

**Premium
High-
Performance
Pilots**

VERSATM
plus



Global leader in
providing fabrication and
stamping solutions

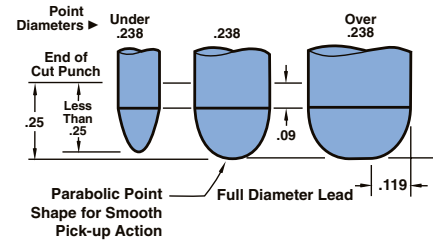
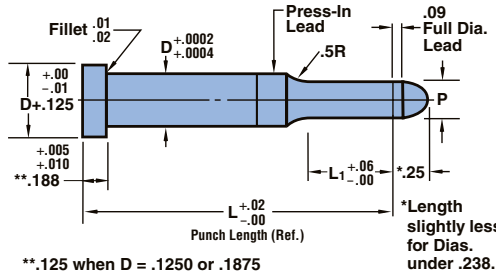
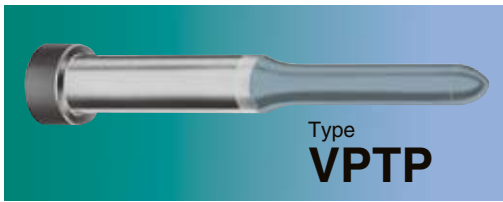
www.daytonprogress.com

**Smoother
pick-up
action,
less hole
distortion**



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Regular Pilots



Material

All heads are drawn to RC 40-55. Proprietary high-performance material and treatment

P Tolerance $\pm\frac{.0002}{.0006}$ P to D $\begin{matrix} .0003 \\ \text{C} \end{matrix}$
When P=D, shank tolerance applies.

Features/Benefits

Regular Versa/plus™ pilots are built to exact tolerances; the parabolic point shape allows for smooth pick-up action; and pilots offer a wide range of unique punching and fabrication applications.

HOW TO ORDER

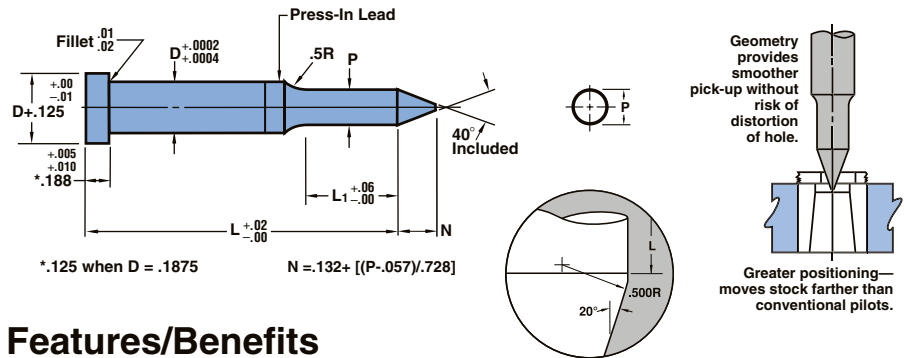
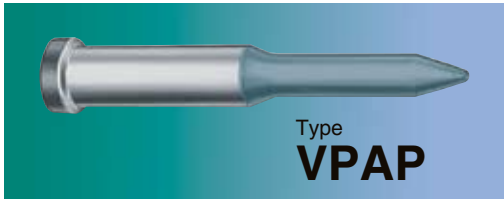
Specify:	Qty.	Type	D Code	L	P Dimension
Example:	3	VPTP	37	100200	P.251
	2	VPTP	43	075250	P.300



Pilots 5 Days

Shank D	Point Lgth. L ₁ Code	Round		L																											
		Min. XP	Range P	1.50	1.75	2.00	2.25	2.50	2.75	3.00	3.25	3.50	3.75	4.00	4.25	4.50	4.75	5.00	5.25	5.50	5.75	6.00	6.25	6.50	6.75	7.00					
.1250	12	.50	.050	.061 - .1250																											
.1875	18		.050	.061 - .1875																											
.2500	25		.061	.061 - .2500																											
.3125	31		.061	.092 - .3125																											
.3750	37		.061	.124 - .3750																											
.4375	43		.092	.186 - .4375	050150	050175	050200	050225	050250	050275	050300	050325	050350	050375	050400																
.5000	50		.124	.224 - .5000												050425	050450	050475	050500												
.6250	62		.234	.309 - .6250																050525	050550	050575	050600								
.7500	75		.299	.389 - .7500																											
.8750	87		.349	.439 - .8750																											
1.0000	100	.399	.484 - 1.0000																												
.1250	12	.75	.057	.061 - .1250																											
.1875	18		.057	.061 - .1875																											
.2500	25		.061	.061 - .2500																											
.3125	31		.061	.092 - .3125																											
.3750	37		.061	.124 - .3750																											
.4375	43		.092	.186 - .4375																											
.5000	50		.124	.224 - .5000												075425	075450	075475	075500												
.6250	62		.234	.309 - .6250																075525	075550	075575	075600								
.7500	75		.299	.389 - .7500																											
.8750	87		.349	.439 - .8750																											
1.0000	100	.399	.484 - 1.0000																												
.1250	12	1.00	.074	.092 - .1250																											
.1875	18		.074	.092 - .1875																											
.2500	25		.079	.092 - .2500																											
.3125	31		.092	.092 - .3125																											
.3750	37		.092	.124 - .3750																											
.4375	43		.092	.186 - .4375																											
.5000	50		.124	.224 - .5000												100425	100450	100475	100500												
.6250	62		.234	.309 - .6250																100525	100550	100575	100600								
.7500	75		.299	.389 - .7500																											
.8750	87		.349	.439 - .8750																											
1.0000	100	.399	.484 - 1.0000																												
.1875	18	1.25	.092	.124 - .1875																											
.2500	25		.092	.124 - .2500																											
.3125	31		.092	.124 - .3125																											
.3750	37		.124	.124 - .3750																											
.4375	43		.124	.186 - .4375																											
.5000	50		.124	.224 - .5000												125250	125275	125300	125325	125350	125375	125400									
.6250	62		.234	.309 - .6250																											
.7500	75		.299	.389 - .7500																											
.8750	87		.349	.439 - .8750																											
1.0000	100		.399	.484 - 1.0000																											

Positive Pick-Up Pilots



Material

All heads are drawn to RC 40-55.
Proprietary high-performance material and treatment

P Tolerance $\pm \frac{.0002}{.0000}$ P to D $\frac{.0003}{\text{C}}$

When P=D, Tolerance is $\pm \frac{.0002}{.0004}$
When P=D, shank tolerance applies.

Features/Benefits

Dayton Versa/plus™ Positive Pick-Up Pilots provide smoother pick-up without the risk of distorting the hole; in addition, the unique design moves the stock farther than conventional pilots.

HOW TO ORDER

Specify:	Qty.	Type	D Code	L	P Dimension
Example:	6	VPAP	100	100400	P.749

Order any length within ranges in the chart. XL (overall length shortened) is available at no charge within catalog range. Standard L₁ length is maintained.



Shank D	Code	Point L ₁	Round Min. XP	Range P	Max. N	L																			
						2.00	2.25	2.50	2.75	3.00	3.25	3.50	3.75	4.00	4.25	4.50	4.75	5.00	5.25	5.50	5.75	6.00	6.25	6.50	6.75
.1875	18	.50	.050	.061 - .1875	.18																				
.2500	25	.50	.061	.061 - .2500	.25																				
.3125	31	.50	.061	.092 - .3125	.31																				
.3750	37	.50	.061	.124 - .3750	.37																				
.4375	43	.50	.092	.186 - .4375	.43																				
.5000	50	.50	.124	.224 - .5000	.50	050200	050225	050250	050275	050300	050325	050350	050375	050400	050425	050450	050475	050500	050525	050550	050575	050600			
.6250	62	.50	.234	.309 - .6250	.62																				
.7500	75	.50	.299	.389 - .7500	.75																				
.8750	87	.50	.349	.439 - .8750	.87																				
1.0000	100	.50	.399	.484 - 1.0000	1.00																				
.1875	18	.75	.057	.061 - .1875	.18																				
.2500	25	.75	.061	.061 - .2500	.25																				
.3125	31	.75	.061	.092 - .3125	.31																				
.3750	37	.75	.061	.124 - .3750	.37																				
.4375	43	.75	.092	.186 - .4375	.43																				
.5000	50	.75	.124	.224 - .5000	.50	075200	075225	075250	075275	075300	075325	075350	075375	075400	075425	075450	075475	075500	075525	075550	075575	075600			
.6250	62	.75	.234	.309 - .6250	.62																				
.7500	75	.75	.299	.389 - .7500	.75																				
.8750	87	.75	.349	.439 - .8750	.87																				
1.0000	100	.75	.399	.484 - 1.0000	1.00																				
.1875	18	1.00	.074	.092 - .1875	.18																				
.2500	25	1.00	.079	.092 - .2500	.25																				
.3125	31	1.00	.092	.092 - .3125	.31																				
.3750	37	1.00	.092	.124 - .3750	.37																				
.4375	43	1.00	.092	.186 - .4375	.43																				
.5000	50	1.00	.124	.224 - .5000	.50																				
.6250	62	1.00	.234	.309 - .6250	.62																				
.7500	75	1.00	.299	.389 - .7500	.75																				
.8750	87	1.00	.349	.439 - .8750	.87																				
1.0000	100	1.00	.399	.484 - 1.0000	1.00																				
.1875	18	1.25	.074	.092 - .1875	.18																				
.2500	25	1.25	.079	.092 - .2500	.25																				
.3125	31	1.25	.092	.092 - .3125	.31																				
.3750	37	1.25	.092	.124 - .3750	.37																				
.4375	43	1.25	.092	.186 - .4375	.43																				
.5000	50	1.25	.124	.224 - .5000	.50																				
.6250	62	1.25	.234	.309 - .6250	.62																				
.7500	75	1.25	.299	.389 - .7500	.75																				
.8750	87	1.25	.349	.439 - .8750	.87																				
1.0000	100	1.25	.399	.484 - 1.0000	1.00																				

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

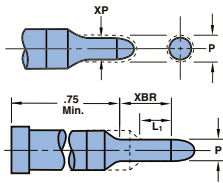
Standard Alterations—Pilots



Standard Alterations

Pilots are available in sizes other than those shown in this flyer and in the product catalogs.

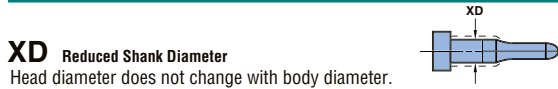
Regular Pilots



XP P Dimension
Smaller than Standard

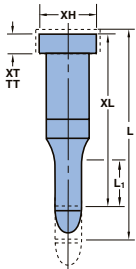
XBR Point Length
Longer than Standard

Point Length	XBR				
	.500-.750	.751-1.000	1.001-1.250	1.251-1.500	1.501-1.625
Code Type	Min. P (Rounds)				
12 VPPT	.050	.057	.074		
18 VPPT	.050	.057	.074	.092	
25 VPPT	.061	.061	.079	.092	
31 VPPT	.061	.061	.092	.124	.124
37 VPPT	.061	.061	.092	.124	.124
43 VPPT	.092	.092	.092	.124	.124
50 VPPT	.124	.124	.124	.124	.124
62 VPPT	.234	.234	.234	.234	.234
75 VPPT	.299	.299	.299	.299	.299
87 VPPT	.349	.349	.349	.349	.349
100 VPPT	.399	.399	.399	.399	.399



XD Reduced Shank Diameter
Head diameter does not change with body diameter.

Shank Dia.	12	18	25	31	37	43	50	62	75	87	100
Min. XD	.063	.126	.188	.251	.313	.376	.438	.562	.688	.813	.938



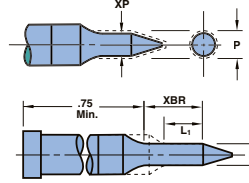
XL Overall Length Shortened (1.00 min.)
Stock removal from point end. L_1 is maintained.

XT Thinner Head than Standard
Stock removal from head end which shortens overall length.

TT Precision Head Thickness
Same as XT except head thickness tolerance is held to $\pm .0005$.

XH Reduced Head Diameter
Minimum head diameter equals $D + .000 - .001$.

Positive Pick-Up Pilots

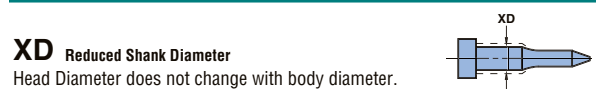


XP P Dimension
Smaller than Standard

XBR Point Length Longer than Standard
Specify XBR, XBB, or X3B and length (see chart below).

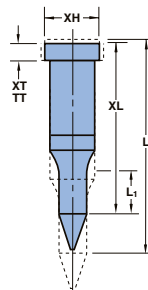
XBB and X3B add to delivery time.

Point Length	XBR										XBB	X3B	
	.500-.625	.626-.750	.751-.875	.876-1.000	1.001-1.125	1.126-1.250	1.251-1.375	1.376-1.500	1.501-1.625	1.626-2.000			2.001-2.500
Code Type	Min. P (Rounds)												
18 VPAP	.050	.050	.057	.057	.074	.074	.092	.092					
25 VPAP	.061	.061	.061	.061	.079	.079	.092	.092					
31 VPAP	.061	.061	.061	.061	.092	.092	.092	.124	.186				
37 VPAP	.061	.061	.061	.061	.092	.092	.124	.124	.124	.186	.249	.311	
43 VPAP	.092	.092	.092	.092	.092	.092	.124	.124	.124	.186	.249	.311	
50 VPAP	.124	.124	.124	.124	.124	.124	.124	.124	.124	.186	.249	.311	
62 VPAP	.234	.234	.234	.234	.234	.234	.234	.234	.234	.234	.311	.374	
75 VPAP	.299	.299	.299	.299	.299	.299	.299	.299	.299	.299	.342	.405	
87 VPAP	.349	.349	.349	.349	.349	.349	.349	.349	.349	.349	.374	.420	
100 VPAP	.399	.399	.399	.399	.399	.399	.399	.399	.399	.399	.399	.436	



XD Reduced Shank Diameter
Head Diameter does not change with body diameter.

Shank Dia.	18	25	31	37	43	50	62	75	87	100
Min. XD	.126	.188	.251	.313	.376	.438	.562	.688	.813	.938



XL Overall Length Shortened (2.00 min.)
Stock removal from point end. L_1 is maintained.

XT Thinner Head than Standard
Stock removal from head end which shortens overall length.

TT Precision Head Thickness
Same as XT except head thickness tolerance is held to $\pm .0005$.

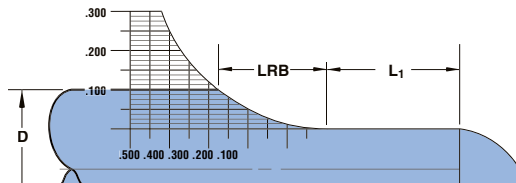
XH Reduced Head Diameter
Minimum head diameter equals $D + .000 - .001$.

SBR Straight Before Radius (L_1)

To determine Length of Radius Blend (LRB)

1. Calculate $(D-P)/2$.
2. Find $(D-P)/2$ value on left side of chart.
3. Follow line over to intersection point on radius blend line.
4. Read LRB value on bottom of chart.

Example: $D = .375$
 $P = .175$
 $(D-P)/2 = (.375 - .175)/2 = .100$
 Following the .100 line on chart over the radius blend line shows the LRB to be approximately .300.



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