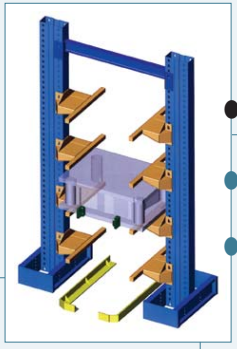
ROTOBLOC-PSP

GROUPE DIMECO



- Quick die change system
- Die handling and storage
- Quick coil change

Rue de la Louvière - Z.I.
25480 PIREY - FRANCE

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Fax +33 3 81 53 80 80
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contact@rotobloc-psp.com

OUR PROGRAMME : 3 departments

Quick tool change

ROTOBLOC-PSP
GROUPE DIMECO

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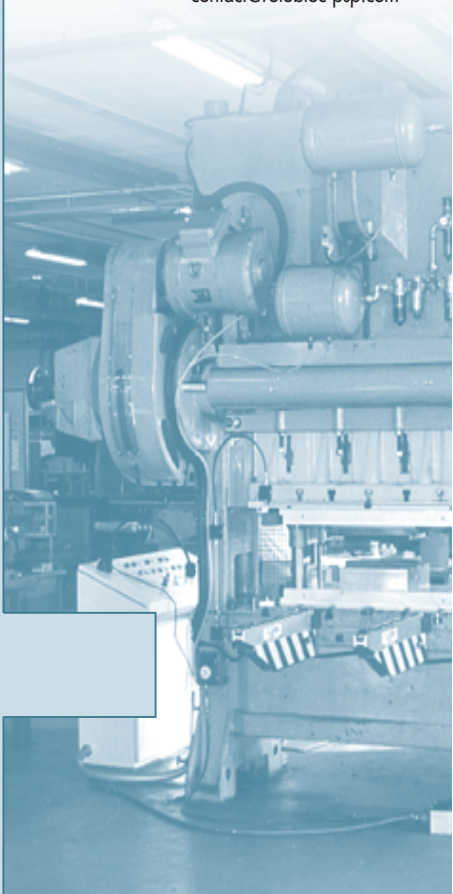
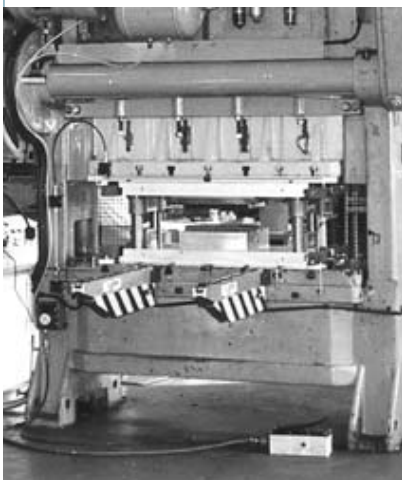


DETACHABLE TOOL CHANGE RAILS : counterbalanced

TCF

ROTOBLOC-PSP GROUPE DIMECO

Dimensions and data subject to amendment

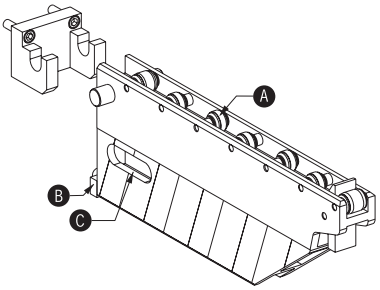


APPLICATION

TCF detachable tool change rails are used to change tools on press tables safely and quickly. Light and easy to handle, they are quick to install or to remove from different sites thanks to their quick-fastening system.

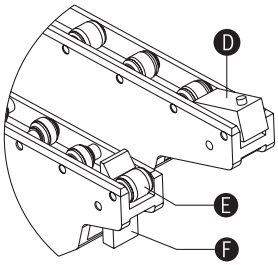
DESCRIPTION

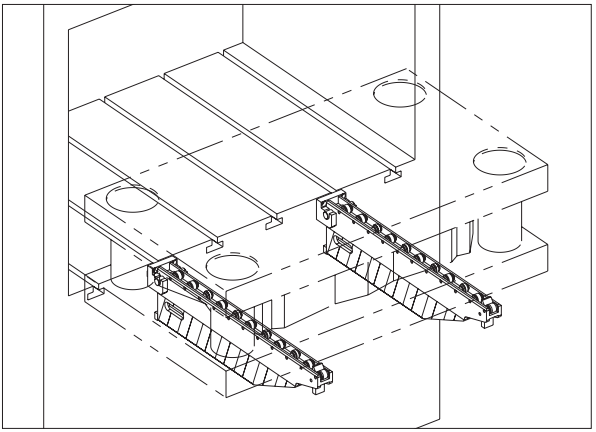
Built from a strong treated alloy section and of high mechanical quality, their movement plane is constituted by compact bearing modules (A). These modules are of the combined needle roller type for heavy loads and the standard roller type for normal loads.
Gripping openings (C) allow a quick and easy handling. The frontal support zone has an adjustable thrust (B) to allows an accurate adjustment of the levelling of the movement plane upon initial installation.
The ends of the arms are equipped with an additional bearing module (E), and this unique design allows tools to be moved smoothly from the handling equipment.
A retractable stop (F) automatically adopts a safety position when a tool is passing through. For high-mass (or Heavy) tools, a progressive ramp stop (D) replaces the retractable stop; this allows the tool to stop without impact.
The choice of these stops may be optional.



ASSEMBLY & USE

The tool change rails are used exclusively in pairs and are positioned and held in place at the front of the press table with the assistance of a set of threaded brackets. Different sets of brackets are available, depending upon the tool change rails and upon requirements. Please see tool change rails page for definition and options.
Tools are moved manually or with the assistance of a motorised unit. The force required for movement depends upon the mass of the tool, its material and the quality of the surface finish. An average rolling friction coefficient is quoted in the specifications for the purpose of evaluating that force.
All the load values are given for static working conditions and are uniformly distributed per pair of tool change rails. Please abide by and reduce laying down speeds as much as possible in order to avoid impact that may engender dynamic overloads. Please see specifications.



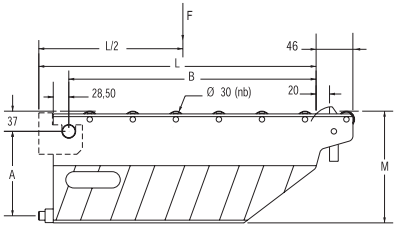


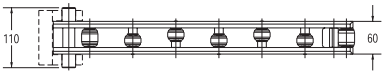
DETACHABLE TOOL CHANGE RAILS : with cantilever

TCF

ROTOBLOC-PSP GROUPE DIMECO

Dimensions and data subject to amendment





GENERAL TCF USER SPECIFICATIONS

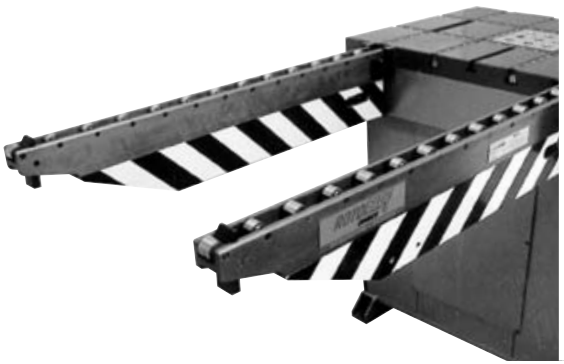
Rolling friction coefficient: 0.03 for steel tools with a surface finish of Ra = 3.2
Admissible tool laying down speed < 20 mm/sec.
Loads F Static uniformly distributed between 2 tool change rails
Admissible temperature < 60.c

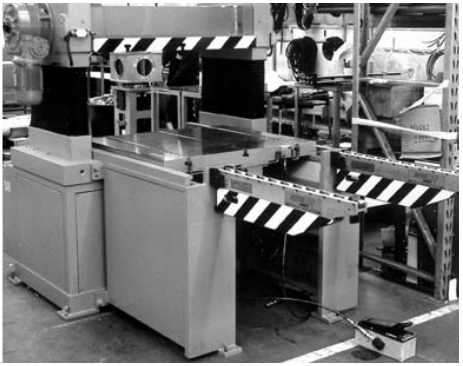
Example of travel force calculation:
Tool mass = 1000 kg, steel material, Ra = 3.2
Rolling friction coefficient = 0.03

Approximate travel force : 1000 x 0.03 = 30 kg (30 daN)

To order : *Quote the full reference details of the pair of tool change rails*
e.g.: TCF 1/800
(Pair of tool change rails capacity 1000 kg & working length of 800 mm.).

Models	A mm	B mm	F/Pair kg	M mm	L mm	Nb	Weight kg/pair
TCF 05/300	155	254	500	205	309	5	12
TCF 05/500	155	455	500	205	509	7	18
TCF 05/800	155	755	500	205	809	11	28
TCF 05/1000	155	955	500	205	1009	13	36
TCF 1/500	155	455	1000	205	509	7	18
TCF 1/800	155	755	1000	205	809	11	29
TCF 1/1000	155	955	1000	205	1009	13	37
TCF 2/500	155	455	2000	205	509	7	18
TCF 2/800	155	755	2000	205	809	11	29
TCF 2/1000	155	955	2000	205	1009	13	37
TCF 2/1250	155	1205	2000	205	1259	16	47
TCF 3/800	155	750	3000	205	805	10	29
TCF 3/1000	355	950	3000	405	1005	12	54
TCF 3/1250	355	1200	3000	405	1254	15	71





ROTATING TOOL CHANGE RAILS

TCRF

ROTOBLOC-PSP GROUPE DIMECO

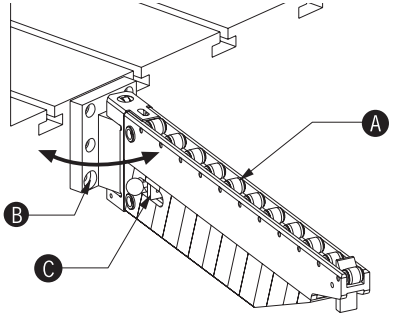
Dimensions and data subject to amendment

APPLICATION

TCRF tool change rails are used to load tools onto press tables safely and quickly. They are permanently fixed to the front of press tables with the assistance of rotating brackets. They can adopt two set positions, the working position and the sliding position that allows complete access to the front of the press.

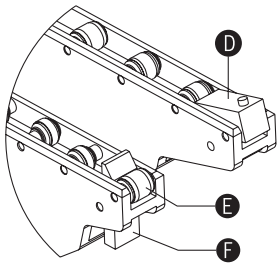
DESCRIPTION

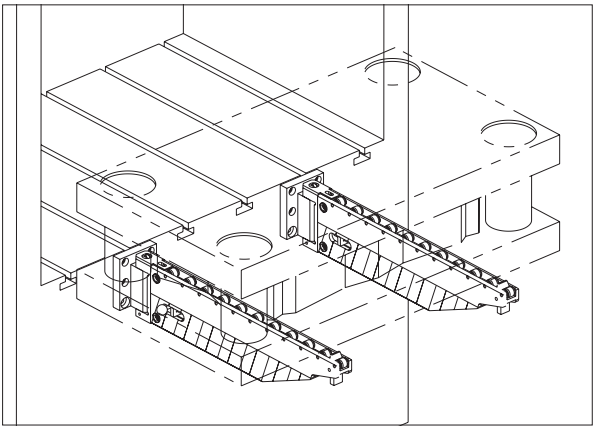
Made from a strong treated alloy section and of high quality mechanically, their movement plane is constituted by compact bearing modules (A). These units are of the combined needle roller type for heavy loads and the standard roller type for normal loads. An indexing lever (C) allows for effective locking and rapid unlocking of the arm so that you can obtain the positions desired. The frontal support zone of the bracket has an adjustment thrust (B) and this allows for accurate adjustment when levelling the plane of movement upon initial installation. The ends of the tool change rails are equipped with an additional bearing module (E) and this unique characteristic allows tools to be moved smoothly from the handling equipment.
A retractable stop (F) takes up an automatic safety position when a tool is being moved. For high-mass tools, a progressive ramp stop (D) replaces the retractable stop; this allows the tool to stop without impact.
The choice of these stops may be optional.



ASSEMBLY & USE

The tool change rails are used exclusively in pairs and are positioned and held in place (or fixed) at the front of the press tables with the assistance of a set of screwed plates. The arms can be swapped from the right to the left, without distinction.
Tools are moved manually or with the assistance of a motorised unit. The force required for movement depends upon the mass of the tool, its material and the quality of the surface finish. An average rolling friction coefficient is quoted in the specifications for the purpose of evaluating that force.
All the load values are given for static working conditions and are uniformly distributed per pair of tool change rails. Please abide by and reduce laying down speeds as much as possible in order to avoid impacts that may engender dynamic overloads. Please see specifications.



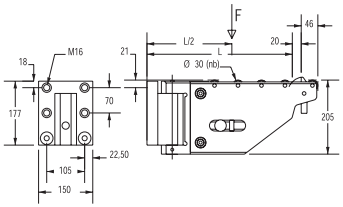


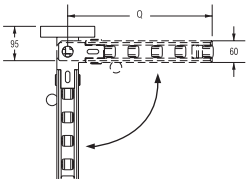
ROTATING TOOL CHANGE RAILS

TCRF

ROTOBLOC-PSP GROUPE DIMECO

Dimensions and data subject to amendment





GENERAL TCRF USER SPECIFICATIONS

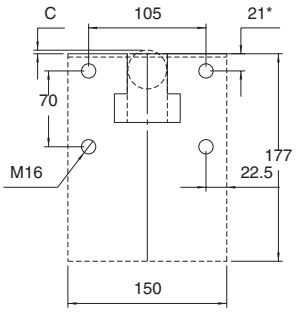
Rolling friction coefficient: 0.03 for steel tools with a surface finish of Ra = 3.2
Admissible tool laying down speed < 20 mm/sec.
Loads F Static uniformly distributed between 2 tool change rails
Admissible temperature < 60.c

Example of travel force calculation:
Tool mass = 1000 kg, steel material, Ra = 3.2
Rolling friction coefficient = 0.03

Approximate travel force
1000 x 0.03 = 30 kg (30 daN)

To order : *Quote the complete reference of the pair of tool change rails*
e.g.: TCF 1/900
(Pair of tool change rails capacity 1000 kg & working length of 900 mm.).

Models	F kg	L mm	Q mm	Nb	Weight kg/pair
TCRF 05/400	500	400	402	5	56
TCRF 05/600	500	600	602	7	63
TCRF 05/900	500	900	902	11	88
TCRF 05/1100	500	1100	1102	13	104
TCRF 1/600	1000	600	602	7	65
TCRF 1/900	1000	900	902	11	88
TCRF 1/1100	1000	1100	1102	13	104
TCRF 2/900	2000	900	902	11	88
TCRF 2/1100	2000	1100	1102	13	104
TCRF 3/900	3000	900	902	11	88

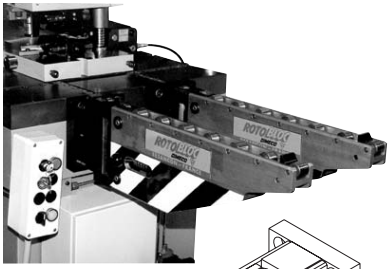


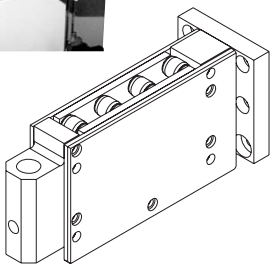
*: If rotobilles or transrollers, reduce dimension of C.

ROTATING BRACKETS

BER

Dimensions and data subject to amendment





APPLICATION

Articulated BER brackets are designed to keep the coupling point away from the edge of the press table.

DESCRIPTION

- *Made from steel;*
- *Upper plane equipped with heavy cage bearings and combined needle rollers;*
- *Front end does not articulate with connecting plate (identical to TCRF tool change rails with which it is assembled);*
- *Rear end with bored bushing for the shaft of TCRF bracket with which it is assembled;*

ASSEMBLY

Only as option: TCRF-type support tool change rails.
N.B.: BERs are supplied by the unit.

EXAMPLE

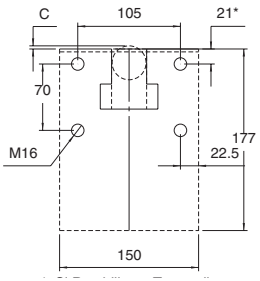
- *Assembly with one tool change rails in order to allow two TCRF arms to be positioned one on above the other.*
- *Assembly with two TCRF tool change rails (a pair) in order to allow you to direct them at a 90° outwards angle, "escaping" the press frame.*

CAPACITIES

The admissible load is the one of the tool change rails with which they are assembled. The admissible length is the one of the tool change rails + the length L.

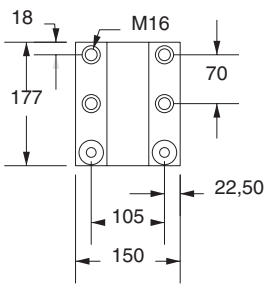
N.B.

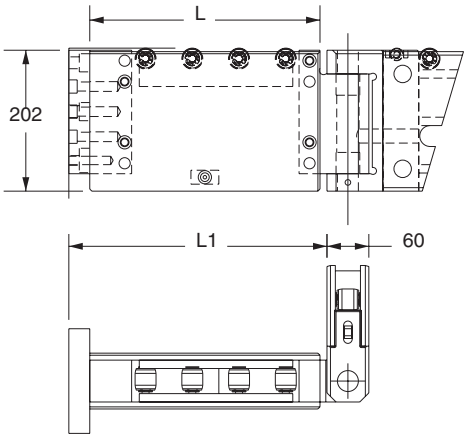
TCRF tool change rails retain their characteristics when they are assembled with BER articulated brackets.



*: If rotobilles or transrollers, reduce dimension of C.

Models	L of BERs
BER 130	*130*
BER 230	*230*
BER 330	*330*
BER 430	*430*



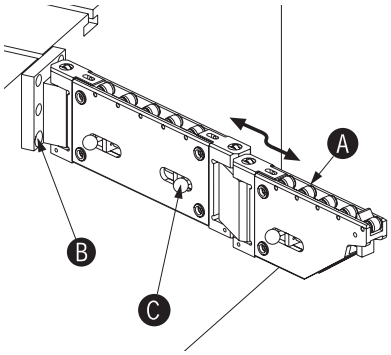


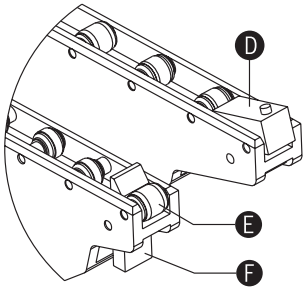
ARTICULATED TOOL CHANGE RAILS

TCAF

ROTOBLOC-PSP GROUPE DIMECO

Dimensions and data subject to amendment





APPLICATION

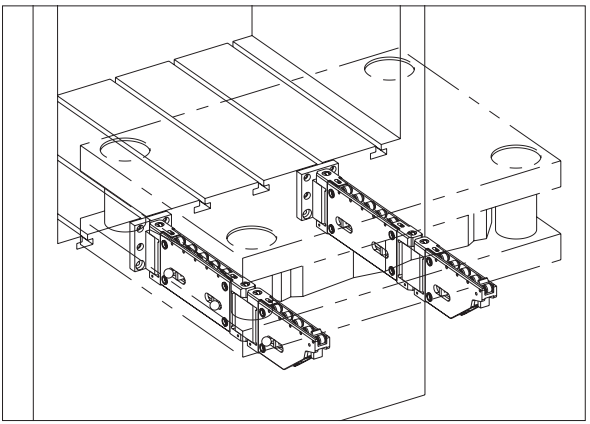
TCAF tool change rails are used to load tools onto press tables safely and quickly. They are permanently attached to the front of a press table with rotating brackets. They can adopt two set positions, the working position and the slide position, which allows complete access to the front of the press.

DESCRIPTION

Built from a strong treated alloy section and of high quality mechanically, their movement plane is constituted by compact bearing modules (A).
These modules are of the combined needle roller type for heavy loads and the standard roller type for normal loads.
An indexing lever (C) allows for effective locking and rapid unlocking of the tool change rails so that you can obtain the positions desired. The frontal support zone of the bracket has an adjustment thrust (B) and this allows for accurate adjustment when levelling the plane of movement upon initial installation. The ends of the tool change rails are equipped with an additional bearing module (E) and this unique characteristic allows tools to be moved smoothly from the handling equipment.
A retractable stop (F) automatically takes up a safety position when a tool is being moved. For high-mass tools, a progressive ramp stop (D) replaces the retractable stop; this allows the tool to stop without impact.
The choice of these stops may be optional.

ASSEMBLY & USE

The tool change rails are used exclusively in pairs and are positioned and held in place at the front of the press tables with the assistance of a set of threaded bracket. The tool change rails can be slid to the right or to the left, without distinction.
Tools are moved manually or with the assistance of a motorised unit. The force required for movement depends upon the mass of the tool, its material and the quality of the surface finish. An average rolling friction coefficient is quoted in the specifications for the purpose of evaluating that force.
All the load values are given for static working conditions and are uniformly distributed per pair of tool change rails. Please abide by and reduce laying down speeds as much as possible in order to avoid impact that may engender dynamic overloads. Please see specifications.

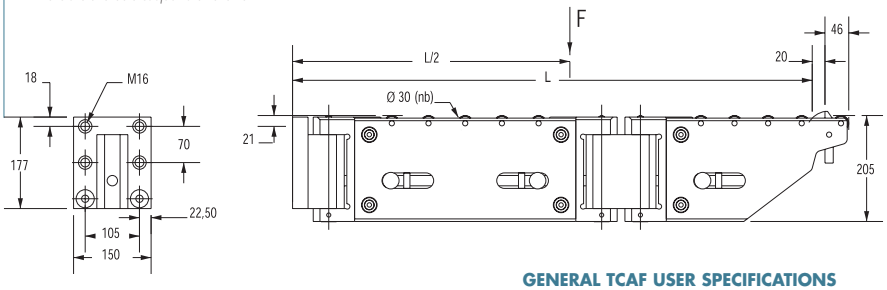


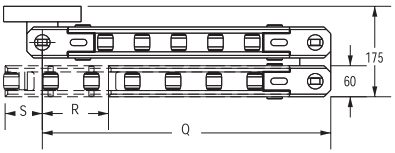
ARTICULATED TOOL CHANGE RAILS

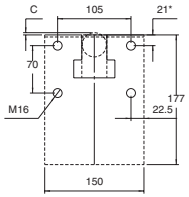
TCAF

ROTOBLOC-PSP GROUPE DIMECO

Dimensions and data subject to amendment







*: If rotobilles or transrollers, reduce dimension of C.

GENERAL TCAF USER SPECIFICATIONS

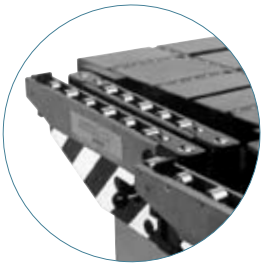
Rolling friction coefficient : 0.03 for steel tools with a surface finish of Ra = 3.2
Admissible tool laying down speed < 20 mm/sec.
Loads F Static uniformly distributed between 2 tool change rails
Admissible temperature < 60.c

Example of travel force calculation:
Tool mass = 1000 kg, steel material, Ra = 3.2
Rolling friction coefficient = 0.03

Approximate travel force
1000 x 0.03 = 30 kg (30 daN)

To order :
Quote the complete reference of the pair of tool change rails
e.g.: TCAF 1/1000
(Pair of tool change rails capacity 1000 kg & working length of 1000 mm.).

Models	F kg	L mm	Q mm	R mm	S mm	Nb	Weight kg/pair
TCAF 05/1000	500	1005	558	128		13	100
TCAF 1/1000	1000	1005	558	128		13	100
TCAF 2/1000	2000	1005	558	128		13	100
TCAF 2/1200A	2000	1205	558		72	15	104
TCAF 2/1200B	2000	1205	758	328		16	104



DETACHABLE TOOL CHANGE RAILS : with supporting leg

TCP

ROTOBLOC-PSP GROUPE DIMECO

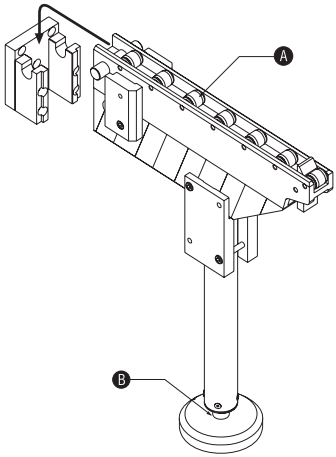
Dimensions and data subject to amendment

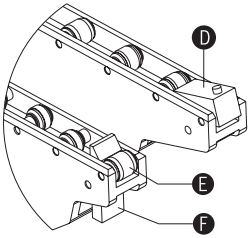
APPLICATION

TCP tool change rails are used to load tools onto press tables safely and quickly. Designed for very long tools, they are equipped with an end leg with sole plate. Optionally, a leg with castor may be used in order to move tool change rails quickly and easily between multiple sites or to place them in storage until needed.

DESCRIPTION

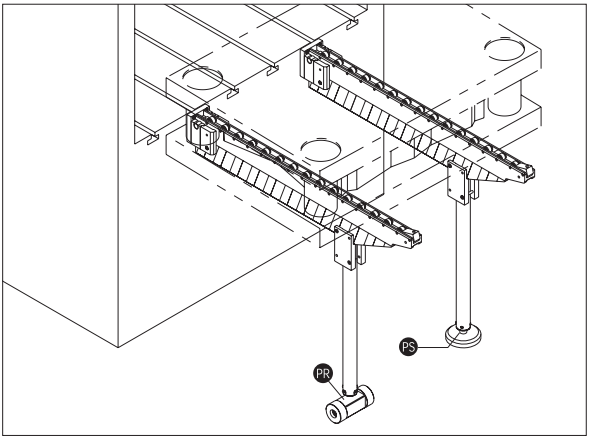
Built from a strong treated light alloy section and of high quality mechanically, their movement plane is constituted by compact bearing modules (A).
These units are of the combined needle roller type for heavy loads and the standard roller type for normal loads.
Gripping pockets allow for quick and easy handling. At the base of each leg is a fine adjustment mechanism (B) that allows for accurate setting of the level of the movement plane upon initial installation. When ordering, you need to indicate the height, H, of the press bed above the ground. The ends of the tool change rails are equipped with an additional bearing module (E) and this unique characteristic allows tools to be moved smoothly from the handling equipment.
A retractable stop (F) automatically takes up a safety position when a tool is being moved. For high-mass tools, a progressive ramp stop (D) replaces the retractable stop; this allows the tool to stop without impact.
The choice of these stops may be optional.





ASSEMBLY & USE

The tool change rails are used exclusively in pairs and are positioned and held in place at the front of the press tables with the assistance of a set of threaded pins. The brackets can be slid to the right or to the left, without distinction.
Tools are moved manually or with the assistance of a motorised unit. The force required for movement depends upon the mass of the tool, its material and the quality of the surface finish. An average rolling friction coefficient is quoted in the specifications for the purpose of evaluating that force.
All the load values are given for static working conditions and are uniformly distributed per pair of tool change rails. Please abide by and reduce laying down speeds as much as possible in order to avoid impact that may engender dynamic overloads. Please see specifications.

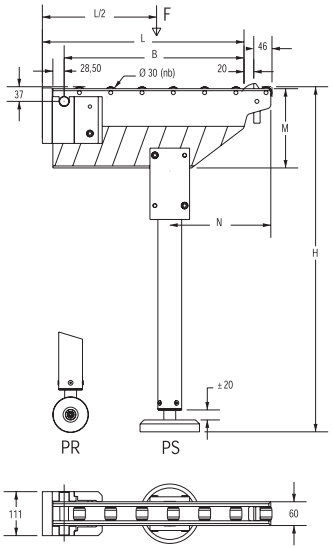


DETACHABLE TOOL CHANGE RAILS with supporting legs

TCP

ROTOBLOC-PSP GROUPE DIMECO

Dimensions and data subject to amendment



GENERAL TCF USER SPECIFICATIONS

Rolling friction coefficient: 0.03 for steel tools with a surface finish of Ra = 3.2
Admissible tool laying down speed < 20 mm/sec.
Loads F Static uniformly distributed between 2 tool change rails
Admissible temperature < 60.c

Example of travel force calculation:
Tool mass = 1000 kg, steel material, Ra = 3.2
Rolling friction coefficient = 0.03

Approximate travel force
2000 x 0.03 = 60 kg (60 daN)

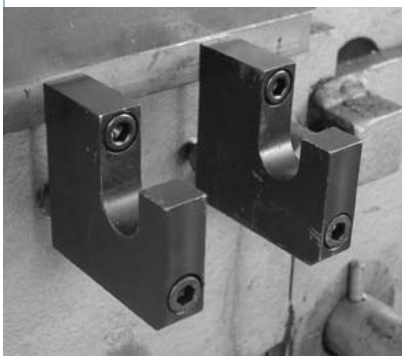
To order:

Quote the complete reference of the pair of tool change rails and the leg type:
PR = leg with castor
PS = leg with soleplate
Specify the height, H, in mm. of table / ground.

e.g.: TCP 2 / 1250-PR-H800
Pair of tool change rails capacity 2000 kg, working length of 1250 mm., leg with castor + table height = 800 mm.

Models	B mm	F kg	M mm	L mm	H min. mm	N mm	Nb	Weight kg/pair
TCP 2/1250	1204	2000	205	1259	455	400	16	71
TCP 2/1600	1554	2000	205	1009	455	400	21	83
TCP 2/2000	1954	2000	205	2009	455	400	26	96
TCP 4/1000	954	4000	205	1009	455	400	13	61
TCP 4/1250	1204	4000	205	1259	455	400	16	71
TCP 4/1600	1554	4000	205	1609	455	400	21	84
TCP 4/2000	1954	4000	205	2009	455	400	26	97
TCP 6/1250	1200	6000	205	1255	455	400	16	71
TCP 6/1600	1550	6000	205	1605	455	400	21	84
TCP 6/2000	1950	6000	405	2005	655	400	26	148
TCP 6/2500	2450	6000	405	2505	655	400	32	180

ACCESSORIES: TCF/TCP tool change rails brackets



APPLICATION

BF brackets are used to attach TCF and TCP-type tool change rails.
Several types exist (BF1, BF2, BF3 and BFR and BSR) depending upon the tool change rails for which they are intended.

ASSEMBLY & USE

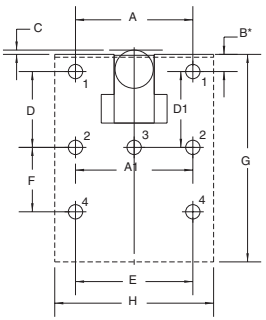
The brackets are screwed onto the front of the press tables and allow for quick assembly and dismantling of TCF and TCP tool change rails.
Table 2 shows the bulk and mounting dimensions of the different brackets.

To order:

- Choose the set of brackets from the table according to the tool change rails type
- Specify the complete reference number for the set of brackets.
E.g.:
BF 3 set of brackets (BF3 brackets for TCF 3-type tool change rails).

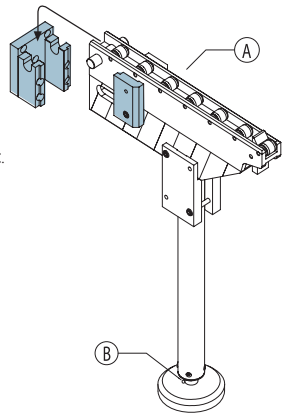
Models	A	A1	B	D	D1	E	F	G	H	Threads	Item Nos.
BF 1	*82*	*82*	*13*	*53*	*53*			*80*	*110*	*M10 x 40*	*1 – 2*
BF 2	*82*	*82*	*13*	*53*	*53*			*80*	*110*	*M12 x 45*	*1 – 2*
BF 3	*76*		*13*	*53*	*53*			*80*	*110*	*M12 x 45*	*1 – 3*
BF R	*76*	*85*	*13*	*60*	*60*	*85*	*45*	*145*	*111*	*M12 x 45*	*1 – 2 – 4*
BS R	*76*	*105*	*13*	*60*	*53*	*105*	*45*	*145*	*131*	*M12 x 45*	*1 – 2 – 3 – 4*

Set of brackets	Tool change rails
BF 1	TCF 05
BF 2	TCF 1 TCF 2
BF 3	TCF 3
BFR	TCP 2 TCP 3 TCP 4
BSR	TCP 6



*: If rotobilles or transrollers, reduce dimension of C.

BFR or BSR

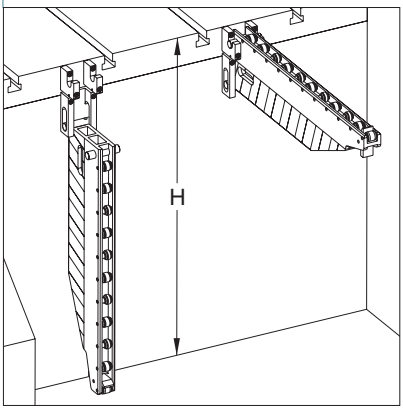


ACCESSORIES : TCF BRACKET PINS

BFA

ROTOBLOC-PSP GROUPE DIMECO

Dimensions and data subject to amendment



APPLICATION

BFA brackets are used to allow access from the front of a press table when the tool change rails are not used. These brackets are only used with TCF-type tool change rails.

ASSEMBLY & USE

BFA brackets feature a slide which allows you to tilt the TCF tool change rails downwards along the press table. The maximum length of tool change rails for this application is defined in relation to the height, H, of the press table.

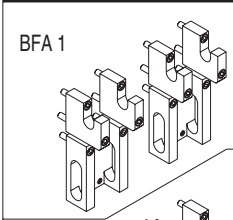
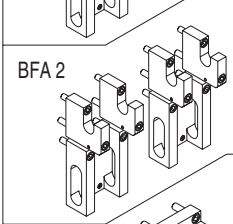
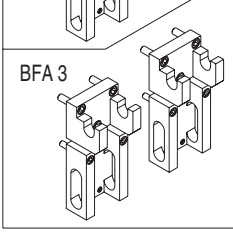
The length, B, given in the dimensional table for TCF tool change rails must be equal to or less than the height, H, of the table less 290 mm. (B < H – 290). The brackets are adjustable to allow the levelling of the running surface. Table 2 shows the bulk and mounting dimensions of the different brackets.

To order :

- Choose the set of brackets from table 1 according to the reference details of the TCF tool change rails in place. N.B.: the set of brackets is designed to fully mount one pair of tool change rails.

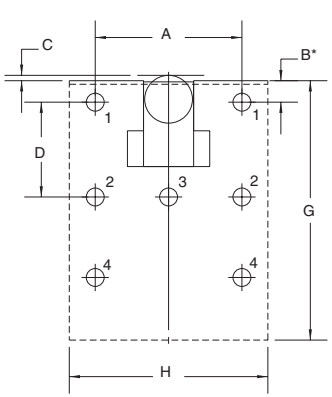
- Quote the complete reference number for the set of brackets.

MODELS	A	B	D	E	F	G	H	Threads	Item Nos.
BFA 1	*82*	*13*	*53*	*80*	*40*	*230*	*110*	*M10 x 40*	*1 + 2 + 4*
BFA 2	*82*	*13*	*53*	*80*	*40*	*230*	*110*	*M12 X 45*	*1 + 2 + 4*
BFA 3	*76*	*13*	*53*	*80*	*40*	*230*	*110*	*M12 x 45*	*1 + 3 + 4*
								M10 x 45	*4*

Set of brackets	Tool change rails
BFA 1 	TCF 05
BFA 2 	TCF 1 TCF 2
BFA 3 	TCF 3

E.g. : Set of BFA 3 brackets

BFA3 brackets for TCF 3-type tool change rails = tool change rails with capacity F = 3000 kg. according to dimensional table.



*: If rotobilles or transrollers, reduce dimension of C.

ROTATING TOOL CHANGE RAILS - Heavy series

TCRSF - TCRDF

ROTOBLOC-PSP GROUPE DIMECO

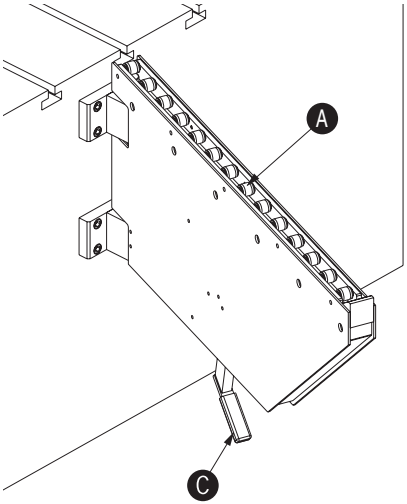
Dimensions and data subject to amendment

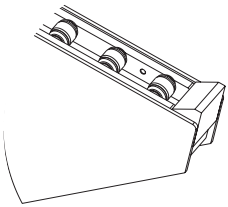
APPLICATION

TCRSF/TCRDF tool change rails are used to load tools onto press tables safely and quickly. They are permanently fixed to the front of press tables with rotating brackets. They can adopt two set positions, the working position and the slide position that allows complete access to the front of the press.

DESCRIPTION

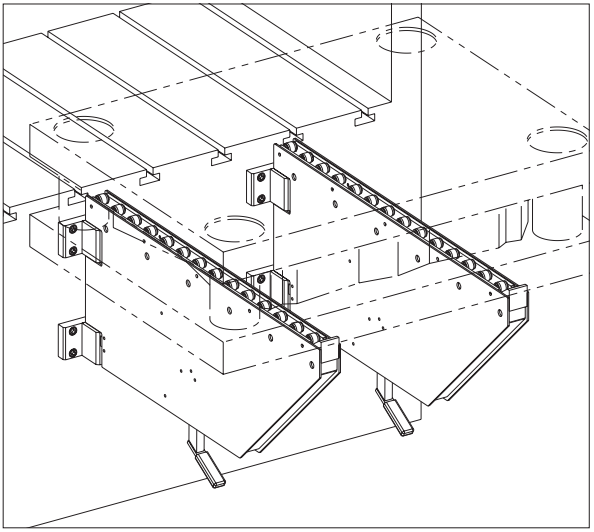
Made from steel, their movement plane is constituted by compact bearing modules (A). These units are of the combined needle roller type with heavy cages.
An indexing pedal (C) allows for effective locking and rapid unlocking of the arm so that you can obtain the positions desired.
The ends of the tool change rails are equipped with a progressive stop.

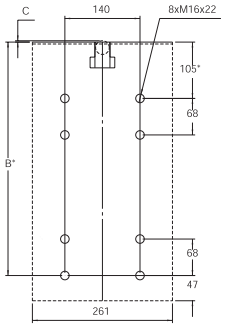




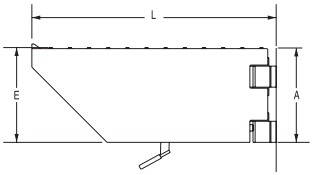
ASSEMBLY & USE

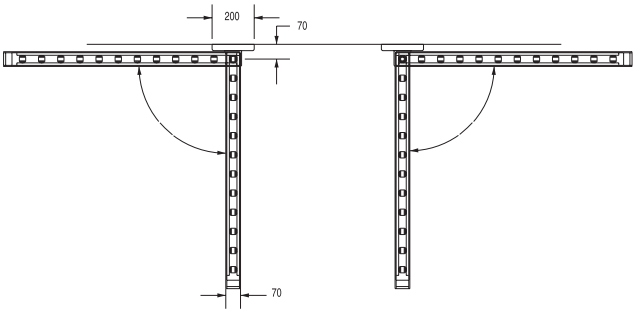
The tool change rails are used exclusively in pairs and are positioned and held in place at the front of the press tables with screwed plates.
The tool change rails can be slid to the right or to the left, without distinction.
Tools are moved manually or with the assistance of a motorised unit. The force required for movement depends upon the mass of the tool, its material and the quality of the surface finish. An average rolling friction coefficient is quoted in the specifications for the purpose of evaluating that force.
All the load values are given for static working conditions and are uniformly distributed per pair of tool change rails. Please abide by and reduce laying down speeds as much as possible in order to avoid impact that may engender dynamic overloads. Please see specifications.





*: Rotobilles or Transrollers, reduce dimension of C.





USE

The joint in TCRSF tool change rails allows them to be folded up: OUTWARDS.
The tool change rails are only used as a pair.

GENERAL TCRSF USER SPECIFICATIONS

Rolling friction coefficient: 0.03 for steel tools with a surface finish of Ra = 3.2
Admissible tool laying down speed < 20 mm/sec.
Loads F Static uniformly distributed between 2 support arms
Admissible temperature < 60.c

Example of travel force calculation:
Data:
Tool mass = 4000 kg, steel material, Ra = 3.2
Rolling friction coefficient = 0.03

Approximate travel force
4000 x 0,03 = 120 Kg (120 daN)

To order:

To order:
Specify the complete reference details of the pair of tool change rails :
e.g.: TCRSF 4 / 1000
(Tool change rails pair capacity 4000 kg, working length of 1000 mm.).

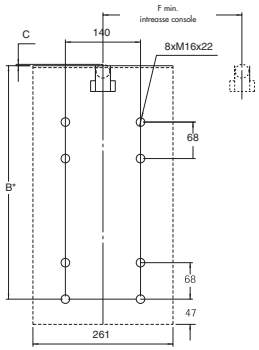
Models	Capacities		Dimensions (mm.)		Installation
	P (Kg)	Lu (mm)	A	E	B (mm)
TCRSF 4-800	4000	800	448	450	434
TCRSF 4-1000	4000	1000	448	450	434
TCRSF 4-1250	4000	1250	448	450	434
TCRSF 4-1500	4000	1500	448	450	434
TCRSF 6-800	6000	800	548	550	534
TCRSF 6-1000	6000	1000	548	550	534
TCRSF 6-1250	6000	1250	548	550	534
TCRSF 6-1500	6000	1500	548	550	534

DISYMMETRICAL ROTATING TOOL CHANGE RAILS : Heavy series

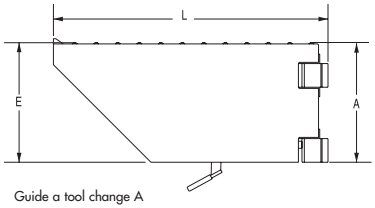
TCRDF

ROTOBLOC-PSP GROUPE DIMECO

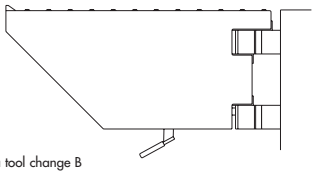
Dimensions and data subject to amendment



*: Rotobilles or Transrollers, reduce dimension of C.



Guide a tool change A



Guide a tool change B

USE

The dissymmetrical joints in TCRDF tool change rails allow them to be folded INWARDS AND ONE OVER THE OTHER.
The tool change rails are only used as a pair.

GENERAL TCRF USER SPECIFICATIONS

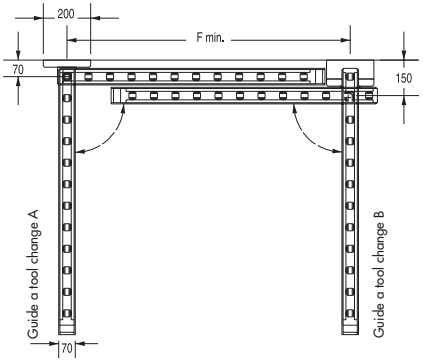
Rolling friction coefficient: 0.03 for steel tools with a surface finish of Ra = 3.2
Admissible tool laying down speed < 20 mm/sec.
Loads F Static uniformly distributed between 2 arms
Admissible temperature < 60.c

Example of travel force calculation:
Data:
Tool mass = 4000 kg, steel material, Ra = 3.2
Rolling friction coefficient = 0.03

Approximate travel force
4000 x 0.03 = 120 kg (120 daN)

To order :

Specify the complete reference details of the pair of tool change rails :
e.g.: TCRSF 4 / 1000
(Tool change rails pair capacity 4000 kg, working length of 1000 mm.).



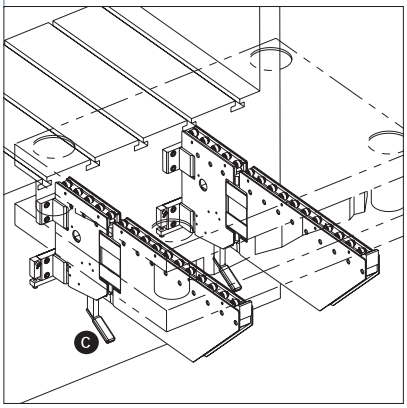
Models	Capacities		Dimensions (mm.)			Installation
	P (Kg)	Lu (mm)	F mini	A	E	B (mm)
TCRDF 4-800	4000	800	1000	448	450	434
TCRDF 4-1000	4000	1000	1200	448	450	434
TCRDF 4-1250	4000	1250	1450	448	450	434
TCRDF 4-1500	4000	1500	1700	448	450	434
TCRDF 6-800	6000	800	1000	548	550	534
TCRDF 6-1000	6000	1000	1200	548	550	534
TCRDF 6-1250	6000	1250	1450	548	550	534
TCRDF 6-1500	6000	1500	1700	548	550	534

ARTICULATED TOOL CHANGE RAILS (Heavy series)

TCAF

ROTOBLOC-PSP GROUPE DIMECO

Dimensions and data subject to amendment



APPLICATION

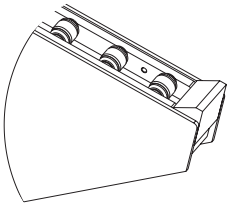
TCAF tool change rails are used to load tools onto press tables safely and quickly. They are permanently fixed to the front of press tables with rotating brackets. They can adopt two set positions, the working position and the slide position that allows complete access to the front of the press.

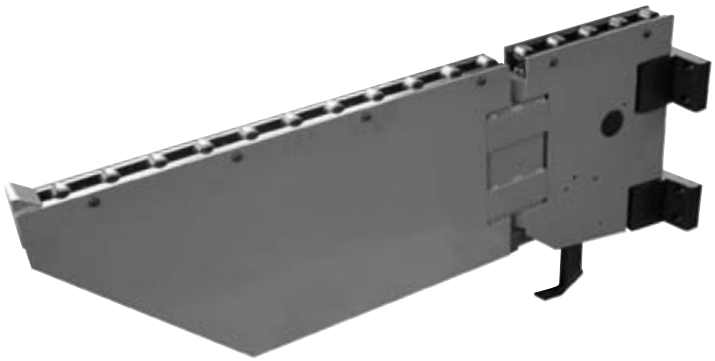
DESCRIPTION

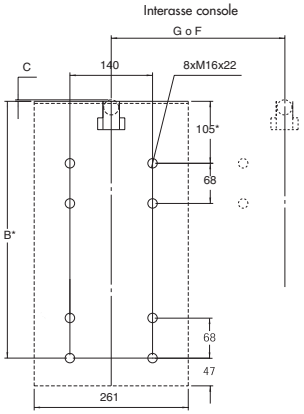
Made from steel, their movement plane is constituted by compact bearing modules (A). These units are of the combined needle roller type with solid cages for heavy loads.
An indexing pedal (C) allows for effective locking and rapid unlocking of the bracket so that you can obtain the positions desired.
The ends of the tool change rails are equipped with a progressive stop.

ASSEMBLY & USE

The tool change rails are used exclusively in pairs and are positioned and held in place at the front of the press tables with a set of threaded attachments.
The tool change rails can be slid to the right or to the left, without distinction.
Tools are moved manually or with the assistance of a motorised unit. The force required for movement depends upon the mass of the tool, its material and the quality of the surface finish. An average rolling friction coefficient is quoted in the specifications for the purpose of evaluating that force.
All the load values are given for static working conditions and are uniformly distributed per pair of tool change rails. Please abide by and reduce laying down speeds as much as possible in order to avoid impact that may engender dynamic overloads. Please see specifications.







*: If Roboball or Transroller, reduce dimension of C .

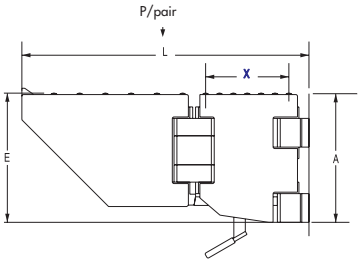
GENERAL TCAF USER SPECIFICATIONS

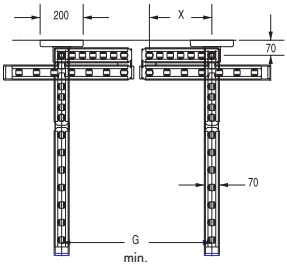
Rolling friction coefficient: 0.03 for steel tools with a surface finish of Ra = 3.2
Admissible tool laying down speed < 20 mm/sec.
Loads F Static uniformly distributed between 2 tool change rails
Admissible temperature < 60.c

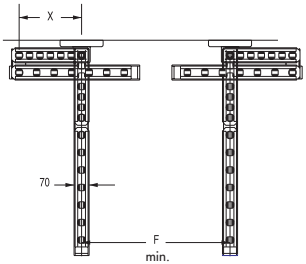
Example of travel force calculation:
Data:
Tool mass = 4000 kg, steel material, Ra = 3.2
Rolling friction coefficient = 0.03

Approximate travel force
4000 x 0.03 = 120 kg (120 daN)

To order :
Quote the complete reference details of the pair of tool change rails:
e.g.: TCAF 4 / 1000
(Tool change rails pair capacity 4000 kg, working length of 1000 mm.).







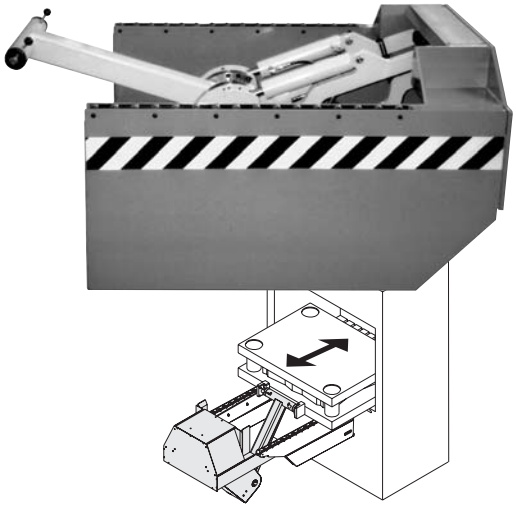
Models BASE	Capacities P (Kg)	Lu (mm)	X (mm)	Dimensions (mm.) F mini	G mini	A	E	Installation B (mm)
TCAF 4-800	4000	750	290	150	680	448	450	434
TCAF 4-1000	4000	950	290	550	680	448	450	434
TCAF 4-1000	4000	950	380	190	870	448	450	434
TCAF 4-1250	4000	1200	290	1050	680	448	450	434
TCAF 4-1250	4000	1200	380	690	870	448	450	434
TCAF 4-1250	4000	1200	470	330	1040	448	450	434
TCAF 4-1500	4000	1450	380	1350	870	448	450	434
TCAF 4-1500	4000	1450	470	1070	1040	448	450	434
TCAF 4-1500	4000	1450	560	710	1220	448	450	434
TCAF 6-800	6000	750	290	150	680	548	550	534
TCAF 6-1000	6000	950	290	550	680	548	550	534
TCAF 6-1000	6000	950	380	190	870	548	550	534
TCAF 6-1250	6000	1200	290	1050	680	548	550	534
TCAF 6-1250	6000	1200	380	690	870	548	550	534
TCAF 6-1250	6000	1200	470	330	1040	548	550	534
TCAF 6-1500	6000	1450	380	1350	870	548	550	534
TCAF 6-1500	6000	1450	470	1070	1040	548	550	534
TCAF 6-1500	6000	1450	560	710	1220	548	550	534

SPECIAL MOTORISED TOOL CHANGE RAILS

TCFM/TCPM

ROTOBLOC-PSP GROUPE DIMECO

Dimensions and data subject to amendment



TCFM - MOTORISED TOOL CHANGE RAILS : INTERNATIONALLY PATENTED "QUICK BLOC" PUSH/PULL

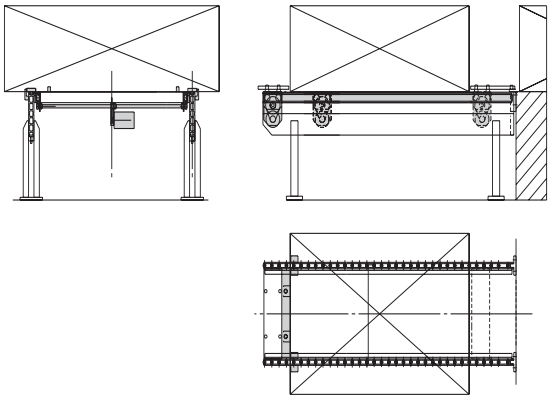
- Principle :
Synchronous, double-jointed hydraulic scissors

- Hooking/unhooking :
Standard : automatic/manual
Optional : hydraulic

- Range :
Stroke from 1000 to 1800 mm.
Weight of tools: up to 10,000 kg.

- Applications :
Referencing of tools on press bed;
Extraction of tools from bed to support arms

NB :
Tools are lowered onto the tool change rails directly via an overhead crane or a lift truck (ASK US FOR GUIDANCE).



TCPM - MOTORISED TOOL CHANGE RAILS : "MOTORISED RAIL" PUSH/PULL

- Principle :
Mobile rail guided by tool change rails

- Hooking/unhooking :
Standard: automatic/manual;
Optional: hydraulic

- Range :
Unlimited stroke
Weight of tools: up to 20 T (above this, ask us for guidance).

- Application :
Placement and extraction of tools of any capacity

NB :
Tools are lowered onto the brackets directly via an overhead crane.

SPECIAL TOOL CHANGE RAILS

ROTOBLOC manufactures special tool change rails (in steel or aluminium) for specific applications.

These tool change rails may be independent or assembled through rails so as to create an assembly that can be handled in a single operation via an overhead crane or lift truck (ASK US FOR GUIDANCE).

APPLICATION

Positioned in the press bed T slots, ROTOBILLES and TRANSROLLERS are used to move and change tools quickly and safely..

DESCRIPTION

ROTOBILLES and TRANSROLLERS (Fig. 1) comprise a rectangular cross-section segment that can, as standard, take "ROTOBILLE" ball-type bearing modules (A) and/or bearing modules of the straight-roller (B) or TRANSROLLER-oriented (C) variety.
The sections made from high-resistance treated light alloy are rigid single blocks. The treated steel alloy bearing modules are equipped with high-quality BALLS for the ROTOBILLES and combined NEEDLE ROLLERS for TRANSROLLERS.
Modules of different types can be combined when equipping a particular section with the aim of resolving specific problems.
E.g.: (fig. 2) ROTOBILLE equipped with a roller module at each end in order to improve the tool's contact and to avoid marking it.

HYDRAULIC AND MECHANICAL PRINCIPLES

A mechanical or a hydraulic version of TRANSROLLERS and ROTOBILLES can be used.

- Mechanical version (fig. 3): bearing modules lift the tool with the help of a spring (A). When the tool has been clamped or when its weight exceeds the total load capacity of the modules in operation, the spring is compressed and the tool rests on the press bed.

- Hydraulic version (fig. 4): The bearing module lifts the tool with the help of hydraulic pressure in the chamber (B). When the hydraulic pressure is removed, the tool rests on the press bed.

LOAD & STROKE

The loads given in the table are dynamic unitary loads per segment (F) or per module (F/n), uniformly distributed. These loads have been evaluated in order to satisfy the majority of circumstances. A greater weight may be taken but it will have the effect of reducing the lifespan of the module as well as marking the lower part of the tools. Any use with excess weights is to be avoided.
The nominal stroke "C" is 1 mm. This stroke is standard for all types of segments installed in DIN650 T slots.

C = 1.25 mm. for a T slot with a nominal width of 18.
C = 1.50 mm. for a T slot with a nominal width of 22.
C = 1.50 mm. for a T slot with a nominal width of 24.
C = 2.00 mm. for a T slot with a nominal width of 28.
C = 2.00 mm. for a T slot with a nominal width of 36.

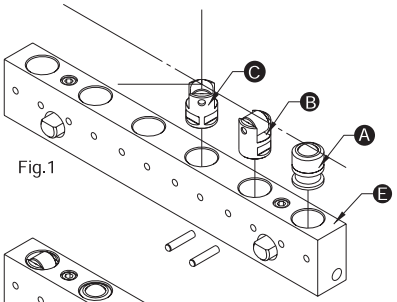


Fig.1

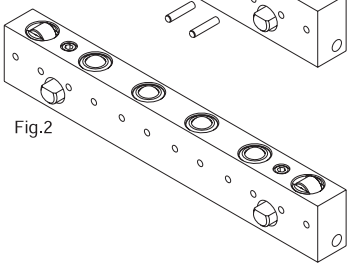


Fig.2

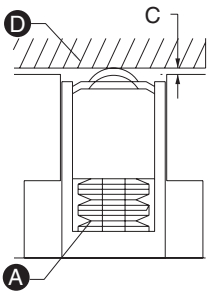


Fig.3

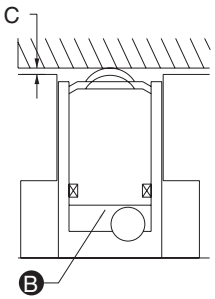


Fig.4

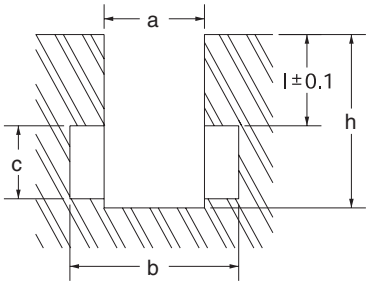
TRANSROLLERS AND ROTOBILLES : HYDRAULIC OR MECHANICAL

TU:RH-BH-RM-BM

ROTOBLOC-PSP GROUPE DIMECO

Dimensions and data subject to amendment

Designation	DIN 650				TS * M (Special)				TS * H (Special)			
	a	b	c	h	a+	a-	h+	h-	a+	a-	h+	h-
18 segment	18	30	12	30	22	17	38	24	22	18	38	29
22 segment	22	37	16	38	28	20	48	32	28	20	48	37
24 segment	24	42	18	42	28	20	48	33	28	22	48	38
28 segment	28	46	20	48	36	25	61	40	36	26	61	44
36 segment	36	56	25	61	36	32	86	51	36	32	86	54

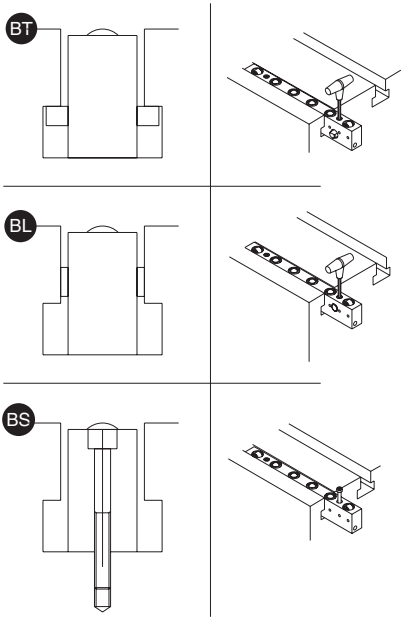


DIMENSIONS

The segments are installed in T-shaped slots meeting DIN 650 standard or rectangular slots. They are defined by the width, a, of the slot. Special sections are manufactured on demand. The table above shows DIN 650 standard and the special "a" and "h" possible designs under this standard.

ASSEMBLY & USE

There are 3 different ways to fasten the segments in the T slots:
- Type BT (fig.1): quick fastening with vertical grip spanner in any type of T-shaped slot. This type is only available for mechanical segments.
- Type BL (fig.2): quick fastening with lateral grip in any type of slot.
- Type BS (f9g.3): Permanent fastening using screws and female threads in the bottom of T slots.
Any type of segment. The dimensional table gives the position of the attachments. Refer to the HYDRAULIC PRESSURE GENERATORS section to choose an appropriate generator and ACCESSORIES for the connection.



ORDER IDENTIFICATION

Complete the following coding grid:

1	2	3	4 - 5/6

1: Segment type: TU for slot complying with standard DIN 650,
S for slot not covered by standard DIN 650.
2: Assembly type: B same assembly with balls, R same assembly with rollers.
*C**RB combined assembly with rollers and balls.*
*The figure** indicates the number of roller modules.*
*O**DR right-oriented roller assembly. The figure ** indicates the angle.*
*O**GR left-oriented roller assembly. The figure ** indicates the angle.*
3: Action type: H hydraulic, M mechanical.
4: Width of DIN 650 "a" slot.
5: Total length, LT, of segment.
6: Type of fastening for the segment BT, BL or BS.

Example 1: TUBM 22-1116/BT: mechanical DIN650 segment, same assembly with ball modules; BT quick fastening; a = 22; LT = 1116.
Example 2: TUC2RBH22-1116/BL: hydraulic DIN650 segment, combined assembly with 2 roller modules and the rest with balls; BL quick fastening; a = 22; LT = 1116.
N.B.: indicate a, l and h dimensions of non-DIN650 TS segments.
Note: oriented roller segments not available in width a = 18.

GENERAL USER SPECIFICATIONS

Create a 1 mm. chamfer at 30° (of the corner of the tool to the passing level of the roller modules, in order to avoid impact). Keep tool-table interfaces clean.
The following values are given in the dimensional tables:

V = Nominal tool movement speed;
F/nB = nominal load per ball module;
P max = Max. hydraulic pressure;
P noR = Nominal Transrollers hydraulic pressure;
Cf = Approx. rolling friction coefficient
(load distributed throughout hydraulic module, steel tool Ra = 3.2. Nominal hydraulic pressure).
D = diameter of ball or roller of module;
F/nR = nominal load per roller module;
P noB = Nominal Rotobilles hydraulic pressure;

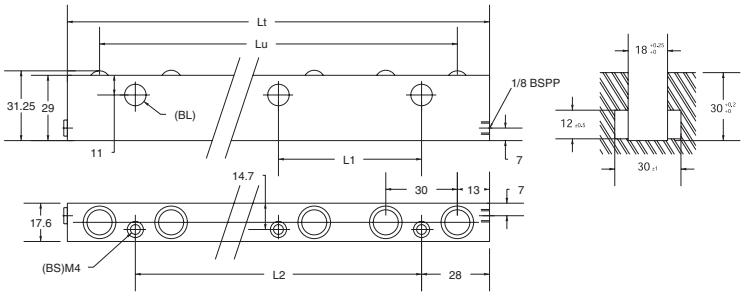
TRANSROLLERS AND ROTOBILLES : HYDRAULIC

Dimensions and data subject to amendment

TURH 18 TUBH 18 Unit	Dimensions Lt mm	Lu mm	L1 mm	L2 mm	n	Lifting power TUBH F daN (kg)	TURH F daN (kg)	Weight kg
18 - 86	86	60			3	120	240	0,16
18 - 116	116	90		60	4	160	320	0,20
18 - 146	146	120		90	5	200	400	0,25
18 - 176	176	150		120	6	240	480	0,29
18 - 206	206	180		150	7	280	560	0,33
18 - 236	236	210		180	8	320	640	0,38
18 - 266	266	240		210	9	360	720	0,42
18 - 296	296	270		240	10	400	800	0,47
18 - 326	326	300		270	11	440	880	0,51
18 - 356	356	330		300	12	480	960	0,55
18 - 386	386	360		330	13	520	1040	0,60
18 - 416	416	390		360	14	560	1120	0,64
18 - 446	446	420		390	15	600	1200	0,69
18 - 476	476	450		420	16	640	1280	0,73
18 - 506	506	480		450	17	680	1360	0,77
18 - 536	536	510		480	18	720	1440	0,82
18 - 566	566	540		510	19	760	1520	0,86
18 - 596	596	570		540	20	800	1600	0,91
18 - 626	626	600		570	21	840	1680	0,95
18 - 656	656	630		600	22	880	1760	0,99
18 - 686	686	660		630	23	920	1840	1,04
18 - 716	716	690		660	24	960	1920	1,08
18 - 746	746	720	360	690	25	1000	2000	1,13
18 - 776	776	750	360	720	26	1040	2080	1,17
18 - 806	806	780	390	750	27	1080	2160	1,21
18 - 836	836	810	390	780	28	1120	2240	1,26
18 - 866	866	840	420	810	29	1160	2320	1,30
18 - 896	896	870	420	840	30	1200	2400	1,35
18 - 926	926	900	450	870	31	1240	2480	1,39
18 - 956	956	930	450	900	32	1280	2560	1,43
18 - 986	986	960	480	930	33	1320	2640	1,48
18 - 1016	1016	990	480	960	34	1360	2720	1,52
18 - 1046	1046	1020	510	990	35	1400	2800	1,57
18 - 1076	1076	1050	510	1020	36	1440	2880	1,61
18 - 1106	1106	1080	540	1050	37	1480	2960	1,65
18 - 1136	1136	1110	540	1080	38	1520	3040	1,70
18 - 1166	1166	1140	570	1110	39	1560	3120	1,74
18 - 1196	1196	1170	570	1140	40	1600	3200	1,79
18 - 1226	1226	1200	600	1170	41	1640	3280	1,83
18 - 1256	1256	1230	600	1200	42	1680	3360	1,87
18 - 1286	1286	1260	630	1230	43	1720	3440	1,92
18 - 1316	1316	1290	630	1260	44	1760	3520	1,96
18 - 1346	1346	1320	660	1290	45	1800	3600	2,01
18 - 1376	1376	1350	660	1320	46	1840	3680	2,05
18 - 1406	1406	1380	690	1350	47	1880	3760	2,09
18 - 1436	1436	1410	690	1380	48	1920	3840	2,14
18 - 1466	1466	1440	720	1410	49	1960	3920	2,18
18 - 1496	1496	1470	720	1440	50	2000	4000	2,23

General user specifications

V	m/mn	8
D	mm	8
F/nB	daN (kg)	40
F/nR	daN (kg)	80
PnoB	bar	32
PnoR	bar	64
Pmax	bar	100
Cf		0,05



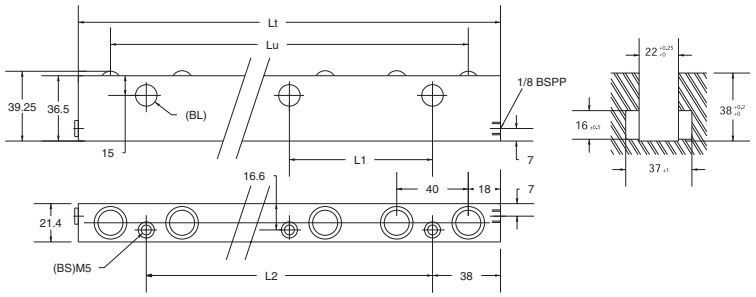
TRANSROLLERS AND ROTOBILLES : HYDRAULIC

Dimensions and data subject to amendment

TURH 22 TUBH 22 Unit	Dimensions Lt mm	 Lu mm	 L1 mm	 L2 mm	 n	Lifting power TUBH F daN (kg)	 TURH F daN (kg)	Weight kg
22 - 116	116	80			3	240	480	0,3
22 - 156	156	120		80	4	320	640	0,4
22 - 196	196	160		120	5	400	800	0,5
22 - 236	236	200		160	6	480	960	0,6
22 - 276	276	240		200	7	560	1120	0,7
22 - 316	316	280		240	8	640	1280	0,8
22 - 356	356	320		280	9	720	1440	0,9
22 - 396	396	360		320	10	800	1600	1
22 - 436	436	400		360	11	880	1760	1,1
22 - 476	476	440		400	12	960	1920	1,2
22 - 516	516	480		440	13	1040	2080	1,3
22 - 556	556	520		480	14	1120	2240	1,4
22 - 596	596	560		520	15	1200	2400	1,5
22 - 636	636	600		560	16	1280	2560	1,6
22 - 676	676	640		600	17	1360	2720	1,7
22 - 716	716	680		640	18	1440	2880	1,7
22 - 756	756	720		680	19	1520	3040	1,8
22 - 796	796	760		720	20	1600	3200	1,9
22 - 836	836	800		760	21	1680	3360	2
22 - 876	876	840		800	22	1760	3520	2,1
22 - 916	916	880		840	23	1840	3680	2,2
22 - 956	956	920		880	24	1920	3840	2,3
22 - 996	996	960		920	25	2000	4000	2,4
22 - 1036	1036	1000	480	960	26	2080	4160	2,5
22 - 1076	1076	1040	480	1000	27	2160	4320	2,6
22 - 1116	1116	1080	520	1040	28	2240	4480	2,7
22 - 1156	1156	1120	520	1080	29	2320	4640	2,8
22 - 1196	1196	1160	560	1120	30	2400	4800	2,9
22 - 1236	1236	1200	560	1160	31	2480	4960	3
22 - 1276	1276	1240	600	1200	32	2560	5120	3,1
22 - 1316	1316	1280	600	1240	33	2640	5280	3,2
22 - 1356	1356	1320	640	1280	34	2720	5440	3,3
22 - 1396	1396	1360	640	1320	35	2800	5600	3,3
22 - 1436	1436	1400	680	1360	36	2880	5760	3,4
22 - 1476	1476	1440	680	1400	37	2960	5920	3,5
22 - 1516	1516	1480	720	1440	38	3040	6080	3,6
22 - 1556	1556	1520	720	1480	39	3120	6240	3,7
22 - 1596	1596	1560	760	1520	40	3200	6400	3,8
22 - 1636	1636	1600	760	1560	41	3280	6560	3,9
22 - 1676	1676	1640	800	1600	42	3360	6720	4
22 - 1716	1716	1680	800	1640	43	3440	6880	4,1
22 - 1756	1756	1720	840	1680	44	3520	7040	4,2
22 - 1796	1796	1760	840	1720	45	3600	7200	4,3
22 - 1836	1836	1800	880	1760	46	3680	7360	4,4
22 - 1876	1876	1840	880	1800	47	3760	7520	4,5
22 - 1916	1916	1880	920	1840	48	3840	7680	4,6
22 - 1956	1956	1920	920	1880	49	3920	7840	4,7
22 - 1996	1996	1960	960	1920	50	4000	8000	4,8

General user specifications

V	m/mn	10
D	mm	12
F/nB	daN (kg)	80
F/nR	daN (kg)	160
PnoB	bar	40
PnoR	bar	80
Pmax	bar	100
Cf		0,05



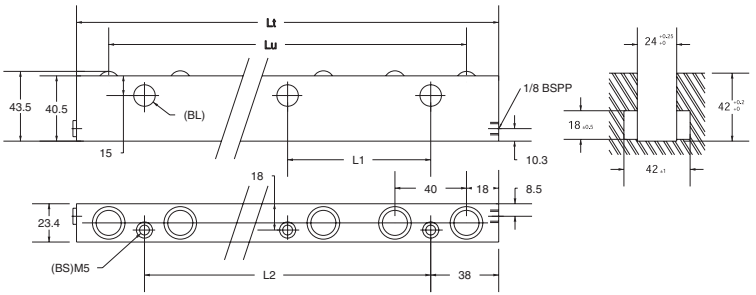
TRANSROLLERS AND ROTOBILLES : HYDRAULIC

Dimensions and data subject to amendment

TURH 24 TUBH 24 Unit	Dimensions Lt mm	Lu mm	L1 mm	L2 mm	n	Lifting power TUBH F daN (kg)	TURH F daN (kg)	Weight kg
24 - 116	116	80			3	240	480	0,4
24 - 156	156	120		80	4	320	640	0,5
24 - 196	196	160		120	5	400	800	0,6
24 - 236	236	200		160	6	480	960	0,7
24 - 276	276	240		200	7	560	1120	0,8
24 - 316	316	280		240	8	640	1280	1
24 - 356	356	320		280	9	720	1440	1,1
24 - 396	396	360		320	10	800	1600	1,2
24 - 436	436	400		360	11	880	1760	1,3
24 - 476	476	440		400	12	960	1920	1,4
24 - 516	516	480		440	13	1040	2080	1,5
24 - 556	556	520		480	14	1120	2240	1,6
24 - 596	596	560		520	15	1200	2400	1,7
24 - 636	636	600		560	16	1280	2560	1,8
24 - 676	676	640		600	17	1360	2720	1,9
24 - 716	716	680		640	18	1440	2880	2,1
24 - 756	756	720		680	19	1520	3040	2,2
24 - 796	796	760		720	20	1600	3200	2,3
24 - 836	836	800		760	21	1680	3360	2,4
24 - 876	876	840		800	22	1760	3520	2,5
24 - 916	916	880		840	23	1840	3680	2,6
24 - 956	956	920		880	24	1920	3840	2,7
24 - 996	996	960		920	25	2000	4000	2,8
24 - 1036	1036	1000	480	960	26	2080	4160	2,9
24 - 1076	1076	1040	480	1000	27	2160	4320	3
24 - 1116	1116	1080	520	1040	28	2240	4480	3,2
24 - 1156	1156	1120	520	1080	29	2320	4640	3,3
24 - 1196	1196	1160	560	1120	30	2400	4800	3,4
24 - 1236	1236	1200	560	1160	31	2480	4960	3,5
24 - 1276	1276	1240	600	1200	32	2560	5120	3,6
24 - 1316	1316	1280	600	1240	33	2640	5280	3,7
24 - 1356	1356	1320	640	1280	34	2720	5440	3,8
24 - 1396	1396	1360	640	1320	35	2800	5600	3,9
24 - 1436	1436	1400	680	1360	36	2880	5760	4
24 - 1476	1476	1440	680	1400	37	2960	5920	4,1
24 - 1516	1516	1480	720	1440	38	3040	6080	4,3
24 - 1556	1556	1520	720	1480	39	3120	6240	4,4
24 - 1596	1596	1560	760	1520	40	3200	6400	4,5
24 - 1636	1636	1600	760	1560	41	3280	6560	4,6
24 - 1676	1676	1640	800	1600	42	3360	6720	4,7
24 - 1716	1716	1680	800	1640	43	3440	6880	4,8
24 - 1756	1756	1720	840	1680	44	3520	7040	4,9
24 - 1796	1796	1760	840	1720	45	3600	7200	5
24 - 1836	1836	1800	880	1760	46	3680	7360	5,1
24 - 1876	1876	1840	880	1800	47	3760	7520	5,2
24 - 1916	1916	1880	920	1840	48	3840	7680	5,4
24 - 1956	1956	1920	920	1880	49	3920	7840	5,5
24 - 1996	1996	1960	960	1920	50	4000	8000	5,6

General user specifications

V	m/mn	10
D	mm	12
F/nB	daN (kg)	80
F/nR	daN (kg)	160
PnoB	bar	40
PnoR	bar	80
Pmax	bar	100
Cf		0,05



TRANSROLLERS AND ROTOBILLES : HYDRAULIC

TUBH 28 - TURH 28

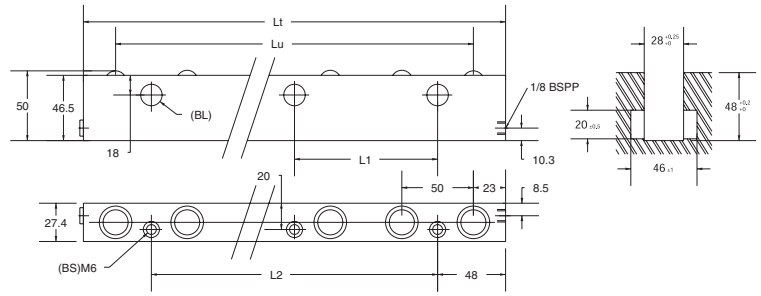
ROTOBLOC-PSP GROUPE DIMECO

Dimensions and data subject to amendment

TURH 28 TUBH 28 Unit	Dimensions Lt mm	Lu mm	L1 mm	L2 mm	n	Lifting power TUBH F daN (kg)	TURH F daN (kg)	Weight kg
28 - 146	146	100			3	375	750	0,7
28 - 196	196	150		100	4	500	1000	0,9
28 - 246	246	200		150	5	625	1250	1,1
28 - 296	296	250		200	6	750	1500	1,3
28 - 346	346	300		250	7	875	1750	1,5
28 - 396	396	350		300	8	1000	2000	1,7
28 - 446	446	400		350	9	1125	2250	1,9
28 - 496	496	450		400	10	1250	2500	2,1
28 - 546	546	500		450	11	1375	2750	2,3
28 - 596	596	550		500	12	1500	3000	2,5
28 - 646	646	600		550	13	1625	3250	2,7
28 - 696	696	650		600	14	1750	3500	2,9
28 - 746	746	700		650	15	1875	3750	3,1
28 - 796	796	750		700	16	2000	4000	3,2
28 - 846	846	800		750	17	2125	4250	3,4
28 - 896	896	850		800	18	2250	4500	3,6
28 - 946	946	900		850	19	2375	4750	3,8
28 - 996	996	950		900	20	2500	5000	4
28 - 1046	1046	1000		950	21	2625	5250	4,2
28 - 1096	1096	1050		1000	22	2750	5500	4,4
28 - 1146	1146	1100		1050	23	2875	5750	4,6
28 - 1196	1196	1150	550	1100	24	3000	6000	4,8
28 - 1246	1246	1200	550	1150	25	3125	6250	5
28 - 1296	1296	1250	600	1200	26	3250	6500	5,2
28 - 1346	1346	1300	600	1250	27	3375	6750	5,4
28 - 1396	1396	1350	650	1300	28	3500	7000	5,6
28 - 1446	1446	1400	650	1350	29	3625	7250	5,8
28 - 1496	1496	1450	700	1400	30	3750	7500	6
28 - 1546	1546	1500	700	1450	31	3875	7750	6,2
28 - 1596	1596	1550	750	1500	32	4000	8000	6,4
28 - 1646	1646	1600	750	1550	33	4125	8250	6,6
28 - 1696	1696	1650	800	1600	34	4250	8500	6,8
28 - 1746	1746	1700	800	1650	35	4375	8750	7
28 - 1796	1796	1750	850	1700	36	4500	9000	7,1
28 - 1846	1846	1800	850	1750	37	4625	9250	7,3
28 - 1896	1896	1850	900	1800	38	4750	9500	7,5
28 - 1946	1946	1900	900	1850	39	4875	9750	7,7
28 - 1996	1996	1950	950	1900	40	5000	10000	7,9
28 - 2046	2046	2000	950	1950	41	5125	10250	8,1
28 - 2096	2096	2050	1000	2000	42	5250	10500	8,3
28 - 2146	2146	2100	1000	2050	43	5375	10750	8,5
28 - 2196	2196	2150	1050	2100	44	5500	11000	8,7
28 - 2246	2246	2200	1050	2150	45	5625	11250	8,9
28 - 2296	2296	2250	2 x 750	2200	46	5750	11500	9,1
28 - 2346	2346	2300	2 x 750	2250	47	5875	11750	9,3
28 - 2396	2396	2350	2 x 750	2300	48	6000	12000	9,5
28 - 2446	2446	2400	2 x 800	2350	49	6125	12250	9,7
28 - 2496	2496	2450	2 x 800	2400	50	6250	12500	9,9

General user specifications

V	m/mn	12
D	mm	15
F/nB	daN (kg)	125
F/nR	daN (kg)	250
PnoB	bar	42
PnoR	bar	85
Pmax	bar	100
Cf		0,05



TRANSROLLERS AND ROTOBILLES : HYDRAULIC

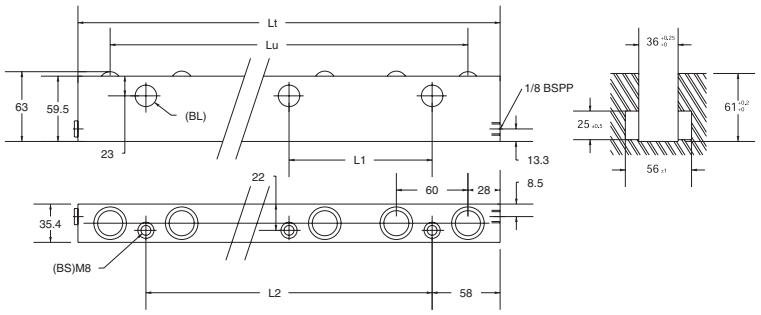
ROTOBLOC-PSP GROUPE DIMECO

Dimensions and data subject to amendment

TURH 36 TUBH 36 Unit	Dimensions Lt mm	 Lu mm	 L1 mm	 L2 mm	 n	Lifting power TUBH F daN (kg)	 TURH F daN (kg)	Weight kg
36 - 176	176	120			3	600	1200	1,3
36 - 236	236	180		120	4	800	1600	1,7
36 - 296	296	240		180	5	1000	2000	2,1
36 - 356	356	300		240	6	1200	2400	2,5
36 - 416	416	360		300	7	1400	2800	2,9
36 - 476	476	420		360	8	1600	3200	3,2
36 - 536	536	480		420	9	1800	3600	3,6
36 - 596	596	540		480	10	2000	4000	4
36 - 656	656	600		540	11	2200	4400	4,4
36 - 716	716	660		600	12	2400	4800	4,8
36 - 776	776	720		660	13	2600	5200	5,1
36 - 836	836	780		720	14	2800	5600	5,5
36 - 896	896	840		780	15	3000	6000	5,9
36 - 956	956	900		840	16	3200	6400	6,3
36 - 1016	1016	960		900	17	3400	6800	6,7
36 - 1076	1076	1020		960	18	3600	7200	7,0
36 - 1136	1136	1080		1020	19	3800	7600	7,4
36 - 1196	1196	1140		1080	20	4000	8000	7,8
36 - 1256	1256	1200		1140	21	4200	8400	8,2
36 - 1316	1316	1260	600	1200	22	4400	8800	8,6
36 - 1376	1376	1320	600	1260	23	4600	9200	8,9
36 - 1436	1436	1380	660	1320	24	4800	9600	9,3
36 - 1496	1496	1440	660	1380	25	5000	10000	9,7
36 - 1556	1556	1500	720	1440	26	5200	10400	10,1
36 - 1616	1616	1560	720	1500	27	5400	10800	10,5
36 - 1676	1676	1620	780	1560	28	5600	11200	10,8
36 - 1736	1736	1680	780	1620	29	5800	11600	11,2
36 - 1796	1796	1740	840	1680	30	6000	12000	11,6
36 - 1856	1856	1800	840	1740	31	6200	12400	12,0
36 - 1916	1916	1860	900	1800	32	6400	12800	12,4
36 - 1976	1976	1920	900	1860	33	6600	13200	12,7
36 - 2036	2036	1980	960	1920	34	6800	13600	13,1
36 - 2096	2096	2040	960	1980	35	7000	14000	13,5
36 - 2156	2156	2100	1020	2040	36	7200	14400	13,9
36 - 2216	2216	2160	1020	2100	37	7400	14800	14,3
36 - 2276	2276	2220	1080	2160	38	7600	15200	14,6
36 - 2336	2336	2280	1080	2220	39	7800	15600	15,0
36 - 2396	2396	2340	1140	2280	40	8000	16000	15,4
36 - 2456	2456	2400	1140	2340	41	8200	16400	15,8
36 - 2516	2516	2460	1200	2400	42	8400	16800	16,2
36 - 2576	2576	2520	2 x 840	2460	43	8600	17200	16,5
36 - 2636	2636	2580	2 x 840	2520	44	8800	17600	16,9
36 - 2696	2696	2640	2 x 840	2580	45	9000	18000	17,3
36 - 2756	2756	2700	2 x 900	2640	46	9200	18400	17,7
36 - 2816	2816	2760	2 x 900	2700	47	9400	18800	18,0
36 - 2876	2876	2820	2 x 900	2760	48	9600	19200	18,4
36 - 2936	2936	2880	2 x 960	2820	49	9800	19600	18,8
36 - 2996	2996	2940	2 x 960	2880	50	10000	20000	19,2

General user specifications

V	m/mn	15
D	mm	19
F/nB	daN (kg)	200
F/nR	daN (kg)	400
PnoB	bar	42
PnoR	bar	85
Pmax	bar	100
Cf		0,05



APPLICATION

These types of smooth cartridges are movement equipment designed to be installed in press bed bore holes to allow tools to be moved easily.
The cartridges are often used when the option of installing Transrollers or Rotobilles is tricky or impossible.

DESCRIPTION

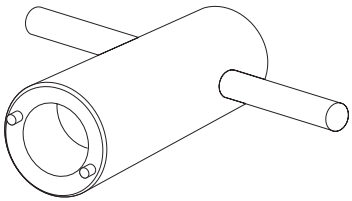
*The upper bearing element of the cartridges may be: ball (CB**) or roller (CR**).*
These bearings are lifted up thanks to a hydraulic action.
- The hydraulic action particular to each cartridge supports the load F on the stroke E.
- The cartridges are fitted directly into drilled holes. An elastomer joint (o-ring) inserted in a groove allows them to be immobilised. The orientation of roller cartridges is carried out using a pin tool. The cartridges may be extracted using screws in the M4 female thread holes, G.
The cartridges are supplied without any connection or tool.

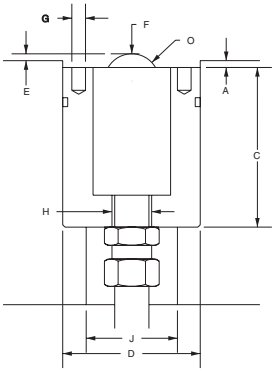
TO ORDER

Quote the complete reference number of the cartridge.
E.g.: cartridge CRHL 28
Smooth hydraulic-action roller cartridge, drilling Ø 35.25.

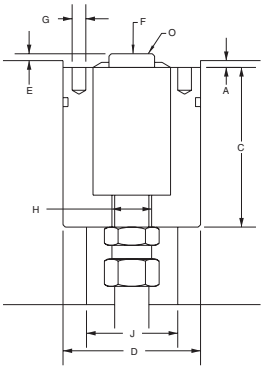
Tools for cartridges

Reference data	
D = 30,25	*OTL 30*
D = 35,25	*OTL 35*





CBHL



CRHL

MODELS	A mm	C mm	D H11/mm	E mm	F daN	G mm	O mm	H mm	J mm	P nom bar	P max bar
CBHL 22	1,5	36,5	30,25	1,5	80	3,3	12	1/8bspp	20	40	100
CBHL 28	1,5	44,5	35,25	2	125	3,3	15	1/8bspp	25	42	100
CRHL 22	1,5	36,5	30,25	1,5	160	3,3	12	1/8bspp	20	80	100
CRHL 28	1,5	44,5	35,25	2	250	3,3	15	1/8bspp	25	85	100

APPLICATION

These types of threaded cartridge are movement equipment designed to be fitted in press bed bore holes to allow tools to be moved easily.
The cartridges are often used when the option of installing Transrollers or Rotobilles is tricky or impossible.

DESCRIPTION

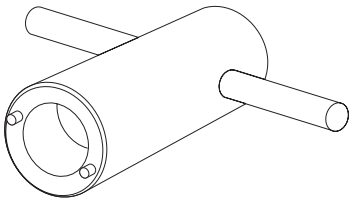
*The upper bearing element of the cartridges may be: ball (CB**) or roller (CR**).*
These bearings are lifted up thanks to a hydraulic action.
- The hydraulic action particular to each cartridge supports the load F on the stroke E.
- The cartridges are fitted directly into threaded holes. An elastomer joint (o-ring) inserted in a groove allows them to be immobilised. The cartridges are immobilised by applying a light coating of anaerobic glue to the thread. The disassembly and/or orientation of roller cartridges are carried out using a pin tool and the holes, G. The cartridges are supplied without any connection or tool.

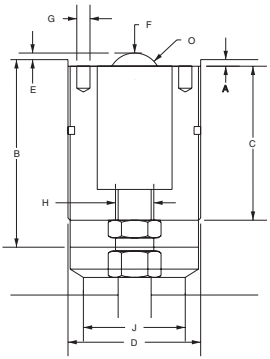
TO ORDER

Quote the complete reference details of the cartridge.
E.g.: cartridge CRHF 28
Threaded hydraulic-action roller cartridge, M35 thread, 1.5 lead.

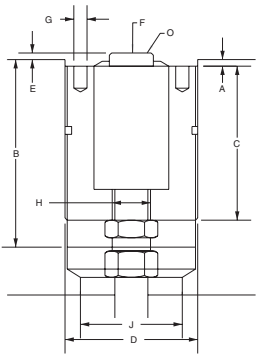
Tools for cartridges

Reference data	
D = M30	*OTL 30*
D = M35	*OTL 35*





CBHF



CRHF

MODELS	A mm	B mm	C mm	D mm	E mm	F daN	G mm	O mm	H mm	J mm	Pnom bar	Pmax bar
CBHF 22	1,5	42	36,5	M30x1,5	1,5	80	3,3	12	1/8bspp	20	40	100
CBHF 28	1,5	50	44,5	M35x1,5	2	125	3,3	15	1/8bspp	25	42	100
CRHF 22	1,5	42	36,5	M30x1,5	1,5	160	3,3	12	1/8bspp	20	80	100
CRHF 28	1,5	50	44,5	M35x1,5	2	250	3,3	15	1/8bspp	25	85	100

HPF 100

APPLICATION

HPF and HPMS pressure generators are pneumo-hydraulic power units that allow you to operate components that only require a low flow rate (Rotobilles or Transrollers).

DESCRIPTION

HPF and HPMS pressure generators are units of an anti-shock resin body forming a tank and containing a dynamic intensifier that transforms network supplied compressed air into hydraulic energy. The hydraulic action is of the single action type. The generators include a safety valve that limits hydraulic pressure so as to avoid overloading the sinks.

USE: HPF model

single foot pedal action operate the generator
- *Position 1: generator feed oil until nominal pressure is reached*
- *Position 2 (no foot action) :*
  hydraulic circuit is closed,pressure keep on in rotoballs,generator is not opereting
- *Position 3 : oil retun to generator, pressure is down*

HPMS 100 - HPMD 100

USE : HPMS/D model

The HPMS/D 100 pressure generator may power any of the following:
- *A set of Rotobilles (or Transrollers) powered simultaneously by a single hydraulic circuit.*
- *Two sets of Rotobilles (or Transrollers) powered by two separate hydraulic circuits.*

a) Powering a set of Rotobilles (or Transrollers) with simultaneous power
- *Manual valve turned to meet the connected circuit.*
- *If you press control #1 the unit powers the sink up to the nominal pressure of the generator.*
- *If you release control #1 (spring return) the pressure to the sink is maintained.*
- *To put the pressure to the sink in reverse you just need to reposition the manual switch to a central position (c.f. next page).*

b) Powering two sets of Rotobilles (or Transrollers) that are powered separately
Same procedure as previous paragraph (a), but select pressurisation of the sink required (c.f. next page).

NB :
Using a valve to select a circuit simultaneously puts the other circuit into reverse.
A mounting plate is available as an accessory for the HPMS/D.
The HPMS/D pneumo-hydraulic generator may be mounted vertically.

TO ORDER

Quote the complete reference details of the pump.
E.g.: Pump HPF 100;
Pump HPMS 100;
Pump HPMD 100.
**Pos. H = Horizontal position;*
Pos. V = Vertical position.

Specifications	Unit	HPF 100	HPMS 100	HPMD 100
Air pressure	bar	3,6	2,5	2,5
Oil pressure	bar	100	100	100
Air connection		1/4 BSPP	1/4 BSPP	1/4 BSPP
Oil connection		3/8 18 NPTF	1/4 BSPP	1/4 BSPP
Vacuum capacity	L/min	0,8	1,8	1,8
Tank volume	L	1,4	* Pos. O :2,1 - Pos. V:1,5	Pos. O:2,1 - Pos. V:1,5
Mass	Kg	5	6,3	6,3
Length	mm	195	319,5	3,19,5
Width	mm	145	155	155
Height	mm	170	233	233

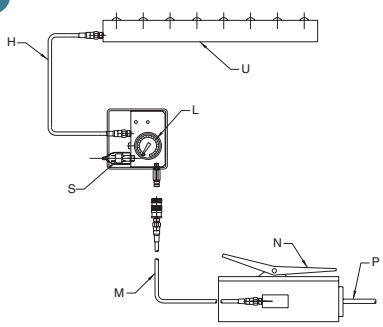
ACCESSORIES: Safety blocks

BDS

ROTOBLOC-PSP GROUPE DIMECO

Dimensions and data subject to amendment

a



DISTRIBUTION AND SAFETY BLOCKS

BD and BDS blocks etc. are safety blocks specially designed for use with hydraulic movement segments. Powered by hydraulic pressure generators, they allow you:
- to operate Transrollers or Rotobilles and to control and monitor the state of the pressure
- to reduce the pressure, if needed

N.B. An electric pressure switch controls the circuit pressure and gives the authorisation of start to the press.

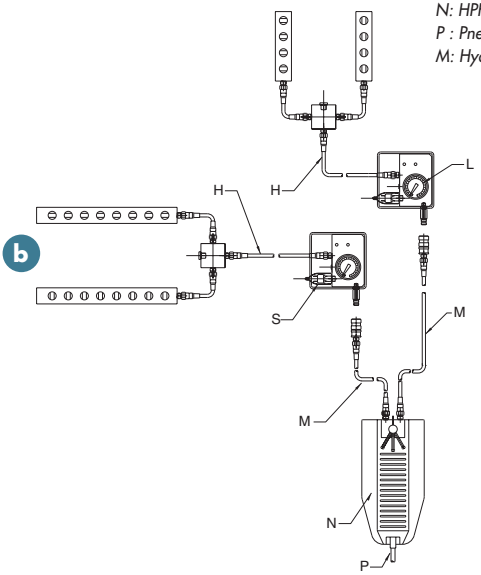
DESCRIPTION

The distribution block is made from treated aluminium and, depending upon the model selected, it has the following equipment:
- Control manometer for hydraulic pressure (calibrated up to 300 bar)
- Electric pressure gauge (only on BDS version)

CONNECTION REFERENCES

U: Movement segments (Rotobilles or Transrollers)
N: HPF 100/ HPMS/D100 pneumo-hydraulic power generator
P : Pneumatic input power supply (6 bar)
M: Hydraulic power supply of block (100 bar): ref. KH1R100.1-2M

b



NB:
If ordering a hydraulic hose, the nozzles must be crimped in the factory. Specify the total length, L (including nozzles).

*** Please specify length for each connecting hose.

SAFETY LOCK

100 bar output

Safety pressure gauge

Feed rate 300 bar maximum

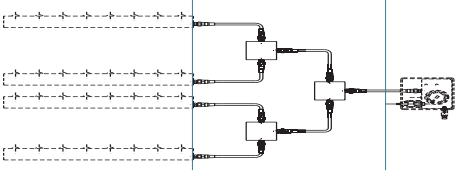
MODELS	FUNCTIONS			SINKS
Safety and distribution block	Manometer	Pressure gauge	Pressure reducer	
BDS 100,1	•	•		Rotobilles or transrollers
BDS 300,1 - 100,1*	•	•	•	Rotobilles or transrollers +Dynabloc (c.f. p.46)

* Max. feed pressure 300 bar

SEGMENT PIPING KITS

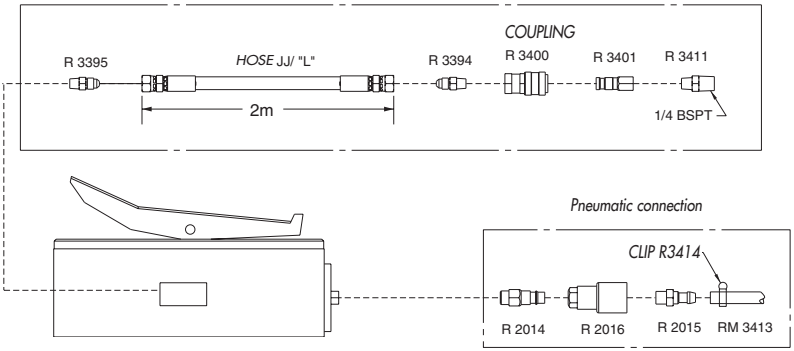
Models	Number of segments connected
KH2R 100.1	2 connected Transrollers or Rotobilles
KH3R 100.1	3 connected Transrollers or Rotobilles
KH4R 100.1	4 connected Transrollers or Rotobilles
KH6R 100.1	6 connected Transrollers or Rotobilles
KH8R 100.1	8 connected Transrollers or Rotobilles

Segments	Kit ref. KH4R 100.1	Power supply



GENERATOR PIPING KITS

KH1R 100.1 (1-2 m.) hydraulic connection kit

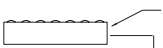


HPF 100/HPMS 100/HPMD 100
Pneumo-hydraulic generator

STANDARD CONNECTIONS AND COMPONENTS USED

The R... references are from ROTOBLOC notices
(to be copied for your orders)

NB
If ordering hydraulic hoses, the nozzles must be crimped in the factory. Please specify total length, L (including nozzles).

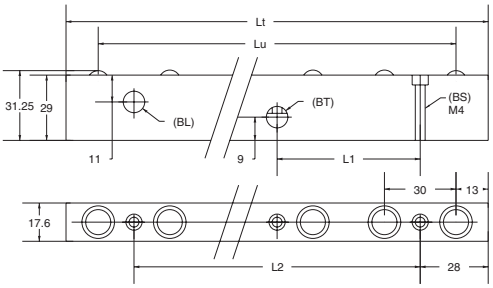


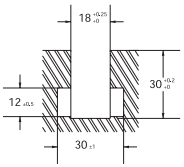
BSPP parallel BSPT Conical	rigid assembly RM 2925	flexible assembly R 3684 RM 1599 37° JIC
1/8 BSPP		R 3402
1/8 BSPT		R 3396
1/8 BSPT		R 3394
1/8 BSPP		R 3405
1/8 BSPT	R 1925	
1/8 BSPP	R 1907	
1/8 BSPT	R 3421	

TURM 18 TUBM 18 Unit	Dimensions Lt mm	 Lu mm	 L1 mm	 L2 mm	 n	Lifting power TUBM F daN (kg)	 TURM F daN (kg)	Weight kg
18 - 86	86	60			3	60	120	0,16
18 - 116	116	90		60	4	80	160	0,20
18 - 146	146	120		90	5	100	200	0,25
18 - 176	176	150		120	6	120	240	0,29
18 - 206	206	180		150	7	140	280	0,33
18 - 236	236	210		180	8	160	320	0,38
18 - 266	266	240		210	9	180	360	0,42
18 - 296	296	270		240	10	200	400	0,47
18 - 326	326	300		270	11	220	440	0,51
18 - 356	356	330		300	12	240	480	0,55
18 - 386	386	360		330	13	260	520	0,60
18 - 416	416	390		360	14	280	560	0,64
18 - 446	446	420		390	15	300	600	0,69
18 - 476	476	450		420	16	320	640	0,73
18 - 506	506	480		450	17	340	680	0,77
18 - 536	536	510		480	18	360	720	0,82
18 - 566	566	540		510	19	380	760	0,86
18 - 596	596	570		540	20	400	800	0,91
18 - 626	626	600		570	21	420	840	0,95
18 - 656	656	630		600	22	440	880	0,99
18 - 686	686	660		630	23	460	920	1,04
18 - 716	716	690		660	24	480	960	1,08
18 - 746	746	720	360	690	25	500	1000	1,13
18 - 776	776	750	360	720	26	520	1040	1,17
18 - 806	806	780	390	750	27	540	1080	1,21
18 - 836	836	810	390	780	28	560	1120	1,26
18 - 866	866	840	420	810	29	580	1160	1,30
18 - 896	896	870	420	840	30	600	1200	1,35
18 - 926	926	900	450	870	31	620	1240	1,39
18 - 956	956	930	450	900	32	640	1280	1,43
18 - 986	986	960	480	930	33	660	1320	1,48
18 - 1016	1016	990	480	960	34	680	1360	1,52
18 - 1046	1046	1020	510	990	35	700	1400	1,57
18 - 1076	1076	1050	510	1020	36	720	1440	1,61
18 - 1106	1106	1080	540	1050	37	740	1480	1,65
18 - 1136	1136	1110	540	1080	38	760	1520	1,70
18 - 1166	1166	1140	570	1110	39	780	1560	1,74
18 - 1196	1196	1170	570	1140	40	800	1600	1,79
18 - 1226	1226	1200	600	1170	41	820	1640	1,83
18 - 1256	1256	1230	600	1200	42	840	1680	1,87
18 - 1286	1286	1260	630	1230	43	860	1720	1,92
18 - 1316	1316	1290	630	1260	44	880	1760	1,96
18 - 1346	1346	1320	660	1290	45	900	1800	2,01
18 - 1376	1376	1350	660	1320	46	920	1840	2,05
18 - 1406	1406	1380	690	1350	47	940	1880	2,09
18 - 1436	1436	1410	690	1380	48	960	1920	2,14
18 - 1466	1466	1440	720	1410	49	980	1960	2,18
18 - 1496	1496	1470	720	1440	50	1000	2000	2,23

General user specifications

V	m/mn	8
D	mm	8
F/nB	daN (kg)	20
F/nR	daN (kg)	40
Cf		0,05





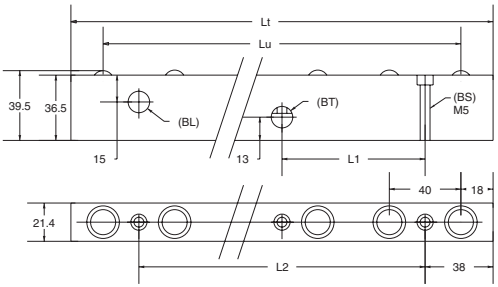
TRANSROLLERS AND ROTOBILLES : MECHANICAL

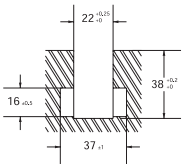
Dimensions and data subject to amendment

TURM 22 TUBM 22 Unit	Dimensions					Lifting power		Weight kg
	Lt mm	Lu mm	L1 mm	L2 mm	n	TUBM F daN (kg)	TURM F daN (kg)	
22 - 116	116	80			3	120	240	0,3
22 - 156	156	120		80	4	160	320	0,4
22 - 196	196	160		120	5	200	400	0,5
22 - 236	236	200		160	6	240	480	0,6
22 - 276	276	240		200	7	280	560	0,7
22 - 316	316	280		240	8	320	640	0,8
22 - 356	356	320		280	9	360	720	0,9
22 - 396	396	360		320	10	400	800	1
22 - 436	436	400		360	11	440	880	1,1
22 - 476	476	440		400	12	480	960	1,2
22 - 516	516	480		440	13	520	1040	1,3
22 - 556	556	520		480	14	560	1120	1,4
22 - 596	596	560		520	15	600	1200	1,5
22 - 636	636	600		560	16	640	1280	1,6
22 - 676	676	640		600	17	680	1360	1,7
22 - 716	716	680		640	18	720	1440	1,7
22 - 756	756	720		680	19	760	1520	1,8
22 - 796	796	760		720	20	800	1600	1,9
22 - 836	836	800		760	21	840	1680	2
22 - 876	876	840		800	22	880	1760	2,1
22 - 916	916	880		840	23	920	1840	2,2
22 - 956	956	920		880	24	960	1920	2,3
22 - 996	996	960		920	25	1000	2000	2,4
22 - 1036	1036	1000	480	960	26	1040	2080	2,5
22 - 1076	1076	1040	480	1000	27	1080	2160	2,6
22 - 1116	1116	1080	520	1040	28	1120	2240	2,7
22 - 1156	1156	1120	520	1080	29	1160	2320	2,8
22 - 1196	1196	1160	560	1120	30	1200	2400	2,9
22 - 1236	1236	1200	560	1160	31	1240	2480	3
22 - 1276	1276	1240	600	1200	32	1280	2560	3,1
22 - 1316	1316	1280	600	1240	33	1320	2640	3,2
22 - 1356	1356	1320	640	1280	34	1360	2720	3,3
22 - 1396	1396	1360	640	1320	35	1400	2800	3,3
22 - 1436	1436	1400	680	1360	36	1440	2880	3,4
22 - 1476	1476	1440	680	1400	37	1480	2960	3,5
22 - 1516	1516	1480	720	1440	38	1520	3040	3,6
22 - 1556	1556	1520	720	1480	39	1560	3120	3,7
22 - 1596	1596	1560	760	1520	40	1600	3200	3,8
22 - 1636	1636	1600	760	1560	41	1640	3280	3,9
22 - 1676	1676	1640	800	1600	42	1680	3360	4
22 - 1716	1716	1680	800	1640	43	1720	3440	4,1
22 - 1756	1756	1720	840	1680	44	1760	3520	4,2
22 - 1796	1796	1760	840	1720	45	1800	3600	4,3
22 - 1836	1836	1800	880	1760	46	1840	3680	4,4
22 - 1876	1876	1840	880	1800	47	1880	3760	4,5
22 - 1916	1916	1880	920	1840	48	1920	3840	4,6
22 - 1956	1956	1920	920	1880	49	1960	3920	4,7
22 - 1996	1996	1960	960	1920	50	2000	4000	4,8

General user specifications

V	m/mn	10
D	mm	12
F/nB	daN (kg)	40
F/nR	daN (kg)	80
Cf		0,05



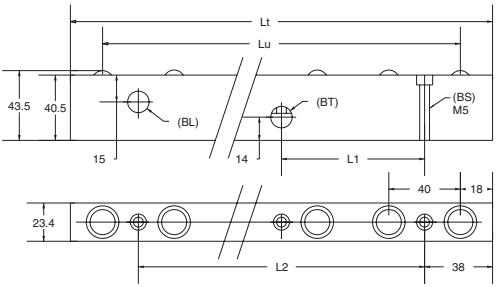


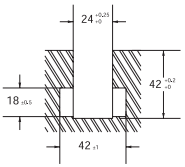
Dimensions and data subject to amendment

TURM 24 TUBM 24 Unit	Dimensions Lt mm	Lu mm	L1 mm	L2 mm	n	Lifting power TUBM F daN (kg)	TURM F daN (kg)	Weight kg
24 - 116	116	80			3	120	240	0,4
24 - 156	156	120		80	4	160	320	0,5
24 - 196	196	160		120	5	200	400	0,6
24 - 236	236	200		160	6	240	480	0,7
24 - 276	276	240		200	7	280	560	0,8
24 - 316	316	280		240	8	320	640	1
24 - 356	356	320		280	9	360	720	1,1
24 - 396	396	360		320	10	400	800	1,2
24 - 436	436	400		360	11	440	880	1,3
24 - 476	476	440		400	12	480	960	1,4
24 - 516	516	480		440	13	520	1040	1,5
24 - 556	556	520		480	14	560	1120	1,6
24 - 596	596	560		520	15	600	1200	1,7
24 - 636	636	600		560	16	640	1280	1,8
24 - 676	676	640		600	17	680	1360	1,9
24 - 716	716	680		640	18	720	1440	2,1
24 - 756	756	720		680	19	760	1520	2,2
24 - 796	796	760		720	20	800	1600	2,3
24 - 836	836	800		760	21	840	1680	2,4
24 - 876	876	840		800	22	880	1760	2,5
24 - 916	916	880		840	23	920	1840	2,6
24 - 956	956	920		880	24	960	1920	2,7
24 - 996	996	960		920	25	1000	2000	2,8
24 - 1036	1036	1000	480	960	26	1040	2080	2,9
24 - 1076	1076	1040	480	1000	27	1080	2160	3
24 - 1116	1116	1080	520	1040	28	1120	2240	3,2
24 - 1156	1156	1120	520	1080	29	1160	2320	3,3
24 - 1196	1196	1160	560	1120	30	1200	2400	3,4
24 - 1236	1236	1200	560	1160	31	1240	2480	3,5
24 - 1276	1276	1240	600	1200	32	1280	2560	3,6
24 - 1316	1316	1280	600	1240	33	1320	2640	3,7
24 - 1356	1356	1320	640	1280	34	1360	2720	3,8
24 - 1396	1396	1360	640	1320	35	1400	2800	3,9
24 - 1436	1436	1400	680	1360	36	1440	2880	4
24 - 1476	1476	1440	680	1400	37	1480	2960	4,1
24 - 1516	1516	1480	720	1440	38	1520	3040	4,3
24 - 1556	1556	1520	720	1480	39	1560	3120	4,4
24 - 1596	1596	1560	760	1520	40	1600	3200	4,5
24 - 1636	1636	1600	760	1560	41	1640	3280	4,6
24 - 1676	1676	1640	800	1600	42	1680	3360	4,7
24 - 1716	1716	1680	800	1640	43	1720	3440	4,8
24 - 1756	1756	1720	840	1680	44	1760	3520	4,9
24 - 1796	1796	1760	840	1720	45	1800	3600	5
24 - 1836	1836	1800	880	1760	46	1840	3680	5,1
24 - 1876	1876	1840	880	1800	47	1880	3760	5,2
24 - 1916	1916	1880	920	1840	48	1920	3840	5,4
24 - 1956	1956	1920	920	1880	49	1960	3920	5,5
24 - 1996	1996	1960	960	1920	50	2000	4000	5,6

General user specifications

V	m/mn	10
D	mm	12
F/nB	daN (kg)	40
F/nR	daN (kg)	80
Cf		0,05



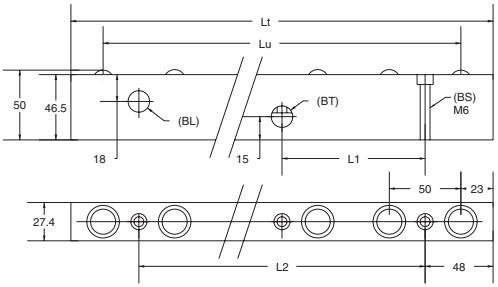


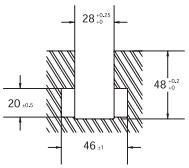
Dimensions and data subject to amendment

TURM 28 TUBM 28 Unit	Dimensions Lt mm	Lu mm	L1 mm	L2 mm	n	Lifting power TUBM F daN (kg)	TURM F daN (kg)	Weight kg
28 - 146	146	100			3	180	360	0,7
28 - 196	196	150		100	4	240	480	0,9
28 - 246	246	200		150	5	300	600	1,1
28 - 296	296	250		200	6	360	720	1,3
28 - 346	346	300		250	7	420	840	1,5
28 - 396	396	350		300	8	480	960	1,7
28 - 446	446	400		350	9	540	1080	1,9
28 - 496	496	450		400	10	600	1200	2,1
28 - 546	546	500		450	11	660	1320	2,3
28 - 596	596	550		500	12	720	1440	2,5
28 - 646	646	600		550	13	780	1560	2,7
28 - 696	696	650		600	14	840	1680	2,9
28 - 746	746	700		650	15	900	1800	3,1
28 - 796	796	750		700	16	960	1920	3,2
28 - 846	846	800		750	17	1020	2040	3,4
28 - 896	896	850		800	18	1080	2160	3,6
28 - 946	946	900		850	19	1140	2280	3,8
28 - 996	996	950		900	20	1200	2400	4
28 - 1046	1046	1000		950	21	1260	2520	4,2
28 - 1096	1096	1050		1000	22	1320	2640	4,4
28 - 1146	1146	1100		1050	23	1380	2760	4,6
28 - 1196	1196	1150	550	1100	24	1440	2880	4,8
28 - 1246	1246	1200	550	1150	25	1500	3000	5
28 - 1296	1296	1250	600	1200	26	1560	3120	5,2
28 - 1346	1346	1300	600	1250	27	1620	3240	5,4
28 - 1396	1396	1350	650	1300	28	1680	3360	5,6
28 - 1446	1446	1400	650	1350	29	1740	3480	5,8
28 - 1496	1496	1450	700	1400	30	1800	3600	6
28 - 1546	1546	1500	700	1450	31	1860	3720	6,2
28 - 1596	1596	1550	750	1500	32	1920	3840	6,4
28 - 1646	1646	1600	750	1550	33	1980	3960	6,6
28 - 1696	1696	1650	800	1600	34	2040	4080	6,8
28 - 1746	1746	1700	800	1650	35	2100	4200	7
28 - 1796	1796	1750	850	1700	36	2160	4320	7,1
28 - 1846	1846	1800	850	1750	37	2220	4440	7,3
28 - 1896	1896	1850	900	1800	38	2280	4560	7,5
28 - 1946	1946	1900	900	1850	39	2340	4680	7,7
28 - 1996	1996	1950	950	1900	40	2400	4800	7,9
28 - 2046	2046	2000	950	1950	41	2460	4920	8,1
28 - 2096	2096	2050	1000	2000	42	2520	5040	8,3
28 - 2146	2146	2100	1000	2050	43	2580	5160	8,5
28 - 2196	2196	2150	1050	2100	44	2640	5280	8,7
28 - 2246	2246	2200	1050	2150	45	2700	5400	8,9
28 - 2296	2296	2250	2 x 750	2200	46	2760	5520	9,1
28 - 2346	2346	2300	2 x 750	2250	47	2820	5640	9,3
28 - 2396	2396	2350	2 x 750	2300	48	2880	5760	9,5
28 - 2446	2446	2400	2 x 800	2350	49	2940	5880	9,7

General user specifications

V	*m/mn*	*12*
D	*mm*	*15*
F/nB	*daN (kg)*	*60*
F/nR	*daN (kg)*	*120*
Cf		*0,05*

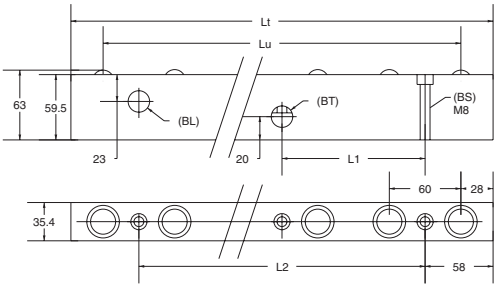


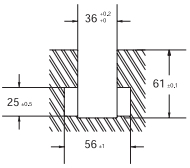


TURM 36 TUBM 36 Unit	Dimensions Lt mm	Lu mm	L1 mm	L2 mm	n	Lifting power TUBM F daN (kg)	TURM F daN (kg)	Weight kg
36 - 176	176	120			3	300	600	1,3
36 - 236	236	180		120	4	400	800	1,7
36 - 296	296	240		180	5	500	1000	2,1
36 - 356	356	300		240	6	600	1200	2,5
36 - 416	416	360		300	7	700	1400	2,9
36 - 476	476	420		360	8	800	1600	3,2
36 - 536	536	480		420	9	900	1800	3,6
36 - 596	596	540		480	10	1000	2000	4
36 - 656	656	600		540	11	1100	2200	4,4
36 - 716	716	660		600	12	1200	2400	4,8
36 - 776	776	720		660	13	1300	2600	5,1
36 - 836	836	780		720	14	1400	2800	5,5
36 - 896	896	840		780	15	1500	3000	5,9
36 - 956	956	900		840	16	1600	3200	6,3
36 - 1016	1016	960		900	17	1700	3400	6,7
36 - 1076	1076	1020		960	18	1800	3600	7,0
36 - 1136	1136	1080		1020	19	1900	3800	7,4
36 - 1196	1196	1140		1080	20	2000	4000	7,8
36 - 1256	1256	1200		1140	21	2100	4200	8,2
36 - 1316	1316	1260	600	1200	22	2200	4400	8,6
36 - 1376	1376	1320	600	1260	23	2300	4600	8,9
36 - 1436	1436	1380	660	1320	24	2400	4800	9,3
36 - 1496	1496	1440	660	1380	25	2500	5000	9,7
36 - 1556	1556	1500	720	1440	26	2600	5200	10,1
36 - 1616	1616	1560	720	1500	27	2700	5400	10,5
36 - 1676	1676	1620	780	1560	28	2800	5600	10,8
36 - 1736	1736	1680	780	1620	29	2900	5800	11,2
36 - 1796	1796	1740	840	1680	30	3000	6000	11,6
36 - 1856	1856	1800	840	1740	31	3100	6200	12,0
36 - 1916	1916	1860	900	1800	32	3200	6400	12,4
36 - 1976	1976	1920	900	1860	33	3300	6600	12,7
36 - 2036	2036	1980	960	1920	34	3400	6800	13,1
36 - 2096	2096	2040	960	1980	35	3500	7000	13,5
36 - 2156	2156	2100	1020	2040	36	3600	7200	13,9
36 - 2216	2216	2160	1020	2100	37	3700	7400	14,3
36 - 2276	2276	2220	1080	2160	38	3800	7600	14,6
36 - 2336	2336	2280	1080	2220	39	3900	7800	15,0
36 - 2396	2396	2340	1140	2280	40	4000	8000	15,4
36 - 2456	2456	2400	1140	2340	41	4100	8200	15,8
36 - 2516	2516	2460	1200	2400	42	4200	8400	16,2
36 - 2576	2576	2520	2 x 840	2460	43	4300	8600	16,5
36 - 2636	2636	2580	2 x 840	2520	44	4400	8800	16,9
36 - 2696	2696	2640	2 x 840	2580	45	4500	9000	17,3
36 - 2756	2756	2700	2 x 900	2640	46	4600	9200	17,7
36 - 2816	2816	2760	2 x 900	2700	47	4700	9400	18,0
36 - 2876	2876	2820	2 x 900	2760	48	4800	9600	18,4
36 - 2936	2936	2880	2 x 960	2820	49	4900	9800	18,8
36 - 2996	2996	2940	2 x 960	2880	50	5000	10000	19,2

General user specifications

V	*m/mn*	*15*
D	*mm*	*19*
F/nB	*daN (kg)*	*100*
F/nR	*daN (kg)*	*200*
Cf		*0,05*





SMOOTH MECHANICAL BALL OR ROLLER CARTRIDGES

CBML - CRML

ROTOBLOC-PSP GROUPE DIMECO

Dimensions and data subject to amendment

APPLICATION

These smooth types of cartridges are operating equipment designed to be housed in table bore holes so as to allow tools to be moved easily.
The cartridges are often used when the option of installing Transrollers or Rotobilles is tricky or impossible.

DESCRIPTION

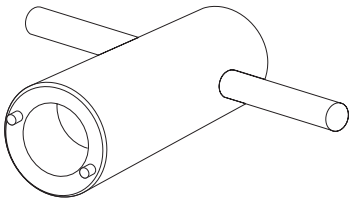
*The upper bearing element of the cartridges may be: ball (CB**) or roller (CR**).*
These bearings are lifted up thanks to a mechanical action (spring loaded)
- The mechanical action particular to each cartridge supports the load F on the stroke E.
- The cartridges are fitted directly into drilled holes. An elastomer joint (o-ring) inserted in a groove allows them to be immobilised. The base of a mechanical cartridge includes a height adjustment mechanism.
Roller cartridges are oriented using pin tools.
The cartridges may be extracted using screws in the M4 female thread holes, G.

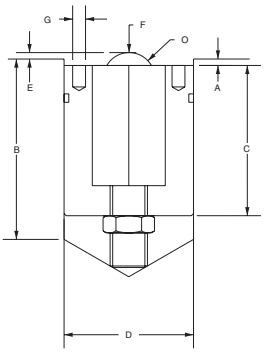
TO ORDER

Quote the complete reference details of the cartridge.
E.g.: cartridge CRML 28
Smooth mechanically-operated roller cartridge, drilling Ø 35.25.

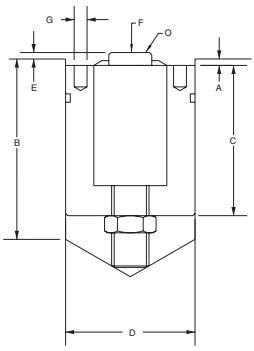
Tools for cartridges

Reference data	
D = 30,25	*OTL 30*
D = 35,25	*OTL 35*





CBML



CRML

MODELS	A mm	B mm	C mm	D H11/mm	E mm	F daN	G mm	O mm
CBML 22	1,5	42	36,5	30,25	1,5	40	3,3	12
CBML 28	1,5	49	44,5	35,25	2	60	3,3	15
CRML 22	1,5	42	36,5	30,25	1,5	80	3,3	12
CRML 28	1,5	49	44,5	35,25	2	120	3,3	15

APPLICATION

These types of threaded cartridges are movement equipment designed to be fitted in press bed bore holes to allow tools to be moved easily.
The cartridges are often used when the option of installing Transrollers or Rotobilles is tricky or impossible.

DESCRIPTION

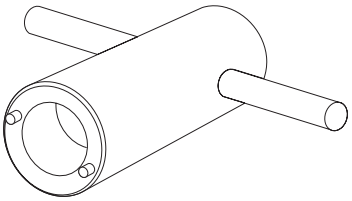
*The upper bearing element of the cartridges may be: ball (CB**) or roller (CR**).*
These bearings are lifted up thanks to a mechanical action.
- The mechanical action particular to each cartridge supports the load F on the stroke E
- - The cartridges are mounted directly into the threaded holes. The cartridges are immobilised through the application of a light coating of anaerobic glue to the thread. The disassembly and/or orientation of roller cartridges are carried out using a pin tool and the holes, G.

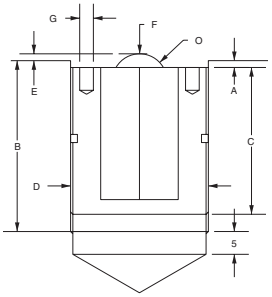
TO ORDER

Quote the complete reference number of the cartridge.
E.g.: cartridge CRMF 28
Threaded mechanically operated roller cartridge, M 35 thread, 1.5 lead.

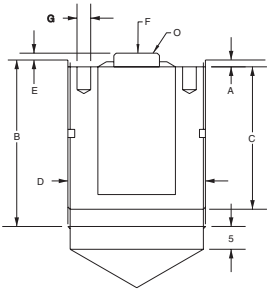
Tools for cartridges

Reference data	
D = M30	*OTL 30*
D = M35	*OTL 35*





CBMF



CRMF

MODELS	A mm	B mm	C mm	D H11/mm	E mm	F daN	G mm	O mm
CBMF 22	1,5	42	36,5	M30 x 1,5	1,5	40	3,3	12
CBMF 28	1,5	50	44,5	M35 x 1,5	2	60	3,3	15
CRMF 22	1,5	42	36,5	M30 x 1,5	1,5	80	3,3	12
CRMF 28	1,5	50	44,5	M35 x 1,5	2	120	3,3	15

APPLICATION

TBU and TRU* modules are operating equipment designed to be fitted in press bed bore holes to allow tools to be moved easily.*
TBU and TRU* modules are often used when the option of installing Transrollers or Rotobilles is tricky or impossible.*

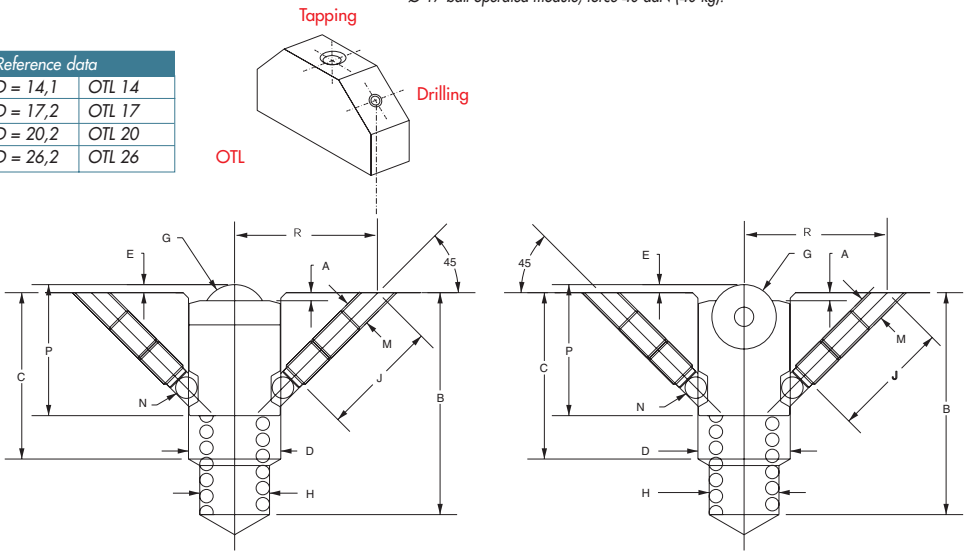
DESCRIPTION

*The upper bearing element of the modules may be: ball (CB**) or roller (CR**).*
These bearings are lifted up using a spring placed directly beneath the module. The action of the spring allows to support the load F on the stroke E.
The modules are mounted into drilled holes. The axial immobilisation, the stroke of the module and its direction are obtained using a ball-operated stop mechanism and a locking screw. The 45° drilling of the immobilisation hole is carried out using a jig bush that is available.

TO ORDER

Quote the complete reference details of the cartridge.
E.g.: cartridge TBU 22
Ø 17 ball-operated module, force 40 daN (40 kg).

Reference data	
D = 14,1	*OTL 14*
D = 17,2	*OTL 17*
D = 20,2	*OTL 20*
D = 26,2	*OTL 26*



MODELS	A mm	B mm	C mm	D H11/mm	E mm	F daN	G mm	H mm	J mm	M mm	N mm	P mm	R mm
TBU/TRU 18	0,5	34,5	23	14,1	1	20	8	10	12	M4	3	19	17,5
TBU/TRU 22	1,5	41,4	31	17,2	1	40	12	13	22	M5	4	27	26,7
TBU/TRU 28	1,5	49,7	38	20,2	1	60	15	16	30	M5	4	33,8	33,5
TBU/TRU 36	1,5	55,1	47	26,2	1	100	18	16	40	M6	5	43,5	44,1

PATENTED

TOTAL CONTROL OF GAS SPRING ALLOWS ROTOBLOC TO APPLY THE NITROGEN CYLINDER TECHNIQUE TO AUTOMATIC PRESS CLAMPING

PRINCIPAL RISKS OR DISADVANTAGES OF STANDARD AUTOMATIC CLAMPING TECHNIQUES:

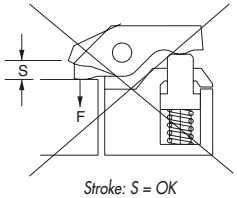
- Hydraulic clamping with single or dual-action circuit

- REMINDER:
Whether they are of the single-action (high pressure) or dual action (average pressure) type, all traditional hydraulic solutions require a permanent hydraulic connection between the hydraulic generator and the clamps.
- RISK OF HYDRAULIC HOSES BURSTING:
Under pressure, hoses become hard, extremely rigid and suffer enormous fatigue, especially when they have to undergo variations in curvature.
E.g.: Connection between the frame (fixed) and the ram (mobile).
- COMPLEXITY OF INSTALLATION:
In order to obtain an adequate level of security, you need to create independent hydraulic circuits on each press and to continuously control the pressure on each circuit. This type of installation requires a hydraulic unit with a complex valve system.
- HIGH LEVEL OF INVESTMENT:
This is directly connected to the complexity of installation referred to above and to the performance levels of components.
- SIGNIFICANT MAINTENANCE :
In order to avoid any risk of accident, you need to control and replace the hydraulic hoses or other connecting items frequently.

- Spring, spring washer, elastomer clamping etc. (and hydraulic unclamping)

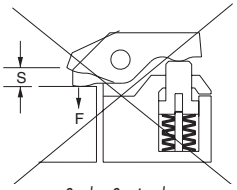
- INADEQUATE PERFORMANCE LEVELS:
The compromise between force, stroke and bulk is never satisfactorily resolved.
- CRITICAL VIBRATIONS:
The coincidence of press vibration frequencies with the actual frequency of one of the above systems may cause the tool to move.

Spring clamping



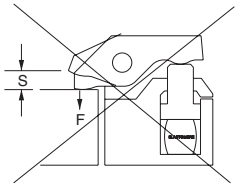
Stroke: S = OK
Force: F = inadequate

Spring washer clamping



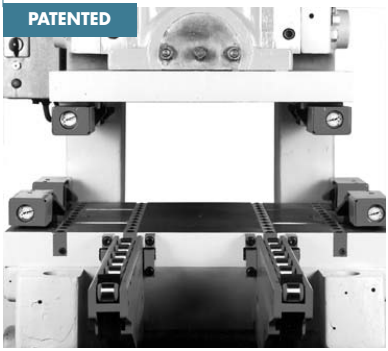
Stroke: S = inadequate
Force: F = OK

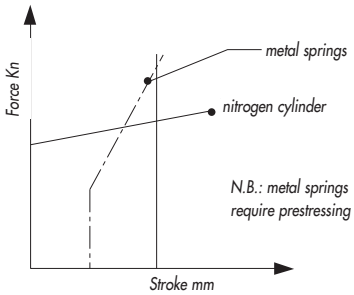
Elastomer clamping



According to Schore hardness:
S: if stroke OK, force inadequate
F: if force OK, stroke inadequate

PATENTED





WHY CHOOSE A SOLUTION WHERE THE CLAMPING ENERGY IS A NITROGEN CHARGE INTEGRATED INTO THE BODY OF THE CLAMP?

INDEPENDENT CLAMPING = TOTAL SECURITY

As each clamp possesses its own clamping energy, the effectiveness of the tightening joint is solely and directly connected to the performance of each clamp, the reliability of the installation no longer depends upon complex external equipment such as hydraulic units or valve systems.
As for hydraulic hoses, there is very little demand for them as they are solely used for the unclamping function when the press is stopped.

COMPRESSED NITROGEN BEST BALANCE: FORCE + STROKE + BULK

REDUCED INVESTMENT

The lack of a large hydraulic unit, sophisticated hydraulic distribution, complex installation and costly and time-consuming commissioning brings a considerable reduction in investment levels.
The hydraulic pressure generator (a pneumo-hydraulic pump) is reduced to its simplest form.
As it is only required in order to open clamps when the press is stopped, one hydraulic pressure generator may serve all the presses in the workshop.

REDUCED MAINTENANCE COSTS

Built using gas spring tightening and manufacturing techniques, the DYNABLOC clamp has an exceptional life expectancy (many millions of cycles).
If it is dismantled accidentally, it is as simple to fill as a car tyre.
Nitrogen bottles are available at all specialist stores.

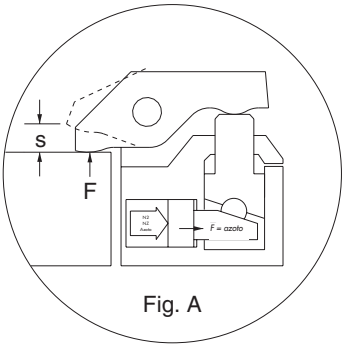
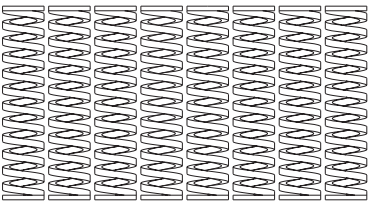
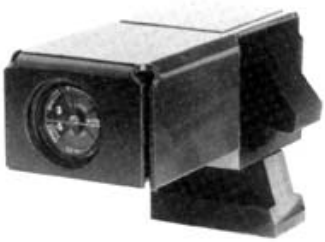


Fig. A



F = nitrogen

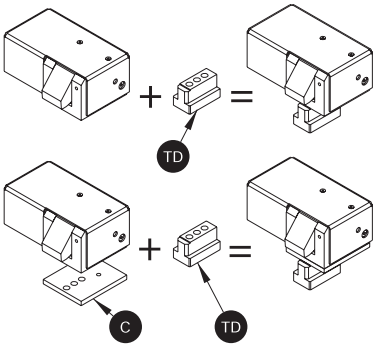
PATENTED



NHLC DYNABLOCS are semi-autonomous gas clamps with hydraulic loosening. They are used for quick clamping of press tools... The independence of DYNABLOC gas clamping offers a higher level of security than traditional hydraulic techniques with a single or double action circuit.

DESCRIPTION

NHLC DYNABLOCS are of the "normally closed" type upon hydraulic opening. As it is irreversible, a mechanism combining a sloping ramp and a lever provides a guarantee that the clamping force will be maintained whatever the frequency of the vibrations encountered (fig. A).
A graduated dial constantly displays the clamping force applied.



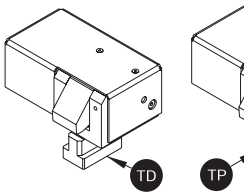
ADVANTAGES

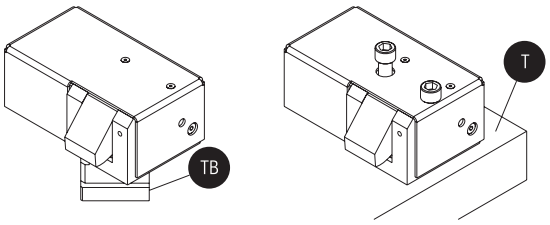
- Autonomy:
The integrated clamping energy allows you to do without any permanent hydraulic connection.
- Bulk:
The lateral mounting of the power cylinder makes the clamp very small in the clamping direction, which maximises space for the tool on the plate (table or slide block).
- Lack of hydraulic unit:
Normally closed (nitrogen load), DYNABLOCS only use hydraulic action when opening. The generators are simple small single pumps without a sophisticated valve system.
E.g.: HPF 300, HPMS 300, HPDMD 300 pneumo-hydraulic generator etc.

ASSEMBLY

Initial DYNABLOC assembly may be carried out using straight T-bolts (TD) with special or standard sections complying with the DIN 650 standard (see dimensional table 2). Orientated T-bolts (TB), (TP) may also equip the body of DYNABLOCS for special applications. In any case, the body of the clamp must sit completely on the table during clamping.
A standard or special additional wedge (C) may be added in any case to provide a special clamping height.
DYNABLOCS may be screwed directly onto tables (T) for fixed placement.

N.B.: T-bolt assembly (carried out in the factory) or screw assembly onto a table is carried out using high coupling-resistance screws and a specified tightening procedure. Please see the technical notice concerned.





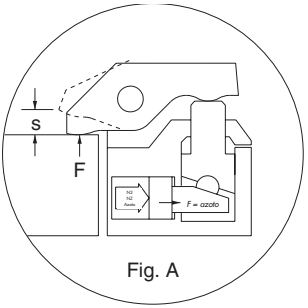
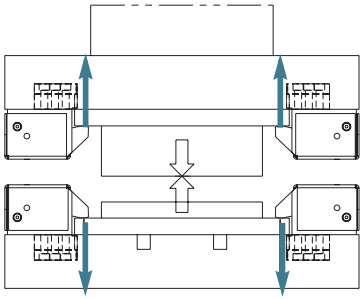


Fig. A

PATENTED

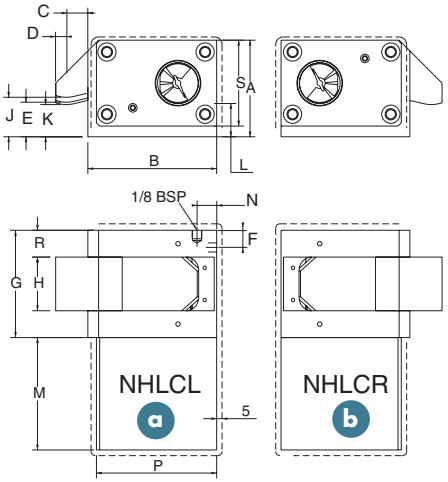


DETERMINING OF CLAMPING FORCE : Mechanical press

For pressing/drawing, the force necessary to clamp the tool is directly dependent upon a number of parameters, the principal ones being: rigidity of the frame, speed of the press, material worked on, stripping force, force distribution and tool mass. The irreversibility of the internal mechanism (fig. A) gives this type of clamp a very high resistance to loosening; this is why the clamping power option required is often much lower than that required with traditional hydraulic clamping. As a rule of thumb, for a total power installed figure take 12% to 15% of the power of the press distributed as follows: 8% to 10% on the slide block and around 4% to 6% on the table. To obtain the power of each DYNABLOC, divide the power calculated by the number of DYNABLOCS installed.

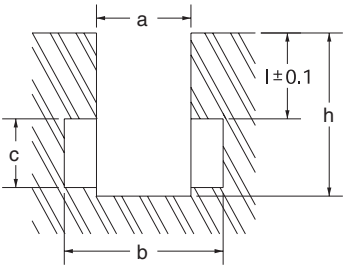
E.g. :
200-T. mechanical arch press = potential installation of 4 clamps on the slide block + 4 clamps on the table: Slide block: 200 T. x 0.08 = 16 T. or 4 x NHLC 40K dynablocs.
Table: 200 T. x 0.04 = 8 T. or 4 x NHLC 20K dynablocs.

TABLE 1 Specifications		NHLC 20 K	NHLC 40 K	NHLC 60 K	NHLC 100 K
Height	A	60	75	90	105
Body lengths	B	73	105	120	150
Nominal support	C	15	17	20	22
Joint tilt (axial)	D	7,5	7,5	10	10
Nominal height	E	20	25	30	35
Hydraulic port	F	16	16	16	16
Body width	G	70	80	100	120
Joint width	H	30	40	50	60
Max. height	J	22	28	33	39
Min. height	K	16	21	25	30
Hydraulic port	L	22	29,5	31	35
Tank length	M	81	94	105	108
Hydraulic port	N	11	16,5	18,5	24,5
Tank width	P	68	97	112	143
Joint tilt (transversal)	R	20	20	25	30
Tank height	S	50	64	80	95
Nominal force kg (DaN)		2000	4000	6000	10000
Nom. clamping pressure (Bar)		300	300	300	300
Nominal temperature		20° C	20° C	20° C	20° C
Min.		10° C	10° C	10° C	10° C
Max.		50° C	50° C	50° C	50° C
Oil vol. (cm^3)		8,7	20,1	36,5	70,7



a = *so-called "LEFT SIDE" model*
b = *so-called "RIGHT SIDE" model*

Table 2 - DIN 650				
a	b	C	h	l
18	30	12	30	18
22	37	16	38	22
28	46	20	48	28
36	56	25	61	36
24	42	18	42	24



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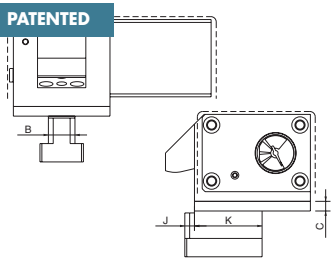


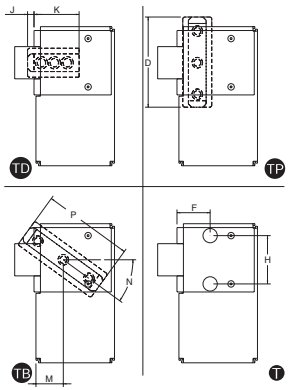


Table 3 shows the dimensions of standard T-bolts and assemblies for the different DYNABLOC models. Special T-bolts may be produced on demand.

ORDER IDENTIFICATION

Complete the following grid:

1	2	3	4	5

Specify the references for your DYNABLOC order as defined below.

1. *Choose "left side" or "right side" model (fig. B, p.44), see previous page.*
   L: Left; R: Right.

2. *Choose force according to needs (table 1)*
   e.g.: DYNABLOC 20K (2000 kg tightening force)
   reference: 20K.

3. *Choice of mode of attachment according to slot or requirements (tables 2 and 3)*
   e.g.: Straight T-bolt arbor for slot a = 22 under
   DIN 650 standard - ref.: TD 22.

4. *Addition of standard 10-mm. thick wedge*
   reference: C 10 (if required).

5. *In the case of a special T-bolt for slot a = 10, l = 18, c = 15, b = 29*
   reference: TS a20 = L18 – c15 – b29.

General example: DYNABLOC NHLCR 20 K TD 22 C10
N.B.: the "l" dimension must be given to an accuracy of ± 0.1 mm.

The SHS supports on which the DYNABLOCS can be rested are recommended for the temporary positioning of the latter when changing a tool. See the SHS supports page to make an appropriate choice from among these supports.

TABLE 3 Version	Clamps	D	E	F	H	J	K	M	N	P	R	Slots a 18	22	28	36	Wedge C
TD T-bolt	20 K					10	60					X	X	X		X
	40 K					10	70						X	X		X
	60 K					10	80						X	X	X	X
	100 K					10	95							X	X	X
TP T-bolt	20 K	90	14									X	X	X		X
	40 K	100	14										X	X		X
	60 K	120	18										X	X	X	X
	100 K	140	18											X	X	X
TB T-bolt	20 K							32	55	105		X	X	X		X
	40 K							39	50	118			X	X		X
	60 K							45	54	138			X	X	X	X
	100 K							53	52	164				X	X	X
Attachment	20 K			30, 5	50						M10					X
on the table T	40 K			47	60						M12					X
	60 K			51,5	75						M14					X
	100 K			65	90						M18					X

HPF 300

HPMS 300 - HPMD 300

TO ORDER

Quote the complete reference details of the pump.
E.g.: Pump HPF 300;
Pump HPMS 300;
Pump HPMD 300.

** Pos. H = Horizontal position;*
Pos. V = Vertical position.

APPLICATION

HPF and HPMS pressure generators are pneumo-hydraulic power units that allow you to operate components that only require a low flow rate (Rotoballs or Transrollers).

DESCRIPTION

HPF and HPMS pressure generators are units with an anti-shock resin body forming a tank and containing a dynamic intensifier that transforms network supplied compressed air into hydraulic energy. The hydraulic action is of the single action type. The generators include a safety valve that limits hydraulic pressure so as to avoid overloading the sinks.

USE: HPF model

single foot pedal action operate the generator
- Position 1: generator feed oil until nominal pressure is reached
- Position 2 (no foot action) :
hydraulic circuit is closed,pressure keep on in rotoballs,generator is not opereting
- Position 3 : oil retun to generator, pressure is down

USE: HPMS/D model

The HPMS/D 300 pressure generator may power any of the following:
- A set of Dynablocs powered simultaneously by a single hydraulic circuit.
- Two sets of Dynablocs powered by two separate hydraulic circuits.

***a** - Powering a set of Dynablocs with simultaneous power supply*
- Manual valve turned to meet the connected circuit.
- If you press control #1 the unit powers the sink up to the nominal pressure of the generator (c.f. next page).
- If you release control #1 (spring return) the pressure to the sink is maintained.
- To put the pressure to the sink in reverse you just need to reposition the manual switch to a central position (c.f. next page).

***b** - Powering two sets of Dynablocs that are powered separately*
Same procedure as previous paragraph (a), but select pressurisation of the sink required (c.f. next page).
N.B.: Using a valve to select a circuit simultaneously puts the other circuit into reverse.

A mounting deck is available as an accessory for the HPMS/D.
The HPMS/D pneumo-hydraulic generator may be mounted vertically.

Specifications	Unit	HPF 300	HPMS 300	HPMD 300
Air pressure	bar	5	5	5
Oil pressure	bar	300	300	300
Air connection		BSPP	1/4 G	1/4 G
Oil connection		3/8 BSPP	1/4 G	1/4 G
Vacuum capacity	L/min	0,8	1,4	1,4
Tank volume L	L	1,4	* Pos. o:2,4 - Pos. v:2,1	Pos. o:2,4 - Pos. v:2,1
Hydraulic outlet No.		1	1	2
Mass	kg	5	5,7	5,7
Length	mm	295	404	404
Width	mm	145	209	209
Height	mm	170	233	233

MODELS		FUNCTIONS	LABEL
BDS 300	BDS 300.1 100.1		
•	•	Hydraulic circuit for unclamping lower DYNABLOCS	D
•	•	Hydraulic circuit for unclamping upper DYNABLOCS	E
	•	Hydraulic circuit for working Transrollers or Rotobilles	H
•	•	Electric pressure gauge for press functioning authorisation	S

DISTRIBUTION AND SAFETY BLOCKS
(accessory indispensable to "DYNABLOC SYSTEM")

DEFINITION

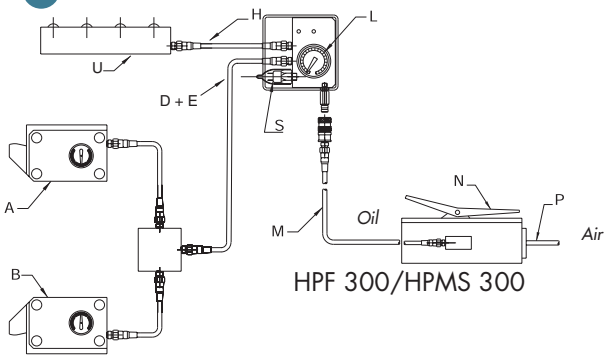
BDS blocks etc. are distribution blocks specially designed for use of the DYNABLOC principle, with or without hydraulic movement segments.
Powered by hydraulic pressure generators, they allow you:
- to clamp or unclamp DYNABLOCS that are installed
- to operate Transrollers or Rotobilles
- to carry out both functions simultaneously

N.B. Depending upon the choice of distribution block, an electric pressure gauge controls the clamping circuit pressure and gives the authorisation of start to the press.

DESCRIPTION

The distribution block is made from treated aluminium and, depending upon the model selected, it has the following equipment:
- Manometer to control hydraulic pressure (300 bar): Item L
- Electric pressure gauge: Item S.

a

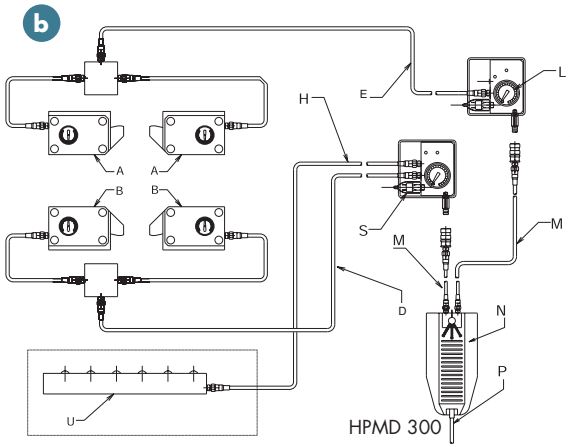


HPF 300/HPMS 300

HYDRAULIC CONNECTION DIAGRAM OF THE DIFFERENT COMPONENTS OF THE "DYNABLOC" CLAMPING SYSTEM

Ref. / Connections
A: Upper DYNABLOCS (slide block)
B: Lower DYNABLOCS (table)
U: Movement segments (Rotobilles or Transrollers)
N: Pneumo-hydraulic generator
P: Main Pneumatic supply (5 bars)
M:: Hydraulic supply to block (300 bar)

b



HPMD 300

DISTRIBUTION AND SAFETY BLOCK

100 bar output

300 bar output

Safety pressure gauge

Hydraulic supply 300 bar maximum

NB

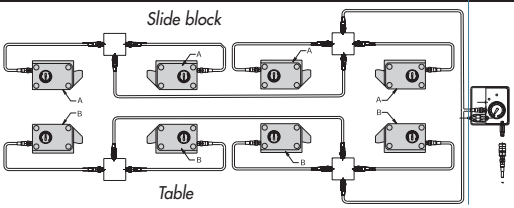
If ordering a hydraulic hose, the nozzles must be crimped in the factory. Specify the total length, L (including nozzles).

DYNABLOC PIPING KITS

Models	Number of Dynablocs
KH2NH 300.1	2 Dynabloc
KH2 + 2NH 300.1	4 Dynabloc
KH4 + 4NH 300.1	8 Dynabloc
KH6 + 6NH 300.1	12 Dynabloc

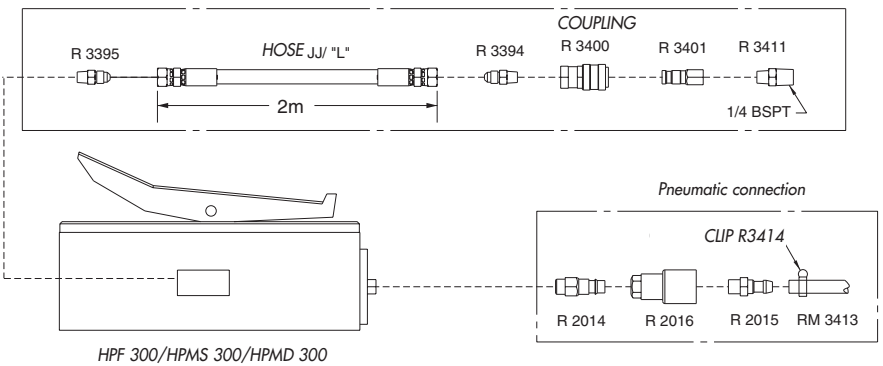
If rotobilles or transrollers, add a segment piping kit (c.f. page 31)

KH4 + 4NH 300.1 Kit | **Power supply**



GENERATOR PIPING KITS

KH1R 300.1 (1-2 m.) hydraulic connection kit



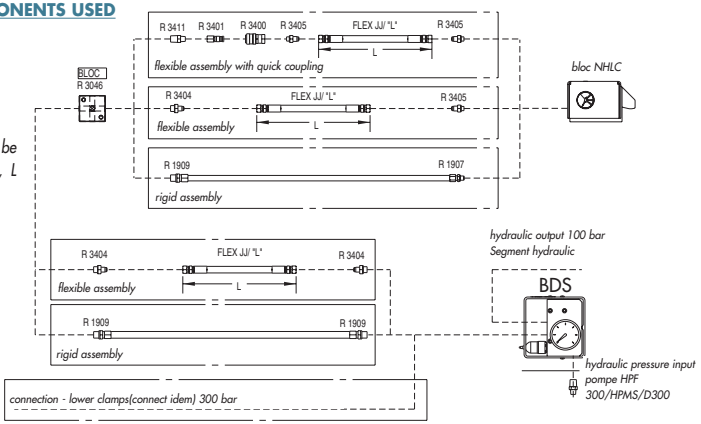
HPF 300/HPMS 300/HPMD 300
Pneumo-hydraulic generator

STANDARD CONNECTIONS AND COMPONENTS USED

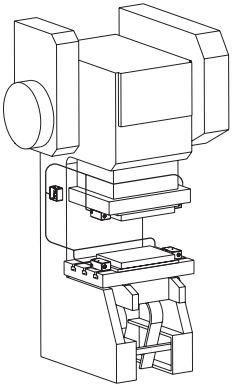
The R... references are from ROTOBLOC notices (to be copied for your orders)

NB

If ordering hydraulic flexible hoses, the nozzles must be crimped in the factory. Please specify total length, L (including nozzles).

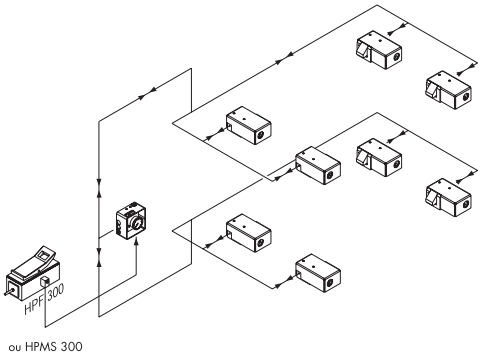


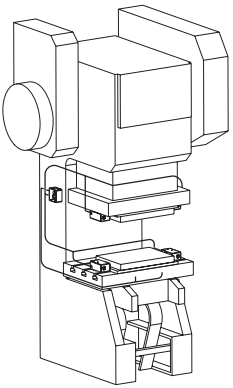
AUTONOMOUS CLAMPING = THANKS TO DYNABLOC, ROTO-BLOC IS OFFERING YOU A COMPLETE SOLUTION



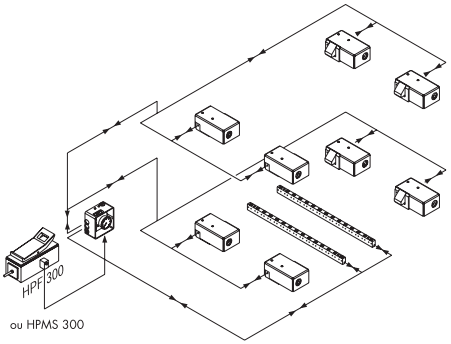
DYNABLOC: STANDARD APPLICATIONS

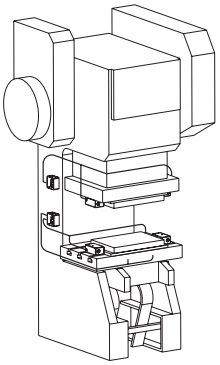
APPLITION A : DYNABLOC SYSTEM WITHOUT HYDRAULIC SEGMENTS





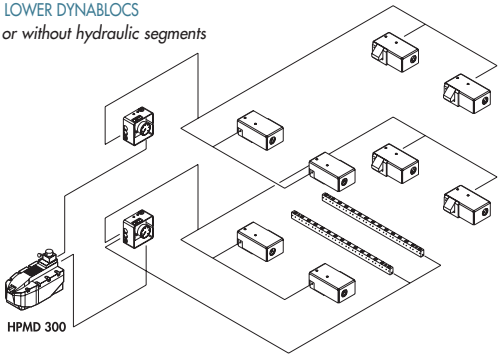
APPLICATION B : DYNABLOC SYSTEM WITH HYDRAULIC SEGMENTS





APPLICATION C : INDEPENDENT CONTROL OF UPPER AND LOWER DYNABLOCS

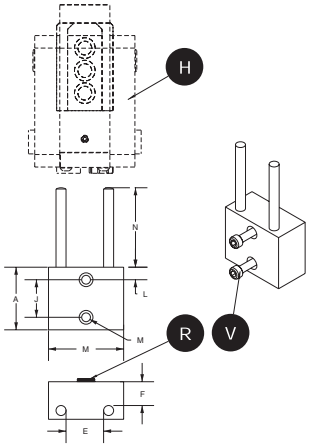
with or without hydraulic segments



ACCESSORIES : SUPPORTS FOR CLAMPS NOT IN USE

SHS

Dimensions and data subject to amendment



APPLICATION

SHS clamp supports are used to hold clamps when they are removed from the table or slide block while changing the tool.
When the clamps become non-operational, they must be left resting in an appropriate position. SHS supports are designed to take clamps by their T-shaped bolts.
Easy to install and taking up little space, they can be placed in an accessible area without hindering any aspect of tool handling; the clamps thereby rest in a natural position and the hydraulic hoses are not constrained or placed under stress.

ASSEMBLY

SHS supports are fixed to the frame of the machine with two screws (V). During installation, you should check that the space available (H) is sufficient for complete engagement of the body of the clamp. Depending upon the different thicknesses (l) of the T-bolts, you sometimes need to insert one or more washers under the support body.

TO ORDER

The supports are defined by the width a of the slots to which the T-bolts of the clamps belong.
E.g.: SHS 22 (Support for T-bolt where a = 22 DIN 650).

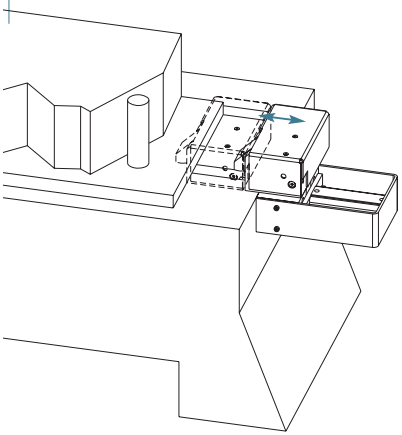
DIN 650				
a	b	c	h	l
18	30	12	30	18
22	37	16	38	22
28	46	20	48	28
36	56	25	61	36
24	42	18	42	24

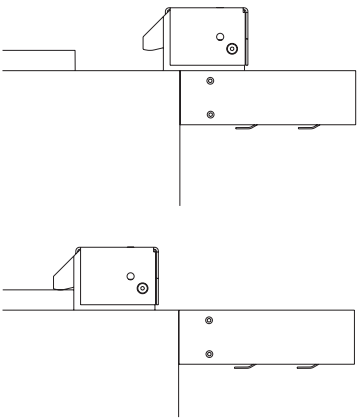
MODELS	A	B	C	E	F	J	L	M	N
SHS 18	50	60	30	22	19	30	10	M6	45
SHS 22	50	60	30	26	19	30	10	M6	45
SHS 24	50	60	30	26	19	30	10	M6	45
SHS 28	50	60	30	30	19	30	10	M6	45
SHS 36	50	60	30	34	19	30	10	M6	45

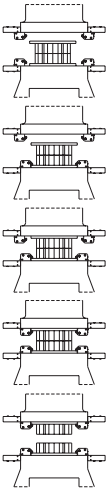
OPTIONS : PNEUMATIC MOVEMENT

TRPN

Dimensions and data subject to amendment





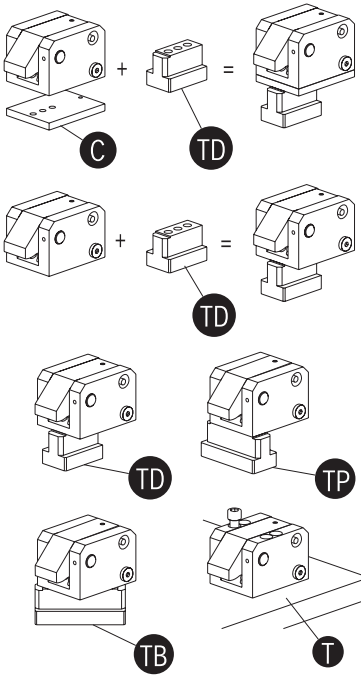


HYDRAULIC CLAMP & LEVER-OPERATED BRIDABLOC

HLC

ROTOBLOC-PSP GROUPE DIMECO

Dimensions and data subject to amendment



APPLICATION

HLC BRIDABLOCS are hydraulically operated clamps mainly used for quick clamping of press tools.

The hydraulic clamping of BRIDABLOCS offers security through the constant and regular pattern of the clamping forces.

DESCRIPTION

BRIDABLOCS are single-action intensifier lever-operated clamps with spring return. The elements of the clamp are made from high quality burnished treated steel. Its very small dimensions allow it to be used in applications where there is little space available.

A large-dimensioned piston controls the tightening lever at a pressure of 250 bars for the nominal force of the clamp.

The specific spherical connections between the tightening lever and the piston allow you to obtain high strokes. The end-of-stroke stop (A) of the tightening lever is visible in its end positions. This unusual construction allows the operator to ensure that the tool is clamped with complete safety between these two end positions.*

ASSEMBLY

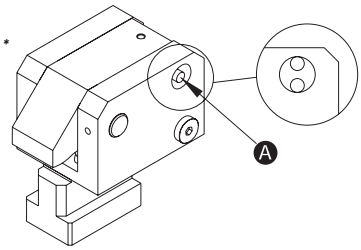
Initial BRIDABLOC assembly may be carried out using straight T-bolts (TD) with special or standard sections complying with the DIN 650 standard (see dimensional table 2). Directed T-bolts (TB), (TP) may also equip the body of BRIDABLOCS for special applications. Under all circumstances, the body of the clamp must be placed completely on the table during clamping.

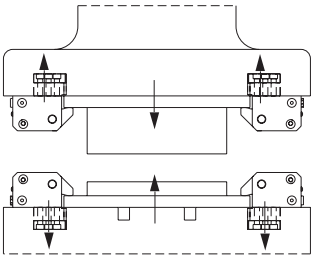
A standard or special additional wedge (C) may be added in all cases to provide a particular clamping height.

BRIDABLOCS may be screwed directly onto tables (T) for fixed placement with a hydraulic main supply integrated into the table as an option.

N.B.: T-bolt assembly (carried out in the factory) or screw assembly onto a table is carried out using high coupling-resistance screws and a specified tightening procedure. Please see the technical notice concerned.

The use of HLC HYDRAULIC BRIDABLOCS involves a continuous line connection to an outside generator that provides constant pressure. The connection may be joint or individual. Please see the HYDRAULIC PRESSURE GENERATOR Type HP1E heading for the choice as well as the appropriate BRIDABLOC connection.





NB:
Pressing and forming generally involves major dynamic components that subject their environment to severe cycles of fatigue. Constant monitoring and maintenance of mechanical and hydraulic equipment (hoses) is advisable so as to avoid any risk of an accident.

CLAMPING FORCE

For pressing/drawing, the force necessary to clamp the tool is directly dependent upon a number of parameters, the principal ones being: rigidity of the frame, speed of the press, material worked on, stripping force, force distribution and tool mass. Its theoretical evaluation is relatively difficult. Practical measures may be adopted on-site with the assistance of appropriate sensors.
As a rule of thumb, an approximate evaluation may be made by assuming total clamping power to be 12% to 18% of the nominal capacity of the press (4% to 8% on the table and around 8% to 10% on the slide block). This force will then be divided by the total number of clamps.

E.g.: 160-T. arch press: 4 clamps on the slide block + 4 clamps on the table.

SLIDE BLOCK:
F = 160,000 x 0.10 = 16,000 kg: 4 = 4,000 daN.
Equivalent to 4 HLC 40K clamps.

TABLE:
F = 160,000 x 0.5 = 8,000 kg: 4 = 2000 daN
Equivalent to 4 HLC 20K clamps.

If the stripping forces are very high, add them onto the force, F, directly.

TABLE 1 Specifications		HLC 20 K	HLC 40 K	HLC 60 K	HLC 100 K
Force kg (DaN)		2000	4000	6000	10000
Pressure (Bar)		250	250	250	250
Oil volume (cm^3)		4	7	11	18
Body height	A	60	75	90	105
Body lengths	B	90	105	120	150
Nominal support	C	15	17	20	22
Joint tilt	D	7,5	7,5	10	10
Nominal height	E	20	25	30	35
Hydraulic port	F	20	20	20	25
Body width	G	60	80	100	120
Joint width	H	30	40	50	60
Max. height	J	22	28	33	38
Min. height	K	16	21	25	30
Hydraulic port	L	13	15	15	17
Hydraulic port	M	1/4 BSPP	1/4 BSPP	1/4 BSPP	1/4 BSPP
Hydraulic port	N	24	26	30	40
Mass (kg)		2,2	4,6	7,9	12,5

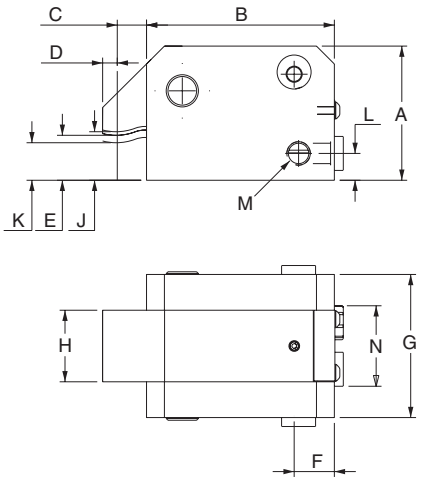
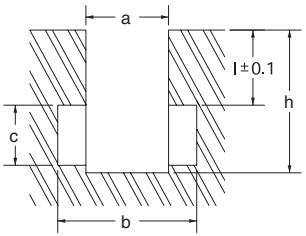


TABLE 2 - DIN 650				
a	b	c	h	l
18	30	12	30	18
22	37	16	38	22
28	46	20	48	28
36	56	25	61	36
24	42	18	42	24



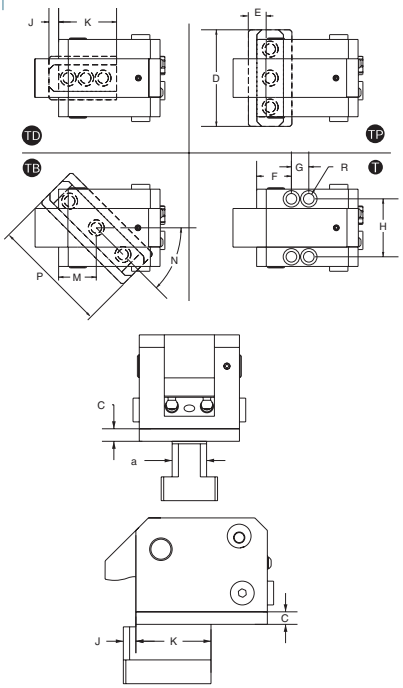


Table 3 shows the dimensions of standard T-bolts and assemblies for the different BRIDABLOC models. Special T-bolts may be produced on demand.

ORDER IDENTIFICATION

Complete the following grid: 1 2 3 4 5

Specify the references for your BRIDABLOC order as defined below.

1 - Choose force according to needs (table 1)
E.g.: BRIDABLOC 20K (2000 kg tightening force)
Reference: 20K.

2 - Choice of mode of attachment according to slot or requirements (tables 2 and 3)
E.g. Straight/upright T-bolt for slot a = 22 under DIN 650 standard
Reference: TD 22.

3 - Addition of standard 10-mm. thick wedge
Reference: C 10 (if required).

4 - In the case of a special T-bolt, indicate the a, l, c and b dimensions of the slot:
E.g.: a= 20, l = 18, c = 15, b = 29
Reference: TS a20 - L18 – c15 – b29.

General example: BRIDABLOC HLC 20 K TD 22 C10
N.B.: the "l" dimension must be given to an accuracy of ± 0.1 mm.

The SHS supports used to rest the BRIDABLOCS are recommended for temporary BRIDABLOC positioning while changing the tool. See the SHS supports page to make an appropriate choice from among these supports.

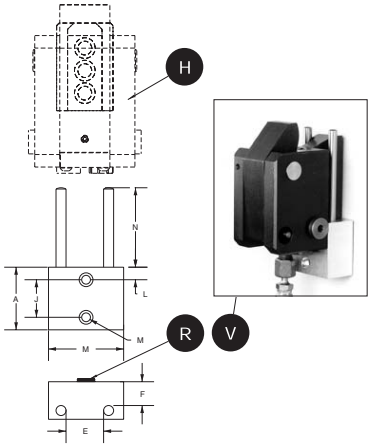
TABLE 1 Version	Clamp	D	E	F	G	H	J	K	M	N	P	R	Key a 18	22	28	36	Wedge C
TD T-bolt	20 K						10	60					X	X	X		X
	40 K						10	70						X	X		X
	60 K						10	80						X	X	X	X
	100 K						10	95							X	X	X
TP T-bolt	20 K	80	14										X	X	X		X
	40 K	100	14											X	X		X
	60 K	120	18											X	X	X	X
	100 K	140	18												X	X	X
TB T-bolt	20 K								32	55	90		X	X	X		X
	40 K								39	50	118			X	X		X
	60 K								45	54	138			X	X	X	X
	100 K								53	52	164				X	X	X
Attachment	20 K			31	15	50						M8					X
on the table T	40 K			36	18	60						M10					X
	60 K			38	20	75						M12					X
	100 K			49	24	90						M14					X

ACCESSORIES : SUPPORTS FOR CLAMPS NOT IN USE

SHS

ROTOBLOC-PSP GROUPE DIMECO

Dimensions and data subject to amendment



APPLICATION

SHS clamp supports are used to hold clamps when they are removed from the table or slide block during a tool change.
When the clamps become non-operational, they must be left resting in an appropriate position. SHS supports are designed to take clamps by their T-shaped bolts.
Easily installed and taking up little space, they can be placed in an accessible location without hindering any aspect of tool handling; the clamps thereby rest in a natural position and the hydraulic hoses are not constrained or placed under stress.

ASSEMBLY

SHS supports are attached to the frame of the machine with two screws (V). During installation, you should check that the space available (H) is sufficient for complete engagement of the body of the clamp. Depending upon the different thicknesses (l) of the T-bolts, you sometimes need to insert one or more washers under the support body.

ORDERING

The supports are defined by the "a" width of the slots to which the T-bolts of the clamps belong.
E.g.: SHS 22 (Support for T-bolt where a = 22 DIN 650).

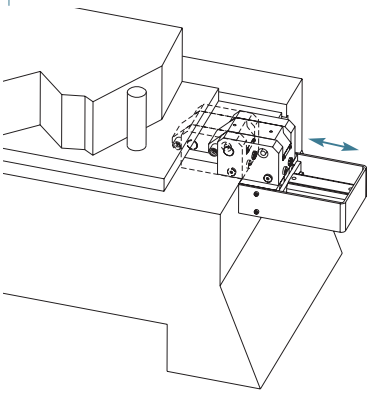
DIN 650				
a	b	c	h	l
18	30	12	30	18
22	37	16	38	22
28	46	20	48	28
36	56	25	61	36
24	42	18	42	24

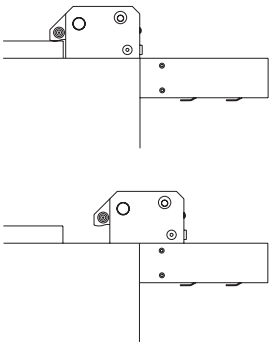
MODELS	A	B	C	E	F	J	L	M	N
SHS 18	50	60	30	22	19	30	10	M6	45
SHS 22	50	60	30	26	19	30	10	M6	45
SHS 24	50	60	30	26	19	30	10	M6	45
SHS 28	50	60	30	30	19	30	10	M6	45
SHS 36	50	60	30	34	19	30	10	M6	45

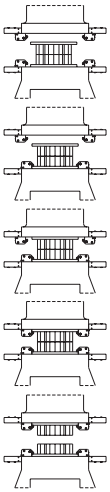
OPTIONS : PNEUMATIC MOVEMENT

TRPH

Dimensions and data subject to amendment





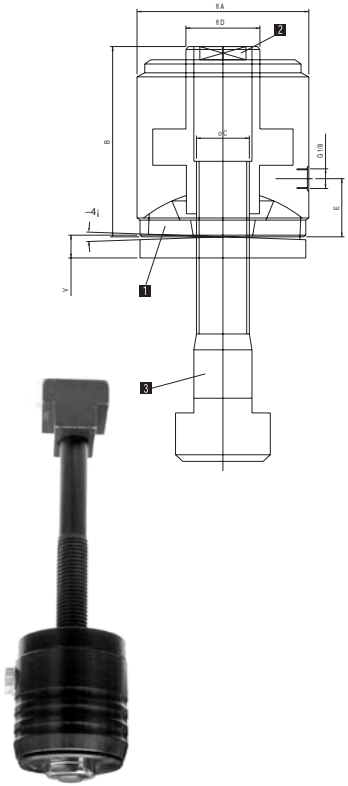


HYDRAULIC NUTS

HTB

ROTOBLOC-PSP GROUPE DIMECO

Dimensions and data subject to amendment



NUT COMPRISING A HYDRAULIC HOLLOW PISTON ROD CYLINDER

- Single action hydraulic power supply
- Spring return

1 - Magnetic semi-spherical washer
2 - Double-sided end for adjustment of clamping height
3 - Forged locking device or stud + T-bolt assembly (not provided) may be supplied as accessories.
Tell us the clamping height and the dimensions of the T-shaped slot.

APPLICATION

Tool or mould clamping with sole plates supplied with "open buttonholes" on press tables and slide blocks equipped with T-shaped slots.

DESCRIPTION

Hydraulic hollow piston rod cylinder with spring return. The "rod side" hydraulic power supply of the piston has the effect of exercising traction force on the tie rod, which makes the base of the cylinder resting against the sole plate to clamp.

ADVANTAGES

- Tools can occupy the entire area of the table;
- The clamping height can be adjusted through the piston rotation;
- The semi-spherical supporting washer allows disparities of ± 4° with parallel;
- Economical solution that does not require any specific adaptation.

NOTE

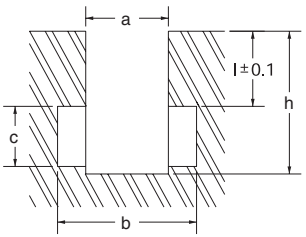
DIN 787 locking devices or stud + T-bolt assemblies are not part of the equipment supplied.

Please see the "HYDRAULIC PRESSURE GENERATOR Type HP1E" heading for the choice of the most suitable type of hydraulic unit.

Models	SPECIFICATIONS					
	Lifting force at		Stroke Vmm	Section Cm^3	Volume Cm^3	For tie rod DIN 787 12.9 quality
	250 bar kN	350 bar kN				
HTB 28 K	28,5	39,8	6	11,38	7	M 16
HTB 44 K	44	61,6	6	17,60	11	M 20
HTB 72 K	72,2	101	6	28,86	17	M 24
HTB 102 K	102	102	6	40,80	24	M 30

Max. pressure admissible: 400 bar

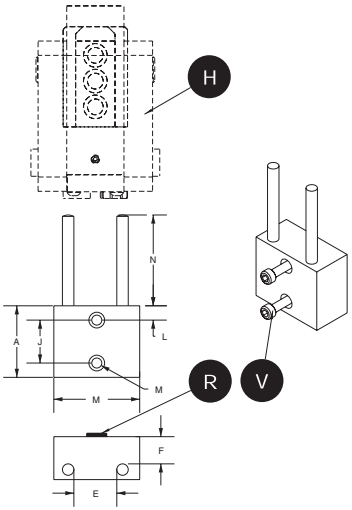
Models	Dimension in mm				
	A	B	C	D	E
HTB 28 K	55	66	M 16	24	20
HTB 44 K	65	72	M 20	28	22
HTB 72 K	85	82	M 24	35	23
HTB 102 K	100	92	M 30	45	25



ACCESSORIES : SUPPORTS FOR CLAMPS NOT IN USE

SHS

Dimensions and data subject to amendment



APPLICATION

SHS clamp supports are used to hold clamps when they are removed from the table or slide block during a tool change.
When the clamps become non-operational, they must be left resting in an appropriate position. SHS supports are designed to take clamps by their T-shaped arbors.
Easily installed and taking up little space, they can be placed in an accessible location without hindering any aspect of tool handling; the clamps thereby rest in a natural position and the hydraulic hoses are not constrained or placed under stress.

ASSEMBLY

SHS supports are attached to the frame of the machine with two screws (V). During installation, you should check that the space available (H) is sufficient for complete engagement of the body of the clamp. Depending upon the different thicknesses (l) of the T-bolts, you sometimes need to insert one or more washers under the support body.

ORDERING

The supports are defined by the "a" width of the slots to which the T-bolts of the clamps belong.
E.g.: SHS 22 (Support for T-bolt where a = 22 DIN 650

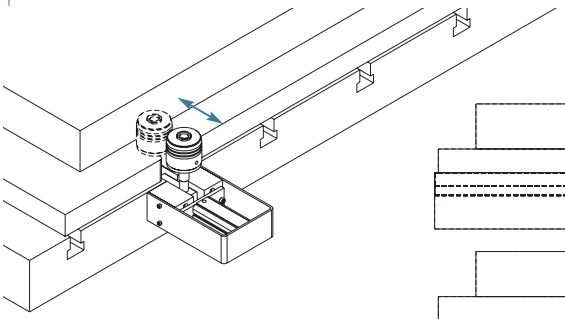
DIN 650				
a	b	c	h	l
18	30	12	30	18
22	37	16	38	22
28	46	20	48	28
36	56	25	61	36
24	42	18	42	24

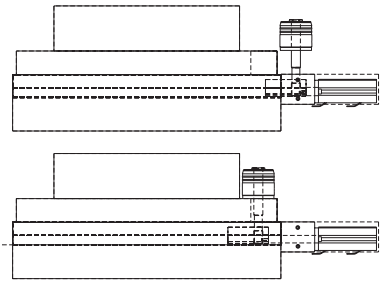
MODELS	A	B	C	E	F	J	L	M	N
SHS 18	50	60	30	22	19	30	10	M6	45
SHS 22	50	60	30	26	19	30	10	M6	45
SHS 24	50	60	30	26	19	30	10	M6	45
SHS 28	50	60	30	30	19	30	10	M6	45
SHS 36	50	60	30	34	19	30	10	M6	45

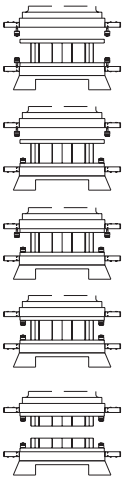
OPTIONS : PNEUMATIC MOVEMENT

TRPE

Dimensions and data subject to amendment







ACCESSORIES : PNEUMO-HYDRAULIC GENERATORS

HP1E

ROTOBLOC-PSP GROUPE DIMECO

Dimensions and data subject to amendment

MODELS	1 service pressure		2 service pressure			
	Pressure (bar)	Circuit S-D*	Pressure 1 (bar)	Circuit S-D*	Pressure 2 (bar)	Circuit S-D*
HP1E 100.1S	100	1S				
HP1E 250.1S	250	1S				
HP1E 250.2S	250	2S				
HP1E 250.3S	250	3S				
HP1E 250.4S	250	4S				
HP1E 100.1D	100	1D				
HP1E 100.2D	100	2D				
HP1E 100.1S.2D	100	1S-2D				
HP1E 250.1S 100.1S			250	1S	100	1S
HP1E 250.2S 100.1S			250	2S	100	1S
HP1E 250.3S 100.1S			250	3S	100	1S
HP1E 250.4S 100.1S			250	4S	100	1S
HP1E 250.1S 100.1D			250	1S	100	1D
HP1E 250.1S 100.1D.1S			250	1S	100	1D-1S
HP1E 250.2S 100.1D.1S			250	2S	100	1D-1S

S = simple effect - D = dual effect

Specifications

Air pressure	Bar	3
PO Flow	L/mm	0,8
Tank capacity	L	5
Working capacity	L	4,2
Main Electrical power supply	U	220
Circuit electrical power supply	U	24
Average pressure	Bar	250
Low pressure	Bar	100
Connection		_ BSPP

APPLICATION

HP1E pressure generators are pneumo-hydraulic power units that essentially allow you to control the clamping and translation of tools. They are compact and are easy to install on any kind of press.

DESCRIPTION

HP1E pressure generators are electrically controlled.
The generator comprises an integrated electrical cabinet ready for connection to the main supply. A separate control box connected to the cabinet allows you to control all hydraulic functions remotely. Lighting switches placed on the control box ensure proper use of these functions.
(Press) production site emergency stop electrical terminals are available in the cabinet in case of incidents coming from the generator.

The pump is of the balanced-pressure pneumo-hydraulic type. It is powered from the compressed air network. The output hydraulic pressure is directly proportional to the air pressure set at the intake control valve.
When working, if the preset service pressure is reached, the pump locks into standby position through the balance of internal pressures. Its cycle will automatically respond to any hydraulic stress. Working and resting changeovers relate solely to the actual internal functioning of the pump.
Distribution is ensured with the assistance of poppet valves that ensure the clamping circuits are air tight. All the distribution and the pressure relief valve are flaccid on the bored unit.
Additional safety pressure switches may be added onto clamping lines in order to increase security. The oil tank made from translucent material allows you a good view of its level.

SPECIFICATIONS AND DIMENSIONS

The table above shows the standard hydraulic configuration of HP1E generators. An average pressure of 250 bars and a low pressure of 100 bars are available. Other service pressures are also available on request. A distribution set may comprise one or two service pressures (average pressure and low pressure stage). Additional pressure stages may also be examined.
The type of distribution may be single or double action depending upon the sinks. One distribution set may constitute several single or double action circuits.

TO ORDER

To order a generator, complete the identification grid above. E.g.: Pressure generator HP1E 250.2S2P / 100.1S. Electrically-controlled generator: 1 250-bar average pressure stage, single action circuits with 2 additional line pressure switches, 1 100-bar low pressure stage with 1 single action circuit.

N.B. See page with examples of hydraulic circuits for different connections. Consult us if you need to.

ACCESSORIES : PNEUMO-HYDRAULIC GENERATORS

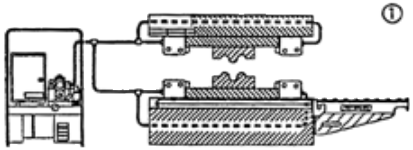
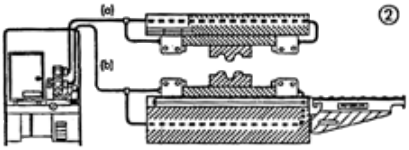
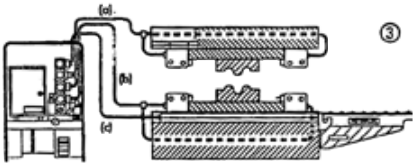
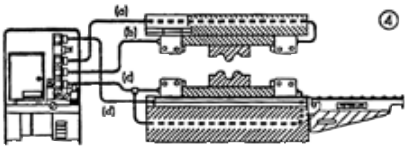
HP1E

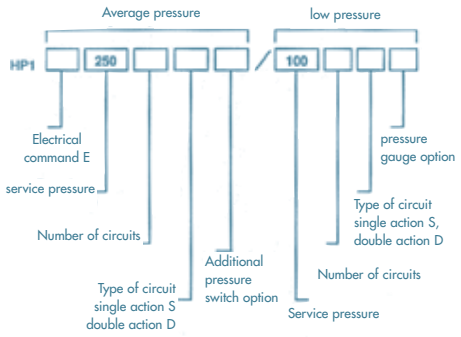
Dimensions and data subject to amendment

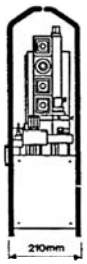
ORDERING

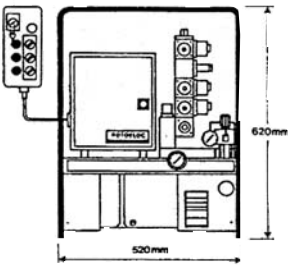
To order a generator, complete the identification grid below (marked in green).
E.g.: Pressure generator HP1E 250.2S2P / 100.1S. Electrically-controlled generator: 1 250-bar average pressure stage, single action circuits with 2 additional line pressure switches, 1 100-bar low pressure stage with 1 single action circuit.

N.B. See page with examples of hydraulic circuits for different connections.

H.P. MODEL	PRINCIPLE	NUMBER AND TYPE OF CIRCUITS	SINKS SUPPLIED
HP1E 250 1S		*1 single-action circuit*	*4 HLC clamps 250-bar slide block* *4 HLC clamps 250-bar press table*
HP1E 250 2S		*2 single-action circuits*	*(a) 4 HLC clamps 250-bar slide block* *(b) 4 HLC clamps 250-bar press table*
HP1E 250 2S /100 1S		*3 single-action circuits*	*(a) 4 HLC clamps 250-bar slide block* *(b) 4 HLC clamps 250-bar press table* *(c) 2 100-bar transrollers*
HP1E 250 3S /100 1S		*4 single-action circuits*	*(a) 2 HLC clamps 250-bar slide block* *(b) 2 HLC clamps 250-bar press table* *(c) 4 HLC clamps 250-bar press table* *(d) 2 100-bar transrollers*





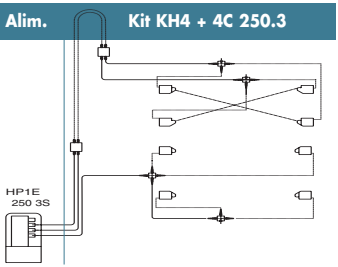


ACCESSORIES : CONNECTING EQUIPMENT

Dimensions and data subject to amendment

Generators	Piping kits: models		
Pneumo-hydraulic	*Number of single-action clamps connected*		
	2 + 2	*4 + 4*	*6 + 6*
HP1E 250.1S	*KH2+2C 250.1*	*KH4+4C 250.1*	*KH6+6C 250.1*
HP1E 250.2S	*KH2+2C 250.2*	*KH4+4C 250.2*	*KH6+6C 250.2*
HP1E 250.3S		*KH4+4C 250.3*	*KH6+6C 250.3*
HP1E 250.4S		*KH4+4C 250.4*	*KH6+6C 250.4*

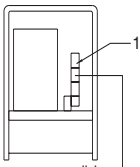
Alim. **Kit KH4 + 4C 250.3**



If rotobilles or transrollers, add a segment piping kit (c.f. page 31).

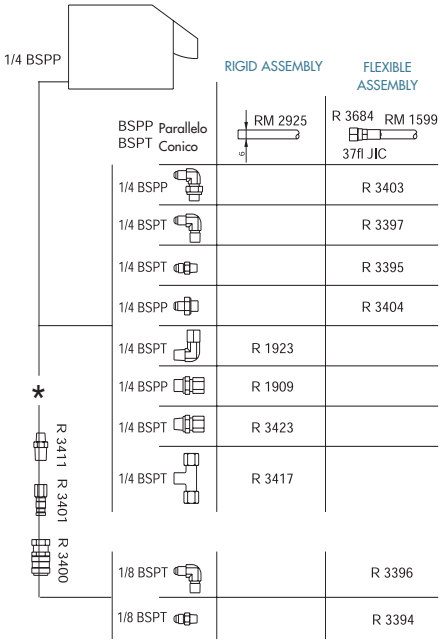
STANDARD COMPONENTS AND CONNECTIONS USED

Pneumo-hydraulic generator: HP1E range



BSPP Parallel / BSPT Conical	RIGID ASSEMBLY RM 2925	FLEXIBLE ASSEMBLY R 3684 RM 1599 37fl JIC
1/4 BSPP		R 3403
1/4 BSPT		R 3397
1/4 BSPT		R 3395
1/4 BSPP		R 3404
1/4 BSPT	R 1923	
1/4 BSPP	R 1909	
1/4 BSPT	R 3423	

Hydraulic clamp

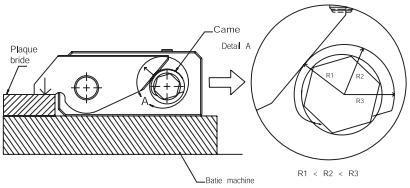


* assembly flexible with quick connection

The R.... references are ROTOBLOC notices (to be copied for your orders).

Note

If ordering hydraulic hoses, the nozzles must be crimped in the factory.
Specify the total length, L (including nozzles)



AUTO-TIGHTENING

The mechanical principle behind CA-type clamps involves a lever operated by an unloosenable cam. When that cam is turned in an anti-clockwise direction, the point F moves in relation to the scale of the eccentricity of the cam (r1<r2<r3). The clamping force at C causes the lever to respond and this pulls the cam in a tightening direction.
Consequently, the greater the rotation of the cam, the greater the clamping force and the greater the response of the lever vis-à-vis the cam as it pulls it ever more in the tightening direction.

CLAMPING FORCE

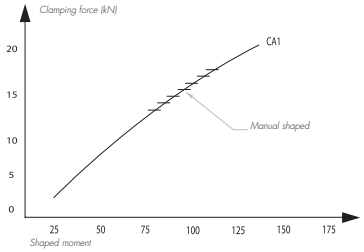
T-shaped key tightening allows you to obtain an 80 to 100 Nm tightening coupling without excessive force, and thus, a clamping force of 12 to 25 kN.
The clamping force obtained with CA clamps is generally greater than a conventional clamping system, which is, for example, 6.8 to 7.2 kN for a screw/nut system.

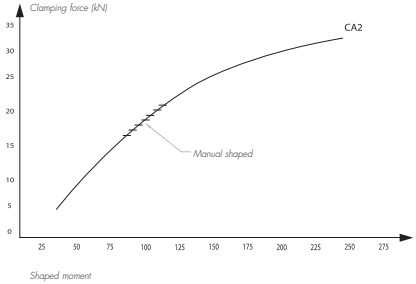
APPLICATION

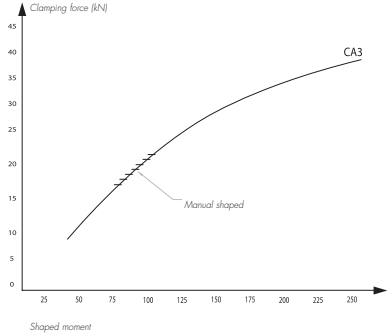
CA mechanical clamps were specially designed to resolve very tricky problems involving the clamping of tools on presses and obviously they can be mounted on any machining equipment: drilling machines, screwing machines, turning lathes, milling machines, machining centres etc.

COMMENTS

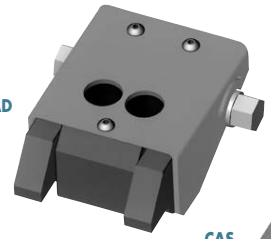
The basic CA-type model has 2 or 3 clamping jaws in order to avoid any risk of the part that is to be clamped pivoting.
Only the CAS model is supplied with a locking pin that can be used so that it adapts itself to the T-shaped slot or attachment type selected.



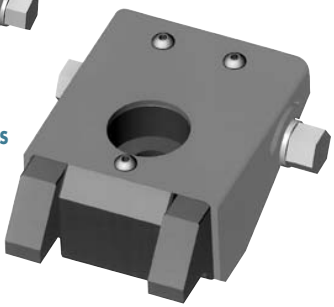




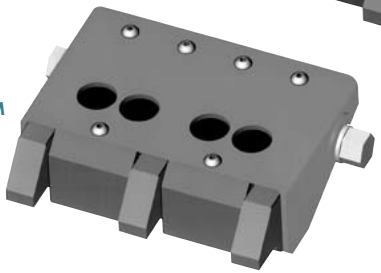
CAD



CAS



CAM

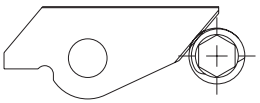


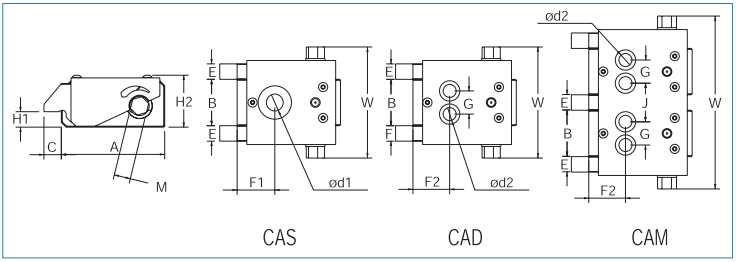
CAMBLOC MECHANICAL CLAMPS: LEVER OPERATED

Dimensions and data subject to amendment

- Ease of use
- Security\P-Rapidity
- Rigidity

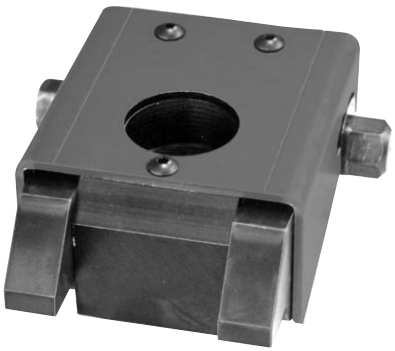
Max. force 2.5 tons.

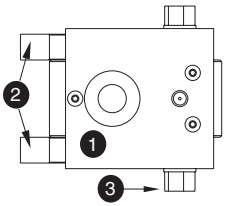


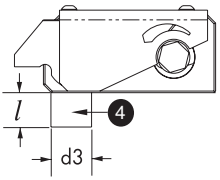


MODELS		Mechanical clamps - specifications														Clamping force			
		A	B	H1	H2	C	E	F1	F2	G	J	ø d1	ø d2	W	M	kN	d3	l	Weight Kg
S	CAS-0	71	32	16	37,2	10,5	11	30	-	-	-	12,5	-	85	12	16	6	-	0,850
	CAS-1	88	38	16	41,75	13,5	13	37	-	-	-	17,5	-	99	14	18	6	-	1,400
	CAS-2	107	48	16	53,75	18	16	39	-	-	-	17,5	-	115	17	20	20	17	2,800
	CAS-3	120	56	22	58,75	23	20	47	-	-	-	19	-	137	19	24	25	17	4,200
D	CAD-2	107	48	16	53,75	18	16	-	38	24	-	-	13	115	17	20	-	-	2,800
	CAD-3	120	56	22	58,75	23	20	-	45	28	-	-	15	137	19	24	-	-	4,200
M	CAM-1	88	38	16	41,75	13,5	13	37	-	-	51	17,5	-	150	14	18	-	-	2,500
	CAM-2	107	48	16	53,75	18	16	-	38	24	40	-	13	179	17	20	-	-	4,000
	CAM-3	120	56	22	58,75	23	20	-	45	28	48	-	15	213	19	24	-	-	7,500

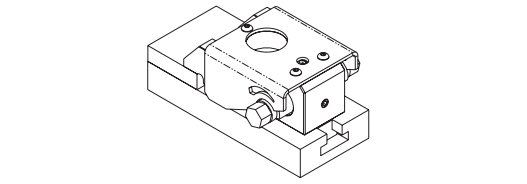
* Witch operating torque = 100Nm

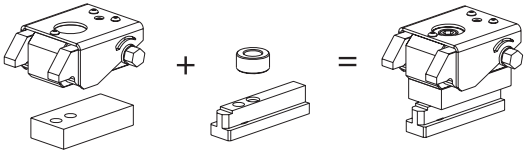


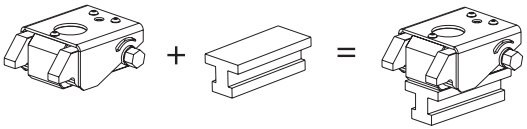


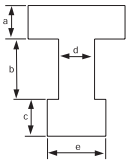


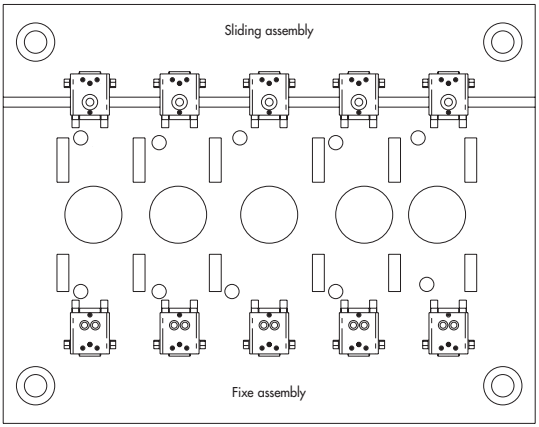
1 - Body
2 - Jaws
3 - Camshaft
4 - Locking pin (CAS)











SLIDING ASSEMBLIES IN T-SHAPED SLOTS

COMMENT

The third letter in the commercial reference figure, S, D or M refers to the number of counterbored holes (for CHC screw) machined into the clamp. The type of potential assembly depends upon this number of holes
CAS: 1 counterbored hole (+ 1 locking pin)
CAD: 2 counterbored holes
CAM: 4 counterbored holes

LONGITUDINAL SLIDING ASSEMBLY

In the pressing or plastic moulding industry, there is no doubt that this is the most interesting assembly type as it can be adapted to all tools whatever their dimensions and only the clamp height has to be standardised. Cam rotation causes the following simultaneous effects:
- Longitudinal immobilisation of the clamp
- Clamping of the sole plate

Use of the CAS model is, in any case, suitable for this type of assembly; you need to combine it with a machined assembly: T-bolt + shim (monobloc, if possible) adapted to the height to be clamped and to the dimensions of the T-shaped slots.

PRICE ON REQUEST: please notify us of the dimensions required (see sketch alongside).

Note

The short stroke of the clamping jaws (around 2 mm.) only allows for very low disparities in height tolerance (thickness of sole plate + position of slot in relation to attachment plane).

TRANSVERSE SLIDING ASSEMBLY

This case occurs only rarely as it requires sole plate dimensions compatible with the position of the T-shaped slots on the table. Nevertheless, it can be found in transfer tools (see sketch alongside).
For this type of assembly all three models (CAS, CAD and CAM) are suitable.
Here again, you need to manufacture a T-bolt + shim to match the T-shaped slot and the height to be clamped (ask for our advice).

Note

Tightening spanner: for access reasons, it is sometimes preferable to use a socket wring spanner or a ring spanner for tightening.

fig. A

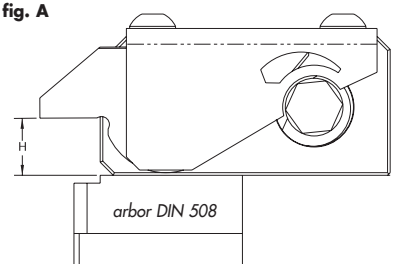


fig. B

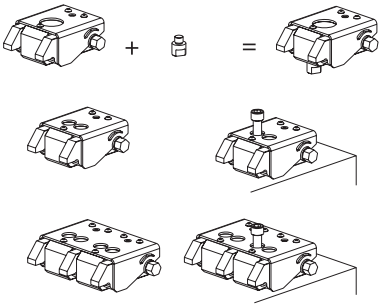
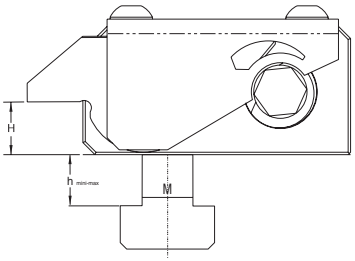
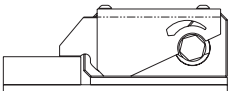


fig. C

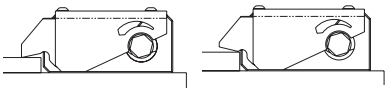


CORRECT

The outline of the handling cam makes it essential that you keep to the clamping height.



INCORRECT



FIXED ASSEMBLIES: SUMMARY AND RECOMMENDATIONS

FIXED ASSEMBLY WITH LONGITUDINAL T-SHAPED SLOTS: Fig. A

Only the CAS model is suitable.
DIN 508 or DIN 508R T-bolts are sufficient for use as stops in the T-shaped slots.
The locking pin, which can be modified, prevents the rotation of the clamp.

FIXED ASSEMBLY ON A SMOOTH TABLE: Fig. B

All 3 models can be assembled so you only need to machine screwed holes corresponding to the dimensions of the holes that are in the clamps.

FIXED ASSEMBLY WITH TRANSVERSE T-SHAPED SLOTS: Fig. C

All 3 models can be assembled.
Equipment with T-bolt and shim: idem longitudinal T-shaped slots.

SUMMARY

c.f. table below

RECOMMENDATIONS

Clamping height to respect
Hexagonal spanner manoeuvre: mind the tightening coupling.

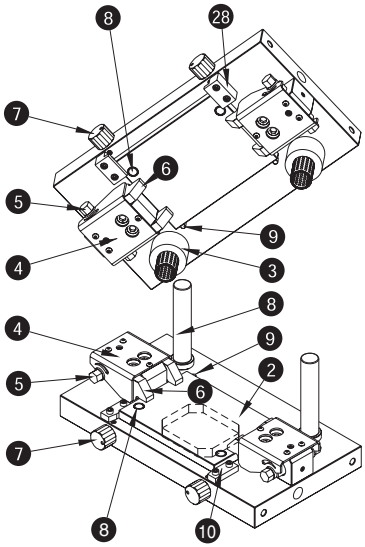
ASSEMBLY TYPES	CAS	CAD	CAM	Additional wedge if required
Longitudinal sliding in T-shaped slots	X X			X
Transverse sliding in T-shaped slots		X X	X X	X
Fixed in longitudinal T-shaped slots	X X			X
Fixed in transverse T-shaped slots		X X	X X	X
Fixed on smooth table	X X	X X	X X	X

BLOCMATIC : RAPID CASSETTE CHANGE BLOCK

RLP

ROTOBLOC-PSP GROUPE DIMECO

Dimensions and data subject to amendment



UPPER PART

1 - Punch holder slide block support
2 - Upper part of press tool (punch holder sliding block)
3 - Guide bushing with ball cage
4 - Clamping mechanism
5 - Clamping cam
6 - Clamp
7 - Control knobs for alignment cotter pins
8 - Alignment cotter pin
9 - Stop
10 - Positioning guide

LOWER PART

1 - Sole plate support
2 - die holder sole plate
3 - Guide column
4 - Clamping mechanism
5 - Clamping cam
6 - Clamp
7 - Control knobs for alignment cotter pins
8 - Alignment cotter pin
9 - Stop
10 - Positioning guide

LESS THAN A MINUTE TO CHANGE THE PRODUCTION

With reduction in series, tooling changes and settings often take longer than production itself. In order to sort out this problem, we have developed a new tool design that allows you to make a production change in less than a minute. This new design is based upon the principle of the block itself, which is common to an entire family of parts. Production changes consist simply in changing "active parts": die holders and punch holders.

CHANGE MECHANISM

A BLOCMATIC comprises a column and plain or ball bearing guide bush unit and a pair of grinded plates with a punch holder attached to the top and a die holder attached to the bottom.

The BLOCMATIC replaces standard pressing tools and there is no need to change it when you change production. The BLOCMATIC remains continuously mounted on the press.

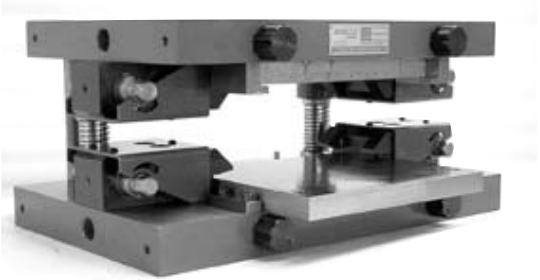
The interchangeable grinded plates (onto which the die holder assemblies are mounted) are installed between the clamps of the upper and lower sole plates of the BLOCMATIC system.

The grinded plates are clamped by means of mechanical clamps and a single rotation of the camshafts.

The die holders and punch holders are aligned to an accuracy of 0.02 mm. by means of retractable cotter pins operated via rotary knobs on the front face.

Thus, with the BLOCMATIC system, it is possible to change punch and die assemblies without disassembling the block. No adjustment or location work is required and dies and punches may be changed in less than a minute with a repeatability of 0.02 mm.

Standard grinded plates are available in the dimensions of the RLPP series. If necessary, the alignment of a punch with a die may be checked and adjusted on an RLPS series presetting bench.

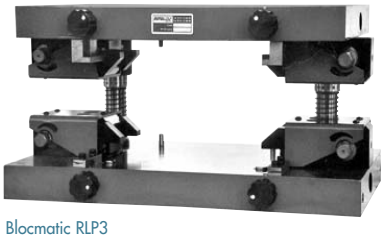


RAPID CASSETTE CHANGE BLOCK: BLOCMATIC

RLP

ROTOBLOC-PSP GROUPE DIMECO

Dimensions and data subject to amendment



Blocmatic RLP3

RLP STANDARD BLOCKS

This is the most popular model

- *1 single post*
- *2 rear offset standard or ball bearing columns*
- *Plates positioned using detachable cotter pins*
- *Quick mechanical clamping of RLPP plates*

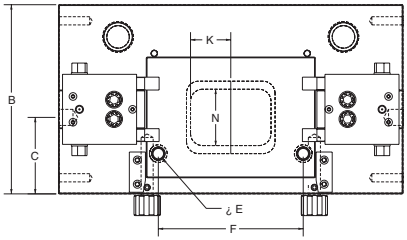
APPLICATIONS

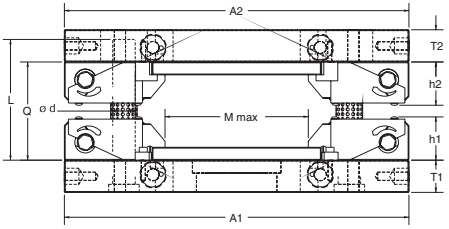
on off tools, progressive tools, transfers etc.

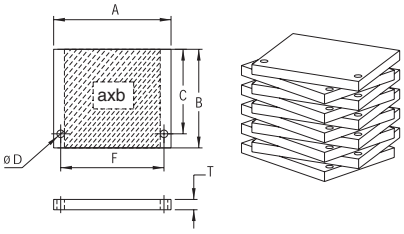
ASSEMBLY NOTES: on all 5 to 150-ton presses

- *longer columns available on request*
- *combined RLP2/3, RLP 3/4 block available on request*
- *adapted guide equipment allows you to work by "EXPOSED/DISLODGED"*
- *the bottom dead centre of the press must be reached between Qmin and Qmax.*

Models N°	BLOCMATIC dimensions mm													Columns		Cassettes height		Weight
	A1	A2	B	C	øE +0,005 +0	F ±0,01	T1	T2	h1	h2	M	K	N	ø d	L	Q max	Q min.	kg
RLP-1	330	286	180	55	14	120	35	35	42	42	123	40	50	32	180	115	84	38
RLP-2	428	365	235	95	16	180	40	40	54	54	180	50	70	32	200	120	110	67
RLP-3	494	450	290	125	16	220	45	40	59	59	214	75	110	32	220	130	120	113
RLP-4	594	546	390	170	16	320	60	45	59	59	315	110	160	50	250	145	120	227
RLP-5	694	700	450	180	25	375	65	55	59	59	404	135	160	50	280	175	120	370







RLPP STANDARD GRINDED PLATES : *S 55 C carbon steel.*

Standard RLPP grinded plates are designed for use on mounting blocks and presetting benches with corresponding numbers. The control of die-punch alignment is carried out on the RLPS presetting bench.

When you change tooling, you only have to remove the previous plates from the mounting unit and to insert the new plates. That takes no more than a minute. No adjustment is required. After clamping, the plates are positioned with a repeatability tolerance of 0.02 mm. Aside from saving time assembling tooling on standard RLPP plates considerably reduces tooling costs compared to conventional solutions.

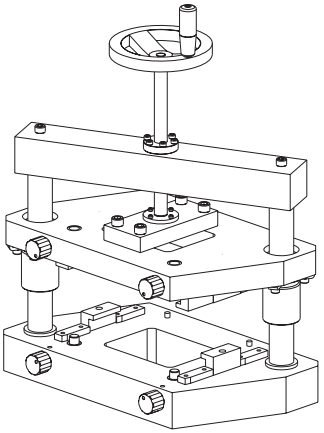
Models	Dimensions (mm)						Working area	For assembly on	
N°	A	B	C	F	T	øD(H7)	axb	Mounting block	Presetting bench
RLPP-1	150	100	82	120	16	14	123x100	RLP-1	RLPS-21
RLPP-2	210	150	120	180	16	16	174x150	RLP-2	RLPS-22
RLPP-3	250	210	180	220	22	16	204x210	RLP-3	RLPS-23
RLPP-4	350	300	270	320	22	16	304x300	RLP-4	RLPS-34
RLPP-5	450	315	270	370	30	25	395x315	RLP-5	RLPS-35

ACCESSORIES : PRESETTING BENCH

RLPS

ROTOBLOC-PSP GROUPE DIMECO

Dimensions and data subject to amendment

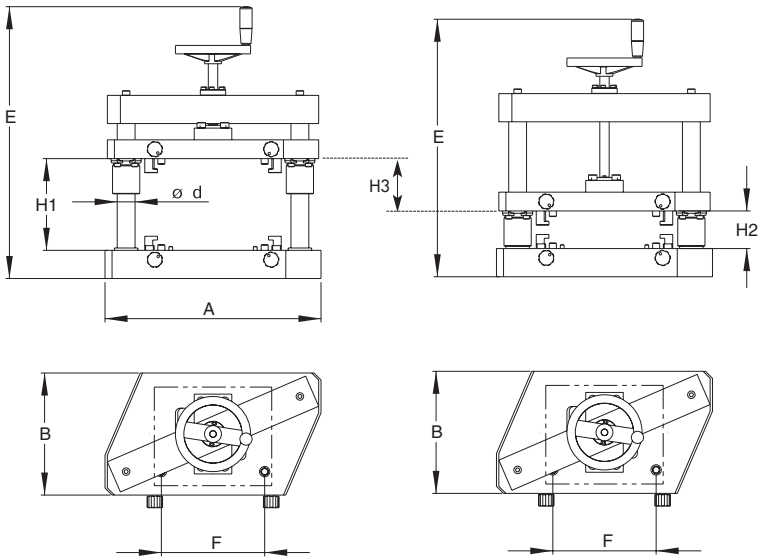


POSITIONING OF PRESETTING BENCH

The presetting bench is designed to allow quick and accurate control of the tools on plates with a rigorous alignment of punches with dies.

As this equipment is independent from the press, it eliminates breaks in production.

Models N°	No. of columns	Dimensions A	B	E	d	H1	H2	H3	Weight Peso (kg)
RLPS-21	2	320	200	455	28	130	77	53	51
RLPS-22	2	390	195	550	32	180	85	95	41
RLPS-23	2	460	260	540	38	205	105	100	61
RLPS-34	3	570	420	645	45	300	120	180	158
RLPS-35	3	645	425	680	45	320	130	190	230



RAPID CASSETTE CHANGE BLOCK: BLOCMATIC

RLP

ROTOBLOC-PSP GROUPE DIMECO

Dimensions and data subject to amendment

ADVANTAGES: RLP Master-tool block

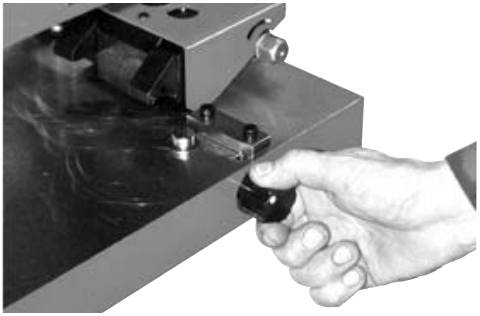
- 0.02 mm.: repeatability and accuracy of positioning of the 2 semi-cassettes
- Production change in less than a minute
- Very short production time for a new part: just the 2 semi-cassettes to manufacture.
- Economies: the "blocmatic" assembly involves just a single investment.
  It forms an integral part of the press for a whole range of parts.
- Interchangeable: Cassettes can be used by 2 "Blocmatics" with the same capacity on 2 different sites.

STORAGE :

The space required to store RLPP plates is just a third of that required for conventional tools.

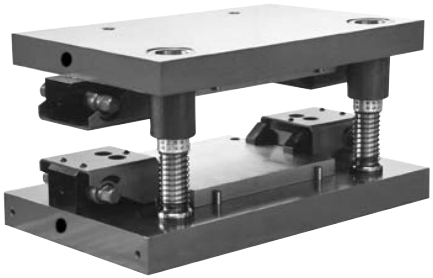
1 - INDEXING

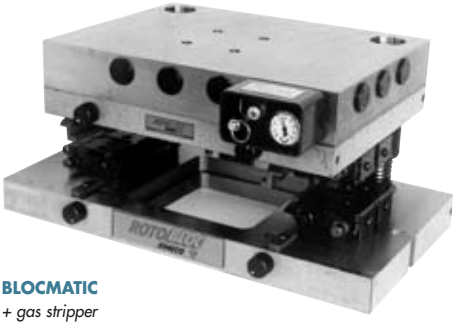
Indexing + clamping = 1 minute



BLOCMATIC

RLP series



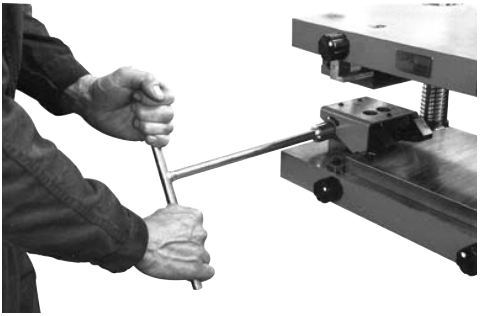


BLOCMATIC

+ gas stripper

2 - CLAMPING

of die-holders and punch-holders



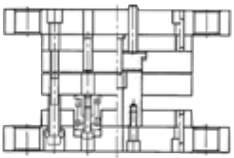
RAPID CASSETTE CHANGE BLOCK : EXAMPLE

CAD DESIGN OF "CASSETTES" AND "BLOCMATICS"

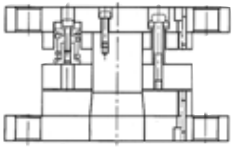
Rapidly introduce "BLOCMATIC" standards into your CAD
Using these basic items, you will design and manufacture your pressing tools as quickly as possible and at the lowest possible cost.

EXAMPLE below

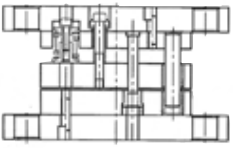
4 standard tools produced using CAD BLOCMATIC RLP



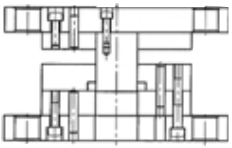
1) "Swiss" tool



2) "Cross run" Pressing tool



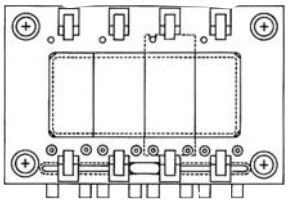
3) Punching tool

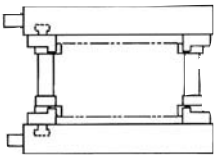


4) "Parisian" tool

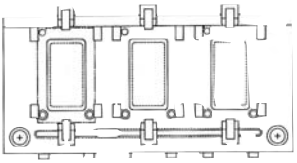
EXAMPLE: Successive post tools

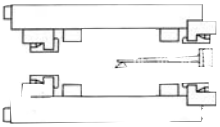
1) "progressive tool" successive post tool



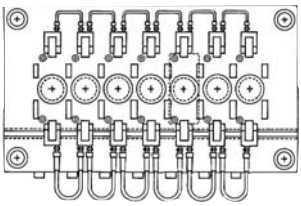


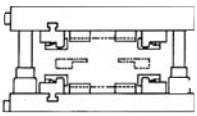
2) Transfer tool for MONOBAR TRANSFER





3) Transfer tool for TWO-BAR TRANSFER

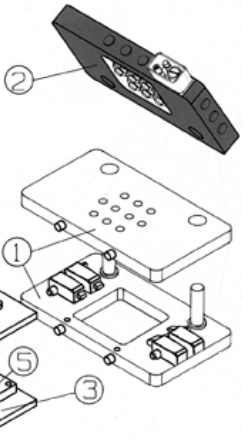




BLOCMATIC + "NITROGEN PLATE"

Application: printed circuit punching

Combining a Blocmatic RLP4 and a nitrogen stripper plate permanently mounted on the press allows you to considerably reduce tooling costs:
You just have to make the punch/die assembly attached to standard RLPP4 plates for each new printed circuit. (labels 3 + 4 + 5).



1 - Blocmatic RLP4
2 - "Nitrogen" stripper plate
3 - Standard RLPP4 plate
4 -Punch
5 - Die

QUESTIONNAIRE : QUICK TOOL CHANGE

ROTOBLOC-PSP GROUPE DIMECO

Company			
Address			
Tel.		*Fax*	
Email			
Contact			

	Maximum	*Minimum*	
Tool	*G*		
	K		
	W		
	J		
	F		
	Weight 1/2 upper tool		
	Weight 1/2 lower tool		
	Total tool weight		
	Funct. Temperature		
	Lower sole plate material		*HRC*

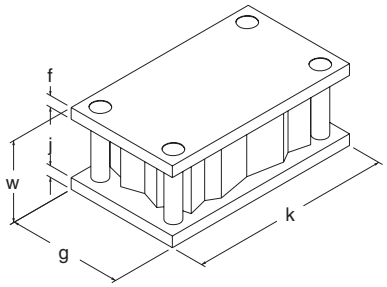
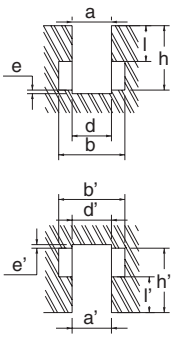
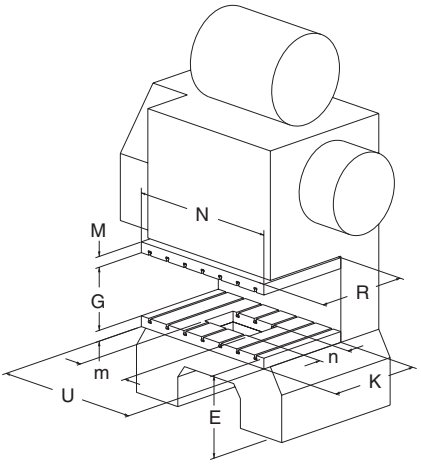


	table		*Slide block*	
Slot	*a*		*a'*	
	b		*b'*	
	c		*c'*	
	d		*d'*	
	e		*e'*	
	h		*h'*	
	l		*l'*	
	number of slots	*Right to left* / *Front rear*	*number of slots*	*Right to left* / *Front rear*



press	*Press type*	*Cross shaft* ☐	*Arcade* ☐	*Transfer* ☐
	model		*power*	
	Speed	*min.*	*max*	*corrente*
	Stroke	*min.*	*max.*	*corrente*
	Ambient temperature:			
	Table		***Slide block***	
	U		*N*	
	K		*R*	
	G		*M*	
	E			
	If opening present			
	m			
	n			



TROLLEYS & MANUAL SMOOTH-PLATFORM LIFTING TABLES

Load from 200 to 1200 kg

TL 200M TL 200E

MANUAL TROLLEY, MANUAL OR ELECTRIC LIFTING

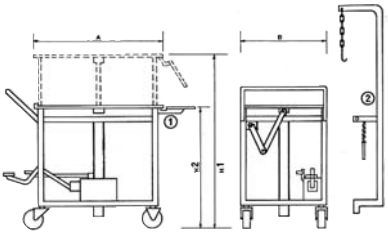
- *Capacity: 200 kg.*
- *Lifting height: 1450 mm. with platform*
  1750 mm. with jib arm
- *Dimensions:*
  Plate: 380 x 390 mm.
  Arm: length 200 mm.
- *Weight: TL200M: 68 kg.*
  TL200E: 83 kg. (without battery)
- *Battery: 12 V.50 Ah*

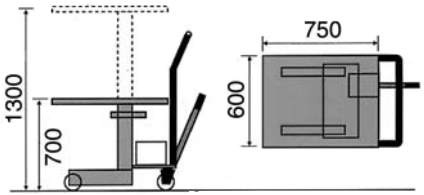
MANUAL LIFTING TABLE: 500 kg.

MODEL	A X B	H1	H2	Load (KG)	Weight (Kg)
CS 22/5	750x500	1110	670	500	95

ACCESSORIES:

- *Extension shelf*
- *1.2 T. opening jib arm*





MANUAL LIFTING TABLE: 1200 kg.

- *Capacity: 1200 kg.*
- *Weight: 160 kg.*

TROLLEYS & MANUAL ROLLER-TRAY LIFTING TABLES

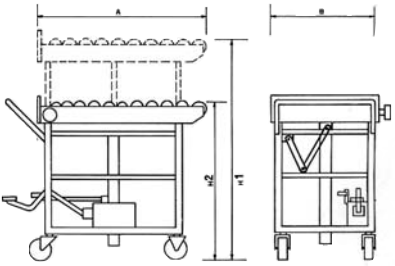
ROTOBLOC-PSP GROUPE DIMECO

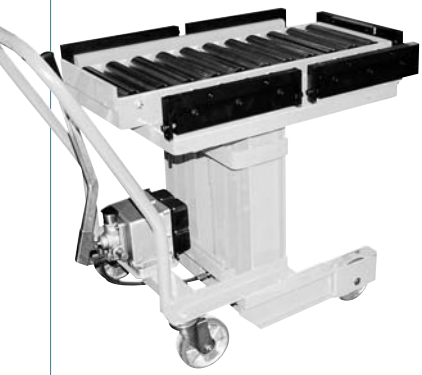
Load from 500 to 1000 kg.

MANUAL LIFTING TABLE: 500 kg

MODEL	A X B	H1	H2	Load (KG)	Weight (Kg)
CS 22/5R	800x520	1200	760	500	150

SECURITY:
- *Roller immobilisation mechanism*
- *Detachable front stop*



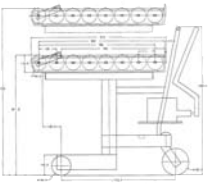


MANUAL LIFTING TABLE: 1000 kg

MODEL	Capacity kg	Height mm mini	Height mm maxi	Useful length mm	Useful plate width mm
MULTIUSO R	1000	810	1430	785	510

OPTION:
- *Detachable or fixed side bars*
- *Other plate dimensions (on request)*

SECURITY:
- *Roller immobilisation mechanism*
- *Detachable front stop.*



HANDLING EQUIPMENT EQUIPPED WITH TOOL SUPPORT TRAY

We manufacture tool support tray with balls blanking holes (patented)

SECURITY: *During transport, the balls are brought down within the plate and the tool rests on the structure of the latter. TOOL LOADING: manual when the balls are up.*

X Table: 1000 kg

MANUBLOC MPH stacking truck: 1000 kg.

MANUBLOC WITH "QUICKBLOC" PUSH/PULL ARM

MAH

ROTOBLOC-PSP GROUPE DIMECO

Load a tool in less than a minute.

There is no doubt that the MAH-type MANUBLOC is the SIMPLEST and most COMPLETE system.

It allows you to take a tool (up to 10 T.) from a storage rack (see CANTIBLOC range), to transport it and to position it on the press bed.

All these operations, carried out perfectly safely in LESS than 2 MINUTES, are completed by only one OPERATOR who remains continuously at the control unit of the system.

MANUBLOC MAH 20

SPECIFIC CHARACTERISTICS

- ROLL LIFTERS: retractable rollers with heavy cage and combined needle rollers.
They are up while the tool is loaded onto the press, but are down while you transport the tool, which thereby rests on the structure of the forks.

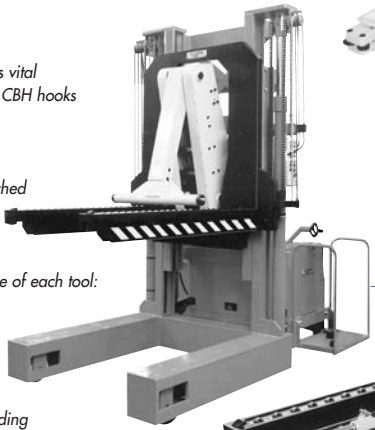
- QUICK BLOC: very simple, hydraulically-operated "push/pull" system. Its synchronous double articulation hydraulic scissors principle allows its free end to remain completely rigid in space.
- The coupling with twin bayonet fitting principle allows the tool to be coupled or uncoupled automatically as a background task during the rack stacking phase (International patent).

ACCESSORIES

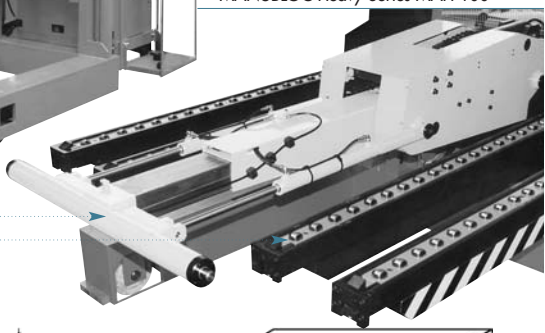
- CBH: LEVELLING HOOKS / STOPS
In order to transfer the tool in complete security, it is vital to temporarily attach the MANUBLOC to the press; CBH hooks fulfil this function.

- VPLA: LATERAL POSITIONING
These are V-shaped metal parts that are to be attached to the press or in front of each rack module.

- CH30: HOOKS
Parts designed to be attached to the lower sole plate of each tool: they allow the "Quickbloc" push/pull system to be coupled / uncoupled.



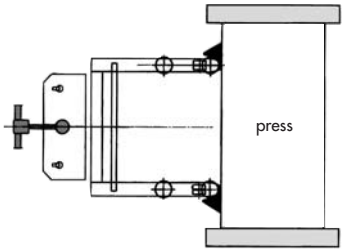
MANUBLOC Heavy Series MAH 100

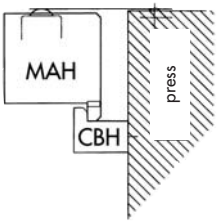


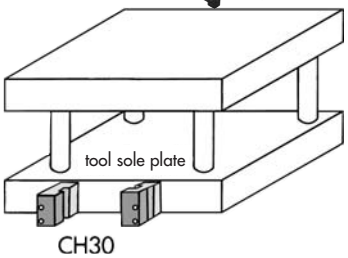
NOTE:

Unloading is carried out in the reverse order to loading

Patented "QUICKBLOC" arm.
ROLL-LIFTER







MANUBLOC WITH "QUICKBLOC" PUSH/PULL ARM

MAH

ROTOBLOC-PSP GROUPE DIMECO

Load a tool in less than a minute

M.A.H	TOOLS			QUICK BLOC AMR		MAT. ELD / ELM		MAT. DUP	OPTIONS		
MODELS	Max weight kg.	Max depth mm	Max width mm	AMR stroke mm	Force daN AMR min/max	lifting height min/max Direct	lifting height min/max Rigged	Duplex	AMRH min/max	BID	DAF
MAH 10 AMR - 24 V	1000	600	1000	800	450/1100	-	100/1600	100/3000	option		
MAH.20 AMR - 24 V	2000	600/800	1250	800/1000	450/1100	-	100/1600	100/3000	option		
MAH 30 AMR - 24 V	3000	800/1000	1250	1000/1250	450/1100	-	100/1600	100/3000	option	option	option
MAH 40 AMR - 24 V	4000	1000/1250	1600	1250/1500	900/2100	-	150/1600	150/3000	option	option	option
Includes: 24-volt batteries & 300 Ah & 220-volts mono 30-Ah charger											
MAH 60 AMR - DAF - 48 V	6000	1250	2000	1500	900/2100	300/1500	300/1800	300/3000	option	option	standard
MAH 80 AMR - DAF - 48 V	8000	1250/1500	2500	1500/1800	1200/2800	350/1500	350/1800	350/2500	option	option	standard
MAH 100 AMR - DAF - 48 V	10000	1250/1500	2800	1500/1800	1200/3500	400/1500	400/1800	400/2500	option	option	standard
Includes: 48-volt batteries & 225 Ah & 220-volts mono 30-Ah charger											

OPTION : *supplied on request* **STANDARD :** *included in the machine*

OPTION (all models)
AMR/H: HYDRAULIC COUPLING / UNCOUPLING
Entry or exit of coupling bayonet fittings is controlled directly using a lever located on the control unit of the equipment.

MANUBLOC Heavy Series – 6-T, 8-T and 10-T models

PARTICULAR CHARACTERISTICS (standard)

1. *On-board driver (travels standing up)*
2. *DAF – fixed post assisted steering*
3. *Bidirectional (crab movement): BID*
4. *Electronic control of accurate positioning.*

OVERALL SYSTEM : *The MANUBLOC MAH and its "QUICK BLOC" is the crucial element of the SYSTEM encompassing the advance layout of tools, presses and storage racks. Reducing tool changeover times to the minimum requires an overall view of this SYSTEM.*

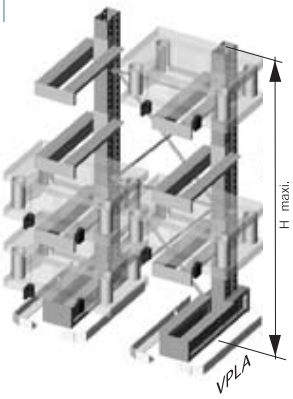
Subject to technical modifications

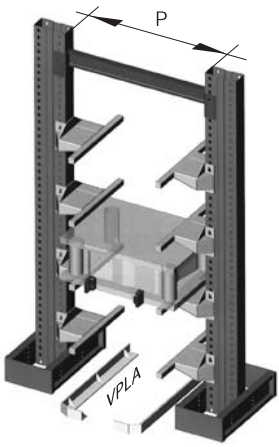
NEW CANTIBLOC RANGE

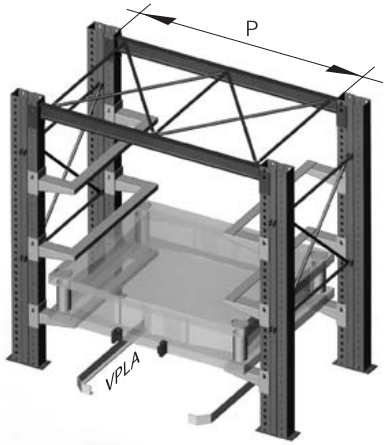
MNCA-CA-MACA

ROTOBLOC-PSP GROUPE DIMECO

Organise your space and store equipment in complete safety





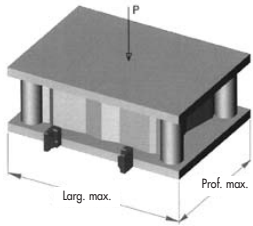


MINI CANTIBLOC
with 2 columns, max. tool weight = 3000 kg
Min. number of columns = 2

CANTIBLOC
with 2 columns
Max. tool weight = 6000 kg

MAXI CANTIBLOC
with 4 columns
Max. tool weight = 10,000 kg

PARTICULAR CHARACTERISTICS:
- *Lack of rails and crossbeams often allows for an additional storage level*
- *Lack of columns on front face: good visibility & easy access*
- *Height adjustment of different levels*
- *Holding tray: on request*



NOTES:
- *Compatible with MANUBLOC MAH*
- *Ground guides = VPLA: accurate MANUBLOC positioning*
- *DF = double-face version: replace letters SF with DF*

RANGE	TOOL *(when ordering, specify max. & min. width)*			RACK		
	max kg	Max depth mm	Max width mm	P : distance between column	H : Max height mm	Number of levels
Mini CANTIBLOC (single face)						
MN-CA-SF-30-070	3000	700	1200	-	3000	4+1= 5
CANTIBLOC (single face)						
CA-SF 30-060	3000	600	≈ 3000 *	= Maximum tool width +150 mm	3000	≈ 5
SA-SF 30-080	3000	800				
CA-SF 30-100	3000	1000				
CA-SF 40-080	4000	800				
CA-SF 40-100	4000	1000				
CA-SF 40-125	4000	1250				
CA-SF 60-100	6000	1000				
CA-SF 60-125	6000	1250				
MAXI CANTIBLOC (single face)						
MA-CA-SF 60-100	6000	1000	≈ 3500 *	= Maximum tool width +200 mm	3000	≈ 4
MA-SA-SF 60-125	6000	1250			3000	≈ 4
MA-CA-SF 80-125	8000	1250			2500	≈ 3
MA-CA-SF 80-150	8000	1500			2500	≈ 3
MA-CA-SF 100-125	10000	1250			2500	≈ 3
MA-CA-SF 100-150	10000	1500			2500	≈ 3

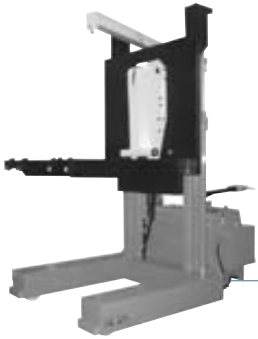
EP PATENT: 0892758; US PATENT: 6 129 502

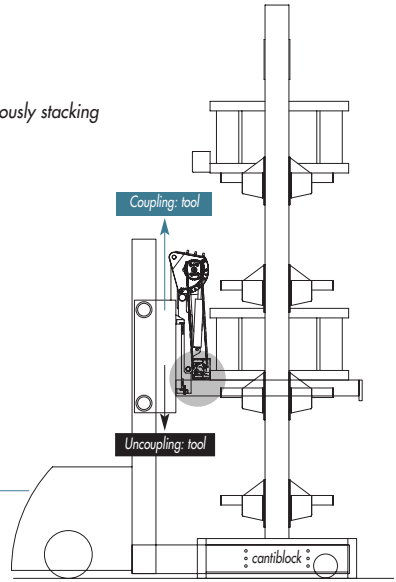
QUICK BLOC

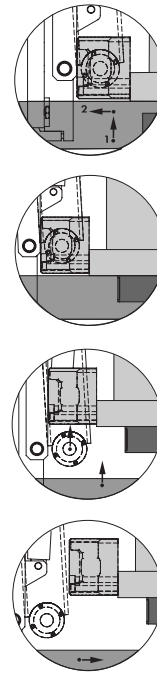
ROTOBLOC-PSP GROUPE DIMECO

The "QUICKBLOC" push/pull arm and its tool connection system have been internationally patented

This highly innovative system allows one to obtain:
- *very high thrust (or traction) force*
- *accurate positioning of the tool on the press bed*
- *coupling/uncoupling of tool directly and simultaneously stacking into the "cantibloc" rack.*

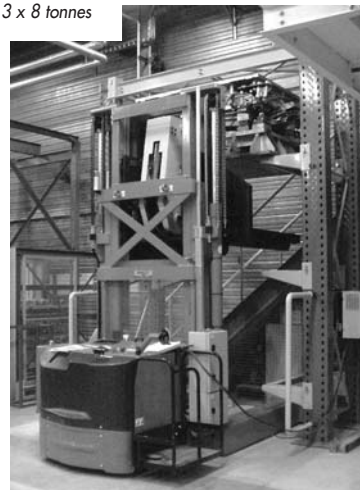


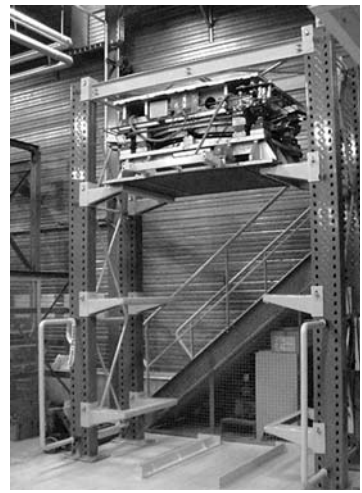




MANUBLOC + CANTIBLOC + (press equipment) = HIGH PERFORMANCE

Maxi Cantibloc 3 x 8 tonnes



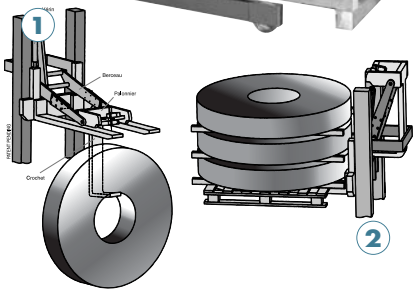


MANUCOIL

MAC

ROTOBLOC-PSP GROUPE DIMECO

Load a coil in less than a minute.



A - MANUCOIL *Documentation on request*

The MANUCOIL is a handling equipment allowing you to:
Grasp coils (vertical axis) from palettes (or deal).
Turn those coils around and load them onto horizontal decoilers.

All these operations are carried out from the control unit of the equipment WITHOUT ANY MANUAL INTERVENTION AT THE LEVEL OF THE COIL.

RANGE

It allows you to lift coils of up to 4-T, with a maximum weight of up to 550 mm. and a maximum external Ø of around 1500 mm.
It allows you to load coils onto a mandrel (horizontal axis) up to 800 mm. in width.

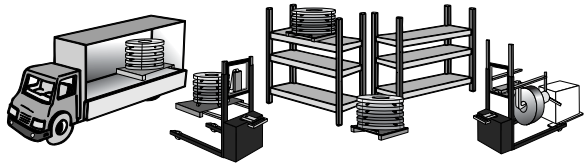
B - QUICK COIL

A very simple mechanism, the originality of the equipment is that:
In the lowered position (1) it consolidates the "CE" grip with the forks; thus, the coil "is rigid" in space throughout all handling.
In the raised position (2) it disappears within the shaft; the equipment resumes its initial function as a general stacking truck for palettes, containers etc.
A simple hydraulic valve (manual controls on the control unit) allows you to switch instantly from position (1) to position (2).

NOTES

- *The forged forks are standard and compatible with all European palettes. The QUICK COIL "CE", which is also forged, is built in dimensions such as will allow it to "slip" between the segments of the mandrel of the decoiler (3 or 4-jaw spindle).*
- ***For QUICK- COIL adaptable for a stacking truck already in service, please ask us for guidance.***

APPLICATIONS



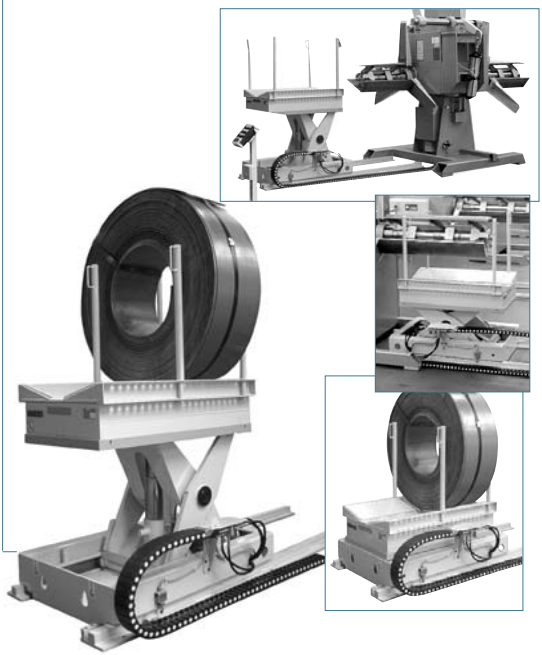
THREE MACHINES IN ONE: STACKING TRUCK + TURNOVER UNIT + LOADER

HIGH CAPACITY LOW-LOADING COIL CAR

CCS

ROTOBLOC-PSP GROUPE DIMECO

Loading a mandrel



LOADING & UNLOADING COIL CARS FOR HIGH CAPACITY DECOILERS

LOW-LOADING CONSTRUCTION
- *Allows you to load decoilers with low standing mandrel*
- *No civil engineering*

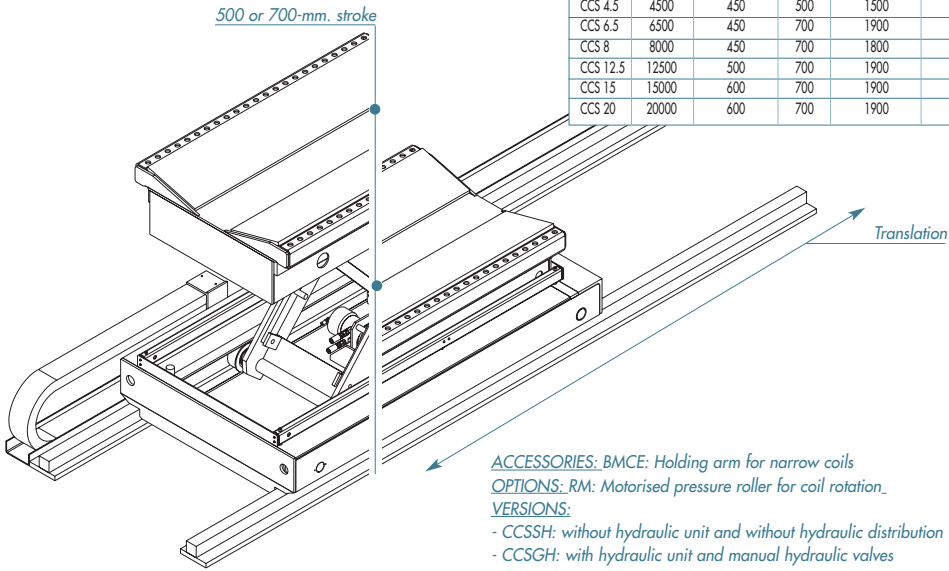
HIGH LIFTING STROKE
- *Loading of coils with very high diameters*
- *Unloading of coils that have been almost used up (without adjustment)*

SECURITY
- *Peripheral anti-crush bumper*
- *Peripheral anti-shearing frame*

SPECIFICATIONS
- *Hydraulic lifting speed: V = 0.6 – 1.1 m/mn.*
- *Hydraulic translation speed: V = 5 m/mn.*

- Lifting stroke = 500 or 700 mm.
- Altitude at bottom dead centre = 420-500-600 mm.

Model	Max. load (kg)	Altitude of BDC (mm)	Stroke (mm)	ext. Ø of coils Max. (mm)	Max. width of coils (mm)
CCS 3	3000	450	500	1500	1500
CCS 4.5	4500	450	500	1500	1500
CCS 6.5	6500	450	700	1900	1800
CCS 8	8000	450	700	1800	1800
CCS 12.5	12500	500	700	1900	2000
CCS 15	15000	600	700	1900	2000
CCS 20	20000	600	700	1900	2000



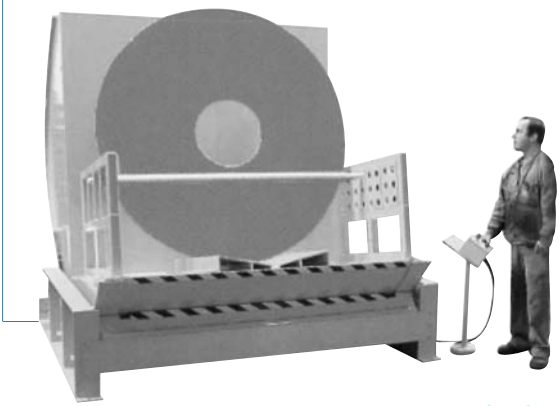
ACCESSORIES: BMCE: Holding arm for narrow coils
OPTIONS: RM: Motorised pressure roller for coil rotation
VERSIONS:
- CCSSH: without hydraulic unit and without hydraulic distribution
- CCSGH: with hydraulic unit and manual hydraulic valves
LENGTHS:
- Ground guide rails } *to be defined*
- Cable chains: } *according to set-up*

COIL AND PALETTE TURNING SYSTEMS

VCP

ROTOBLOC-PSP GROUPE DIMECO

Rotate material in complete safety



Very compact equipment
No civil engineering
Does not require a safety barrier
Loading / unloading by sling or stacking truck
Accessible from 4 sides
Movement time (90°) 10 to 15 seconds
Simplified commissioning

OPTION

VCV : Continuous speed variation
SSL : "V"-shaped gripper system with lateral security
SDL : "V"-shaped gripper system with double lateral security and safety bar

MODEL	Max. load (kg)	Max. coil Ø (mm)	Max. coil height (mm)
VCP 20-12-14	2000	1200	1400
VCP 30-12-14	3000	1200	1400
VCP 45-12-14	4500	1500	1400
VCP 30-15-14	3000	1500	1400
VCP 45-15-14	4500	1500	1400
VCP 60-15-14	6000	1500	1400
VCP 45-19-14	4500	1900	1400
VCP 60-19-14	6000	1900	1400
VCP 80-18-14	8000	1900	1400

OTHER CAPACITIES = Consult us.

PERSONAL NOTES

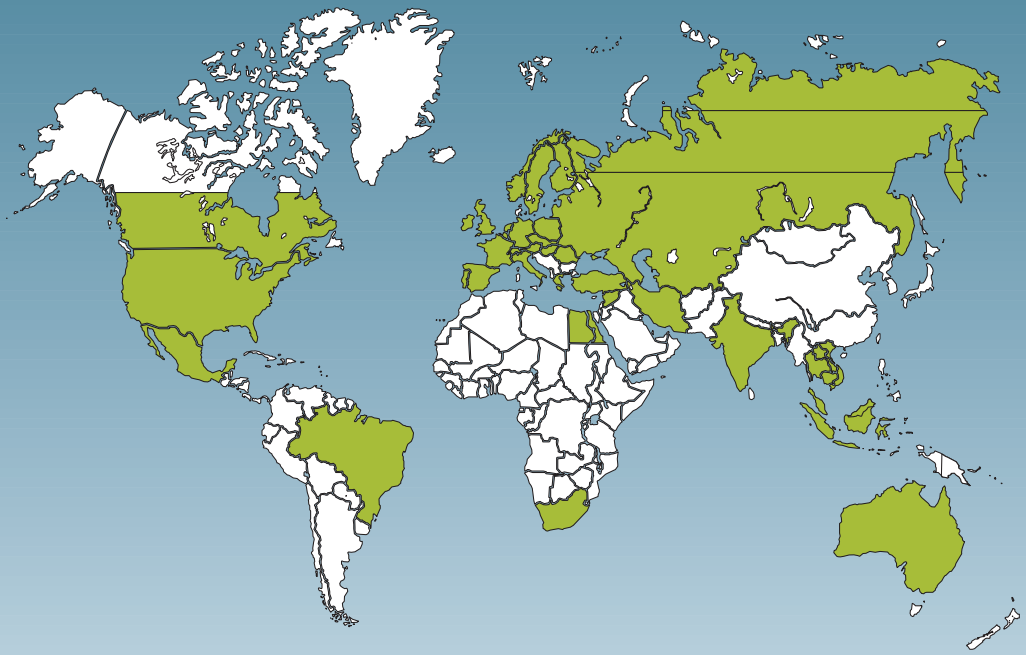
CCS : Coilcar - *capacity: 6.5 tonnes*
Series assembly

MAH Heavy Series Range: *from 6 to 10 tonnes*
SERIES ASSEMBLY OF TOOL HANDLING EQUIPMENT

A GLOBAL PRESENCE

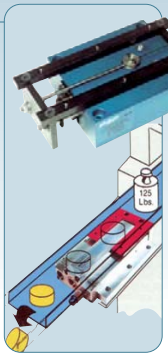
In all the industrialised countries, there is at least one person who speaks your language and knows our technologies.

To find your contact, please log to our website *http://www.rotobloc-psp.com/contact.php?rub=agentsInter*

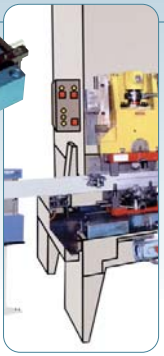


PROGRAM

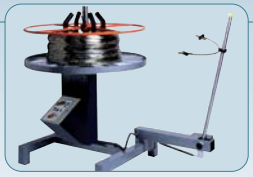
Electronic unit control

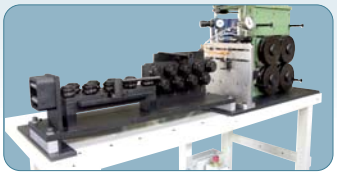


Friction Transport'air



Transfert unit NC conrol





Wire decoiler Wire feeder

Multimatic Tool transfert

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