

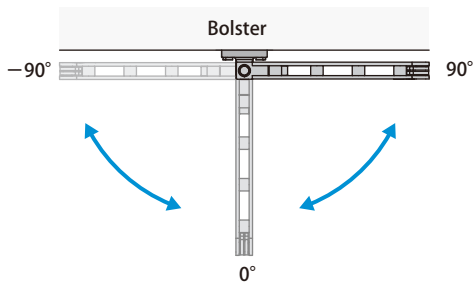
It is a horizontally fold type of pre-roller which can be folded horizontally.



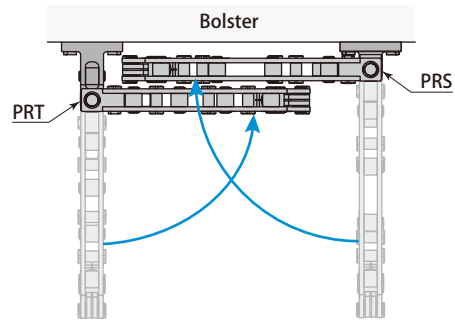
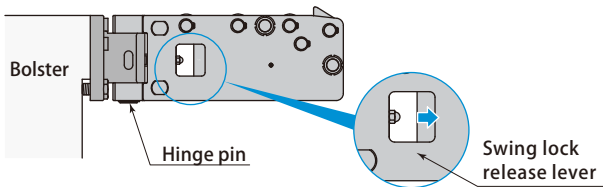
Pre-roller horizontally fold PRS/T

Folding method

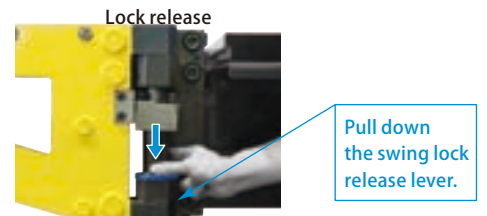
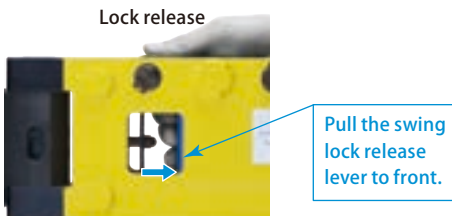
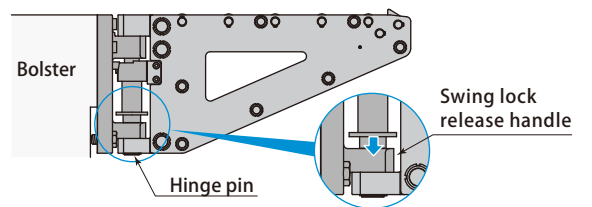
Pre-roller will lock at 0°, 90°, and -90° positions.



PRS3 PRT3 PRS5 PRT5



PRS8 PRT8



- Hinge pins with grease nipples are available as an option to prevent fretting corrosion. Contact Pascal for detail when installing it on high-speed presses.

Model designation

PRS Pre-roller model type

PRS **3** - **0630** B

Size ●
PRS3 PRS5 PRS8

1 Die travel (mm) * Indicated in 4 digits

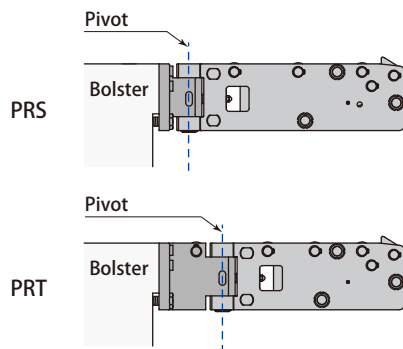
PRT Pre-roller model type

PRT **3** - **0630** B

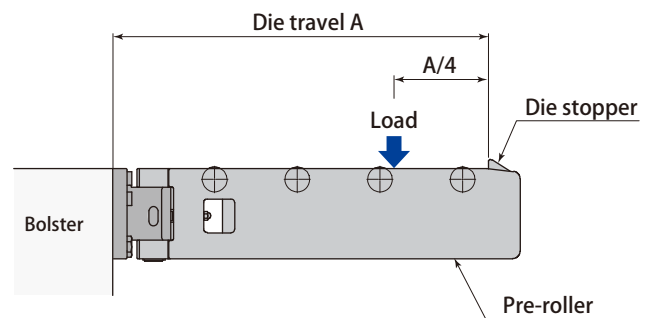
Size ●
PRT3 PRT5 PRT8

1 Die travel (mm) * Indicated in 4 digits

Difference of PRS/PRT



Pivot position is different.



Pre-roller horizontally fold PRS/T

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

Die travel		mm	315	355	400	450	500	560	630	710	800	850	900	950	1000
PRS3	Allowable load *	kN	16	16	13	13	10	8	8	6	—	—	—	—	—
	Number of rollers		3	3	3	4	4	5	5	6	—	—	—	—	—
	Weight	kg	11.3	12.1	12.9	14	15	16.2	17.4	19.2	—	—	—	—	—
PRT3	Allowable load	kN	16	16	13	13	10	8	8	6	—	—	—	—	—
	Number of rollers		3	4	4	4	5	6	6	7	—	—	—	—	—
	Weight	kg	12.6	13.5	14.4	15.4	16.4	17.7	18.9	20.6	—	—	—	—	—
PRS5	Allowable load	kN	—	—	—	—	16	16	16	13	10	10	8	8	6
	Number of rollers		—	—	—	—	5	5	5	6	7	7	7	8	8
	Weight	kg	—	—	—	—	24.3	26	28	30.4	33.1	34.4	35.8	37.4	38.8
PRT5	Allowable load	kN	—	—	—	—	16	16	16	13	10	10	8	8	6
	Number of rollers		—	—	—	—	5	5	5	6	7	7	7	8	8
	Weight	kg	—	—	—	—	27.3	28.9	30.8	33.3	36.1	37.5	38.9	40.4	41.5
PRS8	Allowable load	kN	—	—	—	—	—	—	25	20	16	16	16	13	13
	Number of rollers		—	—	—	—	—	—	5	6	6	7	7	8	8
	Weight	kg	—	—	—	—	—	—	44.8	47.3	49.9	51.5	52.9	54.6	56.1
PRT8	Allowable load	kN	—	—	—	—	—	—	25	20	16	16	16	13	13
	Number of rollers		—	—	—	—	—	—	5	6	7	7	8	8	8
	Weight	kg	—	—	—	—	—	—	51.1	53.5	56.5	57.9	59.5	60.9	62.3

● 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

External dimension

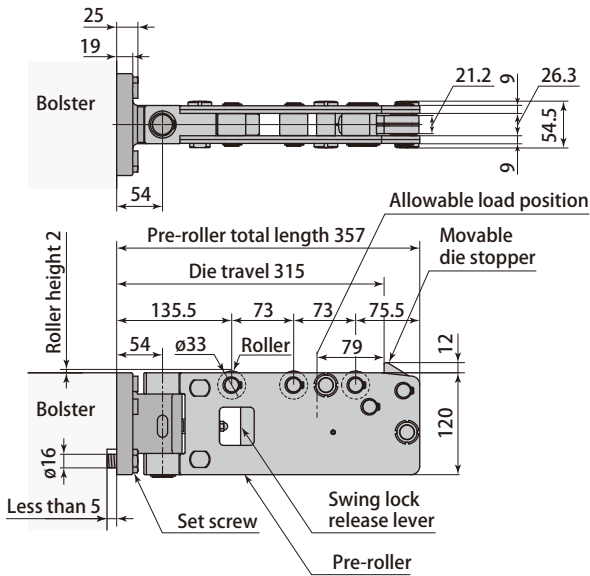
PRS 3 – 0315 B

1 Die travel (mm)
* Indicated in 4 digits

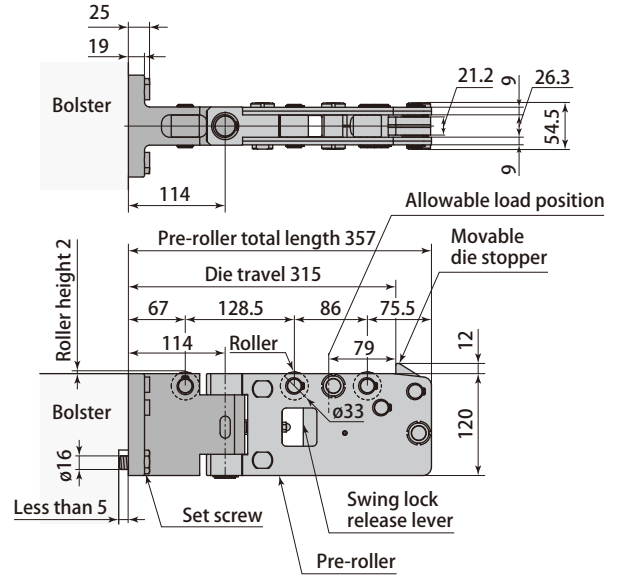
PRT 3 – 0315 B

1 Die travel (mm)
* Indicated in 4 digits

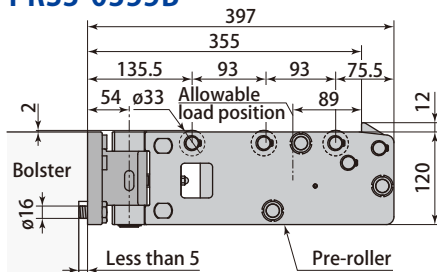
PRS3-0315B



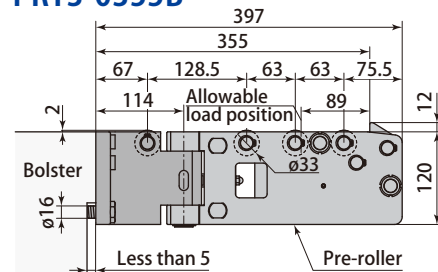
PRT3-0315B



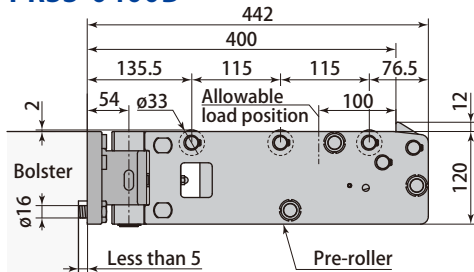
PRS3-0355B



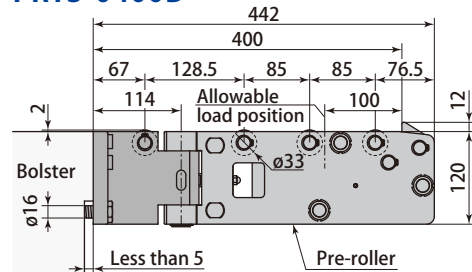
PRT3-0355B



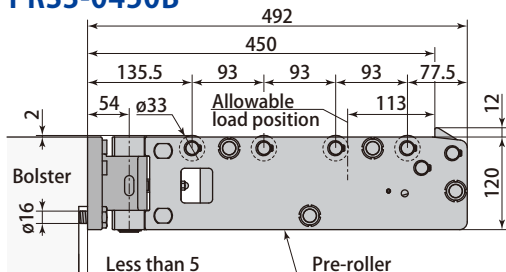
PRS3-0400B



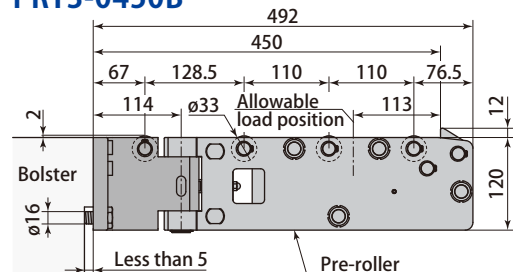
PRT3-0400B



PRS3-0450B



PRT3-0450B



Pre-roller horizontally fold PRS/T

External dimension

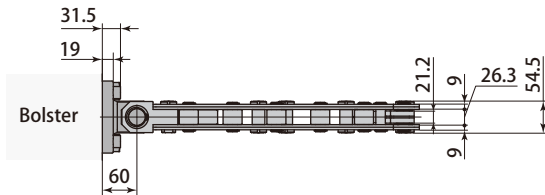
PRS 5 - 0500 B

1 Die travel (mm)
* Indicated in 4 digits

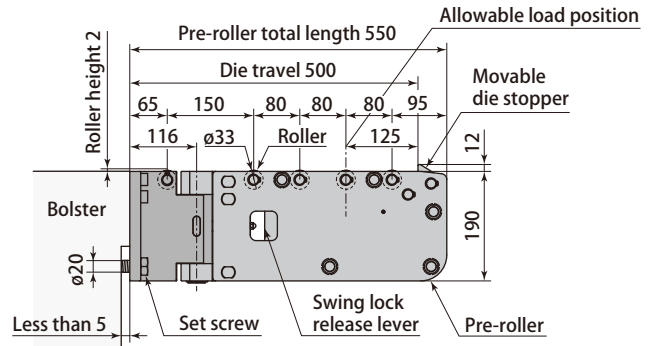
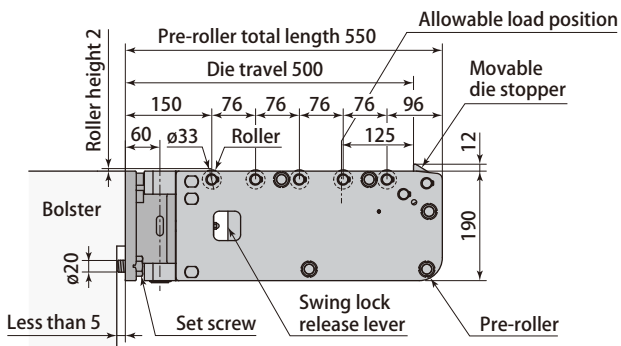
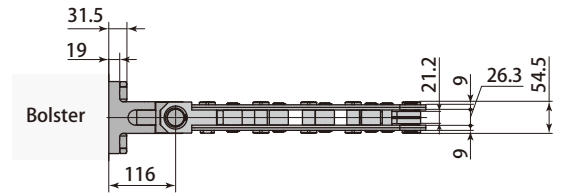
PRT 5 - 0500 B

1 Die travel (mm)
* Indicated in 4 digits

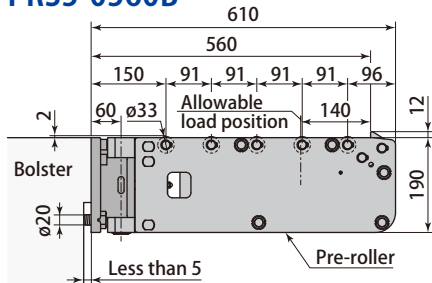
PRS5-0500B



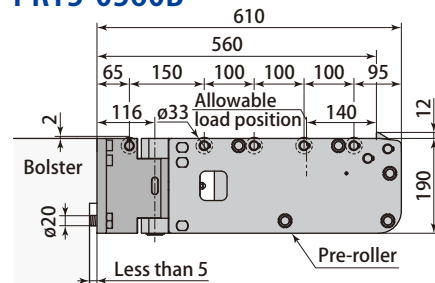
PRT5-0500B



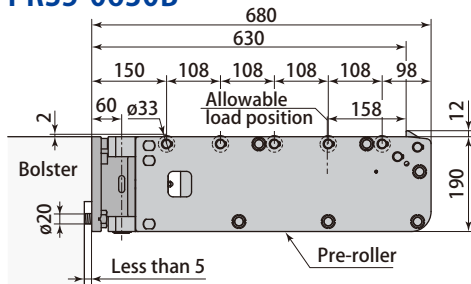
PRS5-0560B



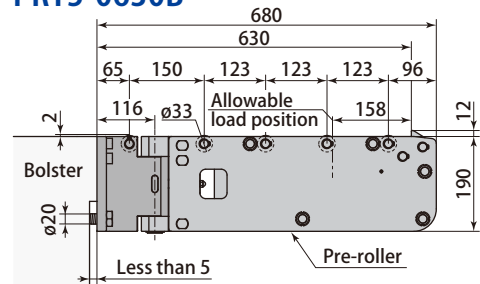
PRT5-0560B



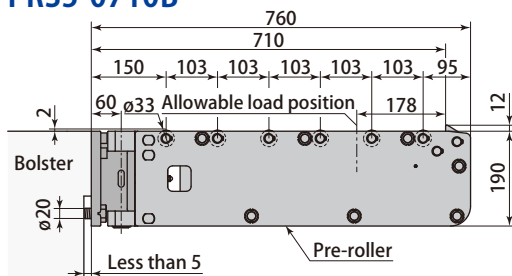
PRS5-0630B



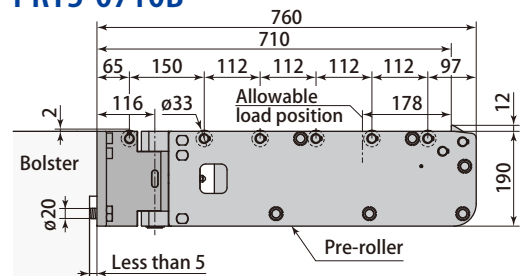
PRT5-0630B



PRS5-0710B



PRT5-0710B



Pre-roller horizontally fold PRS/T

External dimension

PRS 8 – 0630 B

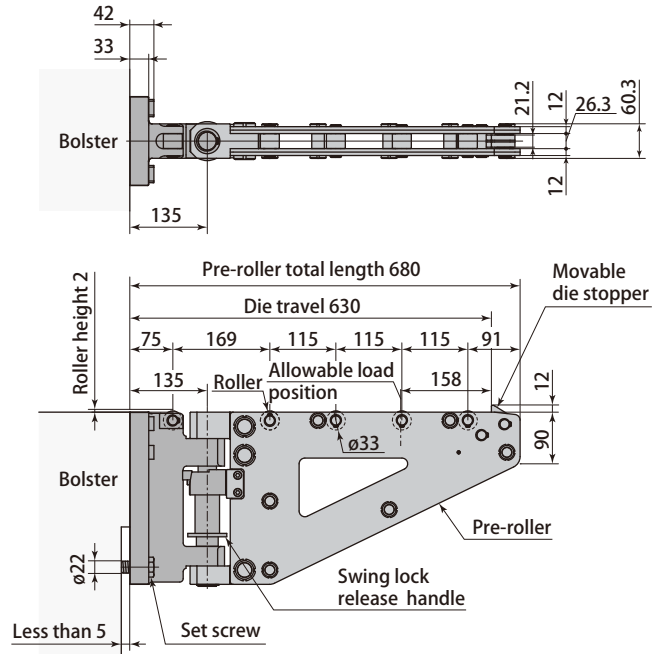
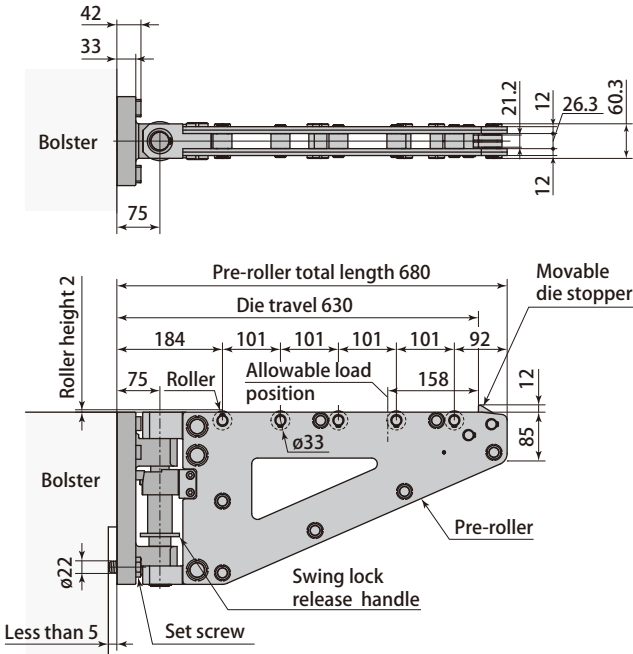
PRT 8 – 0630 B

1 Die travel (mm)
* Indicated in 4 digits

1 Die travel (mm)
* Indicated in 4 digits

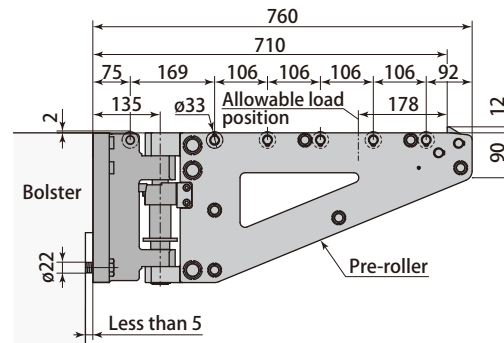
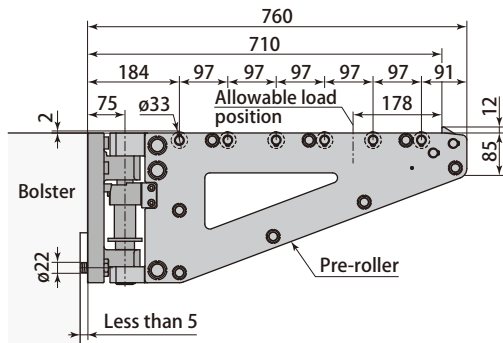
PRS8-0630B

PRT8-0630B



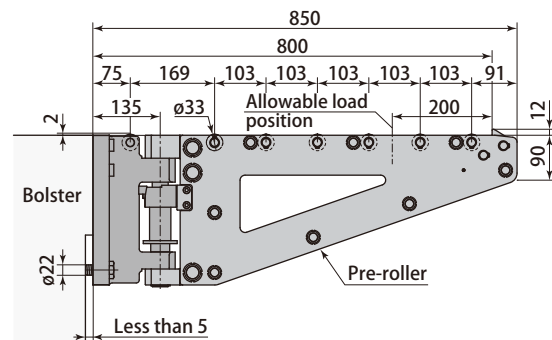
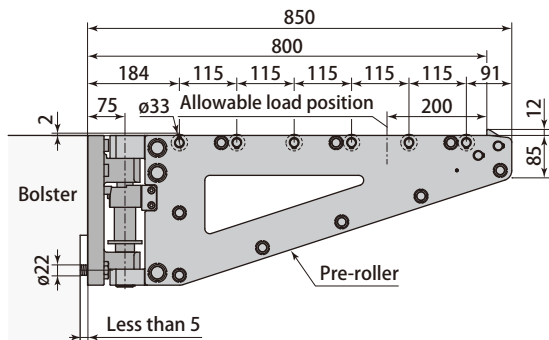
PRS8-0710B

PRT8-0710B

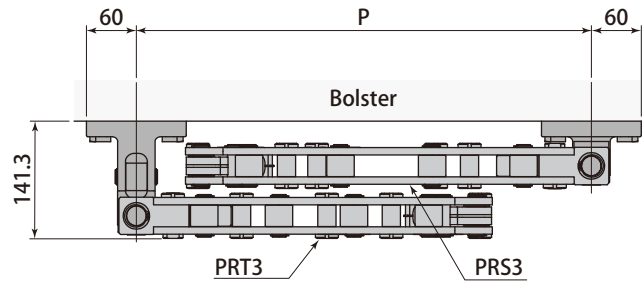


PRS8-0800B

PRT8-0800B



Pre-roller horizontally fold PRS/T



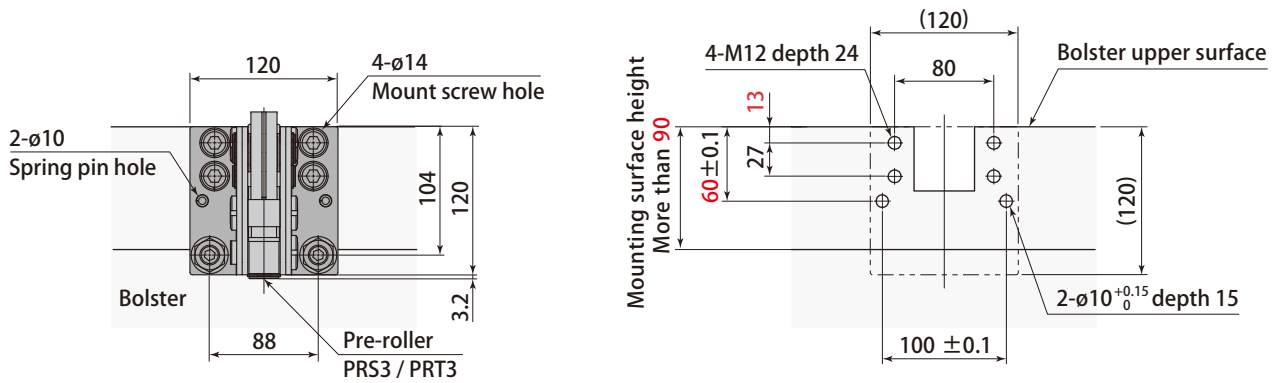
Minimum mounting pitch

mm

Model	PRS3-0315B	PRS3-0355B	PRS3-0400B	PRS3-0450B	PRS3-0500B	PRS3-0560B	PRS3-0630B	PRS3-0710B
	PRT3-0315B	PRT3-0355B	PRT3-0400B	PRT3-0450B	PRT3-0500B	PRT3-0560B	PRT3-0630B	PRT3-0710B
Minimum mounting pitch P	362	402	447	497	547	607	677	757

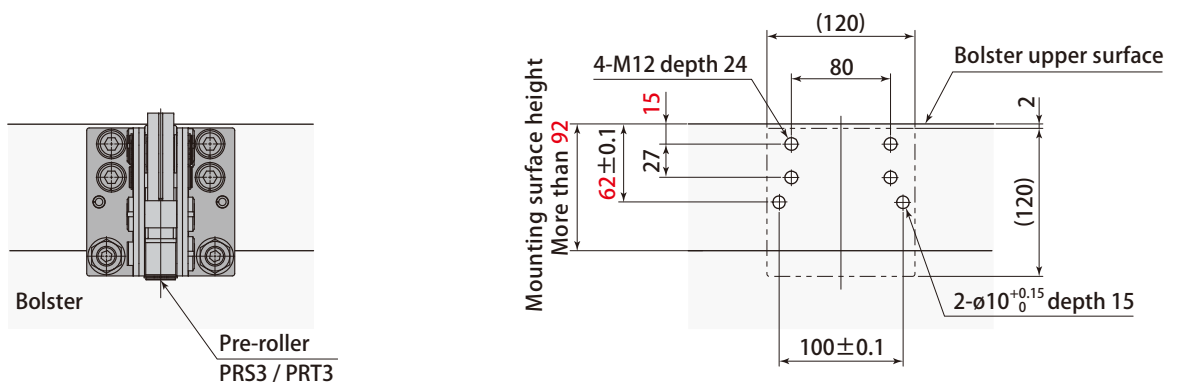
Mounting details

● When using the Die-lifter



● When not using the Die-lifter

When aligning the level between roller top and bolster surface

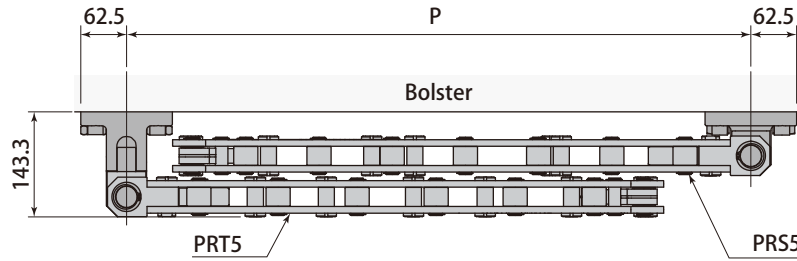


- When machining the spring pin hole, keep the tolerances shown above.
- Drill dia 10mm, 15mm deep hole for spring pin when co-machining the block with mount face.

Included

Pre-roller model type	PRS3 / PRT3
Mount screw	4-M12 length 35
Spring washer	4-M12
Spring pin	2-C10 length 32

Pre-roller horizontally fold
PRS/T Mounting details



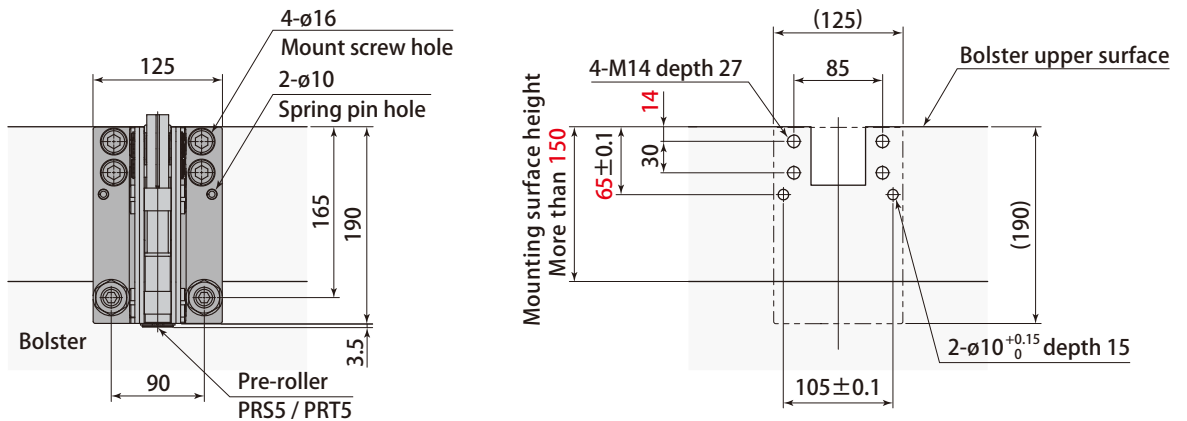
Minimum mounting pitch

mm

Model	PRS5-0500B	PRS5-0560B	PRS5-0630B	PRS5-0710B	PRS5-0800B	PRS5-0850B	PRS5-0900B	PRS5-0950B	PRS5-1000B
	PRT5-0500B	PRT5-0560B	PRT5-0630B	PRT5-0710B	PRT5-0800B	PRT5-0850B	PRT5-0900B	PRT5-0950B	PRT5-1000B
Minimum mounting pitch P	553	613	683	763	853	903	953	1003	1053

Mounting details

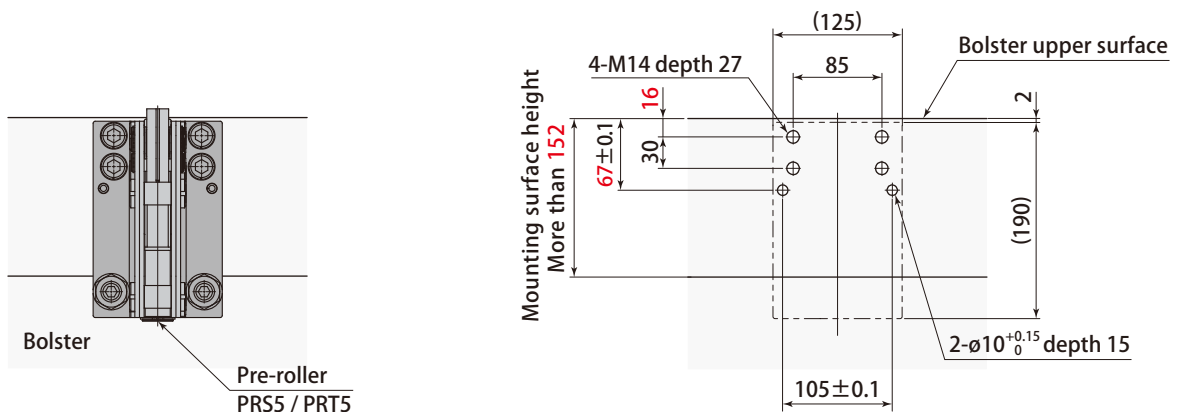
● When using the Die-lifter



Pre-roller horizontally fold
PRS/T Mounting details

● When not using the Die-lifter

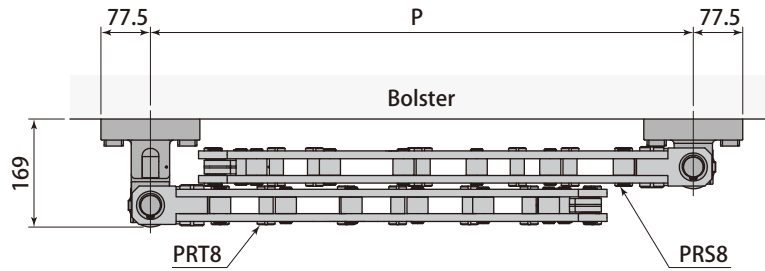
When aligning the level between roller top and bolster surface



- 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.

Included

Pre-roller model type	PRS5 / PRT5
Mount screw	4-M14 length 40
Spring washer	4-M14
Spring pin	2-C10 length 32

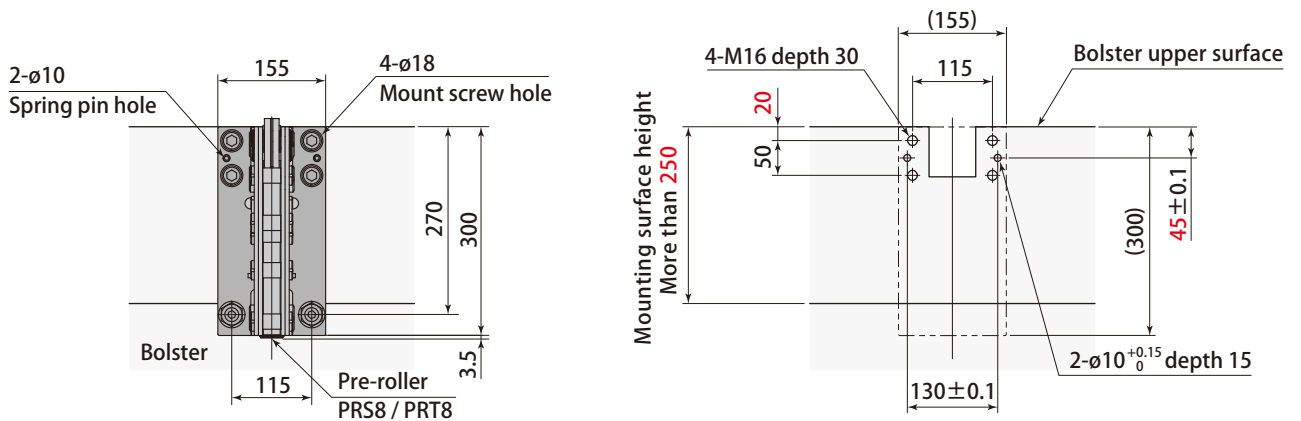


Minimum mounting pitch

Model	PRS8-0630B	PRS8-0710B	PRS8-0800B	PRS8-0850B	PRS8-0900B	PRS8-0950B	PRS8-1000B
	PRT8-0630B	PRT8-0710B	PRT8-0800B	PRT8-0850B	PRT8-0900B	PRT8-0950B	PRT8-1000B
Minimum mounting pitch P	680	760	850	900	950	1000	1050

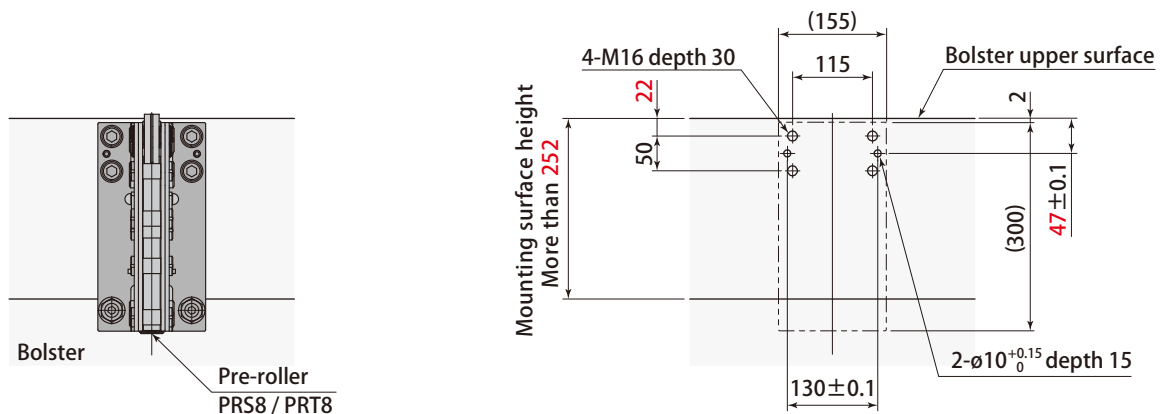
Mounting details

● 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.

Included

Pre-roller model type	PRS8 / PRT8
Mount screw	4-M16 length 55
Spring washer	4-M16
Spring pin	2-C10 length 45

Pre-roller horizontally fold PRS/T Mounting details

Set screw (PRS 3 / PRT3 , PRS 5 / PRT 5 , PRS 8 / PRT 8)

The set screw is included to all the models for PRS/T.

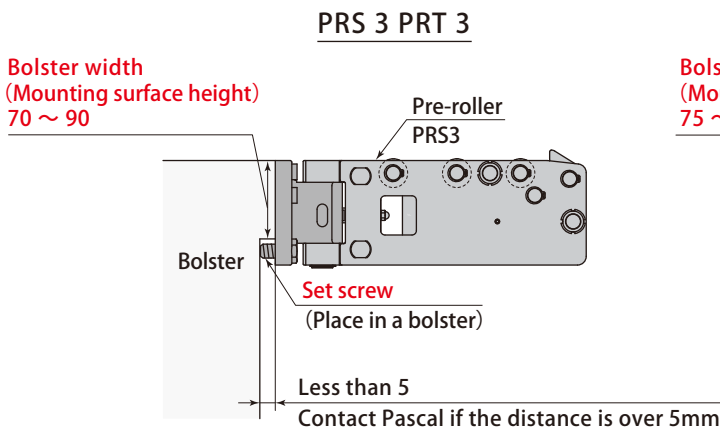
Model	PRS 3 / PRT3	
Bolster width (Mounting surface height)	70mm ~ 90mm	More than 90mm
Set screw	Required	Not required

Model	PRS 5 / PRT 5	
Bolster width (Mounting surface height)	75mm ~ 150mm	More than 150mm
Set screw	Required	Not required

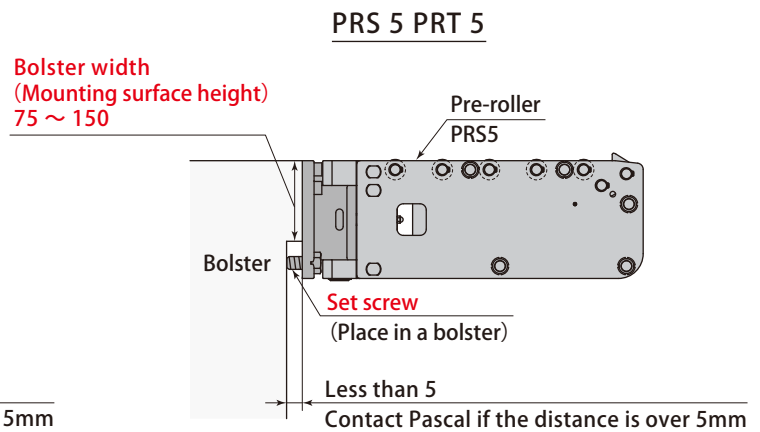
Model	PRS 8 / PRT 8	
Bolster width (Mounting surface height)	85mm ~ 250mm	More than 250mm
Set screw	Required	Not required

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

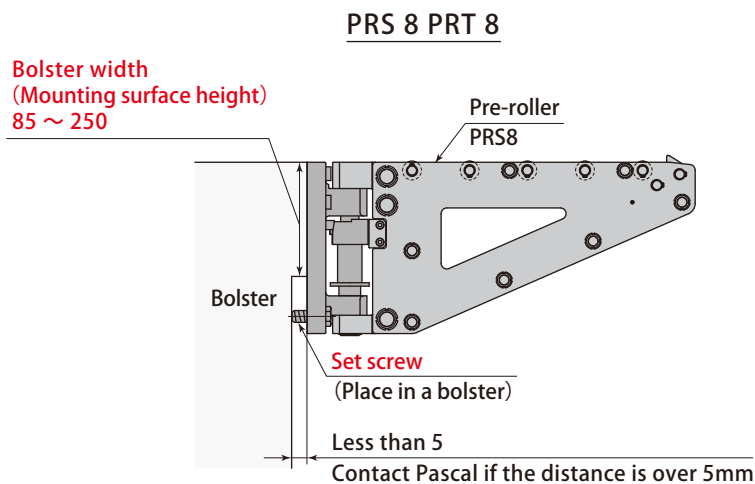
Pre-roller horizontally fold
PRS/T
Caution in use



* This drawing is PRS3-0315B.



* This drawing is PRS5-0500B.



* This drawing is PRS8-0630B.