

STATIONARY SPRING LOADED DIE LIFTER RAILS

HOW TO DETERMINE AVAILABLE DIE LIFTER RAIL OPTIONS

1. 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 = _____

2. 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

3. For the heaviest die, check the number of available slots under the die: Number of available slots = _____

4. Take the die density from Part 1 and find the closest larger lbs./ft./pair in the chart to the right. Then move across the chart to find the minimum number of slots, keeping in mind the Narrow or Wide from Part 2 and the number of available slots from Part 3. If your application does not support the number of slots needed, see page 11 (Hydraulic Die Lifters/Rollers) or call PFA for assistance.

5. Record the rail model number and number of needed rail slots from the chart:

Model _____ No. of Slots _____

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

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

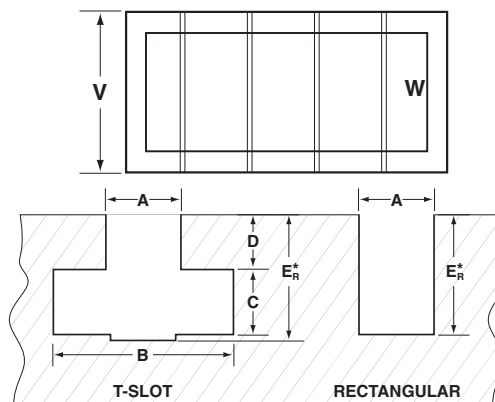
Die 1 _____ x _____ x _____ ÷ 2 = _____ > _____

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

Ensure lift capacity is greater than die weight.

8. Use the Model Number and Bolster Length (V) to determine the slot length to fill. Lifters should start at the loading side of the bolster and end near the other side for maximum versatility.

9. Use slot dimensions to determine rail part numbers. Use of multiple 10" or 12" rail sections versus one long rail is recommended to take advantage of stock parts and flexible installations.



DIE DENSITY (lbs./ft./pair)	NARROW SLOT	WIDE SLOT
	357N (1,800 lbs./ft./pr.)	357W (2,000 lbs./ft./pr.)
1,800	2 Rail Slots	2 Rail Slots
2,000	3 Rail Slots	2 Rail Slots
2,700	3 Rail Slots	3 Rail Slots
3,000	4 Rail Slots	3 Rail Slots
3,600	4 Rail Slots	4 Rail Slots
4,000	5 Rail Slots	4 Rail Slots

Length (in)	357N Max Load Capacity (each section)	357W Max Load Capacity (each section)	Ball Rollers (each section)
10	800 lbs.	920 lbs.	8
12	900 lbs.	1035 lbs.	9

Other sizes available. Please contact PFA for details.

Example:
3/4" slot with Depth = 1.520"

Style	Model No.	Length	Rail Height*	Rail Width
MR	357N 357W	inches	$E_R = X.XXX$	Narrow = 0.800" std Width = 1.000 std
MR-357N		10-1520		0800

Part No: **MR-357N10-15200800**

*357N E_R min. = 1.30"; E_R max. = 2.0" std.
357W E_R min. = 1.75"; E_R max. = 2.0" std.