Posi-Loc™ True Position® Retainers *with & without* Backing Plates

Dayton's Posi-Loc™ Positive Locking Mechanism is designed to eliminate "ball bouncing" in retainers. Bouncing can occur in ball lock retainers because of the impact generated from the new high strength steels—even when heavy-duty springs are used. The bounce typically does not affect the stamping operation at normal levels. However, in high-demand punching—especially when high strength, lighter weight steels are used—bouncing can have a negative effect on punching accuracy and tool life. The Dayton Posi-Loc™ locking feature is a modification to existing Dayton True Position® Retainers. It prevents the bounce with the help of an adjustable angled setscrew to create a positive lock against the punch by "locking" the retainer ball in position. Dayton Ball Lock Retainers with the Posi-Loc™ feature also allow punch replacement without disassembly of the die, thus making tool changeover quick and easy.

Posi-Loc™ True Position® retainers guarantee true dimensional accuracy.

Single Punch Retainers (Inch and Metric)

Posi-Loc™ BALL LOCK Retainers

DAYTON®

Global leader in quality metal fabrication and stamping tools

a MiSUMi Group Company

www.daytonprogress.com

Backing Plugs

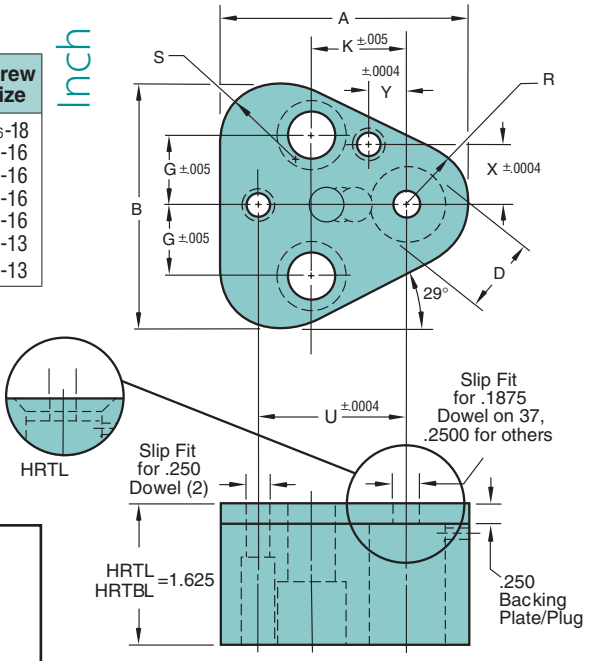
The hardened backing plug acts as a head on the punch much like press fit punches, but actually produces more support for the load than a press fit punch of the same size. The backing plug is precision ground with the in-line dowel accurately located on the centerline of the punch.

Backing Plates

The hardened backing plate has the same function as the backing plug. That is to prevent the punch from sinking into the upper die on impact. Backing plates spread the load over a larger area for very demanding applications where extreme pressures are being exerted and you are looking for extra insurance to minimize sinking into the upper die.

Inch

Back Plug	Back Plate	Code	D	A	B	G	K	R	S	U	X	Y	Screw Size
HRTL	HRTBL	37	.3750	1.75	1.72	.438	.750	.38	.47	1.060	.354	.295	5/16-18
HRTL	HRTBL	50	.5000	2.00	1.97	.562	.750	.50	.60	1.180	.472	.256	3/8-16
HRTL	HRTBL	62	.6250	2.12	2.09	.625	.750	.56	.66	1.250	.532	.236	3/8-16
HRTL	HRTBL	75	.7500	2.38	2.34	.688	.750	.69	.79	1.320	.650	.197	3/8-16
HRTL	HRTBL	87	.8750	2.50	2.47	.688	.750	.75	.85	1.400	.728	.197	3/8-16
HRTL	HRTBL	100	1.0000	2.75	2.72	.781	.938	.88	.97	1.600	.866	.276	1/2-13
HRTL	HRTBL	125	1.2500	2.75	2.72	.781	.938	.88	.97	1.600	.866	.276	1/2-13



HOW TO ORDER

Specify:	Qty.	Code	D
Example:	23	HRTBL	37
	13	BRTL	25

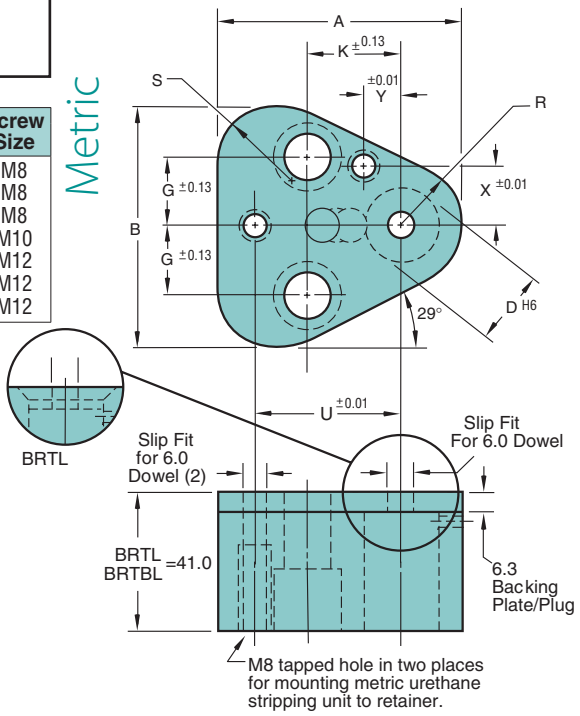
Retainer sets include:

- Ball
- Spring
- Screws
- Dowels
- Ball Release Set Screw
- Posi-Loc Screw

Metric

Back Plug	Back Plate	Code	D	A	B	G	K	R	S	U	X	Y	Screw Size
BRTL	BRTBL	10	10.00	44.5	43.7	11.1	19.0	9.5	12.0	26.925	9.0	7.5	M8
BRTL	BRTBL	13	13.00	50.8	50.0	14.3	19.0	12.7	15.2	29.970	12.0	6.5	M8
BRTL	BRTBL	16	16.00	54.0	53.2	15.9	19.0	14.3	16.8	31.750	13.5	6.0	M8
BRTL	BRTBL	20	20.00	60.3	59.5	17.5	19.0	17.5	20.0	33.530	16.5	5.0	M10
BRTL	BRTBL	25	25.00	69.9	69.1	19.8	23.8	22.2	24.7	40.640	22.0	7.0	M12
BRTL	BRTBL	32	32.00	69.9	69.1	19.8	23.8	22.2	24.7	40.640	22.0	7.0	M12
BRTL	BRTBL	40	40.00	77.4	76.6	24.0	27.0	26.0	28.5	43.993	26.0	10.0	M12

BRTBL conforms to the NAAMS™ Standard for Ball Lock Punch Retainers.



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