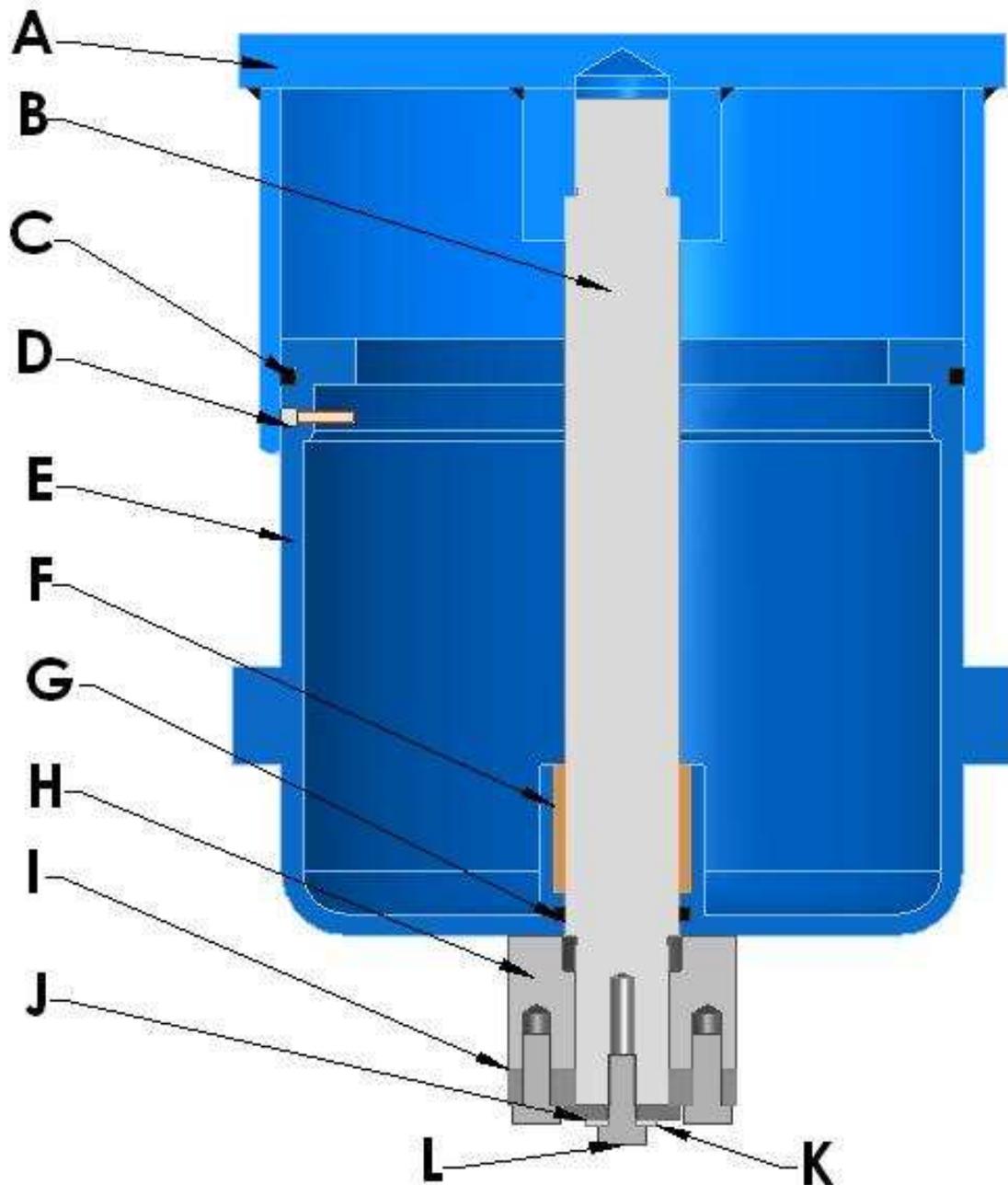


## Model D Parts List

**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 D Parts List

Description		Cushion Diameter and Part Number						
		5"	6"	8"	10"	12"	14"	16"
Cushion Cylinder <sup>(a)</sup>	A	10114	10148	10150	10136	10152	10166	10169
Cylinder Rod	B	10113	12153	10151	10137	10153	10167	10170
Quad Ring	C	10013	8312	8335	8700	10109	9878	10110
Lubrication Set <sup>(b)</sup>	D	1134	1134	1134	1134	1134	1134	1134
Piston <sup>(a)</sup>	E	10112	12146	694	707	5288	756	892
Bearing	F	813	813	698	698	668	668	668
Quad Ring	G	7954	7954	9324	9324	8311	8311	8311
Adjustment Nut	H	6404	6404	6405	6405	7006	7006	7006
Lock Plate	I	7217	7217	7218	7218	7008	7008	7008
Limit Plate	J	6400	6400	7534	7534	6402	6402	6402
Lockwasher	K	7234	7234	7234	7234	7235	7235	7235
Hex. Hd. Cap Screw	L	3584	3584	3584	3584	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)

(b) See detailed sketch on Page. 21.

## 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 D Piston Packings				
	Piston Diameter	Cup Packing Part Number	Quad Ring Part Number	Cushion Serial Number *
D-5	5"	646	10013	19035
D-6	6"	495	8312	18985
D-8	8"	169	8335	19105
D-10	10"	490	8700	19185
D-12	12"	492	10109	19532
D-14	14"	179	9878	20264
D-16	16"	168	10110	19232

- Quad Ring Packings used after this Serial Number.

Model D Rod Packings				
	Rod Diameter	Chevron Type Packing Part Number	Quad Ring Part Number	Cushion Serial Number *
D-5	1 ¼" Quad, 1 ½" Chevron	702	10013	19035
D-6	1 ¼"	811	8312	18985
D-8	1 ½"	702	8335	19105
D-10	1 ½"	702	8700	19185
D-12	2"	684	10109	19532
D-14	2"	684	9878	20264
D-16	2"	684	10110	19232

- \* 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

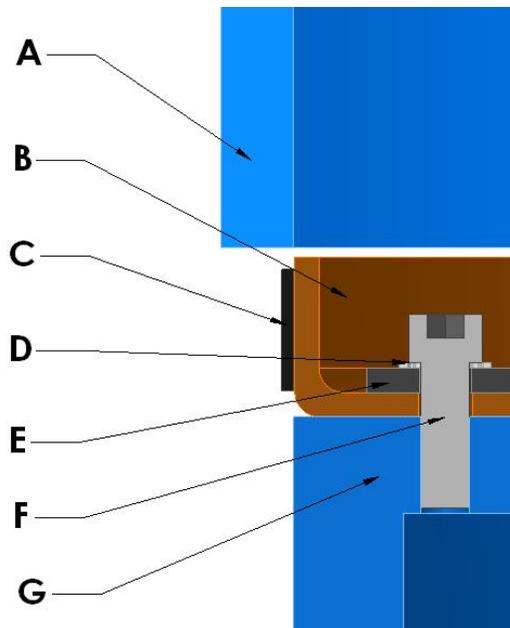


Fig. 16 Cup Packing Installation

# 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 19 will explain the procedure to follow in checking the lubrication system.

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

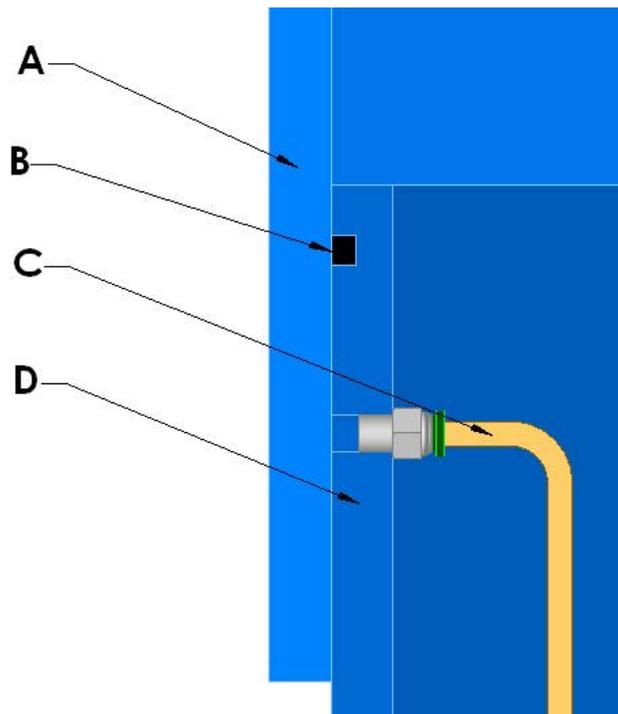


Fig. 17 Quad Ring Installation