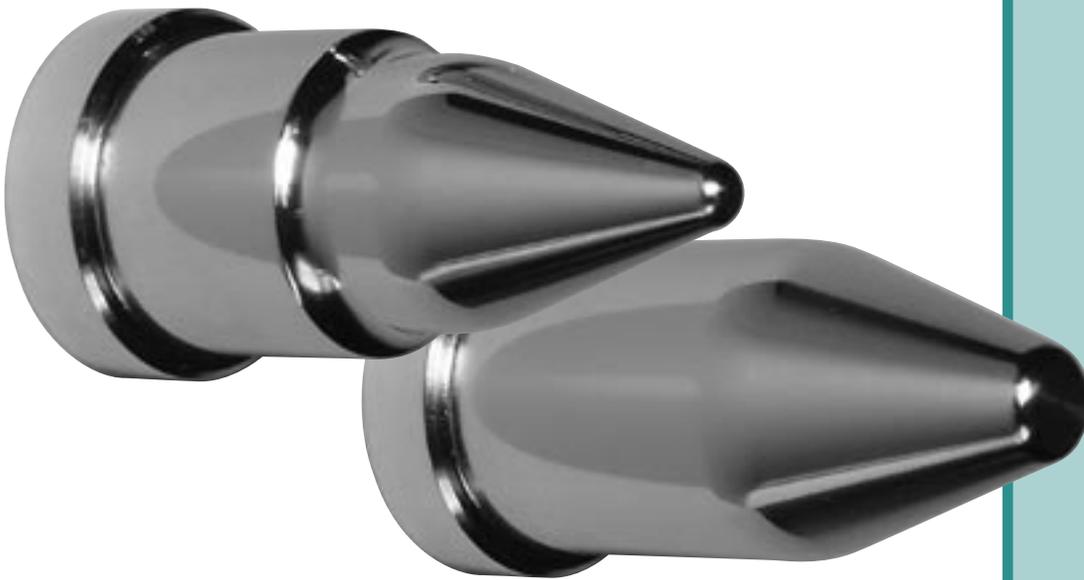


Compact Positive Pick-Up Pilots

KOMMERCIAL — Inch & Metric



Dayton Kommercial 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

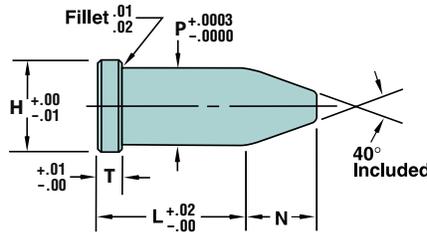
Subsidiary Federal Signal Corporation 

www.daytonprogress.com

| Type | Head | | Range P | N | *Overall Length L | | | | | | |
|------------------|------|-------|----------------|------|-------------------|------|------|------|-------|-------|-------|
| | T | H | | | .625 | .750 | .875 | 1.00 | 1.125 | 1.250 | 1.375 |
| KUAC Straight | .125 | .375 | .1865 - .2500 | .25 | 62 | | | | | | |
| | .125 | .438 | .2501 - .3130 | .31 | | | | | | | |
| | .188 | .500 | .3131 - .3750 | .37 | | | | | | | |
| | .188 | .562 | .3751 - .4380 | .43 | | | | | | | |
| | .188 | .625 | .4381 - .5000 | .50 | | | | | | | |
| | .250 | .750 | .5001 - .6250 | .62 | | | | | | | |
| | .250 | .875 | .6251 - .7500 | .75 | | | | | | | |
| | .250 | 1.000 | .7501 - .8750 | .87 | | | | | | | |
| | .250 | 1.125 | .8751 - 1.0000 | 1.00 | | | | | | | |

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

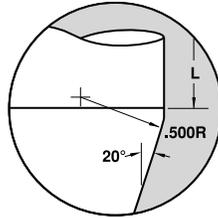
KUAC
Straight



KUAC and KPAC

Material

Steel: A2, M2, RC 60-63



Surface Coatings

| Code / Added Delivery | | Material |
|-----------------------|----------|----------|
| XNT —DayTIN® | + 2 days | M2 |
| XCN —TiCN | + 2 days | M2 |
| XAN —DayTAN® (TiAlN) | + 4 days | M2 |

HOW TO ORDER

| Specify: | Qty. | Type | D Code | L | P Dimension | Alt. | Steel |
|----------|------|------|--------|-----|-------------|--------|-------|
| Example: | 25 | KUAC | — | 75 | .3750 | XL.695 | M2 |
| | 14 | KPAC | 75 | 112 | .7300 | — | M2 |



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 | | Min. XP | Range P | Max. N | *Overall Length L | | | | | | | |
|-----------------|---------|------|------|-------|---------|---------------|--------|-------------------|------|------|------|-------|-------|-------|--|
| | | | T | H | | | | .625 | .750 | .875 | 1.00 | 1.125 | 1.250 | 1.375 | |
| KPAC Pointed | .2500 | 25 | .125 | .375 | .092 | .1650 - .2499 | .25 | 62 | | | | | | | |
| | .3125 | 31 | .125 | .438 | .092 | .2100 - .3124 | .31 | | | | | | | | |
| | .3750 | 37 | .188 | .500 | .092 | .2550 - .3749 | .37 | | | | | | | | |
| | .4375 | 43 | .188 | .562 | .092 | .3000 - .4374 | .43 | | | | | | | | |
| | .5000 | 50 | .188 | .625 | .124 | .3450 - .4999 | .50 | | | | | | | | |
| | .6250 | 62 | .250 | .750 | .234 | .4400 - .6249 | .62 | | | | | | | | |
| | .7500 | 75 | .250 | .875 | .299 | .5300 - .7499 | .75 | | | | | | | | |
| | .8750 | 87 | .250 | 1.000 | .349 | .6200 - .8749 | .87 | | | | | | | | |
| | 1.0000 | 100 | .250 | 1.125 | .399 | .7100 - .9999 | 1.00 | | | | | | | | |

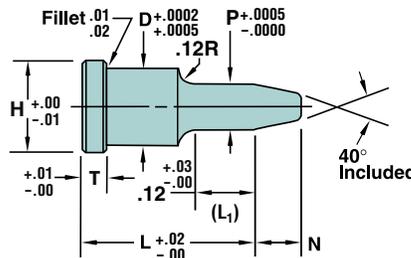
N = .132+ [(P-.057)/.728]

* 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.)

KPAC
Pointed



P to D .0005



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

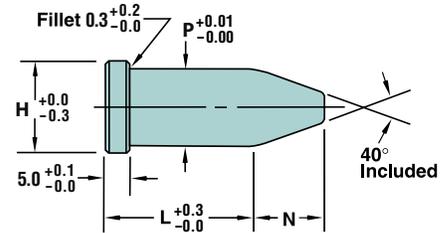
The following are standard alterations available on all Dayton Compact Pilots:

- 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 |
| AUAC 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 | ● | ● | ● | ● | ● | ● | ● | |

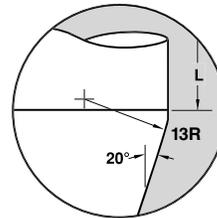
*Any overall length is available within catalog range. Specify "XL" and length.

AUAC Straight



AUAC and APAC

Material
Steel: A2, M2, RC 60-63



Surface Coatings

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

HOW TO ORDER

| Specify: | Qty. | Type | D Code | L | P Dimension | Alt. | Steel |
|----------|------|------|--------|----|-------------|---------|-------|
| Example: | 10 | AUAC | — | 20 | 8.70 | — | M2 |
| | 22 | APAC | 10 | 32 | 9.90 | XL 31.3 | A2 |



| Type | Shank D | Code | Head H | Min. XP | Range P | Max. N | *Overall Length L | | | | | | |
|-----------------|---------|------|--------|---------|---------------|--------|-------------------|----|----|----|----|----|----|
| | | | | | | | 16 | 20 | 22 | 25 | 28 | 32 | 35 |
| APAC Pointed | 4.0 | 04 | 7 | 1.55 | 1.95 - 3.99 | 4 | ● | ● | ● | ● | ● | ● | ● |
| | 5.0 | 05 | 8 | 1.55 | 2.65 - 4.99 | 5 | ● | ● | ● | ● | ● | ● | ● |
| | 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 | ● | ● | ● | ● | ● | ● | ● |

$N = 3.35 + [(P - 1.45) / .728]$

*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.)

APAC Pointed



P to D

