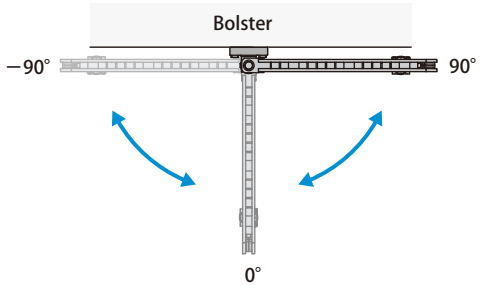
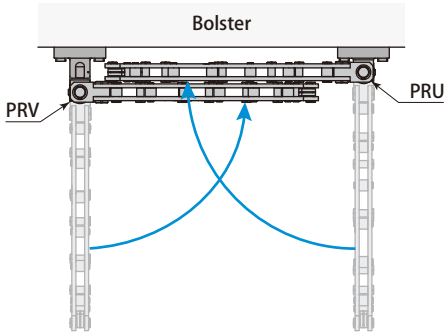
It is a heavy load type of pre-roller which attaches pillar to horizontally fold type PRS/PRT.
It is used by combination of model PRU and PRV.

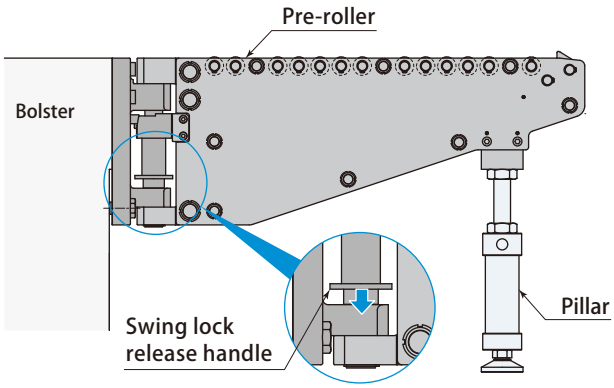


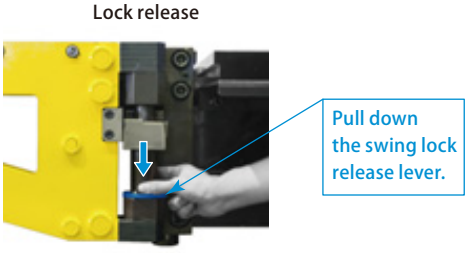
Folding method

Pre-roller will lock at 0°, 90°, and -90°positions.









Model designation

PRU Pre-roller model type **PRU 8 – 0800 B**

1 Die travel (mm) ＊ Indicated in 4 digits

PRV Pre-roller model type **PRV 8 – 0800 B**

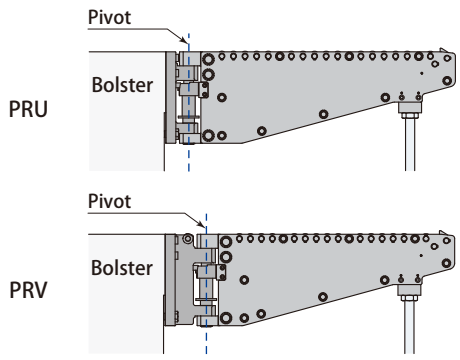
Set model (Pre-roller＋Pillar) **PR U/V 8 – 0800 B 0400 – S**

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

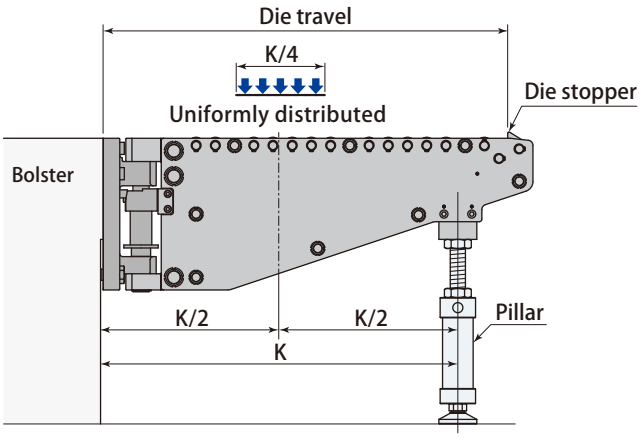
Pillar size ＊ Indicated in 4 digits
Refer to **page → 222**

Pillar model type **PRP – 0400 – U**

Difference of PRU/PRT



Pivot position is different.



1 Die travel 800 ～ 1250 mm

Die travel mm		800	900	1000	1250
PRU8	Allowable load ＊ kN	40	40	40	35
	Number of rollers	13	16	17	23
	Weight kg	59.1	64.1	69.1	82.4
PRV8	Allowable load kN	40	40	40	35
	Number of rollers	13	16	18	24
	Weight kg	63.7	68.8	74.4	87.1

- Die loading speed on Pre-roller : Less than 50mm/s
- Die transfer speed : Less than 100mm/s
- Weight does not include 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

PRU 8 – 0800 B 0400 – S

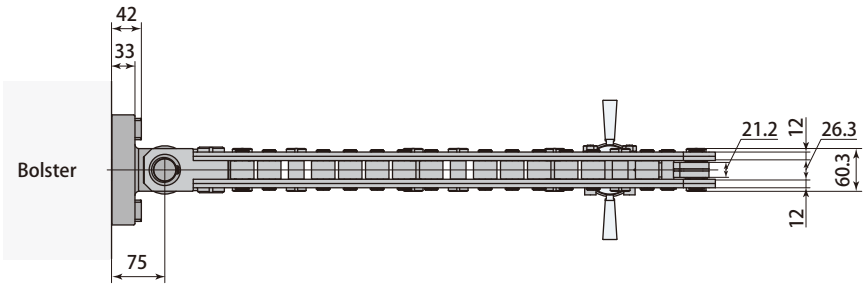
1 Die travel (mm)
＊ Indicated in 4 digits

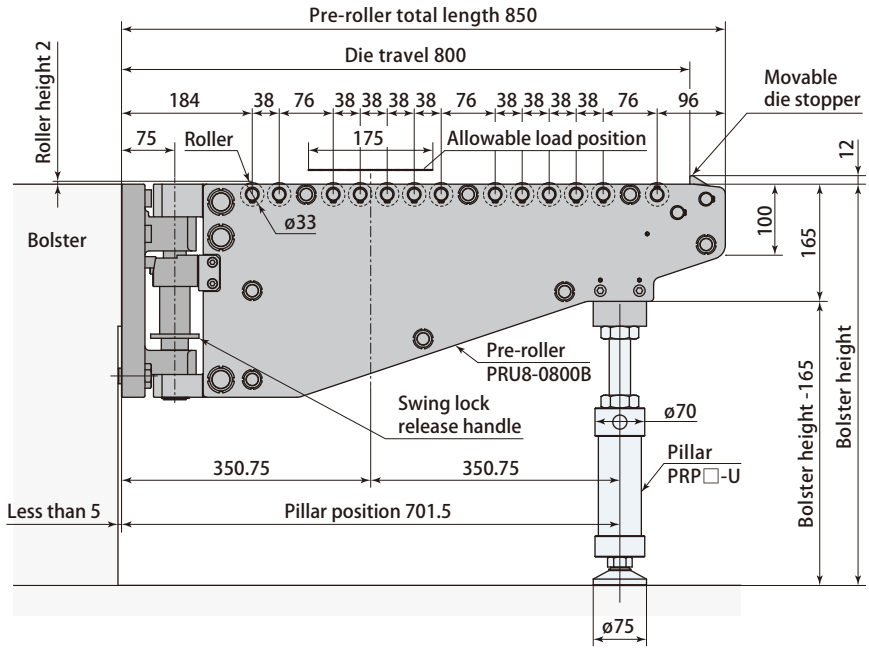
Pillar size
＊ Indicated in 4 digits

1 Die travel 800 ～ 1250 mm

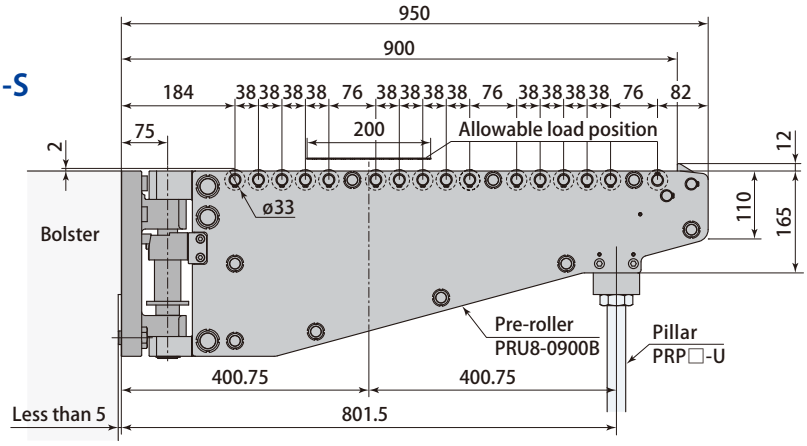
Model		PRU8-0800B	PRU8-0900B	PRU8-1000B	PRU8-1250B
Die travel	mm	800	900	1000	1250
Pre-roller total length	mm	850	950	1050	1300
Weight	kg	59.1	64.1	69.1	82.4

PRU8-0800B□-S

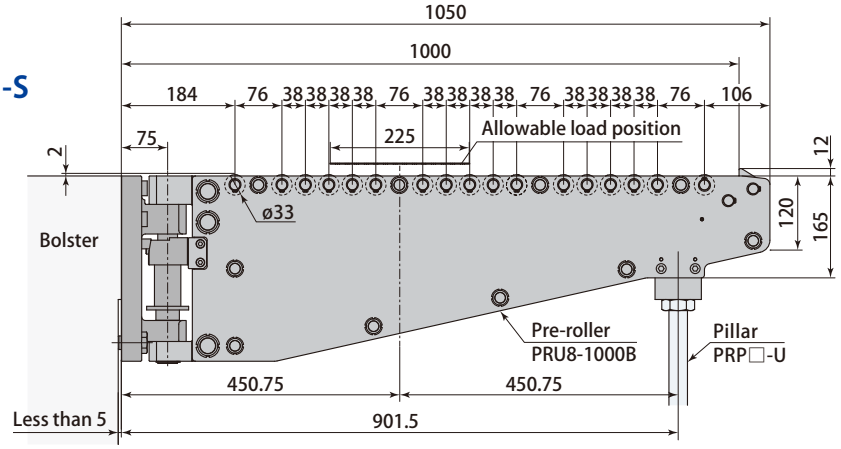




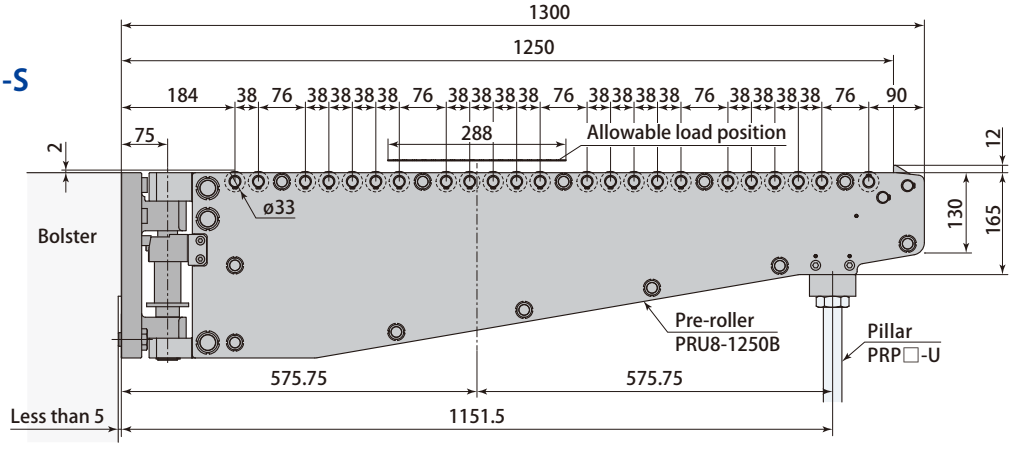
PRU8-0900B□-S



PRU8-1000B□-S



PRU8-1250B□-S



Dimensions

PRV 8 – 0800 B 0400 – S

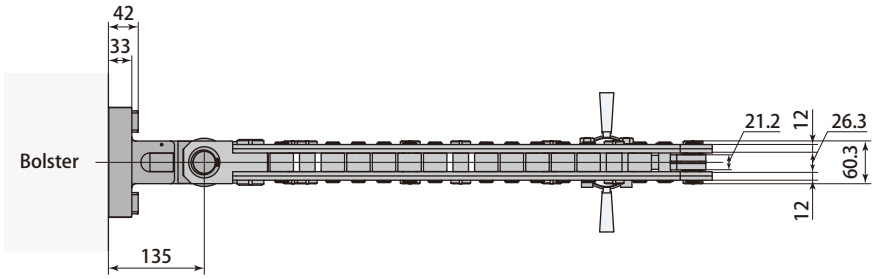
1 Die travel (mm)
＊ Indicated in 4 digits

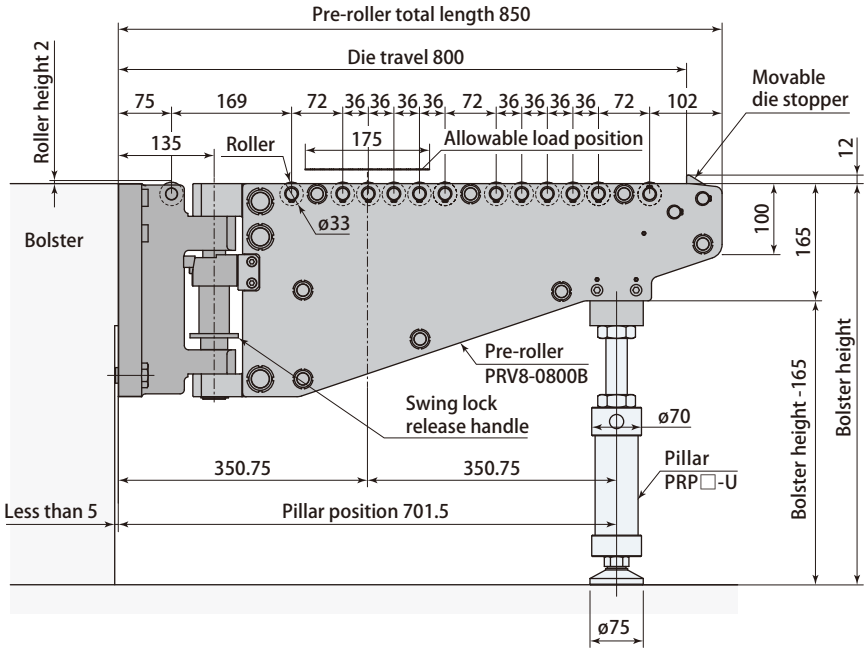
Pillar size
＊ Indicated in 4 digits

1 Die travel 800 ～ 1250 mm

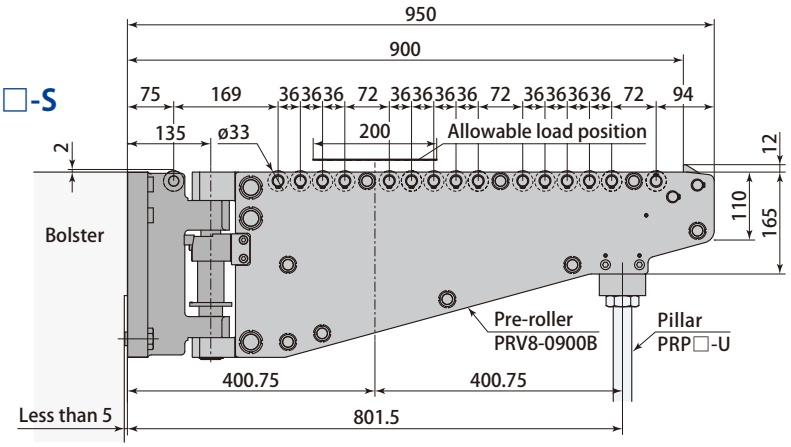
Model		PRV8-0800B	PRV8-0900B	PRV8-1000B	PRV8-1250B
Die travel	mm	800	900	1000	1250
Pre-roller total length	mm	850	950	1050	1300
Weight	kg	63.7	68.8	74.4	87.1

PRV8-0800B□-S

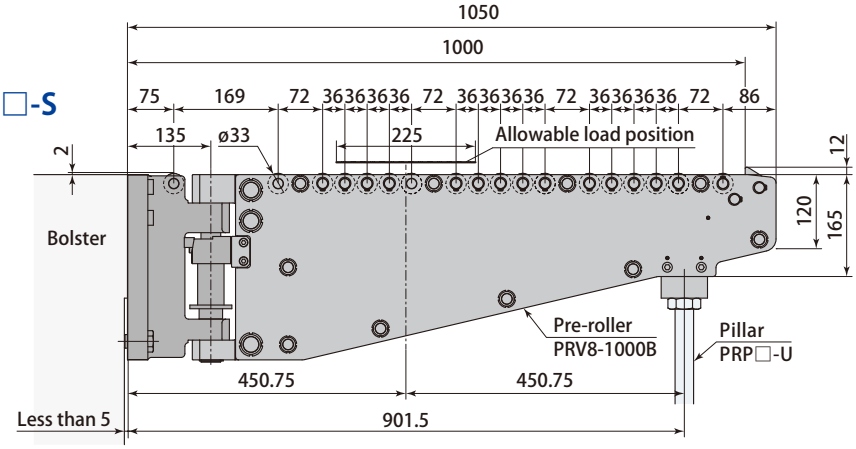




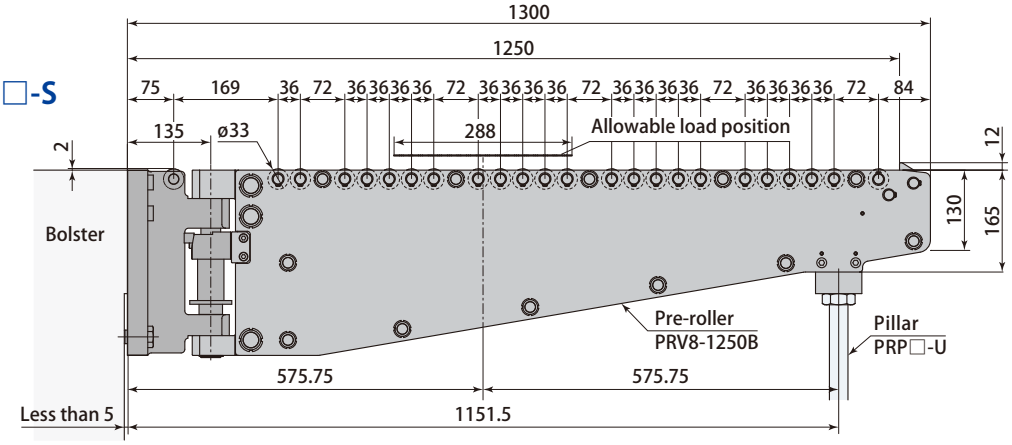
PRV8-0900B□-S

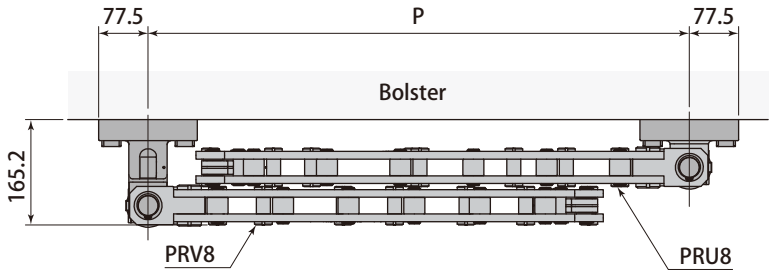


PRV8-1000B□-S



PRV8-1250B□-S



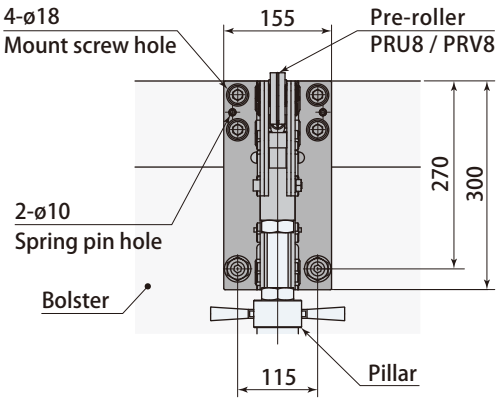


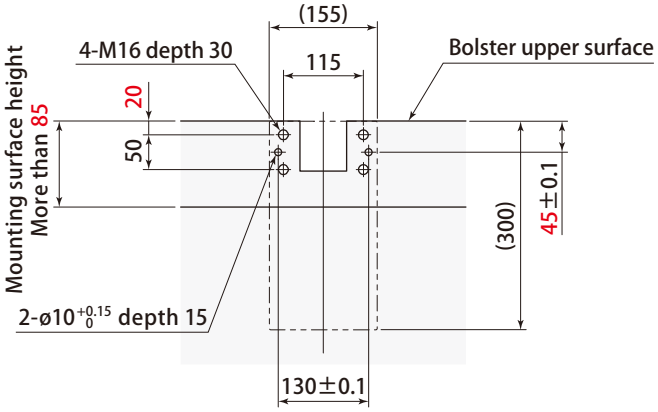
Minimum mounting pitch

Model	PRU8-0800	PRU8-0900	PRU8-1000	PRU8-1250
	PRV8-0800	PRV8-0900	PRV8-1000	PRV8-1250
Minimum mounting pitch P	850	950	1050	1300

Mounting details

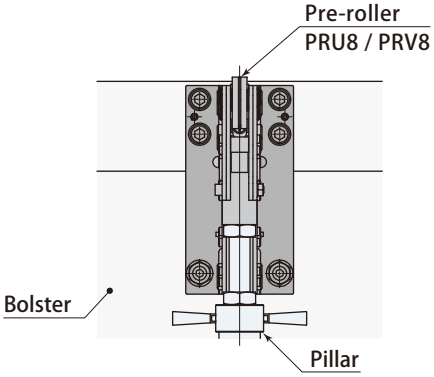
When using the Die-lifter

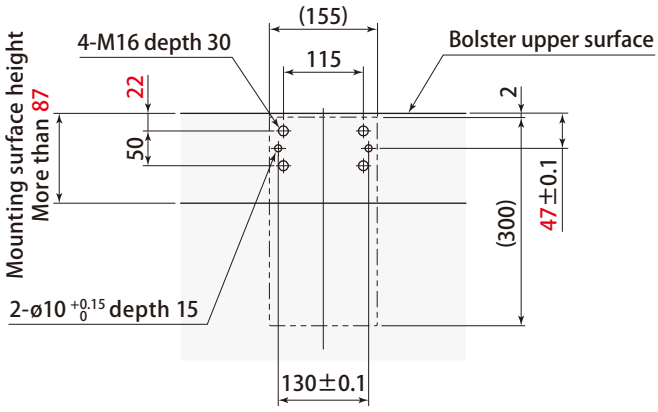




When not using the Die-lifter

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.

Pre-roller model type	PRU8 / PRV8
Mount screw	4-M16 length55
Spring washer	4-M16
Spring pin	2-C10 length45

Pillar

Select Pillar for aligning the height with bolster.

Model designation

Pillar model type

PRP 0400 – U

2 Pillar size
∗ Indicated in 4 digits

PRU 8 Set model

PRU 8 – 0800 B 0400 – S

1 Die travel (mm)
∗ Indicated in 4 digits

2 Pillar size
∗ Indicated in 4 digits

Set symbol

PRV 8 Set model

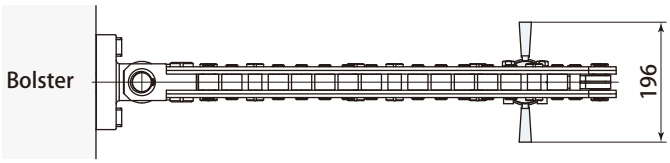
PRV 8 – 0800 B 0400 – S

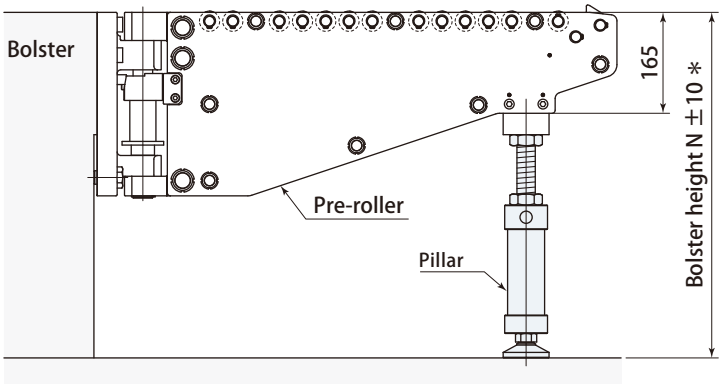
1 Die travel (mm)
∗ Indicated in 4 digits

2 Pillar size
∗ Indicated in 4 digits

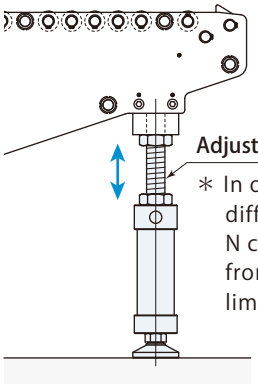
Set symbol

1 Refer to page → 216





With the Adjustment bolt, Pillar height can be adjusted



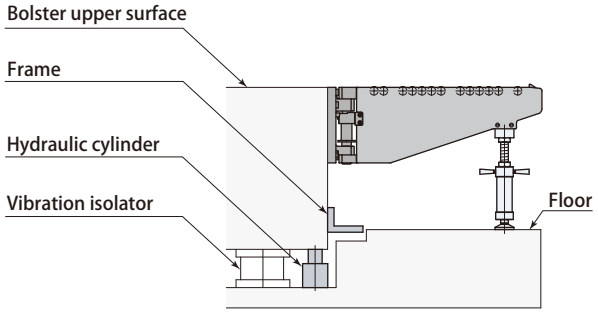
∗ In order to match the difference, bolster height N can be adjusted ±10mm from the upper and lower limits.

2 Pillar size 0400 ~ 1000

Pillar size		0400	0500	0600	0700	0800	0900	1000
Bolster height N	mm	565 ⟆ 664	665 ⟆ 764	765 ⟆ 864	865 ⟆ 964	965 ⟆ 1064	1065 ⟆ 1164	1165 ⟆ 1264
Weight	kg	5.6	6.1	6.7	7.2	7.7	8.3	8.8

- Fix Pillar on the floor except when the pre-roller is swung. Otherwise the Pre-roller may damage due to the vibration through stamping operation.
- In case that the machine is installed with vibration isolators, there is a risk of bolster height change when die loading or unloading. To protect the rollers and pillars, provision of hydraulic cylinder and pillar support bracket are highly recommended as shown in the sketch below.

At die changing



At stamping operation

