

PRF

Pre-roller Removable & fold type PRF

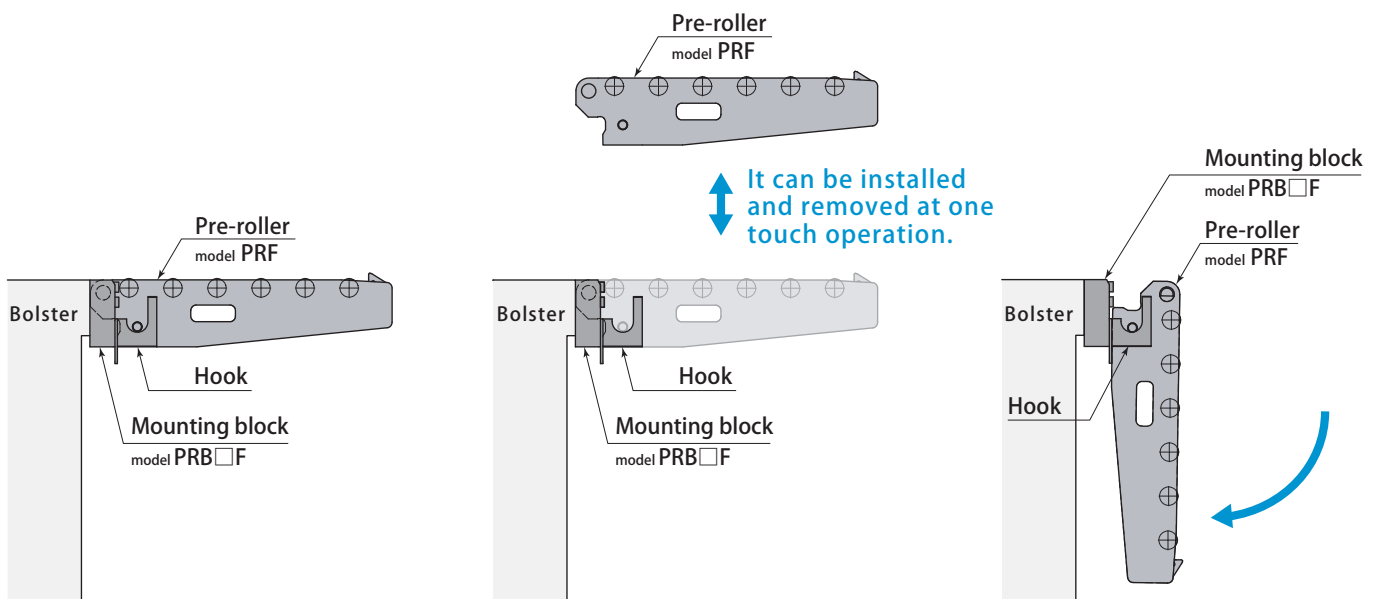
It is the pre-roller installed with fold to removable type PRA.



At installation

At removal

At hanging



- Be noted that the specifications of Mounting block PRB and PRB□F (mounting block for PRA) are different.
- Pull down the pre-roller slowly at folding.

Model designation

Set model (Pre-roller + Mounting block)

PRF 2 - 0200 B - S

Size
PRF2 PRF3 PRF5

1 Die travel (mm)
* Indicated in 4 digits

For set model, S is added
at the end of model No.

Pre-roller model type

PRF 2 - 0200 B

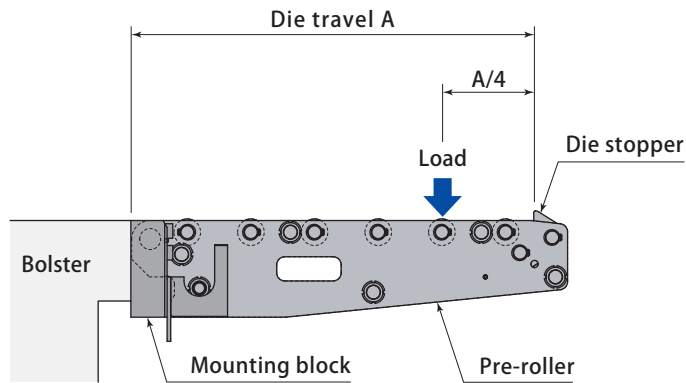
Size
PRF2 PRF3 PRF5

1 Die travel (mm) * Indicated in 4 digits

Mounting block model type

PRB 2 F

Size
PRB2F PRB3F PRB5F



1 Die travel 200 ~ 1000 mm

Die travel		mm	200	250	315	355	400	450	500	560	630	710	800	850	900	950	1000
PRF2	Allowable load *	kN	8	8	5	5	4	4	3	2.5	2.5	—	—	—	—	—	—
	Number of rollers		3	4	4	5	5	6	6	7	7	—	—	—	—	—	—
	Weight	kg	3.1	3.7	4.2	4.7	5.1	5.5	5.9	6.6	7.2	—	—	—	—	—	—
PRF3	Allowable load	kN	—	—	16	16	13	10	8	8	8	6	5	5	4	4	3
	Number of rollers		—	—	4	4	5	5	6	6	7	7	7	8	8	8	9
	Weight	kg	—	—	7.2	8	8.8	9.2	10.1	11	12.1	13.5	14.9	15.9	16.7	17.5	18.4
PRF5	Allowable load	kN	—	—	—	—	25	20	16	16	13	13	10	10	8	8	8
	Number of rollers		—	—	—	—	4	5	5	6	6	7	7	8	8	9	9
	Weight	kg	—	—	—	—	10.4	11.4	12.2	13.6	15.1	16.9	18.1	19.2	20.1	21.5	22.5

● Die loading speed on Pre-roller : Less than 50mm/s ● Die transfer speed : Less than 100mm/s

● Weight does not include mounting block.

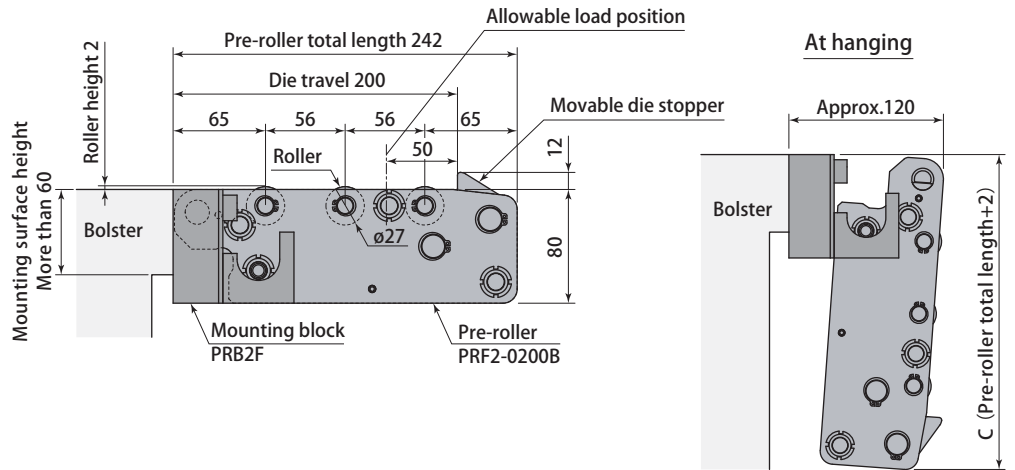
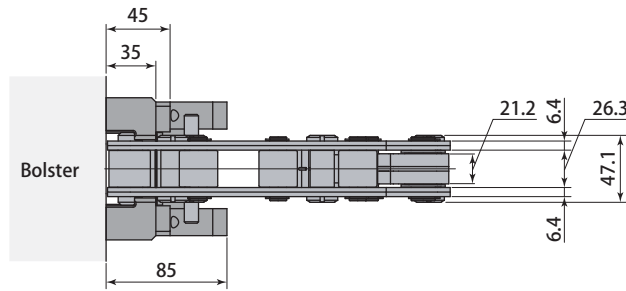
* Allowable load is a static load measured at the position of 1/4 of the die travel from the stopper. Select Pre-roller where allowable load (kN) multiplied by the quantity is greater than the die weight. SI conversion : Die weight (kN)=Die weight (kgf)×9.8÷1000

Dimensions

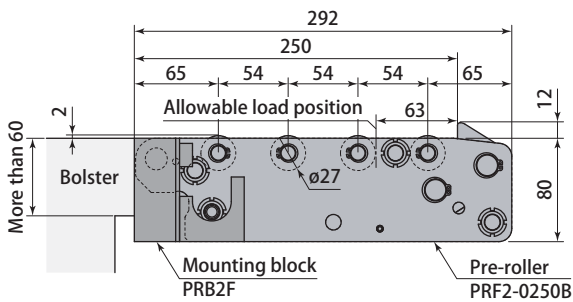
PRF 2 - **0200** B - S

- 1 Die travel (mm)
- * Indicated in 4 digits

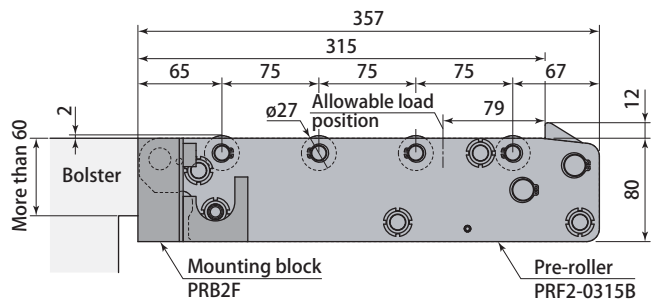
PRF2-0200B-S



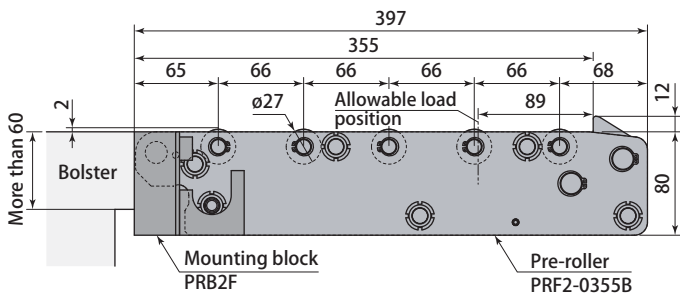
PRF2-0250B-S



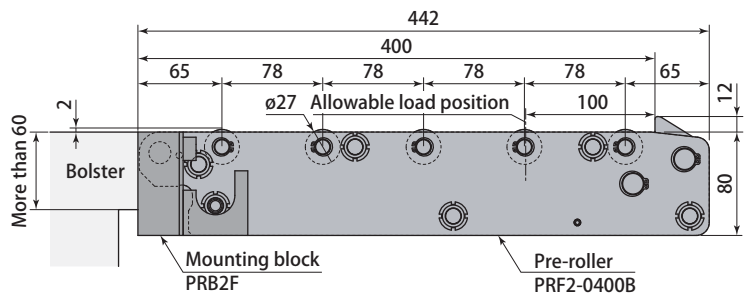
PRF2-0315B-S



PRF2-0355B-S



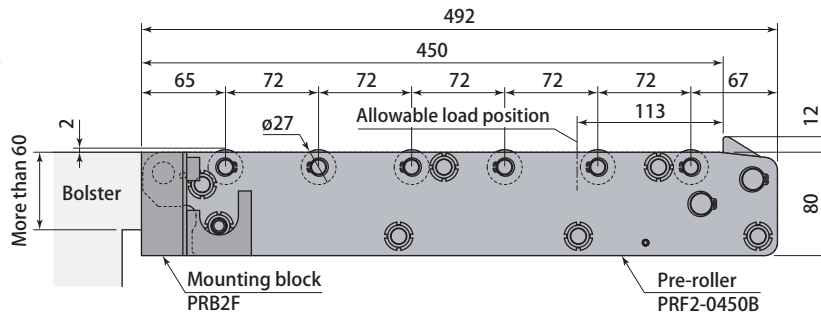
PRF2-0400B-S



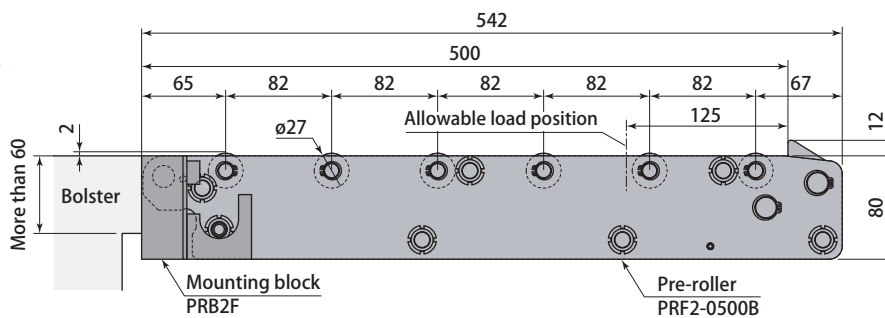
1 Die travel 200 ~ 630 mm

Model	PRF2-0200B	PRF2-0250B	PRF2-0315B	PRF2-0355B	PRF2-0400B	PRF2-0450B	PRF2-0500B	PRF2-0560B	PRF2-0630B
Die travel mm	200	250	315	355	400	450	500	560	630
Pre-roller total length mm	242	292	357	397	442	492	542	602	672
C mm	244	294	359	399	444	494	544	604	674
Weight kg	3.1	3.7	4.2	4.7	5.1	5.5	5.9	6.6	7.2

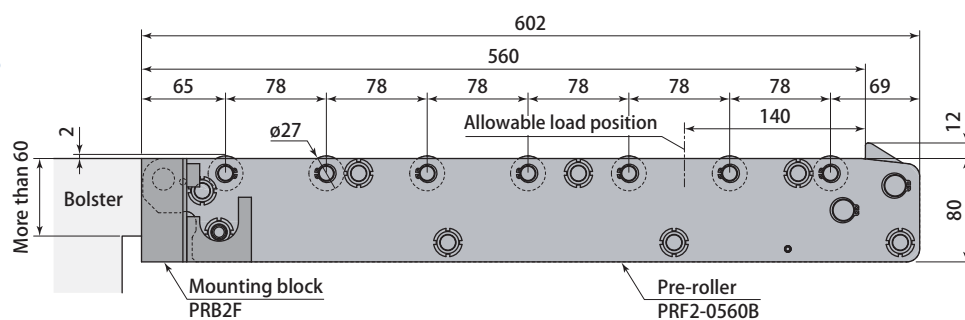
PRF2-0450B-S



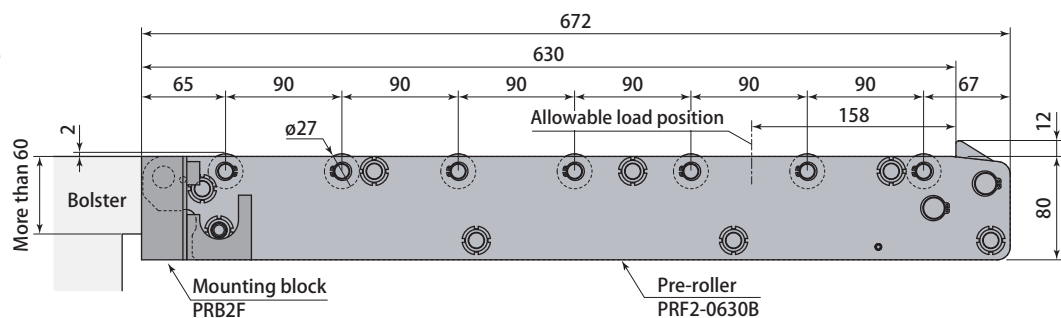
PRF2-0500B-S



PRF2-0560B-S



PRF2-0630B-S

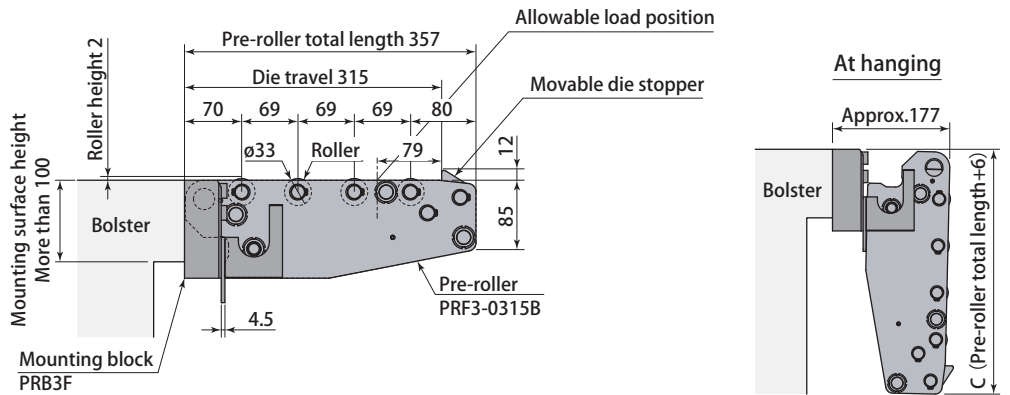
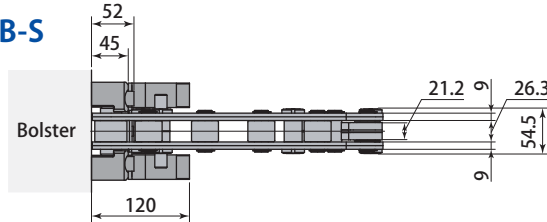


Dimensions

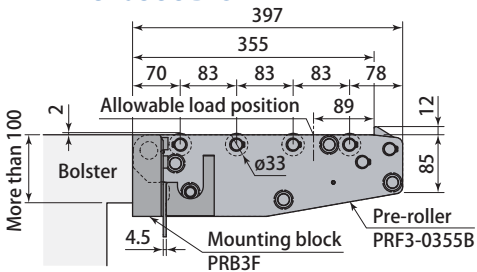
PRF 3 - 0315 B - S

- 1 Die travel (mm)
* Indicated in 4 digits

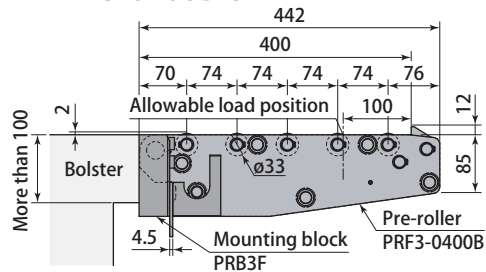
PRF3-0315B-S



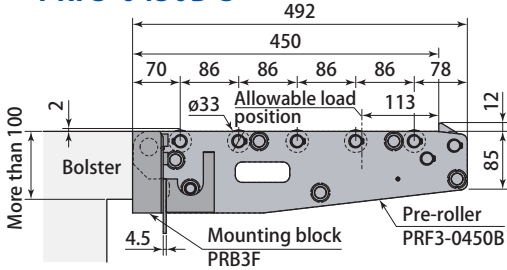
PRF3-0355B-S



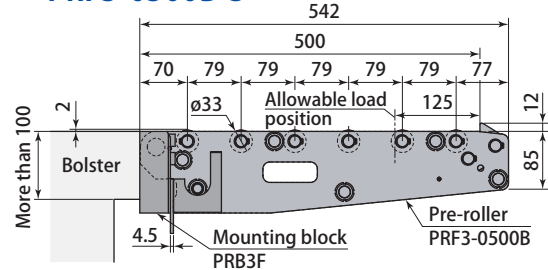
PRF3-0400B-S



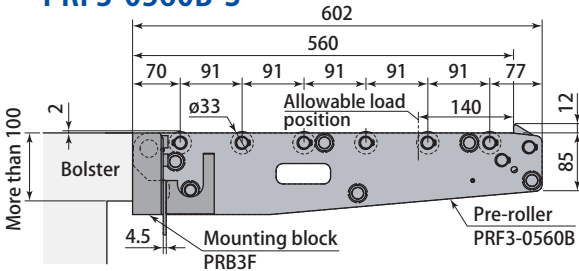
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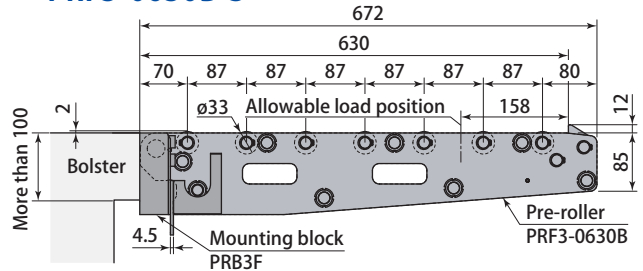
PRF3-0500B-S



PRF3-0560B-S



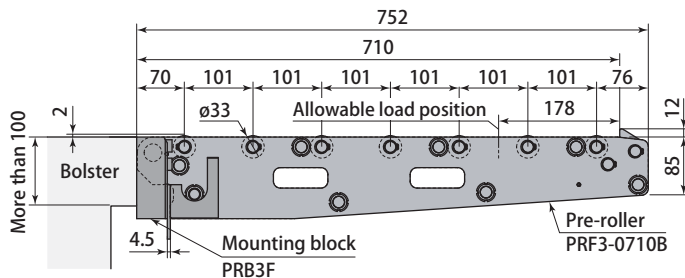
PRF3-0630B-S



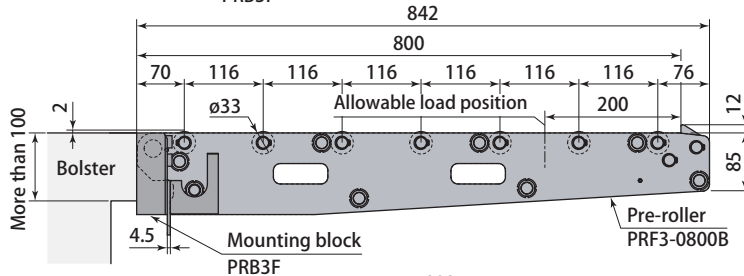
1 Die travel 315 ~ 1000 mm

Model	PRF3-0315B	PRF3-0355B	PRF3-0400B	PRF3-0450B	PRF3-0500B	PRF3-0560B	PRF3-0630B	PRF3-0710B	PRF3-0800B	PRF3-0850B	PRF3-0900B	PRF3-0950B	PRF3-1000B
Die travel mm	315	355	400	450	500	560	630	710	800	850	900	950	1000
Pre-roller total length mm	357	397	442	492	542	602	672	752	842	892	942	992	1042
C mm	363	403	448	498	548	608	678	758	848	898	948	998	1048
Weight kg	7.2	8	8.8	9.2	10.1	11	12.1	13.5	14.9	15.9	16.7	17.5	18.4

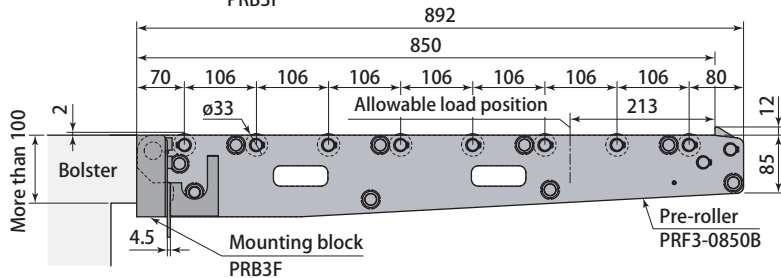
PRF3-0710B-S



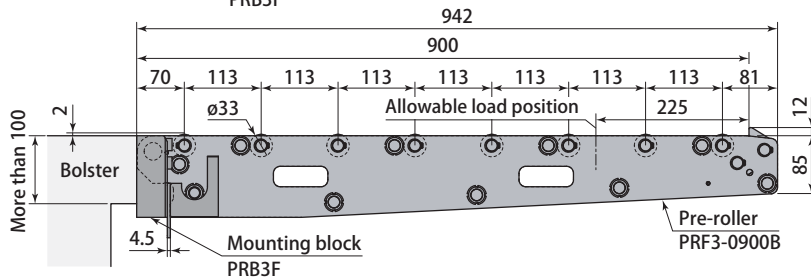
PRF3-0800B-S



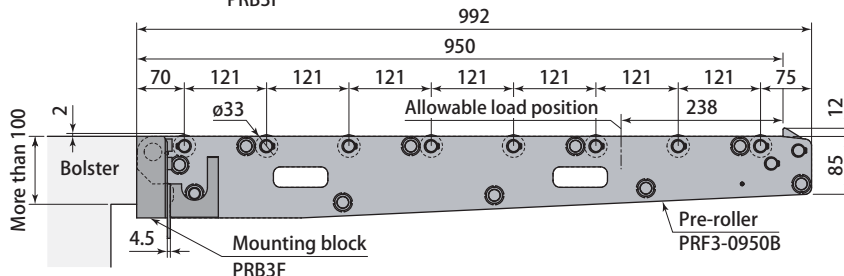
PRF3-0850B-S



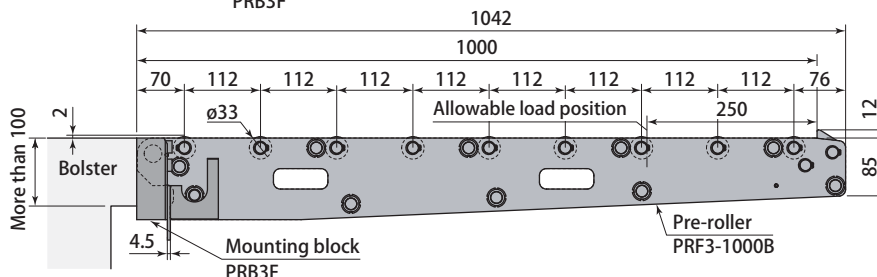
PRF3-0900B-S



PRF3-0950B-S



PRF3-1000B-S

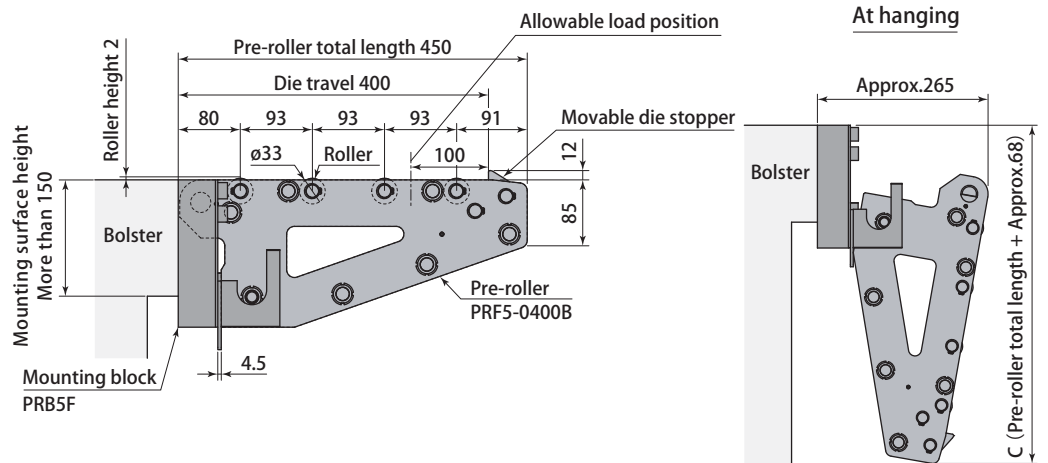
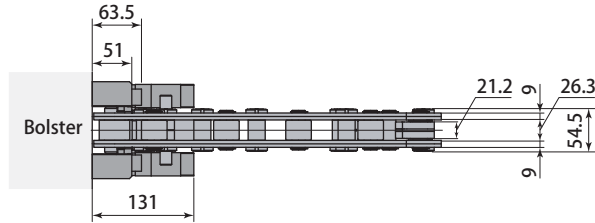


Dimensions

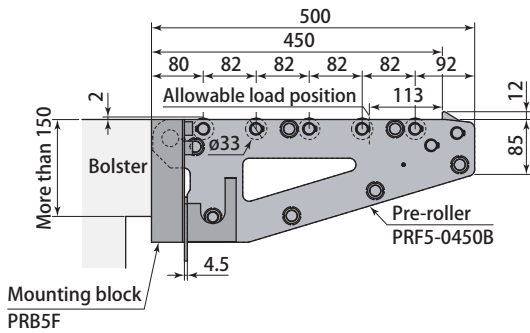
PRF 5 - 0400 B - S

- 1 Die travel (mm)
- * Indicated in 4 digits

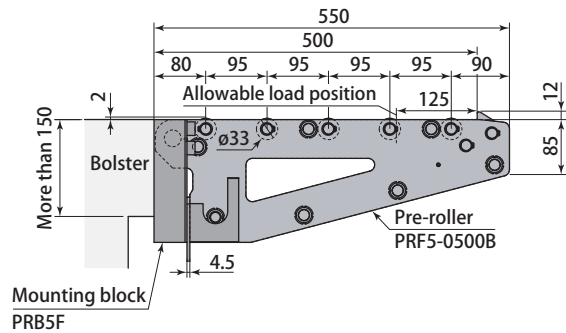
PRF5-0400B-S



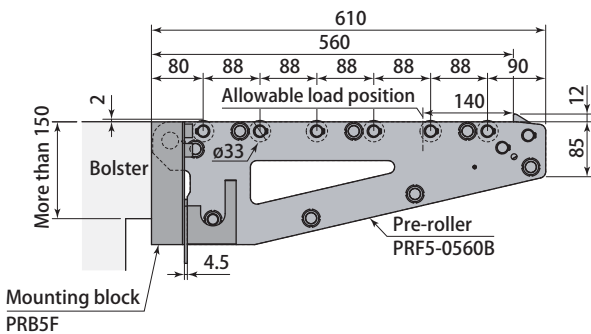
PRF5-0450B-S



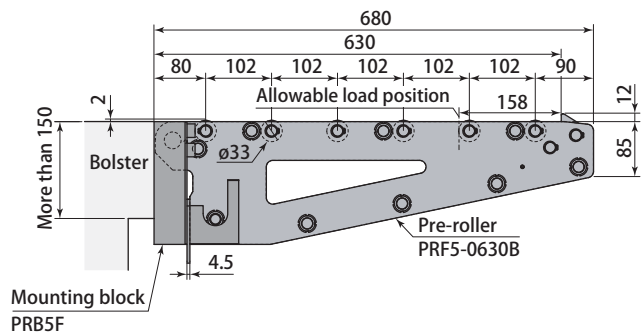
PRF5-0500B-S



PRF5-0560B-S



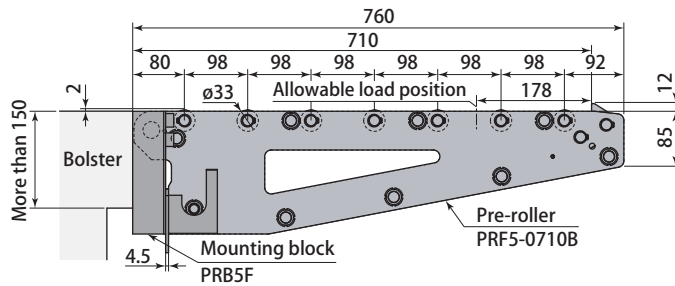
PRF5-0630B-S



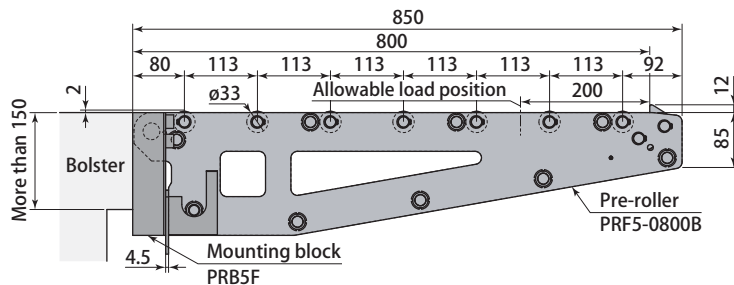
1 Die travel 400 ~ 1000 mm

Model	PRF5-0400B	PRF5-0450B	PRF5-0500B	PRF5-0560B	PRF5-0630B	PRF5-0710B	PRF5-0800B	PRF5-0850B	PRF5-0900B	PRF5-0950B	PRF5-1000B
Die travel mm	400	450	500	560	630	710	800	850	900	950	1000
Pre-roller total length mm	450	500	550	610	680	760	850	900	950	1000	1050
C (Approximately) mm	518	568	618	678	748	828	918	968	1018	1068	1118
Weight kg	10.4	11.4	12.2	13.6	15.1	16.9	18.1	19.2	20.1	21.5	22.5

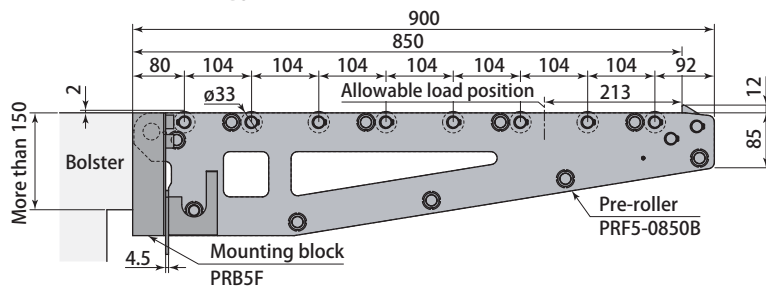
PRF5-0710B-S



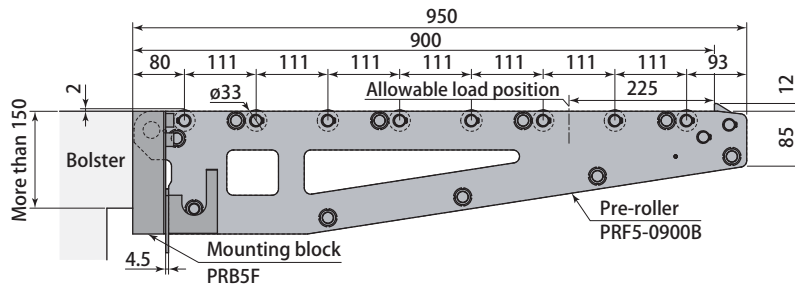
PRF5-0800B-S



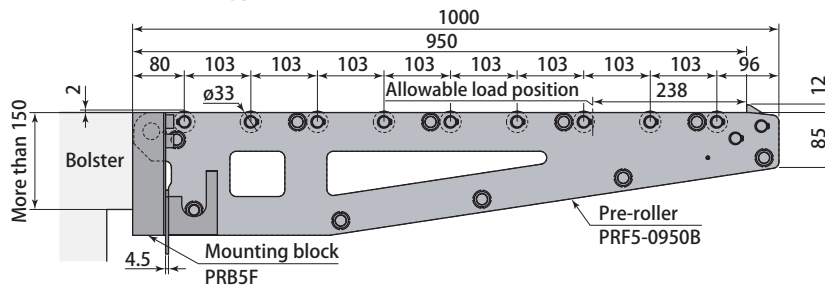
PRF5-0850B-S



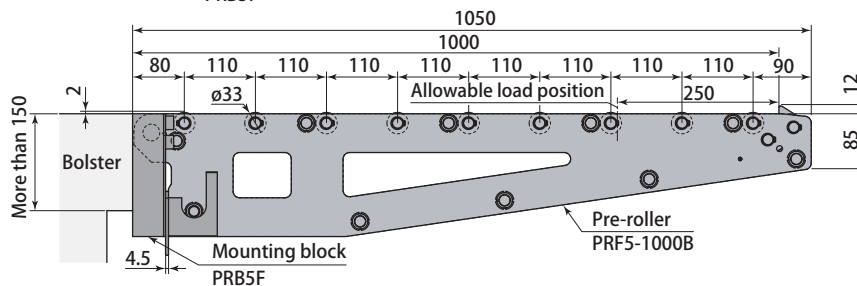
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PRF5-0950B-S



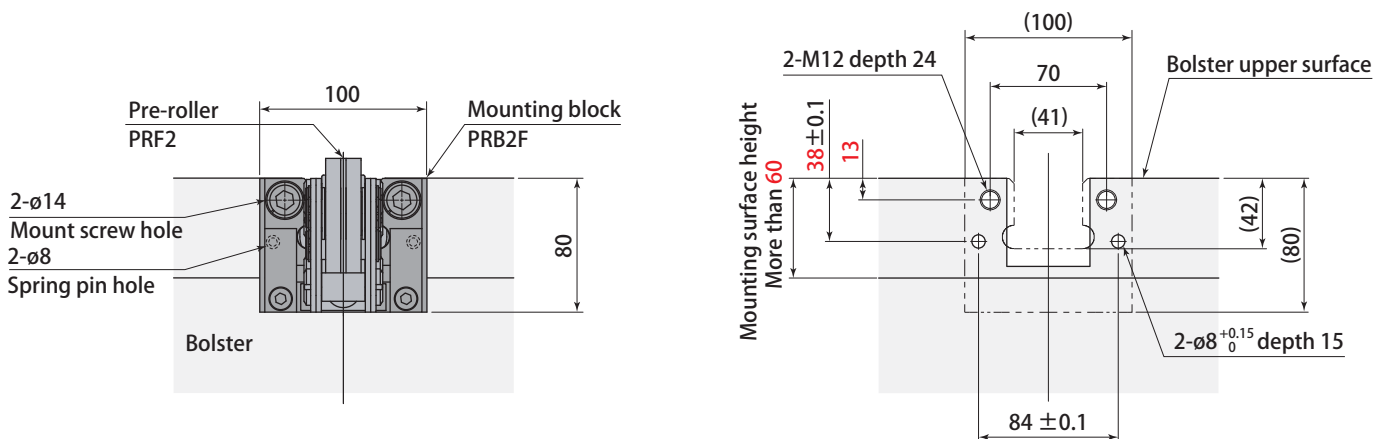
PRF5-1000B-S



Pre-roller removable & fold PRF

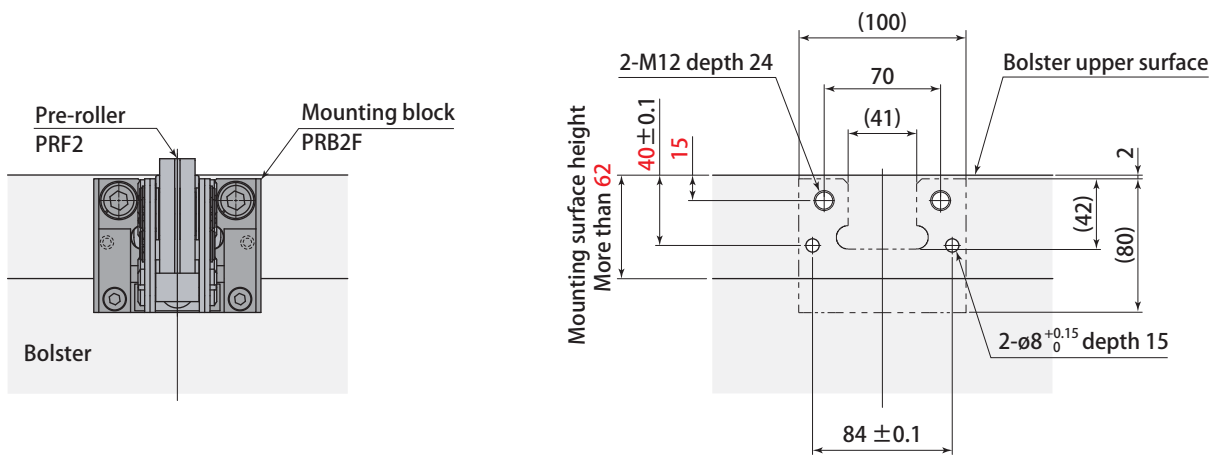
Dimensions, Mounting details

● When using the Die-lifter



● When not using the Die-lifter

When aligning the level between roller top and bolster surface



- When machining the spring pin hole, keep the tolerances shown above.
- Drill dia 8mm, 15mm deep hole for spring pin when co-machining the block with mount face.

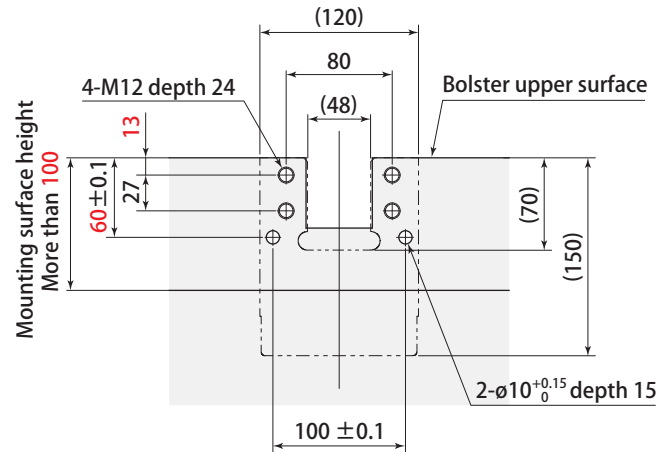
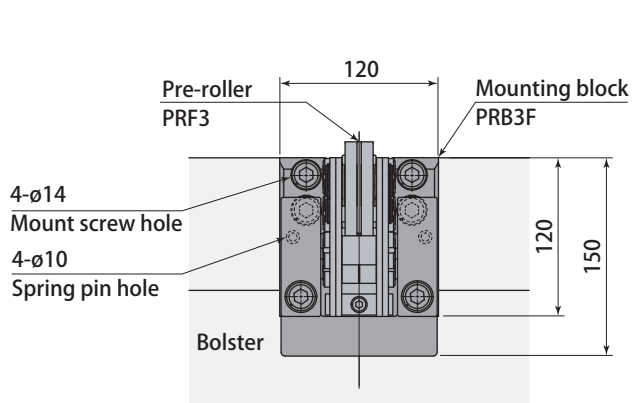
Model	PRB2F
Weight	kg 2.1
Mount screw	2-M12 length 55
Spring washer	2-M12
Spring pin	2-ø8 length 45

- Mounting block for PRF2

Pre-roller removable & fold
PRF Mounting block

Dimensions, Mounting details

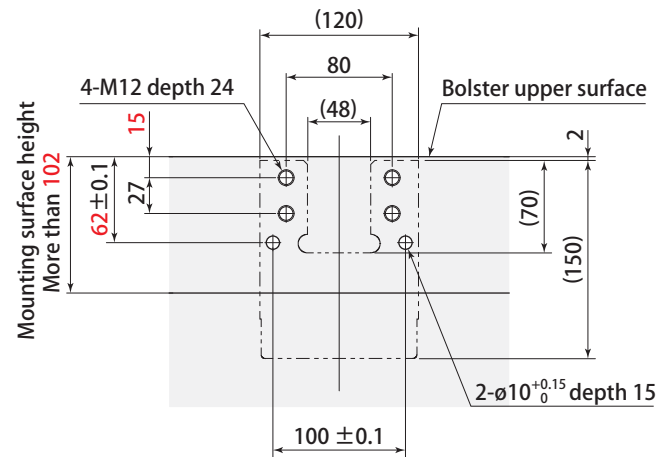
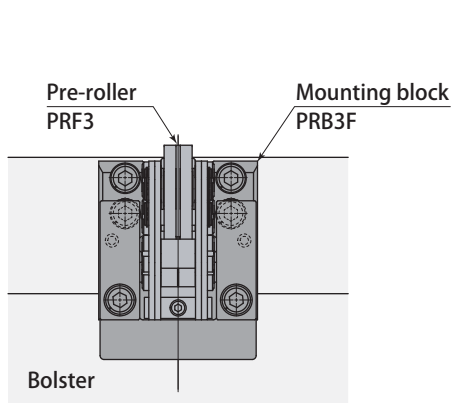
● When using the Die-lifter



Pre-roller removable & fold
PRF Mounting block

● When not using the Die-lifter

When aligning the level between roller top and bolster surface



- When machining the spring pin hole, keep the tolerances shown above.
- Drill dia 10mm, 15mm deep hole for spring pin when co-machining the block with mount face.

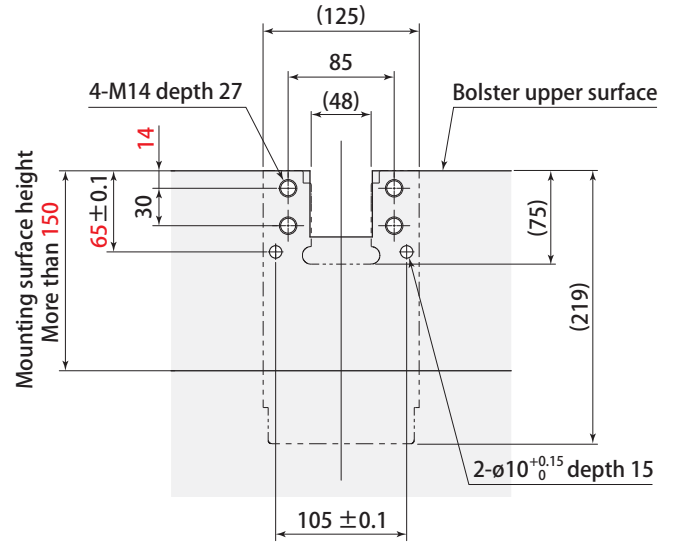
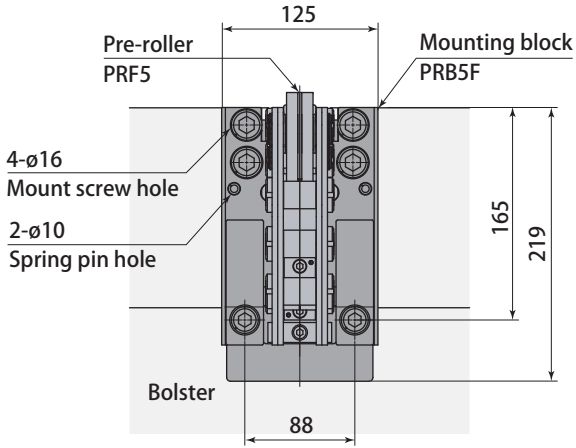
Model	PRB3F
Weight	kg 5.8
Mount screw	4-M12 length 60
Spring washer	4-M12
Spring pin	2-ø10 length 56

● Mounting block for PRF3

Dimensions, Mounting details

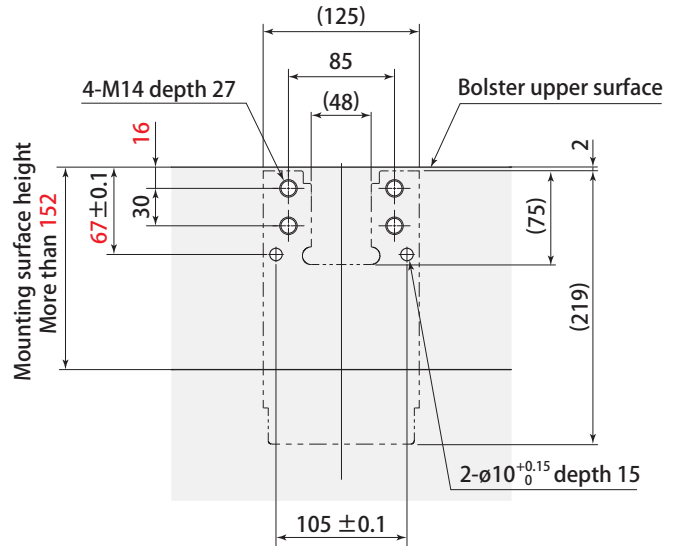
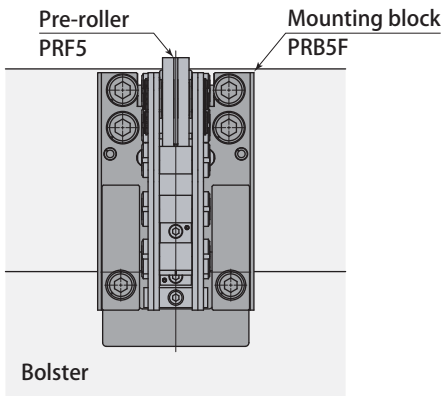
Pre-roller removable & fold
PRF Mounting block

● When using the Die-lifter



● When not using the Die-lifter

When aligning the level between roller top and bolster surface



- When machining the spring pin hole, keep the tolerances shown above.
- Drill dia 10mm, 15mm deep hole for spring pin when co-machining the block with mount face.

Model		PRB5F
Weight	kg	10
Mount screw		4-M14 length 75
Spring washer		4-M14
Spring pin		2-ø10 length 63

- Mounting block for PRF5