

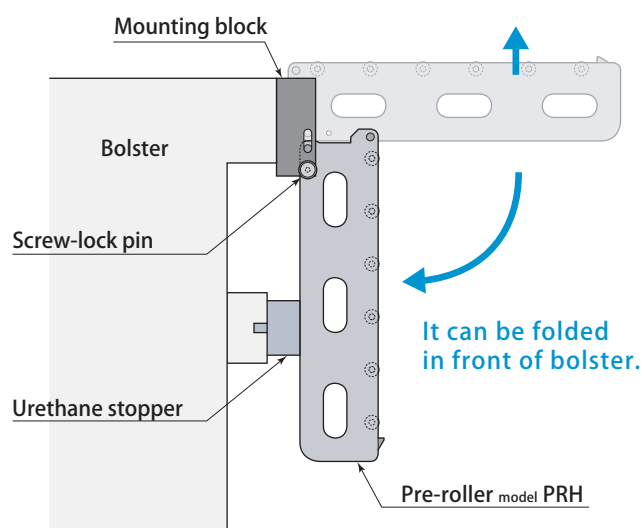
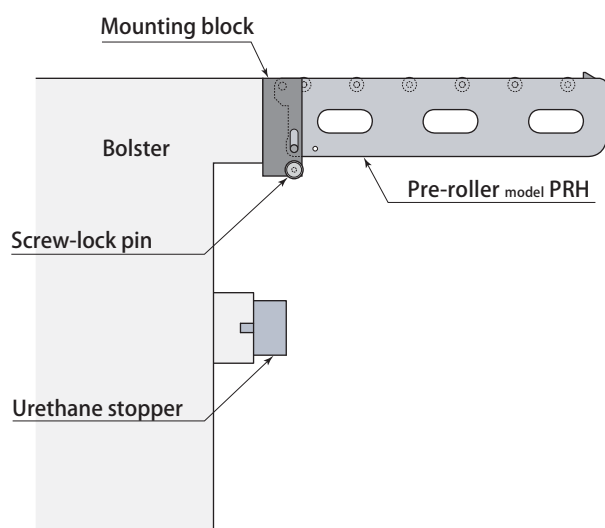
The pre-roller can be folded in front of bolster.

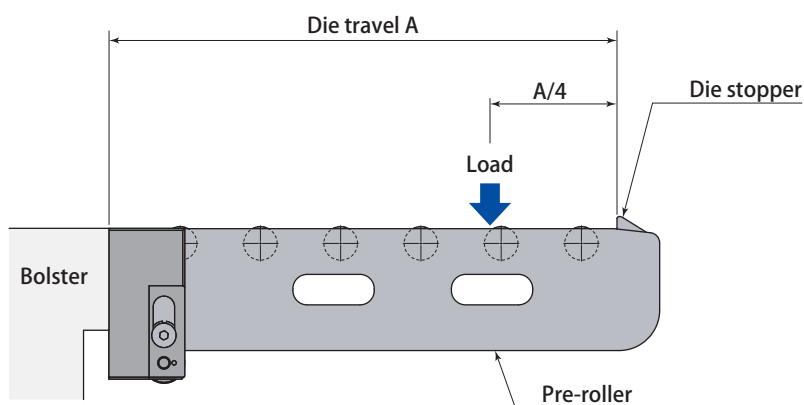
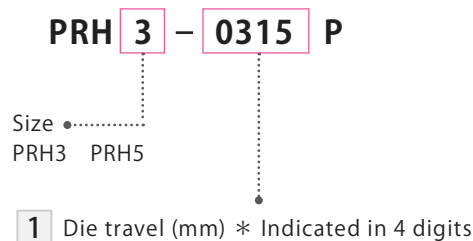


Pre-roller vertically fold
PRH

At installation

At folding



Model designation

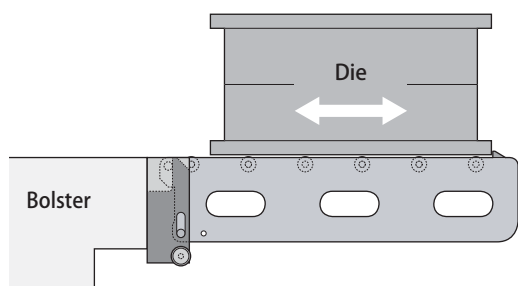
1 Die travel **315** ~ **1000** mm

	Die travel	mm	315	355	400	450	500	560	630	710	800	850	900	950	1000
PRH3	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	13.8	14.6	15.7	16.2	17.2	18.3	19.6	20.9	22.1	23.3	24.3	25.1	26.2
PRH5	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	—	—	24.4	25.9	27.3	28.4	30.4	32.8	35.2	36	37.4	38.9	39.5

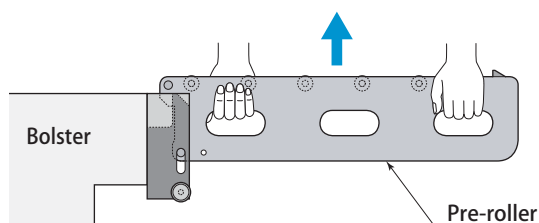
● Die loading speed on Pre-roller : Less than 50mm/s ● Die transfer speed : Less than 100mm/s

* 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

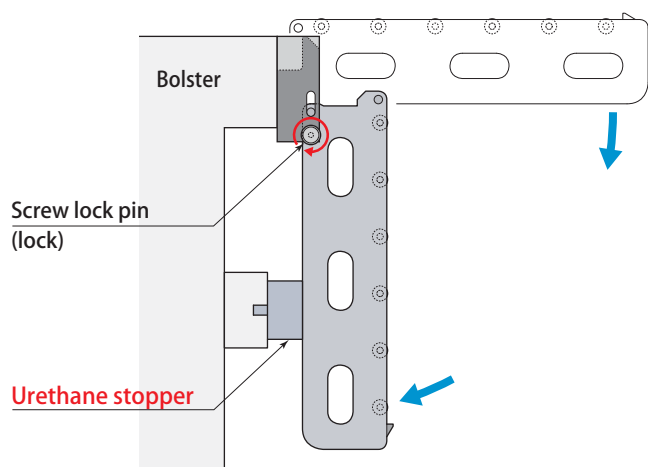
Folding / set up operation



1. At die change

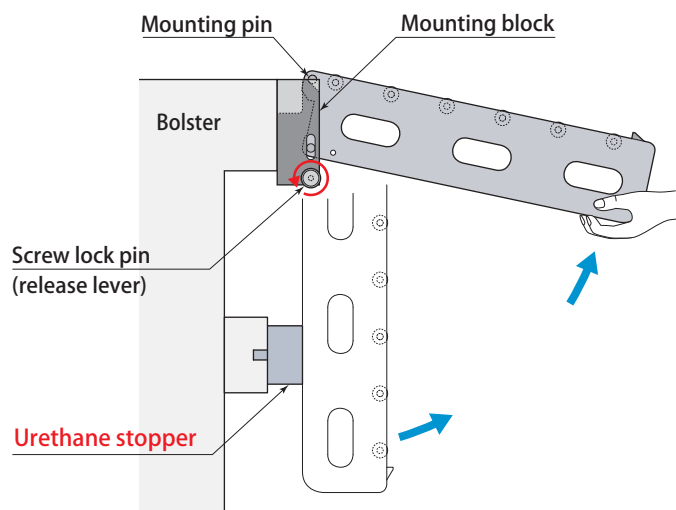


2. Lift up the pre-roller after die change.



3. Lower the tip and fold the pre-roller downward. When screwing the lock pin, the pre-roller is locked and it prevents vibration due to stamping operation.

* When folding, lower the pre-roller slowly. Never get the hand off.



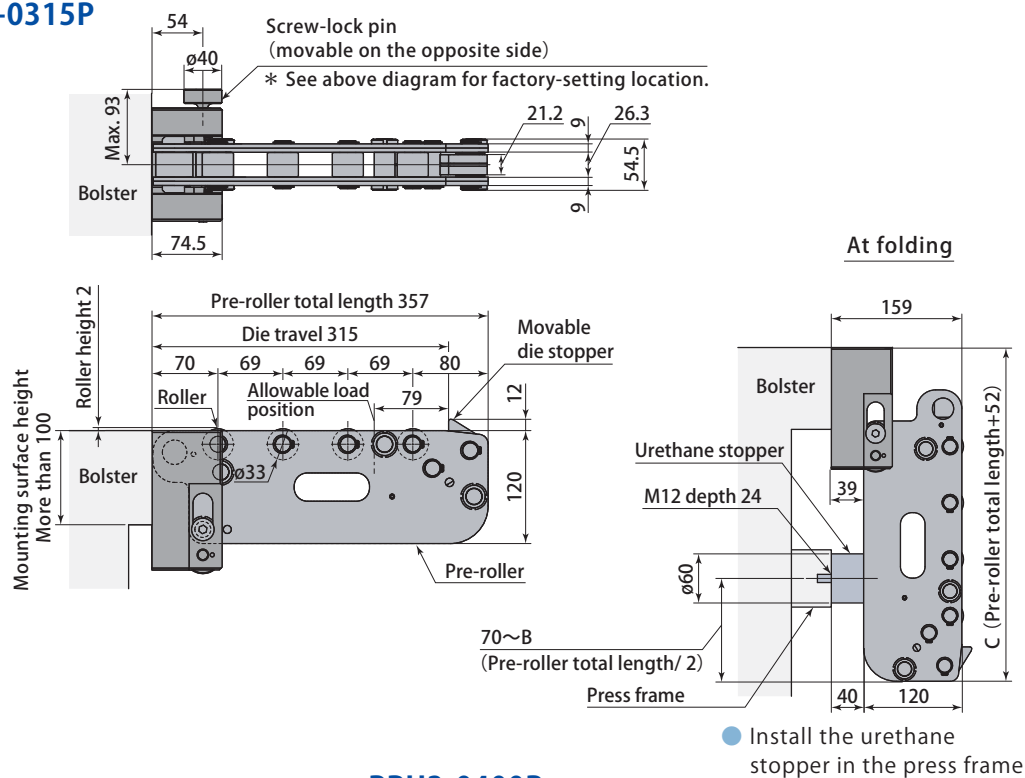
4. When turning the unscrewing lock pin to release the lock and lifting up the tip of pre-roller, mounting pin is hooked to mounting block and the set up shall be completed.

Dimensions

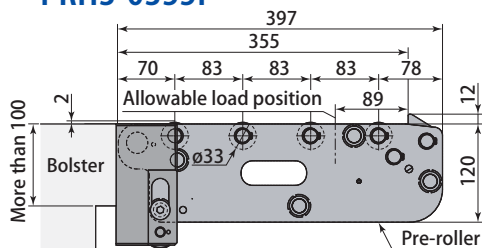
PRH 3 – 0315 P

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

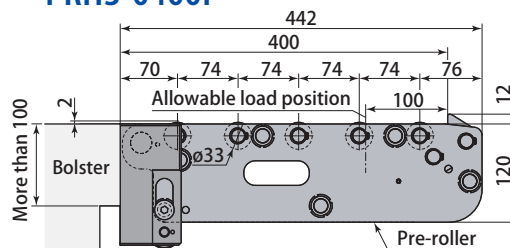
PRH3-0315P



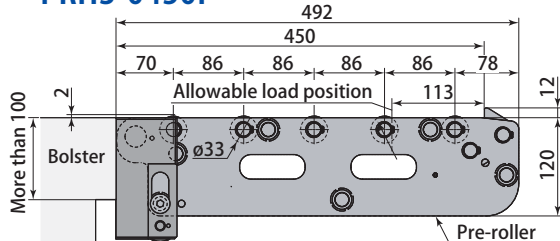
PRH3-0355P



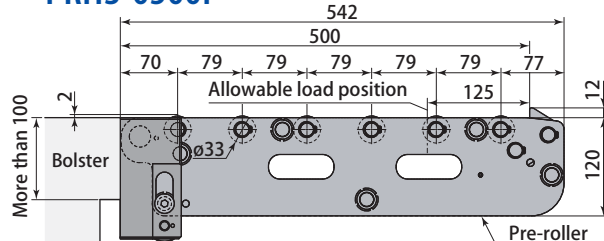
PRH3-0400P



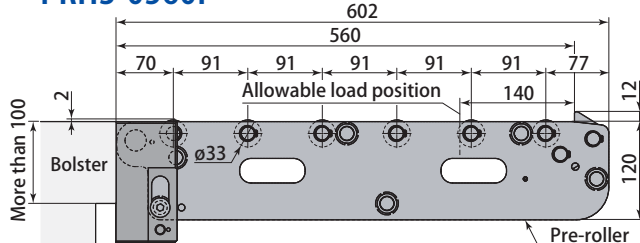
PRH3-0450P



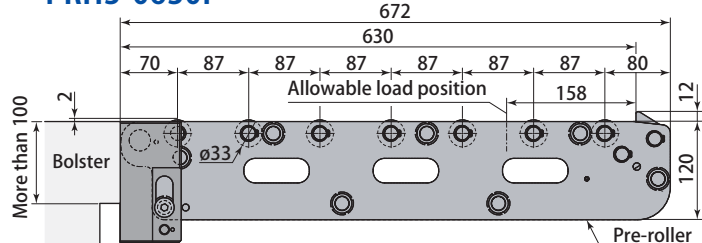
PRH3-0500P



PRH3-0560P

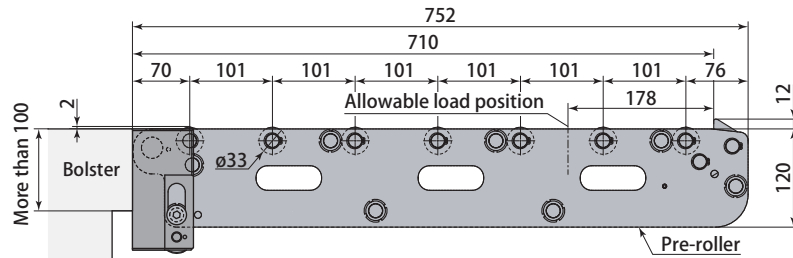
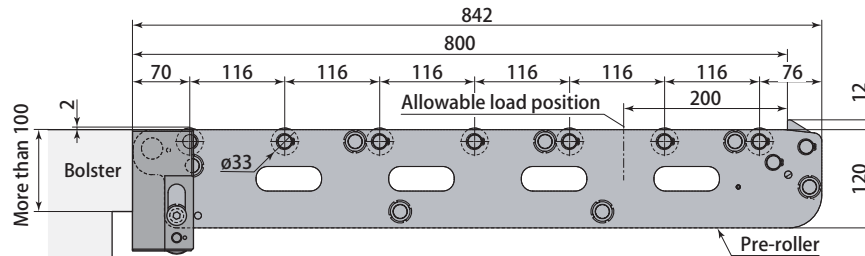
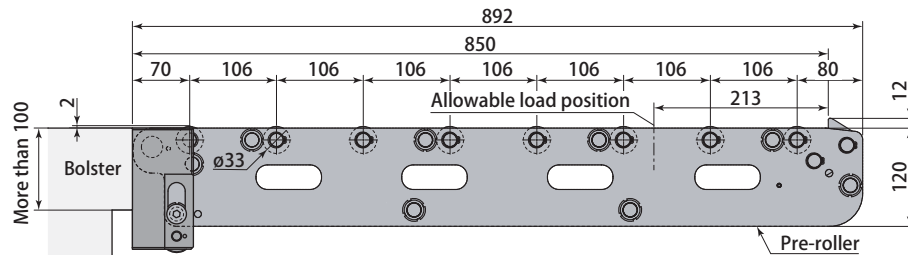
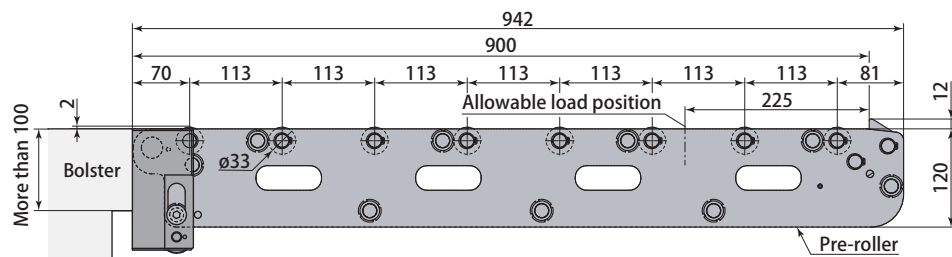
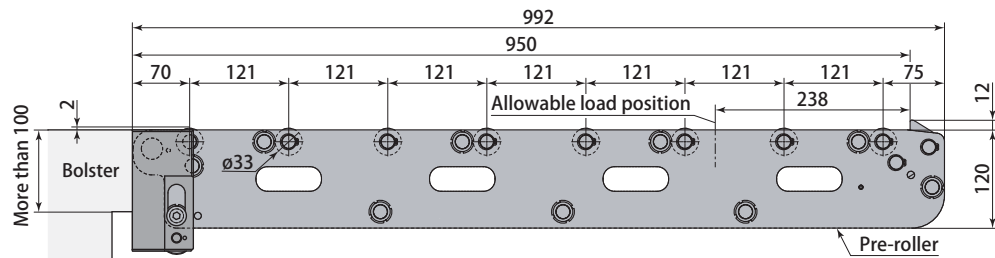
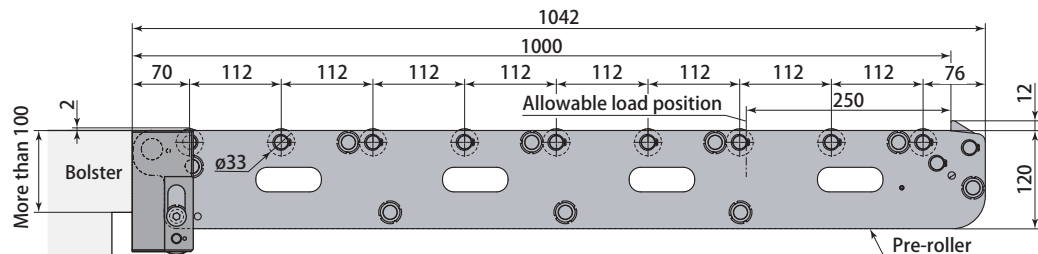


PRH3-0630P



1 Die travel 315 ~ 1000 mm

Model	PRH3-0315P	PRH3-0355P	PRH3-0400P	PRH3-0450P	PRH3-0500P	PRH3-0560P	PRH3-0630P	PRH3-0710P	PRH3-0800P	PRH3-0850P	PRH3-0900P	PRH3-0950P	PRH3-1000P
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
B mm	178.5	198.5	221	246	271	301	336	376	421	446	471	496	521
C mm	409	449	494	544	594	654	724	804	894	944	994	1044	1094
Pre-roller weight kg	7.5	8.3	9.4	9.9	10.9	12	13.3	14.6	15.8	17	18	18.8	19.9

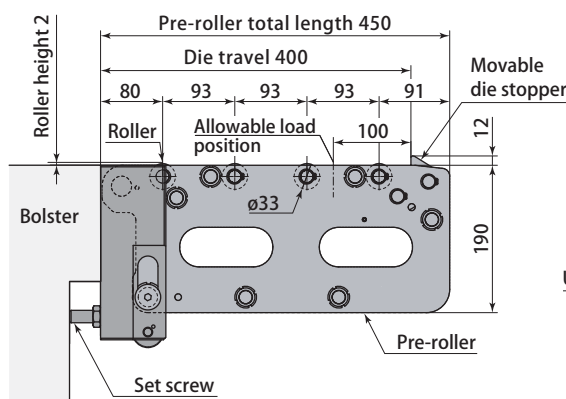
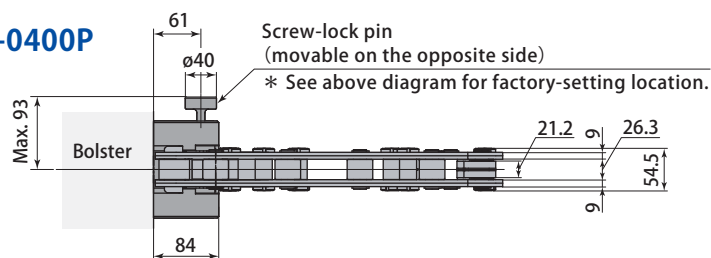
PRH3-0710P

PRH3-0800P

PRH3-0850P

PRH3-0900P

PRH3-0950P

PRH3-1000P


Dimensions

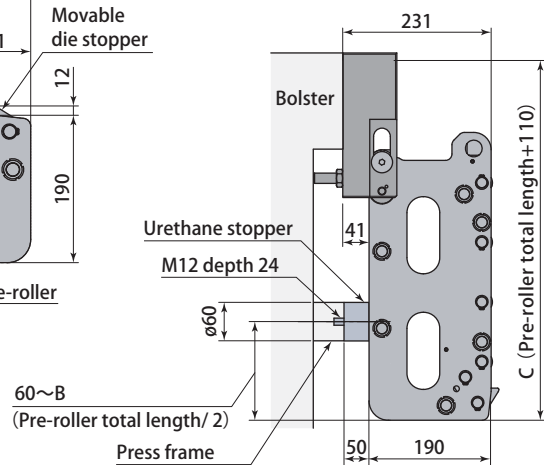
PRH 5 – 0400 P

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

PRH5-0400P

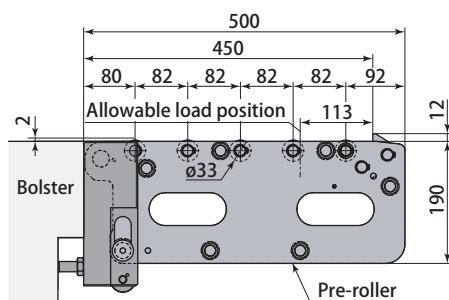


At folding

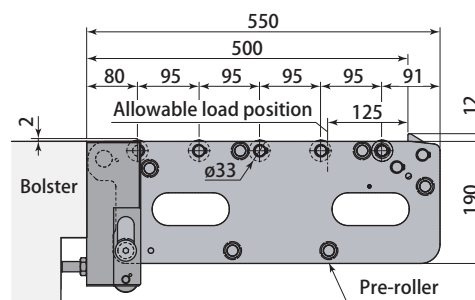


- Install the urethane stopper in the press frame

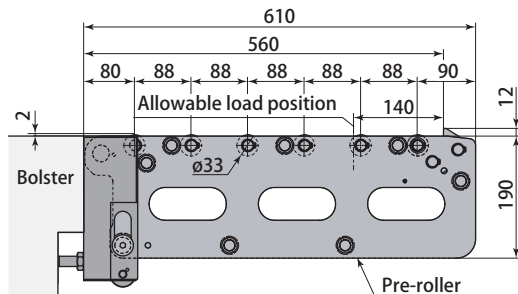
PRH5-0450P



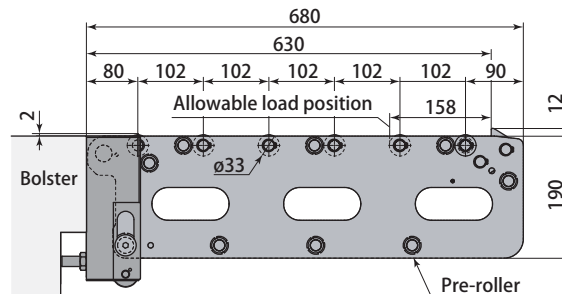
PRH5-0500P



PRH5-0560P

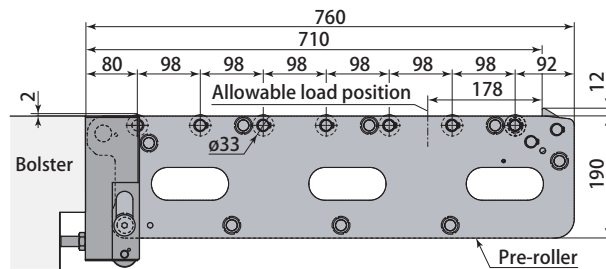
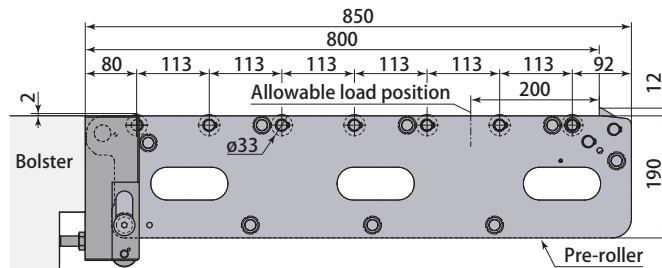
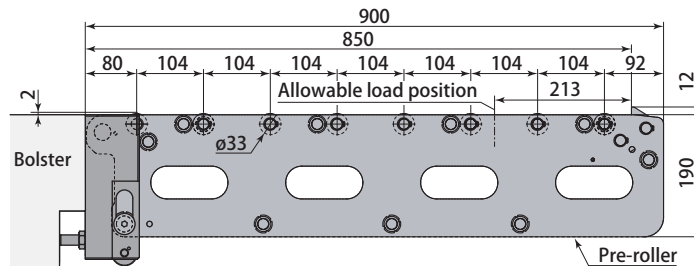
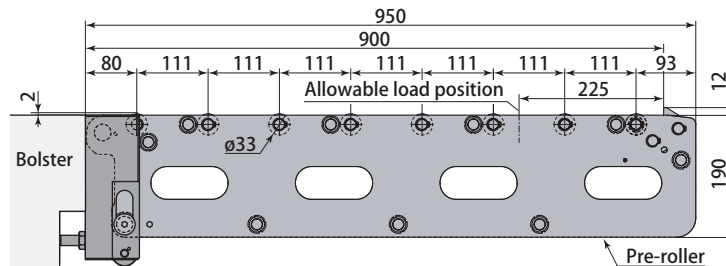
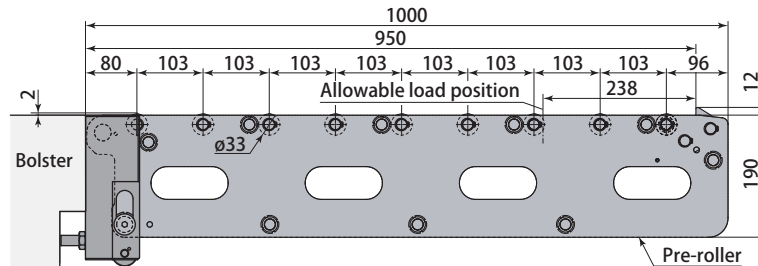
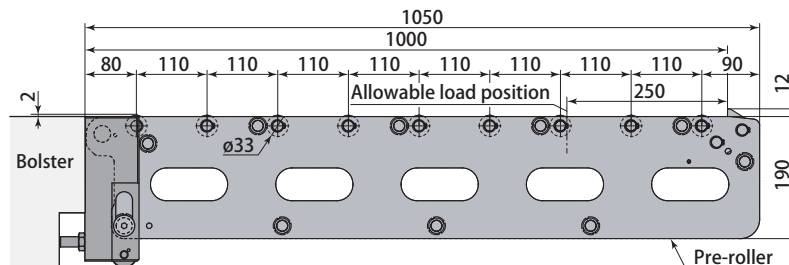


PRH5-0630P



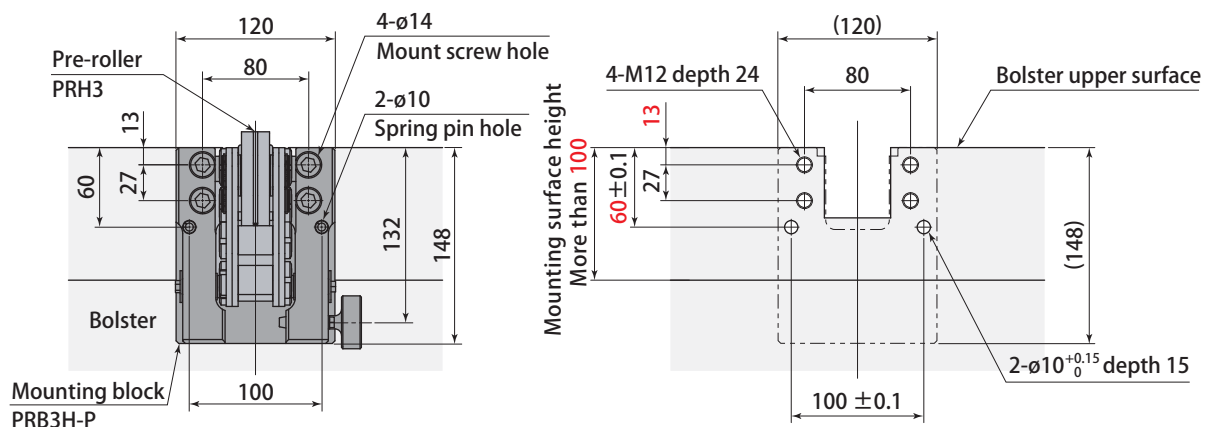
1 Die travel 400 ~ 1000 mm

Model		PRH5-0400P	PRH5-0450P	PRH5-0500P	PRH5-0560P	PRH5-0630P	PRH5-0710P	PRH5-0800P	PRH5-0850P	PRH5-0900P	PRH5-0950P	PRH5-1000P
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
B	mm	225	250	275	305	340	380	425	450	475	500	525
C	mm	560	610	660	720	790	870	960	1010	1060	1110	1160
Pre-roller weight	kg	12.4	13.9	15.3	16.4	18.4	20.8	23.2	24	25.4	26.9	27.5

PRH5-0710P

PRH5-0800P

PRH5-0850P

PRH5-0900P

PRH5-0950P

PRH5-1000P


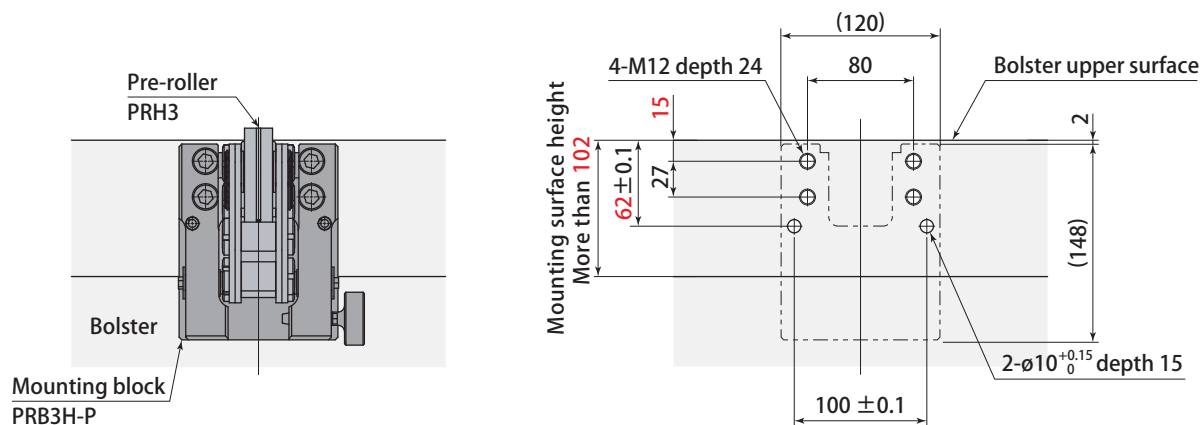
Dimensions, Mounting details

● When using the Die-lifter



● When not using the Die-lifter

When aligning the level between roller top and bolter surface



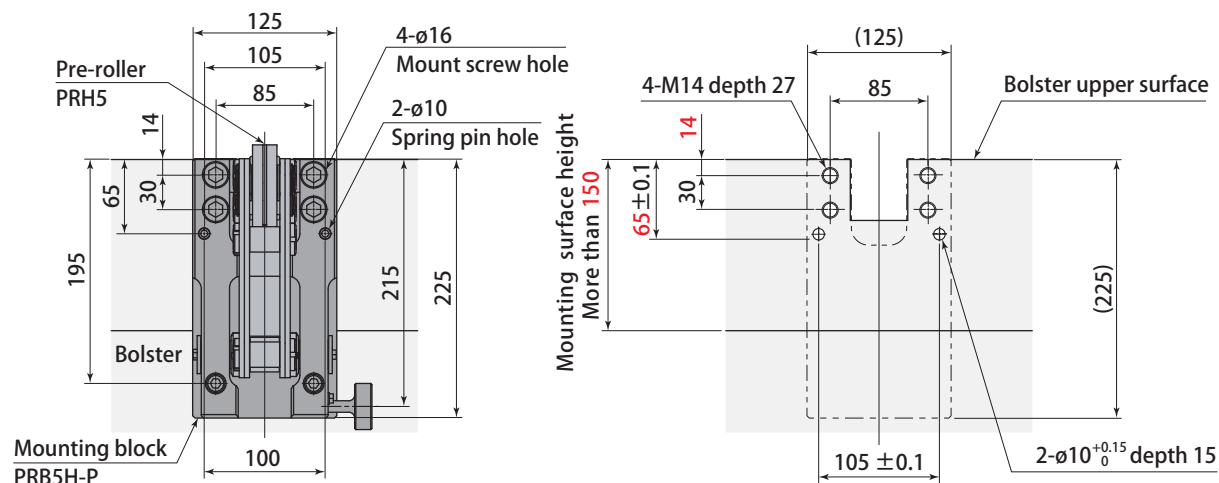
- When machining the spring pin hole, keep the tolerances shown above.
- Drill dia 10mm, 15mm deep hole for spring pin when co-machining the block with mount face.

Model	PRB3H-P
Weight	kg 6.3
Mount screw	4-M12 length 80
Spring washer	2-ø10 length 85

- Mounting block for PRH3

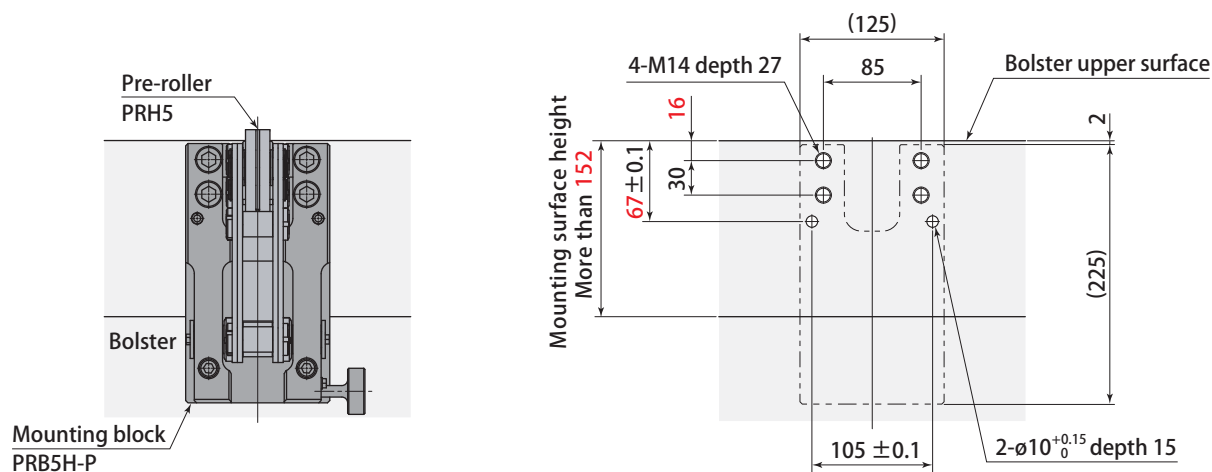
Dimensions, Mounting details

● When using the Die-lifter



● When not using the Die-lifter

When aligning the level between roller top and bolter 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	PRB5H-P
Weight	kg 12
Mount screw	4-M14 length 90
Spring washer	2-ø10 length 95

● Mounting block for PRH5

Set screw (only PRA5)

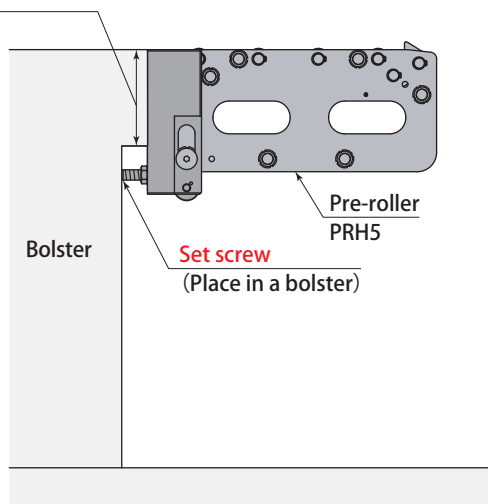
● Set screw presence

Model	PRH3	PRH5
Set screw	Not included	Included

Model	PRH5	
Mounting surface height	80mm ~ 150mm	More than 150mm
Use of set screw	Required	Not required

- The set screw is used to prevent the inclination of pre-roller in case that the mounting surface height is short.

Bolster width (Mounting surface height)
80 ~ 150



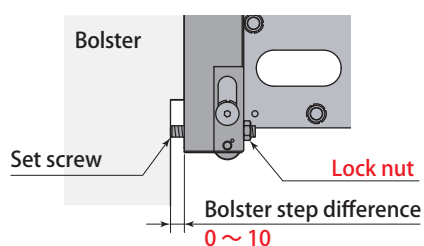
* This drawing indicates PRH5-0400P.

Mounting position of lock nut

The installed position of lock nut varies according to bolster width.

Bolster width	Less than 10mm	11 ~ 80mm	More than 80mm
Mounting position of lock nut	Refer the lower left drawing	Refer the lower right drawing	Contact Pascal

Less than 10mm



11~80mm

