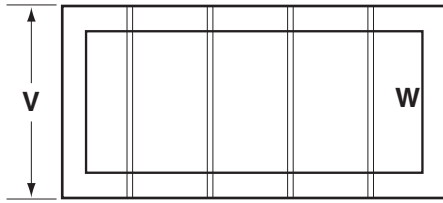


HOW TO DETERMINE AVAILABLE DIE LIFTER RAIL OPTIONS

- 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.

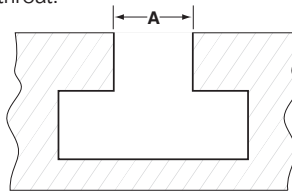
Heaviest die density lb./ft./pair = _____

- 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. (*Assume 85psi air available)

| DIE DENSITY (lbs./ft./pair) | NARROW SLOT 948N (1,800 lbs./ft./pr.) | WIDE SLOT 948W (2,600 lbs./ft./pr.) |
|--------------------------------|---|---|
| 1,800 | 2 Rails | 2 Rails |
| 2,600 | 3 Rails | 2 Rails |
| 3,600 | 4 Rails | 3 Rails |
| 3,900 | 5 Rails | 3 Rails |
| 4,500 | 5 Rails | 4 Rails |

For larger die weights or fewer available slots mechanical or hydraulic die lifters are recommended.

Example:

| Rail Style Model | Length (L) | Tab Height (T) | Neck Width (W) | Lifter Height (H) | Filler Length (F) |
|------------------|---|----------------|----------------|-------------------|-------------------|
| PR948N PR948W | 12, 18, 24, 30, 36, 42, 48, 54, 60, 66, 72 | .XXX | .0800 or 1000 | H.HHH | F.FFF or NONE |
| PR948W | 36 | XXX | 1000 | HHHH | FFFF |

Part No: **PR948W36-375-1000-1500-NONE**

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

Model _____ Quantity _____

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

W ft. Chart lbs./ft./pair No. of Rails Lift Capacity Weight lbs

Die 1 _____ x _____ x _____ ÷ 2 = _____ > . _____

Die 2 _____ x _____ x _____ ÷ 2 = _____ > . _____

Ensure lift capacity is greater than die weight.

- With model number and quantity determined, select the rail length desired. Lifter will be flush with the loading side and should be near the back side but not longer than the bolster slot. Nominal lengths are 12", 18", 24", 30", 36", 42", 48", 54", 60", 66", 72", + + + Length = _____

If slot is longer than nominal, add filler bar length

to end of part number. Filler = _____

- Finally, the profile and final shape of the rail must be calculated below.

HOW TO SIZE A "T" SLOT:

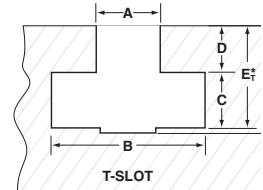
- Measure Neck Height (D), Full Width Depth (E_T) and B:

D = _____

E_T = _____

B = _____

C = E_T - D = _____



- Determine Nominal Lift (N)

Typically N = .085" or .125" (1/8" max)

Choose N = _____

- Calculate Tab Height (T)

T = C - N - .250" = _____ (.xxx)

- Calculate Rail Height (H)

H = E_T - .250 = _____ (H.HHH)

For Narrow Rail (.800 < A < 1.00) confirm slot fit

B ≥ 1.300" C ≥ .500" E_T ≥ 1.250"

For Wide Rail (1.00 < A < 1.25) confirm slot fit

B ≥ 1.700" C ≥ .575" E_T ≥ 1.300"