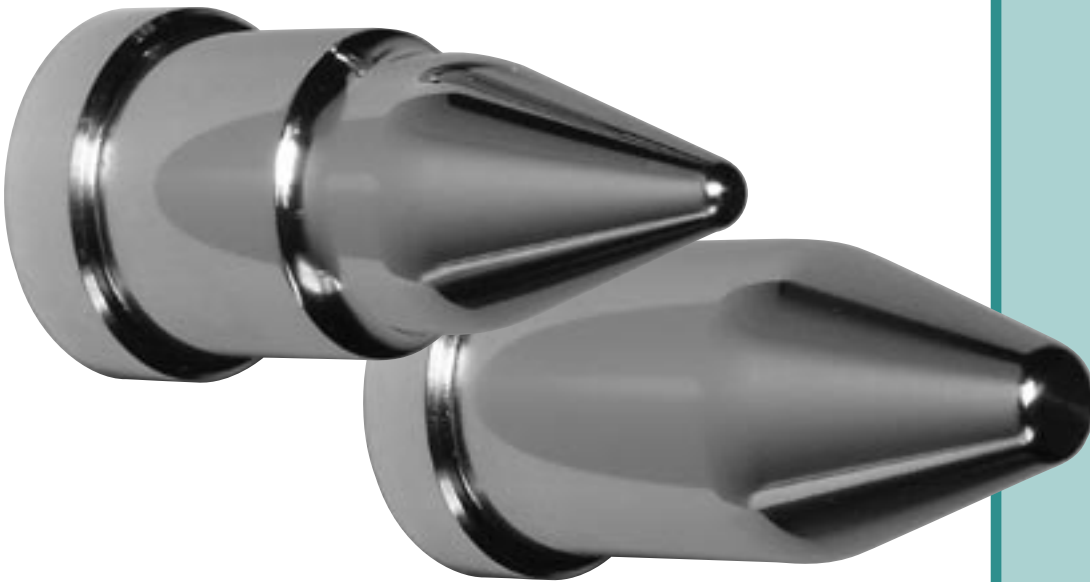


# Compact Positive Pick-Up Pilots

VERSATILE — Inch & Metric



Dayton Versatile Compact Positive Pick-Up Pilots—mounted in a guided stripper—provide exceptional resistance to lateral deflection. A typical *longer* pilot can have several inches of exposed, unsupported surface and be susceptible to added sideways movement, stress, and wear. Dayton Compact Pilots are rigid during use; last longer; and are ideally suited for high-demand manufacturing applications.

## Stronger! Not Longer

*Rigid,  
Long-Lasting*  
Positive Pick-Up  
Pilots

# Compacts



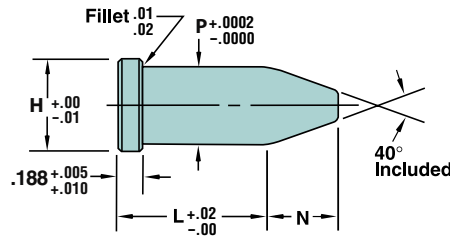
Global leader in  
providing fabrication  
and stamping solutions

[www.daytonprogress.com](http://www.daytonprogress.com)

Type	Head H	Range P	N	*Overall Length L						
				.625	.750	.875	1.00	1.125	1.250	1.375
VUAC Straight	.375	.1865 - .2500	.25	62	75	87	100	112	125	137
	.438	.2501 - .3130	.31							
	.500	.3131 - .3750	.37							
	.562	.3751 - .4380	.43							
	.625	.4381 - .5000	.50							
	.750	.5001 - .6250	.62							
	.875	.6251 - .7500	.75							
	1.000	.7501 - .8750	.87							
	1.125	.8751 - 1.0000	1.00							

\*Any overall length is available within catalog range. Specify "XL" and length.

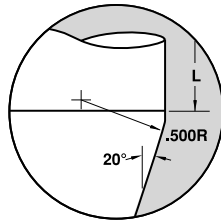
**VUAC**  
Straight



**VUAC and VPAC**

**Material**

Steel: A2, M2, RC 60-63, PS, RC 63-65



**Surface Coatings**

Code / Added Delivery		Material
XNT —DayTiN®	+ 2 days	M2, PS
XCN —TiCN	+ 2 days	M2, PS
XAN —DayTAN® (TiAIN)	+ 4 days	M2, PS

**HOW TO ORDER**

Specify:	Qty.	Type	D Code	L	P Dimension	Alt.	Steel
Example:	25	VUAC	—	75	.4380	XL.695	A2
	11	VPAC	62	100	.5500	—	A2



# Designer's Choice

In specifying die set components, designers have typically chosen so-called "standard" length pilots for most high-demand applications. In recent years, however, they have begun specifying shorter length pilots—especially in larger die set configurations. Longer pilots have two or more inches of unsupported surface that is susceptible to deflection. As bending or forming takes place, this lateral deflection can create excessive forces on the pilot. Often, the strength of the pilot—as well as the function of the other die set components—is compromised.

# Dayton Compact Pilots

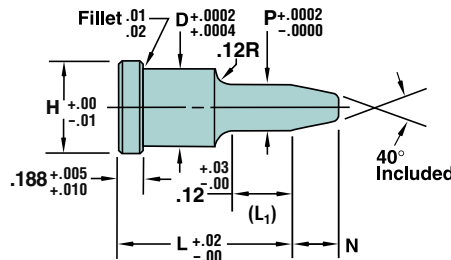
Dayton Compact Pilots provide virtually no unsupported surface that is susceptible to sideways movement, stress, or wear. Pilots—which are mounted in a guided stripper—always maintain the proper extension, and there is no need to move or adjust the pilot during regrinding.

Type	Shank D	Code	Head H	Min. XP	Range P	Max. N	*Overall Length L						
							.625	.750	.875	1.00	1.125	1.250	1.375
VPAC Pointed	.2500	25	.375	.092	.1500 - .2499	.25	62	75	87	100	112	125	137
	.3125	31	.438	.092	.1870 - .3124	.31							
	.3750	37	.500	.092	.2250 - .3749	.37							
	.4375	43	.562	.092	.2650 - .4374	.43							
	.5000	50	.625	.124	.3000 - .4999	.50							
	.6250	62	.750	.234	.3750 - .6249	.62							
	.7500	75	.875	.299	.4500 - .7499	.75							
	.8750	87	1.000	.349	.5250 - .8749	.87							
	1.0000	100	1.125	.399	.6000 - .9999	1.00							

$N = .132 + [(P - .057) / .728]$

\* Any overall length is available within catalog range. Specify "XL" and length. The point length is maintained. For other than standard point length use alteration code "XBR" (0.060 min.)

**VPAC**  
Pointed



P to D .0003



# Surface Coatings

Dayton Compact Pilots can be treated to increase hardness, improve wear, etc. The available coatings and added delivery times are shown in the charts on the appropriate product pages.

**DayTiN® (XNT)**—a hard-as-carbide (Vickers 2300) PVD coating that provides excellent lubricity when used with a lubricant.

**TiCN (XCN)**—a harder-than-carbide (Vickers 3000), very thin PVD film that provides superior hardness and extraordinary abrasive wear resistance.

**DayTAN® (TiAlN)**—an ultra-hard (Vickers 3400), high-aluminum PVD coating that absorbs shear stress and provides high-temperature toughness.

## Standard Alterations

The following are standard alterations available on all Dayton Compact Pilots:

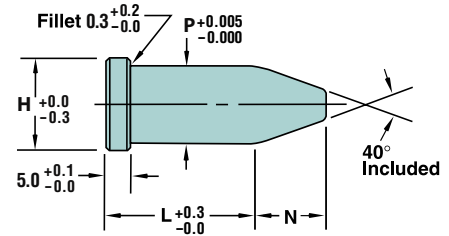
- XP**— P dimension smaller than standard
- XBR**—  $L_1$  other than standard
- XL**— Overall length shorter
- XT**— Thinner head than standard
- TT**— Precision head thickness
- XH**— Reduced head diameter
- XD**— Reduced shank diameter



Type	Head H	Range P	N	*Overall Length L						
				16	20	22	25	28	32	35
DUAC Straight	7	3.00 - 4.00	4	●	●	●	●	●	●	●
	8	4.01 - 5.00	5	●	●	●	●	●	●	●
	9	5.01 - 6.00	6	●	●	●	●	●	●	●
	11	6.01 - 8.00	7	●	●	●	●	●	●	●
	13	8.01 - 10.00	8	●	●	●	●	●	●	●
	16	10.01 - 13.00	10	●	●	●	●	●	●	●
	19	13.01 - 16.00	15	●	●	●	●	●	●	●
23	16.01 - 20.00	20	●	●	●	●	●	●	●	

\*Any overall length is available within catalog range. Specify "XL" and length.

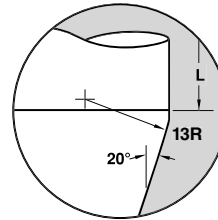
### DUAC Straight



### DUAC and DPAC

#### Material

Steel: A2, M2, RC 60-63, PS, RC 63-65



### Surface Coatings

Code / Added Delivery	Material
XNT —DayTiN® + 2 days	M2, PS
XCN —TiCN + 2 days	M2, PS
XAN —DayTAN® (TiAlN) + 4 days	M2, PS

#### HOW TO ORDER

Specify:	Qty.	Type	D Code	L	P Dimension	Alt.	Steel
Example:	10	DUAC	—	22	7.50	A2	
	25	DPAC	16	35	11.60	XL33.5	A2

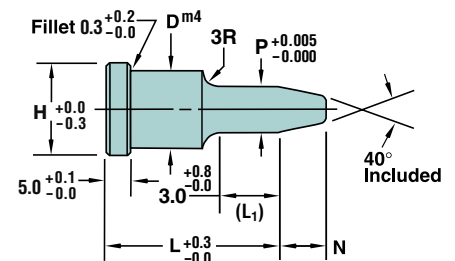


Type	Shank D	Code	Head H	Min. XP	Range P	Max. N	*Overall Length L						
							16	20	22	25	28	32	35
DPAC Pointed	4.0	04	7	1.55	1.95 - 3.99	6	●	●	●	●	●	●	
	5.0	05	8	1.55	2.65 - 4.99	7	●	●	●	●	●	●	
	6.0	06	9	2.10	3.40 - 5.99	6	●	●	●	●	●	●	
	8.0	08	11	2.10	4.10 - 7.99	7	●	●	●	●	●	●	
	10.0	10	13	2.10	4.85 - 9.99	8	●	●	●	●	●	●	
	13.0	13	16	3.15	6.30 - 12.99	10	●	●	●	●	●	●	
	16.0	16	19	5.95	9.95 - 15.99	15	●	●	●	●	●	●	
	20.0	20	23	5.95	13.60 - 19.99	20	●	●	●	●	●	●	
	25.0	25	28	7.95	17.25 - 24.99	25	●	●	●	●	●	●	
	32.0	32	35	9.95	20.85 - 31.99	30	●	●	●	●	●	●	

$$N = 3.35 + [(P - 1.45) / 1.728]$$

\* Any overall length is available within catalog range. Specify "XL" and length. The point length is maintained. For other than standard point length use alteration code "XBR" (1.5 min.)

### DPAC Pointed



P to D 0.008

DAYTON PROGRESS CORPORATION

500 Progress Road  
P.O. Box 39  
Dayton, Ohio 45449-0039 USA  
Telephone: (937) 859-5111  
Fax: (937) 859-5353

Dayton Progress Canada, Ltd.  
861 Rowntree Dairy Road  
Woodbridge, Ontario L4L 5W3  
Telephone: (905) 264-2445  
Fax: (905) 264-1071

Dayton Progress Ltd.  
G1 Holly Farm Business Park  
Honiley, Kenilworth  
Warwickshire CV8 1NP UK  
Telephone: 44 1 926 484192  
Fax: 44 1 926 484172

Dayton Progress Corporation of Japan  
2-7-35 Hashimotodai  
Sagamihara-Shi, Kanagawa-Ken  
229-1132 Japan  
Telephone: 81 427 74 0821  
Fax: 81 427 73 4955

Dayton Progress GmbH  
Im Heidegraben 8  
Postfach 1165  
61401 Oberursel/Ts., Germany  
Telephone: 49 61 71 924201  
Fax: 49 61 71 924220

Dayton Progress SAS  
105 Avenue de l'Épinette  
BP 128  
Zone Industrielle  
77107 Meaux Cedex  
France  
Telephone: 33 1 60 247301  
Fax: 33 1 60 247300



Global leader in providing fabrication and stamping solutions