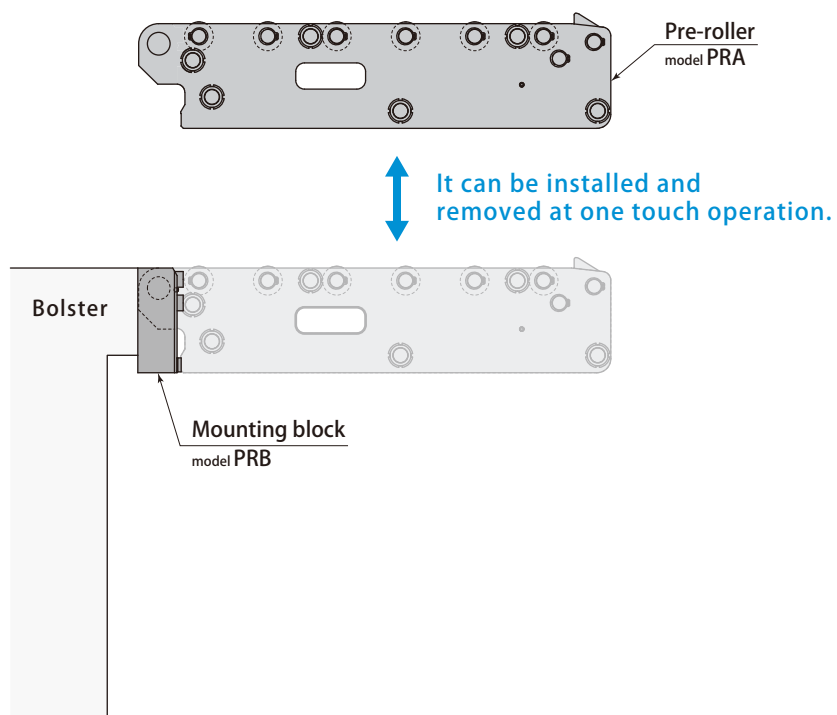


Detachable type Pre-roller



- The Pre-roller may be damaged due to the vibration through stamping operation. The removal of pre-roller during the operation is recommended.
- Be noted that the specifications of Mounting block PRB and PRB□F(mounting block for PRF) are different.

Model designation

Set model (Pre-roller + Mounting block)

PRA **2** - **0200** B - S

Size
PRA2 PRA3 PRA5

1 Die travel (mm)
* Indicated in 4digits

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

Pre-roller model type

PRA **2** - **0200** B

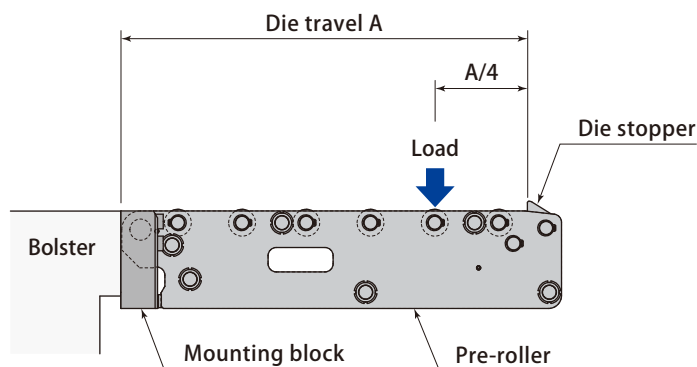
Size
PRA2 PRA3 PRA5

1 Die travel (mm) * Indicated in 4 digits

Mounting block model type

PRB **2**

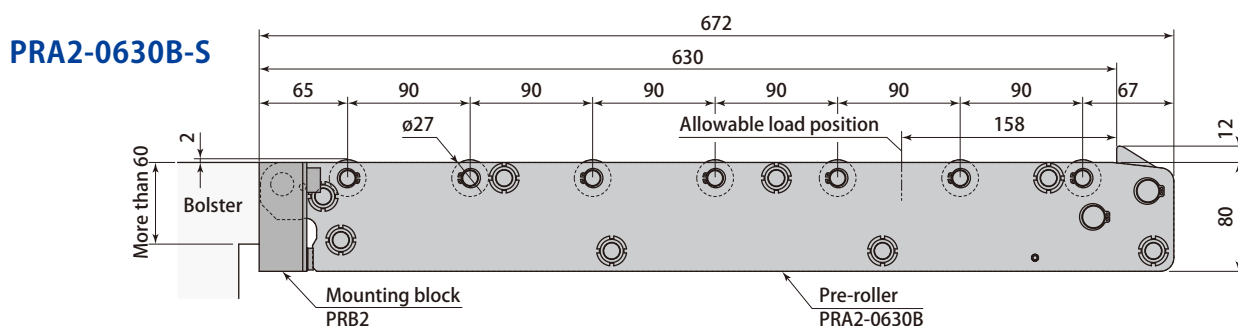
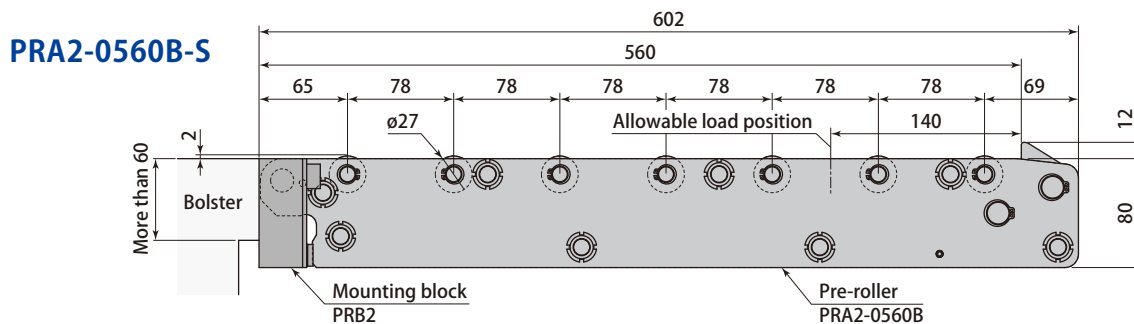
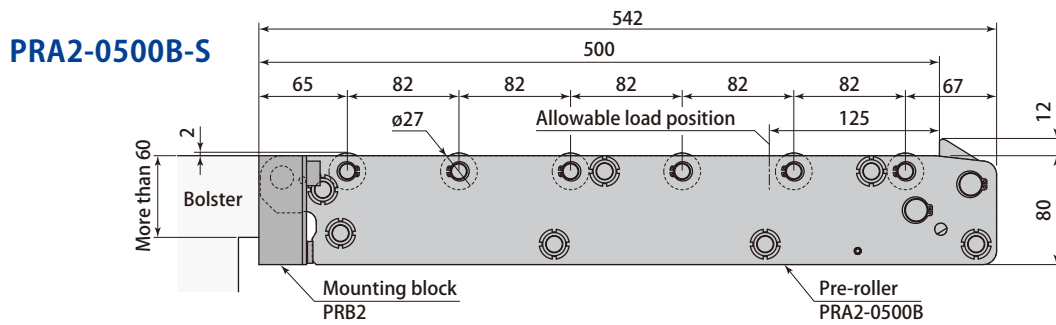
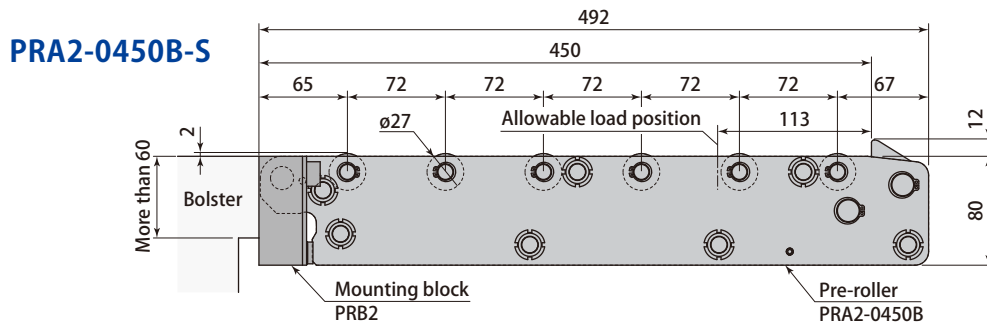
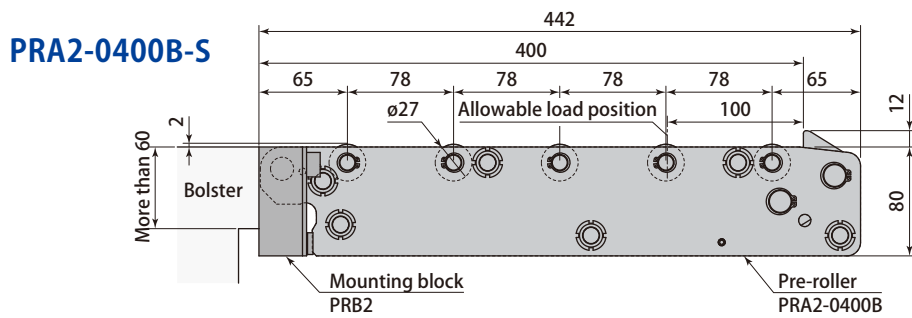
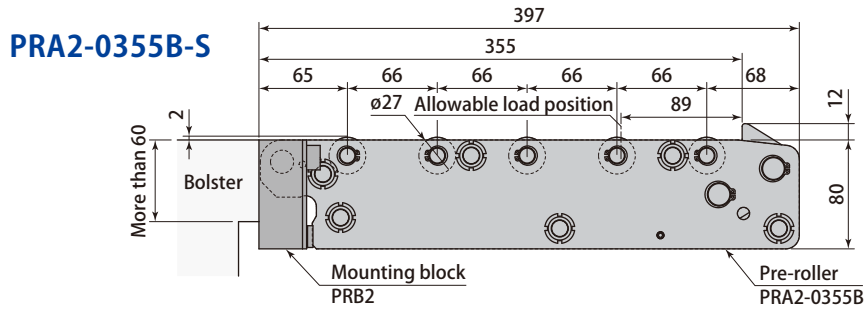
Size
PRB2 PRB3 PRB5



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

Die travel		mm	200	250	315	355	400	450	500	560	630	710	800	850	900	950	1000
PRA2	Allowable load *	kN	8	8	5	5	4	4	3	2.5	2.5	—	—	—	—	—	—
	Number of rollers		3	4	4	5	5	6	6	7	7	—	—	—	—	—	—
	Weight	kg	3.1	3.7	4.2	4.7	5.1	5.5	5.9	6.6	7.2	—	—	—	—	—	—
PRA3	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	—	—	7.6	8.4	9.5	10	11.1	12.1	13.4	14.7	16.3	17.4	18.4	19.2	20.3
PRA5	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	—	—	—	—	10.4	11.4	12.2	13.6	15.1	16.9	18.1	19.2	20.1	21.5	22.5

● 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)×9.8÷1000



Dimensions

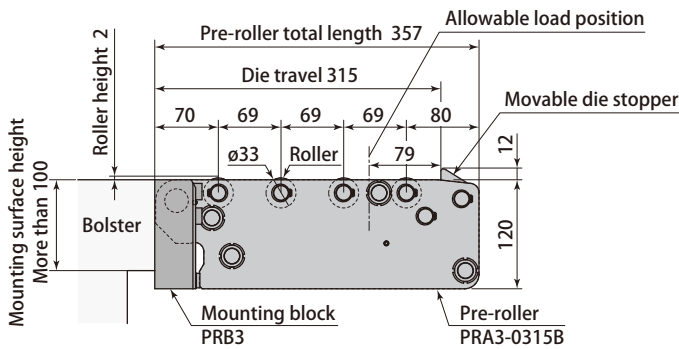
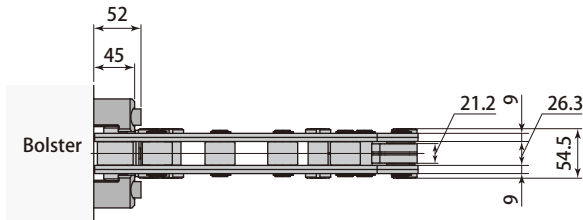
PRA 3 – 0315 B – S

1 Die travel (mm)
* Indicated in 4 digits

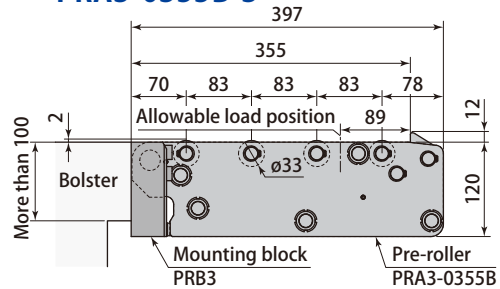
1 Die travel 315 ~ 1000 mm

Model	PRA3-0315B	PRA3-0355B	PRA3-0400B	PRA3-0450B	PRA3-0500B	PRA3-0560B	PRA3-0630B	PRA3-0710B	PRA3-0800B	PRA3-0850B	PRA3-0900B	PRA3-0950B	PRA3-1000B
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
Weight	kg 7.6	8.4	9.5	10	11.1	12.1	13.4	14.7	16.3	17.4	18.4	19.2	20.3

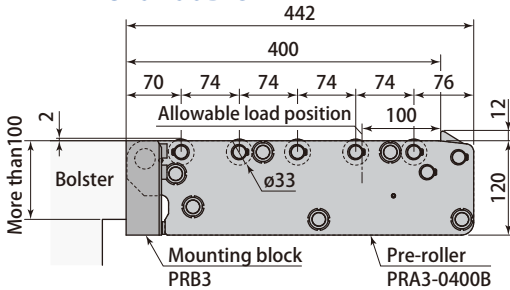
PRA3-0315B-S



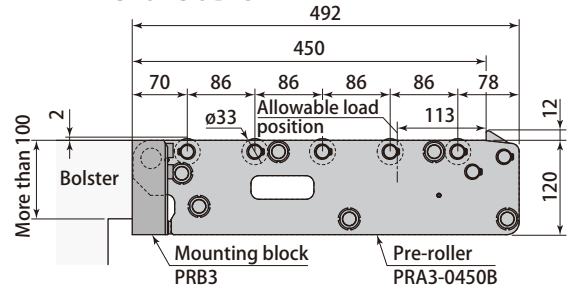
PRA3-0355B-S



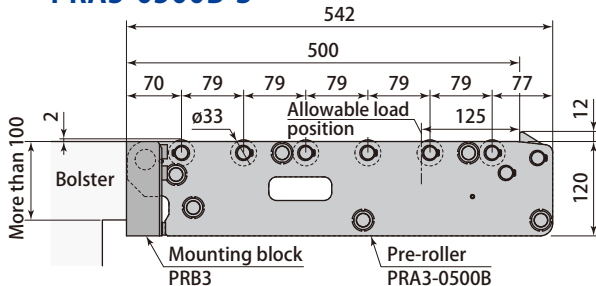
PRA3-0400B-S



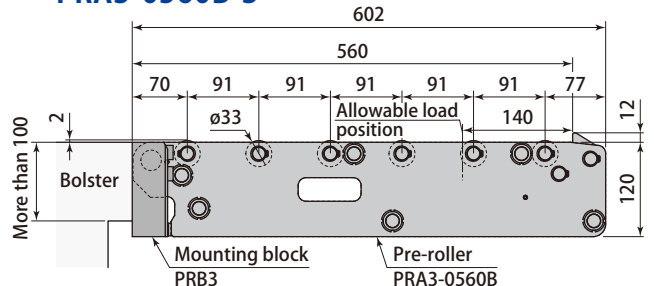
PRA3-0450B-S



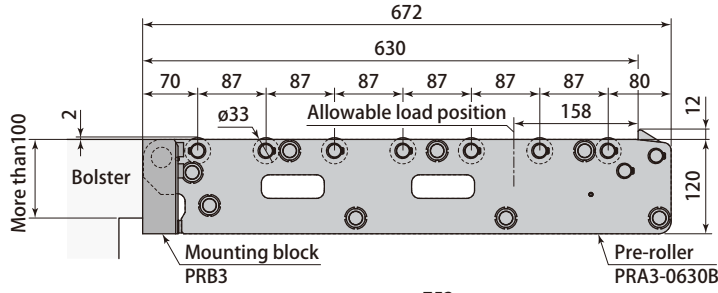
PRA3-0500B-S



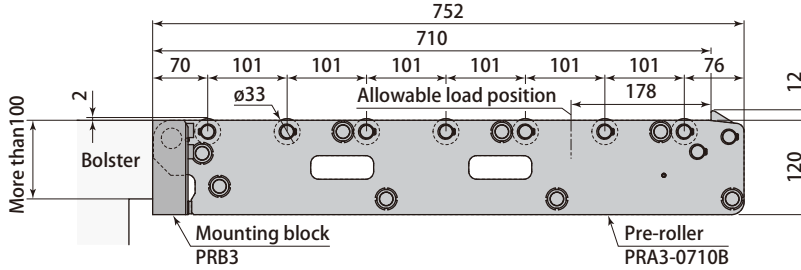
PRA3-0560B-S



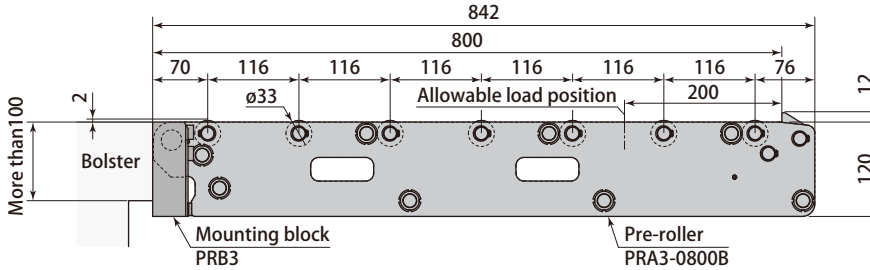
PRA3-0630B-S



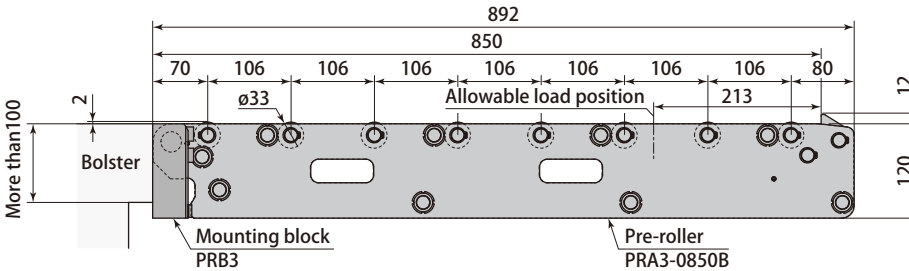
PRA3-0710B-S



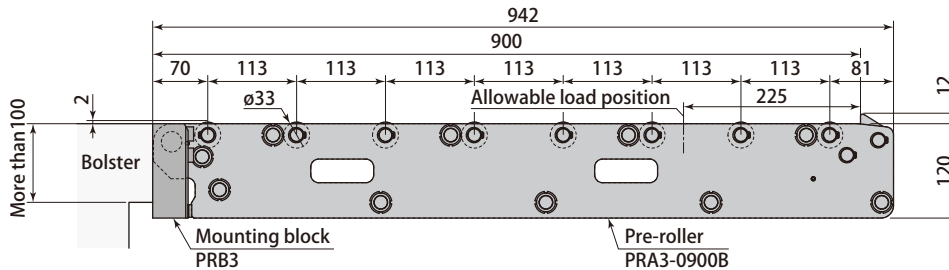
PRA3-0800B-S



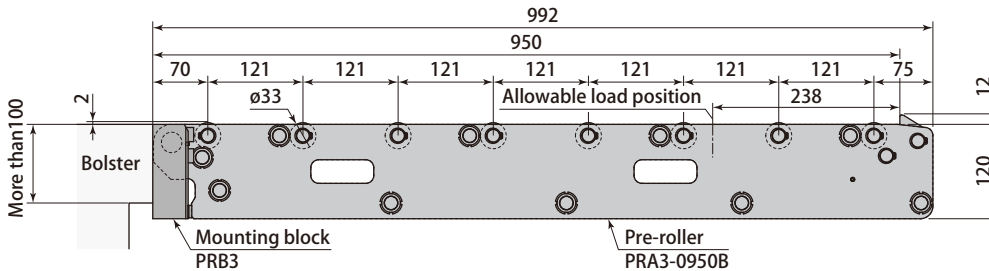
PRA3-0850B-S



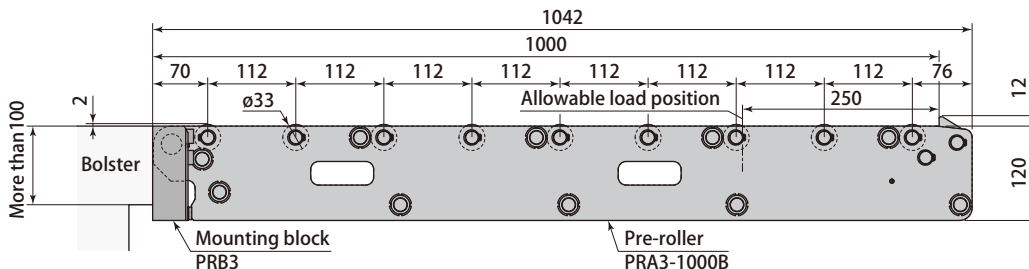
PRA3-0900B-S



PRA3-0950B-S



PRA3-1000B-S



Dimensions

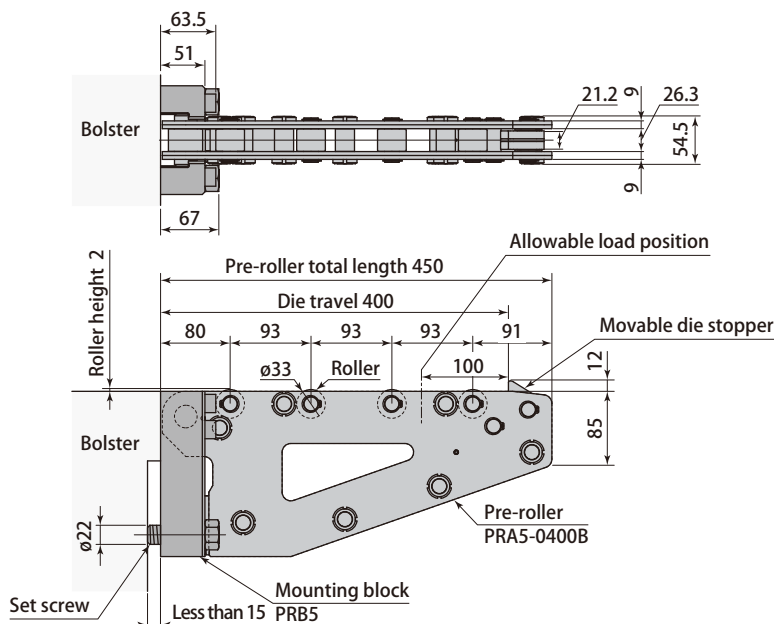
PRA 5 - 0400 B - S

1 Die travel (mm)
* Indicated in 4 digits

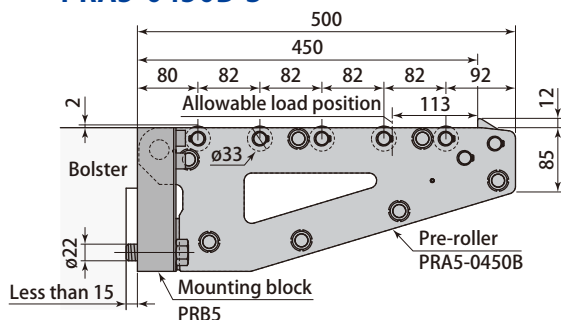
1 Die travel 400 ~ 1000 mm

Model	PRA5-0400B	PRA5-0450B	PRA5-0500B	PRA5-0560B	PRA5-0630B	PRA5-0710B	PRA5-0800B	PRA5-0850B	PRA5-0900B	PRA5-0950B	PRA5-1000B
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
Weight	kg 10.4	11.4	12.2	13.6	15.1	16.9	18.1	19.2	20.1	21.5	22.5

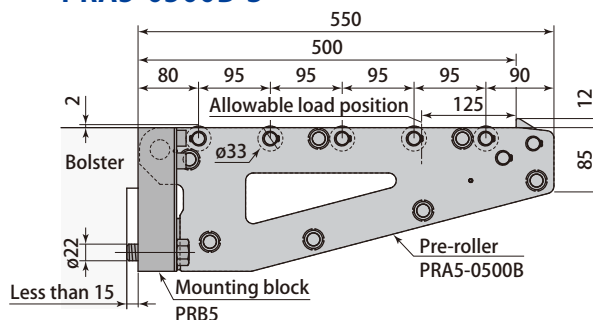
PRA5-0400B-S



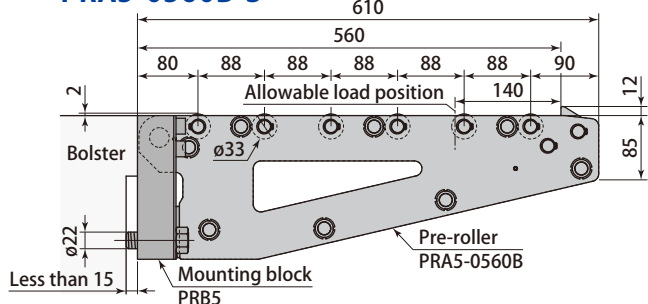
PRA5-0450B-S



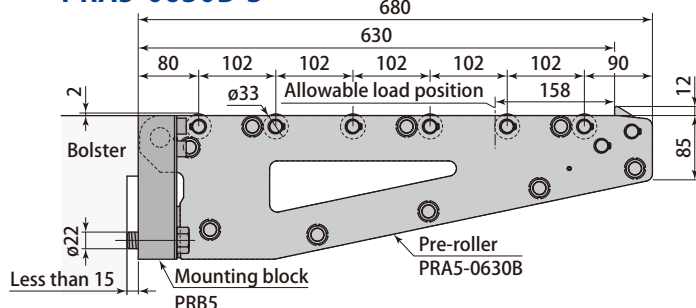
PRA5-0500B-S



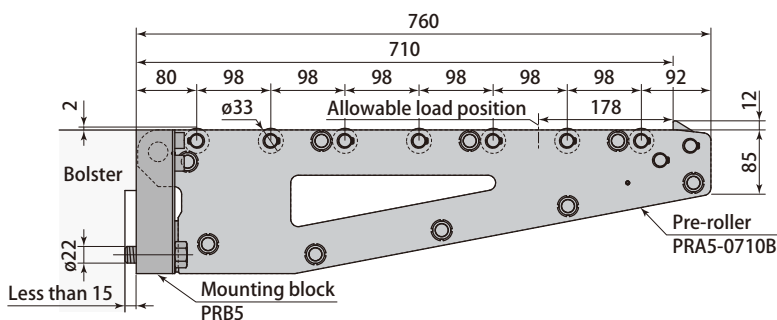
PRA5-0560B-S



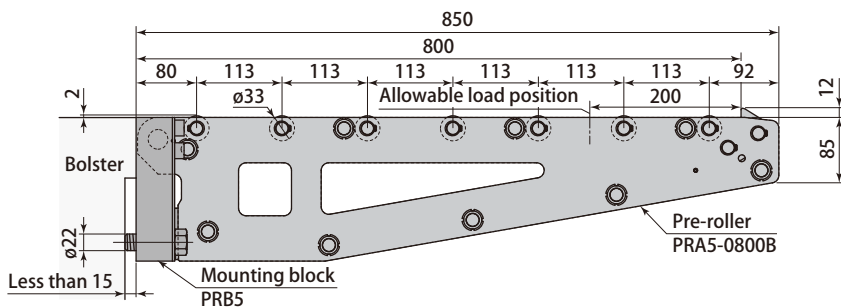
PRA5-0630B-S



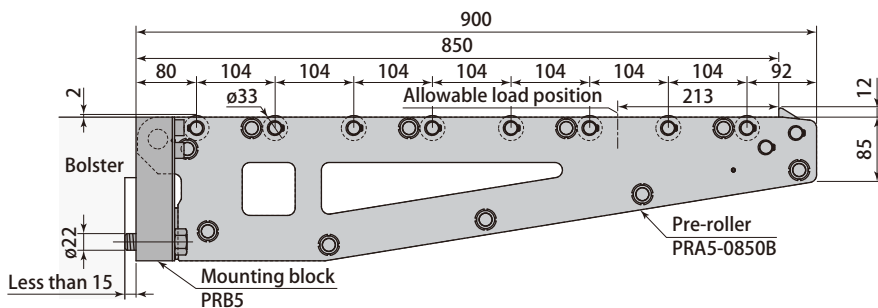
PRA5-0710B-S



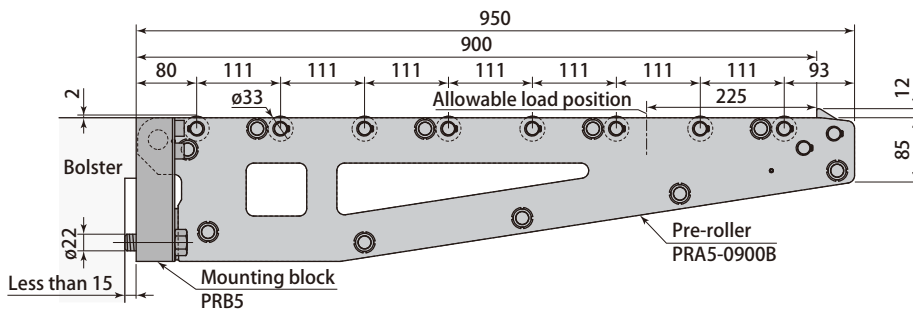
PRA5-0800B-S



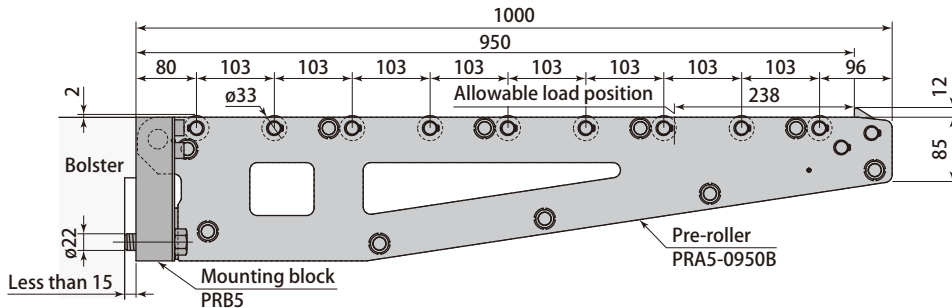
PRA5-0850B-S



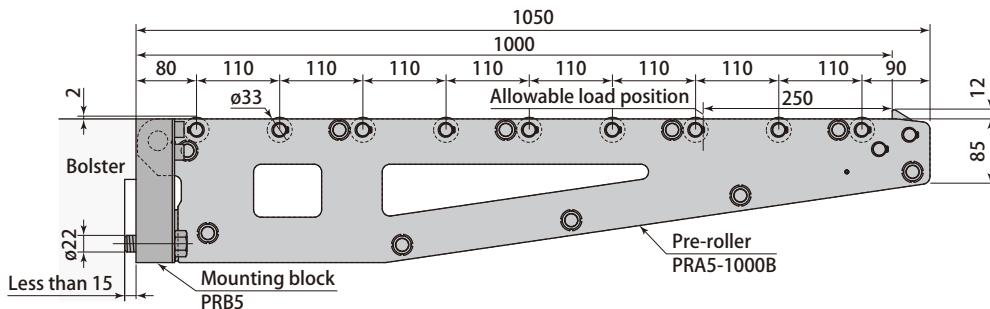
PRA5-0900B-S



PRA5-0950B-S

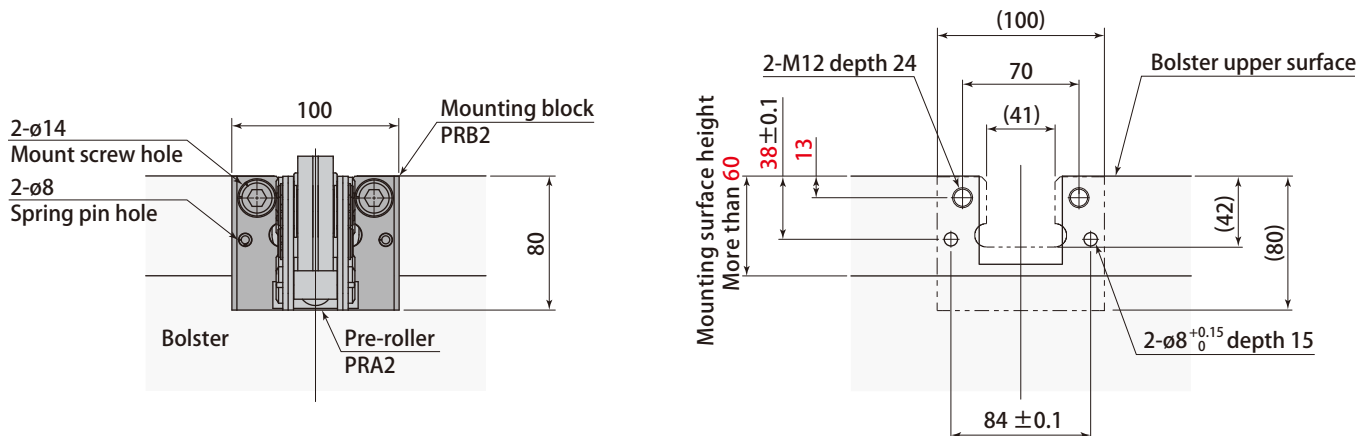


PRA5-1000B-S



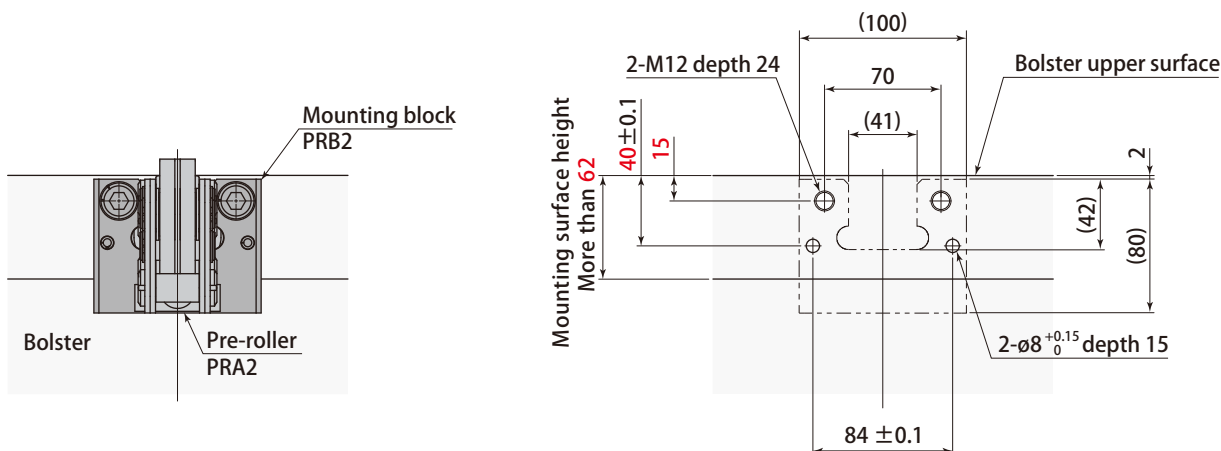
Dimensions, Mounting details

● When using the Die-lifter



● When not using the Die-lifter

When aligning the level between roller top and bolster surface.



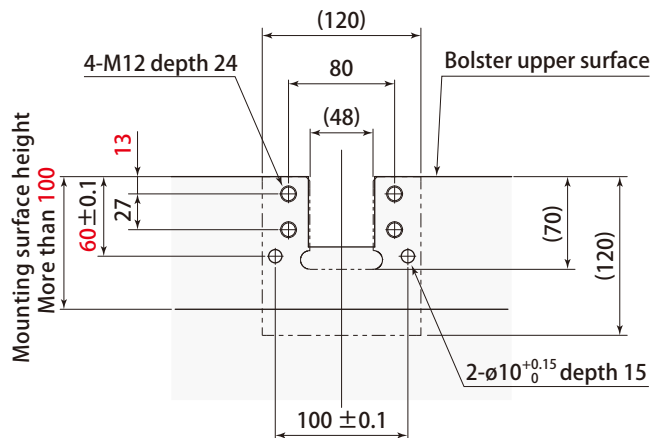
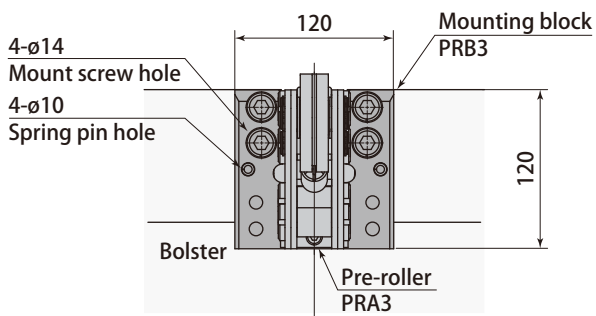
- When machining the spring pin hole, keep the tolerances shown above.
- Drill dia 8mm, 15mm deep hole for spring pin when co-machining the block with mount face.

Model		PRB2
Weight	kg	1.5
Mount screw		2-M12 length 55
Spring washer		2-M12
Spring pin		2-ø8 length 45

● Mounting block for PRA2

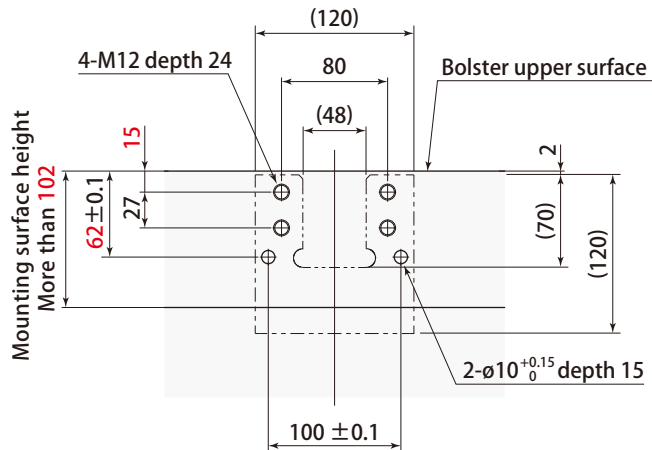
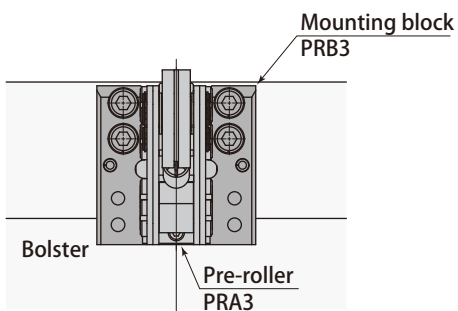
Dimensions, Mounting details

● When using the Die-lifter



● When not using the Die-lifter

When aligning the level between roller top and bolster surface.



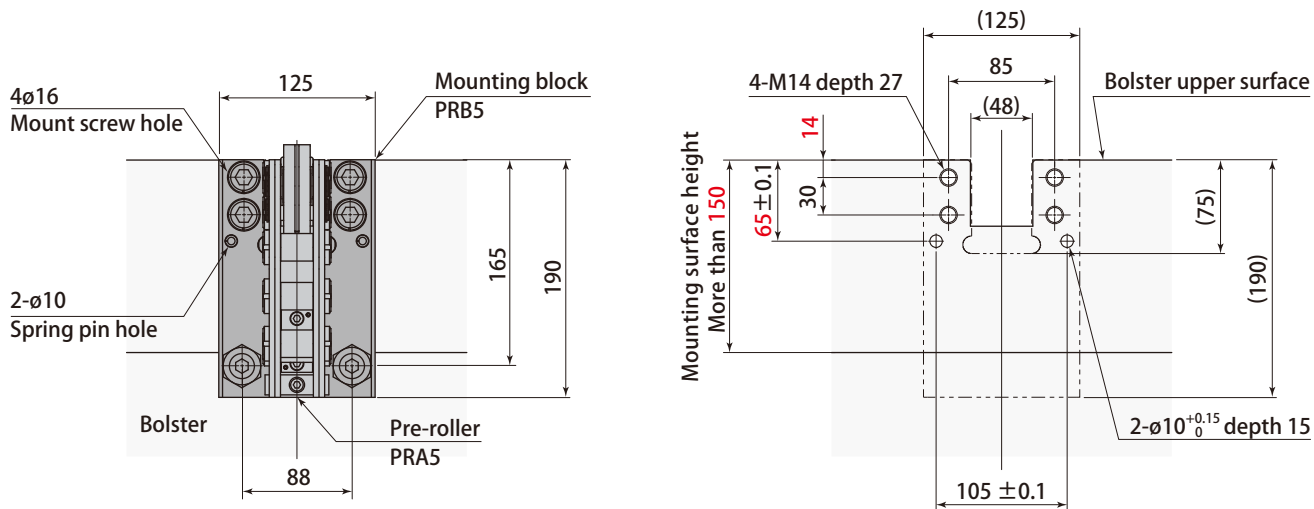
- When machining the spring pin hole, keep the tolerances shown above.
- Drill dia 10mm, 15mm deep hole for spring pin when co-machining the block with mount face.

Model		PRB3
Weight	kg	3.6
Mount screw		4-M12 length 60
Spring washer		4-M12
Spring pin		2-ø10 length 56

● Mounting block for PRA3

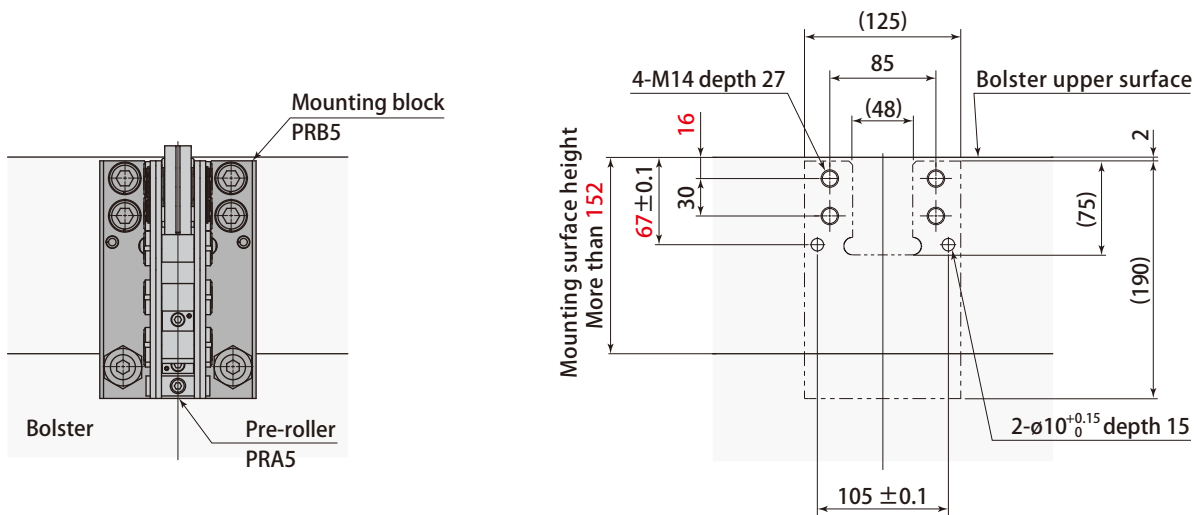
Dimensions, Mounting details

● 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 with 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	2-10 length 63

● Mounting block for PRA5

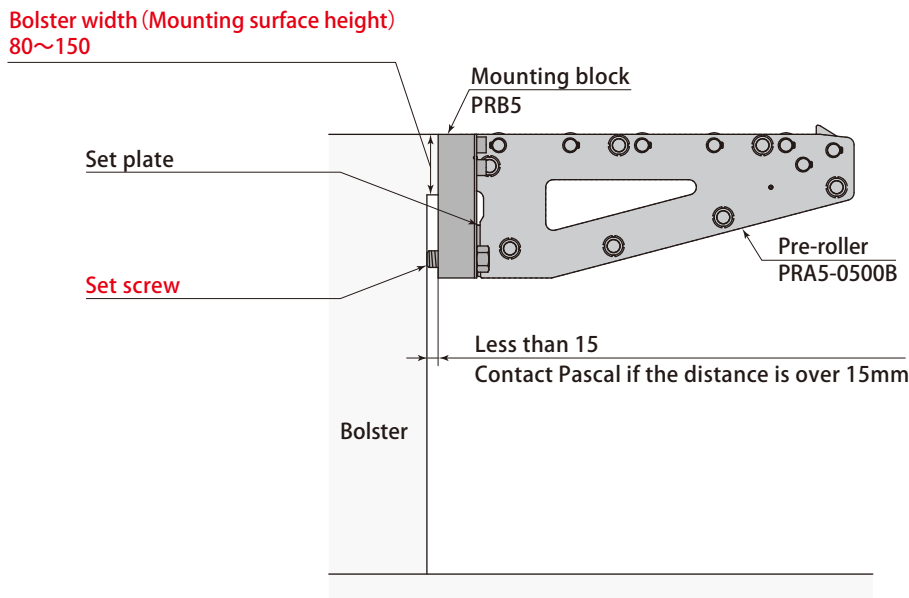
Set screw (only PRA5)

● Set screw presence

Model	PRA2	PRA3	PRA5
Set screw	Not included	Not included	Included

Model	PRA5	
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.



* This drawing indicates PRA5-0500B-S.