Made in the USA

N-FORCER

GAS Springs Since 1986

Accessories

MCB-6

MCB-3

MCB-6 (six station Control Block)

N-Forcer offers different sizes of control blocks, from 3 to 6 individual port stations which operate independent from each other. All stations can be set for different pressures or they can all have the same pressure but isolate different sections of the die for maintenance purposes. All stations have a pressure gage and an opening and closing valve.

MCB-3, MCB-4, MCB-5, MCB-6
For Specifications—see page 4

Control Panels

CB-4 G1/8 BSPP Ports in 4 Places
CB-3 7/16-20SAE Ports in 3 Places
Specifications—see page 5

6 & 12 Port Distribution Blocks

DCB-6 & DCB-12
1/2” 20 SAE Ports
DCB-6-4 & DCB-12-4
7/16” 2– SAE Ports— See page 6

For G 1/8 BSPP Ports—See page 7

Flex ratcheting wrench: FRW-1
Wrench removal Sleeve: RSTM-1

Used to position the cartridge correctly and to assemble and disassemble threaded mini cylinders

T– HANDLE

For removing the piston rod when disassembling and to reassembling correctly. M8 Thread. (P/N: M8-T-Handle)

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FILLING ADAPTERS

HC-1QD—Female Quick Disconnect Coupling— Fits all FA filling adapters.

CN & CSN Series

FA-4QD—Quick Disconnect Filling Adapter—7/16-20 threads. Threaded into valve compartment of cylinder port. Attach high pressure hose coupling to male end.

(MINI) MF Series

FA-1MFQD for M6 Ports

(JUNIOR) UC025, CL025, UC075, & UCL75 Models

FA-2QD for (.206-36 Ports)

IS & CISN SERIES

FA-G1/8QD for G 1/8 Ports

SPRING RETAINERS

See drawings

Specifications: page 8

PRESSURE TESTERS

Available with either 12.5” hydraulic hose for hard to get to locations, or the compact model (6” shown) with solid fittings.

Available in 500# to 10,000# capacity glycerin filled gauges. All have a re-settable maximum indicator needle.

Specifications: page 9 & 10

FORCE TESTER

Quick, Accurate, Easy way to check the condition of your small series nitrogen die springs.

Diameter 3/4” (19 mm) to 1-1/2” (38.1mm)
Length 0-15” (380MM) 0-600 psi.

Specifications: page 11

CA-2000 QD—Charging Assembly.

*Must Specify 4000 or 6000 PSI Tank.
Comes with a quick disconnect coupling.

NH-025 — Medium pressure hose for use with reusable swivels.

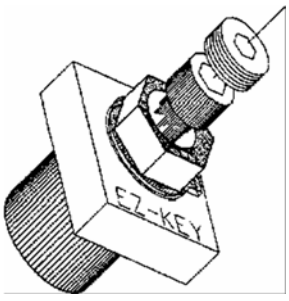
520N-4—High pressure hose for permanent swivels

Spaghetti or **Flexible** hose is also available. We don’t recommend these options as drainage is very time consuming

EZ-KEY

Adjustable key for Tools—Dies—Fixtures

EZ-KEY operates on an eccentric cam with a floating pressure plate. Rotation of the hex nut (attached to the cam) shifts the pressure plate providing the necessary key force. The C/L of the bore in the pressure plate is located so that it is variable in relation to each face. This allows for a wide range of adjustments.



Specifications: page 12 & 13

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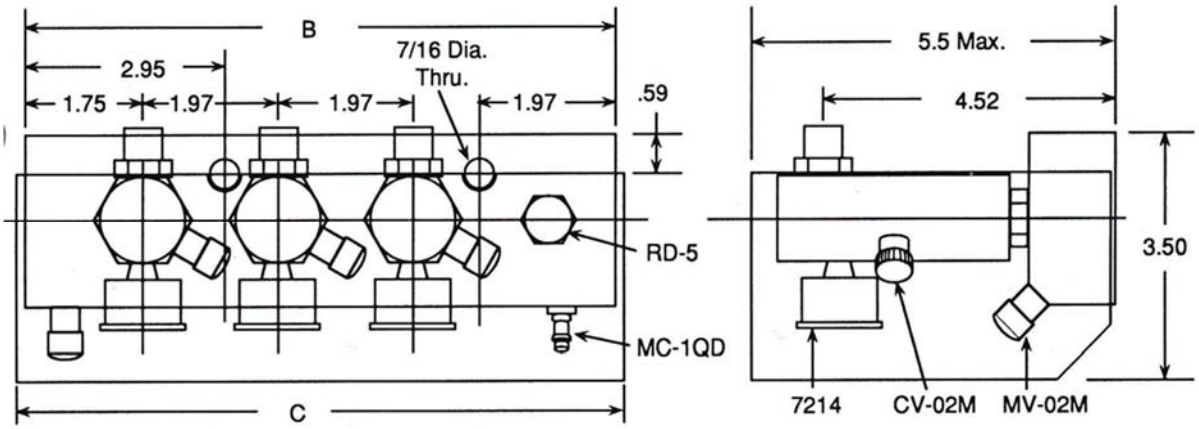
Multiple Station Control Block



	B	C
MCB-3 (Three Station)	219.9mm	226.2mm
MCB-4 (Four Station)	269.9mm	276.3mm
MCB-5 (Five Station)	320mm	326.3mm
MCB-6 (Six Station)	370mm	376.3mm

Multiple Station Control Block

This control block offers from 3 to 6 individual port stations which operate independent from each other. Each station has two 7/16-20 SAE ports for hosing nitrogen die springs. All stations can be set for different pressures or they can all be the same pressure but isolate different sections of the die for maintenance purposes. All stations have a pressure gage and an opening and closing valve.

Control Panels

CB-3
with 7/16-20 Ports
&
CB-4
with G 1/8 Ports

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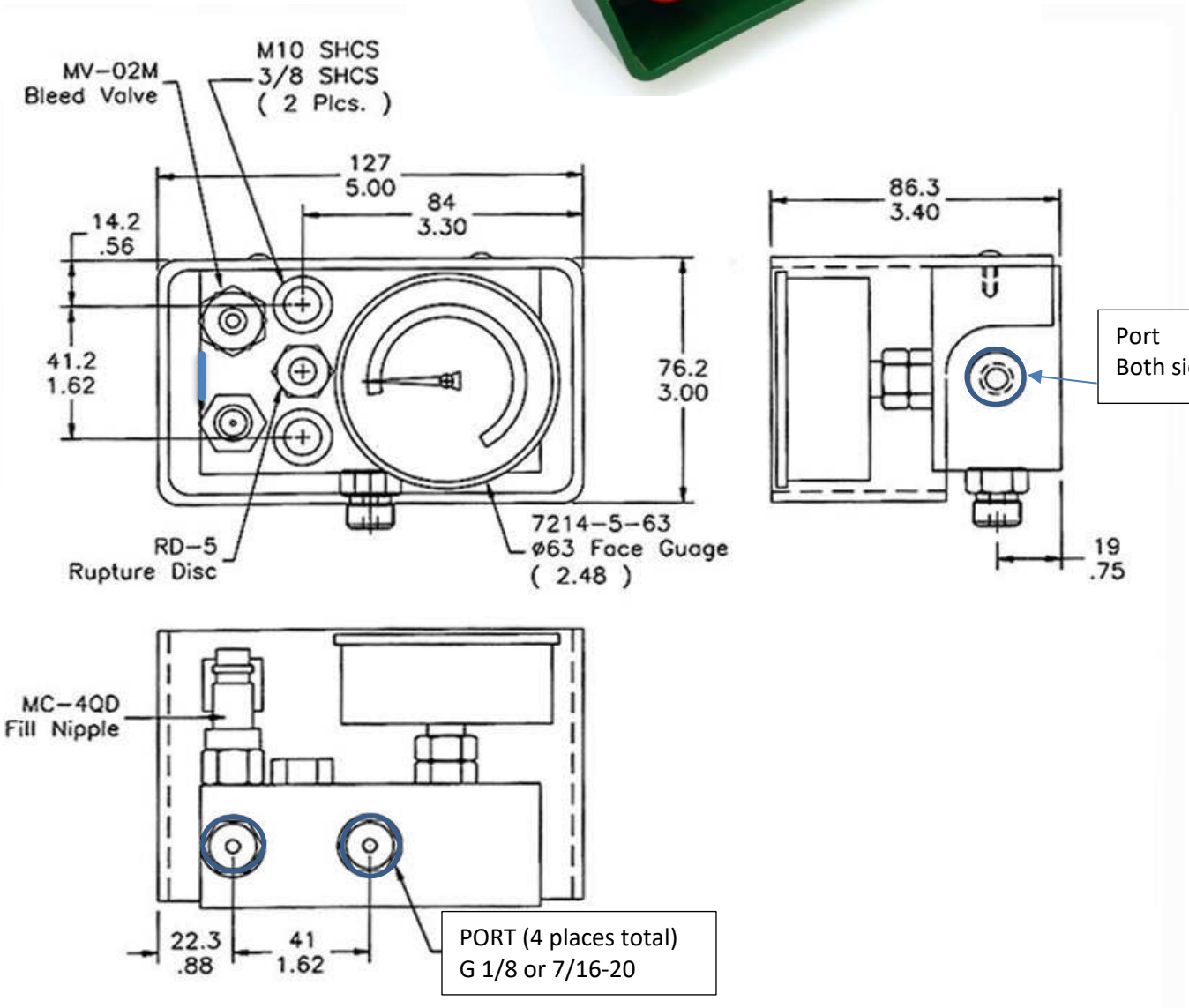
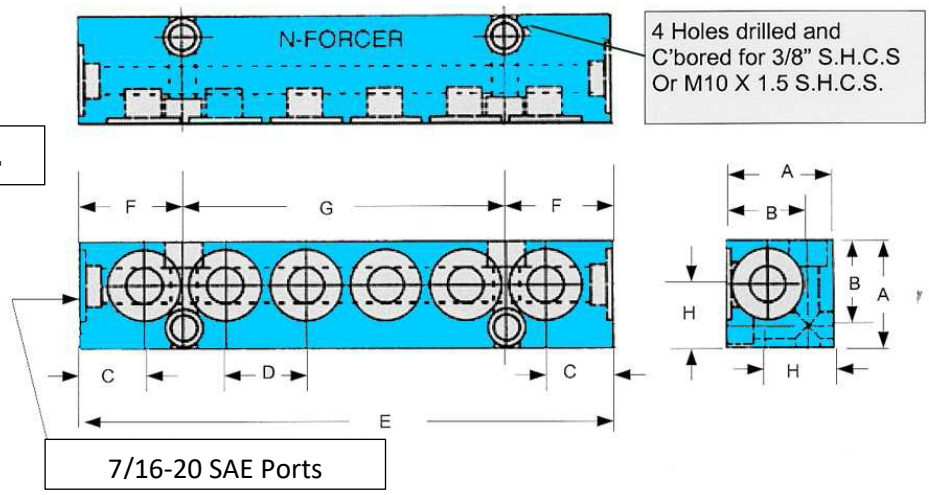
GAS Springs Since 1986



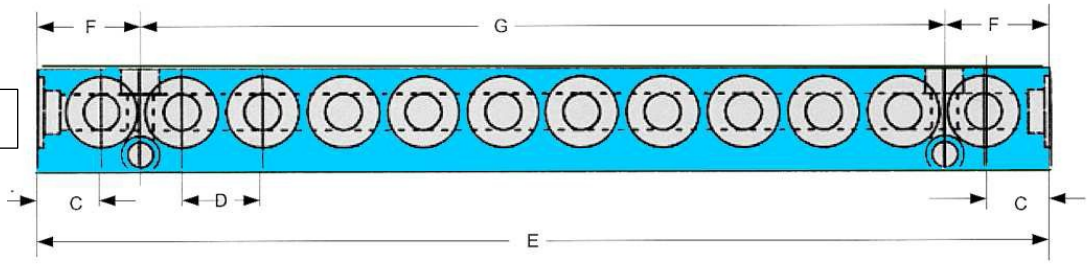
N-FORCER
Six & Twelve Port Distribution Blocks
DCB-6-4 and DCB-12-4 (7/16” - 20 SAE Ports)
DCB-6 and DCB-12 (1/2” 20 SAE Ports)
For G 1/8 BSPP Ports - see next page

Distribution blocks allow cylinders to be hosed to a control block with fewer hose connections. Every hose connection is a potential leak. These blocks eliminate all tee fittings by hosing cylinders directly to the distribution block. There are two ports on the ends of the blocks to hose to a control block and / or a pressure monitor. Order straight fittings for each cylinder to be connected to block and plugs for ports not to be used.

DCB-6-4



DCB-12-4

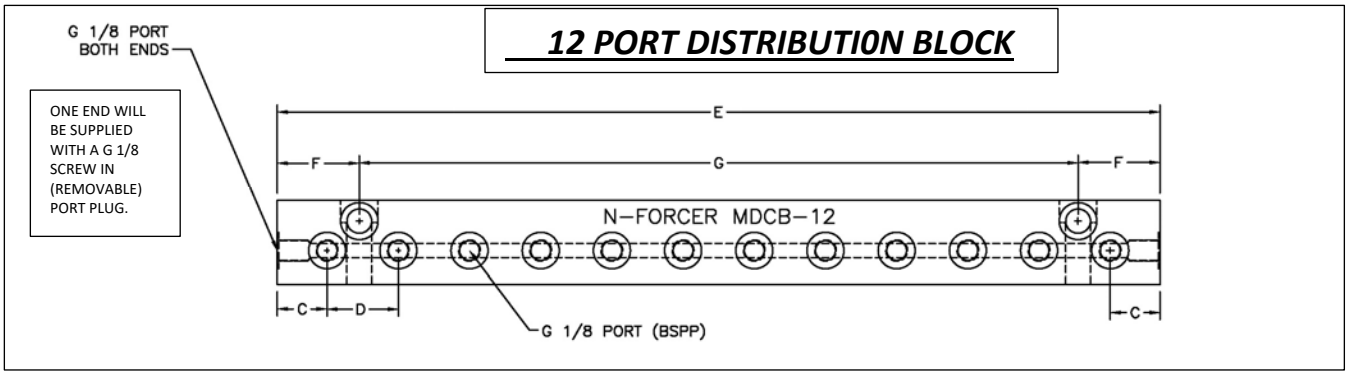


Part No.		A	B	C	D	E	F	G	H
DCB-6	in.	1.50	1.18	.865	1.13	7.38	1.1440	4.50	.90
	mm	38	30	22	29	187	36.5	114	23
DBC-12	in.	1.50	1.18	.850	1.13	14.13	1.440	11.25	.90
	mm	38	30	21.5	29	359	359	286	23

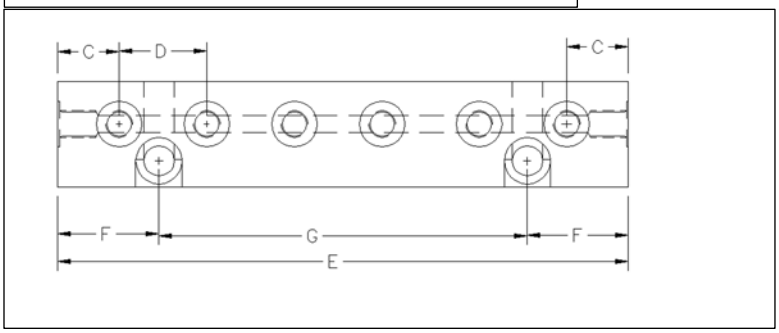
N-FORCER®
Distribution Blocks
For Hosed Systems with 1/8 BSPP Ports

Distribution blocks are used with a control panel for multiple hose options

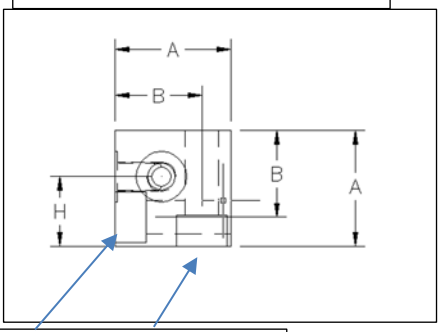
12 PORT DISTRIBUTI0N BLOCK



6 PORT DISTRIBUTION BLOCK



SIDE VIEW (6 & 12 PORT)



C'BORE FOR M10 (OR 3/8") SHCS (4) HOLES.

	P/N:	PORT COUNT	UNITS	A	B	C	D	E	F	G	H
GM	M-1630-6	6 PORT	MM	38	29	22	29	187	37	114	25
			IN	1.49	1.14	0.86	1.14	7.36	1.45	4.48	0.98
GM	M-1630-12	12 PORT	MM	38	29	22	29	359	37	286	25
			IN	1.49	1.14	0.86	1.14	14.13	1.45	11.25	0.98
Nforcer Standard	MDCB-6	6 PORT	MM	38	28.6	22.2	31.7	203.2	36.6	130	22.9
			IN	1.49	1.12	0.87	1.24	8	1.44	5.11	0.9
Nforcer Standard	MDCB-12	12 PORT	MM	38	28.6	22.2	31.7	393	36.6	320.5	22.9
			IN	1.49	1.12	0.87	1.24	15.47	1.44	12.61	0.9

MDCB-6 & 12 allow room for 90 degree elbow fittings to be rotated without interference with fitting in the next port.

*NAAMS N520121 fittings maybe ordered separately to adapter the female G1/8 thread to a male 9/16-18 thread for easy hosing.

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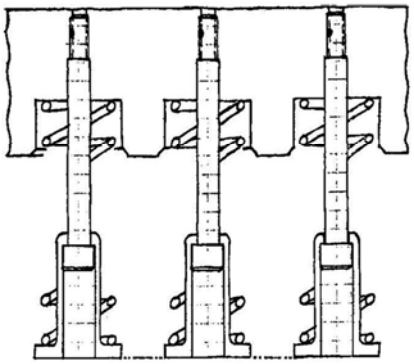
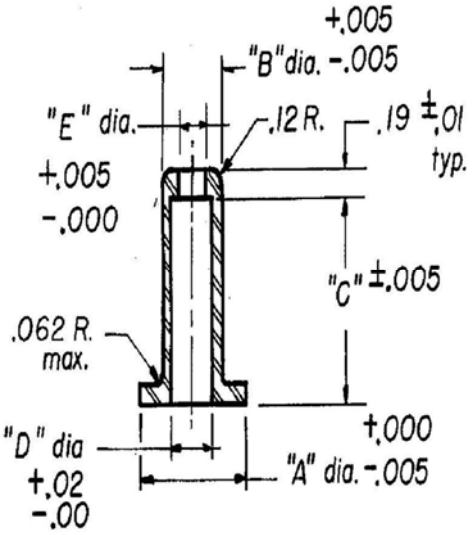
SPRING RETAINERS

These are CNC machined from bar stock and heavy walled. ***Not a thin wall stamping.***





Part No.	A	B	C	D	E	STRIPPER BOLT SIZE	CROSS REF DANLY ITEM #
SR-1	1.25	0.625	1.50	0.442	0.315	5/16	SR125150
SR-2	1.25	0.625	2.00	0.442	0.315	5/16	SR125200
SR-3	1.25	0.625	2.50	0.442	0.315	5/16	SR125250
SR-4	1.50	0.75	1.50	0.566	0.378	3/8	SR150150
SR-5	1.50	0.75	2.00	0.566	0.378	3/8	SR150200
SR-6	1.50	0.75	2.50	0.566	0.378	3/8	SR150250
SR-7	2.00	1.00	1.5	0.754	0.503	1/2	SR200150
SR-8	2.00	1.00	2.00	0.754	0.503	1/2	SR200200
SR-9	2.00	1.00	2.50	0.754	0.503	1/2	SR200250

DIRECT READING *FORCE GAUGES*

6.25” or 12.5” lengths.

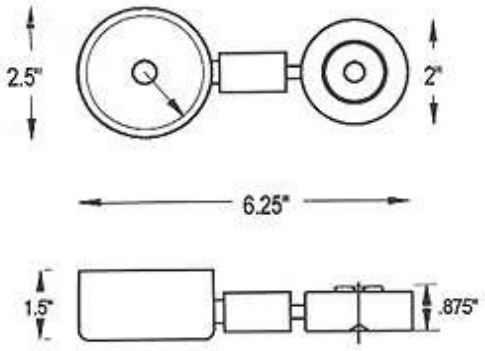
Available with either 12.5” hydraulic hose for hard to get to locations, or the compact model with solid fittings.

Available in 500# to 10,000# capacity glycerin filled gauges. All have resettable maximum indicator needle. The direct reading feature is helpful in setting up rocker arm welders with various pivot movements.

FOR USE IN READING PRESSURE IN NITROGEN SPRINGS. COMES WITH UNDER CUT IN CENTER ON BOTH SIDES. CAN ALSO BE USED FOR CHECKING SPOT WELDER CLAMPING PRESSURE.

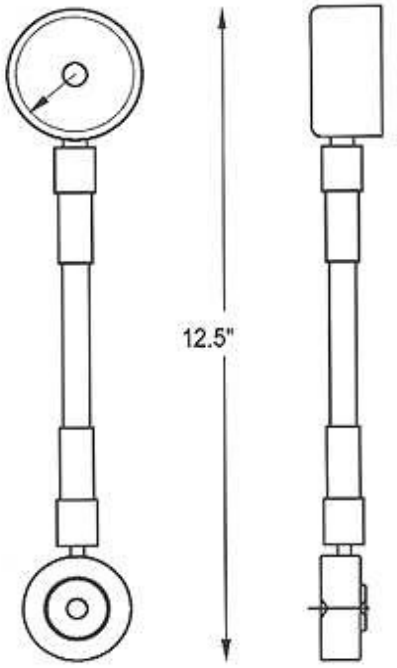
FORCE GAGE SPECIFICATIONS

Solid Fitting Design (SP5-SP100)



Components are machined of non-magnetic stainless and brass. The chamfered détente assists in alignment of tips to the center of the puck.

Hydr. Hose Design (HP5-HP100)



Solid Fittings	Maximum Gauge Reading	Hydraulic Hose
SP5	500#	HP5
SP10	1000	HP10
SP15	1500	HP15
SP20	2000	HP20
SP30	3000	HP30
SP50	5000	HP50
SP60	6000	HP60
SP75	7500	HP75
SP100	10000	HP100

Force Tester

Made in the USA

N-FORCER

GAS Springs Since 1986

THE QUICK, ACCURATE*, EASY WAY TO CHECK THE CONDITION OF YOUR SMALL Jr. SERIES NITROGEN DIE SPRINGS.

Diameter 3/4”(19mm) to 1-1/2” (38.1mm)
Length 0-15” (380mm) 0-600 psi.

Please be safety conscious when working with nitrogen cylinders. Carefully align charged cylinder when placing in tester.

Can be mounted on table or vertically.

*Accurate to plus or minus 2% in midrange.

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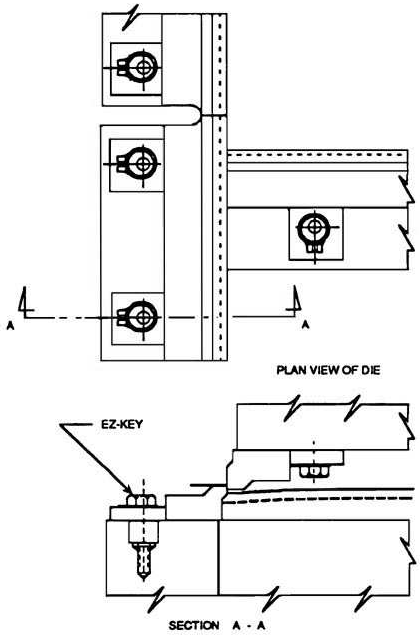
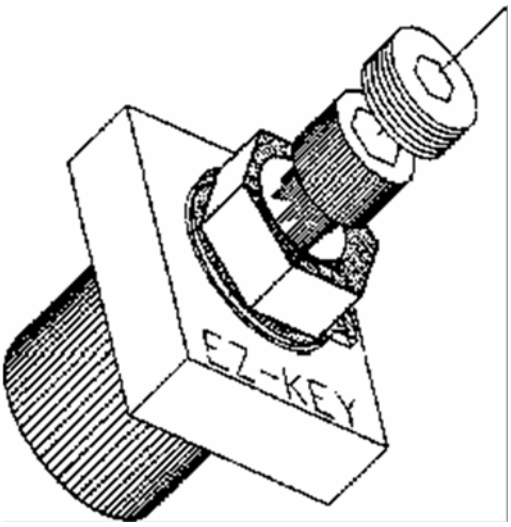
EZ - KEY

ADJUSTABLE KEY
FOR
TOOLS - DIE - FIXTURES





How it works - EZ-Key operates on an eccentric cam with a floating pressure plate. Rotation of the hex nut (attached to the cam) shifts the pressure plate providing the necessary key force. The C/L of the bore in the pressure plate is located so that it is variable in relation to each face. This allows for a wide range of adjustment.

ADVANTAGES

EZ-Key is adjustable and designed for easy installation on sections or details needing secure locking forces.

EZ-Key provides adjustability when maintaining or resharpening trim steels or details subject to wear.

EZ-Key eliminates the need for traditional milling of keyway slots and provides instant adjustability once installed.

No more shimming required.

Saves time and costs during maintenance, adjustments, and initial setup.

Safety lock screw securely locks EZ-Key in position.

EZ - KEY

Continued….

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Use Example:

Locate Ez-Keys 4-5 inches apart. Minimum of 2 keys per detail.

The pressure plate of Ez-Key increases by .06 inches on each side.

Rotate the hex screw counterclockwise to adjust face of key to detail. Hold hex in position with wrench while tightening socket head cap screw. After the socket head cap screw is tight, insert lock screw and tighten. Note: Do not over torque the hex nut when adjust the key face.