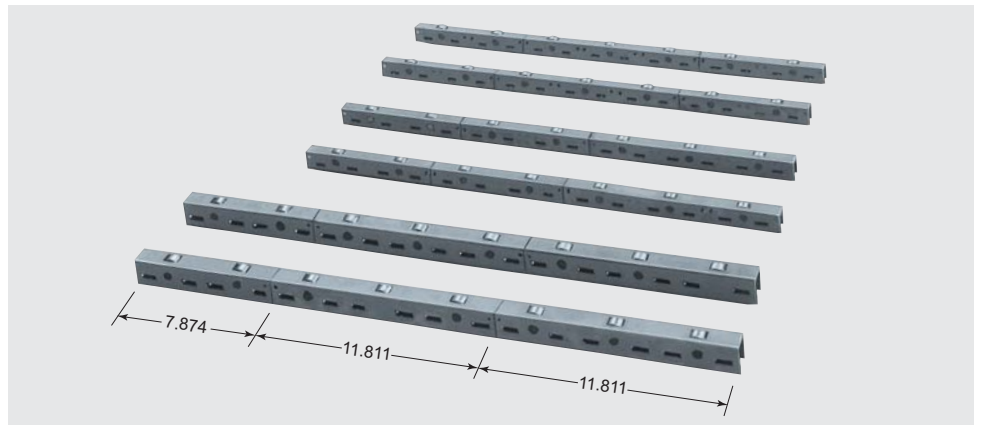
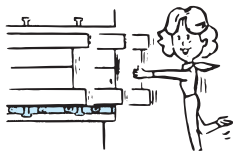
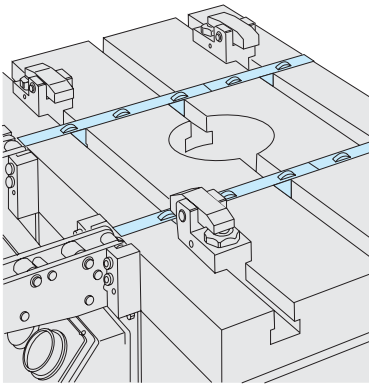
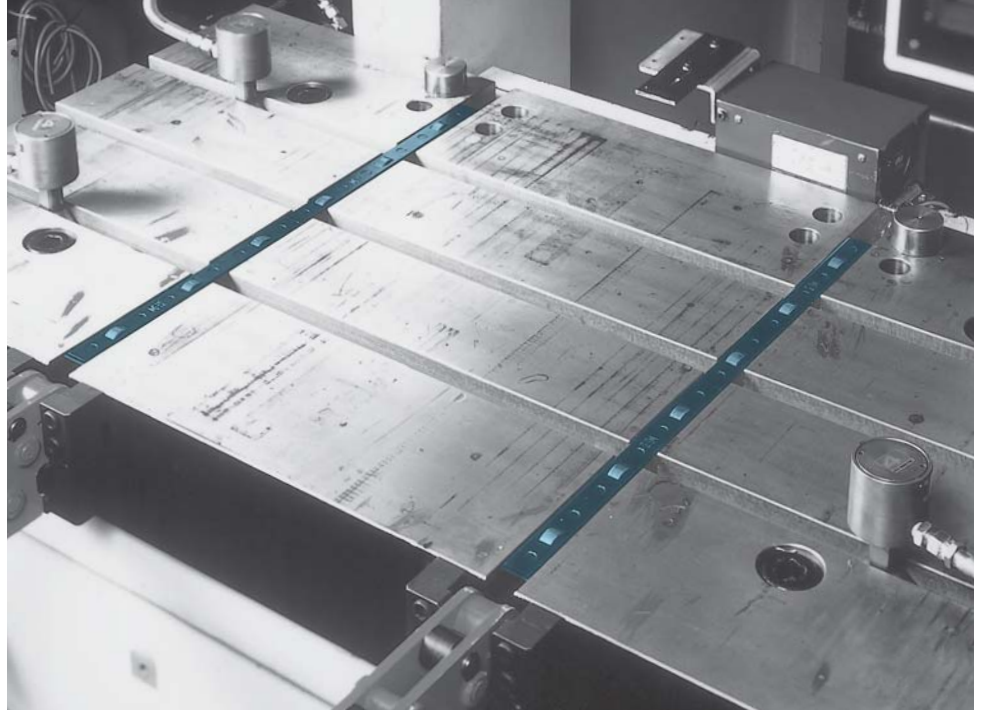


DIE-ROLLER

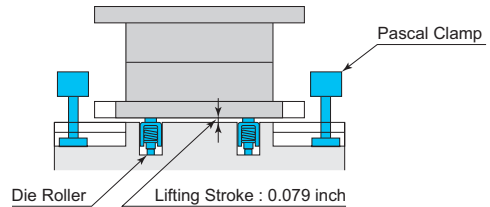
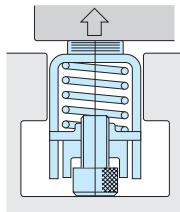
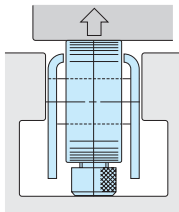
DRA

MODEL DRA SPRING-LIFTING ROLLERS

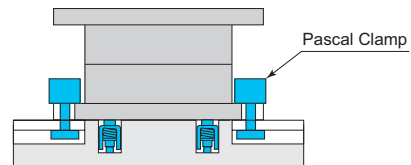
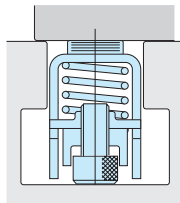
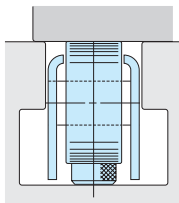
Simple economical spring lifting rollers are suitable for small to mid sized die. They can be mounted into most standard T-slot and do not require a power source. They are held down by clamping the die on to the press. Selection of DRA series is determined by the die weight, size, bed size and T-slot dimensions.



UP



DOWN



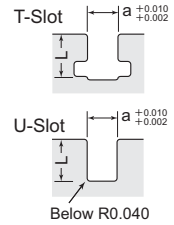
Die Rollers are pressed down into bolster by clamping force.

MODEL AND SPECIFICATIONS

DRA ① - ② - ③

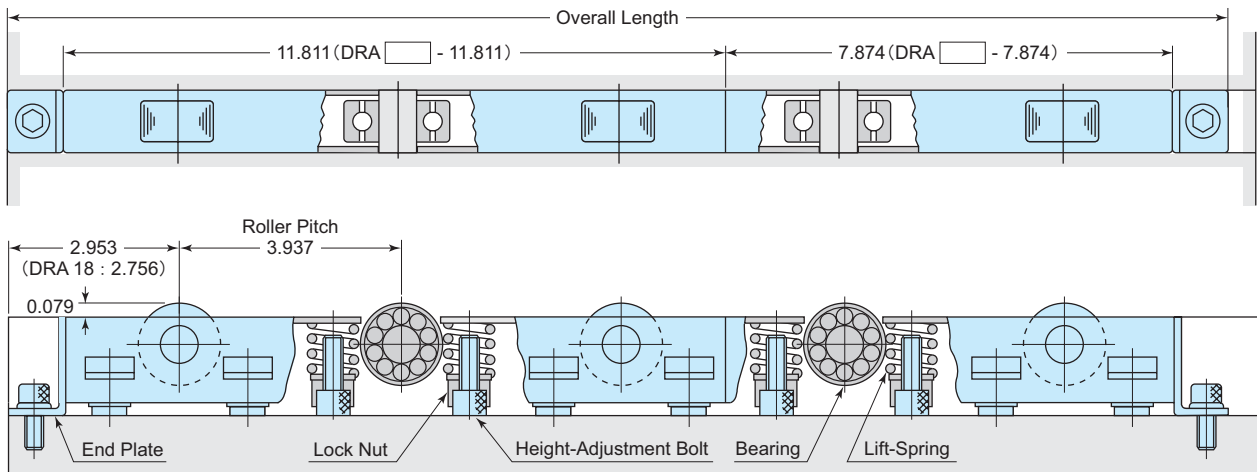
- ① Basic Model
18, 20 : Light load 30 : Heavy load
- ② Length of 1 piece
(7.874 in, 11.811 in)
- ③ T/U-Slot "a" dimension

Model	Lifting force per 4 inches (1 line)	Weight per single roller		T/U-Slot (in)	
		Length	Weight	a	L
DRA18 (Light load)	132 lbs	7.874 in	0.68 lbs	0.709	1.260 ~ 1.693
		11.811 in	1.01 lbs		
DRA20 (Light load)	165 lbs	7.874 in	0.79 lbs	0.787	1.260 ~ 1.693
		11.811 in	1.17 lbs	0.866 0.945	
DRA30 (Heavy load)	330 lbs	7.874 in	1.65 lbs	1.102	1.732 ~ 2.283
		11.811 in	2.49 lbs	1.260 1.417	



■ Working temperature range : 32~230°F

DIMENSIONS (Unit : inch)



- Select requested total length in combinations of 7.874 inches and 11.811 inches Die-Lifting Rollers.
- Roller-top level can be adjusted by height-adjustment bolts to meet T/U-Slot depth.
- Lock the height adjustment bolts with lock nuts after adjusting height.
- Lifting force can be reduced by removing the height-adjustment bolts. The bolts at both ends of the die-lifting rollers should not be removed.
- Lifting force per one spring/bolt : Model DRA18 ... 66.1 lbs, DRA20 ... 82.7 lbs, DRA30 ... 165.3 lbs

MAXIMUM LIFTING FORCE PER PAIR ROLLERS

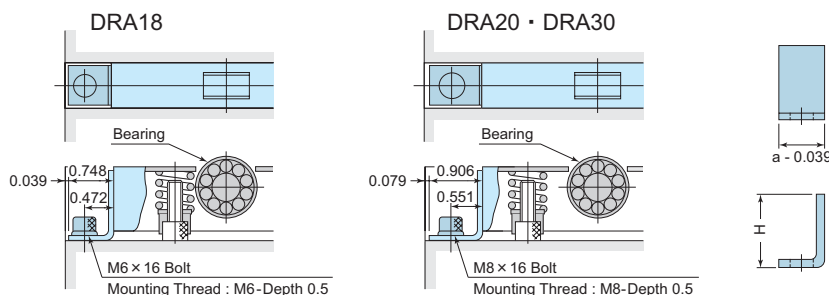
(lbs)

Overall Length (in)	9.843	13.780	17.717	21.654	25.591	29.528	33.465	37.402	41.339	45.276	49.213	53.150	57.087	61.024
※DRA18	528	792	1056	1320	1584	1848	2112	2376	2640	2904	3168	3432	3696	3960
DRA20	660	990	1320	1650	1980	2310	2640	2970	3300	3630	3960	4290	4620	4950
DRA30	1320	1980	2640	3300	3960	4620	5280	5940	6600	7260	7920	8580	9240	9900

※ Overall length of Model DRA18 is 0.394 inches shorter than above lengths.

END PLATE

MODEL DRL
(L Stopper)



Model	a	H
DRL-18L	0.709	1.260
DRL-18H	0.709	1.693
DRL-20L	0.787	1.260
DRL-20H	0.787	1.693
DRL-22H	0.866	1.693
DRL-24H	0.945	1.693
DRL-28L	1.102	1.772
DRL-28H	1.102	2.283
DRL-32H	1.260	2.283
DRL-36H	1.417	2.480

Cut the end plate 0.02 inches shorter than the depth of the T/U-slot.