



The addition of a Pneumatic Die Cushion to an Inclinable Press will increase the draw capacity of the press.

The feature of the Pneumatic Die Cushion is that the exact amount of buffer pressure can be applied to keep a drawing operation wrinkle-free and this same pressure is applied through the whole depth of draw. When other mediums, such as rubber or springs are used, the pressure build-up is sometimes great enough to cause the drawn metal to be torn, resulting in many rejects. Pneumatic Die Cushions are available for all "John Heine" Inclinable Presses, 30 tons capacity and upwards.

Specifications of these cushions are listed below.

Die cushions are also available for our range of Straight Sided Presses, details of which will be supplied on request.

A diagrammatic sketch of a Die Cushion lay-out for an Inclinable Press is illustrated above. Each "John Heine" Die Cushion is supplied with Surge Tank and fittings as shown.

NOTE: 207A and 208A Die Cushions are the internally guided type.

DIE CUSHION No.	67R-8 x 2½	77R-11 x 2½	77R-11 x 3	207A	208A
FOR PRESS MODEL No.	203A (Series 2 & 3) 203AG (Series 2 & 3)	205A (Series 2) 205AG (Series 2)	205A & 206A (Series 3) 205AG & 206AG (Series 3)	207A (Series 4) 207AG (Series 4)	208A (Series 1) 208AG (Series 1)
Diameter of Cylinder	8	11	11	12½ & 14½	14½ & 16½
No. of Cylinders	1	2	2	2	2
Max. pressure @ 100 lbs. per sq. inch	2½ ton	8½ ton	8½ ton	12½ ton	17 ton
Area of Pressure Plate	10½ dia.	11 dia.	11½ dia.	13 x 13	19½ x 13½
Maximum Stroke	2½	2½	3	4½	4½

# Pneumatic DIE CUSHIONS



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