-11/16	8-1/4	1-1/4	1 -8
HD-12	13-3/8	9-1/2	1-5/8	1-1/4 -7
HD-14	15-1/8	10-7/8	1-5/8	1-1/4 -7
HD-16	17	12-1/4	1-3/4	1-3/8 -6



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