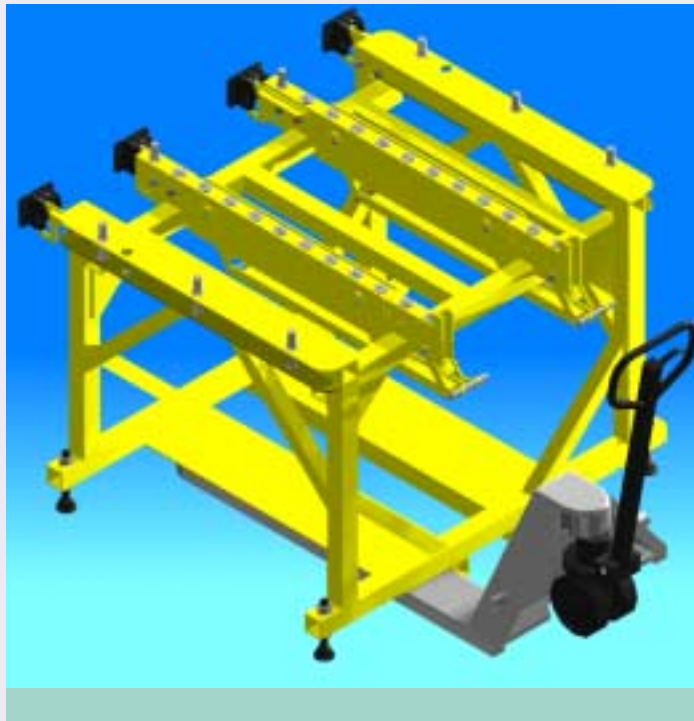


Die Handling Options Small Dies



**A leading manufacturer
of equipment for
Quick Die Change**

Use your Pallet Truck to Move Table and Dies to 3,500 lbs.

The Model-872 Die Transfer Table is moved on a flat floor using a Pallet Truck. The table is only elevated about 1/2" to avoid tip-over possibility. After table is docked to press or die rack the Pallet Truck's hydraulic lifting system can be used, if necessary, to match table height with bolster or rack.

Bolster Mounted Docking Bracket.
Optional item-may be installed in
any of the four locations shown.
(Only 2 are used).

Die Support Bridge

Pin-Die Stop (Qty 8)

Die Lifting Bar (Qty 2) shown recessed.
When elevated bars lift die above rollers.

Ball Roller (Qty 22) 250 lbs. capacity each.
For cylindrical rollers specify Model-872CR.

Stability and Die Fall Through Protection
(Qty 3). Die Support Bridge Spacing and
Die Fall Through Protection are cus-
tomized for each application.

Fixed Die Stop (Qty 2)

Handle (Qty 2)
Shown extended-Die Lifting Bar is
recessed.

Fork Lift Tine Clearance (Qty 2).
If not required a plate, close to roller
level, can be installed.

Pad (Qty 4)
For one time height adjustment to
match bolster height.

Pallet Truck Tine Access. Elevate table
about 1/2" when moving.

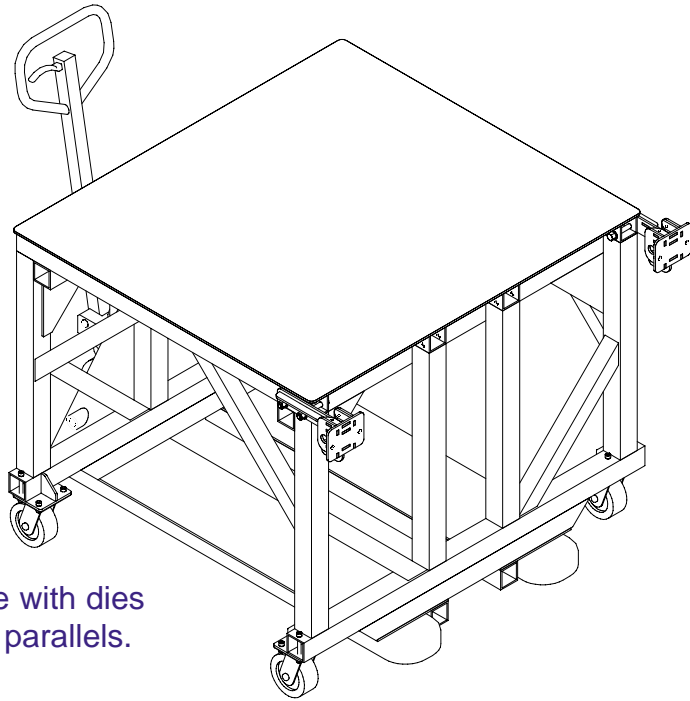
Use this table Model-872BR
(with Ball Roller) or Model-
872CR (with Cylindrical
Roller) when dies have flat
bottom surface.

Typical Die Exchange Sequence

- An empty table is docked at the rear of the press.
- Die is unclamped and ram is elevated.
- In-bolster die lifters are elevated and die is rolled onto rear table.
- Next die is staged on another table nearby. Die Lifting Bar is already elevated to support die above roller balls. Pallet truck is used to position table at bolster. (Use docking brackets if table pads are not supporting table during die exchange.)
- Die Lifting Bars are recessed by pulling handle forward.
- Die (now supported by ball rollers) is squared, centered and pushed onto bolster.
- Table is removed, die lifters are recessed and die is clamped.
- Later the rear table is used to move die to die maintenance or storage area.

Please note that all dimensions are shown in inches.

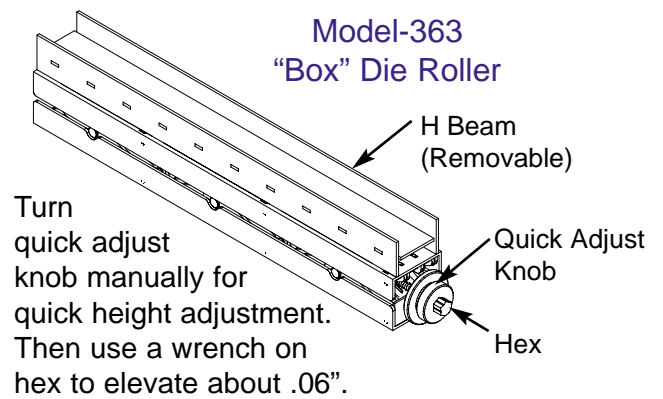
**Model-872PN
Table**



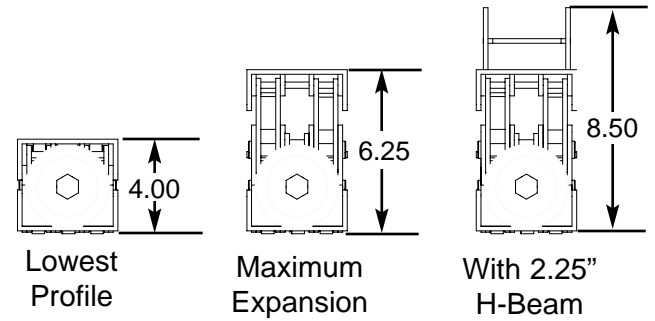
For use with dies having parallels.

Model-872PN has a flat plate on top allowing use of die rollers which lift the die and travel with the die onto the top of the bolster. Refer to illustration examples below and on the back page.

**Model-363
"Box" Die Roller**

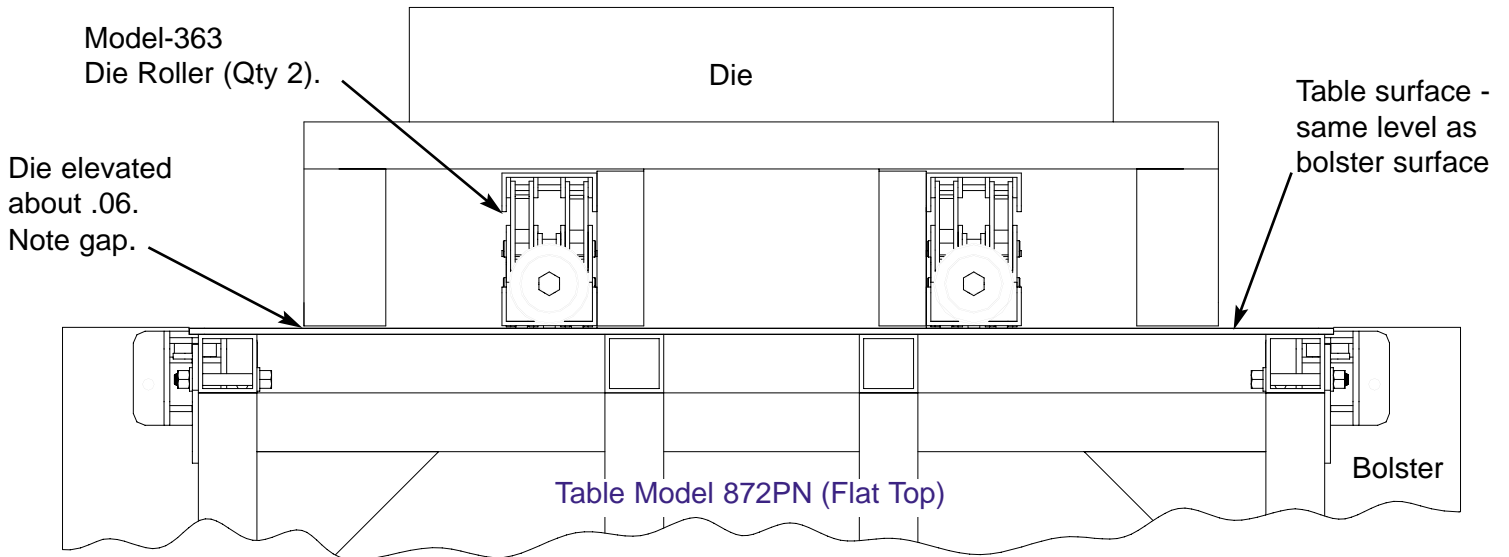


Turn quick adjust knob manually for quick height adjustment. Then use a wrench on hex to elevate about .06".



H-Beam is available in different heights. A total of 15 side by side roller bearings support each die roller. Heights shown above are required minimum and maximum parallel heights.

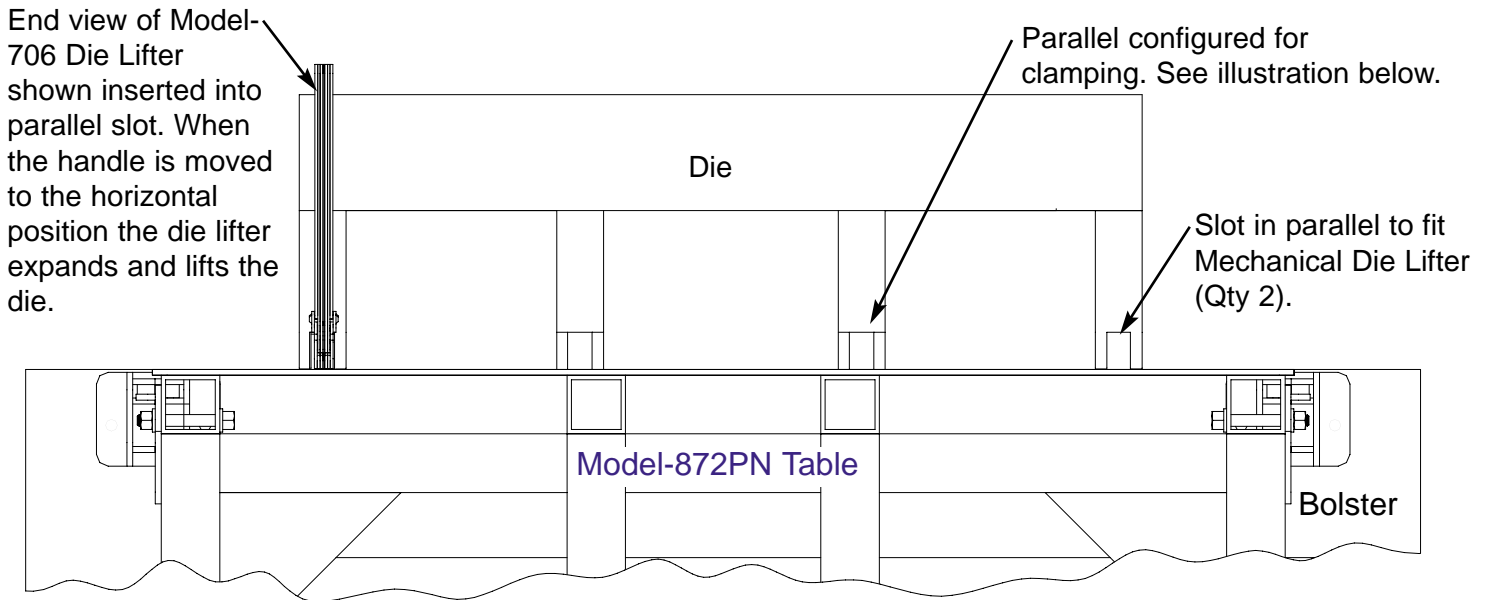
Application Example - Box Die Rollers/Flat Table Top



Typical Die Loading Sequence

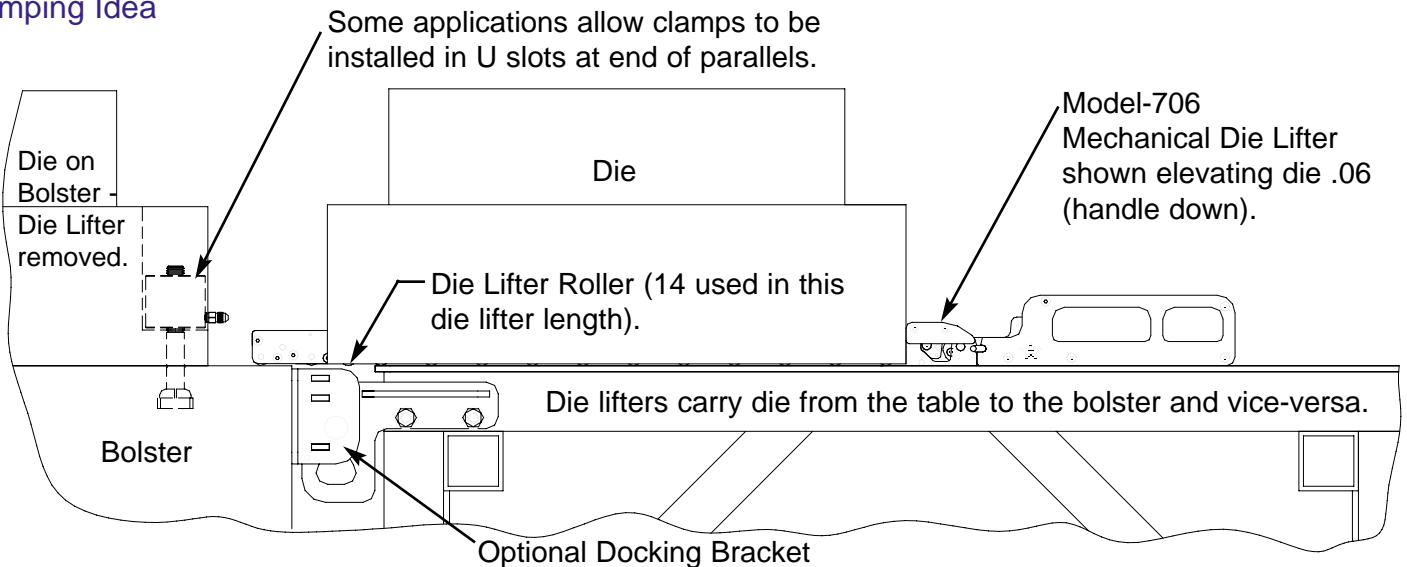
- Die table is docked at press - previous die is already removed.
- Box style die lifters are placed adjacent to two parallels and elevated so that the die is lifted about .06 as illustrated above. (Side by side rollers on bottom of die rollers allow running die roller along a T-slot.)
- Die is pushed onto bolster.
- Die table is removed.
- Die lifters are lowered and pulled away from the die.

Application Example - Mechanical Die Lifter/Flat Table



Die Exchange using Table and Mechanical Die Lifters

Clamping Idea



When die is placed on the Model-872PN DieTable, Model-706 Die Lifters are inserted into 1 1/2" deep slots milled in two parallels. Die Lifters are elevated and the die rolled onto the bolster. The die lifters are then lowered and removed from the parallel slots. The die is clamped, perhaps using clamps as shown above. To remove a die the die lifters are inserted into slots after unclamping die. The die lifters are elevated and the die rolled onto the table. For further data see Mechanical Die Lifters Applications Guide.

Related Brochures:

Die Lifters • Bolster Extensions • Mechanical Die Lifters • Clamps • Power and Control Modules

Please visit our Web Site at www.astar.com to download and print this and other brochures.



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