



DAYTON DIE CUSHIONS

MODEL MD ADJUSTABLE PNEUMATIC DIE CUSHIONS

The Model MD 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 5/8". Unit provides extremely high ring holding force by virtue of a double piston design. 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.



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

FEATURES:

- ✓ Operates at normal 100 P.S.I. shop air pressure.
 - ✓ 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 hardened and ground. Pin pads are available in round, rectangular or square shapes.
 - ✓ Raised pin pads can be supplied for fitting to smaller than normal bed openings or to allow for slug removal by adding a hole in the pin pad with a slug chute. (See page 1)
 - ✓ Lubrication fittings are positioned at the front of the front of the lower flange on standard designs. An external centralized greasing system available as a customer option.
 - ✓ The unit features excellent guiding by use of an internal cylinder rod, and generous cylinder to piston overlap. External guiding mechanism available.
 - ✓ Furnished complete with pin pad, mounting structure, surge tank, regulator, gauge hoses, fittings and Installation and Service Manual.
 - ✓ Each installation is warranted for one year from date of shipment.
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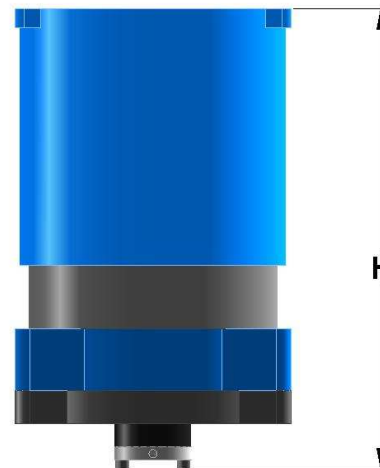
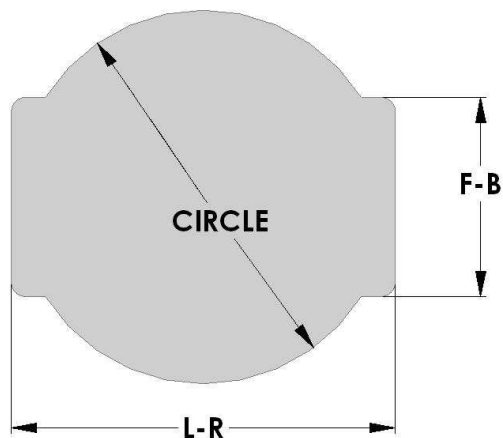


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CUSHION SELECTION CHART

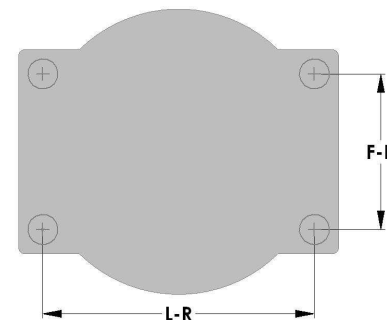
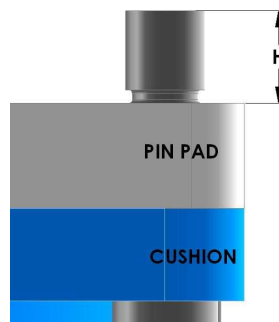
MODEL	TONS@ 100 P.S.I.	STANDARD PIN PADS			HEIGHT STD. DRAW	CUSHION DRAW		MAX ADJ.
		L-R	F-B	CIR.		STD	MAX	
MD-8	5.0	10-1/4	7-1/4	9	23	3	6	5/8
MD-10	7.8	12-5/8	8-1/8	11	23-3/8	3	6	5/8
MD-12	11.4	13-3/4	10-3/16	13-1/8	23-7/8	3	6	5/8
MD-14	15.4	16-1/2	12-1/4	15-1/4	27-3/8	4	6	5/8
MD-16	20.0	19	13-1/2	17-1/4	26	3	5	5/8

*Height includes pin pad thickness and maximum adjustment, but NOT mounting structure thickness.



MOUNTING ROD SPECIFICATIONS FOR STANDARD BOLSTER MOUNTED DIE CUSHIONS

Model	L-R	F-B	H	Thread
MD-8	8-19/32	5-19/32	1-1/4	7/8 -9
MD-10	10-7/8	6-3/8	1-3/8	1 -8
MD-12	12	8-7/16	1-5/8	1 -8
MD-14	14-1/4	10-1/4	1-5/8	1-1/4 -7
MD-16	16-1/2	11	2	1-3/8 -6



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