

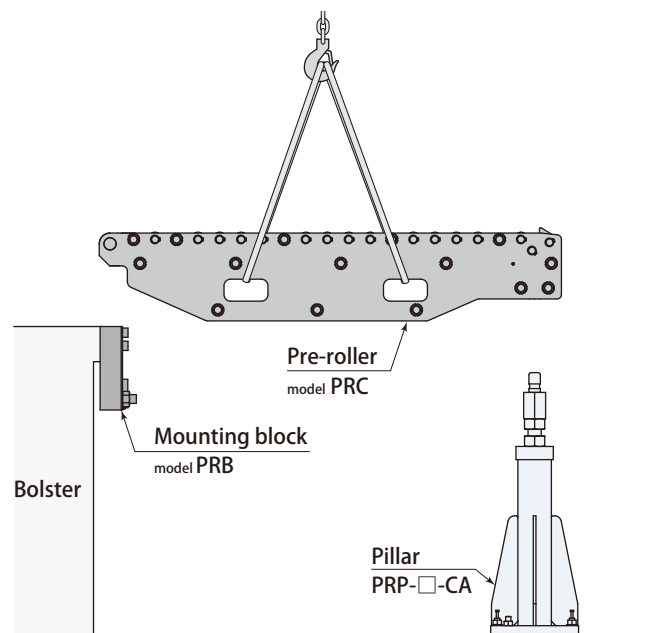
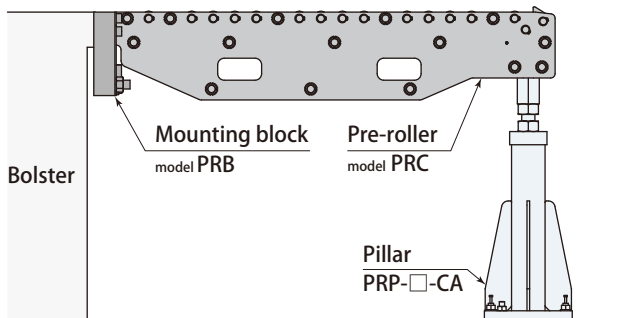
It is heavy load type of pre-roller which attaches pillar to the removal type PRA.



Pre-roller heavy load
PRC

At installation

At removal



- The Pre-roller may be damaged due to the vibration through stamping operation. The removal of pre-roller during the operation is recommended.

Model designation

Set model (Pre-roller + Mounting block + Pillar)

PRC **3** - **0710** B **0300** - S

Size
PRC3 PRC5

1 Die travel (mm) * Indicated in 4 digits

Pillar size * Indicated in 4 digits
Refer to page → 201

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

Pre-roller model type

PRC **3** - **0710** B

Size
PRC3 PRC5

1 Die travel (mm) * Indicated in 4 digits

Mounting block model type

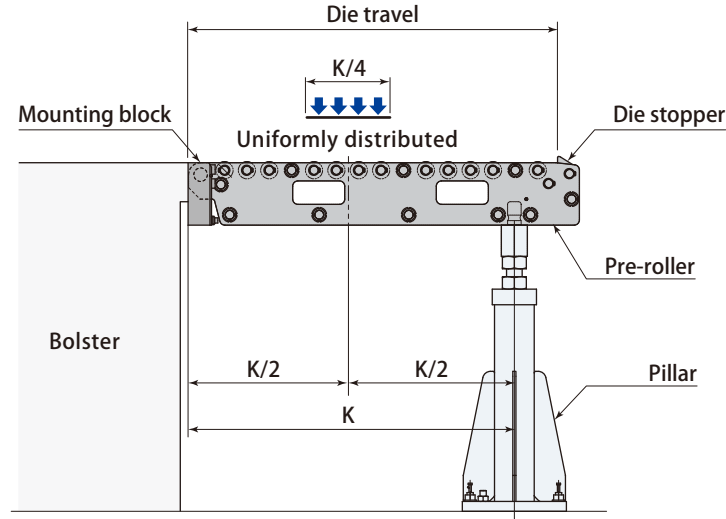
PRB **3**

Size
PRB3 PRB5

Pillar model type

PRP - **0300** - CA

Pillar size * Indicated in 4 digits
Refer to page → 201



1 Die travel **710** ~ **1250** mm

Die travel		mm	710	800	850	900	950	1000	1250
PRC3	Allowable load *	kN	30	30	25	25	25	20	16
	Number of rollers		12	12	14	14	16	16	22
	Weight	kg	15.4	16.9	18.3	19.2	20.5	21.3	27.5
PRC5	Allowable load	kN	—	—	—	—	—	35	35
	Number of rollers		—	—	—	—	—	14	18
	Weight	kg	—	—	—	—	—	29.8	38

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

● Weight does not include mounting block and pillar.

* Allowable load is uniformly distributed and is held by the middle part of the Pre-roller. 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

PRC 3 – 0710 B 0300 – S

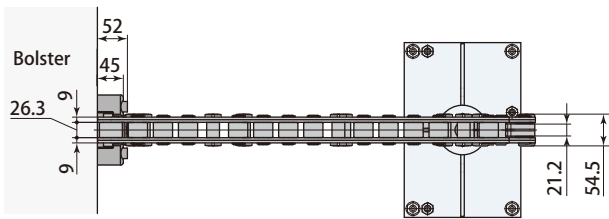
1 Die travel (mm) •
* Indicated in 4 digits

Pillar size •
* Indicated in 4 digits

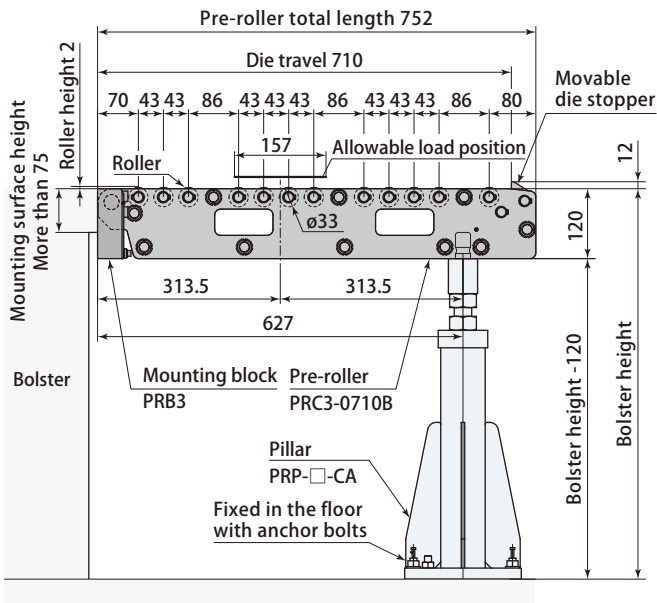
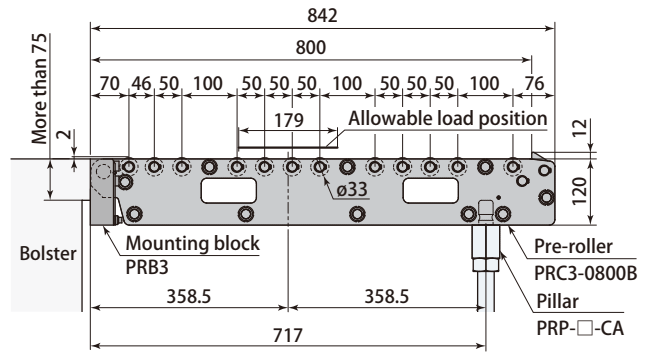
1 Die travel 710 ~ 1250 mm

Model	PRC3-0710B	PRC3-0800B	PRC3-0850B	PRC3-0900B	PRC3-0950B	PRC3-1000B	PRC3-1250B
Die travel	mm 710	800	850	900	950	1000	1250
Pre-roller total length	mm 752	842	892	942	992	1042	1292
Weight	kg 15.4	16.9	18.3	19.2	20.5	21.3	27.5

PRC3-0710B□-S

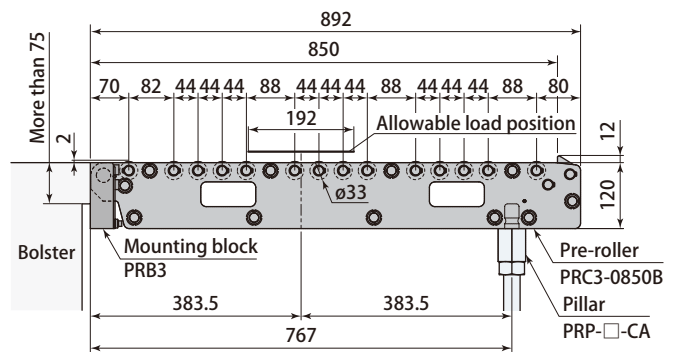


PRC3-0800B□-S



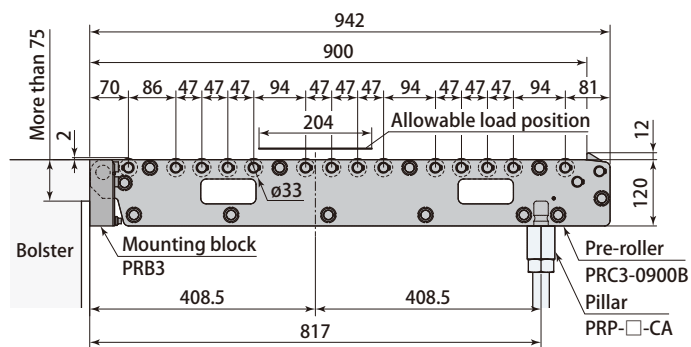
Refer to page → 201 for Pillar.

PRC3-0850B□-S

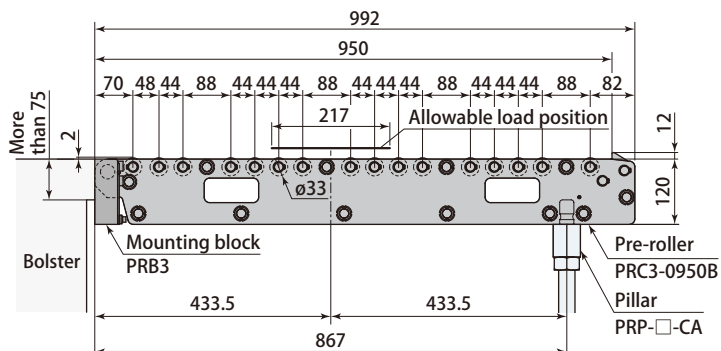


Pre-roller heavy load PRC

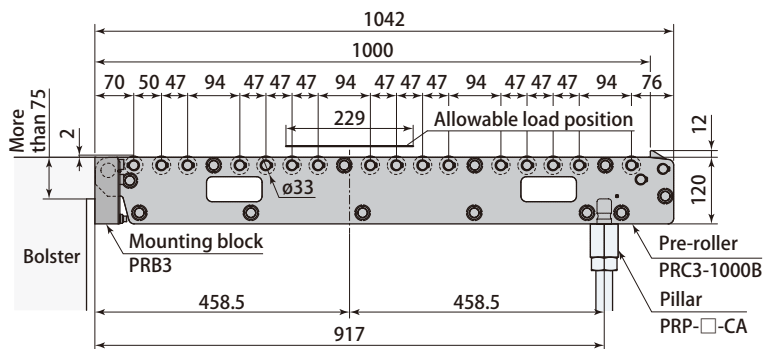
PRC3-0900B□-S



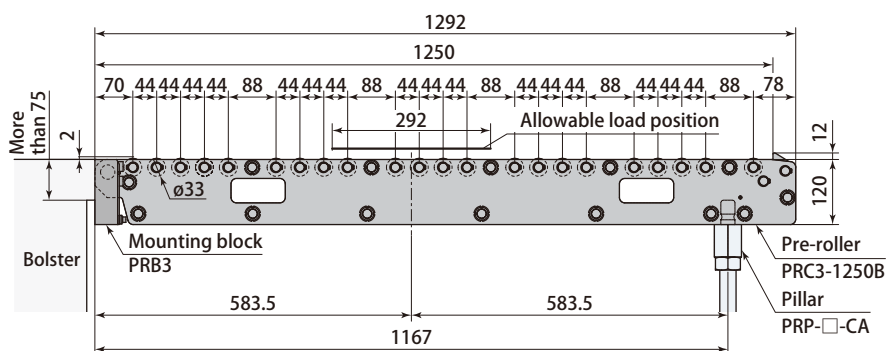
PRC3-0950B□-S



PRC3-1000B□-S



PRC3-1250B□-S



Pre-roller heavy load PRC

Dimensions

PRC 5 – 1000 B 0300 – S

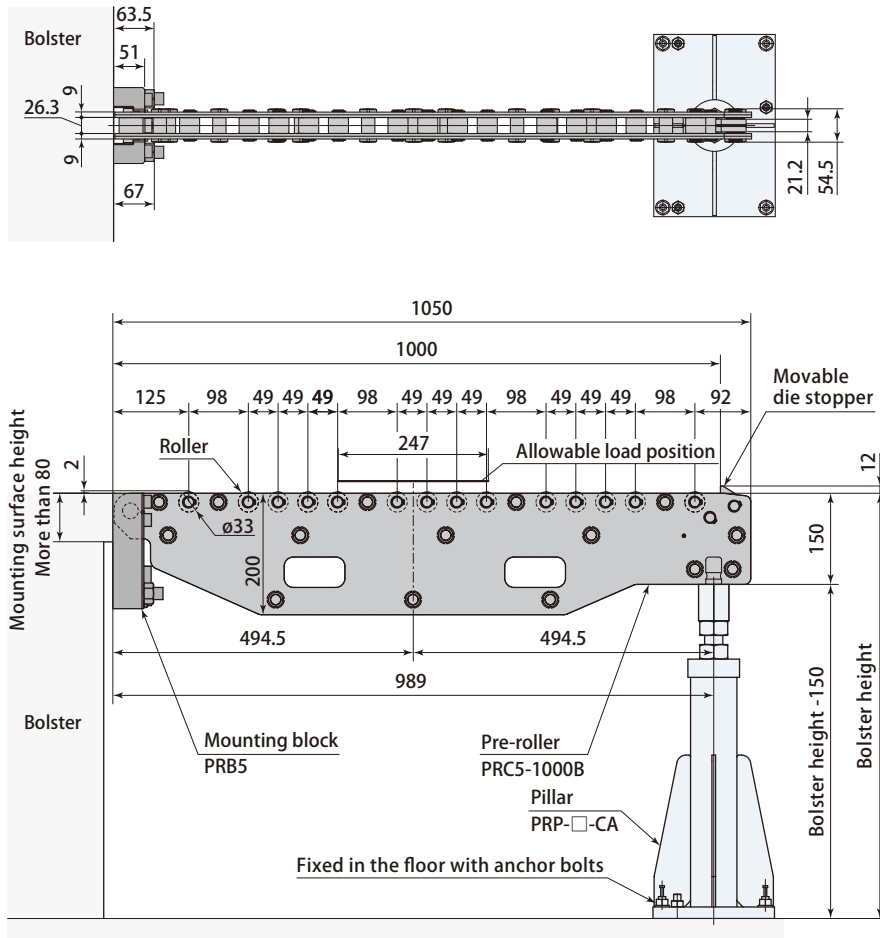
1 Die travel (mm) •.....
* Indicated in 4 digits

Pillar size •.....
* Indicated in 4 digits

1 Die travel 1000, 1250 mm

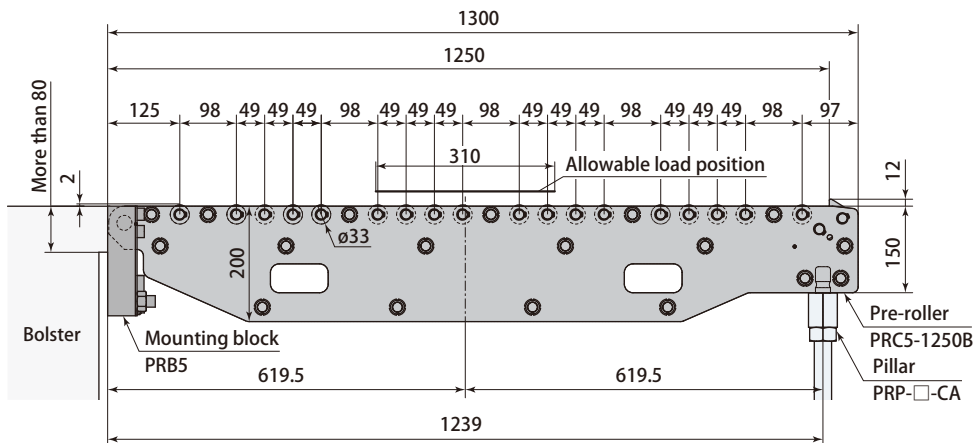
Model		PRC5-1000B	PRC5-1250B
Die travel	mm	1000	1250
Pre-roller total length	mm	1050	1300
Weight	kg	29.8	38

PRC5-1000B□-S



Refer to page → 201 for Pillar.

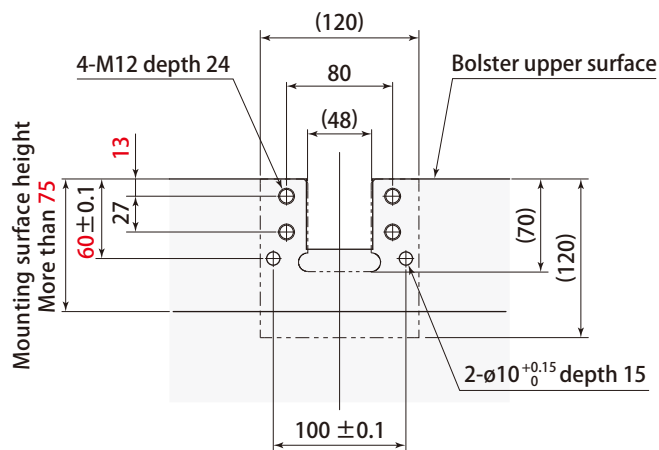
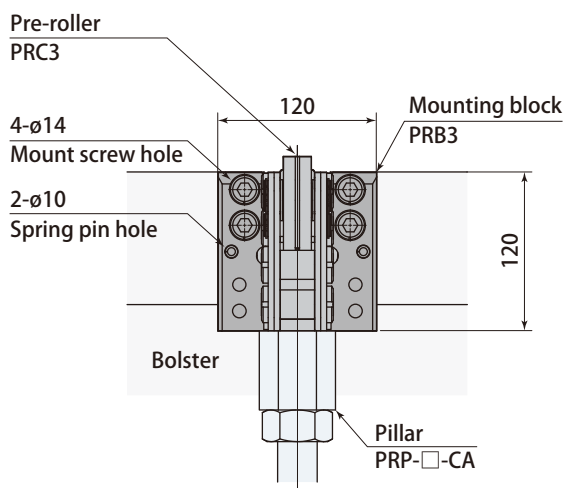
PRC5-1250B□-S



Pre-roller heavy load
PRC

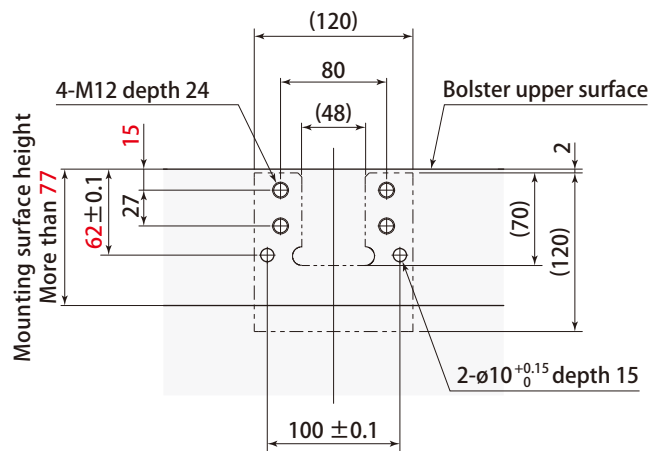
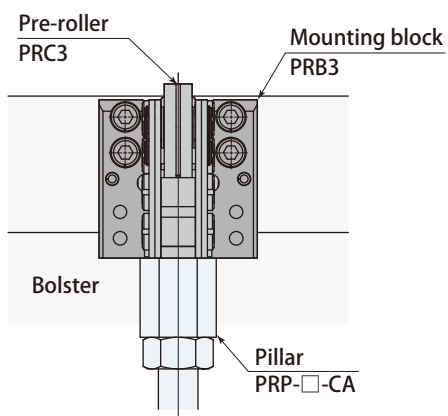
Dimensions, Mounting details

● 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 10mm, 15mm deep hole for spring pin when co-machining the block with mount face.

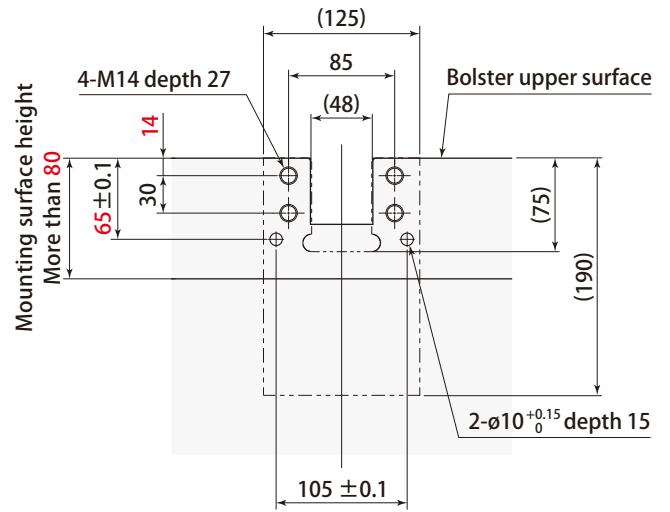
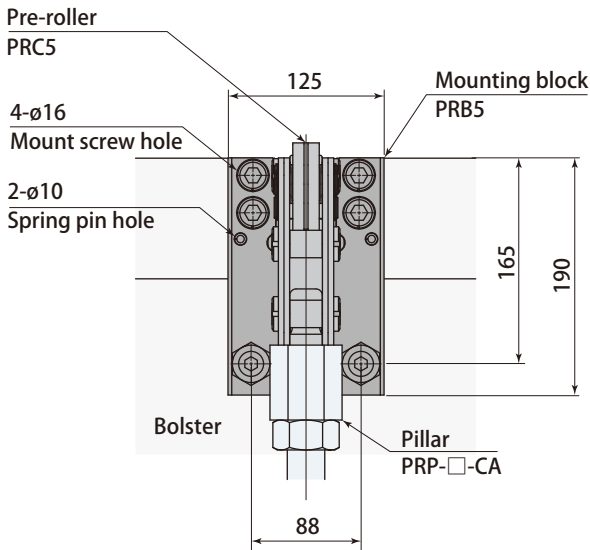
Model	PRB3
Weight	kg 3.6
Mount screw	4-M12 length 60
Spring washer	4-M12
Spring pin	2-C10 length 56

● Mounting block for PRC3

Pre-roller heavy load PRC Mounting details

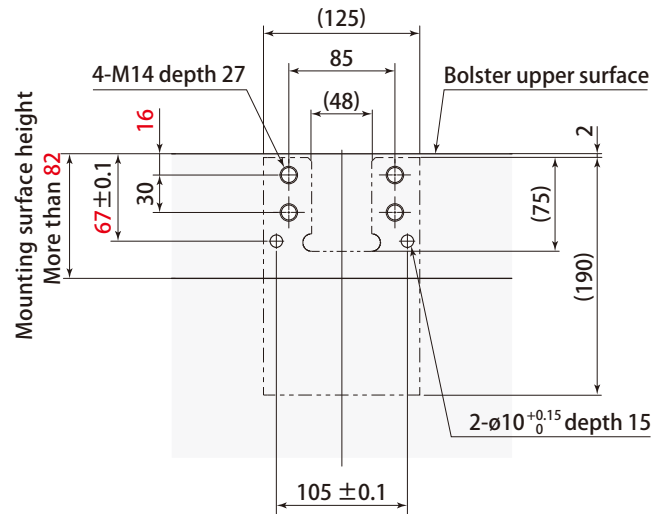
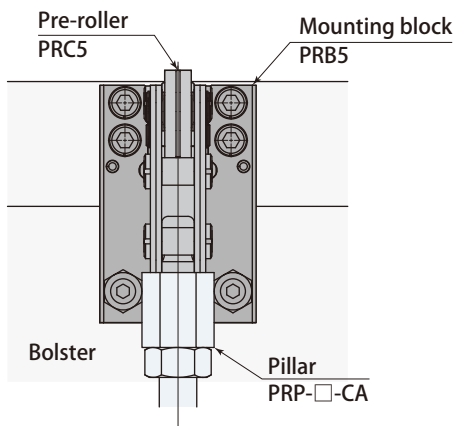
Dimensions, Mounting details

● When using the Die-lifter



● When not using the Die-lifter

When aligning the level between roller top and bolster surface



Pre-roller heavy load
PRC Mounting details

- 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	PRB5
Weight	kg 7.5
Mount screw	4-M14 length 75
Spring washer	4-M14
Spring pin	2-C10 length 63

● Mounting block for PRC5

Pillar Select Pillar for aligning the height with bolster. Pillar weight and dimension of PRC3 and PRC5 is the same.

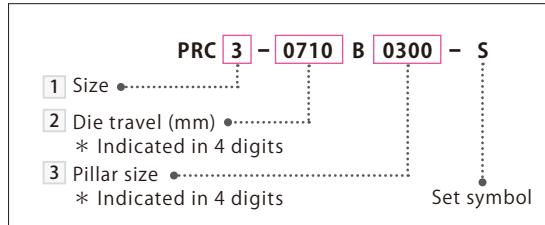
Model designation

Pillar model type

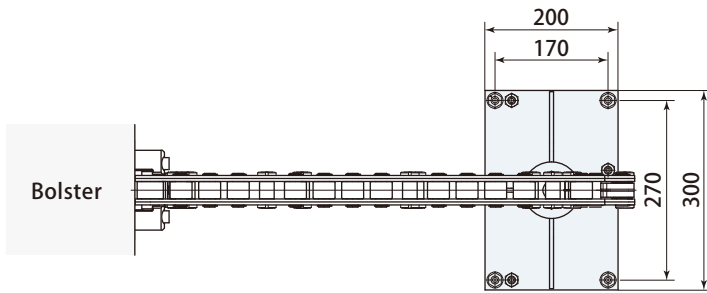
PRP **0300** - CA

3 Pillar size
* Indicated in 4 digits

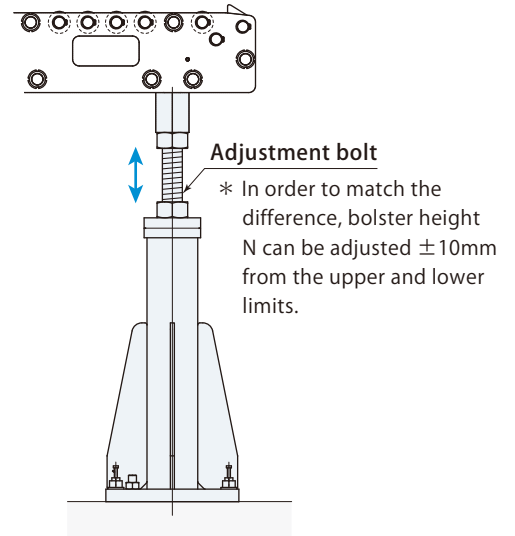
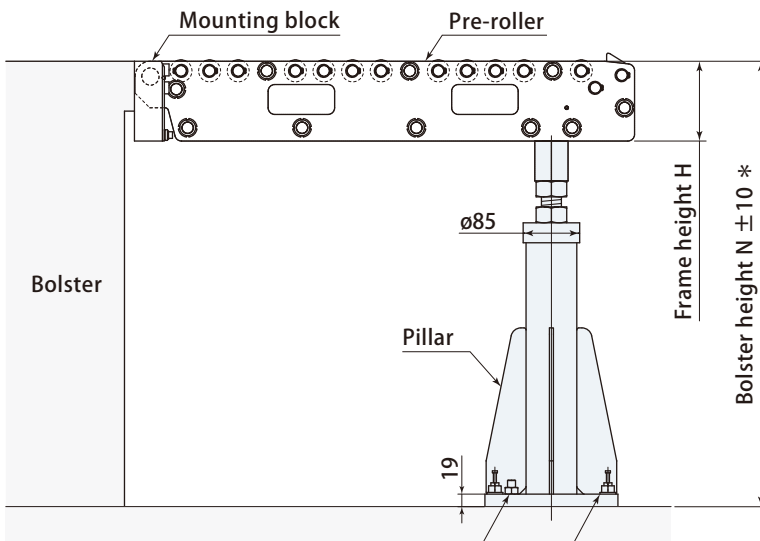
Set model



1 2
Refer to page → 194



With the Adjustment bolt, Pillar height can be adjusted



- 3- ϕ 10.3
- 3-M12 length 40 Level adjustment bolt
- 3-M12 Hex. Nut
- ϕ 85
- 4- ϕ 14
- 4-C12 length 90 Strike anchor

- Adjust the Pillar horizontally using a level adjustment bolt and shim.
- The shim is not included. Order it separately.

3 Pillar size **0300** ~ **1050**

Pillar size		0300	0350	0400	0450	0500	0550	0600	0650	0700	0750	0800	0850	0900	0950	1000	1050
PRC3-0710 ~ 1250	Bolster height N mm	420 S 469	470 S 519	520 S 569	570 S 619	620 S 669	670 S 719	720 S 769	770 S 819	820 S 869	870 S 919	920 S 969	970 S 1019	1020 S 1069	1070 S 1119	1120 S 1169	1170 S 1219
	Frame height H mm	120															
PRC5-1000, 1250	Bolster height N mm	450 S 499	500 S 549	550 S 599	600 S 649	650 S 699	700 S 749	750 S 799	800 S 849	850 S 899	900 S 949	950 S 999	1000 S 1049	1050 S 1099	1100 S 1149	1150 S 1199	1200 S 1249
	Frame height H mm	150															
Weight kg		15.7	16.1	16.5	18.4	18.8	19.2	19.6	20.0	20.4	20.8	21.2	21.6	22.0	22.4	22.8	23.2

Pre-roller heavy load PRC Pillar