ROLLBLOC die lifters for the slot formats:

→ T-SLOT 22, DIN 650 Order code D22...

→ RECTANGULAR SLOT 22x38 Order code D22...

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

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

Load carrying element: Ball **0.4** kN

Ball spacing 40 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 **0.8** kN

Roller spacing 40 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
400 mm	10	8	12	16
500 mm	12	10	15	20
630 mm	15	12	18	24
800 mm	20	16	24	32
1000 mm	25	20	30	40
1250 mm	31	25	37.5	50

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
400 mm	10	16	24	32
500 mm	12	19	29	38
630 mm	15	24	36	48
800 mm	20	32	48	64
1000 mm	25	40	60	80
1250 mm	31	50	75	100

Type list ④

Lifter length	Number of balls	Load bearing capacity/Lifter	Order code
120 mm	3	1.2 kN	D22KF03 / 380 – N
160 mm	4	1.6 kN	D22KF04 / . . . – N
200 mm	5	2.0 kN	D22KF05 / . . . – N
240 mm	6	2.4 kN	D22KF06 / . . . – N
320 mm	8	3.2 kN	D22KF08 / . . . – N
400 mm	10	4.0 kN	D22KF10 / . . . – N

Use the detailed information on the fold-in flap order designation for exact order data (Page 14).

Lifter length	Number of rollers	Load bearing capacity/Lifter	Order code
120 mm	3	2.4 kN	D22WF03 / 380 L N
160 mm	4	3.2 kN	D22WF04 / . . . L N
200 mm	5	4.0 kN	D22WF05 / . . . L N
240 mm	6	4.8 kN	D22WF06 / . . . L N
320 mm	8	6.4 kN	D22WF08 / . . . L N
400 mm	10	8.0 kN	D22WF10 / . . . L N

Use the detailed information on the fold-in flap order designation for exact order data (Page 14).

Explanatory order information

① Preliminary remarks on allocation planning

The slot size is generally defined. The relatively heaviest 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

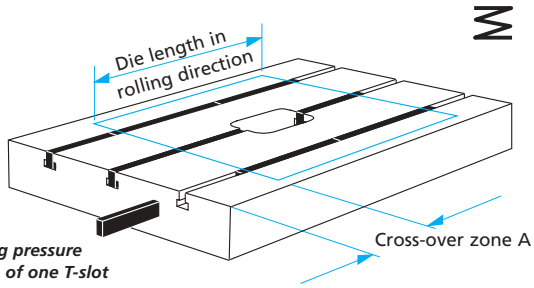
There are a corresponding number of load carrying points per runway (underside of die base plate) for a defined die length (in rolling direction).

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** (Page 14).



ROLLBLOC die lifters with spring pressure Multi-part allocation of one T-slot

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

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

Load carrying element: Ball **0.8** kN, op pressure 40 bar (4 MPa)
Ball spacing 40 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 **1.6** kN, op pressure 80 bar (8 MPa)
Roller spacing 40 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
400 mm	10	16	24	32
500 mm	12	19	29	38
630 mm	15	24	36	48
800 mm	20	32	48	64
1000 mm	25	40	60	80
1250 mm	31	50	75	100

Die size ②		Load bearing capacity (kN) ③		
Length in rolling direction	Carrying points per rollway	Allocation of 2 slots	3 slots	4 slots
400 mm	10	32	48	64
500 mm	12	38	58	76
630 mm	15	48	72	96
800 mm	20	64	96	128
1000 mm	25	80	120	160
1250 mm	31	100	150	200

Type list ④

Lifter length	Number of balls	Load bearing capacity/Lifter	Order code
320 mm	8	6.4 kN	D22KH08 / 380 – N R
400 mm	10	8.0 kN	D22KH10 / . . . – N R
480 mm	12	9.6 kN	D22KH12 / . . . – N R
560 mm	14	11.2 kN	D22KH14 / . . . – N R
640 mm	16	12.8 kN	D22KH16 / . . . – N R
720 mm	18	14.4 kN	D22KH18 / . . . – N R
800 mm	20	16.0 kN	D22KH20 / . . . – N R
880 mm	22	17.6 kN	D22KH22 / . . . – N R
1000 mm	25	20.0 kN	D22KH25 / . . . – N R
1120 mm	28	22.4 kN	D22KH28 / . . . – N R
1240 mm	31	24.8 kN	D22KH31 / . . . – N R
1400 mm	35	28.0 kN	D22KH35 / . . . – N R
1600 mm	40	32.0 kN	D22KH40 / . . . – N R

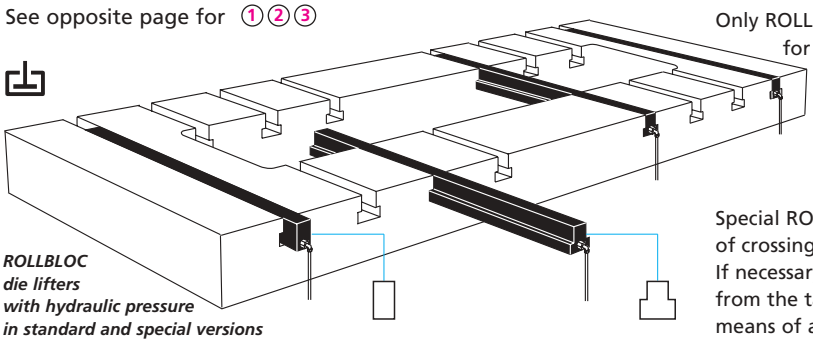
Use the detailed information on the fold-in flap ▲1 ▲2 ▲3 ▲4 order designation for exact order data (Page 14).

Lifter length	Number of rollers	Load bearing capacity/Lifter	Order code
320 mm	8	12.8 kN	D22WH08 / 380 L N R
400 mm	10	16.0 kN	D22WH10 / . . . L N R
480 mm	12	19.2 kN	D22WH12 / . . . L N R
560 mm	14	22.4 kN	D22WH14 / . . . L N R
640 mm	16	25.6 kN	D22WH16 / . . . L N R
720 mm	18	28.8 kN	D22WH18 / . . . L N R
800 mm	20	32.0 kN	D22WH20 / . . . L N R
880 mm	22	35.2 kN	D22WH22 / . . . L N R
1000 mm	25	40.0 kN	D22WH25 / . . . L N R
1120 mm	28	44.8 kN	D22WH28 / . . . L N R
1240 mm	31	49.6 kN	D22WH31 / . . . L N R
1400 mm	35	56.0 kN	D22WH35 / . . . L N R
1600 mm	40	64.0 kN	D22WH40 / . . . L N R

Use the detailed information on the fold-in flap ▲1 ▲2 ▲3 ▲4 order designation for exact order data (Page 14).

Bestellvorklärung

See opposite page for ①②③



ROLLBLOC die lifters with hydraulic pressure in standard and special versions

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

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).