

DADCO®

Nitrogen Gas Spring Linked System Components



Everything You Need to Construct a Linked System

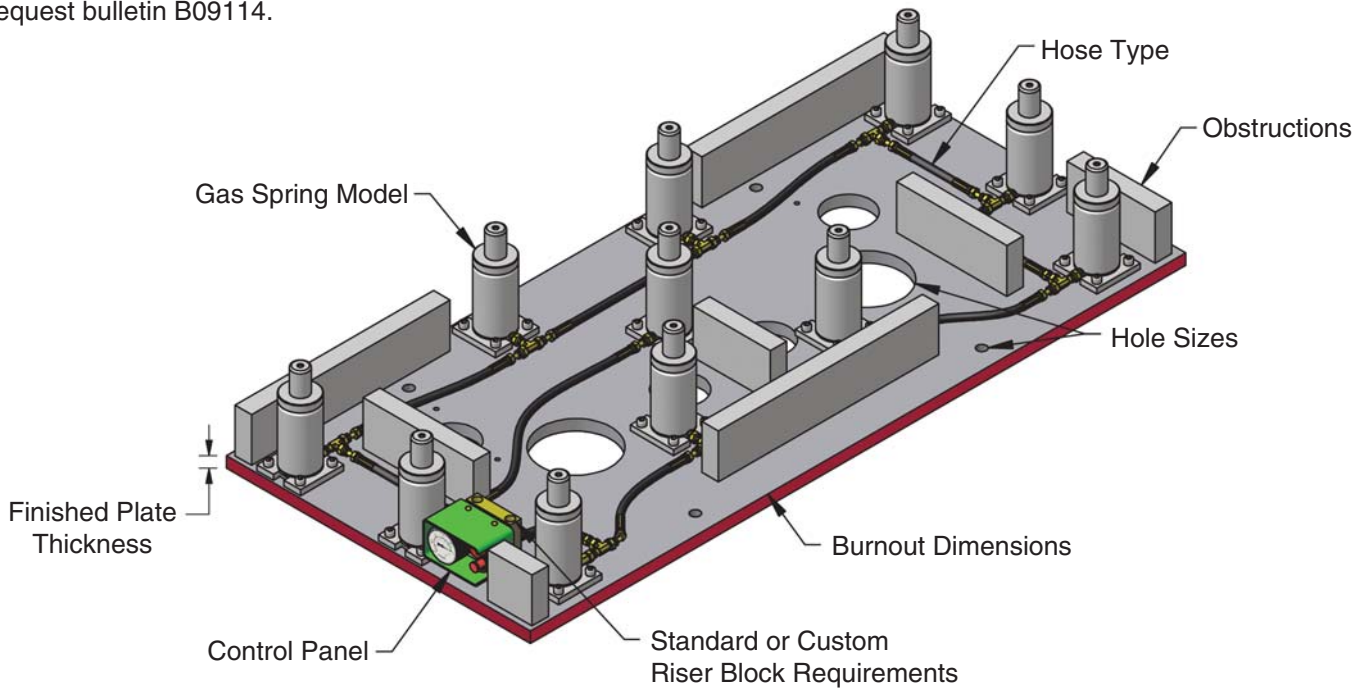
Numerous Piping Options

Many customers recognize the benefits of linking nitrogen gas springs; linked systems allow users to easily monitor, control and adjust pressure from outside the die. In this catalog DADCO has brought together all of the components necessary to easily configure a linked system. Choose from the various types of fittings, hose, control panels and specialty components to design a linked system best suited for your application.

DADCO also offers ready-to-install complete linked systems built to customer specifications.

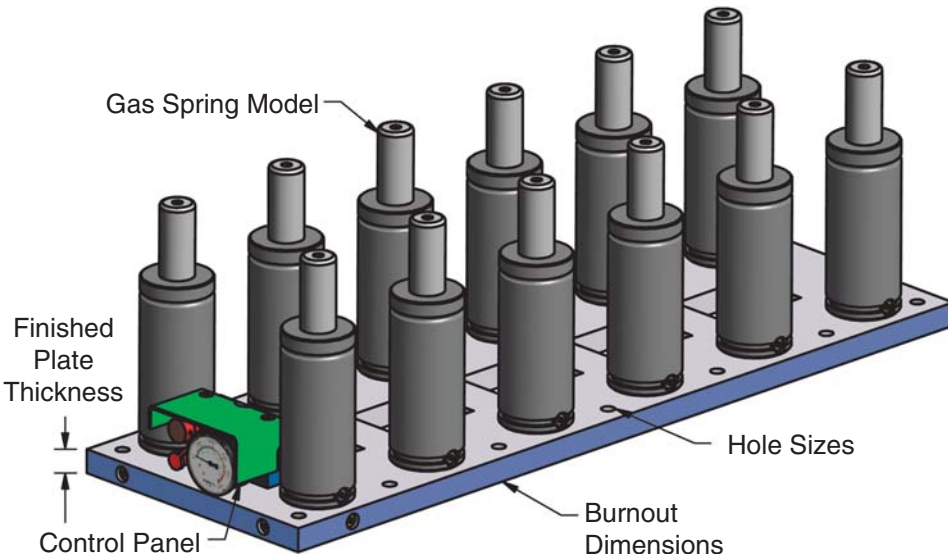
Complete Linked Systems from DADCO SMS®

For those instances where a customer prefers to have DADCO provide a finished system, DADCO offers several options. First is the Sectional Mounting System (SMS®) where DADCO will mount cylinders to a SMS® plate and link them using hose, fittings and a control panel based on a customer design. For more information on DADCO's SMS® request bulletin B09114.

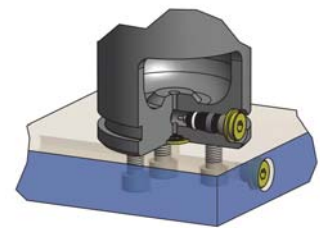


SMS-i®

Another option, which is new from DADCO, is the Sectional Mounting System - Internal (SMS-i®). DADCO will mount cylinders to a plate that has been piped internally. DADCO recommends using the SMS-i® as an alternative to traditional manifold systems. For more information on DADCO's SMS-i® request bulletin B07104A.



SMS-i® Connection



DADCO gas springs used in a SMS-i® have a bottom port and are attached to the base plate with a sealing washer and standard mounting hardware.

Overview

DADCO Gas Springs are grouped by two main classifications: Mini Springs with a M6 Port and Large Springs with a G 1/8 BSPP Port. DADCO recommends choosing control panels, fittings and hose type based on port style and application requirements.

Port Style

M6 Mini Port



Gas Springs with M6 Port:

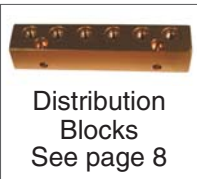
Micro Series
U.0175 – U.2600
LJ and L Series
SCR Series
90.9.01500

G 1/8 Large Port



Gas Springs with G 1/8 Port:

U.4600 – U.20000
UX Series
90.8 Series
90.9.03000 – 90.9.07500
90.10 Series



Compatible Fitting Styles

Preferred

Preferred

DADCO MINILink®
(M8 x 1)



See page 15

D-24 Tapered
(M12 x 1.5)



See page 14

Zip (CNOMO)
(S12.65 x 1.5)



See page 16

O-Ring Face Seal (ORFS)
(9/16-18)



See pages 11-13

Hose System

90.700 (Y-700) Hose



See page 10

90.500 (Y-500) Hose



See page 10

90.400 (Y-400) Hose



See page 10

90.250 (Y-250) Hose

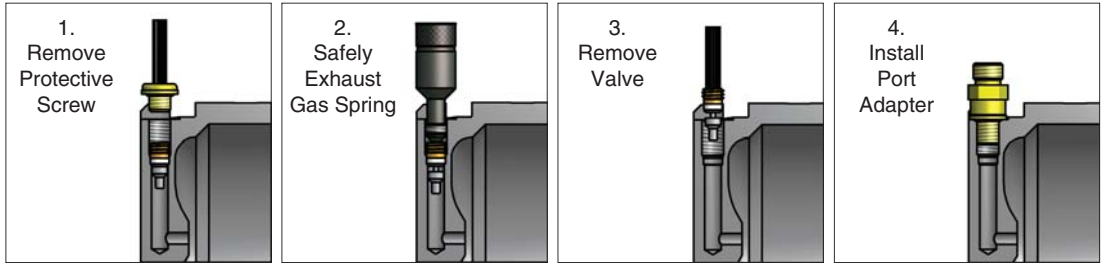


See page 10

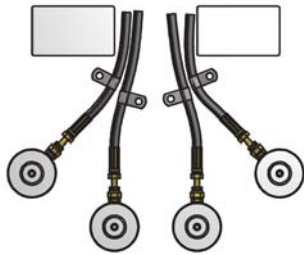
Converting from Self-Contained to Linked Mode

The following basic steps show how to easily convert DADCO gas springs from self-contained to linked mode. For more detailed instructions, refer to the relevant product catalog. (*Mini series gas spring with M6 port shown below.*)

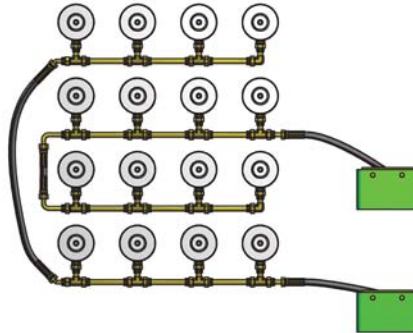
CAUTION
Always wear safety goggles when performing maintenance on nitrogen gas springs.



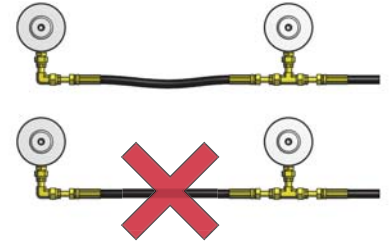
Recommendations for Linked Systems



Allow ample space to secure hoses to plate. It is preferred that hoses rest side by side.



Arrange gas springs to provide uniformity and balance within the die. Use multiple panels for large systems to allow faster filling and discharging.



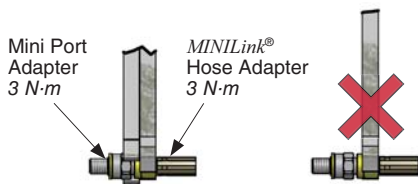
When linking cylinders allow for ample hose to avoid taut connections.

Torque Specifications

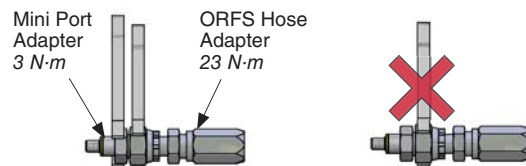
Tighten fittings to the following torque specifications to prevent damage and loosening from vibration during operation.

Type	Thread	lb _f -in	lb _f -ft	N-m
M6 Port Adapter	M6 x 1	25	2.1	3
MINILink [®] Hose Adapter	M8 x 1	25	2.1	3
G 1/8 Port Adapter	BSPP	168	14	19
ORFS Hose Adapter	9/16-18	204	17	23
D-24 Hose Adapter	M12 x 1.5	Hand-tight then ¼ turn with wrench		
Zip Hose Adapter	S12.65 x 1.5	Hand-tight		

Use two wrenches, one on the port adapter and one on the hose adapter, to avoid over-tightening. The drawings below depict the importance of torque specifications in common port and hose adapter combinations.



Mini Port Adapter + MINILink[®] Hose Adapter
Mini fittings and hose adapters have low torque values. Refer to the chart above to avoid possible damage from over-tightening.



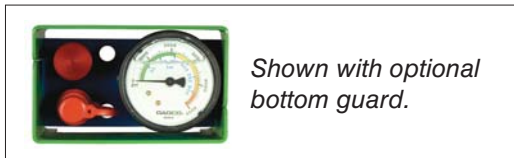
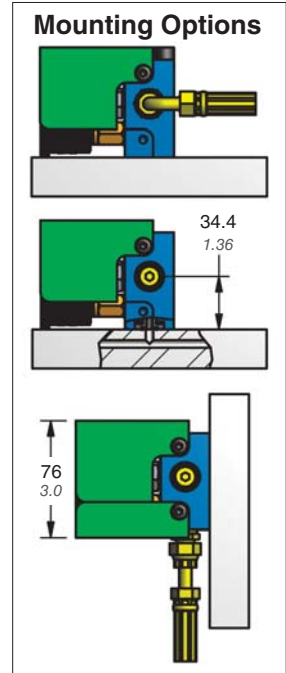
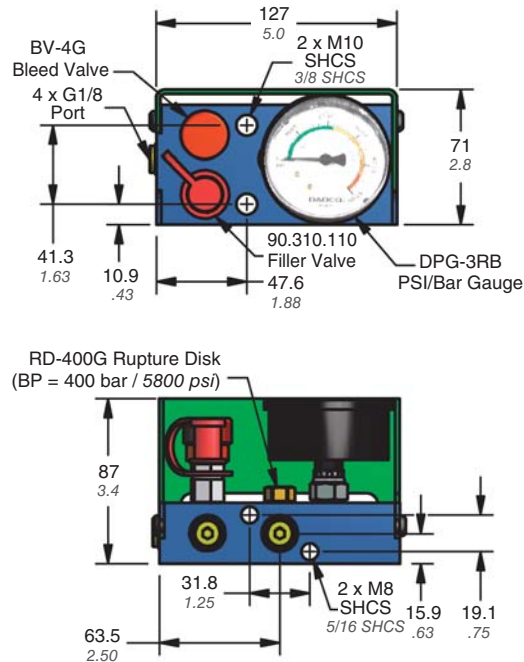
Mini Port Adapter + 9/16-18 ORFS Hose Adapter
The torque requirement for the Mini Port Adapter is smaller than the ORFS Hose Adapter. Refer to the chart above. Do not torque port fitting with larger hose adapter nut.

Components: Control Panels

Convertible Control Panel



The DADCO Convertible Control Panel is used to fill, drain and monitor the pressure of linked DADCO nitrogen gas springs from outside the die. The panel consists of four G 1/8 BSPP ports, a high pressure 63 mm diameter gauge, a quick disconnect fill valve, a bleed valve and a rupture disk to prevent overpressurization. For maximum versatility, the panel is available with a variety of fitting connections. See below for information on the 90.406.220 riser block available for use with the control panel.



Ordering Example:

90.406. P 1 N

Common Control Panel

Gauge Style

PSI/Bar Gauge (DPG-3RB) = P,
Bar/MPa Gauge (DPG-3RM) = A
When not specified, default is P.

Guard

Top Guard = 1, Top and Bottom Guards = 2
When not specified, default is 1.

Fitting Connection

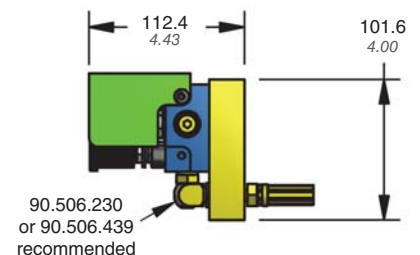
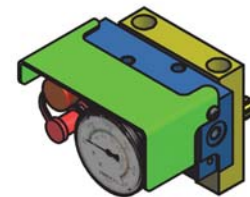
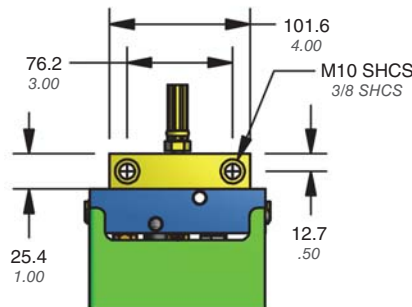
N = No Fitting Supplied,
M = Manifold Seal,
S = ORFS Fitting,
D = D-24 Fitting,
B = Zip Fitting
When not specified, default is N.

NOTE: The 90.406.P2S is a direct replacement of DADCO's 90.406.03.

Riser Block

90.406.220

DADCO offers the 90.406.220 Riser Block for use with the Convertible Control Panel for maximum mounting versatility. It allows for easy mounting of the Control Panel to SMS® plates.



NEW!

Compact Control Panel

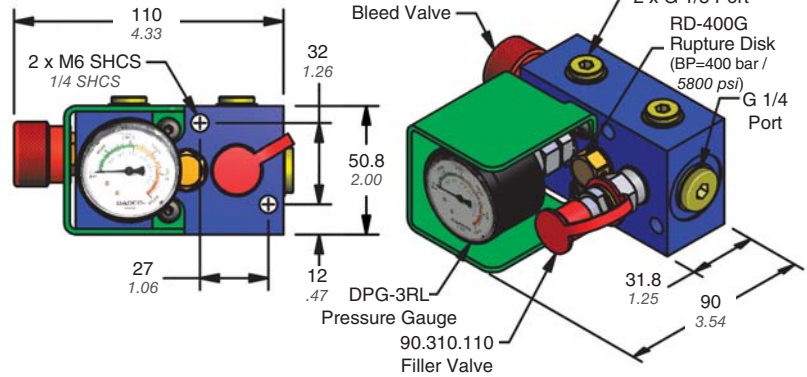
The DADCO Compact Control Panel is used to fill, drain and monitor the pressure of linked DADCO nitrogen gas springs from outside the die. The panel consists of two G 1/8 BSPP ports, a high pressure gauge, a quick disconnect fill valve, a bleed valve and a rupture disk to prevent overpressurization. To allow for connection to pressure monitors, the panel comes standard with a G 1/4 BSPP port. For pressure monitor options, see page 17.

Ordering Example:

90.405. P N

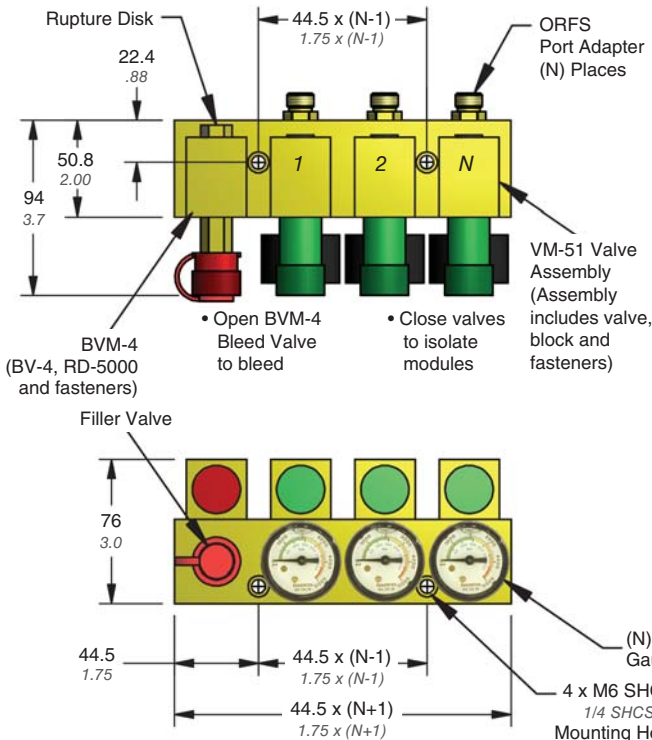
Mini Control Panel
Gauge Style
 PSI/Bar Gauge = P

Fitting Connection
 N = No Fitting Supplied,
 S = ORFS Fitting,
 D = D-24 Fitting,
 When not specified,
 default is N.



Multi Panel

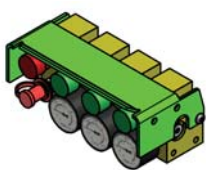
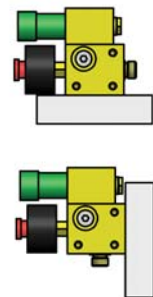
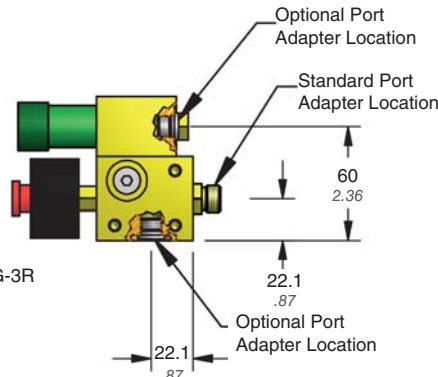
The DADCO Multi Panel features modules that may be filled, monitored, adjusted and vented from outside the die, either commonly or individually. No other control panel offers the advantages of the DADCO Multi Panel. For replacement parts refer to bulletin B04105B.



Features

- Each module features a simple two position valve for easy operation.
- Three port locations on each module give maximum piping flexibility.
- Each module is supplied with a straight service fitting.
 (For unused ports, DADCO recommends closing the module off before filling or using tube end caps, 90.506.112, on the unused port.)
- The panel can be flush mounted on the bottom or back.
- An optional tilt-guard protects all control valves and gauges during operation.

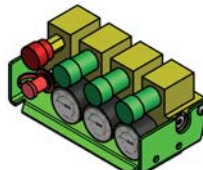
Mounting Options



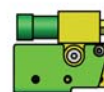
Top Guard – 90.402



Bottom Guard – 90.403



Both Guards – 90.404



Ordering Example:

90.401. 3.

Guard Location:
 Standard (No Guard) = 401, Top = 402,
 Bottom = 403, Both = 404

Number of Modules:
 2-6, 8 or 10

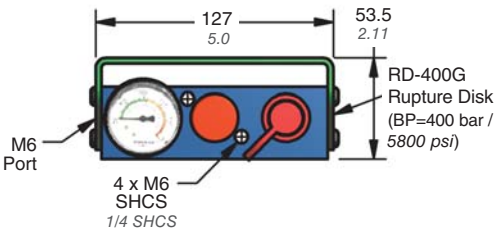
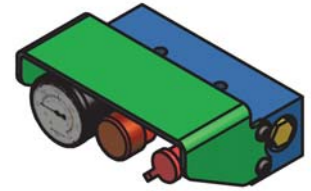
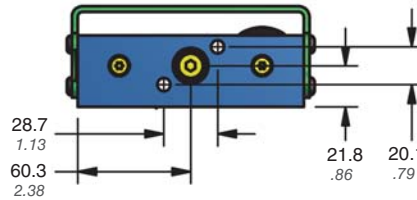
For optional reversed mounting, add R.

Components: Control Panels

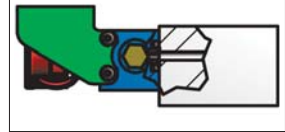
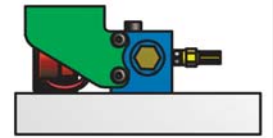
Mini Convertible Control Panel



The DADCO Mini Convertible Control Panel is used to fill, drain and monitor the pressure of linked DADCO nitrogen gas springs from outside the die. The panel is compatible with SMS-i® and traditional linked systems and has five M6 ports, a high pressure gauge, a quick disconnect fill valve, a bleed valve and a rupture disk to prevent overpressurization. To allow for maximum versatility when linking, the panel is available with a variety of fitting connections.



Mounting Options

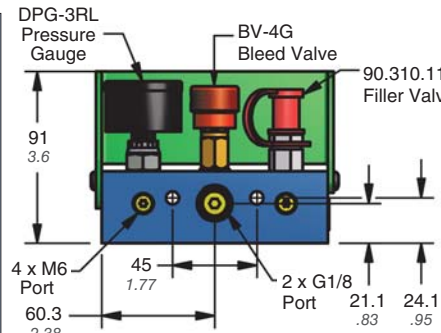


Ordering Example:

90.407. P N

Mini Control Panel
Gauge Style
PSI/Bar Gauge = P

Fitting Connection
N = No Fitting Supplied,
M = Manifold Seal,
S = ORFS Fitting,
D = D-24 Fitting,
L = MINILink® Fitting
When not specified,
default is N.

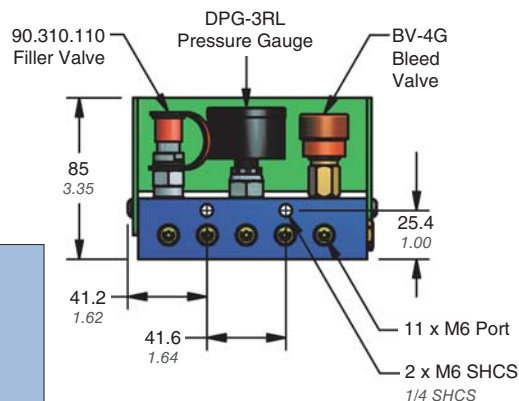
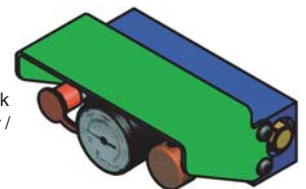
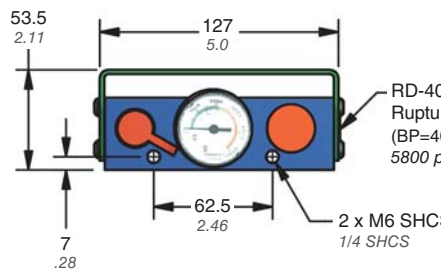


Mini Control Panel 90.407.11G

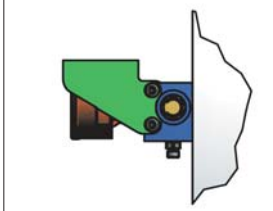
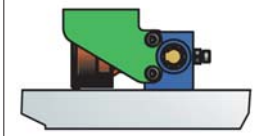
NEW!



The DADCO 90.407.11G Mini Control Panel is used to fill, drain and monitor the pressure of linked DADCO nitrogen gas springs from outside the die. The panel consists of eleven M6 ports, a high pressure gauge, a quick disconnect fill valve, a bleed valve and a rupture disk to prevent overpressurization. To allow for maximum versatility when linking, the panel also contains eleven different port locations.



Mounting Options



Ordering Example:

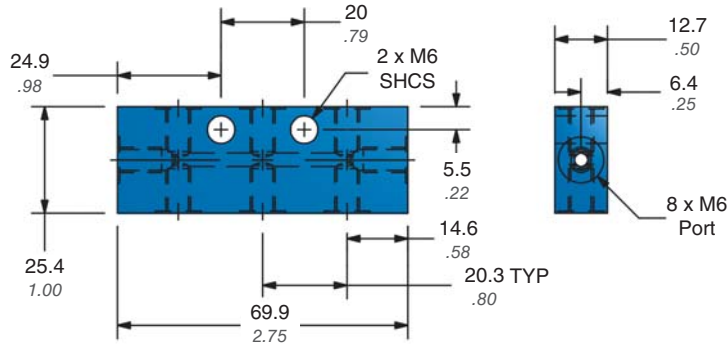
90.407. 11G

Mini Control Panel
Number of Ports

Mini Distribution Block

90.410.08

The Mini Distribution Block, with eight M6 port locations, is used with a Control Panel to simplify piping to multiple cylinders. Plug unused ports with 90.607.110 Port Plug.

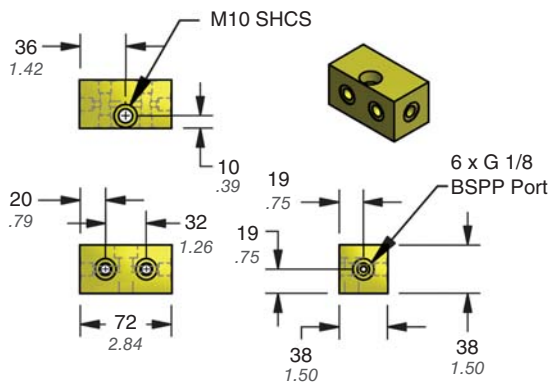


Large Distribution Blocks

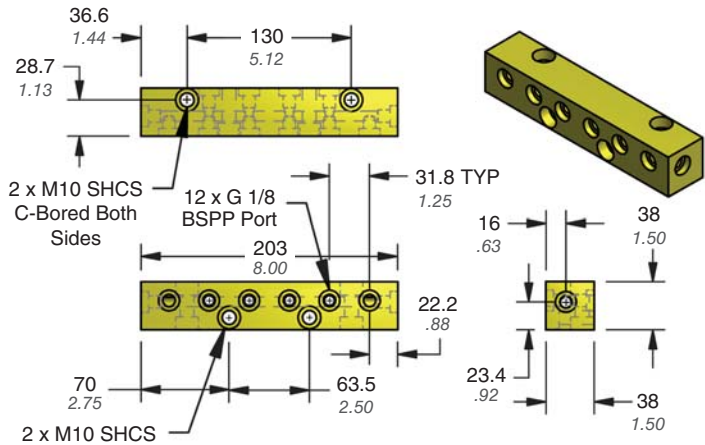
90.411.04 • 90.411.10 • 90.411.12

The Distribution Block is used with a Control Panel to simplify piping to multiple cylinders with a uniform system pressure. DADCO offers three Large Distribution Blocks with four, ten or twelve G 1/8 BSPP ports. DADCO advises plugging unused ports with 90.505.110 Flush Plugs before charging the system.

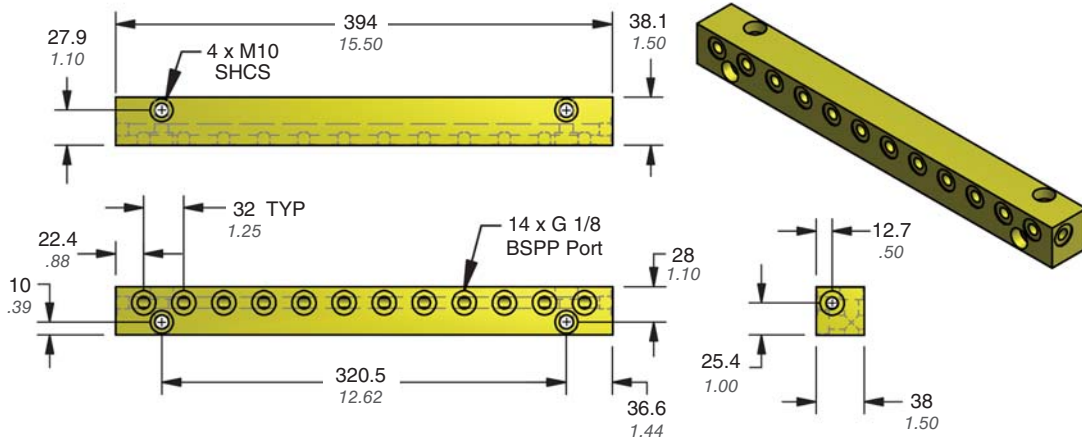
90.411.04



90.411.10



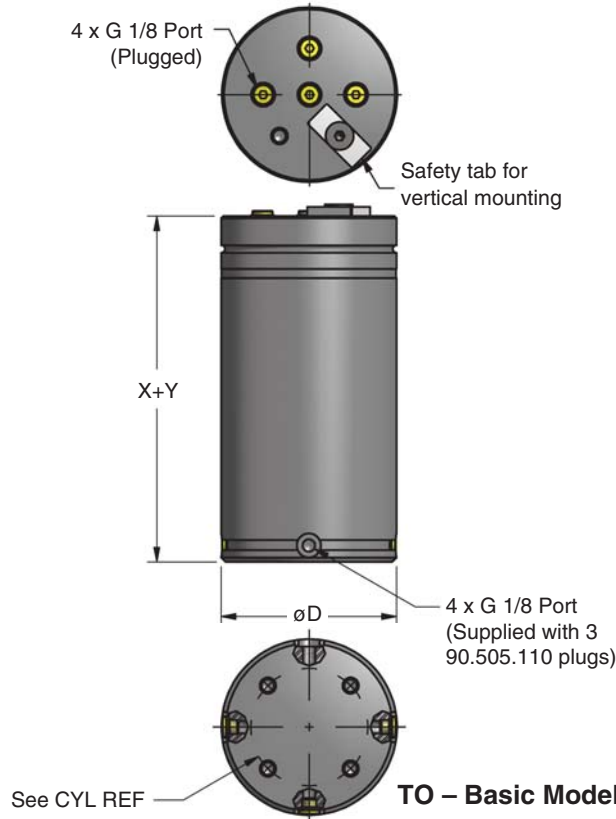
90.411.12



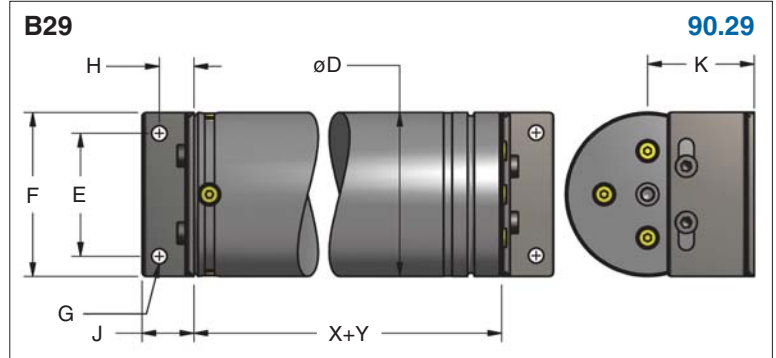
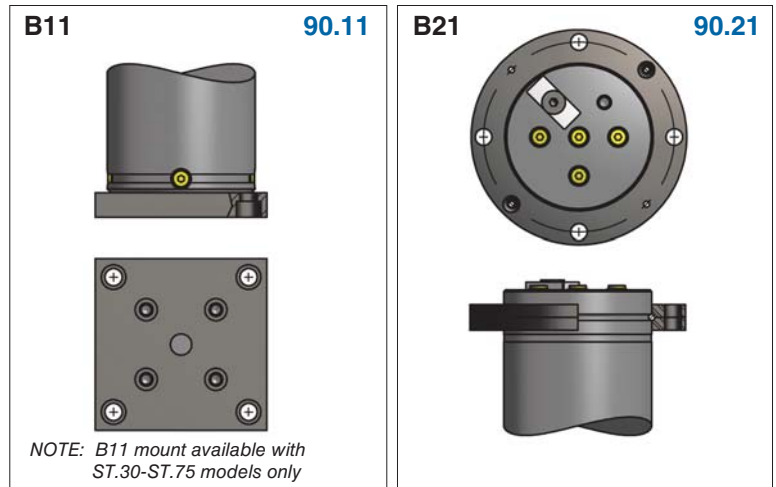
Components: Surge Tanks

DADCO surge tanks are used with open-flow systems to increase the volume in the system thereby reducing the pressure rise when cylinders are stroked. Both ends have multiple open ports supplied as standard for maximum flexibility when piping. Gauges and shut-off ball valves are available upon request.

For assistance in determining appropriate surge tank size for your system, contact DADCO with the cylinder size, length of stroke being used and amount of pressure rise desired. *DADCO 90.700 (Y-700) hose is generally not recommended for use with surge tanks due to restricted flow capability.*



Preferred Mounts for Surge Tanks.
See the 90.10 Catalog for mount details.



ST	30	50	75	100
X	117 4.61	137 5.39	152 5.98	157 6.18
Y	Volume of Tank L (in ³)			
50	0.59 1.97	0.99 36	1.62 60.4	2.89 98.8
100	0.84 3.94	1.38 51.4	2.23 84.4	3.96 136.3
150	1.09 5.91	1.78 66.7	2.85 108.4	5.03 173.8
200	1.34 7.87	2.17 82.1	3.46 132.4	6.10 211.3
250	1.60 9.84	2.56 97.4	4.08 156.4	7.17 248.8
300	1.85 11.81	2.96 112.7	4.69 180.4	8.24 286.3
400	N/A 15.74	3.74 —	5.92 228.4	10.38 633.7

Ex. ST.30.150 Vol. = 1.09L (67 in³)

Surge Tank	30	50	75	100
CYL REF	3000	5000	7500	10000
D	95 3.74	120 4.72	150 5.91	195 7.67
E	50 1.97	90 3.54	90 3.54	100 3.94
F	75 2.95	120 4.72	120 4.72	150 5.91
G	4 x M10 3/8	4 x M10 3/8	4 x M10 3/8	4 x M12 1/2
H	25.4 1.00	25.4 1.00	25.4 1.00	31.8 1.25
J	38 1.50	38 1.50	38 1.50	50.8 2.00
K	50.5 1.99	78 3.07	85 3.35	98.5 3.88

Ordering Example:

ST.30. 150. TO

Size:

30, 50, 75, 100

Length (Y):

50, 100, 150, 200, 250, 300, 400

Mount Option:

TO = Basic Model. When not specified, default is TO. Mount ordered with cylinder will be attached at factory. **NOTE:** B11 mount is only available with ST.30-ST.75 models.

MINIFLEX®

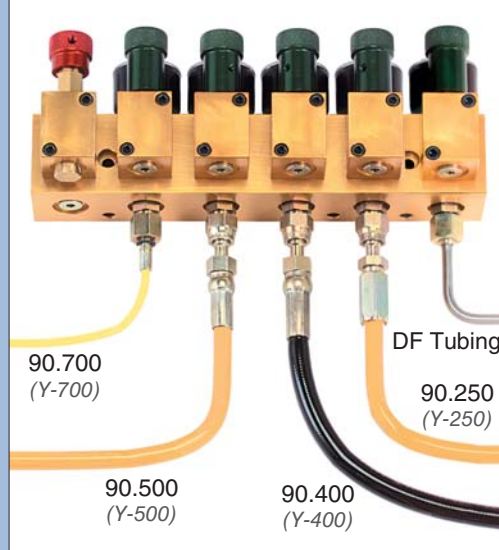
90.700 (Y-700) Hose

- + Offers the smallest possible bend radius available for flexible hose
- + Compatible with Mini, ORFS, D-24 and Zip style fittings
- Only permanent, crimped adapters available
- Cannot be linked with a surge tank

DADCOFLEX®

90.500 (Y-500) Hose

- + Higher working pressure than 90.250 (Y-250) without sacrificing bend radius or flow rate
- + Compatible with ORFS and D-24 style fittings
- + Can be linked with a surge tank
- Only permanent adapters available



DADCOFLEX®

90.400 (Y-400) Hose

- + Can withstand high pressures while maintaining a good flow rate
- + Can be linked with a surge tank
- Least flexible bend radius
- Can be used with permanent, crimped adapters only

DADCOFLEX®

90.250 (Y-250) Hose

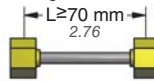
- + Accepts both reusable and permanent, crimped adapters
- + Assemble in field without additional tools using reusable adapters
- + Can be linked with a surge tank
- 190 bar (2750 psi) is maximum for surging pressure

DF Tubing

DF. _____
Length (mm)

- + Extremely durable
- + Compact
- Dimensions critical
- No Flexibility

DF Tubing Minimum Length



NOTE: To order straight lengths of DF Tubing, use the part number to the left. For curved pieces, it is necessary to provide a drawing. Request Bulletin B02118B for more information.

Part No.	OD	ID	Working Pressure	Burst Pressure	Bend Radius	Crimp Die
90.700 (Y-700)	5.3 .21	2.3 .09	413 bar 6000 psi	1655 bar 24000 psi	6.4 .25	Mini-Crimp 90.710.1 No Ring Required
90.500 (Y-500)	11 .43	5 .19	345 bar 5000 psi	1380 bar 20000 psi	38 1.50	80C-P03 Gray Die 82C-R01 Ring
90.400 (Y-400)	13 .51	6.5 .25	345 bar 5000 psi	1380 bar 20000 psi	50 1.97	80C-P04 Red Die 82C-R01 Ring
90.250 (Y-250)	12 .47	6.4 .25	190 bar 2750 psi	758 bar 11000 psi	38 1.50	80C-P04J Red Die 82C-R01 Ring
DF Tubing	6.4 .25	4.5 .18	260 bar 3750 psi	1000 bar 15000 psi	15.9 .625	Assembly at DADCO

DADCO offers hydraulically or pneumatically operated crimping units, turn to page 18 for more information.

Hose Assembly

A DADCO hose assembly consists of a length of hose with a hose adapter on each end. Refer to bulletin 99B105D for more information on ordering a hose assembly.

Hose Assembly

Ordering Example: **90.500. S843. S854. 600. I**

Hose Type _____
(700, 500, 400 or 250)

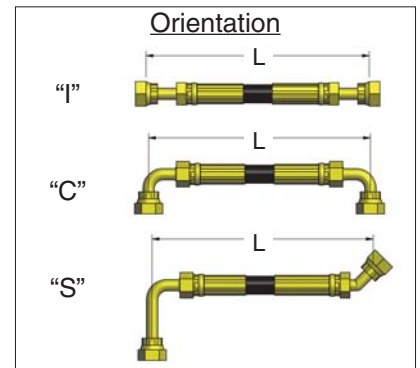
Hose Adapters _____

Sealing Type	Example
ORFS	S943
D-24	D843
Mini	L943
Zip	B943

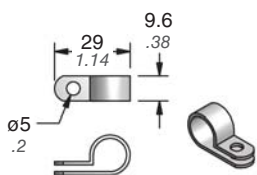
Reference appropriate sealing type prefix (S, D, L or B).

Orientation
Hose adapter
orientation:
I, C or S

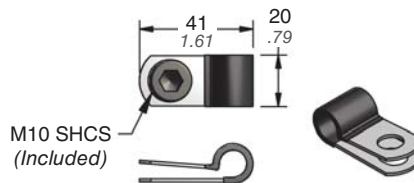
Length of Hose
Assembly (L) in mm
Distance between
sealing faces



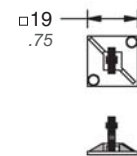
Hose Straps



90.504.250
(HS-250)



90.504.400

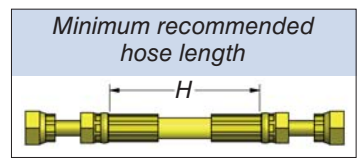


90.600.250
(L-250)

Permanent
adhesive
strap, clean
surface
required.

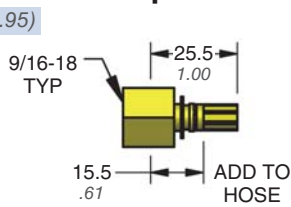
Components: ORFS Hose Adapters

DADCO was the first gas spring manufacturer to offer 9/16-18 o-ring face seals (ORFS). DADCO's ORFS fittings prevent any loss of high pressure nitrogen gas by providing elastomeric seals at every joint. DADCO recommends using DADCO brand hoses featured on page 10 with the adapters shown throughout this catalog. If the length of hose required is less than the H Value, use DF Tubing (page 10) or Solid Hose Fittings (page 12).

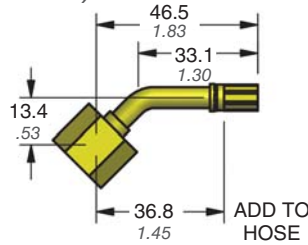


Permanent Hose Adapters for 90.700 (Y-700)

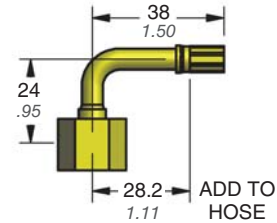
H Value = 75 (2.95)



90.504.943
(S-943)
Straight Swivel



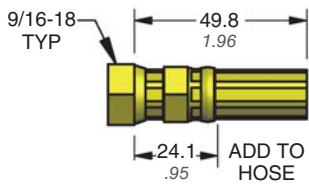
90.504.954
(S-954)
45° Swivel



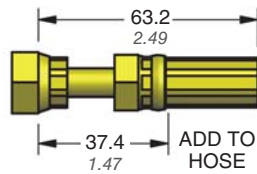
90.504.959
(S-959)
90° Swivel

Permanent Hose Adapters for 90.500 (Y-500)

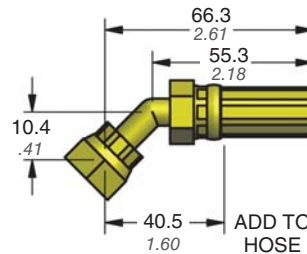
H Value = 80 (3.15)



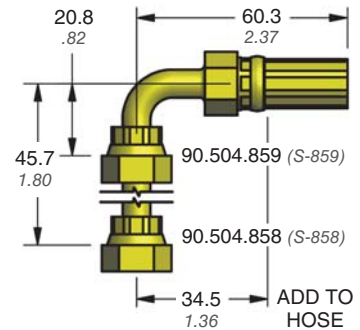
90.504.843
(S-843)
Compact Swivel



90.504.851
(S-851)
Retractable Swivel



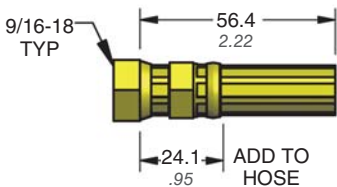
90.504.854
(S-854)
45° Female Face Seal



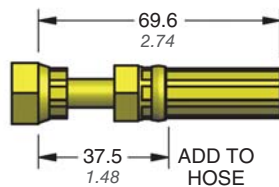
90.504.859 (S-859) Short Neck
90.504.858 (S-858) Long Neck

Permanent Hose Adapters for 90.250 or 90.400 (Y-250 or Y-400)

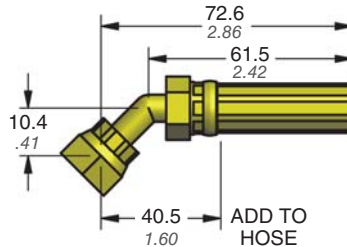
H Value = 85 (3.35)



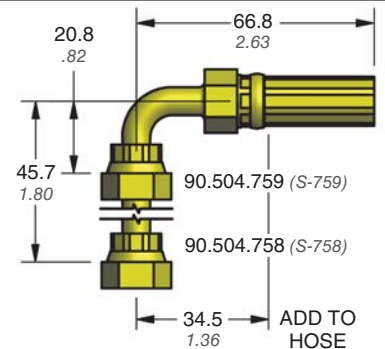
90.504.743
(S-743)
Compact Swivel



90.504.751
(S-751)
Retractable Swivel



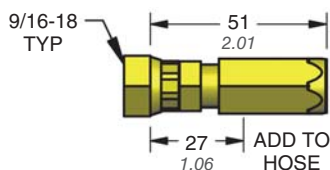
90.504.754
(S-754)
45° Female Face Seal



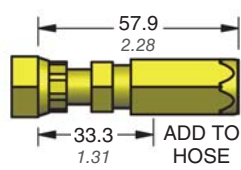
90.504.759 (S-759) Short Neck
90.504.758 (S-758) Long Neck

Reusable Hose Adapters for 90.250 (Y-250)

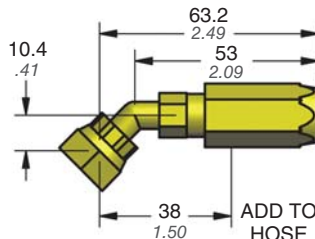
H Value = 85 (3.35)



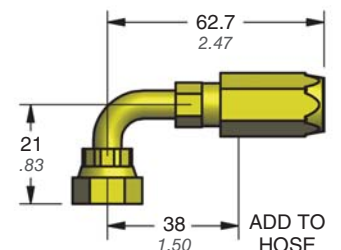
90.504.643
(S-643)
Compact Swivel



90.504.651
(S-651)
Retractable Swivel



90.504.654
(S-654)
45° Female Face Seal



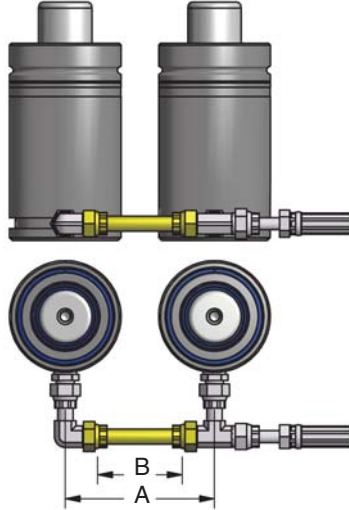
90.504.659
(S-659)
90° Female Face Seal

Solid Hose Fittings

Solid hose fittings come in predetermined lengths and are ideal for limited space applications. They can replace traditional hose assemblies, particularly when the length of hose required is shorter than DADCO's recommended minimum hose length (see H Values on page 11). For custom lengths of solid hose, see DF Tubing on page 10.

Metric

Part No.	A	B
90.503.xxxx (S-9xxx)	mm	A - 43.2
9075	75	31.8
9100	100	56.8
9120	120	76.8
9125	125	81.8
9130	130	86.8
9140	140	96.8
9150	150	106.8

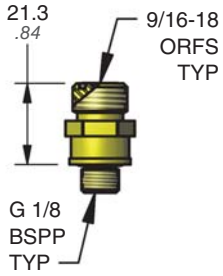


English

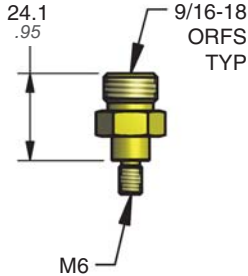
Part No.	A	B
90.503.xxx (S-8xx)	in.	A - 1.70
830	3.00	1.30
832	3.25	1.55
835	3.50	1.80
837	3.75	2.05
840	4.00	2.30
845	4.50	2.80
850	5.00	3.30
855	5.50	3.80
860	6.00	4.30

Port Adapters

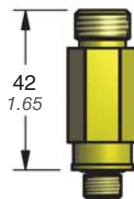
DADCO's O-Ring Face Seal (ORFS) Fittings have elastomeric seals at every joint.



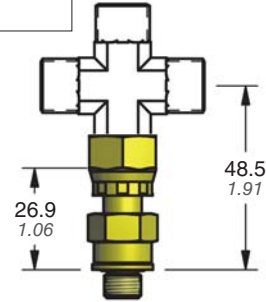
90.505.115
(S-115)
Straight



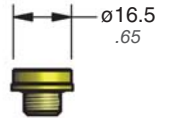
90.505.116
(S-116)
M6 → 9/16-18



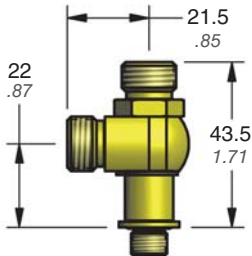
90.505.117
(S-117)
Extended Straight



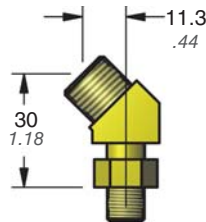
90.505.121
(S-121)
Swivel Straight



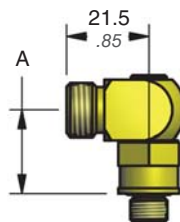
90.505.110
(G-109)
Flush Plug



90.505.438
(S-438)
Run Tee

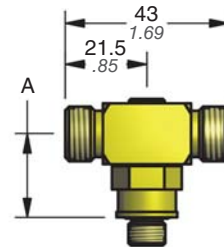


90.505.330
(S-330)
45° Elbow



90.506.230
(S-230)
90° Swivel

Part No.	A
90.506.230	22 .87
90.506.240	36 1.42
90.506.250	43 1.69



90.506.439
(S-439)
Branch Tee

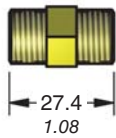
Part No.	A
90.506.439	22 .87
90.506.449	36 1.42
90.506.459	43 1.69

Components: ORFS Fittings

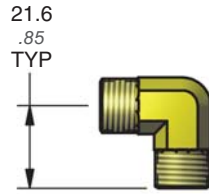
Fittings



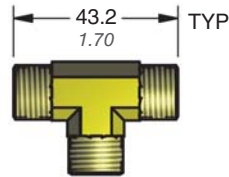
90.506.112
(S-112)
Tube End Cap



90.506.303
(S-303)
Union



90.506.201
(S-201)
Elbow

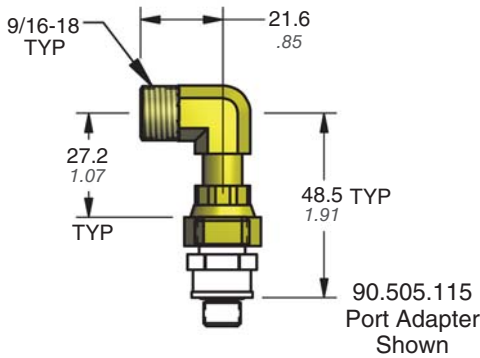


90.506.401
(S-401)
Tee

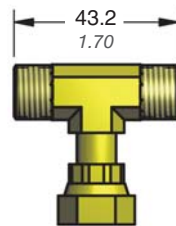


90.506.501
(S-501)
Cross

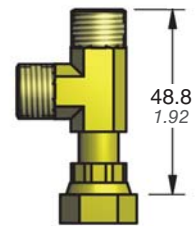
Standard Swivel Nut Fittings



90.506.221
(S-221)
90° Elbow

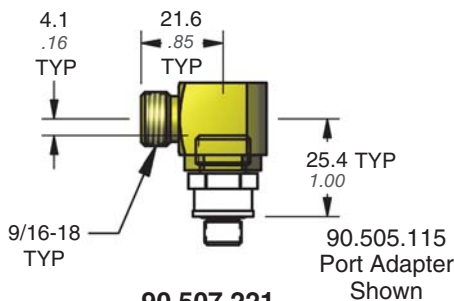


90.506.433
(S-433)
Branch Tee

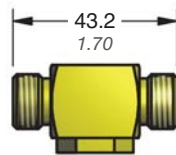


90.506.432
(S-432)
Run Tee

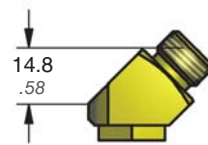
Compact Swivel Nut Fittings



90.507.221
(SJ-221)
90° Elbow

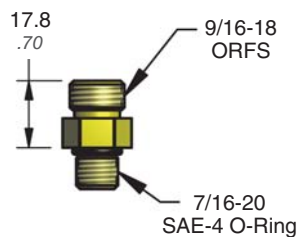


90.507.433
(SJ-433)
Branch Tee



90.507.321
(SJ-321)
45° Elbow

Retrofit Port Adapters

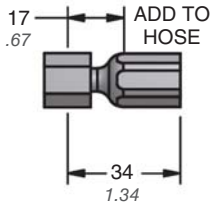
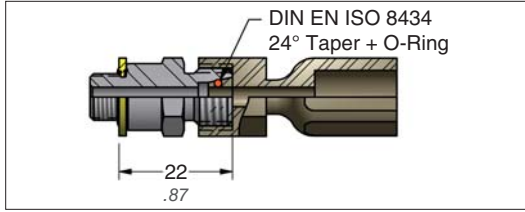


90.505.120
(S-120)
Port Adapter

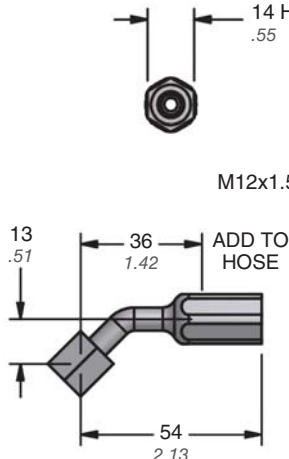


90.505.104
(D-104)
Flush Plug

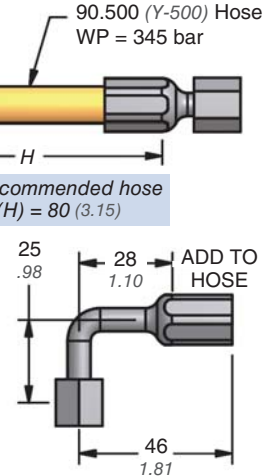
D-24 Hose System with 90.500 (Y-500)



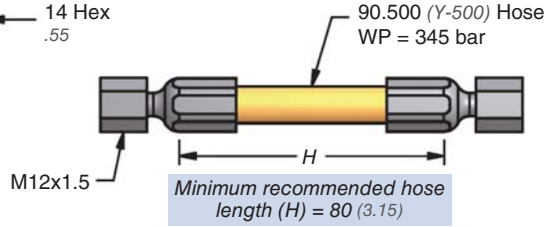
90.508.843 (D-843)
Compact Hose Adapter



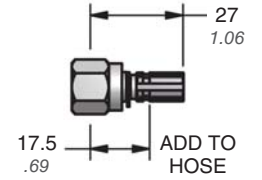
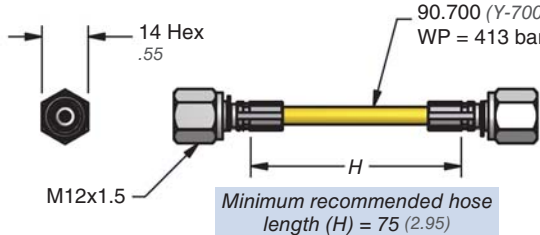
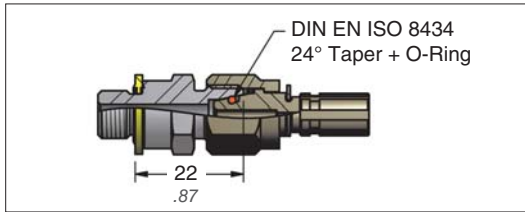
90.508.854 (D-854)
45° Hose Adapter



90.508.858 (D-858)
90° Hose Adapter



D-24 Hose System with 90.700 (Y-700)

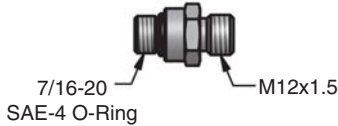


90.508.943 (D-943)
Compact Hose Adapter

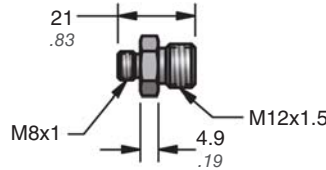
Fittings



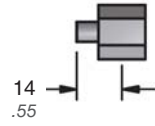
90.508.115 (D-115)
Port Adapter



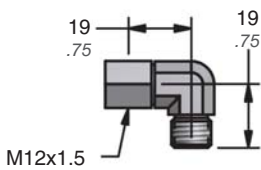
90.508.120 (D-120)
Port Adapter



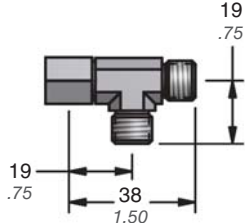
90.508.607 (D-607)
Reducing Union



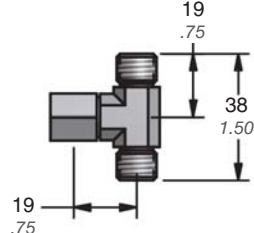
90.508.112 (D-112)
Tube End Cap



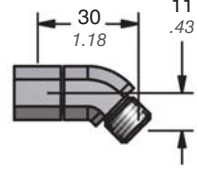
90.508.221 (D-221)
90° Elbow



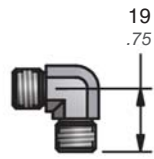
90.508.432 (D-432)
Run Tee



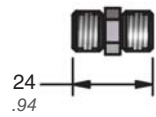
90.508.433 (D-433)
Branch Tee



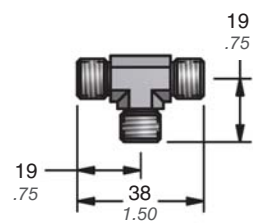
90.508.321 (D-321)
45° Elbow



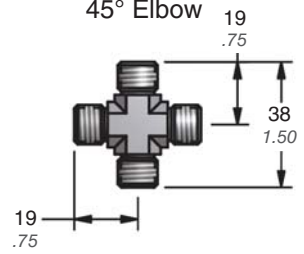
90.508.201 (D-201)
Elbow



90.508.303 (D-303)
Union



90.508.401 (D-401)
Tee

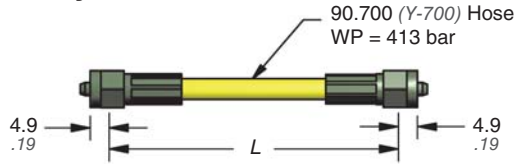


90.508.501 (D-501)
Cross

Components: **MINILink®** Fittings

MINIFLEX® Hose System

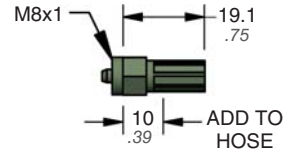
90.700 (Y-700)



Minimum recommended distance between sealing faces (L) = 75 (2.95)

90.700.L943.L943.____.I
L

Hose Assembly



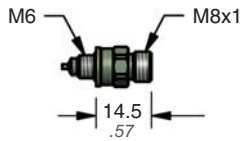
90.601.943

(L-943)

Permanent Hose Adapter

MINILink® Fittings

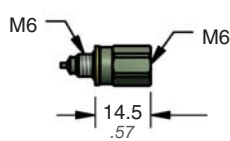
Micro Series (C.045 – C.250) Port Adapters



90.607.122

(L-122)

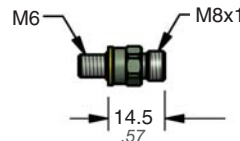
Micro Service Fitting



90.607.038

(L-38)

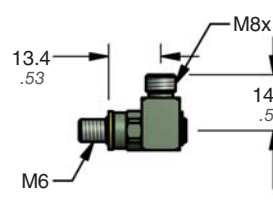
Micro Port Adapter Extension



90.607.120

(L-120)

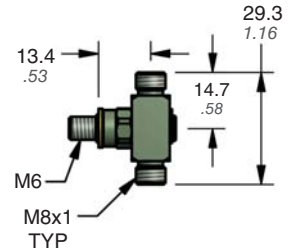
Straight Port Adapter



90.607.220

(L-220)

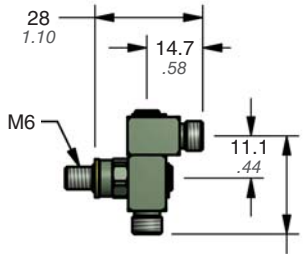
90° Port Adapter



90.607.429

(L-429)

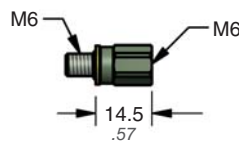
Branch Tee Port Adapter



90.607.428

(L-428)

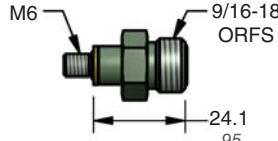
Run Tee Port Adapter



90.607.035

(L-35)

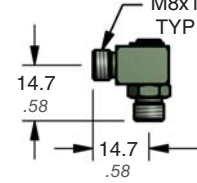
Port Adapter Extension



90.505.116

(S-116)

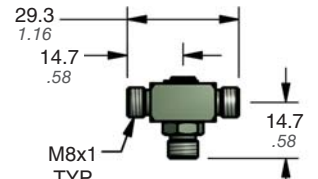
Reducer
M6 → 9/16-18



90.607.201

(L-201)

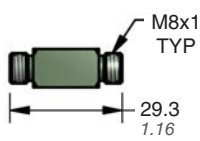
Elbow



90.607.401

(L-401)

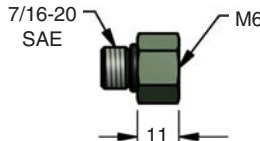
Union Tee



90.606.303

(L-303)

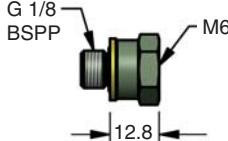
Union



90.607.055

(L-55)

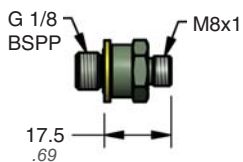
Reducer
7/16-20 → M6



90.607.065

(L-65)

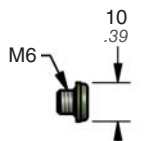
Reducer
G 1/8 → M6



90.607.115

(L-115)

Reducer
G 1/8 → M8x1



90.607.110

(L-110)

Port Plug

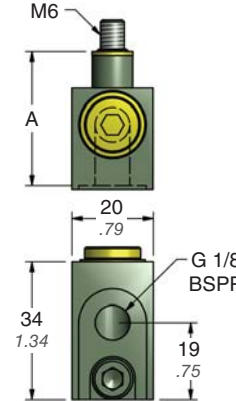


90.605.109

(L-109)

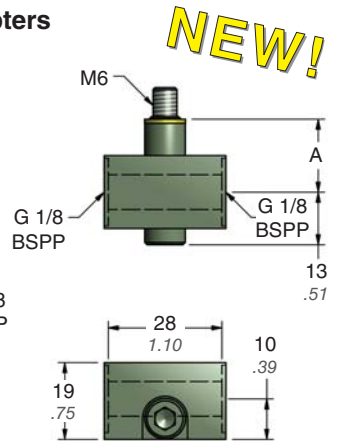
Fitting Plug

M6 → G 1/8 Port Adapters



Straight

Part No.	A
90.607.116	33 1.30
90.607.126	46 1.81



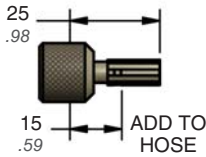
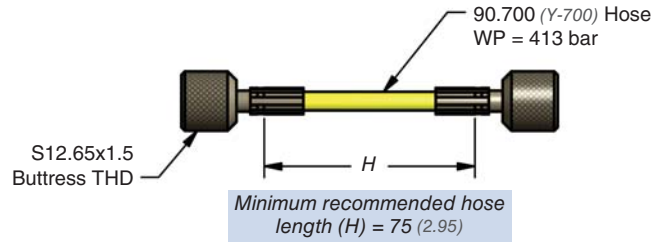
Branch Tee

Part No.	A
90.607.439	18 .71
90.607.449	31 1.22

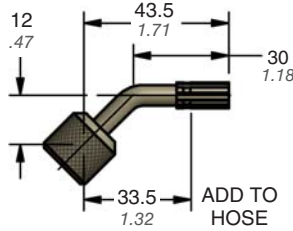
NEW!

Components: Zip (CNOMO) Fittings

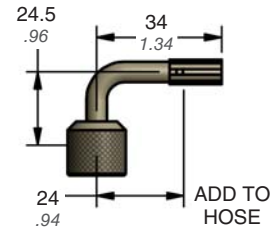
Zip Hose System with 90.700 (Y-700)



90.804.943
(B-943)
Straight Hose Adapter

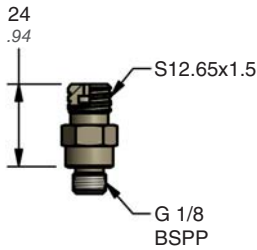


90.804.954
(B-954)
45° Hose Adapter

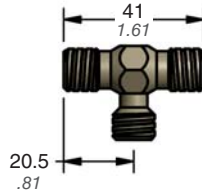


90.804.959
(B-959)
90° Hose Adapter

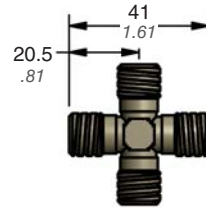
Fittings



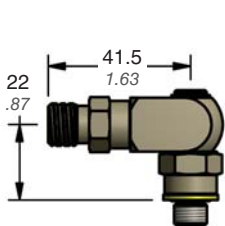
90.805.115
(B-115)
Port Adapter



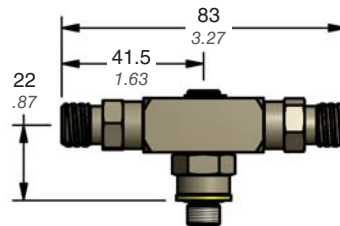
90.806.401
(B-401)
Tee



90.806.501
(B-501)
Cross



90.806.230
(B-230)
Angle Swivel Adapter

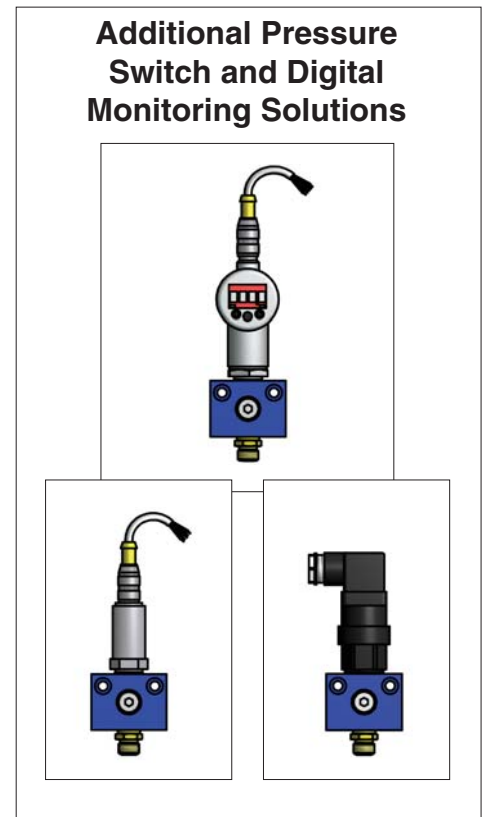
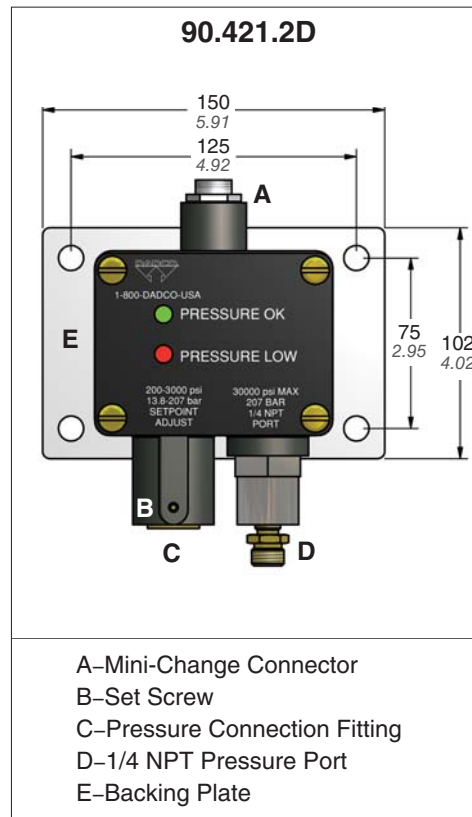
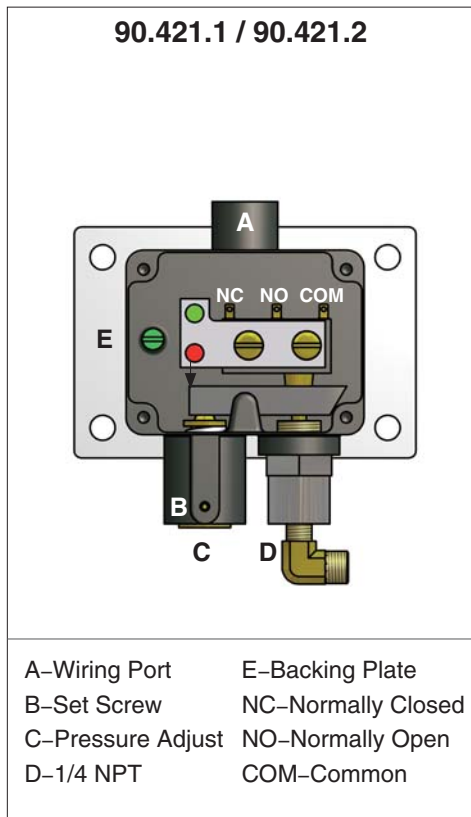


90.806.439
(B-439)
Two-Way Swivel Adapter

Components: Pressure Monitors

The DADCO Pressure Monitor indicates if pressure drops below a preset level, alerting the press controller to shut down the press. The shutdown point is adjustable between 15 and 200 bar (220 – 3000 psi). The monitor indicates a green light if the pressure is at or above the minimum operating pressure or red if below the minimum operating pressure. The 90.421.2D is also capable of shutting the press down if it drops below the minimum operating pressure. For more information, refer to the following bulletins: B00136 for 90.421.1, B01115A for 90.421.2 and B00134 for 90.421.2D.

Part No.	Supply Power	Switch Type	Connection	Pressure Range
90.421.1 (DPM-1)	120 VAC	SPDT	1/2 NPS	15 – 200 bar 220 – 3000 psi
90.421.2 (DPM-2)	24 VDC	SPDT	1/2 NPS	15 – 200 bar 220 – 3000 psi
90.421.2D (DPM-2D)	24 VDC	SPDT Relay	Male Brad-Harrison 4-Pin Mini-Change Connector	15 – 200 bar 220 – 3000 psi



Ordering Example:

90.421.2D. *BH1. BP. 102

Volt / Switch: _____
90.421.1, 90.421.2 or
90.421.2D

Connector: _____
BH1 – 90° Connector
BH3 – Straight Connector

(*Connector options are for 90.421.2D Model only.)

Fitting: _____
90.505.102 – Straight Fitting
90.505.202 – 90° Fitting

Backing Plate
(optional)

DADCO offers a variety of pressure switches and digital monitoring options. The three drawings above represent a sampling of the different configurations available using a sensor base with fitting, attached to a pressure switch and cable option. For more information, contact DADCO.

Tools for Hose Assembly Construction

Hose Cutter HC-11

Used to cut hose to appropriate length. For more information, request bulletin B00120B.



Hose Assembly Clamp HAC

Used to secure hose while installing hose adapter. For more information, request bulletin B00120B.



Portable Crimping Unit 90.720

Used with appropriate die ring to create permanent hose assemblies. For more information, request bulletin B04112.



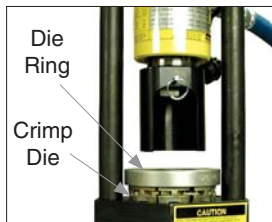
Mini-Crimp 90.710.1

Used in a crimping machine to construct hose assemblies using *MINIFLEX*® 90.700 (Y-700) hose. For more information, see below or request bulletin B00106B.



Crimp Dies

Used in Portable Crimping Unit to construct hose assemblies. For information on constructing hose assemblies, refer to bulletins B00120B and B00109B.



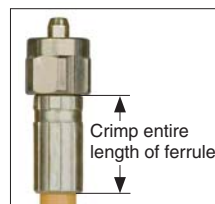
Part No.	Crimp Die	Crimp Diameter mm / inch
90.700 (Y-700)	Mini-Crimp 90.710.1 No Ring Required	7.04 – 7.29 .277 – .287
90.500 (Y-500)	80C-P03 Gray Die 82C-R01 Ring	12.19 – 12.70 .480 – .500
90.400 (Y-400)	80C-P04 Red Die 82C-R01 Ring	14.22 – 14.73 .560 – .580
90.250 (Y-250)	80C-P04J Red Die 82C-R01 Ring	13.59 – 14.10 .535 – .555

Using DADCO's Mini-Crimp

1. Place the Mini-Crimp 90.710.1 into the crimping machine. No die ring is required.

2. Insert the hose assembly from below through the center of the Mini-Crimp 90.710.1 (F.1). For instructions on constructing a *MINILink*® Hose Assembly request bulletin B00109B.

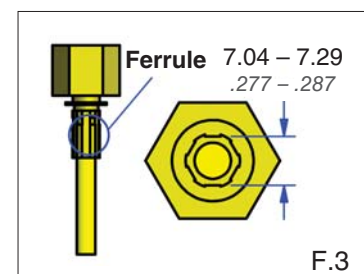
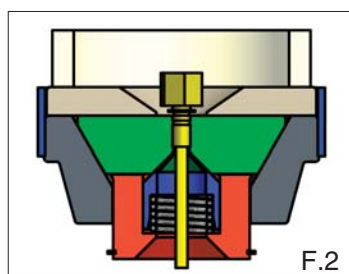
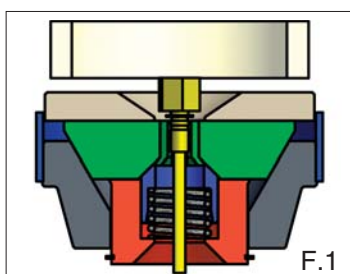
3. Activate the hydraulic or pneumatic crimping machine to permanently crimp fitting to the hose (F.1).



4. As the DADCO Mini-Crimp begins to close, position the fitting to ensure the entire length of the ferrule is crimped (F.2).

5. Remove completed hose assembly from the Mini-Crimp 90.710.1.

6. Measure the crimped ferrule diameter across the flats to verify it is within the crimp dimension range (F.3).



Charging Accessories

**Quick Disconnect Charging Assembly
90.310.040**

Use the DADCO Quick Disconnect Charging Assembly, 90.310.040, with the 90.310.143 or 90.310.111 Charging Nipple or the 90.315.5 Pressure Analyzer to charge self-contained gas springs. The 90.310.040 can also be used with a DADCO control panel to charge linked systems.

The 90.310.040 includes the 90.310.201 Pressure Regulator, 90.310.252 Hose Assembly and the 90.310.338 Quick Disconnect Filling Assembly.

DADCO recommends using the 90.310.041 High Pressure Charging Assembly to charge Micro Series, SCR Series and U.0175 – U.0400 nitrogen gas springs to maximum pressure.



**Quick Disconnect
Charging Nipple
90.310.143 (M6 Port)
90.310.111 (G 1/8 Port)**

Use the appropriate Quick Disconnect Charging Nipple to charge DADCO Nitrogen Gas Springs.



90.310.143



90.310.111

**DADCO Tank Analyzer
90.316.1**

The DADCO Tank Analyzer, 90.316.1, easily threads onto a standard pressure nitrogen tank with a CGA-580 thread to verify available pressure. It includes a gauge and a bleed valve. Contact DADCO for more information.



Safety Plates

DADCO recommends customers identify tools containing high pressure nitrogen gas springs to ensure proper handling of the cylinders. DADCO offers several caution tags to meet specific application needs. For more information request bulletin B01130A.



**Nitrogen Gas Booster
DGB-150**

DADCO's Nitrogen Gas Booster System, DGB-150, is an all-in-one solution to the problems of low pressure supply tanks and lost nitrogen gas during discharge. For more information on the booster, refer to bulletin B07101.



Complete Linked System Solutions



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The global leader in nitrogen gas spring technology

43850 Plymouth Oaks Blvd. • Plymouth, Michigan • 48170 • USA

734.207.1100 • 800.DADCO.USA • fax 734.207.2222 • www.dadco.net