Pre-roller Removable & fold type PRF

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

At installation

- Pre-roller model PRF
- Mounting block model PRB\(\text{-}\)F
- Bolster
- Hook

At removal

- Pre-roller model PRF
- Mounting block model PRB\(\text{-}\)F
- Bolster
- Hook

At hanging

- Mounting block model PRB\(\text{-}\)F
- Pre-roller model PRF
- Bolster
- Hook

It can be installed and removed at one touch operation.

- Be noted that the specifications of Mounting block PRB and PRB\(\text{-}\)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
- **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
- **Die travel (mm)**: Indicated in 4 digits

#### Mounting block model type

**PRB 2 F**

- **Size**: PRB2F, PRB3F, PRB5F

---

### Die travel measurement

<table>
<thead>
<tr>
<th>PRF2</th>
<th>PRF3</th>
<th>PRF5</th>
</tr>
</thead>
<tbody>
<tr>
<td>Die travel (mm)</td>
<td>Die travel (mm)</td>
<td>Die travel (mm)</td>
</tr>
<tr>
<td>200</td>
<td>250</td>
<td>315</td>
</tr>
<tr>
<td>mm</td>
<td>mm</td>
<td>mm</td>
</tr>
</tbody>
</table>

- **Pre-roller removable & fold**
- **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) × 9.81 × 1000

---

**1 Die travel** **200 ~ 1000 mm**

**Die transfer speed**

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

![Diagram](image_url)
PRF2 Pre-roller Removable & fold type PRF

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
## PRF2

**Pre-roller Removable & fold type PRF**

### 1 Die travel 200 ~ 630 mm

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

---

**PRF2-0450B-S**

- More than 60
- Bolster
- Mounting block PRB2F
- Pre-roller PRF2-0450B
- Allowable load position
- 492

---

**PRF2-0500B-S**

- More than 60
- Bolster
- Mounting block PRB2F
- Pre-roller PRF2-0500B
- Allowable load position
- 542

---

**PRF2-0560B-S**

- More than 60
- Bolster
- Mounting block PRB2F
- Pre-roller PRF2-0560B
- Allowable load position
- 602

---

**PRF2-0630B-S**

- More than 60
- Bolster
- Mounting block PRB2F
- Pre-roller PRF2-0630B
- Allowable load position
- 672
### PRF3

**Pre-roller Removable & fold type PRF**

| 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  | 315         | 355         | 400        | 450        | 500        | 560        | 630        | 710        | 800        | 850        | 900        | 950        | 1000       |
| Pre-roller total length | 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        |
| 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**

![Diagram](image1)

**PRF3-0800B-S**

![Diagram](image2)

**PRF3-0850B-S**

![Diagram](image3)

**PRF3-0900B-S**

![Diagram](image4)

**PRF3-0950B-S**

![Diagram](image5)

**PRF3-1000B-S**

![Diagram](image6)
Pre-roller  Removable & fold type PRF

1 Die travel  400 ~ 1000 mm

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

PRF5-0710B-S

PRF5-0800B-S

PRF5-0850B-S

PRF5-0900B-S

PRF5-0950B-S

PRF5-1000B-S
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.

<table>
<thead>
<tr>
<th>Model</th>
<th>PRB2F</th>
</tr>
</thead>
<tbody>
<tr>
<td>Weight</td>
<td>2.1</td>
</tr>
<tr>
<td>Mount screw</td>
<td>2-M12 length 55</td>
</tr>
<tr>
<td>Spring washer</td>
<td>2-M12</td>
</tr>
<tr>
<td>Spring pin</td>
<td>2-ø8 length 45</td>
</tr>
</tbody>
</table>

Mounting block for PRF2
### Dimensions, Mounting details

#### When using the Die-lifter

When aligning the level between roller top and bolster surface

#### 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.

<table>
<thead>
<tr>
<th>Model</th>
<th>PRB3F</th>
</tr>
</thead>
<tbody>
<tr>
<td>Weight</td>
<td>5.8</td>
</tr>
<tr>
<td>Mount screw</td>
<td>4-M12 length 60</td>
</tr>
<tr>
<td>Spring washer</td>
<td>4-M12</td>
</tr>
<tr>
<td>Spring pin</td>
<td>2-Ø10 length 56</td>
</tr>
</tbody>
</table>

Mounting block for PRF3
### Dimensions, Mounting details

#### When using the Die-lifter

- **Pre-roller** PRF5
- **Mounting block** PRB5F
- 4-Ø16 Mount screw hole
- 2-Ø10 Spring pin hole

![Diagram of Die-lifter Dimensions](image1)

**Mounting block height:** 85
**4-M14 depth:** 27
**Bolster upper surface:**

- **Dimensions:**
  - 125
  - 165
  - 219
  - 88

#### When not using the Die-lifter

When aligning the level between roller top and bolster surface

![Diagram of Die-lifter Dimensions](image2)

**Mounting block height:** 85
**4-M14 depth:** 27

- **Dimensions:**
  - 125
  - 165
  - 219

#### 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 Specifications

<table>
<thead>
<tr>
<th>Model</th>
<th>PRB5F</th>
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</thead>
<tbody>
<tr>
<td>Weight</td>
<td>10 kg</td>
</tr>
<tr>
<td>Mount screw</td>
<td>4-M14 length 75</td>
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<tr>
<td>Spring washer</td>
<td>4-M14</td>
</tr>
<tr>
<td>Spring pin</td>
<td>2-Ø10 length 63</td>
</tr>
</tbody>
</table>

- **Mounting block for PRF5**