

Durable
Self-contained

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

Posi-Strip™
PUNCH STRIPPING SYSTEM



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, CRT, ART, ARTS, HRT, HRTB, 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.

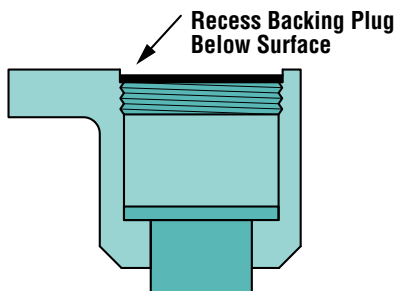
Installation

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.

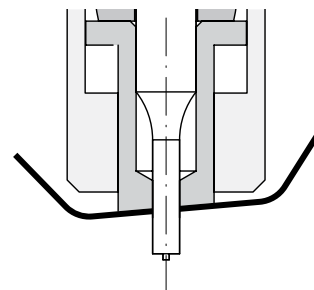
Use the provided socket head cap screw to install the Posi-Strip Punch Stripper to the retainer. The socket head cap screw fits in an elliptical mounting hole for flexibility when fastening to the retainer.

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

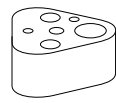
Each Posi-Strip Punch Stripper comes ready-assembled with a spring. To order replacement springs or select from optional stripping forces, see pages 10-11.

Ball Lock Metric

For True Position® Retainers

Heavy Duty

BT_J Regular

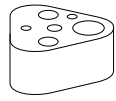


For **BRT & BRTB**
heavy duty retainers

BT_E Compact – Extended Reach

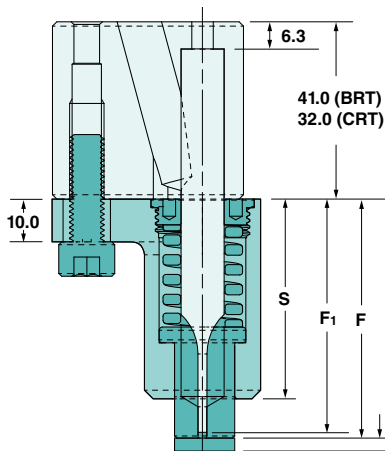
Light Duty

CT_J Regular

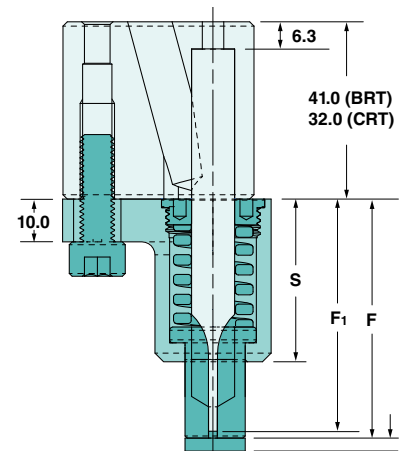
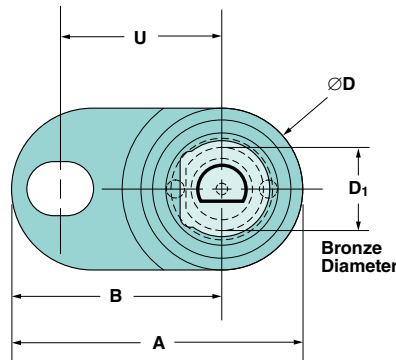


For **CRT** light duty retainers

CT_E Compact – Extended Reach



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



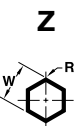
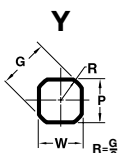
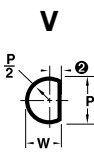
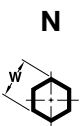
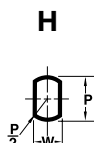
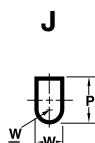
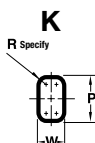
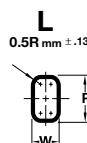
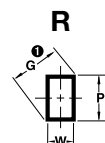
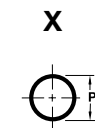
Specify bronze length "L" to add 3 mm
for in-house contour machining.

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.



(Blank)

(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*			
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	9.8	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	8.8	8.8
	BT J 32 80	79.0	47.62	48.0	62.76	40.640	37.5	45.65	45.3	8.2	8.2	9.8	7.1
	BT J 32 90						46.5	55.65	55.3	8.3	8.3	9.8	7.1
	BT J 32 100						54.5	65.65	65.3	11.2	10.8	8.8	8.8
Compact - Extended Reach	BT J 40 80	88.4	51.38	55.0	74.00	43.993	37.5	45.65	45.3	8.2	7.3	6.7	7.2
	BT J 40 90						46.5	55.65	55.3	8.3	7.3	6.7	7.2
	BT J 40 100						54.5	65.65	65.3	11.2	10.3	9.8	9.8
	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						37.5	65.65	65.3				
	BT E 13 90						37.5	55.65	55.3				
	BT E 13 100	54.8	38.10	20.0	33.30	29.972	37.5	65.65	65.3	10.3	11.1	8.7	6.2
	BT E 16 90						37.5	55.65	55.3				
	BT E 16 100						37.5	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						37.5	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						37.5	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	8.3	9.8	7.1
	BT E 32 100						37.5	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	7.3	6.7	7.2
	BT E 40 100						37.5	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*			
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	9.8	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	8.8	8.8
	CT J 32 71	79.0	47.62	48.0	62.76	40.640	37.5	46.65	45.3	8.3	8.3	9.8	7.11
	CT J 32 80						46.5	55.65	54.3	8.3	8.3	9.8	7.11
	CT J 32 90						54.5	65.65	64.3	11.2	10.8	8.8	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						37.5	65.65	64.3				
	CT E 13 80						37.5	55.65	54.3				
	CT E 13 90	54.8	38.10	20.0	33.30	29.972	37.5	65.65	64.3	10.3	11.1	8.7	6.2
	CT E 16 80						37.5	55.65	54.3				
	CT E 16 90						37.5	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						37.5	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						37.5	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	8.3	9.8	7.11
	CT E 32 90						37.5	65.65	64.3				

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

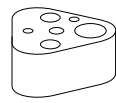
For stripping force selection, see page 10.

Ball Lock Inch

For True Position® Retainers

Heavy Duty

HT_J Regular

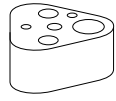


For HRT & HRTB
heavy duty retainers

HT_E Compact – Extended Reach

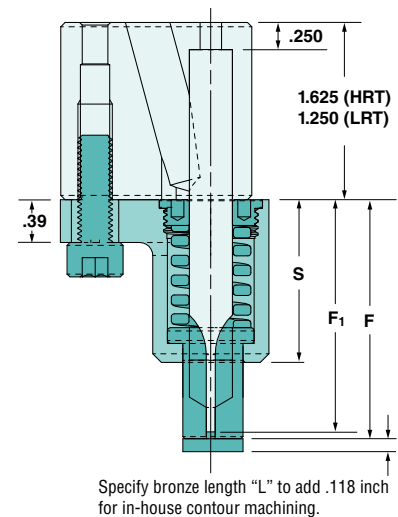
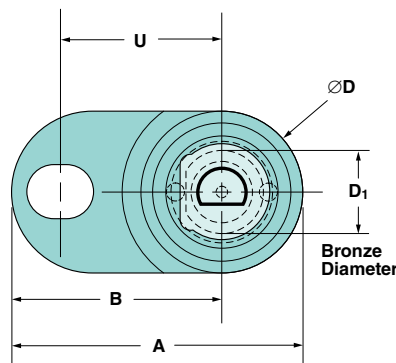
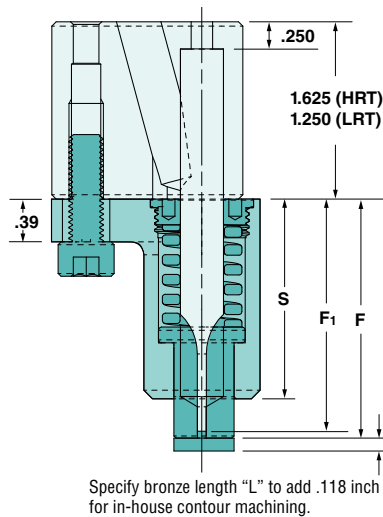
Light Duty

LT_J Regular



For LRT light duty retainers

LT_E Compact – Extended Reach

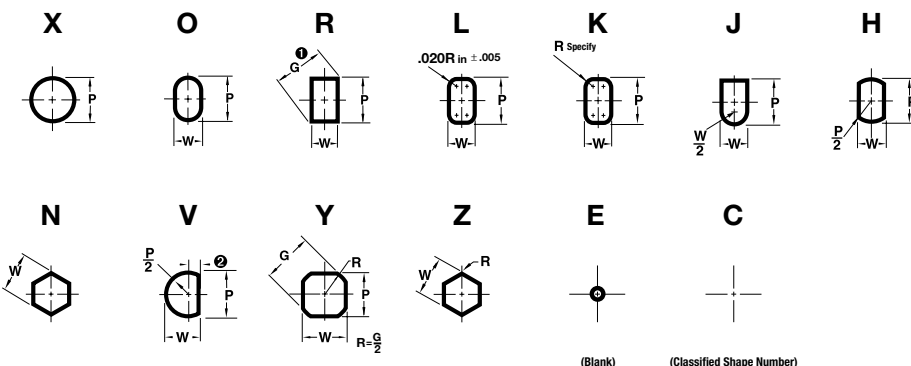


HOW TO ORDER

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, .87, 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.



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*			
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	2.66	2.01	1.50	1.96	1.40	1.48	1.92	1.88	0.27	0.27	0.31	0.24
	HT J 87 350						1.83	2.15	2.13	0.27	0.27	0.31	0.24
	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	0.35	0.35
Compact - Extended Reach	HT J 125 325	3.48	2.02	2.17	2.91	1.60	1.48	1.92	1.88	0.33	0.33	0.38	0.28
	HT J 125 350						1.83	2.15	2.13	0.32	0.32	0.38	0.28
	HT J 125 400						2.15	2.67	2.63	0.52	0.43	0.35	0.35
	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						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	2.66	2.01	1.50	1.96	1.40	1.48	2.15	2.13	0.27	0.27	0.31	0.24
	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	1.60	1.48	2.15	2.13	0.33	0.31	0.38	0.28
	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*			
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	2.66	2.01	1.50	1.96	1.40	1.48	2.04	2.00	0.27	0.27	0.31	0.24
	LT J 87 325						1.83	2.28	2.25	0.27	0.27	0.31	0.24
	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	0.35	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						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	2.66	2.01	1.50	1.96	1.40	1.48	2.28	2.25	0.27	0.27	0.31	0.24
	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.

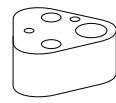
For stripping force selection, see page 11.

Headed Metric / Inch

For True Location™ Retainers

Metric

AT_J_ Regular

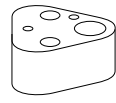


For **ART & ARTS** Press Fit metric retainers

AT_E_ Compact – Extended Reach

Inch

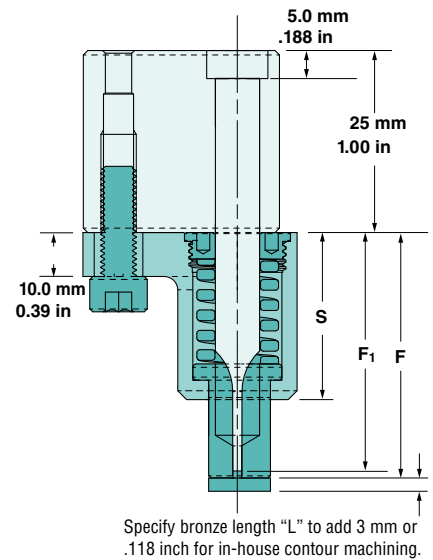
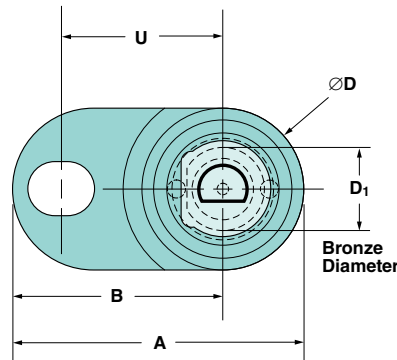
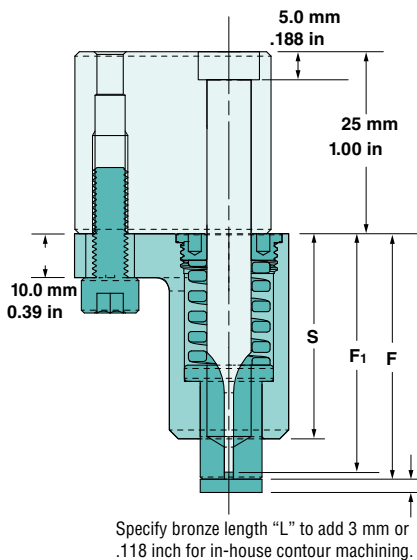
VT_J_ Regular



For specially modified*
VRT & VRTS Versatile
inch retainers

VT_E_ Compact – Extended Reach

* Please contact your Dayton distributor for a quote.

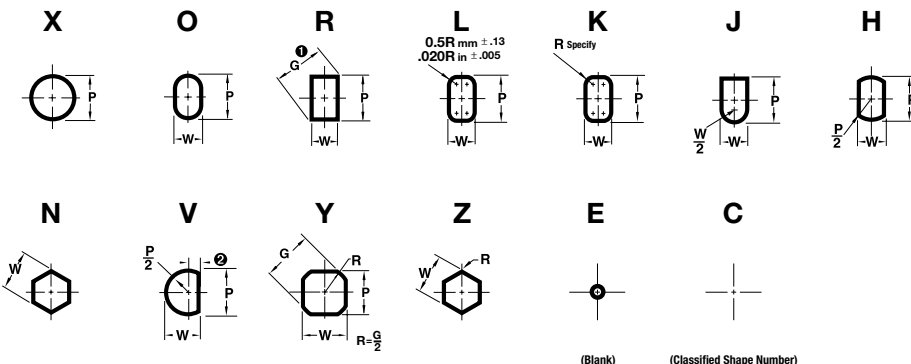


HOW TO ORDER

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.



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

Press Fit Metric										Maximum Spring Travel*			
Product Code		A	B	D ₁	D	U	S	F	F ₁	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	8.8	8.8
AT J 32 71	79.0	47.62	48.0	62.76	40.640	37.5	46.65	46.00	8.3	8.3	9.8	7.11	
AT J 32 80						46.5	55.65	55.00	8.3	8.3	9.8	7.11	
AT J 32 90						54.5	65.65	65.00	11.2	10.8	8.8	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							55.65	55.00				
	AT E 13 90	54.8	38.10	20.0	33.30	29.972	37.5	65.65	65.00	10.3	11.1	8.7	6.2
	AT E 16 80							55.65	55.00				
	AT E 16 90							65.65	65.00				
	AT E 20 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 20 90							65.65	65.00				
	AT E 25 80							55.65	55.00				
	AT E 25 90	76.0	47.62	42.0	56.76	40.640	37.5	65.65	65.00	7.8	6.3	7.8	7.3
	AT E 32 80							55.65	55.00				
	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

Versatile Inch										Maximum Spring Travel*			
Product Code		A	B	D ₁	D	U	S	F	F ₁	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	0.35	0.35
VT J 125 300	3.48	2.02	2.17	2.91	1.60	1.48	2.04	2.00	0.33	0.33	0.38	0.28	
VT J 125 325						1.83	2.28	2.25	0.33	0.33	0.38	0.28	
VT J 125 350						2.15	2.56	2.50	0.40	0.40	0.35	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	1.60	1.48	2.28	2.25	0.33	0.33	0.38	0.28	
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.

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	1035.1	SHD2032	1538.1
	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	1050.0	SHD2532	1825.8
	BT J 32 80	SSD3225	270.0	SLD3225	711.0	SMD3225	1440.0	SHD3225	1777.4
	BT J 32 90	SSD3225	270.0	SLD3225	711.0	SMD3225	1440.0	SHD3225	1777.4
	BT J 32 100	SSD3232	240.0	SLD3232	960.0	SMD3232	1095.0	SHD3232	2993.4
	BT J 40 80	SSD4025	369.0	SLD4025	960.0	SMD4025	1575.0	SHD4025	1540.1
	BT J 40 90	SSD4025	369.0	SLD4025	960.0	SMD4025	1575.0	SHD4025	1540.1
BT J 40 100	SSD4032	288.0	SLD4032	837.0	SMD4032	1395.0	SHD4032	3143.6	
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								
	BT E 13 100	SSD1325	96.0	SLD1325	285.0	SMD1325	465.0	SHD1325	1050.0
	BT E 16 90	SSD1625	150.0	SLD1625	325.9	SMD1625	555.3	SHD1625	1128.0
	BT E 16 100								
	BT E 20 90								
	BT E 20 100	SSD2025	285.0	SLD2025	570.0	SMD2025	720.0	SHD2025	1050.0
	BT E 25 90	SSD2525	345.0	SLD2525	660.0	SMD2525	780.0	SHD2525	1530.0
	BT E 25 100								
BT E 32 90									
BT E 32 100	SSD3225	270.0	SLD3225	711.0	SMD3225	1440.0	SHD3225	1777.4	
BT E 40 90	SSD4025	369.0	SLD4025	960.0	SMD4025	1575.0	SHD4025	1540.1	
BT E 40 100									

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	1035.1	SHD2032	1538.1
	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	1050.0	SHD2532	1825.8
	CT J / AT J 32 71	SSD3225	270.0	SLD3225	711.0	SMD3225	1440.0	SHD3225	1777.4
CT J / AT J 32 80	SSD3225	270.0	SLD3225	711.0	SMD3225	1440.0	SHD3225	1777.4	
CT J / AT J 32 90	SSD3232	240.0	SLD3232	960.0	SMD3232	1095.0	SHD3232	2993.4	
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	711.0	SMD3225	1440.0	SHD3225	1777.4	
CT E / AT E 32 90									

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	197.02	SHD2032	293.20
	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	199.86	SHD2532	348.05
	LT J / VT J 125 300	SSD3225	60.70	SLD3225	135.33	SMD3225	274.09	SHD3225	338.82
	Compact - Extended Reach	LT J / VT J 125 325	SSD3225	60.70	SLD3225	135.33	SMD3225	274.09	SHD3225
LT J / VT J 125 350		SSD3232	53.95	SLD3232	182.72	SMD3232	208.42	SHD3232	570.62
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	135.33	SMD3225	274.09	SHD3225	338.82	
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.

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