

DADCO®

Heavy Duty Guide Retainer Sets

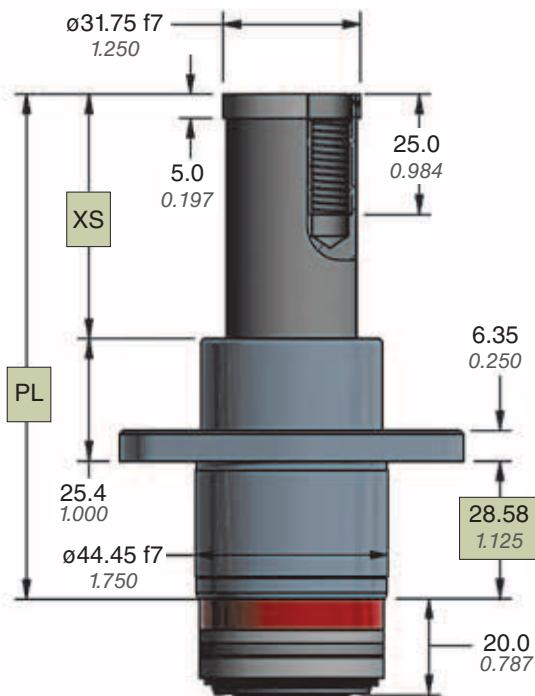
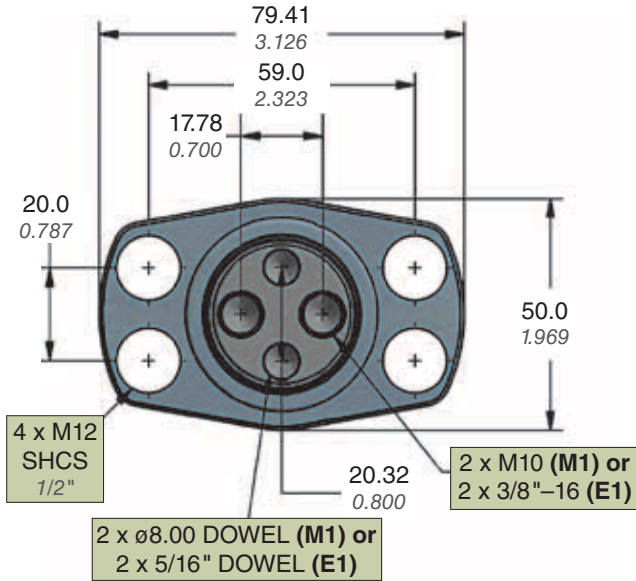
GRS.30.HD / GRS.45.HD

NEW!



Heavy Duty Guidance and Retention with Increased Load Capacity

- Robust one-piece guide retainer
- Extended composite bushings
- High capacity guide rod dampener
- 30 mm and 45 mm guide rod diameter models



Pin Extension Code	XS		PL	
	mm	inch	mm	inch
0200	20.0	0.787	73.98	2.912
0254	25.4	1.000	79.38	3.125
0300	30.0	1.181	83.98	3.306
0318	31.75	1.250	85.73	3.375
0381	38.1	1.500	92.08	3.625
0400	40.0	1.575	93.98	3.700
0445	44.5	1.750	98.43	3.875
0500	50.0	1.969	103.98	4.094
0508	50.8	2.000	104.78	4.125
0572	57.15	2.250	111.13	4.375
0600	60.0	2.362	113.98	4.487
0635	63.5	2.500	117.48	4.625
0700	70.0	2.756	123.98	4.881
0762	76.2	3.000	130.18	5.125
0800	80.0	3.150	133.98	5.275
0889	88.9	3.500	142.88	5.625
0900	90.0	3.543	143.98	5.668

Ordering Example:

GRS.30.HD1. M1. 0500

Part Number:

Includes Series, Model and Retainer Mount Option (HD1)

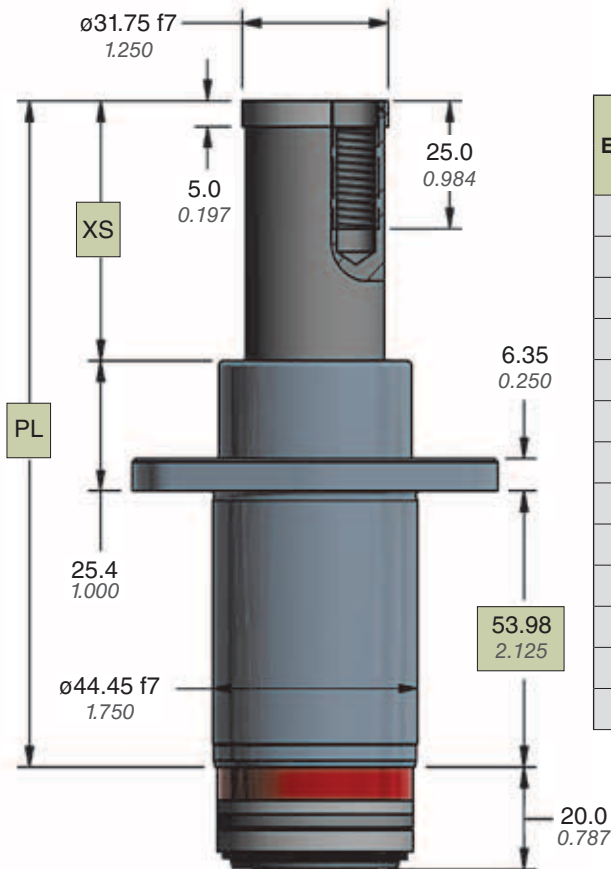
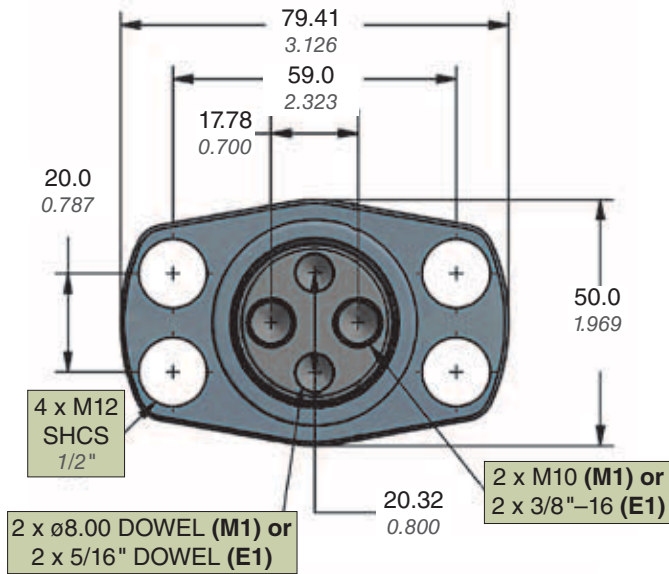
Guide Rod Option:

M1 = 2 x M10, 2 x ø8.00;
E1 = 2 x 3/8"-16, 2 x 5/16"

Pin Extension Code:

20.0 mm to 90.0 mm

Example: 0200 = 20.0 mm (XS Dimension)



Pin Extension Code	XS		PL		Pin Extension Code	XS		PL	
	mm	inch	mm	inch		mm	inch	mm	inch
0200	20.0	0.787	99.38	3.912	0254	25.4	1.000	104.78	4.125
0300	30.0	1.181	109.38	4.306	0318	31.75	1.250	111.13	4.375
0400	40.0	1.575	119.38	4.700	0381	38.1	1.500	117.48	4.625
0500	50.0	1.969	129.38	5.094	0445	44.5	1.750	123.83	4.875
0600	60.0	2.362	139.38	5.487	0508	50.8	2.000	130.18	5.125
0700	70.0	2.756	149.38	5.881	0572	57.15	2.250	136.53	5.375
0800	80.0	3.150	159.38	6.275	0635	63.5	2.500	142.88	5.625
0900	90.0	3.543	169.38	6.668	0762	76.2	3.000	155.58	6.125
1000	100.0	3.937	179.38	7.062	0889	88.9	3.500	168.28	6.625
1100	110.0	4.331	189.38	7.456	1016	101.6	4.000	180.98	7.125
1200	120.0	4.724	199.38	7.849	1143	114.3	4.500	193.68	7.625
1300	130.0	5.118	209.38	8.243	1270	127.0	5.000	206.38	8.125
1400	140.0	5.512	219.38	8.637	1397	139.7	5.500	219.08	8.625

Ordering Example:

GRS.30.HD2. M1. 0500

Part Number:

Includes Series, Model and Retainer Mount Option (HD2)

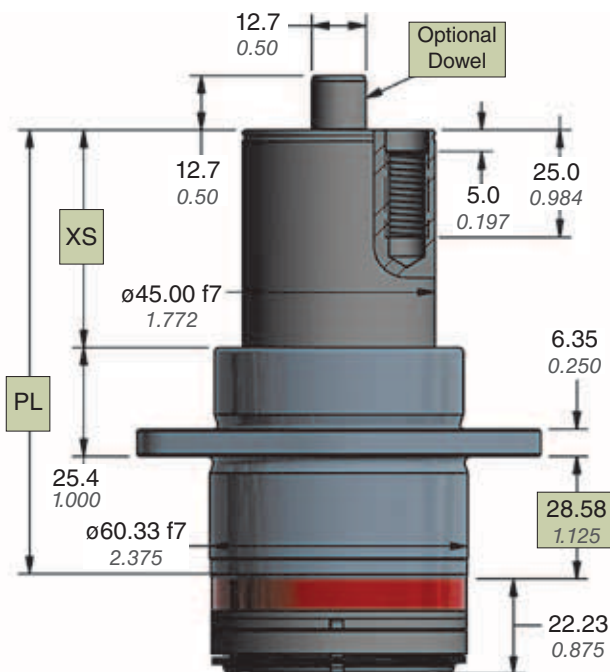
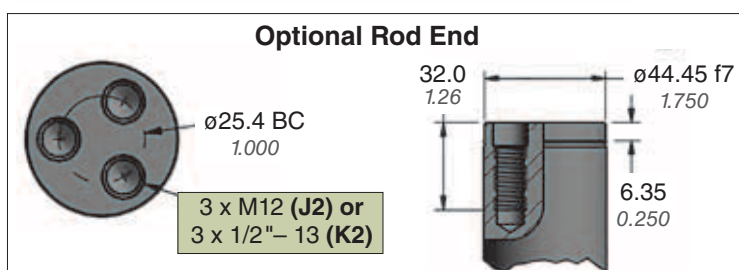
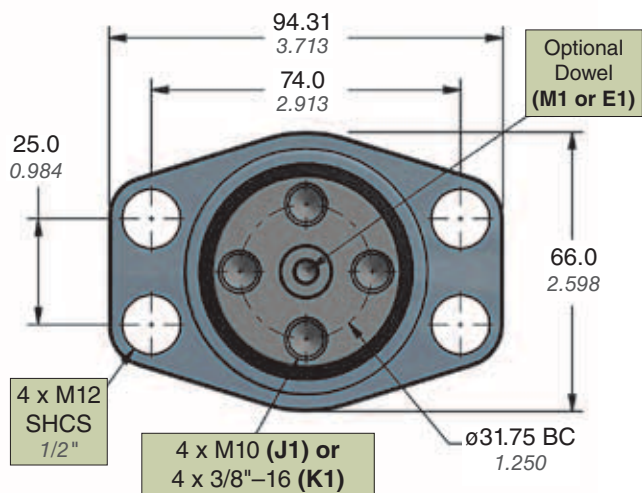
Guide Rod Option:

M1 = 2 x M10, 2 x ø8.00;
E1 = 2 x 3/8"-16, 2 x 5/16"

Pin Extension Code:

20.0 mm to 140.0 mm

Example: 0200 = 20.0 mm (XS Dimension)



Pin Extension Code	XS		PL	
	mm	inch	mm	inch
0200	20.0	0.787	73.98	2.912
0254	25.4	1.000	79.38	3.125
0300	30.0	1.181	83.98	3.306
0318	31.75	1.250	85.73	3.375
0381	38.1	1.500	92.08	3.625
0400	40.0	1.575	93.98	3.700
0445	44.5	1.750	98.43	3.875
0500	50.0	1.969	103.98	4.094
0508	50.8	2.000	104.78	4.125
0572	57.15	2.250	111.13	4.375
0600	60.0	2.362	113.98	4.487
0635	63.5	2.500	117.48	4.625
0700	70.0	2.756	123.98	4.881
0762	76.2	3.000	130.18	5.125
0800	80.0	3.150	133.98	5.275
0889	88.9	3.500	142.88	5.625
0900	90.0	3.543	143.98	5.668

Ordering Example:

GRS.45.HD1. J1. 0500 .

Part Number:

Includes Series, Model and Retainer Mount Option (HD1)

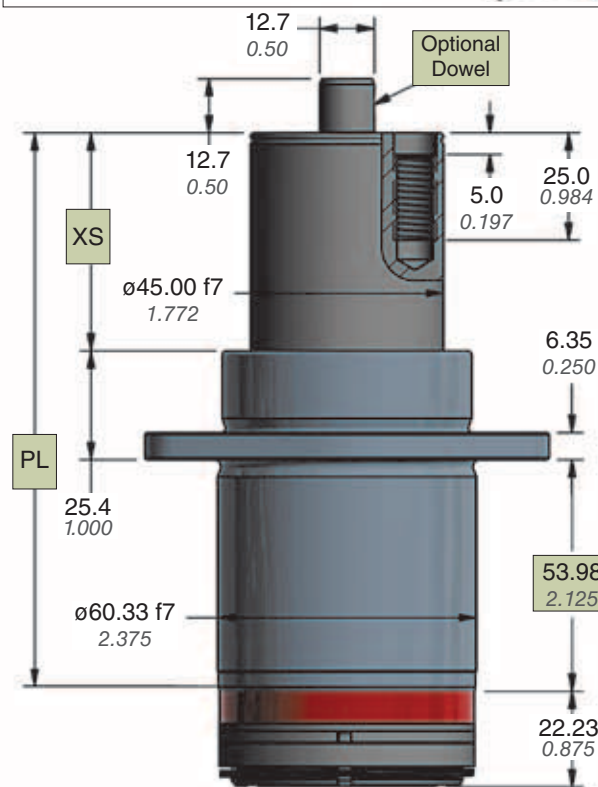
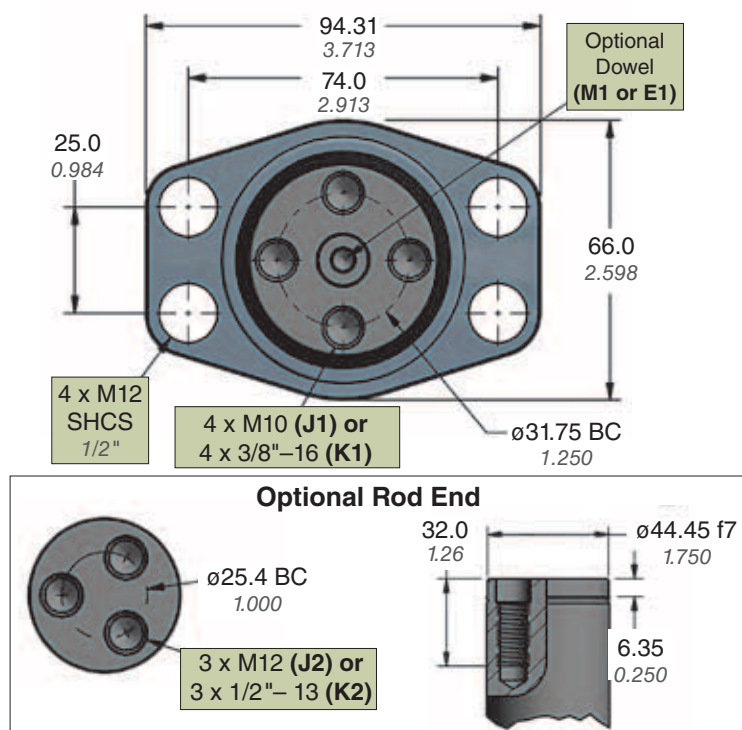
Guide Rod Option:

J1 = 4 x M10; J2 = 3 x M12;
K1 = 4 x 3/8"-16; K2 = 3 x 1/2"-13;
M1 = 4 x M10, with Dowel;
E1 = 4 x 3/8"-16, with Dowel

For optional plate adapter cap, add **AC**.
See page 6 for details.

Pin Extension Code:

20.0 mm to 90.0 mm
Example: 0200 = 20.0 mm (XS Dimension)



Pin Extension Code	XS		PL		Pin Extension Code	XS		PL	
	mm	inch	mm	inch		mm	inch	mm	inch
0200	20.0	0.787	99.38	3.912	0254	25.4	1.000	104.78	4.125
0300	30.0	1.181	109.38	4.306	0318	31.75	1.250	111.13	4.375
0400	40.0	1.575	119.38	4.700	0381	38.1	1.500	117.48	4.625
0500	50.0	1.969	129.38	5.094	0445	44.5	1.750	123.83	4.875
0600	60.0	2.362	139.38	5.487	0508	50.8	2.000	130.18	5.125
0700	70.0	2.756	149.38	5.881	0572	57.15	2.250	136.53	5.375
0800	80.0	3.150	159.38	6.275	0635	63.5	2.500	142.88	5.625
0900	90.0	3.543	169.38	6.668	0762	76.2	3.000	155.58	6.125
1000	100.0	3.937	179.38	7.062	0889	88.9	3.500	168.28	6.625
1100	110.0	4.331	189.38	7.456	1016	101.6	4.000	180.98	7.125
1200	120.0	4.724	199.38	7.849	1143	114.3	4.500	193.68	7.625
1300	130.0	5.118	209.38	8.243	1270	127.0	5.000	206.38	8.125
1400	140.0	5.512	219.38	8.637	1397	139.7	5.500	219.08	8.625

Ordering Example:

GRS.45.HD2. J1. 0500 .

Part Number:

Includes Series, Model and Retainer Mount Option (HD2)

Guide Rod Option:

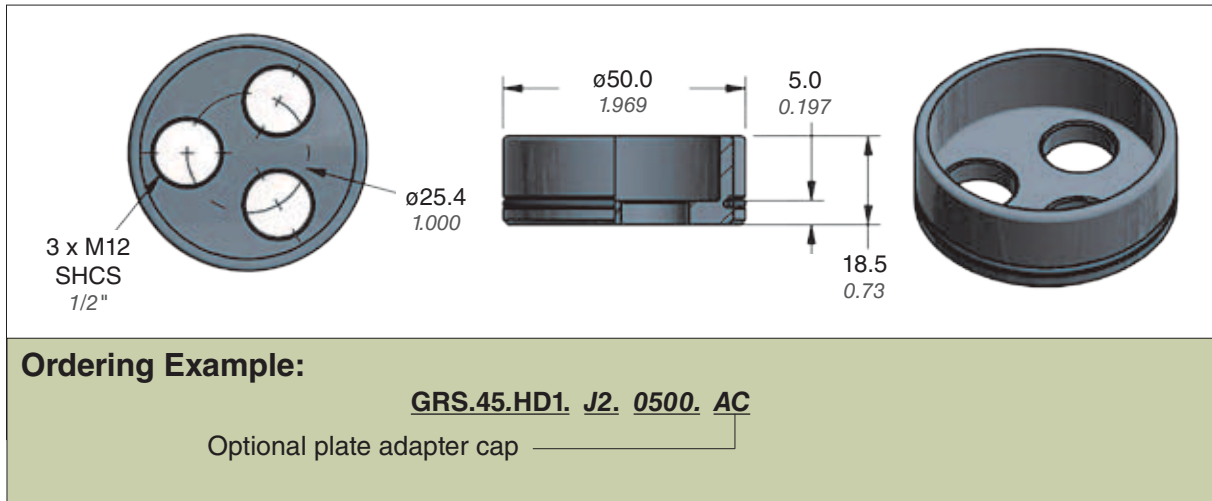
J1 = 4 x M10; J2 = 3 x M12;
 K1 = 4 x 3/8"-16; K2 = 3 x 1/2"-13;
 M1 = 4 x M10, with Dowel;
 E1 = 4 x 3/8"-16, with Dowel

For optional plate adapter cap, add **AC**.
 See page 6 for details.

Pin Extension Code:

20.0 mm to 140.0 mm
 Example: 0200 = 20.0 mm (XS Dimension)

GRS.45.HD__ Optional Plate Adapter Cap



Replacement Parts & Repair Kit Information

Available in two rod diameter sizes: 30 and 45. Includes bushings, rod wiper, dampener and a maintenance manual.

Guide Rods	Guide Retainer	Plate Adapter Cap
GRS. .HD . .RO 30 or 45 HD1 / HD2 M_ / E_ or J_ / K_ Pin Extension Code	GRS. .HD1 GRS. .HD2 30 / 45 30 / 45	GRS.45.HD .AC HD1 / HD2 AC = Adapter Cap

Model	Kit Number
GRS.30.HD1	GRS.30.HD1.RK
GRS.30.HD2	GRS.30.HD2.RK
GRS.45.HD1	GRS.45.HD1.RK
GRS.45.HD2	GRS.45.HD2.RK



Maximum Attachment Capacity

The guidelines below show attachment limits per GRS based on press ram velocity. For increased capacity, install additional Guide Retainer Sets.

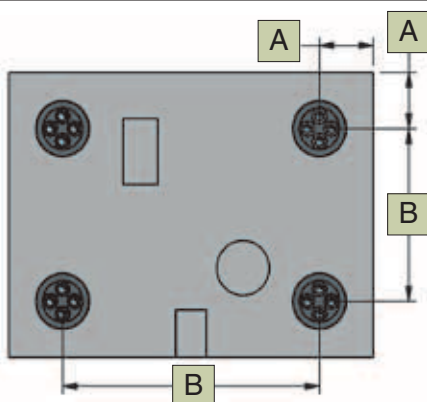
GRS.30.HD__

Velocity Estimate	(m/sec)	0.50	0.60	0.70	0.80	0.90	1.00	1.10	1.20
Per GRS	max (lb.)	141	98	72	55	44	35	29	24
	max (kg)	64	44	33	25	20	16	13	11
Pad Mass		GRS.30.HD__ Quantity							
lb.	kg								
50	23	2	2	2	2	3	3	3	4
100	45	2	3	3	3	4	4	5	6
150	68	3	3	4	4	5	6	7	8
200	91	3	4	4	5	6	7	8	
250	113	3	4	5	6	7			
300	136	4	5	6	7	8			
350	159	4	5	6	8				
400	181	4	6	7					

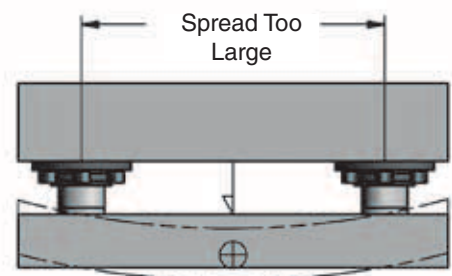
GRS.45.HD__

Velocity Estimate	(m/sec)	0.50	0.60	0.70	0.80	0.90	1.00	1.10	1.20
Per GRS	max (lb.)	317	220	162	124	98	79	66	55
	max (kg)	144	100	73	56	44	36	30	25
Pad Mass		GRS.45.HD__ Quantity							
lb.	kg								
150	68	2	2	2	3	3	3	4	4
200	91	2	2	3	3	4	4	5	5
250	113	2	3	3	4	4	5	5	6
300	136	2	3	3	4	5	5	6	7
350	159	3	3	4	4	5	6	7	8
400	181	3	3	4	5	6	7	8	
450	204	3	4	4	5	6	7	8	
500	227	3	4	5	6	7	8		
550	249	3	4	5	6	7	8		
600	272	3	4	5	6	8			
650	295	4	4	6	7	8			
700	318	4	5	6	7				

Pad Flex



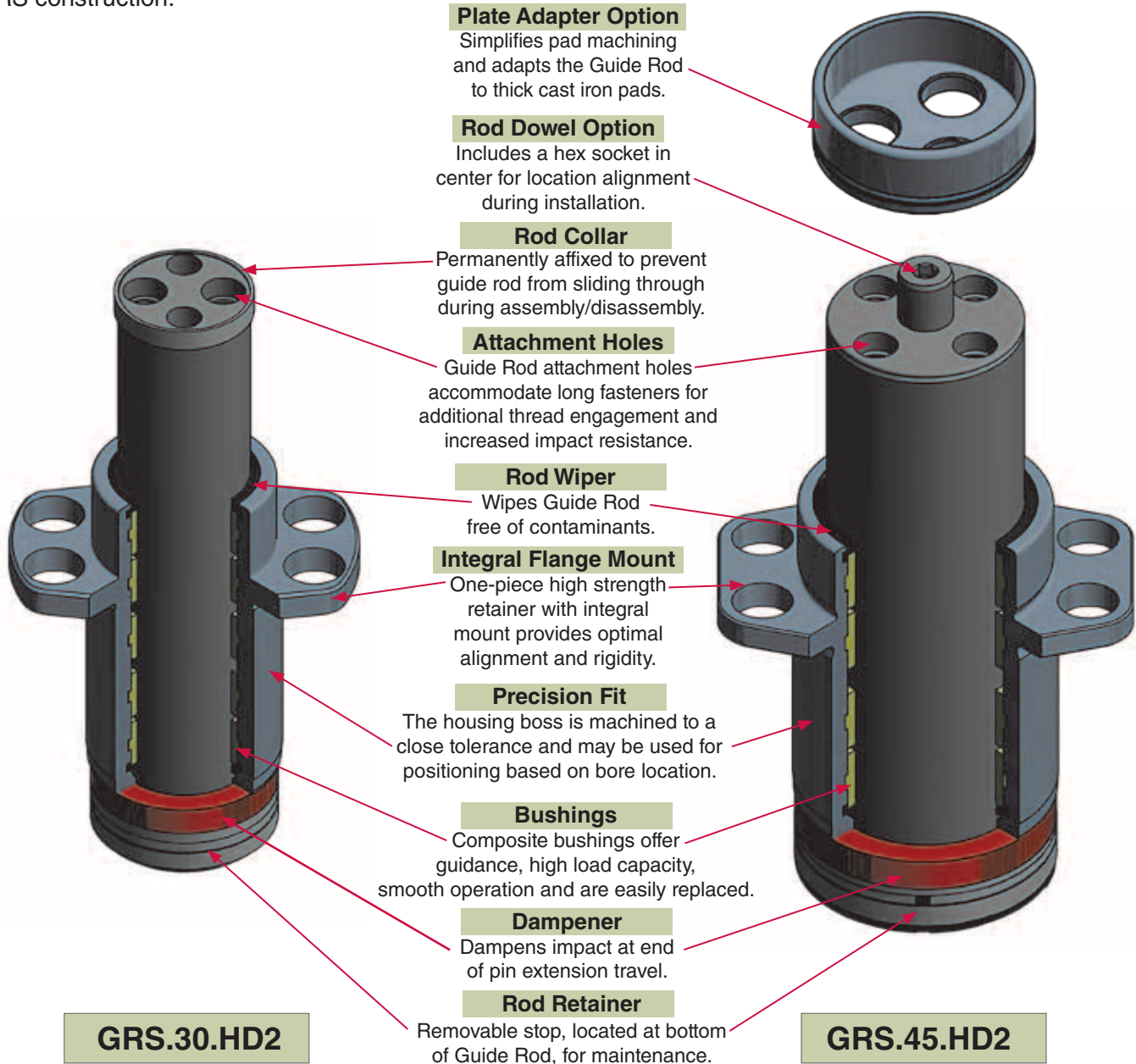
Minimum Distance		
GRS	A	B
GRS.30.HD__	60 2.362	85 3.346
GRS.45.HD__	70 2.756	110 4.331



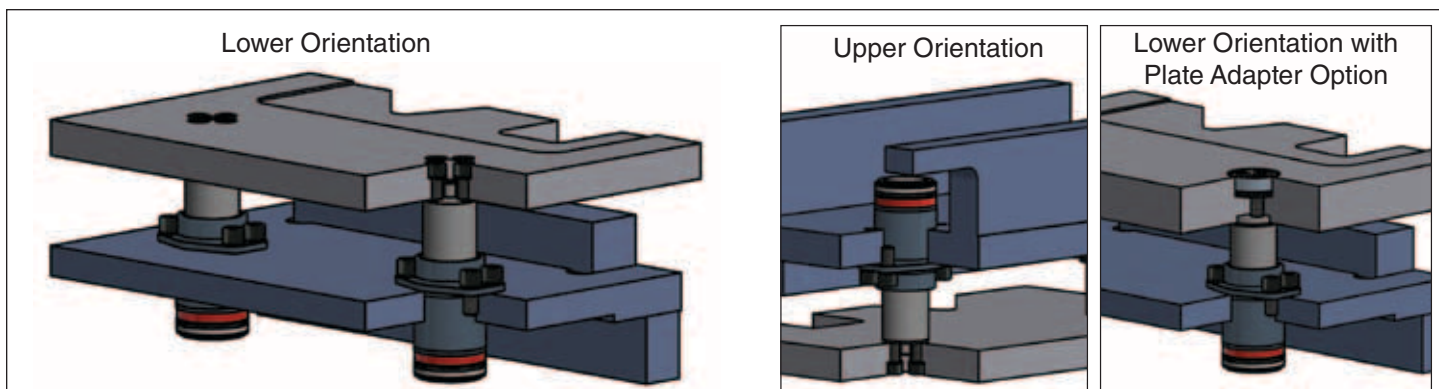
Deceleration of the pad may cause pad flexing to occur. Add additional GRS to the center to prevent side load from inertial deflection at end of stroke travel. Lighter pads may result in a flexible structure requiring center support. Heavier pads will require additional GRS to distribute the weight according to the shape and die steel attachments.

Heavy Duty Guide Retainer Sets

DADCO offers two new Heavy Duty Guide Retainer Sets in sizes GRS.30 and GRS.45. The construction of these models permits up to 4 times the attachment mass and increased operating speed over the standard GRS construction.



Installation Specifications



The GRS.HD Series saves cost by providing an all-in-one replacement to common pins, bushings and spools. The GRS.HD may be installed in upper or lower orientation for maximum versatility.