ROLLBLOC die lifters for the slot formats:

→ T-SLOT 36, DIN 650 Order code D36...

→ RECTANGULAR SLOT 36x53 Order code D36...

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

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

Load carrying element: Ball **1** kN

Ball spacing 50 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 **2** kN

Roller spacing 50 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	4 slots	6 slots
500 mm	10	20	40	60
630 mm	12	24	48	72
800 mm	16	32	64	96
1000 mm	20	40	80	120
1250 mm	25	50	100	150
1600 mm	32	64	128	192
2000 mm	40	80	160	240

Die size ②		Load bearing capacity (kN) ③		
Length in rolling direction	Carrying points per rollway	Allocation of 2 slots	4 slots	6 slots
500 mm	10	40	80	120
630 mm	12	48	96	144
800 mm	16	64	128	192
1000 mm	20	80	160	240
1250 mm	25	100	200	300
1600 mm	32	128	256	384
2000 mm	40	160	320	480

Type list ④

Lifter length	Number of balls	Load bearing capacity/Lifter	Order code
150 mm	3	3 kN	D36KF03 / 610 – N
200 mm	4	4 kN	D36KF04 / . . . – N
250 mm	5	5 kN	D36KF05 / . . . – N
300 mm	6	6 kN	D36KF06 / . . . – N
400 mm	8	8 kN	D36KF08 / . . . – N
500 mm	10	10 kN	D36KF10 / . . . – 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
150 mm	3	6 kN	D36WF03 / 610 L N
200 mm	4	8 kN	D36WF04 / . . . L N
250 mm	5	10 kN	D36WF05 / . . . L N
300 mm	6	12 kN	D36WF06 / . . . L N
400 mm	8	16 kN	D36WF08 / . . . L N
500 mm	10	20 kN	D36WF10 / . . . 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

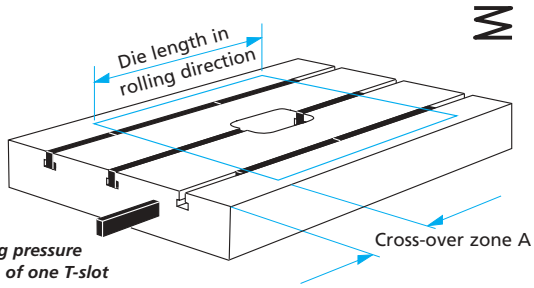
There are a corresponding number of load carrying points per runway (underside of die base plate) for a defined die length (in rolling direction).

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 **2** kN, op pressure 40 bar (4 MPa)
Ball spacing 50 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 **4** kN, op pressure 80 bar (8 MPa)
Roller spacing 50 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	4 slots	6 slots
500 mm	10	40	80	120
630 mm	12	48	96	144
800 mm	16	64	128	192
1000 mm	20	80	160	240
1250 mm	25	100	200	300
1600 mm	32	128	256	384
2000 mm	40	160	320	480

Die size ②		Load bearing capacity (kN) ③		
Length in rolling direction	Carrying points per rollway	Allocation of 2 slots	4 slots	6 slots
500 mm	10	80	160	240
630 mm	12	96	192	288
800 mm	16	128	256	384
1000 mm	20	160	320	480
1250 mm	25	200	400	600
1600 mm	32	256	512	768
2000 mm	40	320	640	960

Type list ④

Lifter length	Number of balls	Load bearing capacity/Lifter	Order code
400 mm	8	16 kN	D36KH08 / 610 – N R
500 mm	10	20 kN	D36KH10 / . . . – N R
600 mm	12	24 kN	D36KH12 / . . . – N R
700 mm	14	28 kN	D36KH14 / . . . – N R
800 mm	16	32 kN	D36KH16 / . . . – N R
900 mm	18	36 kN	D36KH18 / . . . – N R
1000 mm	20	40 kN	D36KH20 / . . . – N R
1100 mm	22	44 kN	D36KH22 / . . . – N R
1250 mm	25	50 kN	D36KH25 / . . . – N R
1400 mm	28	56 kN	D36KH28 / . . . – N R
1550 mm	31	62 kN	D36KH31 / . . . – N R
1750 mm	35	70 kN	D36KH35 / . . . – N R
2000 mm	40	80 kN	D36KH40 / . . . – N R

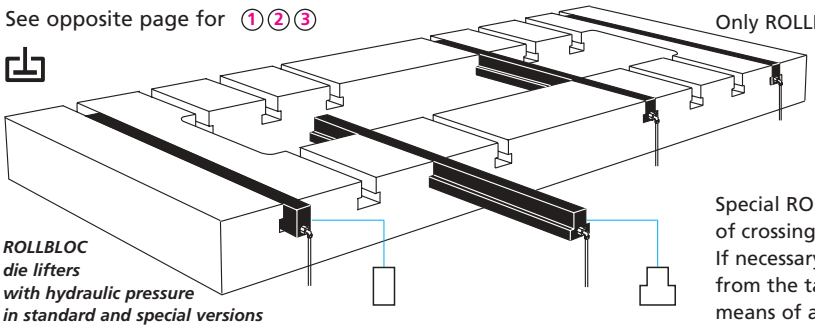
Use the detailed information on the fold-in flap ① ② ③ ④ order designation for exact order data (Page 14).

Lifter length	Number of rollers	Load bearing capacity/Lifter	Order code
400 mm	8	32 kN	D36WH08 / 610 L N R
500 mm	10	40 kN	D36WH10 / . . . L N R
600 mm	12	48 kN	D36WH12 / . . . L N R
700 mm	14	56 kN	D36WH14 / . . . L N R
800 mm	16	64 kN	D36WH16 / . . . L N R
900 mm	18	72 kN	D36WH18 / . . . L N R
1000 mm	20	80 kN	D36WH20 / . . . L N R
1100 mm	22	88 kN	D36WH22 / . . . L N R
1250 mm	25	100 kN	D36WH25 / . . . L N R
1400 mm	28	112 kN	D36WH28 / . . . L N R
1550 mm	31	124 kN	D36WH31 / . . . L N R
1750 mm	35	140 kN	D36WH35 / . . . L N R
2000 mm	40	160 kN	D36WH40 / . . . L N R

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

Explanatory order information

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).