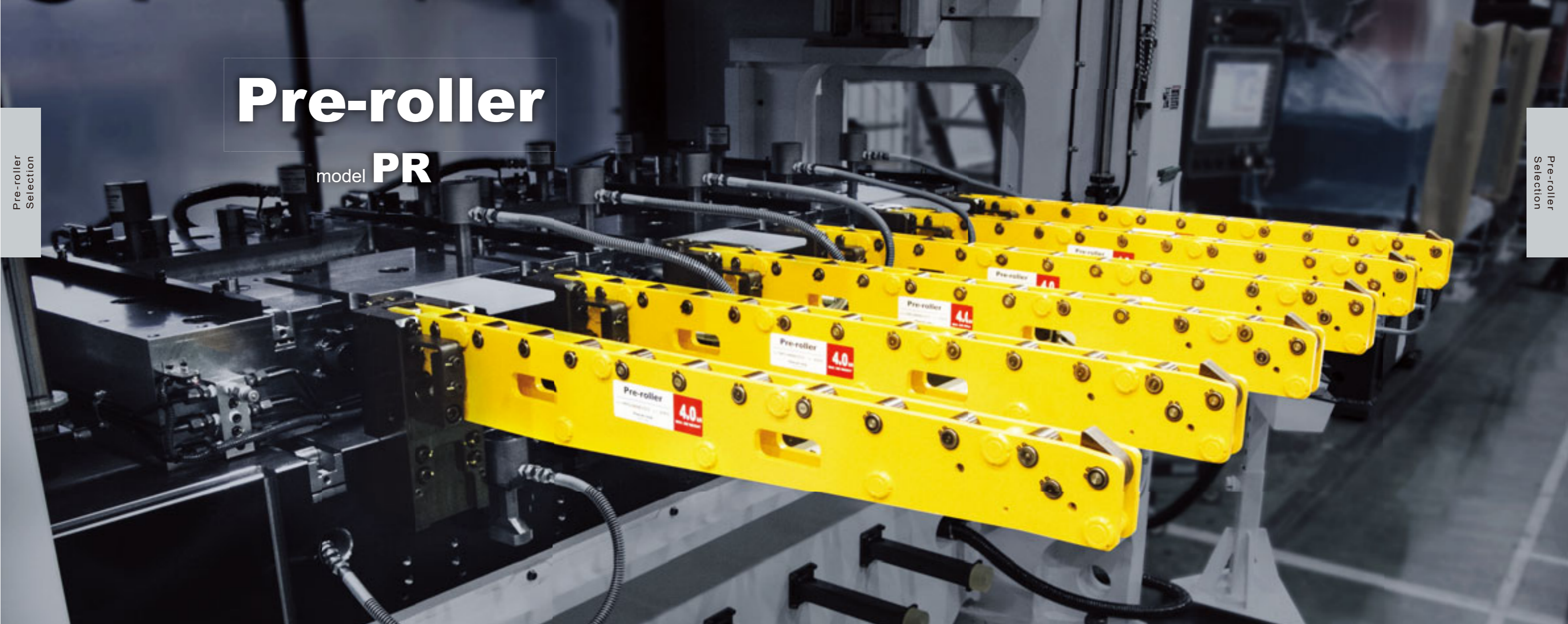


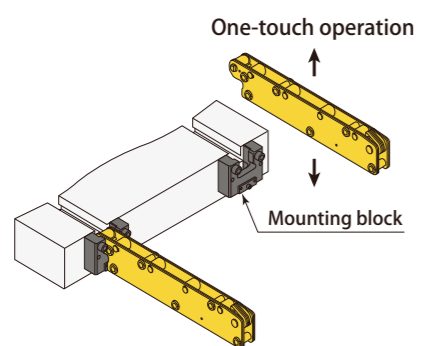
Pre-roller

model **PR**



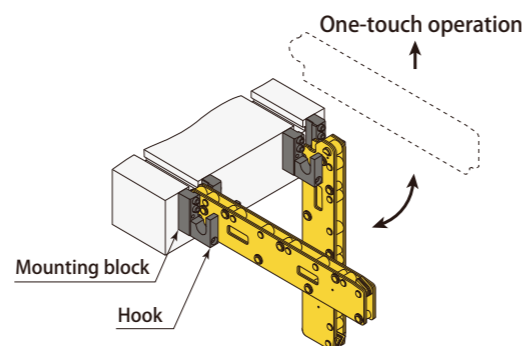
Removable & fold type

model **PRA**



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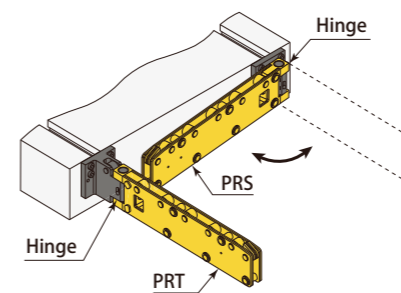
model **PRF**



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Horizontally fold type

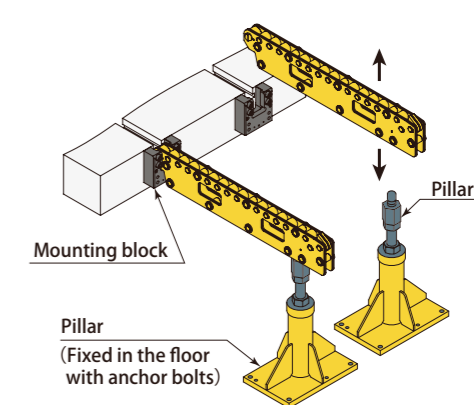
model **PRS** / model **PRT**



* The bending position is different between S and T. Refer to page → 181 for the details.

Heavy load type

model **PRC**



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Model designation

PR A 3 - 0630 B

- 1 Model
- 2 Size
- 3 Die travel (mm) * Indicated in 4 digits

1 Model

A	F	S / T	C
(Standard)	Removable & fold type	Horizontally fold type	Heavy load type
page → 157	page → 169	page → 181	page → 193

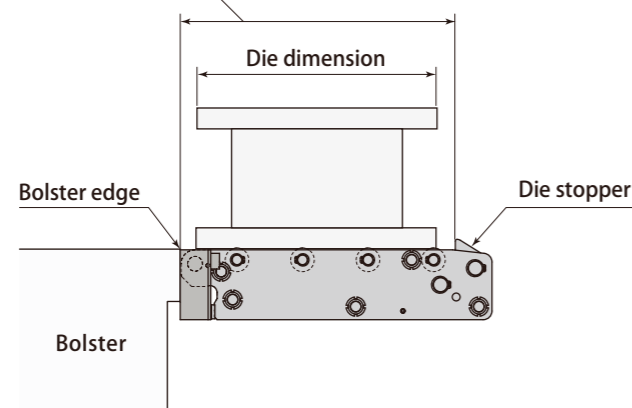
2 Size

PRA			PRF			PRS / T			PRC	
2	3	5	2	3	5	3	5	8	3	5

3 Die travel

Die travel

Die travel = Length from bolster edge to the stopper.



Select the Pre-roller where die dimensions are within die travel.

Selection of Pre-roller each for allowable load (Die weight)

In case the die weight is 5 tons, select PRA5-0400B or PRF5-0400B or PRS8-0630B/PRT8-0630B or PRC3-0950B.

Allowable load * (Die weight)	PRA2	PRA3	PRA5	PRF2	PRF3	PRF5	PRS3 PRT3	PRS5 PRT5	PRS8 PRT8	PRC3	PRC5
	Die travel										
8 tonf (80kN)											
7 tonf (70kN)											1250
6 tonf (60kN)										800	
5 tonf (50kN)			400			400			630	950	
4 tonf (40kN)			450			450			710	1000	
3.2 tonf (32kN)		355	560		355	560	355	630	900		
2.6 tonf (26kN)		400	710		400	710	450	710	1000		
2 tonf (20kN)		450	850		450	850	500	850			
1.6 tonf (16kN)	250	630	1000	250	630	1000	630	950			
1.2 tonf (12kN)		710			710		710	1000			
1 tonf (10kN)	355	850		355	850						
0.8 tonf (8kN)	450	950		450	950						
0.6 tonf (6kN)	500	1000		500	1000						
0.5 tonf (5kN)	630			630							

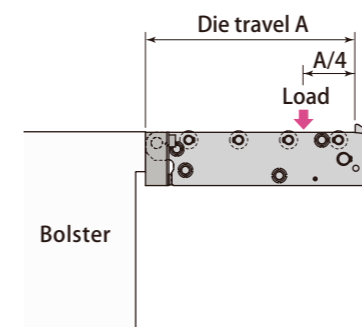
* The allowable load of above table is for 2 pre-rollers.

Allowable load

- 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

Allowable load of
PRA PRF PRS
PRT

Static load measured at the position of 1/4 of the die travel



Allowable load of

PRC

Uniformly distributed and held by the middle part of the Pre-roller

