



HOW TO SIZE A RECTANGULAR RAIL:

Recommended for all slots.

***Nominal .060" to .080" lift above surface of bolster.**

1. Measure Slot Depth (E_R) to center bottom:
 $E_R = \text{_____}$ (See chart on bottom of page 13)
2. Calculate amount of lift needed by piston to raise die desired amount (.080*) for the chosen rail
 $E_R + .080^* - \text{"H"} (LP) = \text{_____}$ Calculated Piston Stroke
3. Can piston stroke that much?
 - a. If calculated piston stroke is less than .36", use LP in part number and enter the calculated stroke. STOP.
 - b. If piston stroke is larger than .36", then try HP calculation:
 $E_R + .080^* - \text{"H"} (HP) = \text{_____}$ Piston Stroke
 If less than .36", use HP in part number and the calculated stroke
4. Verify lowered and raised positions fit slot for selected rail.
 - a. Is "H" less than (E_R)? If yes, ok. If no, call PFA
 - b. Is ($\text{"H"} - .080^* + .36$) more than (E_R)?
 If yes, ok. If no, call PFA

HOW TO SIZE A "T" RAIL:

Only for T-Slots - See Page 13

***Nominal .060" to .080" lift above surface of bolster.**

1. Measure Neck Height (D) and Full Width Depth (E_T):
 $D = \text{_____}$
 $E_T = \text{_____}$ (See chart on bottom of page 13)
2. Calculate amount of Flange Height for desired lift (.080*)
 $H (LP) - .080^* - D = \text{_____}$ Anticipated Flange Height
3. Is anticipated flange height adequate?
 If flange is more than .25", then ok.
 If not, use calculation below for HP rail.
 $H (HP) - .080^* - D = \text{_____}$ Anticipated Flange Height
 If more than .25", ok.
4. Verify lowered and raised positions fit slot for selected rail.
 - a. Is "H" less than (E_T)? If yes, ok. If no, call PFA
 - b. Is ($\text{"H"} - .080^* + .36$) more than (E_T)?
 If yes, ok. If no, call PFA

Rail Style	Model Number	Length (L)	T-Slot Tab Height or Rectangular Piston Stroke	Neck Width	Profile (HP or LP)
DR	See chart on pg 13	Choose from Standard Lengths	.XXX = Flange Height or Stroke to three decimal places	Y.YYY = Width to three decimal places	From formula above
DR	315N	36	XXX**	YYYY***	HP

** All flange and stroke dimensions are less than 1.000", thus the decimal is omitted and fraction decimal entered.

For example, a .310" stroke is XXX=310.

*** Standard widths are shown as .800 and .995 for standard rails. Use 0800 or 0995 for these units or other as desired.

For example, a 1.020 width is YYYY=1020.

Part No: **DR-315N36-3101020HP**

**For free sizing assistance and application support,
 please email or fax application dimensions and information to PFA.**