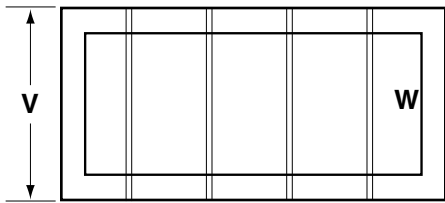


# HOW TO DETERMINE AVAILABLE DIE LIFTER RAIL OPTIONS

- List out die sizes and weights. Calculate die load per foot, per pair of lift rails. **(W=WIDTH IN FEET)**



Die 1 Weight \_\_\_\_\_ ÷ W = \_\_\_\_\_ lbs./ft./pair

Die 2 Weight \_\_\_\_\_ ÷ W = \_\_\_\_\_ lbs./ft./pair

Die 3 Weight \_\_\_\_\_ ÷ W = \_\_\_\_\_ lbs./ft./pair

Determine heaviest die per foot.

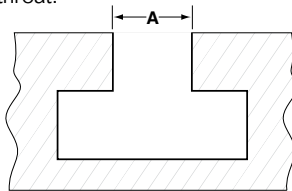
Heaviest die density lb./ft./pair = \_\_\_\_\_

- Measure T-Slot or Rectangular channel throat.

If A = .800 to 1.000, use Narrow Rails

If A = 1.000 to 1.25, use Wide Rails

If A = <.800 or >1.25, contact PFA



- For the heaviest die, check the number of available slots under the die:

Number of available slots = \_\_\_\_\_

- Take the die density from Part 1 and find the closest larger lbs./ft./pair from the chart below. Then move across the top to find your desired die lifter style keeping in mind the Narrow or Wide from Part 2 and the number of available slots from Part 3.

- Record the rail model number and number of needed rails from the chart:

Model \_\_\_\_\_ Quantity \_\_\_\_\_

Model \_\_\_\_\_ Quantity \_\_\_\_\_

Model \_\_\_\_\_ Quantity \_\_\_\_\_

- Select the Model you desire from the chart on page 13:

\_\_\_\_\_

- For the selected model, confirm that the number of rails always supports the dies as follows:

| W<br>ft. | Chart<br>lbs./ft./pair | No. of<br>Rails | Lift<br>Capacity | Weight<br>lbs |
|----------|------------------------|-----------------|------------------|---------------|
|----------|------------------------|-----------------|------------------|---------------|

Die 1 \_\_\_\_\_ x \_\_\_\_\_ x \_\_\_\_\_ ÷ 2 = \_\_\_\_\_ > \_\_\_\_\_

Die 2 \_\_\_\_\_ x \_\_\_\_\_ x \_\_\_\_\_ ÷ 2 = \_\_\_\_\_ > \_\_\_\_\_

Ensure lift capacity is greater than die weight.

- Use the Model Number and Bolster Length (V) to determine the rail length desired (see page 13). Lifter will be flush with the loading side and should be near the back side but less than length (V). (Continue with Step 9)

| DIE DENSITY<br>(lbs./ft./pair) | NARROW SLOT                                       |   | WIDE SLOT                                 |   |   |
|--------------------------------|---|---|---|---|---|
|                                | BALL ROLLERS<br>317N/318N<br>(1,800 lbs./ft./pr.) | CYLINDER ROLLERS<br>315N/316N<br>(1,800 lbs./ft./pr.) | BALL<br>317W/318W<br>(2,150 lbs./ft./pr.) | ROLLERS<br>315W/316W/322W<br>(4,000 lbs./ft./pr.) | HEAVY DUTY ROLLERS<br>327W/328W<br>(9,000 lbs./ft./pr.) |
| 1,800                          | 2 Rails   | ---   | 2 Rails                                   | ---   | ---   |
| 2,150                          | 3 Rails   | 2 Rails   | 2 Rails                                   | 2 Rails   | ---   |
| 2,700                          | 3 Rails   | 2 Rails   | 3 Rails                                   | 2 Rails   | ---   |
| 3,225                          | 4 Rails   | 2 Rails   | 3 Rails                                   | 2 Rails   | ---   |
| 3,600                          | 4 Rails   | 2 Rails   | 4 Rails                                   | 2 Rails   | ---   |
| 4,000                          | 5 Rails   | 2 Rails   | 4 Rails                                   | 2 Rails   | ---   |
| 4,300                          | 5 Rails   | 3 Rails   | 4 Rails                                   | 3 Rails   | 2 Rails   |
| 4,500                          | 5 Rails   | 3 Rails   | 5 Rails                                   | 3 Rails   | 2 Rails   |
| 5,500                          | 6 Rails   | 3 Rails   | 5 Rails                                   | 3 Rails   | 2 Rails   |
| 6,000                          | ---   | 3 Rails   | 6 Rails                                   | 3 Rails   | 2 Rails   |
| 6,500                          | ---   | 4 Rails   | 6 Rails                                   | 4 Rails   | 2 Rails   |
| 8,000                          | ---   | 4 Rails   | ---                                       | 4 Rails   | 2 Rails   |
| 9,000                          | ---   | 5 Rails   | ---                                       | 5 Rails   | 2 Rails   |
| 10,000                         | ---   | 5 Rails   | ---                                       | 5 Rails   | 3 Rails   |
| 12,000                         | ---   | 6 Rails   | ---                                       | 6 Rails   | 3 Rails   |
| 14,000                         | ---   | 8 Rails   | ---                                       | 7 Rails   | 4 Rails   |