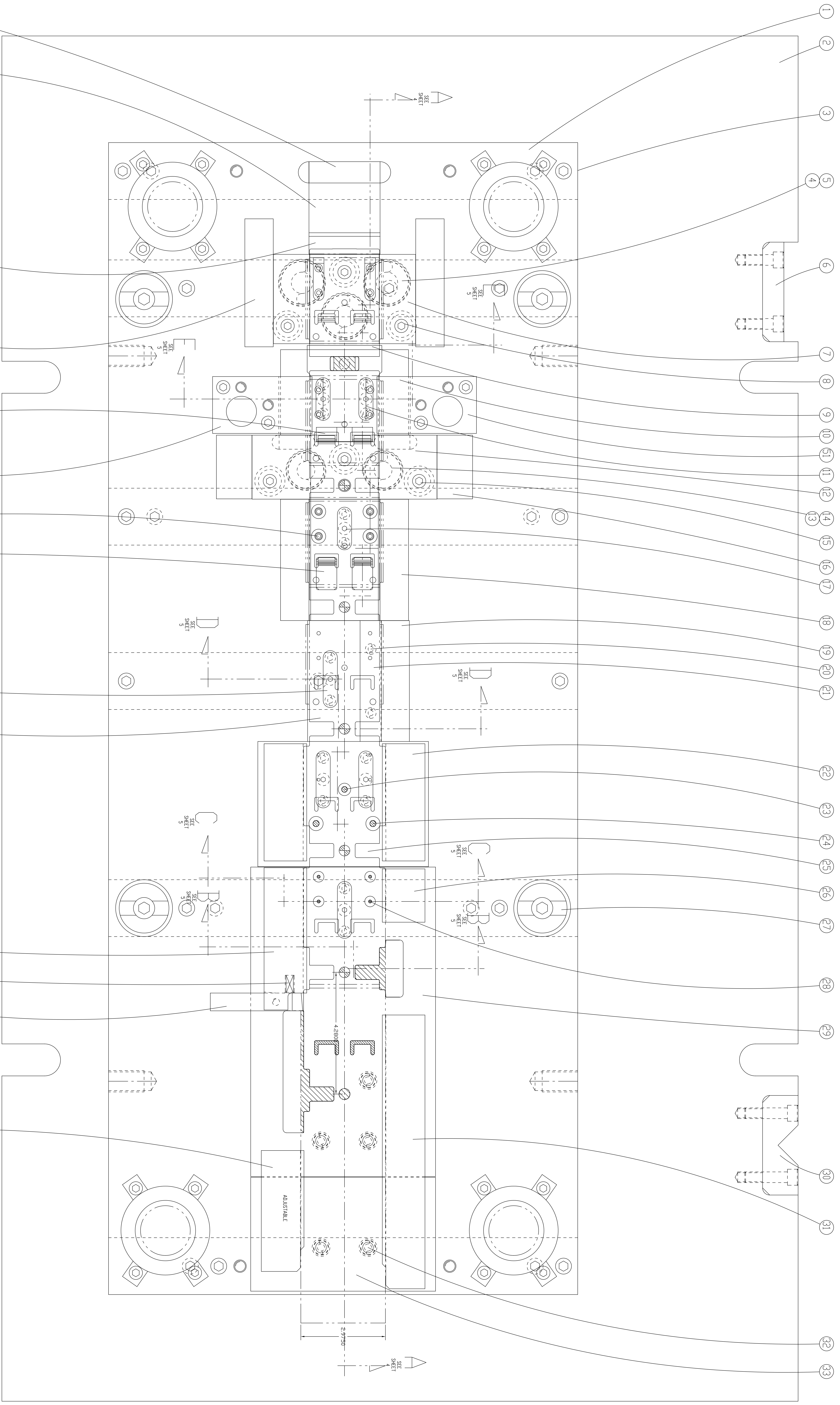
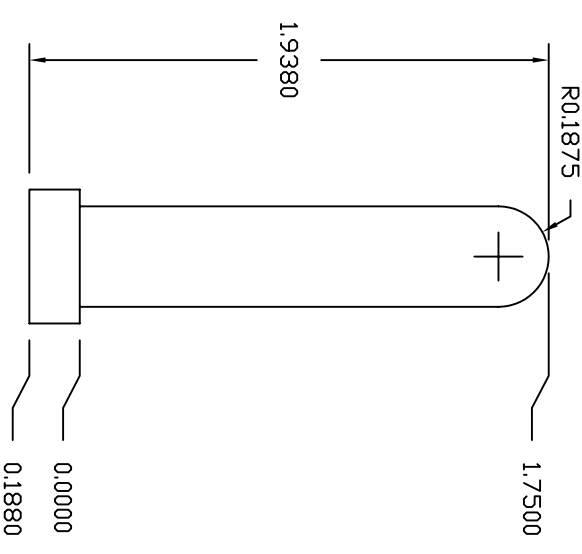
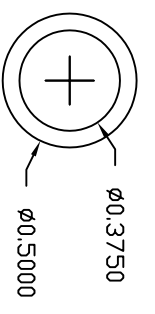


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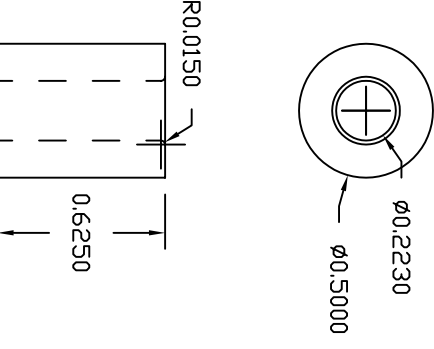
DET.	AMT.	MATERIAL	STOCK SIZE	3HIT
		LIMITS DIM. DIMENSIONS UNLESS OTHERWISE SPECIFIED		
		ANGULAR ± .5°		
		FRACTIONAL ± 1/64		
		3 PLACE DECIMAL .005		
		4 PLACE DECIMAL .0005		
TITLE: PROGRESSIVE DIE CABLE BRACKET				
DRAWN: IST				
SCALE: FULL				
DATE: 9/17/06				
CHECKED: []				
SPEC. BY: []				
DESIGN: []				
DATE: []				
BY: []				
ZONE: []				
DATE: []				
REVISIONS:				
REQ. NO. []				
PROJ.-SPEC. NO. []				
PART NO. []				
MATERIAL: 0.062 THICK GALV. SHEET STEEL				
DWG NO. 3 OF 11				
N.D.				



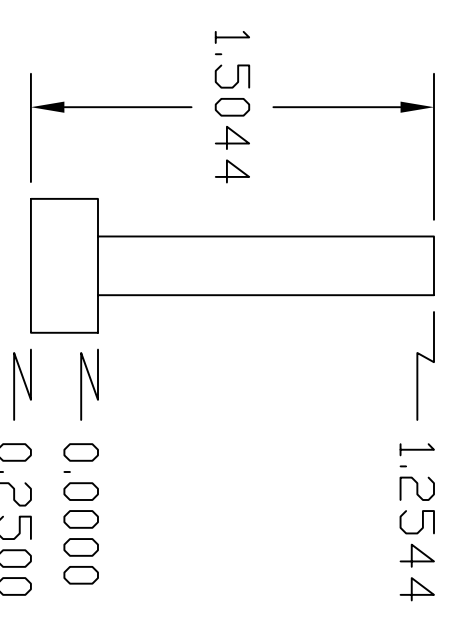
DET.	AMT.	MATERIAL	STOCK SIZE	SHT.
LIMITS ON DIMENSIONS UNLESS OTHERWISE SPECIFIED				
ANGULAR ± .5°				
2 PLACE DECIMAL .005				
FRACTIONS 1/164				
4 PLACE DECIMAL .0005				
DATE 3/21/76				
DRAWN BY [blank]				
CHECKED BY [blank]				
APPROVED BY [blank]				
SCALE FULL				
TITL: PROGRESSIVE DIE				
CABLE BRACKET				
MATERIAL 402 HRS. ONLY SHEET STEEL				
DWG				
SHEET 2 OF 11				
REV. 003				
REV. 002				
REV. 001				
REVISIONS				
DATE IN ZONE				
REV.				



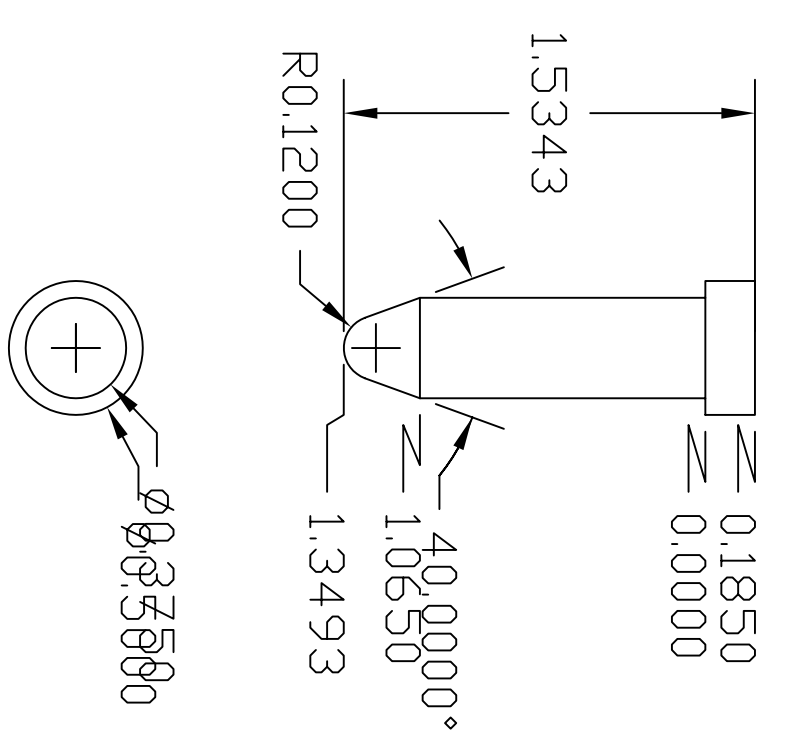
32 FIVE REQUIRED - DAYTON PUNCH BLANK - ALTER
VPB 37-200 A2



42 FOUR REQUIRED - DAYTON DIE BUTTON - ALTER
VNX 50-62 P223 A2



43 FOUR REQUIRED - A-2 TOOL STEEL
HDN & GRD Rc 58-60



47 FOUR REQUIRED - DAYTON PUNCH VPB37-175 A2
ALTER AS SHOWN

BALL BEARING DIE SET DATA	
CATALOG #	37
SERIES AS-	BB
DIE SPACE-A	40.50 P-16.50
THICKNESS-J	0.0000
SHAFT HEIGHT-M	8.00 Max
STROKE X	POST DIA. 1.75
BUSHINGS-Type	DEMONSTRABLE
SHAFT Dia.	1.75
OPERATING CONDITION	
Type I	X
Type II	X
Type III	X
PIN PART #	X
BUSHING PART #	X
CAGE PART #	X
ORDER FROM DAYTON DIE SET 5815 S.W. 54th Ave. P.O. Box 1000 Dayton, Ohio 45424 Tel. 1-503-833-6599	

PLUS: FIVE BURNDOUTS IN DIE SHOE
FOUR 3/4-10 HDL HOLES IN EACH SHOE AS SHOWN
BURNDOUTS MUST BE IN RELATIONSHIP
TO PINS & BUSHINGS

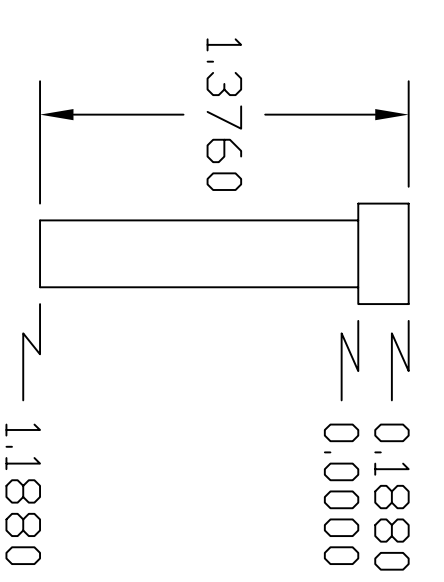
PLEASE SHIP PINS & BUSHINGS UNASSEMBLED

STAMP ON RIGHT FRONT CORNER OF PUNCH-HEADER	
TOL NUMBER	T000636
PART NUMBER	6 920445
TONNAGE	30 TONS APPROX.
SHAFT HEIGHT	X
SHEAR SIZE	2.975
STOCK WIDTH	4.280
PROGRESSION	X
TOP SHEET WEIGHT	X
TOTAL WEIGHT	X
COMPLETION DATE	X
JOB #	06-9303

NOTE: MATL. .062 THICK GALV. SHEET STEEL
CUTTING CLC. .006 PER SIDE

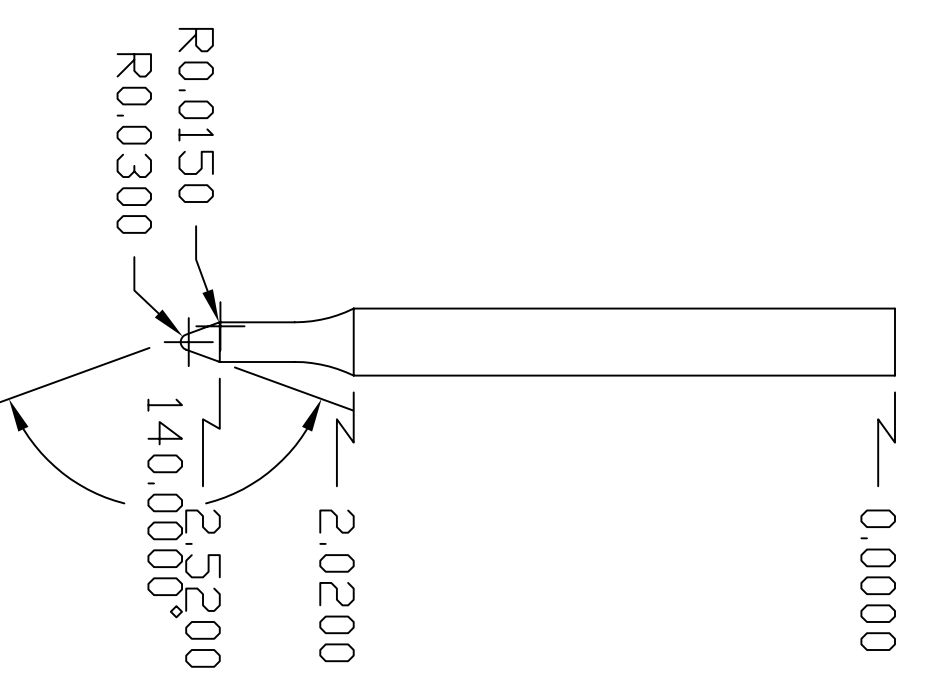
FORM CLC. .058
LOCATE BOLTS, DOWELS & SPRINGS
APPROX AS SHOWN UNLESS SPECIFIED

NOTE: PAINT DIE SAFETY DRANGE



129 TWO REQUIRED - DAYTON PUNCH VPB25-150 A2
ALTER AS SHOWN

125 FOUR REQUIRED - DAYTON PUNCH LPX 25-275 P148 A2 XL2666
ALTER AS SHOWN



DET.	AMT.	DESCRIPTION	STOCK SIZE	QTY	UNIT
154	1	COS	16 X 100 X 262	3	/ 8
153	1	WPE	BURNOUT - 112 THICK	3	/
152	1	DAYTON RETAINER	WET 50	3	/
151	12	DAILY SPRING CAGE	12-16	3	/
150	3	DAYTON ELECTOR SET	9	3	/
149	1	42	265 X 325 X 438	3	/ 8
148	1	DAYTON PILOT	VNA 50-200 P275 A2	3	/
147	4	DAYTON PUNCH - ALTER	SEE DETAIL SHEET 1	3	/ 1
146	1	DAYTON PUNCH	L.P. 37-250 P25 A2	3	/
145	1	440 PREWELD	125 X 275 X 100	3	/ 9
144	1	COS	75 X 75 X 300	3	/
143	10	IEA SPIND	125-225	3	/
142	4	BUSHING	MC100-12	3	/
141	4	DAILY PIN	W100 X 425	3	/
140	5	IEA SPIND	106-225	3	/
139	6	DAILY SPRING CAGE	B-16	3	/
138	6	DAILY SPRING	9-162-21	3	/
137	1	440 PREWELD	138 X 500 X 700	3	/ 10
136	1	42	42 X 100 X 242	3	/ 8
135	1	440 PREWELD	230 X 300 X 312	3	/ 8
134	1	42	42 X 100 X 242	3	/ 8
133	1	42	175 X 200 X 225	3	/ 8
132	1	440 PREWELD	125 X 250 X 475	3	/ 9
131	2	VORCO UNWEDED STEEL CAP	1/2-20 X 5/16 STYLE H	3	/
130	2	DAILY SPRING	9-165-26	3	/
129	2	DAYTON PUNCH BLANK - ALTER	SEE DETAIL SHEET 1	3	/ 1
128	1	42	100 X 125 X 275	3	/ 8
127	1	440 PREWELD	125 X 225 X 475	3	/ 9
126	1	42	125 X 200 X 475	3	/ 9
125	4	DAYTON PUNCH - ALTER	SEE DETAIL SHEET 1	3	/ 1
124	1	COS	75 X 125 X 200	3	/ 8
123	1	42	75 X 75 X 300	3	/
122	2	42	100 X 150 X 312	3	/ 8
121	2	42	300 X 400 X 312	3	/ 8
120	1	WPE	BURNOUT - 112 THICK	3	/ 10
119	12	DAILY SPRING	9-242-26	3	/
118	1	440 PREWELD	25 X 250 X 250	3	/ 9
117	3	DAYTON RETAINER	18T 37	3	/
116	2	DAYTON PUNCH	L.P. 37-250 P220 A2	3	/
115	2	DAYTON SPECIAL RETAINER	SEE DETAIL SHEET 9	3	/ 9
114	4	DAYTON PUNCH	L.P. 25-250 P100 A2	3	/
113	1	42	125 X 150 X 575	3	/ 9
112	1	42	200 X 325 X 325	3	/ 8
111	1	42	125 X 225 X 275	3	/ 8
110	2	42 Q PRICE MARKS 2 DETAILS	200 X 250 X 275	3	/ 8
109	1	WPE	BURNOUT - 112 THICK	3	/
108	1	440 PREWELD	25 X 175 X 242	3	/ 9
107	1	DAYTON RETAINER	18T 50	3	/
106	1	DAYTON PUNCH	L.P. 50-250 P279 A2	3	/
105	1	440 PREWELD	75 X 328 X 1850	3	/ 9
104	1	WPE	BURNOUT - 75 THICK	3	/ 10
103	3	WPE	112 X 200 X 850	3	/
102	10	DAILY SPRING CAGE	10-18	3	/
101	10	DAILY SPRING	9-244-26	3	/
100	8	IEA SPIND	116-250	3	/
DET.	AMT.	MATERIAL	STOCK SIZE	QTY	UNIT

DET.	AMT.	DESCRIPTION	STOCK SIZE	QTY	UNIT
54	7	STRIPPER BLT	3/16 DIA X 175	2	/
DET.	AMT.	MATERIAL	STOCK SIZE	QTY	UNIT

DET.	AMT.	MATERIAL	STOCK SIZE	QTY	UNIT
53	14	DAILY SPRING	9-165-119	2	/
52	1	440 PREWELD	200 X 225 X 350	2	/ 6
51	1	440 PREWELD	200 X 225 X 350	2	/ 6
50	1	COS	75 X 75 X 250	2	/
49	1	42	150 X 200 X 250	2	/ 7
48	1	42	50 X 150 X 250	2	/ 7
47	2	440 PREWELD	100 X 225 X 450	2	/ 7
46	1	42	50 X 175 X 200	2	/ 6
45	9	VORCO UNWEDED STEEL CAP	5/8 DIA X 5/16 STYLE H	2	/
44	4	DAILY SPRING	9-166-11	2	/
43	4	42	50 DIA X 142	2	/ 1
42	4	DAYTON DIE BUTTON-ALTER	SEE DETAIL SHEET 1	2	/ 1
41	2	42	75 X 125 X 150	2	/ 6
40	4	42	50 X 125 X 212	2	/ 7
39	1	42	150 X 200 X 438	2	/ 6
38
37	1	440 PREWELD	42 X 150 X 512	2	/ 7
36	1	WV SPRING	10 SUIT	2	/
35	1	42	42 X 42 X 325	2	/ 7
34	1	440 PREWELD	42 X 150 X 438	2	/ 7
33	1	42	150 X 400 X 450	2	/ 6
32	5	DAYTON PUNCH BLANK-ALTER	SEE DETAIL SHEET 1	2	/ 1
31	1	440 PREWELD	42 X 125 X 975	2	/ 7
30	1	42	100 X 125 X 342	2	/ 11
29	1	42	150 X 650 X 1100	2	/ 6
28	4	DAYTON DIE BUTTON	VNA 37-150 P142 A2	2	/
27	4	3/16 DIA SETUP BLOCK	J-2604	2	/
26	1	440 PREWELD	42 X 150 X 200	2	/ 7
25	1	42	150 X 600 X 450	2	/ 6
24	2	DAYTON DIE BUTTON	VNA 50-150 P242 A2	2	/
23	1	DAYTON DIE BUTTON	VNA 43-150 P207 A2	2	/
22	2	440 PREWELD	42 X 150 X 425	2	/ 7
21	1	42	100 X 150 X 438	2	/ 6
20	2	DAILY SPRING	9-166-11	2	/
19	1	42	100 X 100 X 438	2	/ 6
18	1	42	150 X 450 X 438	2	/ 6
17	1	42	50 X 125 X 142	2	/ 7
16	2	440 PREWELD	125 X 225 X 275	2	/ 7
15	3	IEA SPIND	106-150R	2	/
14	2	DAILY SPRING CAGE	10-18	2	/
13	2	DAILY SPRING	9-206-26	2	/
12	1	42	150 X 250 X 650	2	/ 7
11	2	42	50 X 125 X 142	2	/ 7
10	1	42	150 X 300 X 450	2	/ 6
9	1	42	25 X 150 X 275	2	/ 6
8	3	IEA SPIND	106-150R	2	/
7	1	42	125 X 325 X 512	2	/ 7
6	1	42	75 X 100 X 342	2	/ 11
5	3	DAILY SPRING CAGE	12-16	2	/
4	3	DAILY SPRING	9-242-26	2	/
3	6	MC	200 X 550 X 850	2	/
2	1	WPE	BURNOUT - 112 THICK	2	/ 11
1	1	DAILY DIE SET	SEE STAMP	2	/ 1
DET.	AMT.	MATERIAL	STOCK SIZE	QTY	UNIT

LIMITS DN DIMENSIONS UNLESS OTHERWISE SPECIFIED
ANGULAR ± .5°
3 PLACE DECIMAL #003
FRACTIONAL ± 1/64
4 PLACE DECIMAL #0005

TITLE: PROGRESSIVE DIE
CABLE BRACKET

PART NO. MATL. .062 THICK GALV. SHEET STEEL
SHT. NO. 1 OF 11
DWG NO.

PREP.	SPEC/CHG.	DES. REQ.	REV.	DATE	BY	ZONE

BRAWN	IST
SCALE	FULL
DATE	3/17/06
CHECKED	
SPEC.	
DESIGN	
RECD	
APP'D	
DEPT.	

