



# . . . double-acting cylinders



Index No.		DA-2200-SC			DA-6600-SC			DA-8800-SC		
		No. Req.	Part No.	Price	No. Req.	Part No.	Price	No. Req.	Part No.	Price
1	Cylinder Head Casting	(2)	3301-1	\$67.68	(1) (1)	6601-1 6601-1R (Note 3)	\$94.00	(2)	8800-1	--
2	Cylinder Body Casting	(2)	3301-2 + 2-A	76.91	--	Part of Body Casting	--	--	Part of Body Casting	--
3	Body Casting (Note 1)	(1)	2200-3	--	(1)	6600-3	--	(1)	8800-3	--
4	Cylinder Tube	(2)	2200-4	78.62	(2)	6600-4	185.54	(2)	8800-4	\$228.00
5	Piston Cup	(2)	3301-5	68.91	(2)	6601-5	75.47	(2)	8800-5	205.10
6	Piston Rod	(2)	2200-6	26.25	(2)	6600-6	57.43	(2)	8800-6	96.80
7	Jaw Casting (Note 2)	(2)	DA-2200-7	104.26	(2)	6600-7	196.55	(2)	8800-7	922.93
8	5/16" I.D. Star Washer	(12)	3301-9	0.57	(10)	3301-9		(12)	3301-9	0.57
9	1/2-20 x 1/8 Jam Nut	(2)	3301-11	0.98	--	--	--	--	--	--
9	3/4-16 Jam Nut	--	--	--	(2)	6601-11	3.28	(2)	6601-11	3.28
10	Cylinder Gasket	(4)	3301-12	13.13	(4)	6601-12	9.84	(4)	8800-12	9.84
11	Body Gasket	(2)	3301-13	6.56	--	--	--	--	--	--
12	Guide Bar	(2)	44-14	15.38	(2)	6600-14	76.91	(2)	8800-14	299.10
13	Cylinder Tie Rod	(12)	2200-15 5/16-18 x 2 3/4	1.48	(10)	4401-15 5/16-188 x 6	2.79	(12)	8800-15 5/16-18 x 89.	
14	Stop Bar	(2)	2200-17	10.25	(2)	6600-17	22.22	(2)	8800-17	27.35
15	U-Packing	(2)	3301-18 D-26-R-16	11.49	(2)	6601-18 D-26-R-20	13.13	(2)	8800-18 D-26-R-24	14.77
16	Gear Pin	(1)	2200-20 3/8 x 1 Dowel	4.92	(1)	6600-20 5/8 x 1 1/2 Dowel	7.38	(1)	6600-20 5/8" x 1 1/2 Dowel	
17	Gear	(1)	2200-21	131.26	(1)	77-21 Boston YA-80	237.91	(1)	8800-21 Boston YA-120	319.95
18	Rack	(2)	2200-22	47.58	(2)	6600-22	77.12	(2)	8800-22	91.88
19	Cover Plate	(1)	2200-23	21.33	(1)	6600-23	83.68	(1)	8800-23	113.21
20	1/4-20 x 1/2 Screw	(2)	2200-42	0.98	(4)	2200-42	0.98	(4)	2200-42	0.98
21	Rack Locking Plate	(2)	2200-44	27.89	--	--	--	--	--	--
22	5/16-18 x 2 1/4 Soc. Hd. Cap Screw	(2)	2200-45	1.80	--	--	--	--	--	--
22	1/4-20 x 7/8 Soc. Hd. Cap Screw	--	--	--	(2)	305-8	0.98	(2)	305-8	0.98
23	Shoulder Screw	(2)	3301-39	6.23	(2)	6601-39	18.05	(2)	6601-39	18.05
24	Stat-O-Seal	(2)	600-1/2"	4.92	(2)	600-3/4"	8.05	(2)	600-3/4"	8.20
25	1/4" Street Elbow	(2)	2200-33	5.33	--	--	--	--	--	--
26	Rack Rollpin	(4)	4CL-6 1/8 x 7/8	1.15	(4)	2316-A 3/16 x 1 1/8	1.15	(4)	2316-A 3/16 x 1 1/81	1.15
27	5/16-18 x 3/4 Screw	(6)	33-8	0.98	--	--	--	(2)	None Required	--
28	Back-up Washer	(2)	3301-5A	8.45	(2)	6601-5A	13.13	(2)	6601-5A	13.13
29	Nut	(2)	2200-17A (3/8-16)	0.74	(2)	H-76 (1/2-13)	1.23	(2)	H-76 (1/2-13)	1.23
30	Adapter	(2)	33-16	3.61	--	--	--	--	--	--
31	Rack Rollpin	(4)	4CL-6	1.15	--	--	--	--	--	--

**Note 1.** Price not shown, as replacement body castings are not available.

**Note 2.** If replacement of jaw casting (7) is necessary, it is recommended that the entire vise be returned to the factory, freight charges prepaid, for machining of the jaw, assembled in customer's vise

**Note 3.** When the letters DA-6600-3 are facing front, the -- 1R is on the left end.

Recommended spare parts to be retained in stock at all times to support each unit in service: Index (5) Piston Cup, Index (10) Cylinder Gasket, Index (11) Body Gasket, Index (15) U-Packing.

## WHEN ORDERING PARTS, INDICATE PART NUMBER, MODEL NUMBER AND PRICE.

(Cont. from prev. page)

- Adjust and secure stop screws (or bars in the case of DA-2200-SC) (14) to limit jaw return, for desired jaw opening. Allow minimum clearance to insert and remove part piece. It is important to set stop screws (or bars) on each jaw with equal accuracy.
- Place work in vise AS CLOSE AS POSSIBLE TO CENTER OF JAWS and apply air pressure. Regulate air pressure as required for the operation to be performed. AVOID EXCESSIVE AIR PRESSURE.
- Move **entire** vise to center workpiece.
- For maximum accuracy, securely clamp the vise to the work table, using the **center** side lugs.

## MAINTENANCE:

All operating parts, particularly the gear and rack mechanism in the base, should be kept free of foreign material. Periodic greasing of operating parts is recommended. If vise becomes inoperable, disassemble as shown in exploded view. Clean and check each part for wear or damage. Replacement parts are available for immediate shipment from factory stock, or you may order through your local Heinrich distributor. When re-assembling, all screws and nuts should be evenly and securely tightened.