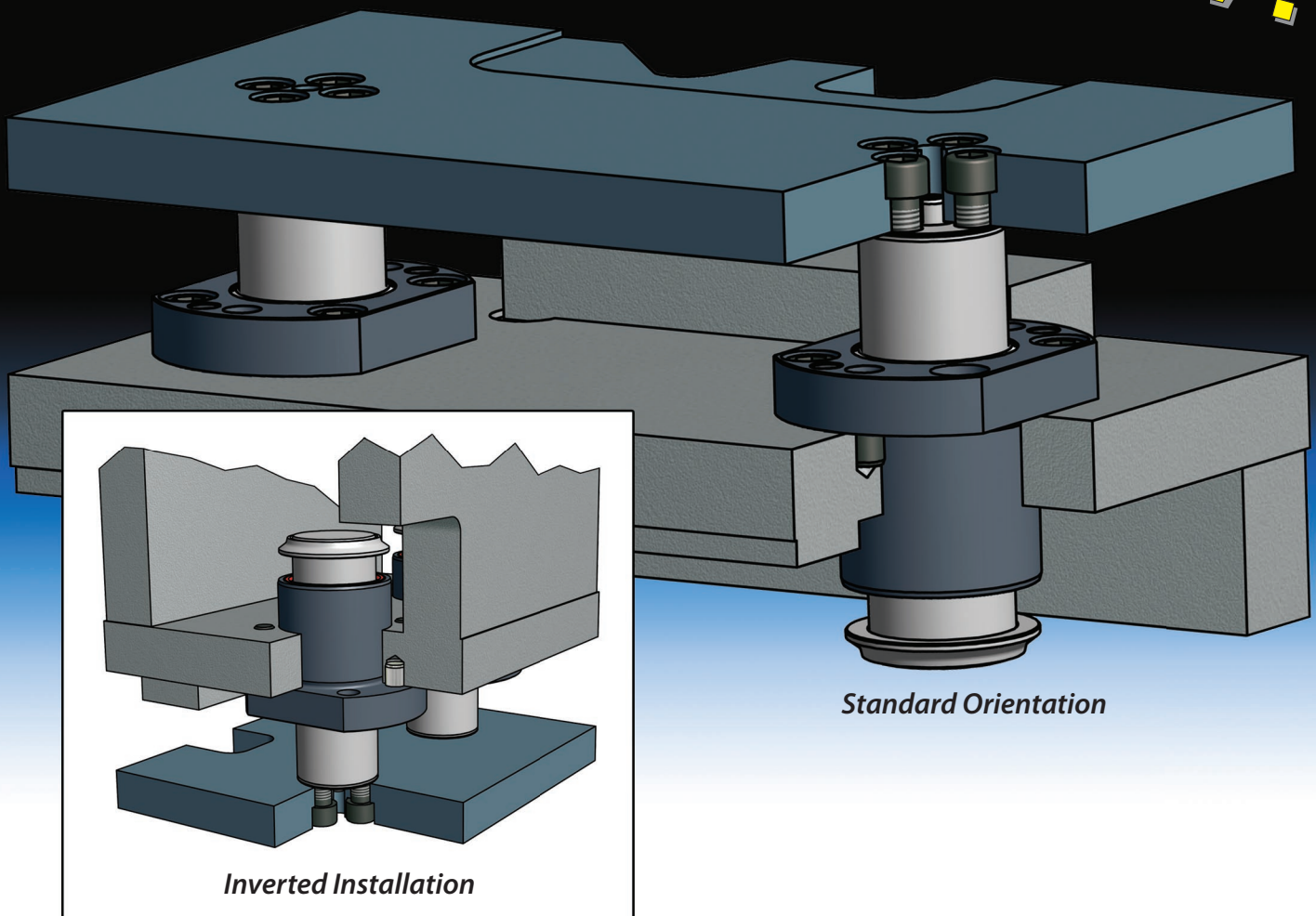


DADCO®

Guide Retainer Sets

GRS Series

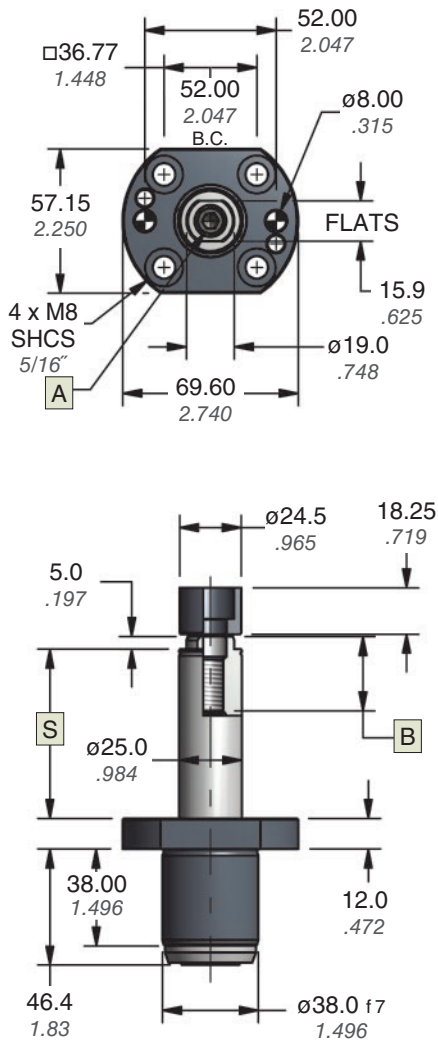
NEW!



Combined Guidance and Retention

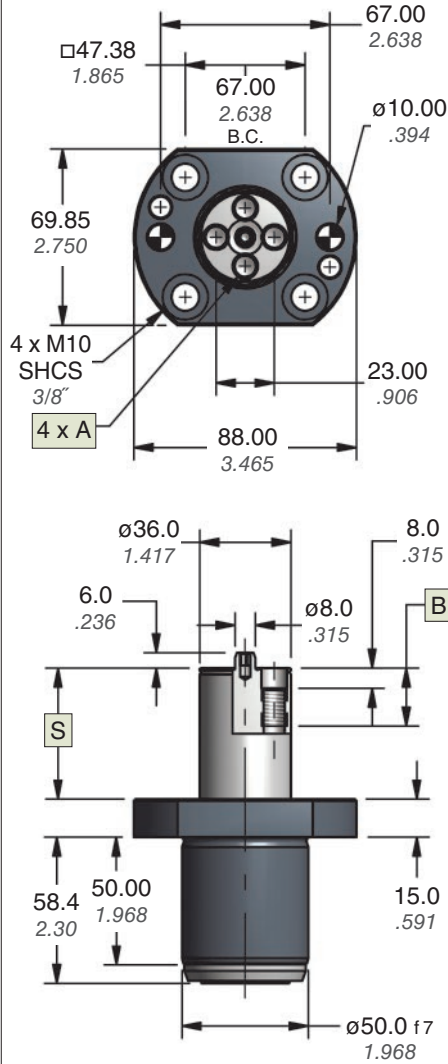
- Cost savings over common pins, bushings and spools
- Three rod diameters: 25 mm, 36 mm and 50 mm
- Robust one-piece housing with top and bottom wipers
- Various stroke lengths to suit application requirements

GRS.25



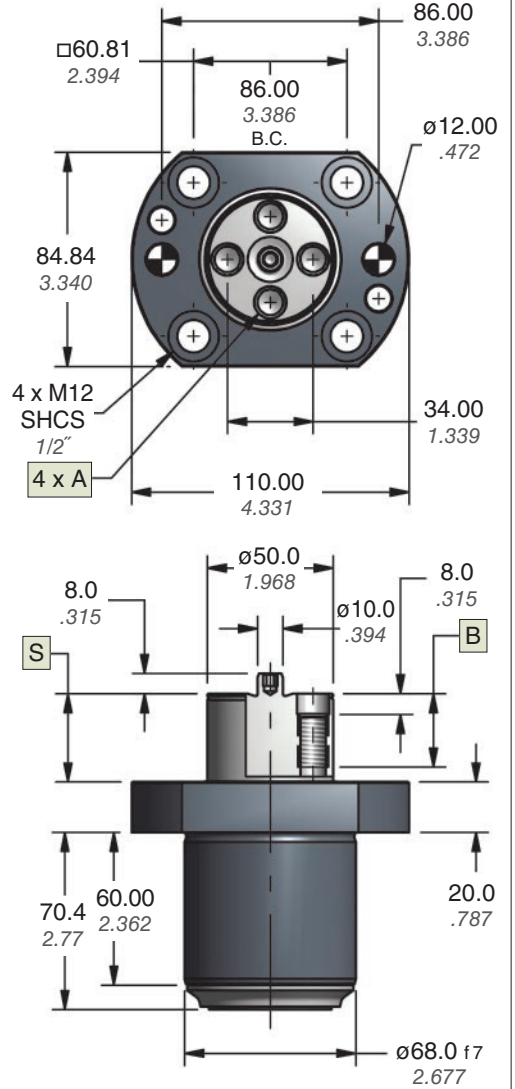
Guide Pin	A Thread	B Depth
M	M12	29
E	1/2"-13	1.14"

GRS.36



Guide Pin	A Thread	B Depth
M	M10	23
E	3/8"-16	.91"

GRS.50



Guide Pin	A Thread	B Depth
M	M12	29
E	1/2"-13	1.14"

Ordering Example:

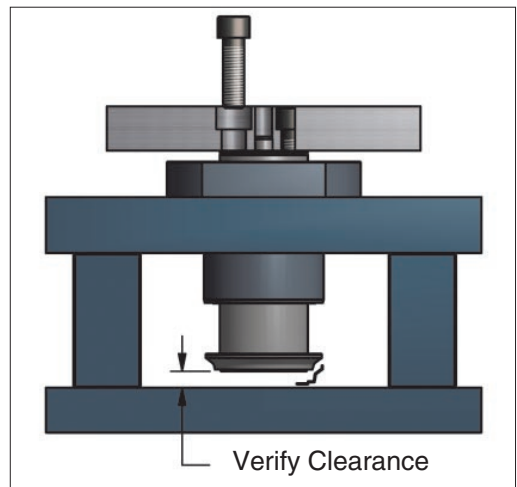
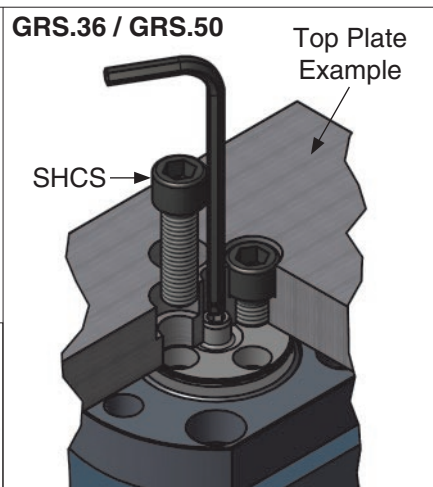
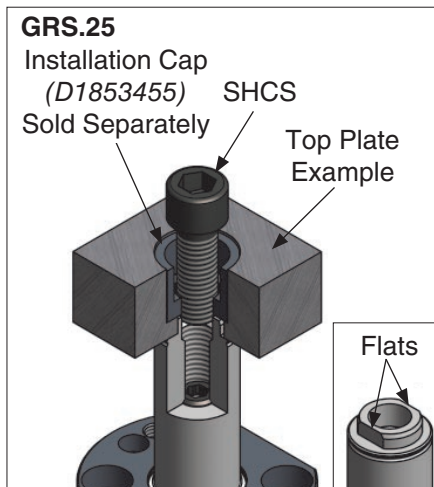
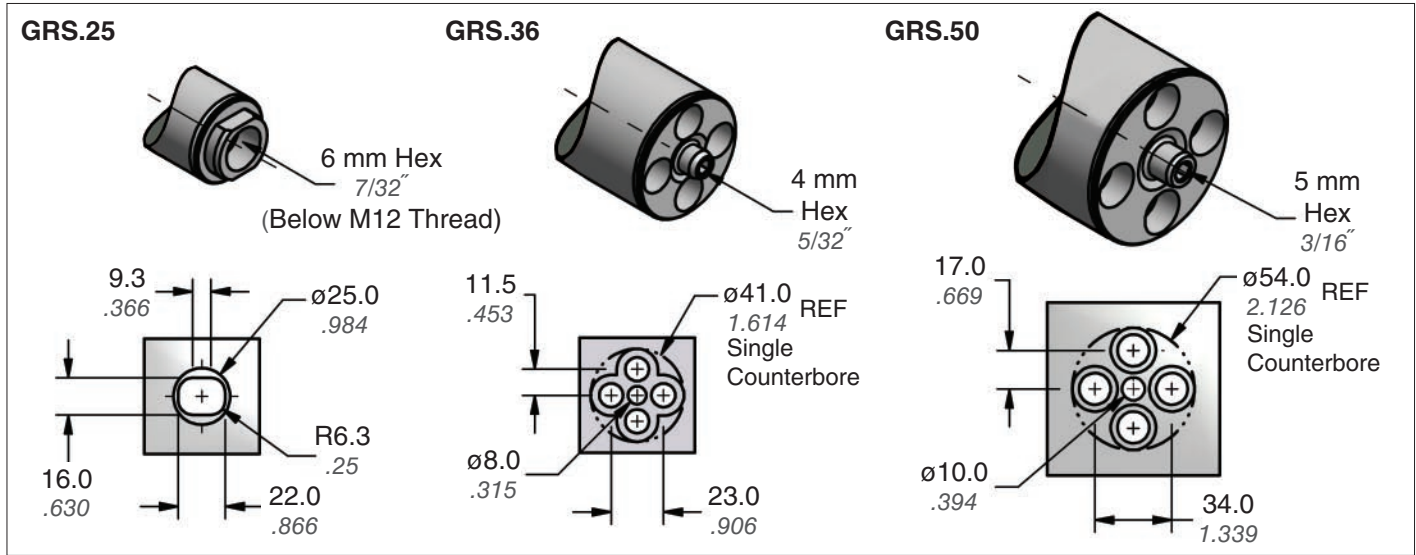
GRS.36. M. 0250

Part Number: _____
Includes Series and Model
(GRS.25, GRS.36 or GRS.50)

Stroke Length:
Specified in 0.1 mm Increments
Example: 25.0 mm = 0250 or 1.00" = 0254
(see charts on page 3).

Guide Rod Option:
Specify: M or E
When not specified, default is M.

Attachment and Installation Details



The GRS series requires machining from only one side of the plate. All models have a small hex socket located in the center of the guide rod that facilitates alignment through the plate during installation and removal. The GRS.25 guide rod has flats to prevent rotation.

Verify that there is adequate clearance for travel during operation. Overstroking the rod or impacting the bottom of the guide retainer set will cause permanent damage.

Stroke Length Recommendations

DADCO offers the Guide Retainer Sets in stroke lengths from 20.0 mm to 150.0 mm (0.75" to 6.00") in increments of 0.1 mm; DADCO recommends ordering stroke lengths in 5.0 mm or 0.25" increments when possible. Refer to charts below for the appropriate stroke length ordering code based on these suggestions. For more information contact DADCO.

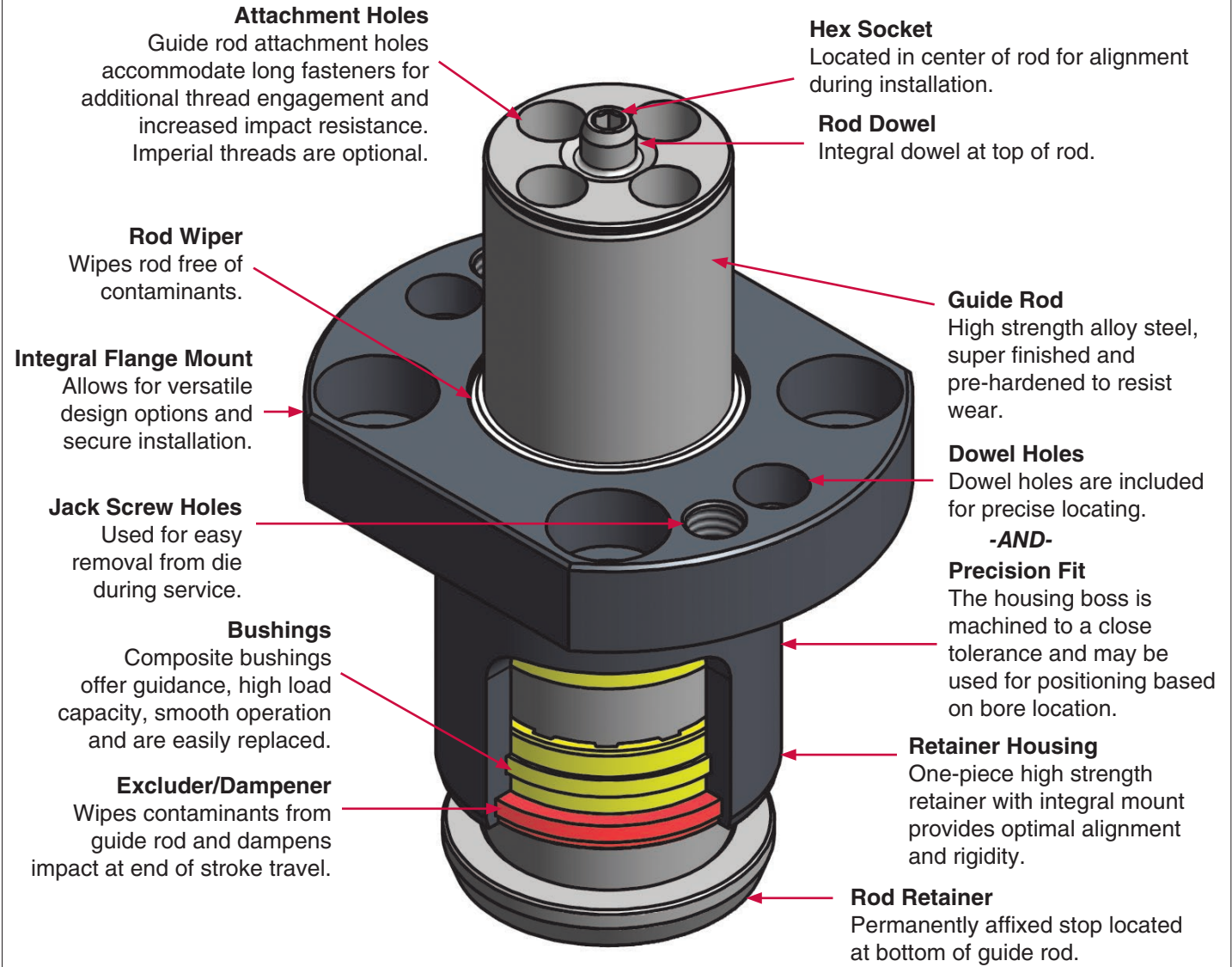
Metric

Stroke Length			Stroke Length		
S		Order Code	S		Order Code
mm	inch		mm	inch	
20.0	0.787	0200	85.0	3.346	0850
25.0	0.984	0250	90.0	3.543	0900
30.0	1.181	0300	95.0	3.740	0950
35.0	1.378	0350	100.0	3.937	1000
40.0	1.575	0400	105.0	4.134	1050
45.0	1.772	0450	110.0	4.331	1100
50.0	1.969	0500	115.0	4.528	1150
55.0	2.165	0550	120.0	4.724	1200
60.0	2.362	0600	125.0	4.921	1250
65.0	2.559	0650	130.0	5.118	1300
70.0	2.756	0700	135.0	5.315	1350
75.0	2.953	0750	140.0	5.512	1400
80.0	3.150	0800	150.0	5.906	1500

Imperial

Stroke Length			Stroke Length		
S		Order Code	S		Order Code
inch	mm		inch	mm	
0.75	19.1	0191	3.25	82.6	0826
0.90	22.9	0229	3.50	88.9	0889
1.00	25.4	0254	3.60	91.4	0914
1.25	31.8	0318	3.75	95.3	0953
1.50	38.1	0381	4.00	101.6	1016
1.75	44.5	0445	4.25	108.0	1080
1.80	45.7	0457	4.50	114.3	1143
2.00	50.8	0508	4.75	120.7	1207
2.25	57.2	0572	5.00	127.0	1270
2.50	63.5	0635	5.25	133.4	1334
2.70	68.6	0686	5.40	137.2	1372
2.75	69.9	0699	5.50	139.7	1397
3.00	76.2	0762	6.00	152.4	1524

GRS Series Features



Maximum Attachment Capacity Per Guide Retainer Set

Consider the dynamic load factors on the guide unit fasteners. The guidelines below show attachment limits per guide retainer set based on the press ram velocity. For increased capacity, install additional guide retainers.

Ram Velocity	Attachment Mass (kg)		
	GRS.25	GRS.36	GRS.50
300 mm/s	31	81	123
400	17	45	69
500	11	29	44
600	7.7	20	31
700	5.6	15	23
800	4.3	11	17

Ram Velocity		Attachment Mass (lb.-mass)		
fpm	in/s	GRS.25	GRS.36	GRS.50
59	12	68	178	271
79	16	38	100	152
98	20	24	64	98
118	24	17	44	68
138	28	12	33	50
157	31	10	25	38

Static Load Rating (Mechanical Strength)	
GRS.25	
Force (kN)	Force (tons)
10	1.2
GRS.36	
Force (kN)	Force (tons)
28	3.2
GRS.50	
Force (kN)	Force (tons)
41	4.6

DADCO

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