ROLLBLOC die lifters for the slot formats:

→ 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	

1 2 3

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	

1 2 3

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 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

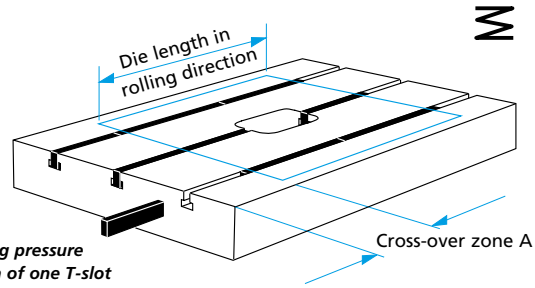
There are a corresponding number of load carrying points per runway (underside of die base plate) for a defined die length (in rolling direction).

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**.



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 **0.5** kN, op pressure 40 bar (4 MPa)
Ball spacing 35 mm, die lift f = 1.5 mm
Oil volume/Ball 0.3 cm³

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
Oil volume/Roller 0.3 cm³

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	3.5 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

1 2 3 4

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

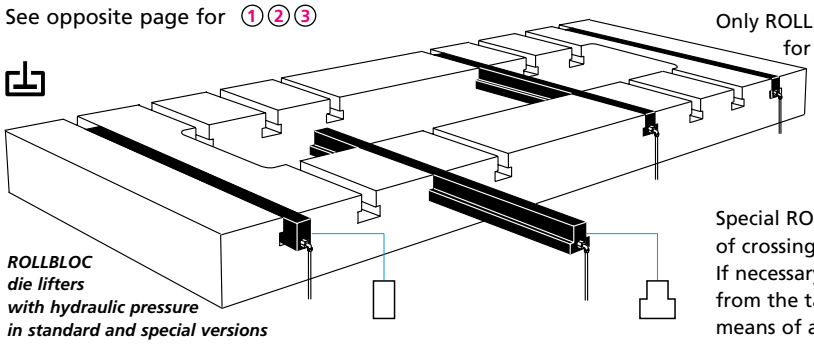
Lifter length	Number of rollers	Load bearing capacity/Lifter	Order code
245 mm	7	7 kN	D18WH07 / 300 L N R
315 mm	9	9 kN	D18WH09 / . . . L N R
385 mm	11	11 kN	D18WH11 / . . . L N R
490 mm	14	14 kN	D18WH14 / . . . L N R
560 mm	16	16 kN	D18WH16 / . . . L N R
630 mm	18	18 kN	D18WH18 / . . . L N R
700 mm	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

1 2 3 4

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

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).

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

1 2 3

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

1 2 3

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

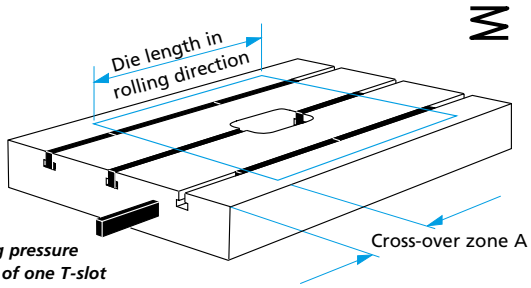
There are a corresponding number of load carrying points per runway (underside of die base plate) for a defined die length (in rolling direction).

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
Oil volume/Ball 0.5 cm³

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
Oil volume/Roller 0.5 cm³

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

1 2 3 4

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

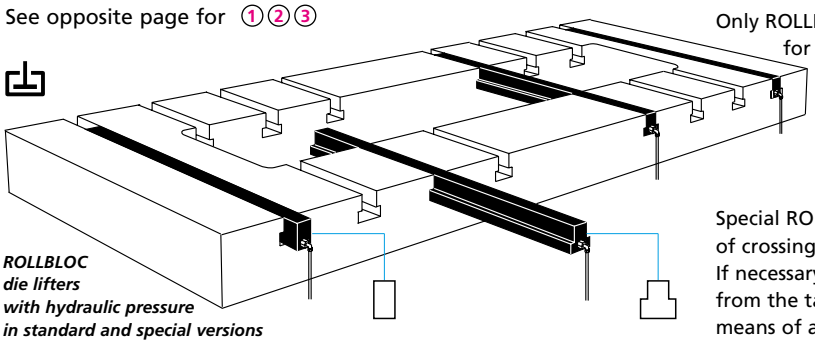
Lifter length	Number of rollers	Load bearing capacity/Lifter	Order code
320 mm	8	12.8 kN	D22WH08 / 380 L N R
400 mm	10	16.0 kN	D22WH10 / . . . L N R
480 mm	12	19.2 kN	D22WH12 / . . . L N R
560 mm	14	22.4 kN	D22WH14 / . . . L N R
640 mm	16	25.6 kN	D22WH16 / . . . L N R
720 mm	18	28.8 kN	D22WH18 / . . . 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

1 2 3 4

Use the detailed information on the fold-in flap 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).

ROLLBLOC die lifters for the slot formats:

→ T-SLOT 28, DIN 650 Order code D28...

→ RECTANGULAR SLOT 28x44 Order code D28...

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

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

Load carrying element: Ball **0.63** kN

Ball spacing 45 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 **1.25** kN

Roller spacing 45 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
400 mm	8	10	20	30
500 mm	11	14	28	42
630 mm	14	18	36	54
800 mm	17	22	44	66
1000 mm	22	28	56	84
1250 mm	27	35	70	105
1600 mm	35	45	90	135

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
400 mm	8	20	40	60
500 mm	11	27.5	55	82
630 mm	14	35	70	105
800 mm	17	42.5	85	127
1000 mm	22	55	110	165
1250 mm	27	67.5	135	202
1600 mm	35	87.5	175	262

Type list ④

Lifter length	Number of balls	Load bearing capacity/Lifter	Order code
135 mm	3	1.9 kN	D28KF03 / 480 – N
180 mm	4	2.5 kN	D28KF04 / . . . – N
225 mm	5	3.2 kN	D28KF05 / . . . – N
270 mm	6	3.8 kN	D28KF06 / . . . – N
360 mm	8	5.0 kN	D28KF08 / . . . – N
450 mm	10	6.3 kN	D28KF10 / . . . – N

1 2 3

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
135 mm	3	3.8 kN	D28WF03 / 480 L N
180 mm	4	5.0 kN	D28WF04 / . . . L N
225 mm	5	6.3 kN	D28WF05 / . . . L N
270 mm	6	7.5 kN	D28WF06 / . . . L N
360 mm	8	10.0 kN	D28WF08 / . . . L N
450 mm	10	12.5 kN	D28WF10 / . . . L N

1 2 3

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

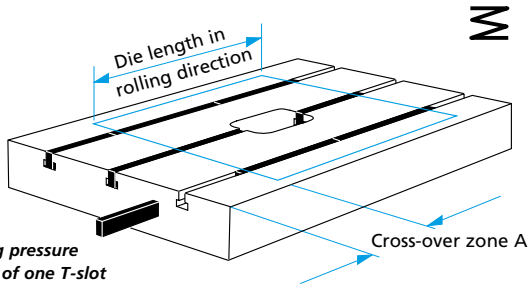
There are a corresponding number of load carrying points per runway (underside of die base plate) for a defined die length (in rolling direction).

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 **1.25** kN, op pressure 40 bar (4 MPa)
Ball spacing 45 mm, die lift f = 1.5 mm
Oil volume/Ball 0.8 cm³

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

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

Load carrying element: Roller **2.5** kN, op pressure 80 bar (8 MPa)
Roller spacing 45 mm, die lift f = 1.5 mm
Oil volume/Roller 0.8 cm³

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
400 mm	8	20	40	60
500 mm	11	27.5	55	82
630 mm	14	35	70	105
800 mm	17	42.5	85	127
1000 mm	22	55	110	165
1250 mm	27	67.5	135	202
1600 mm	35	87.5	175	262

Die size ②		Load bearing capacity (kN) ③		
Length in rolling direction	Carrying points per rollway	Allocation of 2 slots	4 slots	6 slots
400 mm	8	40	80	120
500 mm	11	55	110	165
630 mm	14	70	140	210
800 mm	17	85	170	255
1000 mm	22	110	220	330
1250 mm	27	135	270	405
1600 mm	35	175	350	525

Type list ④

Lifter length	Number of balls	Load bearing capacity/Lifter	Order code
315 mm	7	8.75 kN	D28KH07 / 480 – N R
405 mm	9	11.25 kN	D28KH09 / . . . – N R
495 mm	11	13.75 kN	D28KH11 / . . . – N R
630 mm	14	17.5 kN	D28KH14 / . . . – N R
720 mm	16	20 kN	D28KH16 / . . . – N R
810 mm	18	22.5 kN	D28KH18 / . . . – N R
900 mm	20	25 kN	D28KH20 / . . . – N R
990 mm	22	27.5 kN	D28KH22 / . . . – N R
1125 mm	25	31.25 kN	D28KH25 / . . . – N R
1260 mm	28	35 kN	D28KH28 / . . . – N R
1395 mm	31	38.75 kN	D28KH31 / . . . – N R
1575 mm	35	43.75 kN	D28KH35 / . . . – N R
1800 mm	40	50 kN	D28KH40 / . . . – N R

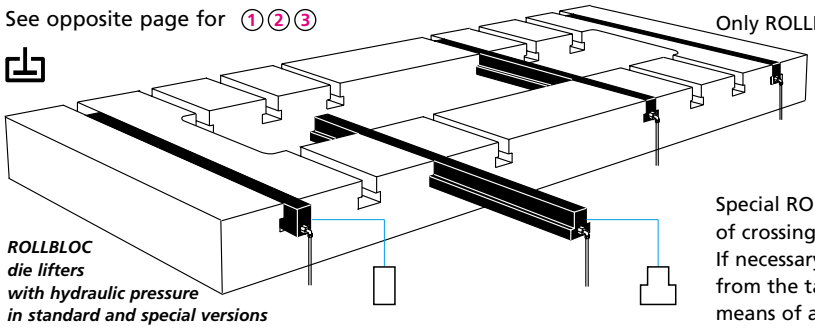
Use the detailed information on the fold-in flap order designation for exact order data (Page 14).

Lifter length	Number of rollers	Load bearing capacity/Lifter	Order code
315 mm	7	17.5 kN	D28WH07 / 480 L N R
405 mm	9	22.5 kN	D28WH09 / . . . L N R
495 mm	11	27.5 kN	D28WH11 / . . . L N R
630 mm	14	35 kN	D28WH14 / . . . L N R
720 mm	16	40 kN	D28WH16 / . . . L N R
810 mm	18	45 kN	D28WH18 / . . . L N R
900 mm	20	50 kN	D28WH20 / . . . L N R
990 mm	22	55 kN	D28WH22 / . . . L N R
1125 mm	25	62.5 kN	D28WH25 / . . . L N R
1260 mm	28	70 kN	D28WH28 / . . . L N R
1395 mm	31	77.5 kN	D28WH31 / . . . L N R
1575 mm	35	87.5 kN	D28WH35 / . . . L N R
1800 mm	40	100 kN	D28WH40 / . . . L N R

Use the detailed information on the fold-in flap 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).

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

1 2 3

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

1 2 3

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

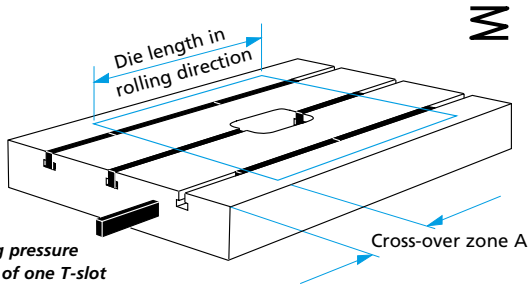
There are a corresponding number of load carrying points per runway (underside of die base plate) for a defined die length (in rolling direction).

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
Oil volume/Ball 1.2 cm³

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
Oil volume/Roller 1.2 cm³

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	

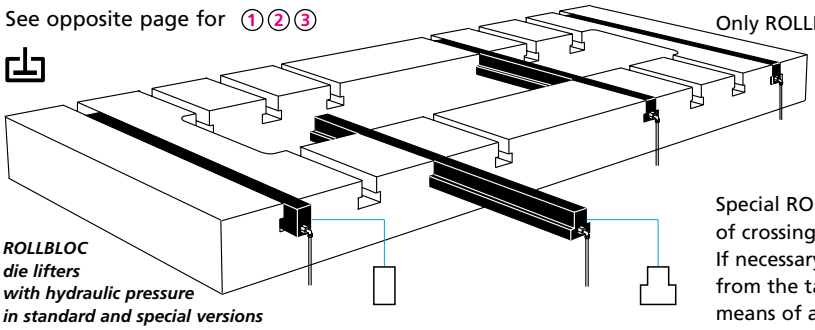
Use the detailed information on the fold-in flap order designation for exact order data (Page 14).

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 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).