

TRAVELING & SLOTLESS BOLSTER EXTENSIONS

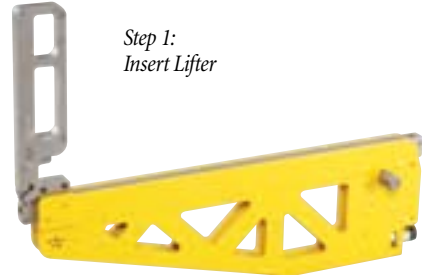
Traveling and Slotless Bolster Extensions are unique versions of our standard lift off bolster extensions. As lift-offs, they provide for easy removal during press operations and allow a single pair to be used for multiple presses. They are unique because the traditional rollers are replaced with a slot or channel, very similar to that in the bolster itself. These slots are used with our Model 706 Mechanical Die Lifters (See page 25) to move dies from the bolster extension into the press via one of two methods:

Traveling Bolster Extensions. The first method is named after the ability of the die lifter to “travel” from the bolster extension into a slot in the bolster. The Traveling Bolster Extension Model 522 is mounted using the Model 913 Mounting Bracket so the channel or slot bottom of the bolster extension lines up with the bottom of the shimmed slot in the bolster. With proper alignment and shimming of the slot, the Model 706 travels easily from the extension into the bolster slot. In cases of cutouts in the bolster, an optional “Bridge” shim can often be used to shim the slot, making use of the mechanical die lifter possible in those situations. After die insertion, both the mechanical die lifter AND the bridge shim can be removed to allow normal die operation. If a bridge is use, a “B” is added to the model number, as in 522B.

Slotless Bolster Extensions. The second method is named because of the lack of slots in the bolster on which these are used. Moving dies easily into a press without slots or slots in the “non-preferred” direction has always been a particular challenge for implementing Quick Die Change. With the Model 530 Slotless Bolster Extensions, however, moving a die into a slotless press is fast and easy. The extensions are mounted using the Model 916 Mounting Bracket so the channel or slot bottom of the bolster extension lines up with the to surface of the bolster. Dies are modified with parallels or spaces are added between parallels to provide for a gap between the bolster and die surface of 1.520”-1.530”, which allows proper clearance for the Model 706 Mechanical die lifter to both lift the die and be removable after die change.



Step 1:
Insert Lifter



Step 2:
Lifter Fully Under Die



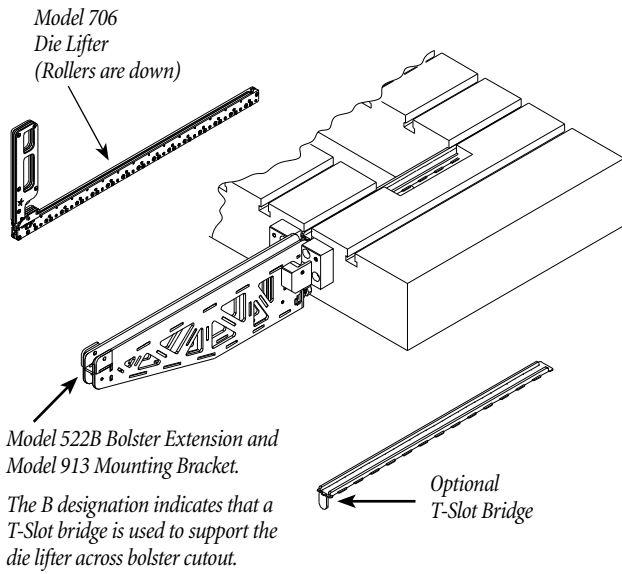
Step 3:
Lift Die with Handle



Step 4:
Move Die Into Press

TRAVELING BOLSTER EXTENSIONS

Models 522 and 522B



The B designation indicates that a T-Slot bridge is used to support the die lifter across bolster cutout.

Model No.	A	B	Weight
522	14"	6.00"	15 lbs.
	16"	6.00"	20 lbs.
	20"	8.00"	25 lbs.
	24"	8.00"	35 lbs.
	28"	8.00"	40 lbs.
	32"	8.00"	45 lbs.
	36"	10.00"	60 lbs.
	40"	10.00"	65 lbs.

530	14"	6.00"	15 lbs.
	16"	6.00"	20 lbs.
	20"	8.00"	25 lbs.
	24"	8.00"	35 lbs.
	28"	8.00"	40 lbs.
	32"	8.00"	45 lbs.
	36"	10.00"	60 lbs.
	40"	10.00"	65 lbs.

Example:

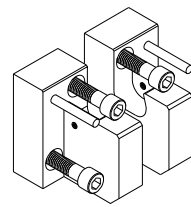
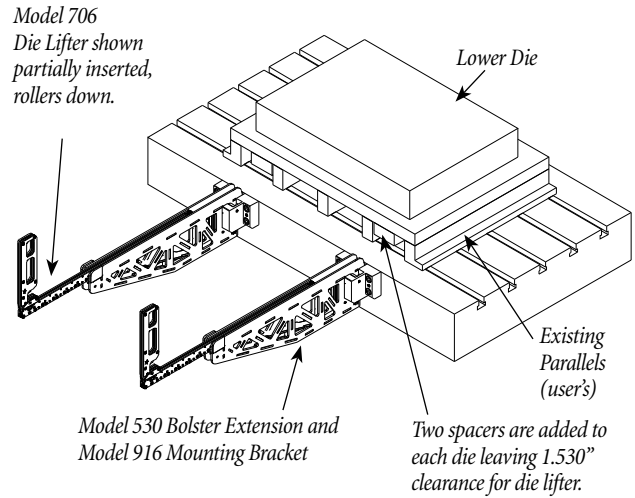
Style	Model Number*	Narrow/Wide (N or W)	Length (A)
BE	522	W	24

Part No: **BE-522W-24**

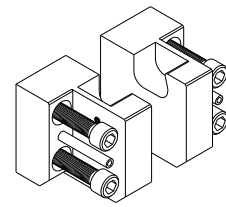
*For Bridge in T-Slot applications, add a "B" to the Model Number. Contact PFA for application assistance.

SLOTTLESS BOLSTER EXTENSIONS

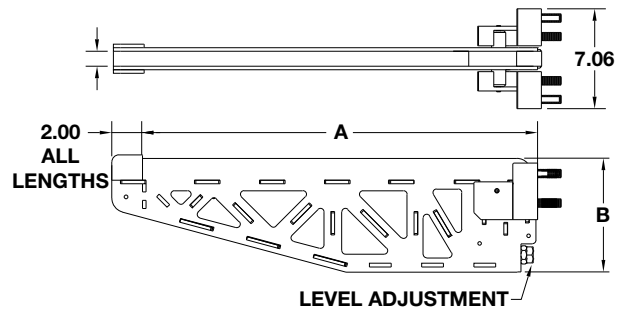
Model 530 for Bolsters *without* slots for die Lifters



Model 913N/913W Mounting Bracket



Model 916N/916W Mounting Bracket



PFA recommends machining or shimming slots to 1.525" - 1.530" for a die lift of approximate .060".

