



# Die-roller model **DRA**

Die-roller



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A spring lifting roller that does not need hydraulic source.  
The compact design allows an easy installation just to slot it in the machine T-slots.



Model designation

DRA **30** - **200** - **28**

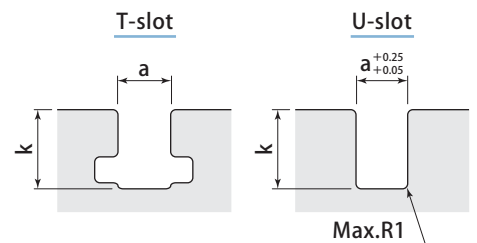
- 1** Die-roller width  
DRA **18** : 18 mm  
DRA **20** : 20, 22, 24 mm  
DRA **30** : 28, 32, 36 mm
- 2** Length of 1 piece  
**200** : 200 mm  
**300** : 300 mm
- 3** T/U-slot dimension a(mm)



Any length of the rollers with 100 mm pitch can be composed by combination of 200mm and 300mm die-lifting rollers.

**3** T/U-slot

Model	DRA18	DRA20	DRA30
<b>3</b> a mm	18	20 (Standard), 22, 24	28 (Standard), 32, 36
k mm	32 ~ 43		44 ~ 58

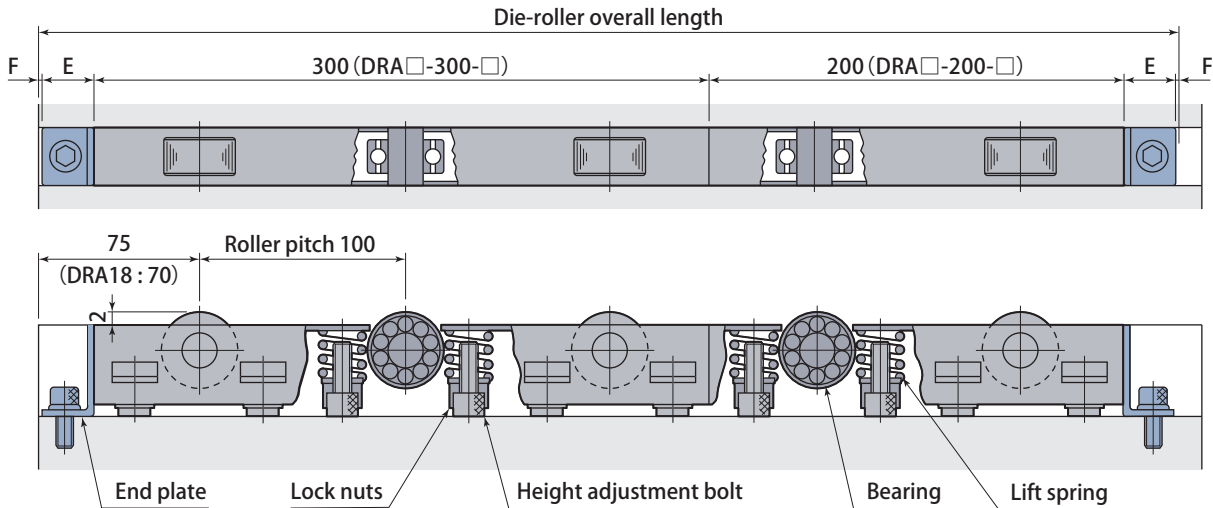


- Adjust roller-top level by height adjustment bolts to meet T/U-slot depth (Max. lifting stroke 2mm).

**Specifications**

Model		DRA18	DRA20	DRA30	
Lifting force per 100 mm (1 line)		kN	0.588	0.735	1.47
Weight per roller	DRA□-200-□ (Length 200mm)	kg	0.31	0.36	0.75
	DRA□-300-□ (Length 300mm)	kg	0.46	0.53	1.13
Lifting force per height adjustment bolt		kN	0.294	0.367	0.735

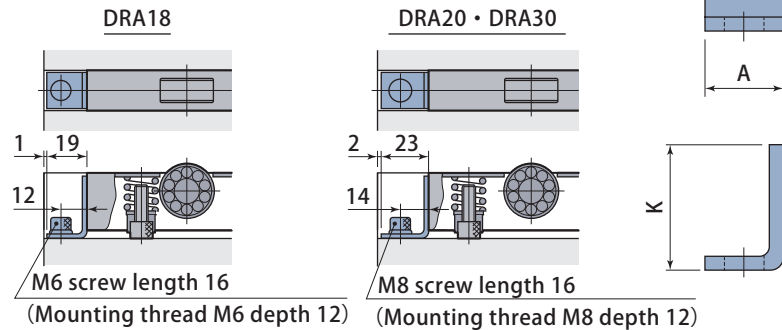
- Operating temperature : 0 ~ 110°C
- Select requested total length in combinations of 200 mm and 300 mm die-lifting rollers.
- Lock the height adjustment bolts with lock nuts after adjusting height.
- Lifting force can be reduced by removing the height adjustment bolts. The bolts at both ends of the die-lifting rollers should not be removed.



	mm		
Model	DRA18	DRA20	DRA30
E	19	23	23
F	1	2	2

**End plate (L stopper)**

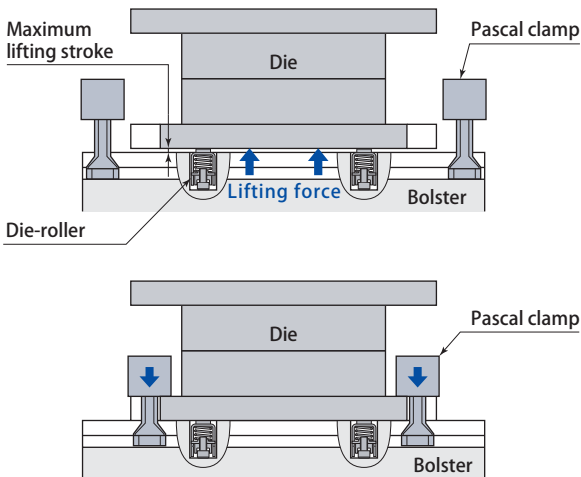
**DRL-18 L** ..... K Dimension L: Low distance clamp type H: Upper distance clamp type  
 T/U-slot dimension a : 18~36 (mm)



Model		T/U-slot dimension a	A	K
DRL-18	L	18	17	32
	H			43
DRL-20	L	20	19	32
	H			43
DRL-22	H	22	21	43
DRL-24	H	24	23	43
DRL-28	L	28	27	45
	H			58
DRL-32	H	32	31	58
DRL-36	H	36	35	63

● Cut the end plate 0.5 mm shorter than the depth of the T/U-slot.

**Maximum lifting force per pair rollers**



Die rollers are pressed down into bolster by clamping force.

* Overall length mm	Model		
	DRA18	DRA20	DRA30
250	2.35	2.94	5.88
350	3.53	4.41	8.82
450	4.70	5.88	11.7
550	5.88	7.35	14.7
650	7.06	8.82	17.6
750	8.23	10.2	20.5
850	9.41	11.7	23.5
950	10.5	13.2	26.4
1050	11.7	14.7	29.2
1150	12.9	16.1	32.3
1250	14.1	17.6	35.3
1350	15.2	19.1	38.2
1450	16.4	20.5	41.1
1550	17.6	22.0	44.1

\* Overall length of model DRA18 is 10mm shorter than above lengths.