

→ T-SLOT 18, DIN 650 Order code D18...

→ RECTANGULAR SLOT 18x30 Order code D18...

ROLLBLOC Ball Version Die Lifters Order code ...K...

with **spring pressure** Order code ...F...

Load carrying element: Ball **0.25 kN**
Ball spacing 35 mm, die lift $f = 1.5$ mm



ROLLBLOC Roller Version Die Lifters Order code ...W...

with **spring pressure** Order code ...F...

Load carrying element: Roller **0.5 kN**
Roller spacing 35 mm, die lift $f = 1.5$ mm



Allocation planning (examples) ①

Die size ②		Load bearing capacity/mean limit load (kN) ③		
Length in rolling direction	Carrying points per rollway	Allocation of 2 slots	3 slots	4 slots
315 mm	9	4.5	6.75	9
400 mm	11	5.5	8.25	11
500 mm	14	7	10.5	14
630 mm	18	9	13.5	18
800 mm	22	11	16.5	22
1000 mm	28	14	21	28

Die size ②		Load bearing capacity/mean limit load (kN) ③		
Length in rolling direction	Carrying points per rollway	Allocation of 2 slots	3 slots	4 slots
315 mm	9	9	13.5	18
400 mm	11	11	16.5	22
500 mm	14	14	21	28
630 mm	18	18	27	36
800 mm	22	22	33	44
1000 mm	28	28	42	56

Type list ④

Lifter length	Number of balls	Load bearing capacity/Lifter	Order code
105 mm	3	0.75 kN	D18KF03 / 300 - N
140 mm	4	1.00 kN	D18KF04 / ... - N
175 mm	5	1.25 kN	D18KF05 / ... - N
210 mm	6	1.50 kN	D18KF06 / ... - N
280 mm	8	2.00 kN	D18KF08 / ... - N
350 mm	10	2.50 kN	D18KF10 / ... - N

Use the detailed information on the fold-in flap *order designation* for exact order data.

Lifter length	Number of rollers	Load bearing capacity/Lifter	Order code
105 mm	3	1.5 kN	D18WF03 / 300 L N
140 mm	4	2.0 kN	D18WF04 / ... L N
175 mm	5	2.5 kN	D18WF05 / ... L N
210 mm	6	3.0 kN	D18WF06 / ... L N
280 mm	8	4.0 kN	D18WF08 / ... L N
350 mm	10	5.0 kN	D18WF10 / ... L N

Use the detailed information on the fold-in flap *order designation* for exact order data.

Explanatory order information

① Preliminary remarks on allocation planning

The slot size is generally defined. The relatively lightest die serves as the basis for allocation planning. The load bearing capacity of the load carrying elements is dependent on their shape (ball, rollers) and the type of pressure system (spring, hydraulic).

② Die dimensions

There are a corresponding number of load carrying points per runway (underside of die base plate) for a defined die length (in rolling direction).

③ Load bearing capacity

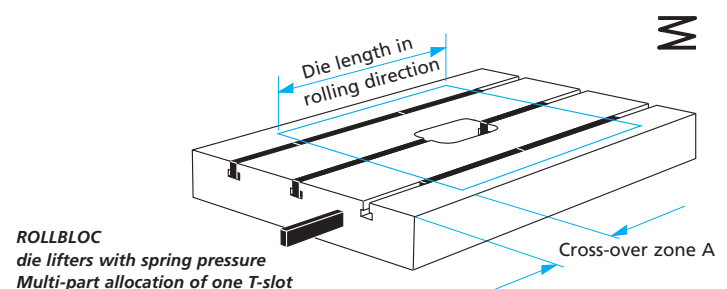
The table *Load bearing capacity* indicates how many table slots are to be equipped with ROLLBLOC die lifters in order to achieve the necessary load bearing capacity based on a defined die length. Any interruptions in the runway at the die base plate must be taken into consideration.

The die with the small/short base plate can turn out to be the relatively heaviest die.

④ Type list

The standard versions are detailed in the *Type list*. The lengths are based on typical press table formats. ROLLBLOC die lifters can be supplied with any number of load carrying elements on request.

The order code is to be completed according to the specific version. For this purpose, please use the detailed information provided on the fold-in flap *Order designation*.



ROLLBLOC Ball Version Die Lifters Order code ...K...

with **hydraulic pressure** Order code ...H...

Load carrying element: Ball **0.5** kN, op pressure 40 bar (4 MPa)
Ball spacing 35 mm, die lift $f = 1.5$ mm

ROLLBLOC Roller Version Die Lifters Order code ...W...

with **hydraulic pressure** Order code ...H...

Load carrying element: Roller **1.0** kN, op pressure 80 bar (8 MPa)
Roller spacing 35 mm, die lift $f = 1.5$ mm

Allocation planning (examples) ①

Die size ②		Load bearing capacity (kN) ③		
Length in rolling direction	Carrying points per rollway	Allocation of 2 slots	3 slots	4 slots
315 mm	9	9	13.5	18
400 mm	11	11	16.5	22
500 mm	14	14	21	28
630 mm	18	18	27	36
800 mm	22	22	33	44
1000 mm	28	28	42	56

Die size ②		Load bearing capacity (kN) ③		
Length in rolling direction	Carrying points per rollway	Allocation of 2 slots	3 slots	4 slots
315 mm	9	18	27	36
400 mm	11	22	33	44
500 mm	14	28	42	56
630 mm	18	36	54	72
800 mm	22	44	66	88
1000 mm	28	56	84	112

Type list ④

Lifter length	Number of balls	Load bearing capacity/Lifter	Order code
245 mm	7	0.35 kN	D18KH07 / 300 - N R
315 mm	9	4.5 kN	D18KH09 / ... - N R
385 mm	11	5.5 kN	D18KH11 / ... - N R
490 mm	14	7 kN	D18KH14 / ... - N R
560 mm	16	8 kN	D18KH16 / ... - N R
630 mm	18	9 kN	D18KH18 / ... - N R
700 mm	20	10 kN	D18KH20 / ... - N R
770 mm	22	11 kN	D18KH22 / ... - N R
875 mm	25	12.5 kN	D18KH25 / ... - N R
980 mm	28	14 kN	D18KH28 / ... - N R
1085 mm	31	15.5 kN	D18KH31 / ... - N R
1225 mm	35	17.5 kN	D18KH35 / ... - N R
1400 mm	40	20 kN	D18KH40 / ... - N R

Lifter length	Number of rollers	Load bearing capacity/Lifter	Order code
245 mm	7	7 kN	D18WH07 / 300 L N R
315 mm	9	9 kN	D18WH09 / ... L N R
385 mm	11	11 kN	D18WH11 / ... L N R
490 mm	14	14 kN	D18WH14 / ... L N R
560 mm	16	16 kN	D18WH16 / ... L N R
630 mm	18	18 kN	D18WH18 / ... L N R
700 mm	20	20 kN	D18WH20 / ... L N R
770 mm	22	22 kN	D18WH22 / ... L N R
875 mm	25	25 kN	D18WH25 / ... L N R
980 mm	28	28 kN	D18WH28 / ... L N R
1085 mm	31	31 kN	D18WH31 / ... L N R
1225 mm	35	35 kN	D18WH35 / ... L N R
1400 mm	40	40 kN	D18WH40 / ... L N R

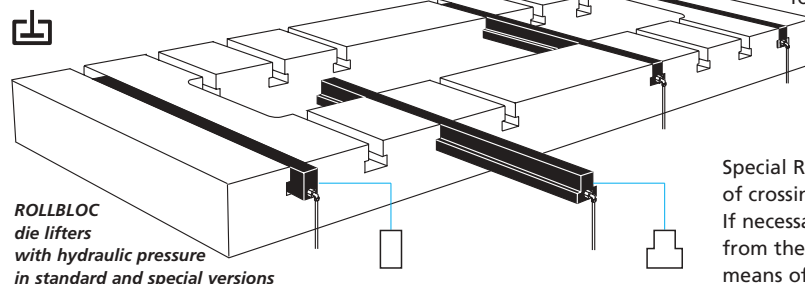
Use the detailed information on the fold-in flap *order designation* for exact order data.

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Explanatory order information

See opposite page for ① ② ③

Only ROLLBLOC roller version die lifters are suitable for overhead installation.


ROLLBLOC
die lifters
with hydraulic pressure
in standard and special versions

Special ROLLBLOC T-version die lifters should be used for the purpose of crossing over table recesses (bridge function).
If necessary, for production purposes, these die lifters can be removed from the table slot. They are disconnected from the hydraulic system by means of a quick-release coupling (Page 25).