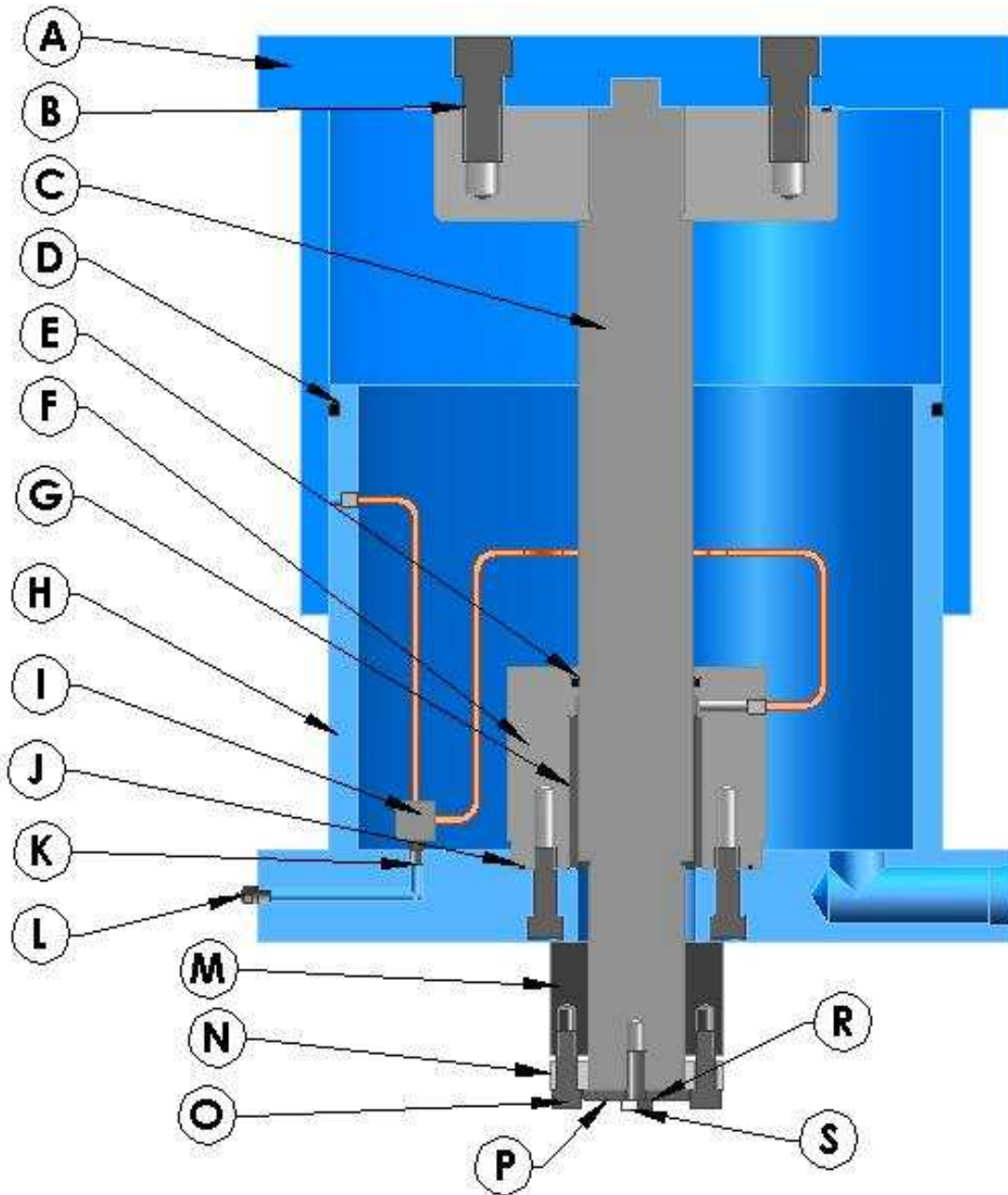


## Model HD Parts List

**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 HD Parts List

Description		Cushion Diameter and Part Number				
		8"	10"	12"	14"	16"
Cylinder <sup>(a)</sup>	A	8542	8598	8619	8442	8625
Soc. Hd. Cap Screw	B	7932	2615	3324	1489	1463
Cylinder Rod	C	7146	7206	6895	6895	7164
Quad Ring	D	8335	8700	10109	9878	10110
Quad Ring	E	8311	8311	9893	9893	9893
Bearing Block	F	8602	8602	8446	8446	8446
Bushing	G	946	946	6955	6955	6955
Piston <sup>(a)</sup>	H	8545	8601	8622	8445	8628
Lubrication Distributor	I	6620	6620	6620	6620	6620
"O" Ring	J	6068	6068	3640	3640	3640
Hex Nipple	K	14498	14498	14498	14498	14498
Lubrication Fitting	L	210	210	210	210	210
Adj. Nut	M	7007	7007	6897	6897	6897
Lock Plate	N	7008	7008	6898	6898	6898
Soc. Hd. Cap Screw	O	774	774	7349	7349	7349
Limit Plate	P	6402	6402	6953	6953	6953
Lock washer	R	7235	7235	7235	7235	7235
Hex. Hd. Cap Screw	S	6394	6394	6394	6394	6394

(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 HD Piston Packings				
	Piston Diameter	Cup Packing Part Number	Quad Ring Part Number	Cushion Serial Number *
HD-8	8"	169	8335	22375
HD-10	10"	490	8700	20000
HD-12	12"	492	10109	
HD-14	14"	179	9878	18873
HD-16	16"	168	10110	19799

\* Quad Ring Packings used after this Serial Number.

Model HD Rod Packings				
	Rod Diameter	Chevron Type Packing Part Number	Quad Ring Part Number	Cushion Serial Number *
HD-8	2"	684	8311	22375
HD-10	2"	684	8311	20000
HD-12	3"	6510	9893	
HD-14	3"	6510	9893	18873
HD-16	3" Quad 3 1/2" Chev.	7310	9893	19799

\* Quad Ring Packings used after this Serial Number.

# Installation Instructions

## Cup Packings

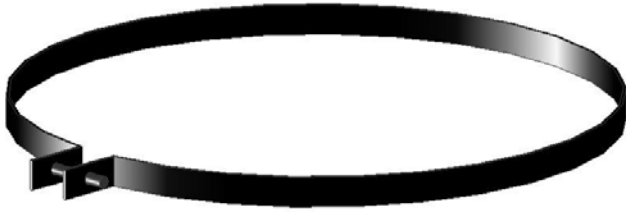


Fig. 15 Clamping band

**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

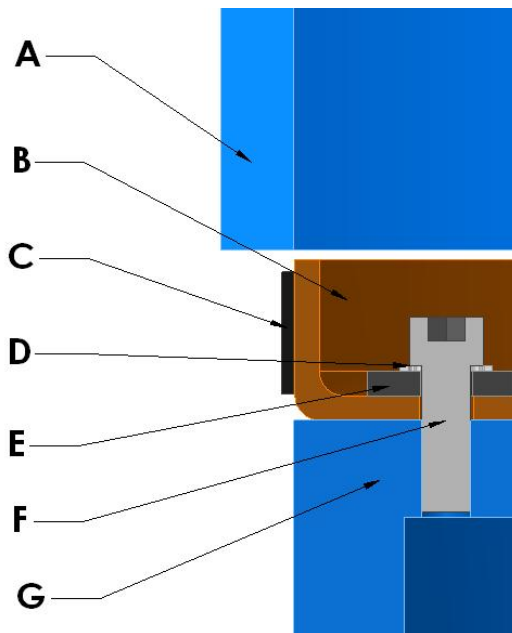


Fig. 16 Cup Packing Installation

# 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

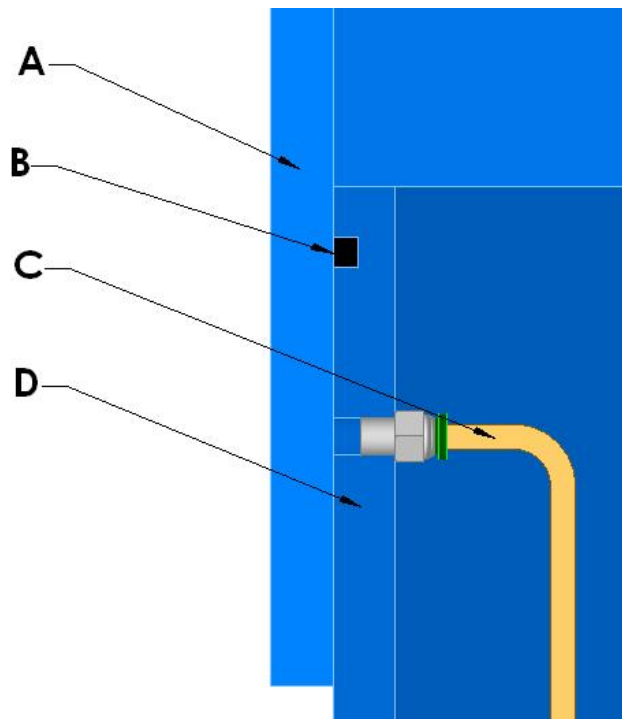


Fig. 17 Quad Ring Installation