Posi-Strip™ Punch Stripping System

Flat or Contoured Surface

Patent Pending.

These easy-to-install self-contained strippers attach to standard catalog retainers with multiple spring pressure options. The compact robust design is ideal for newer high strength steels.

Cost-Effective Alternative to Custom Spring Strippers

Durable
Self-contained

Posi-Strip™
PUNCH STRIPPING SYSTEM

DAY TON®

Global leader in providing fabrication and stamping solutions

www.daytonlamina.com
Check our website for the latest technical information.

Posi-Strip™ Features and Benefits

The **Posi-Strip Punch Stripping System** features a self-contained punch stripping unit for applications where large stripper plates or pads do not fit or cannot be shaped to custom contours. The compact, all-in-one design is a lower-cost alternative to custom built steel spring strippers. It is the ideal solution for holding material in compact spaces. Every punch can have its own designated stripper for more versatility and added flexibility within the die.

Each Posi-Strip unit utilizes its own custom spring, dependent on length and stripping force required. The soft bronze portion comfortably and closely encases the punch point for a clean stripping action that will not deform or damage the work piece during operation. The complete assembly is held together with a threaded backing plug that can be easily removed and restored without requiring special tools. With fewer assembly components, the self-contained unit minimizes the risk of lost items or tooling damage caused by displaced items.

Reduce setup and design time with an easily configured stripper. The small body and simple design make it easy to add to any die set that requires a unique punch stripping application.

A single product code gives you the stripper size, punch shape and force you need. The standardized catalog product code can be expanded to a custom contour defined in your CAD file, or you can order the stripper for your own in-house contour machining. This versatile product can be ordered as a standard catalog item, with no need to order as a special item.

Posi-Strip stripper units are easily paired to industry-standard Dayton punch retainers and can just as easily replace expensive strippers from other manufacturers. Posi-Strip is designed with a housing that mounts effortlessly to most industry standard retainers for a virtually unnoticeable footprint in the die.

Features

- 11 standard shapes, 77 classified shapes, and blank units available as standards.
- Four spring pressures available: Extra Light Duty, Light Duty, Medium Duty, and Heavy Duty
- No special tools required for disassembly – standard spanner wrench is ideal
- Standard design can be used up to a 15° pierce angle. Compact/Extended Reach design is ideal for smaller spaces.

Benefits

- Low cost alternative to expensive custom-built spring strippers
- One piece self-contained unit – No loose parts
- Compact but durable design – Can be used in tight spaces
- Fits industry-standard Dayton ball lock and headed retainers: BRT, BRTB, BRTL, BRTBL, CRT, ART, ARTS, HRT, HRTB, HRTL, HRTBL, LRT, VRT, & VRTS

CAD Data

Ready to place instantly in your design, CAD data for Posi-Strip Punch Strippers is available at:

www.daytonlamina.com/posi-strip

Technical Information

Design

Specify punch type and point shape for each unique Posi-Strip application. The bronze stripper is manufactured for 0.3 mm / .012 inch clearance per side.

The easy-to-order product code defines the stripper's body length, bronze insert, and spring type. Custom contoured bronze inserts can be defined with a supplied CAD file or drawing/print.

Each Posi-Strip Punch Stripper comes with a compression spring. You can choose the pressure of the spring from Extra Light Duty, Light Duty, Medium Duty, and Heavy Duty. See pages 10-11 for stripping forces.

The backing plug is used to locate the Posi-Strip unit with the punch shank.

The designed "F" length is critical. Altering the unit from the published "F" dimension may increase the chance of over-stroking. Over-stroking the unit could lead to premature or catastrophic failure.

Maximum deflection is specified on each Posi-Strip body. Compliance with this value is imperative to successful operation.

All spring data is lab tested.

Each Posi-Strip unit is designed and tested for a travel of 3 mm or .118 inches. If your application requires additional stroke, please call for more information.

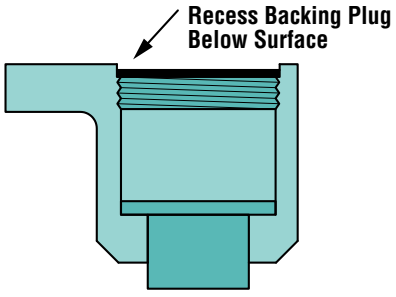
Installation

The Backing Plug utilizes two small holes to assist in the installation and removal. The unit can be easily disassembled with a common spanner wrench.

If a spring shifts off-center during removal of the backing plug, realign by lightly tapping the stripper on the punch.

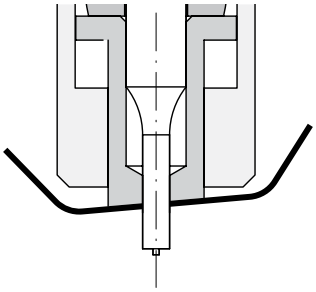
Use the provided socket head cap screw to install the Posi-Strip Punch Stripper to the retainer. The socket head cap screw fits in an elliptical mounting hole for flexibility when fastening to the retainer.

For proper fitting to the retainer, ***ensure that the Backing Plug is recessed below the surface of the stripper***. Damage will occur if the backing plug is not recessed.



Custom Contour Bronze Insert

The bronze insert can be manufactured to contours specified in your CAD file or drawing/print. The contour can be up to 3 mm or .118 inches.



Spanner Wrench

Posi-Strip Punch Strippers are designed to be easily disassembled with common tools like a spanner wrench.

Catalog Number 886483

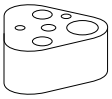
Replacement Springs

Each Posi-Strip Punch Stripper comes ready-assembled with a spring. To order replacement springs or select from optional stripping forces, see pages 10-11.

Ball Lock Metric
For True Position® Retainers

Heavy Duty

BT_J_ Regular

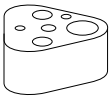


For **BRT**, **BRTB**, **BRTL**, & **BRTBL** heavy duty retainers

BT_E_ Compact – Extended Reach

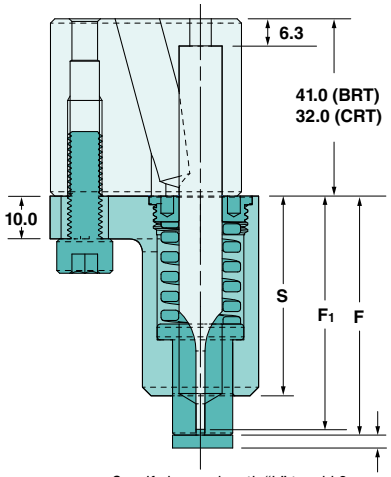
Light Duty

CT_J_ Regular

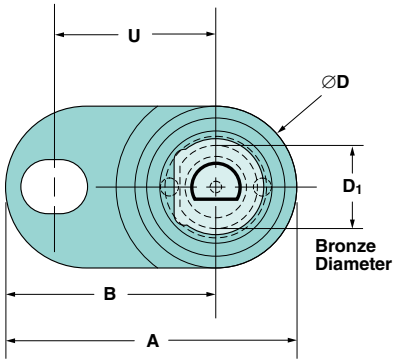


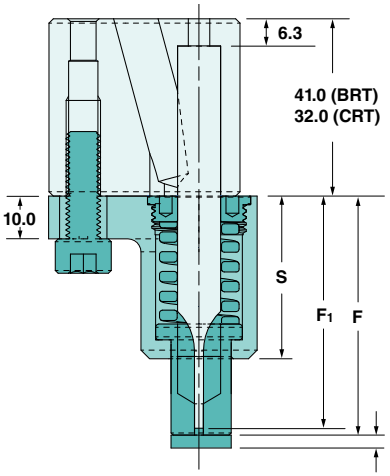
For **CRT** light duty retainers

CT_E_ Compact – Extended Reach



Specify bronze length "L" to add 3 mm for in-house contour machining.





Specify bronze length "L" to add 3 mm for in-house contour machining.

HOW TO ORDER

Example: BTOJM 16 R100 P=12.5 W=8.5 PS89 30
CTXEM 32 L90 P=20.0

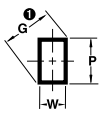
Stripper	Point Shape	Reach	Spring Type	Punch Diameter	Bronze Length	Punch Length	Punch Point Dimensions
BT, CT	C, E, H, J, K, L, N, O, R, V, X, Y, Z	E=Extended J=Regular	S=Extra Light (SSD) L=Light (SLD) M=Medium (SMD) H=Heavy (SHD)	10, 13, 16, 20, 25, 32, 40	R=Regular L=3 mm Longer C=Custom Contour †	71, 80, 90, 100	P, W, etc.

†Custom Contour up to 3 mm per submitted CAD file.

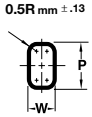
X

O

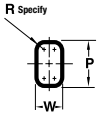
R



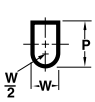
L



K



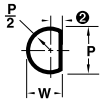
J



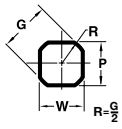
H

N

V



Y



Z

E

(Blank)

C

(Classified Shape Number)

If ball seat on punch is at an angle other than 90° standard, specify stripper alteration PS89 with same angle. No additional charge for PS89.

Point larger than shank is not available.

Bronze stripper clearance per side is 0.3 mm.

Views are reflected.

Additional shapes available upon request. See punch catalog for complete selection of classified shapes.

Paired retainers and punches are ordered as separate line items.

Ball Lock Metric
For True Position® Retainers

Heavy Duty

Product Code		A	B	D_1	D	U	S	F	F_1	Maximum Spring Travel* Extra Light	Light	Medium	Heavy
Regular	BT_J_10_80	48.5	35.00	15.0	27.00	26.924	37.5	45.65	45.3	8.2	8.2	8.2	6.6
	BT_J_10_90						46.5	55.65	55.3	9.8	9.2	9.2	6.6
	BT_J_10_100						54.5	65.65	65.3	11.2	11.2	11.2	8.9
	BT_J_13_80	54.8	38.10	20.0	33.30	29.972	37.5	45.65	45.3	8.2	8.2	8.2	6.2
	BT_J_13_90						46.5	55.65	55.3	9.2	9.2	8.7	6.2
	BT_J_13_100						54.5	65.65	65.3	11.2	11.2	11.2	8.9
	BT_J_16_80	59.0	38.88	27.0	40.25	31.750	37.5	45.65	45.3	7.8	8.2	8.2	6.8
	BT_J_16_90						46.5	55.65	55.3	7.8	9.2	8.8	6.8
	BT_J_16_100						54.5	65.65	65.3	11.2	11.2	9.3	10.3
	BT_J_20_80	65.0	42.68	33.0	44.65	33.528	37.5	45.65	45.3	8.2	8.2	6.8	6.3
	BT_J_20_90						46.5	55.65	55.3	9.8	8.8	6.8	6.3
	BT_J_20_100						54.5	65.65	65.3	11.2	11.2	11.2	9.8
	BT_J_25_80	76.0	47.62	42.0	56.76	40.640	37.5	45.65	45.3	7.8	6.3	7.8	7.3
	BT_J_25_90						46.5	55.65	55.3	7.8	6.3	7.8	7.3
	BT_J_25_100						54.5	65.65	65.3	11.2	11.2	11.2	8.8
	BT_J_32_80	79.0	47.62	48.0	62.76	40.640	37.5	45.65	45.3	8.2	7.8	8.2	3.8
	BT_J_32_90						46.5	55.65	55.3	8.3	7.8	8.3	3.8
	BT_J_32_100						54.5	65.65	65.3	11.2	11.2	10.8	8.8
	BT_J_40_80	88.4	51.38	55.0	74.00	43.993	37.5	45.65	45.3	8.2	6.8	7.3	3.8
	BT_J_40_90						46.5	55.65	55.3	8.3	6.8	7.3	3.8
	BT_J_40_100						54.5	65.65	65.3	11.2	11.2	10.3	9.8
Compact - Extended Reach	BT_E_10_90	48.5	35.00	15.0	27.00	26.924	37.5	55.65	55.3	9.8	11.4	9.1	6.6
	BT_E_10_100							65.65	65.3				
	BT_E_13_90	54.8	38.10	20.0	33.30	29.972	37.5	55.65	55.3	10.3	11.1	8.7	6.2
	BT_E_13_100							65.65	65.3				
	BT_E_16_90	59.0	38.88	27.0	40.25	31.750	37.5	55.65	55.3	7.8	9.8	8.8	6.8
	BT_E_16_100							65.65	65.3				
	BT_E_20_90	65.0	42.68	33.0	44.65	33.528	37.5	55.65	55.3	9.8	8.8	6.8	6.3
	BT_E_20_100							65.65	65.3				
	BT_E_25_90	76.0	47.62	42.0	56.76	40.640	37.5	55.65	55.3	7.8	6.3	7.8	7.3
	BT_E_25_100							65.65	65.3				
	BT_E_32_90	79.0	47.62	48.0	62.76	40.640	37.5	55.65	55.3	8.3	7.8	8.3	3.8
	BT_E_32_100							65.65	65.3				
	BT_E_40_90	88.4	51.38	55.0	74.00	43.993	37.5	55.65	55.3	8.3	6.8	7.3	3.8
	BT_E_40_100							65.65	65.3				

*** Usage at Maximum Travel is not recommended as it can compromise the life of the spring.**

For stripping force selection, see page 10.

Light Duty

Product Code		A	B	D_1	D	U	S	F	F_1	Maximum Spring Travel* Extra Light	Light	Medium	Heavy
Regular	CT_J_10_71	48.5	35.00	15.0	27.00	26.924	37.5	46.65	45.3	9.2	9.2	9.1	6.6
	CT_J_10_80						46.5	55.65	54.3	9.2	9.2	9.1	6.6
	CT_J_10_90						54.5	65.65	64.3	11.2	11.2	11.2	8.9
	CT_J_13_71	54.8	38.10	20.0	33.30	29.972	37.5	46.65	45.3	9.2	9.2	8.7	6.2
	CT_J_13_80						46.5	55.65	54.3	9.2	9.2	8.7	6.2
	CT_J_13_90						54.5	65.65	64.3	11.2	11.2	11.2	8.9
	CT_J_16_71	59.0	38.88	27.0	40.25	31.750	37.5	46.65	45.3	7.8	9.2	8.8	6.8
	CT_J_16_80						46.5	55.65	54.3	7.8	9.2	8.8	6.8
	CT_J_16_90						54.5	65.65	64.3	11.2	11.2	9.3	10.3
	CT_J_20_71	65.0	42.68	33.0	44.65	33.528	37.5	46.65	45.3	9.2	8.8	6.8	6.3
	CT_J_20_80						46.5	55.65	54.3	9.2	8.8	6.8	6.3
	CT_J_20_90						54.5	65.65	64.3	11.2	11.2	11.2	9.8
	CT_J_25_71	76.0	47.62	42.0	56.76	40.640	37.5	46.65	45.3	7.8	6.3	7.8	7.3
	CT_J_25_80						46.5	55.65	54.3	7.8	6.3	7.8	7.3
	CT_J_25_90						54.5	65.65	64.3	11.2	11.2	11.2	8.8
	CT_J_32_71	79.0	47.62	48.0	62.76	40.640	37.5	46.65	45.3	8.3	7.8	8.3	3.8
	CT_J_32_80						46.5	55.65	54.3	8.3	7.8	8.3	3.8
	CT_J_32_90						54.5	65.65	64.3	11.2	11.2	10.8	8.8
Compact - Extended Reach	CT_E_10_80	48.5	35.00	15.0	27.00	26.924	37.5	55.65	54.3	9.8	11.4	9.1	6.6
	CT_E_10_90							65.65	64.3				
	CT_E_13_80	54.8	38.10	20.0	33.30	29.972	37.5	55.65	54.3	10.3	11.1	8.7	6.2
	CT_E_13_90							65.65	64.3				
	CT_E_16_80	59.0	38.88	27.0	40.25	31.750	37.5	55.65	54.3	7.8	9.8	8.8	6.8
	CT_E_16_90							65.65	64.3				
	CT_E_20_80	65.0	42.68	33.0	44.65	33.528	37.5	55.65	54.3	9.8	8.8	6.8	6.3
	CT_E_20_90							65.65	64.3				
	CT_E_25_80	76.0	47.62	42.0	56.76	40.640	37.5	55.65	54.3	7.8	6.3	7.8	7.3
	CT_E_25_90							65.65	64.3				
	CT_E_32_80	79.0	47.62	48.0	62.76	40.640	37.5	55.65	54.3	8.3	7.8	8.3	3.8
	CT_E_32_90							65.65	64.3				

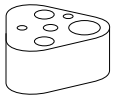
*** Usage at Maximum Travel is not recommended as it can compromise the life of the spring.**

For stripping force selection, see page 10.

Ball Lock Inch
For True Position® Retainers

Heavy Duty

HT_J_ Regular

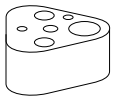


For **HRT**, **HRTB**, **HRTL**, & **HRTBL** heavy duty retainers

HT_E_ Compact – Extended Reach

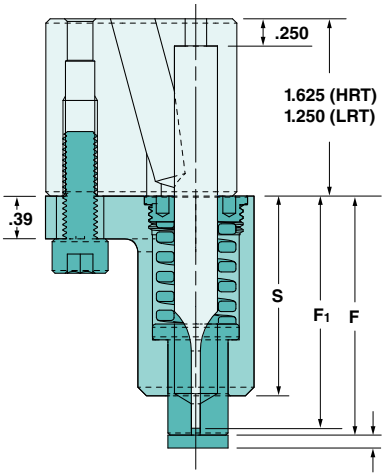
Light Duty

LT_J_ Regular

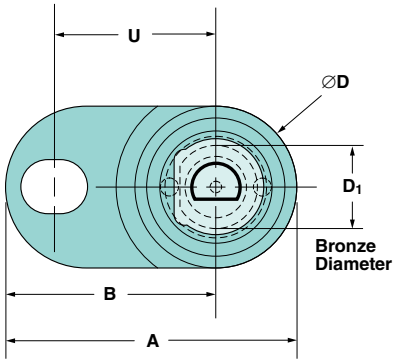


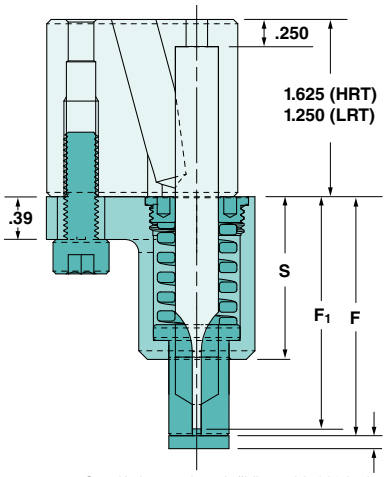
For **LRT** light duty retainers

LT_E_ Compact – Extended Reach



Specify bronze length "L" to add .118 inch for in-house contour machining.





Specify bronze length "L" to add .118 inch for in-house contour machining.

HOW TO ORDER

Example: HTXJM 100 R350 P=.75
LTRJM 75 R325 P=.52 W=.35 PS89 45

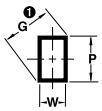
Stripper	Point Shape	Reach	Spring Type	Punch Diameter	Bronze Length	Punch Length	Punch Point Dimensions
HT, LT	C, E, H, J, K, L, N, O, R, V, X, Y, Z	E=Extended J=Regular	S=Extra Light (SSD) L=Light (SLD) M=Medium (SMD) H=Heavy (SHD)	.37, .50, .62, .75, 1.00, 1.25	R=Regular L=.118 inch Longer C=Custom Contour †	3.00, 3.25, 3.50, 4.00	P, W, etc.

†Custom Contour up to .118 inch per submitted CAD file.

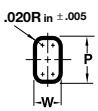
X

O

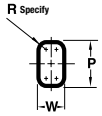
R



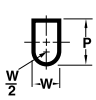
L



K



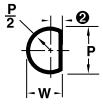
J



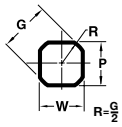
H

N

V



Y



Z

E

(Blank)

C

(Classified Shape Number)

If ball seat on punch is at an angle other than 90° standard, specify stripper alteration PS89 with same angle. No additional charge for PS89.

Point larger than shank is not available.

Bronze stripper clearance per side is .012 inch.

Views are reflected.

Additional shapes available upon request. See punch catalog for complete selection of classified shapes.

Paired retainers and punches are ordered as separate line items.

Ball Lock Inch

For True Position® Retainers

Heavy Duty

	Product Code	A	B	D_1	D	U	S	F	F_1	Maximum Spring Travel* Extra Light	Light	Medium	Heavy
Regular	HT_J_37_325	1.91	1.38	0.59	1.06	1.06	1.48	1.92	1.88	0.39	0.44	0.36	0.26
	HT_J_37_350						1.83	2.15	2.13	0.32	0.32	0.32	0.26
	HT_J_37_400						2.15	2.67	2.63	0.52	0.52	0.46	0.35
	HT_J_50_325	2.16	1.50	0.79	1.31	1.18	1.48	1.92	1.88	0.41	0.44	0.34	0.24
	HT_J_50_350						1.83	2.15	2.13	0.32	0.32	0.32	0.24
	HT_J_50_400						2.15	2.67	2.63	0.52	0.52	0.45	0.35
	HT_J_62_325	2.32	1.53	1.06	1.58	1.25	1.48	1.92	1.88	0.31	0.39	0.35	0.27
	HT_J_62_350						1.83	2.15	2.13	0.31	0.32	0.32	0.27
	HT_J_62_400						2.15	2.67	2.63	0.52	0.52	0.37	0.41
	HT_J_75_325	2.56	1.68	1.30	1.76	1.32	1.48	1.92	1.88	0.39	0.35	0.27	0.25
	HT_J_75_350						1.83	2.15	2.13	0.32	0.32	0.27	0.25
	HT_J_75_400						2.15	2.67	2.63	0.46	0.46	0.46	0.39
	HT_J_87_325	2.99	2.01	1.50	1.96	1.60	1.48	1.92	1.88	0.27	0.27	0.31	0.17
	HT_J_87_350						1.83	2.15	2.13	0.27	0.27	0.31	0.17
	HT_J_87_400						2.15	2.67	2.63	0.48	0.52	0.43	0.41
	HT_J_100_325	3.11	1.87	1.65	2.47	1.60	1.48	1.92	1.88	0.31	0.25	0.31	0.29
	HT_J_100_350						1.83	2.15	2.13	0.31	0.25	0.31	0.29
	HT_J_100_400						2.15	2.67	2.63	0.50	0.48	0.46	0.35
	HT_J_125_325	3.48	2.02	2.17	2.91	1.73	1.48	1.92	1.88	0.33	0.31	0.33	0.15
	HT_J_125_350						1.83	2.15	2.13	0.32	0.31	0.32	0.15
	HT_J_125_400						2.15	2.67	2.63	0.52	0.52	0.43	0.35
Compact - Extended Reach	HT_E_37_350	1.91	1.38	0.59	1.06	1.06	1.48	2.15	2.13	0.39	0.45	0.36	0.26
	HT_E_37_400							2.67	2.63				
	HT_E_50_350	2.16	1.50	0.79	1.31	1.18	1.48	2.15	2.13	0.41	0.44	0.34	0.24
	HT_E_50_400							2.67	2.63				
	HT_E_62_350	2.32	1.53	1.06	1.58	1.25	1.48	2.15	2.13	0.31	0.39	0.35	0.27
	HT_E_62_400							2.67	2.63				
	HT_E_75_350	2.56	1.68	1.30	1.76	1.32	1.48	2.15	2.13	0.39	0.35	0.27	0.25
	HT_E_75_400							2.67	2.63				
	HT_E_87_350	2.99	2.01	1.50	1.96	1.60	1.48	2.15	2.13	0.27	0.27	0.31	0.17
	HT_E_87_400							2.67	2.63				
	HT_E_100_350	3.11	1.87	1.65	2.47	1.60	1.48	2.15	2.13	0.31	0.25	0.31	0.29
	HT_E_100_400							2.67	2.63				
	HT_E_125_350	3.48	2.02	2.17	2.91	1.73	1.48	2.15	2.13	0.33	0.31	0.33	0.15
	HT_E_125_400							2.67	2.63				

*** Usage at Maximum Travel is not recommended as it can compromise the life of the spring.**

For stripping force selection, see page 11.

Light Duty

	Product Code	A	B	D_1	D	U	S	F	F_1	Maximum Spring Travel* Extra Light	Light	Medium	Heavy
Regular	LT_J_37_300	1.91	1.38	0.59	1.06	1.06	1.48	2.04	2.00	0.39	0.45	0.36	0.26
	LT_J_37_325						1.83	2.28	2.25	0.39	0.44	0.36	0.26
	LT_J_37_350						2.15	2.56	2.50	0.40	0.40	0.40	0.35
	LT_J_50_300	2.16	1.50	0.79	1.31	1.18	1.48	2.04	2.00	0.41	0.44	0.34	0.24
	LT_J_50_325						1.83	2.28	2.25	0.41	0.44	0.34	0.24
	LT_J_50_350						2.15	2.56	2.50	0.40	0.40	0.40	0.35
	LT_J_62_300	2.32	1.53	1.06	1.58	1.25	1.48	2.04	2.00	0.31	0.39	0.35	0.27
	LT_J_62_325						1.83	2.28	2.25	0.31	0.39	0.35	0.27
	LT_J_62_350						2.15	2.56	2.50	0.40	0.40	0.37	0.41
	LT_J_75_300	2.56	1.68	1.30	1.76	1.32	1.48	2.04	2.00	0.39	0.35	0.27	0.25
	LT_J_75_325						1.83	2.28	2.25	0.39	0.35	0.27	0.25
	LT_J_75_350						2.15	2.56	2.50	0.40	0.40	0.40	0.39
	LT_J_87_300	2.99	2.01	1.50	1.96	1.60	1.48	2.04	2.00	0.27	0.27	0.31	0.17
	LT_J_87_325						1.83	2.28	2.25	0.27	0.27	0.31	0.17
	LT_J_87_350						2.15	2.56	2.50	0.40	0.40	0.40	0.41
	LT_J_100_300	3.11	1.87	1.65	2.47	1.60	1.48	2.04	2.00	0.31	0.25	0.31	0.29
	LT_J_100_325						1.83	2.28	2.25	0.31	0.25	0.31	0.29
	LT_J_100_350						2.15	2.56	2.50	0.40	0.40	0.40	0.35
Compact - Extended Reach	LT_E_37_325	1.91	1.38	0.59	1.06	1.06	1.48	2.28	2.25	0.39	0.45	0.36	0.26
	LT_E_37_350							2.56	2.50				
	LT_E_50_325	2.16	1.50	0.79	1.31	1.18	1.48	2.28	2.25	0.41	0.44	0.34	0.24
	LT_E_50_350							2.56	2.50				
	LT_E_62_325	2.32	1.53	1.06	1.58	1.25	1.48	2.28	2.25	0.31	0.39	0.35	0.27
	LT_E_62_350							2.56	2.50				
	LT_E_75_325	2.56	1.68	1.30	1.76	1.32	1.48	2.28	2.25	0.39	0.35	0.27	0.25
	LT_E_75_350							2.56	2.50				
	LT_E_87_325	2.99	2.01	1.50	1.96	1.60	1.48	2.28	2.25	0.27	0.27	0.31	0.17
	LT_E_87_350							2.56	2.50				
	LT_E_100_325	3.11	1.87	1.65	2.47	1.60	1.48	2.28	2.25	0.31	0.25	0.31	0.29
	LT_E_100_350							2.56	2.50				

*** Usage at Maximum Travel is not recommended as it can compromise the life of the spring.**

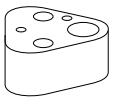
For stripping force selection, see page 11.

Headed Metric / Inch

For True Location™ Retainers

Metric

AT_J_ Regular

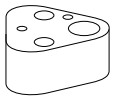


For **ART** & **ARTS** Press Fit metric retainers

AT_E_ Compact – Extended Reach

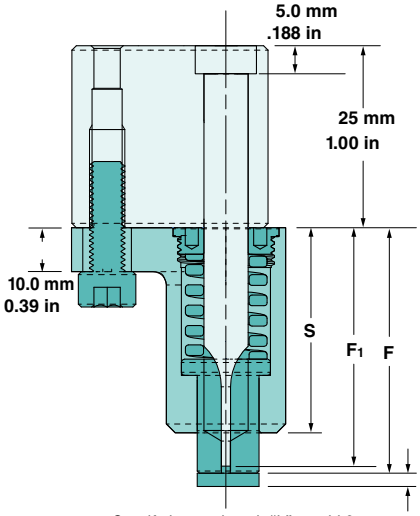
Inch

VT_J_ Regular

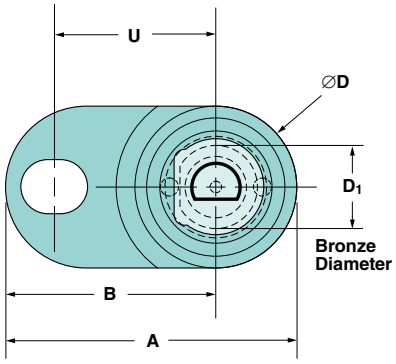


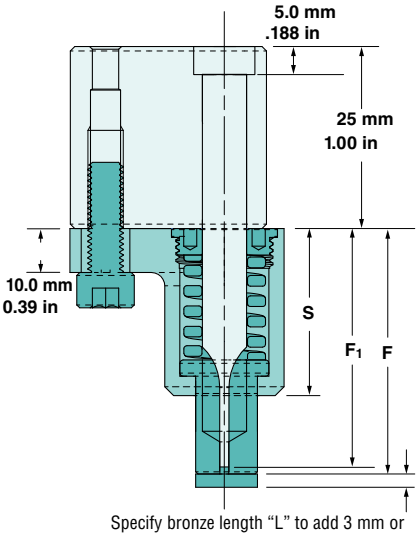
For **VRT** & **VRTS** Versatile inch retainers

VT_E_ Compact – Extended Reach



Specify bronze length "L" to add 3 mm or .118 inch for in-house contour machining.





Specify bronze length "L" to add 3 mm or .118 inch for in-house contour machining.

HOW TO ORDER

Example: ATJJH 16 R90 P=10.5 W=7.3 PS89 90
VTELM 100 L350

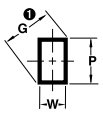
Stripper	Point Shape	Reach	Spring Type	Punch Diameter	Bronze Length	Punch Length	Punch Point Dimensions
AT, VT	C, E, H, J, K, L, N, O, R, V, X, Y, Z	E=Extended J=Regular	S=Extra Light (SSD) L=Light (SLD) M=Medium (SMD) H=Heavy (SHD)	10, 13, 16, 20, 25, 32 mm .37, .50, .62, .75, 1.00, 1.25 in	R=Regular L=3 mm or .118 in Longer C=Custom Contour †	71, 80, 90 mm 3.00, 3.25, 3.50 in	P, W, etc.

†Custom Contour up to 3 mm or .118 inch per submitted CAD file.

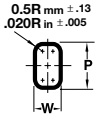
X

O

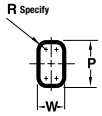
R



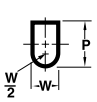
L



K



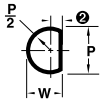
J



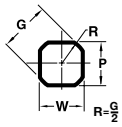
H

N

V



Y



Z

E

(Blank)

C

(Classified Shape Number)

If key flat on punch is at an angle other than 0° standard, specify stripper alteration PS89 with same angle. No additional charge for PS89.

Point larger than shank is not available.

Bronze stripper clearance per side is 0.3 mm / .012 in.

Views are reflected.

Additional shapes available upon request. See punch catalog for complete selection of classified shapes.

Paired retainers and punches are ordered as separate line items.

Headed Metric / Inch

For True Location™ Retainers

Press Fit Metric

Product Code		A	B	D_1	D	U	S	F	F_1	Maximum Spring Travel* Extra Light	Light	Medium	Heavy
Regular	AT_J_10_71	48.5	35.00	15.0	27.00	26.924	37.5	46.65	46.00	9.2	9.2	9.1	6.6
	AT_J_10_80						46.5	55.65	55.00	9.2	9.2	9.1	6.6
	AT_J_10_90						54.5	65.65	65.00	11.2	11.2	11.2	8.9
	AT_J_13_71	54.8	38.10	20.0	33.30	29.972	37.5	46.65	46.00	9.2	9.2	8.7	6.2
	AT_J_13_80						46.5	55.65	55.00	9.2	9.2	8.7	6.2
	AT_J_13_90						54.5	65.65	65.00	11.2	11.2	11.2	8.9
	AT_J_16_71	59.0	38.88	27.0	40.25	31.750	37.5	46.65	46.00	7.8	9.2	8.8	6.8
	AT_J_16_80						46.5	55.65	55.00	7.8	9.2	8.8	6.8
	AT_J_16_90						54.5	65.65	65.00	11.2	11.2	9.3	10.3
	AT_J_20_71	65.0	42.68	33.0	44.65	33.528	37.5	46.65	46.00	9.2	8.8	6.8	6.3
	AT_J_20_80						46.5	55.65	55.00	9.2	8.8	6.8	6.3
	AT_J_20_90						54.5	65.65	65.00	11.2	11.2	11.2	9.8
	AT_J_25_71	76.0	47.62	42.0	56.76	40.640	37.5	46.65	46.00	7.8	6.3	7.8	7.3
	AT_J_25_80						46.5	55.65	55.00	7.8	6.3	7.8	7.3
	AT_J_25_90						54.5	65.65	65.00	11.2	11.2	11.2	8.8
	AT_J_32_71	79.0	47.62	48.0	62.76	40.640	37.5	46.65	46.00	8.3	7.8	8.3	3.8
	AT_J_32_80						46.5	55.65	55.00	8.3	7.8	8.3	3.8
	AT_J_32_90						54.5	65.65	65.00	11.2	11.2	10.8	8.8
Compact - Extended Reach	AT_E_10_80	48.5	35.00	15.0	27.00	26.924	37.5	55.65	55.00	9.8	11.4	9.1	6.6
	AT_E_10_90							65.65	65.00				
	AT_E_13_80	54.8	38.10	20.0	33.30	29.972	37.5	55.65	55.00	10.3	11.1	8.7	6.2
	AT_E_13_90							65.65	65.00				
	AT_E_16_80	59.0	38.88	27.0	40.25	31.750	37.5	55.65	55.00	7.8	9.8	8.8	6.8
	AT_E_16_90							65.65	65.00				
	AT_E_20_80	65.0	42.68	33.0	44.65	33.528	37.5	55.65	55.00	9.8	8.8	6.8	6.3
	AT_E_20_90							65.65	65.00				
	AT_E_25_80	76.0	47.62	42.0	56.76	40.640	37.5	55.65	55.00	7.8	6.3	7.8	7.3
	AT_E_25_90							65.65	65.00				
	AT_E_32_80	79.0	47.62	48.0	62.76	40.640	37.5	55.65	55.00	8.3	7.8	8.3	3.8
	AT_E_32_90							65.65	65.00				

*** Usage at Maximum Travel is not recommended as it can compromise the life of the spring.**

For stripping force selection, see page 10.

Versatile Inch

Product Code		A	B	D_1	D	U	S	F	F_1	Maximum Spring Travel* Extra Light	Light	Medium	Heavy
Regular	VT_J_37_300	1.91	1.38	0.59	1.06	1.06	1.48	2.04	2.00	0.39	0.45	0.36	0.26
	VT_J_37_325						1.83	2.28	2.25	0.39	0.44	0.36	0.26
	VT_J_37_350						2.15	2.56	2.50	0.40	0.40	0.40	0.35
	VT_J_50_300	2.16	1.50	0.79	1.31	1.18	1.48	2.04	2.00	0.41	0.44	0.34	0.24
	VT_J_50_325						1.83	2.28	2.25	0.41	0.44	0.34	0.24
	VT_J_50_350						2.15	2.56	2.50	0.40	0.40	0.40	0.35
	VT_J_62_300	2.32	1.53	1.06	1.58	1.25	1.48	2.04	2.00	0.31	0.39	0.35	0.27
	VT_J_62_325						1.83	2.28	2.25	0.31	0.39	0.35	0.27
	VT_J_62_350						2.15	2.56	2.50	0.40	0.40	0.37	0.41
	VT_J_75_300	2.56	1.68	1.30	1.76	1.32	1.48	2.04	2.00	0.39	0.35	0.27	0.25
	VT_J_75_325						1.83	2.28	2.25	0.39	0.35	0.27	0.25
	VT_J_75_350						2.15	2.56	2.50	0.40	0.40	0.40	0.39
	VT_J_100_300	3.11	1.87	1.65	2.47	1.60	1.48	2.04	2.00	0.31	0.25	0.31	0.29
	VT_J_100_325						1.83	2.28	2.25	0.31	0.25	0.31	0.29
	VT_J_100_350						2.15	2.56	2.50	0.40	0.40	0.40	0.35
	VT_J_125_300	3.48	2.02	2.17	2.91	1.73	1.48	2.04	2.00	0.33	0.31	0.33	0.15
	VT_J_125_325						1.83	2.28	2.25	0.33	0.31	0.33	0.15
	VT_J_125_350						2.15	2.56	2.50	0.40	0.40	0.40	0.35
Compact - Extended Reach	VT_E_37_325	1.91	1.38	0.59	1.06	1.06	1.48	2.28	2.25	0.39	0.45	0.36	0.26
	VT_E_37_350							2.56	2.50				
	VT_E_50_325	2.16	1.50	0.79	1.31	1.18	1.48	2.28	2.25	0.41	0.44	0.34	0.24
	VT_E_50_350							2.56	2.50				
	VT_E_62_325	2.32	1.53	1.06	1.58	1.25	1.48	2.28	2.25	0.31	0.39	0.35	0.27
	VT_E_62_350							2.56	2.50				
	VT_E_75_325	2.56	1.68	1.30	1.76	1.32	1.48	2.28	2.25	0.39	0.35	0.27	0.25
	VT_E_75_350							2.56	2.50				
	VT_E_100_325	3.11	1.87	1.65	2.47	1.60	1.48	2.28	2.25	0.31	0.25	0.31	0.29
	VT_E_100_350							2.56	2.50				
	VT_E_125_325	3.48	2.02	2.17	2.91	1.73	1.48	2.28	2.25	0.33	0.31	0.33	0.15
	VT_E_125_350							2.56	2.50				

*** Usage at Maximum Travel is not recommended as it can compromise the life of the spring.**

For stripping force selection, see page 11.

Metric Spring Stripping Force Selection

For BT_, CT_ & AT_ Stripping Units

Heavy Duty Ball Lock Stripping Units

	Stripper Product Code	Extra Light Duty		Light Duty		Medium Duty		Heavy Duty	
		Spring Code	N @ 3mm	Spring Code	N @ 3mm	Spring Code	N @ 3mm	Spring Code	N @ 3mm
Regular	BT_J_10_80	SSD1025	66.0	SLD1025	168.0	SMD1025	270.6	SHD1025	719.7
	BT_J_10_90	SSD1025	66.0	SLD1025	168.0	SMD1025	270.6	SHD1025	719.7
	BT_J_10_100	SSD1032	54.0	SLD1032	128.1	SMD1032	204.3	SHD1032	541.2
	BT_J_13_80	SSD1325	96.0	SLD1325	285.0	SMD1325	465.0	SHD1325	1050.0
	BT_J_13_90	SSD1325	96.0	SLD1325	285.0	SMD1325	465.0	SHD1325	1050.0
	BT_J_13_100	SSD1332	75.0	SLD1332	210.0	SMD1332	375.0	SHD1332	780.0
	BT_J_16_80	SSD1625	150.0	SLD1625	325.9	SMD1625	555.3	SHD1625	1128.0
	BT_J_16_90	SSD1625	150.0	SLD1625	325.9	SMD1625	555.3	SHD1625	1128.0
	BT_J_16_100	SSD1632	120.0	SLD1632	280.8	SMD1632	630.0	SHD1632	840.0
	BT_J_20_80	SSD2025	285.0	SLD2025	570.0	SMD2025	720.0	SHD2025	1050.0
	BT_J_20_90	SSD2025	285.0	SLD2025	570.0	SMD2025	720.0	SHD2025	1050.0
	BT_J_20_100	SSD2032	192.5	SLD2032	409.9	SMD2032	570.0	SHD2032	1035.1
	BT_J_25_80	SSD2525	345.0	SLD2525	660.0	SMD2525	780.0	SHD2525	1530.0
	BT_J_25_90	SSD2525	345.0	SLD2525	660.0	SMD2525	780.0	SHD2525	1530.0
	BT_J_25_100	SSD2532	225.0	SLD2532	540.0	SMD2532	585.0	SHD2532	1050.0
	BT_J_32_80	SSD3225	270.0	SLD3225	546.0	SMD3225	711.0	SHD3225	1440.0
	BT_J_32_90	SSD3225	270.0	SLD3225	546.0	SMD3225	711.0	SHD3225	1440.0
	BT_J_32_100	SSD3232	240.0	SLD3232	519.0	SMD3232	960.0	SHD3232	1095.0
	BT_J_40_80	SSD4025	369.0	SLD4025	582.0	SMD4025	960.0	SHD4025	1575.0
	BT_J_40_90	SSD4025	369.0	SLD4025	582.0	SMD4025	960.0	SHD4025	1575.0
	BT_J_40_100	SSD4032	288.0	SLD4032	516.0	SMD4032	837.0	SHD4032	1395.0
Compact - Extended Reach	BT_E_10_90	SSD1025	66.0	SLD1025	168.0	SMD1025	270.6	SHD1025	719.7
	BT_E_10_100								
	BT_E_13_90	SSD1325	96.0	SLD1325	285.0	SMD1325	465.0	SHD1325	1050.0
	BT_E_13_100								
	BT_E_16_90	SSD1625	150.0	SLD1625	325.9	SMD1625	555.3	SHD1625	1128.0
	BT_E_16_100								
	BT_E_20_90	SSD2025	285.0	SLD2025	570.0	SMD2025	720.0	SHD2025	1050.0
	BT_E_20_100								
	BT_E_25_90	SSD2525	345.0	SLD2525	660.0	SMD2525	780.0	SHD2525	1530.0
	BT_E_25_100								
	BT_E_32_90	SSD3225	270.0	SLD3225	546.0	SMD3225	711.0	SHD3225	1440.0
	BT_E_32_100								
	BT_E_40_90	SSD4025	369.0	SLD4025	582.0	SMD4025	960.0	SHD4025	1575.0
	BT_E_40_100								

Light Duty Ball Lock & Press Fit Headed Stripping Units

	Stripper Product Code	Extra Light Duty		Light Duty		Medium Duty		Heavy Duty	
		Spring Code	N @ 3mm	Spring Code	N @ 3mm	Spring Code	N @ 3mm	Spring Code	N @ 3mm
Regular	CT_J_/AT_J_10_71	SSD1025	66.0	SLD1025	168.0	SMD1025	270.6	SHD1025	719.7
	CT_J_/AT_J_10_80	SSD1025	66.0	SLD1025	168.0	SMD1025	270.6	SHD1025	719.7
	CT_J_/AT_J_10_90	SSD1032	54.0	SLD1032	128.1	SMD1032	204.3	SHD1032	541.2
	CT_J_/AT_J_13_71	SSD1325	96.0	SLD1325	285.0	SMD1325	465.0	SHD1325	1050.0
	CT_J_/AT_J_13_80	SSD1325	96.0	SLD1325	285.0	SMD1325	465.0	SHD1325	1050.0
	CT_J_/AT_J_13_90	SSD1332	75.0	SLD1332	210.0	SMD1332	375.0	SHD1332	780.0
	CT_J_/AT_J_16_71	SSD1625	150.0	SLD1625	325.9	SMD1625	555.3	SHD1625	1128.0
	CT_J_/AT_J_16_80	SSD1625	150.0	SLD1625	325.9	SMD1625	555.3	SHD1625	1128.0
	CT_J_/AT_J_16_90	SSD1632	120.0	SLD1632	280.8	SMD1632	630.0	SHD1632	840.0
	CT_J_/AT_J_20_71	SSD2025	285.0	SLD2025	570.0	SMD2025	720.0	SHD2025	1050.0
	CT_J_/AT_J_20_80	SSD2025	285.0	SLD2025	570.0	SMD2025	720.0	SHD2025	1050.0
	CT_J_/AT_J_20_90	SSD2032	192.5	SLD2032	409.9	SMD2032	570.0	SHD2032	1035.1
	CT_J_/AT_J_25_71	SSD2525	345.0	SLD2525	660.0	SMD2525	780.0	SHD2525	1530.0
	CT_J_/AT_J_25_80	SSD2525	345.0	SLD2525	660.0	SMD2525	780.0	SHD2525	1530.0
	CT_J_/AT_J_25_90	SSD2532	225.0	SLD2532	540.0	SMD2532	585.0	SHD2532	1050.0
	CT_J_/AT_J_32_71	SSD3225	270.0	SLD3225	546.0	SMD3225	711.0	SHD3225	1440.0
	CT_J_/AT_J_32_80	SSD3225	270.0	SLD3225	546.0	SMD3225	711.0	SHD3225	1440.0
	CT_J_/AT_J_32_90	SSD3232	240.0	SLD3232	519.0	SMD3232	960.0	SHD3232	1095.0
Compact - Extended Reach	CT_E_/AT_E_10_80	SSD1025	66.0	SLD1025	168.0	SMD1025	270.6	SHD1025	719.7
	CT_E_/AT_E_10_90								
	CT_E_/AT_E_13_80	SSD1325	96.0	SLD1325	285.0	SMD1325	465.0	SHD1325	1050.0
	CT_E_/AT_E_13_90								
	CT_E_/AT_E_16_80	SSD1625	150.0	SLD1625	325.9	SMD1625	555.3	SHD1625	1128.0
	CT_E_/AT_E_16_90								
	CT_E_/AT_E_20_80	SSD2025	285.0	SLD2025	570.0	SMD2025	720.0	SHD2025	1050.0
	CT_E_/AT_E_20_90								
	CT_E_/AT_E_25_80	SSD2525	345.0	SLD2525	660.0	SMD2525	780.0	SHD2525	1530.0
	CT_E_/AT_E_25_90								
	CT_E_/AT_E_32_80	SSD3225	270.0	SLD3225	546.0	SMD3225	711.0	SHD3225	1440.0
	CT_E_/AT_E_32_90								

Inch Spring Stripping Force Selection

For HT_, LT_ & VT_ Stripping Units

Heavy Duty Ball Lock Stripping Units

	Stripper Product Code	Extra Light Duty		Light Duty		Medium Duty		Heavy Duty	
		Spring Code	lbf / 0.12 in	Spring Code	lbf / 0.12 in	Spring Code	lbf / 0.12 in	Spring Code	lbf / 0.12 in
Regular	HT_J_37_325	SSD1025	14.84	SLD1025	31.98	SMD1025	51.51	SHD1025	136.99
	HT_J_37_350	SSD1025	14.84	SLD1025	31.98	SMD1025	51.51	SHD1025	136.99
	HT_J_37_400	SSD1032	12.14	SLD1032	24.38	SMD1032	38.89	SHD1032	103.01
	HT_J_50_325	SSD1325	21.57	SLD1325	54.25	SMD1325	88.51	SHD1325	199.86
	HT_J_50_350	SSD1325	21.57	SLD1325	54.25	SMD1325	88.51	SHD1325	199.86
	HT_J_50_400	SSD1332	16.86	SLD1332	39.97	SMD1332	71.38	SHD1332	148.46
	HT_J_62_325	SSD1625	33.72	SLD1625	62.02	SMD1625	105.70	SHD1625	214.70
	HT_J_62_350	SSD1625	33.72	SLD1625	62.02	SMD1625	105.70	SHD1625	214.70
	HT_J_62_400	SSD1632	26.98	SLD1632	53.44	SMD1632	119.91	SHD1632	159.88
	HT_J_75_325	SSD2025	64.07	SLD2025	108.49	SMD2025	137.04	SHD2025	199.86
	HT_J_75_350	SSD2025	64.07	SLD2025	108.49	SMD2025	137.04	SHD2025	199.86
	HT_J_75_400	SSD2032	43.28	SLD2032	78.03	SMD2032	108.49	SHD2032	197.02
	HT_J_87_325	SSD87100	47.21	SLD87100	91.93	SMD87100	138.76	SHD87100	239.83
	HT_J_87_350	SSD87100	47.21	SLD87100	91.93	SMD87100	138.76	SHD87100	239.83
	HT_J_87_400	SSD87125	44.51	SLD87125	77.09	SMD87125	95.93	SHD87125	179.87
	HT_J_100_325	SSD2525	77.56	SLD2525	125.62	SMD2525	148.46	SHD2525	291.22
	HT_J_100_350	SSD2525	77.56	SLD2525	125.62	SMD2525	148.46	SHD2525	291.22
	HT_J_100_400	SSD2532	50.58	SLD2532	102.78	SMD2532	111.35	SHD2532	199.86
	HT_J_125_325	SSD3225	60.70	SLD3225	103.92	SMD3225	135.33	SHD3225	274.09
	HT_J_125_350	SSD3225	60.70	SLD3225	103.92	SMD3225	135.33	SHD3225	274.09
	HT_J_125_400	SSD3232	53.95	SLD3232	98.79	SMD3232	182.72	SHD3232	208.42
Compact - Extended Reach	HT_E_37_350	SSD1025	14.84	SLD1025	31.98	SMD1025	51.51	SHD1025	136.99
	HT_E_37_400								
	HT_E_50_350	SSD1325	21.57	SLD1325	54.25	SMD1325	88.51	SHD1325	199.86
	HT_E_50_400								
	HT_E_62_350	SSD1625	33.72	SLD1625	62.02	SMD1625	105.70	SHD1625	214.70
	HT_E_62_400								
	HT_E_75_350	SSD2025	64.07	SLD2025	108.49	SMD2025	137.04	SHD2025	199.86
	HT_E_75_400								
	HT_E_87_350	SSD87100	47.21	SLD87100	91.93	SMD87100	138.76	SHD87100	239.83
	HT_E_87_400								
	HT_E_100_350	SSD2525	77.56	SLD2525	125.62	SMD2525	148.46	SHD2525	291.22
	HT_E_100_400								
	HT_E_125_350	SSD3225	60.70	SLD3225	103.92	SMD3225	135.33	SHD3225	274.09
	HT_E_125_400								

Light Duty Ball Lock & Versatile Headed Stripping Units

	Stripper Product Code	Extra Light Duty		Light Duty		Medium Duty		Heavy Duty	
		Spring Code	lbf / 0.12 in	Spring Code	lbf / 0.12 in	Spring Code	lbf / 0.12 in	Spring Code	lbf / 0.12 in
Regular	LT_J_/VT_J_37_300	SSD1025	14.84	SLD1025	31.98	SMD1025	51.51	SHD1025	136.99
	LT_J_/VT_J_37_325	SSD1025	14.84	SLD1025	31.98	SMD1025	51.51	SHD1025	136.99
	LT_J_/VT_J_37_350	SSD1032	12.14	SLD1032	24.38	SMD1032	38.89	SHD1032	103.01
	LT_J_/VT_J_50_300	SSD1325	21.57	SLD1325	54.25	SMD1325	88.51	SHD1325	199.86
	LT_J_/VT_J_50_325	SSD1325	21.57	SLD1325	54.25	SMD1325	88.51	SHD1325	199.86
	LT_J_/VT_J_50_350	SSD1332	16.86	SLD1332	39.97	SMD1332	71.38	SHD1332	148.46
	LT_J_/VT_J_62_300	SSD1625	33.72	SLD1625	62.02	SMD1625	105.70	SHD1625	214.70
	LT_J_/VT_J_62_325	SSD1625	33.72	SLD1625	62.02	SMD1625	105.70	SHD1625	214.70
	LT_J_/VT_J_62_350	SSD1632	26.98	SLD1632	53.44	SMD1632	119.91	SHD1632	159.88
	LT_J_/VT_J_75_300	SSD2025	64.07	SLD2025	108.49	SMD2025	137.04	SHD2025	199.86
	LT_J_/VT_J_75_325	SSD2025	64.07	SLD2025	108.49	SMD2025	137.04	SHD2025	199.86
	LT_J_/VT_J_75_350	SSD2032	43.28	SLD2032	78.03	SMD2032	108.49	SHD2032	197.02
	LT_J_87_300	SSD87100	47.21	SLD87100	91.93	SMD87100	138.76	SHD87100	239.83
	LT_J_87_325	SSD87100	47.21	SLD87100	91.93	SMD87100	138.76	SHD87100	239.83
	LT_J_87_350	SSD87125	44.51	SLD87125	77.09	SMD87125	95.93	SHD87125	179.87
	LT_J_/VT_J_100_300	SSD2525	77.56	SLD2525	125.62	SMD2525	148.46	SHD2525	291.22
	LT_J_/VT_J_100_325	SSD2525	77.56	SLD2525	125.62	SMD2525	148.46	SHD2525	291.22
	LT_J_/VT_J_100_350	SSD2532	50.58	SLD2532	102.78	SMD2532	111.35	SHD2532	199.86
	LT_J_/VT_J_125_300	SSD3225	60.70	SLD3225	103.92	SMD3225	135.33	SHD3225	274.09
	LT_J_/VT_J_125_325	SSD3225	60.70	SLD3225	103.92	SMD3225	135.33	SHD3225	274.09
	LT_J_/VT_J_125_350	SSD3232	53.95	SLD3232	98.79	SMD3232	182.72	SHD3232	208.42
Compact - Extended Reach	LT_E_/VT_E_37_325	SSD1025	14.84	SLD1025	31.98	SMD1025	51.51	SHD1025	136.99
	LT_E_/VT_E_37_350								
	LT_E_/VT_E_50_325	SSD1325	21.57	SLD1325	54.25	SMD1325	88.51	SHD1325	199.86
	LT_E_/VT_E_50_350								
	LT_E_/VT_E_62_325	SSD1625	33.72	SLD1625	62.02	SMD1625	105.70	SHD1625	214.70
	LT_E_/VT_E_62_350								
	LT_E_/VT_E_75_325	SSD2025	64.07	SLD2025	108.49	SMD2025	137.04	SHD2025	199.86
	LT_E_/VT_E_75_350								
	LT_E_87_325	SSD87100	47.21	SLD87100	91.93	SMD87100	138.76	SHD87100	239.83
	LT_E_87_350								
	LT_E_/VT_E_100_325	SSD2525	77.56	SLD2525	125.62	SMD2525	148.46	SHD2525	291.22
	LT_E_/VT_E_100_350								
	LT_E_/VT_E_125_325	SSD3225	60.70	SLD3225	103.92	SMD3225	135.33	SHD3225	274.09
	LT_E_/VT_E_125_350								

Commitment to Quality & Customer Satisfaction

Dayton Lamina is a leading manufacturer of tool, die and mold components for the metal-working and plastics industries. As a customer-focused, world-class supplier of choice, we provide the brands, product breadth, distribution network and technical support for all your metal forming needs.

Our goal is to give our customers the most innovative and value-added products and services.

DAYTON Lamina™

a MISUMI Group Company

DAYTON · DANLY · IEM · Lamina · LEMPCO

*Dayton Lamina's line of Danly products is available only to North America.

www.daytonlamina.com

© 2015 Dayton Lamina Corporation. All rights reserved.