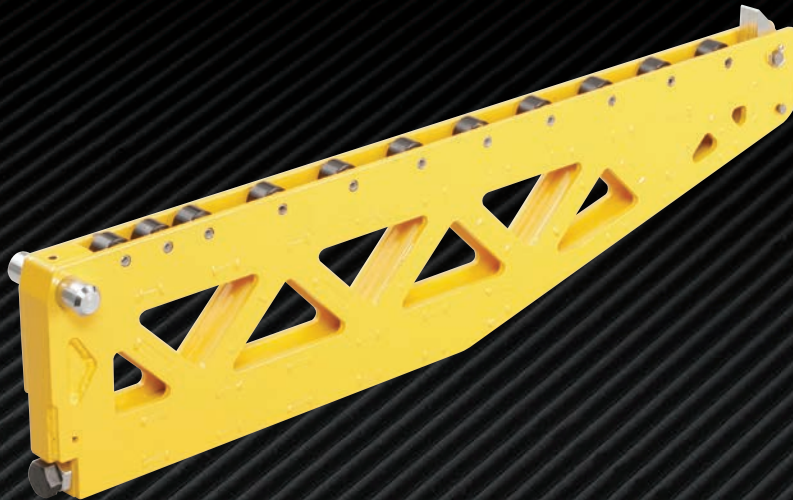


MODEL 520 & 540 BOLSTER EXTENSIONS



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**S3202 BE-520-540
REV A - 10/18**

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INTRODUCTION

NOTICE: The following instructions are guidelines written for experienced mechanics who takes proper safety precautions. All work should be performed to local and internal safety requirements and approved by the company safety officer or appropriate authority. Only experienced mechanics should perform installation of Bolster Extension mounting brackets.

CAUTION:

BOLSTER EXTENSIONS ARE DESIGNED FOR SPECIFIC WEIGHT LIMITS.

MODEL BE-520 - DO NOT EXCEED 6,000 LBS. FOR EACH PAIR (3,000 LBS. PER ARM).

MODEL BE-540 – DO NOT EXCEED 8,000 LBS. FOR EACH PAIR (4,000 LBS. PER ARM).

CAUTION: TO AVOID DAMAGE TO EQUIPMENT AND PERSONAL INJURY, USE MOUNTING BOLTS SUPPLIED WITH EACH BOLSTER EXTENSION. IF REPLACED, USE ONLY BOLTS WITH A TENSILE STRENGTH OF 170,000 PSI MINIMUM. ENSURE ADEQUATE THREAD ENGAGEMENT FOR ALL SCREWS.

CAUTION: REVIEW ENTIRE INSTALLATION PROCEDURE PRIOR TO INSTALLATION TO ENSURE CONSIDERATION IS GIVEN TO SPACING, LEVELING, AND MOUNTING HOLE LOCATIONS AND ADJUSTMENT.

INSTALLATION

1. Refer to appropriate mounting bracket drawing for your application (Model 520 - drawing 910 or 6088 and for Model 540 – drawing 918) and study it carefully. This drawing shows mounting hole pattern referenced to the top of the bolster surface and provides a method of calculating location based on matching Bolster Extension roller height to die lifter roller height. Typical die lifter roller heights range from .080" to .125".

X = Distance from Bolster surface to hole location. Calculate using formula provided on drawing. Contact PFA for assistance.

CAUTION:
MAKE SURE THAT BOLSTER EXTENSIONS ARE SPACED APART PROPERLY, SO THE SMALLEST DIE WILL FIT ON THE BOLSTER EXTENSIONS AND ALL DIES ARE EVENLY SUPPORTED.

2. After drilling and tapping the mounting holes as shown (Model 520 - drawing 910 or 6088 or Model 540 – drawing 918) secure the brackets lightly with socket head cap screws.

Note: The mounting brackets have been counterbored for the socket head cap screws. Place the screws in the bracket and ensure adequate engagement.

3. Place the Bolster Extensions in the brackets and check for proper roller height, fit, and alignment. Make any required adjustment by loosening the screws and repositioning (tapping with soft hammer) as necessary and allowable within the adjustment provided by the .020" oversized bracket mounting holes. If a little more adjustment is necessary a few thousandths may be reamed out of the mounting bracket bolt holes for more adjustment.
4. Adjust the hex head cap screw at the bottom of each Bolster Extension to level the rollers and ensure they are horizontal and aligned with the die lifter rollers in the lifted position. Repeat adjustments of height and level as needed.
5. When all necessary adjustments have been made, secure all screws to proper torque and check hex head cap screw adjustment for final leveling. Conduct final roller height to lifter alignment check using a long piece of flat bar stock or similar methods, before final pinning of the mounts.
6. Transfer Drill the holes for the 3/8" (Model 520) or 5/8" (Model 540) diameter roll pins into bolster.

Note: Examine the roll pins to ensure that they are long enough for adequate bolster engagement.

7. Drive the two roll pins into final position.

OPERATING INSTRUCTIONS

1. To remove the Bolster Extension elevate the **end** opposite the bolster and lift straight up so that the horizontal pin can clear top of mounting bracket.
2. To replace the Bolster Extension elevate **the end opposite the pin** and lower the horizontal pin into the mounting bracket.
3. After placing Bolster Extensions in mounting brackets make sure that each arm is level (horizontal).

MAINTENANCE

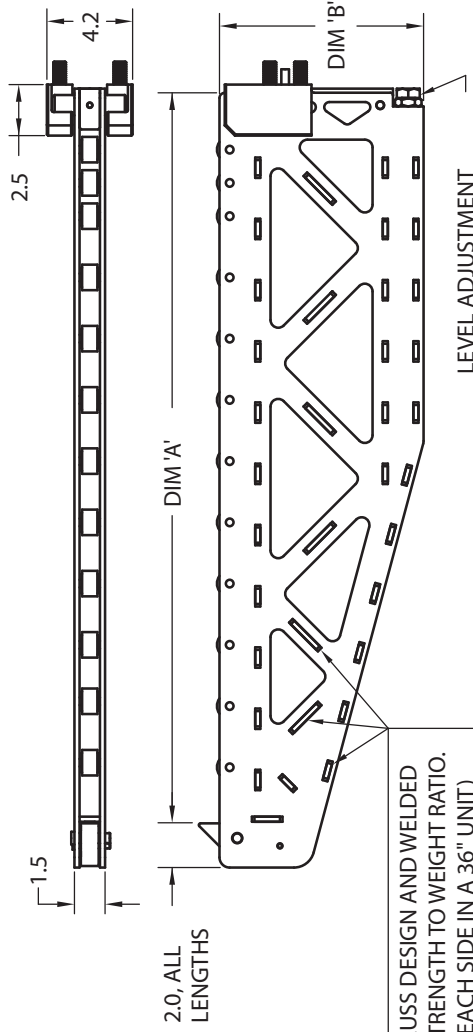
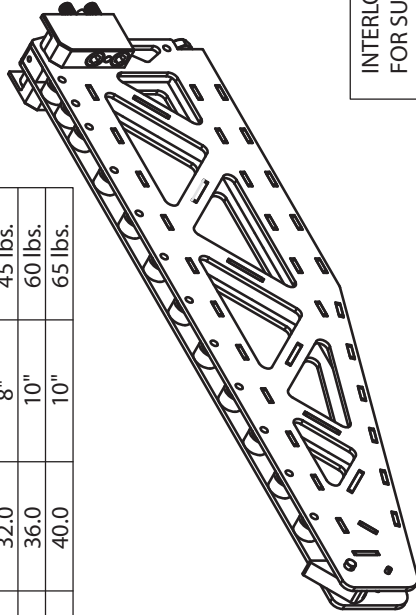
1. Periodically check to ensure that the die stops are operating freely. The die stops will prevent a stationary die from rolling off the bolster. Apply light lubrication as necessary and perform any required repairs.
2. Promptly notify safety engineers in the event of a forklift collision with a Bolster Extension or a die being placed on the Bolster Extension with sufficient shock to possibly cause damage.

If such an event takes place do not use the Bolster Extensions until a safety inspection has been performed by a safety engineer. Do not use until the Bolster Extensions are reviewed and confirmed to be undamaged.

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MODEL#	DIM 'A'	DIM 'B'	WEIGHT
520-14	14.0	6"	15 lbs.
520-16	16.0	6"	20 lbs.
520-20	20.0	6"	25 lbs.
520-24	24.0	8"	35 lbs.
520-28	28.0	8"	40 lbs.
520-32	32.0	8"	45 lbs.
520-36	36.0	10"	60 lbs.
520-40	40.0	10"	65 lbs.



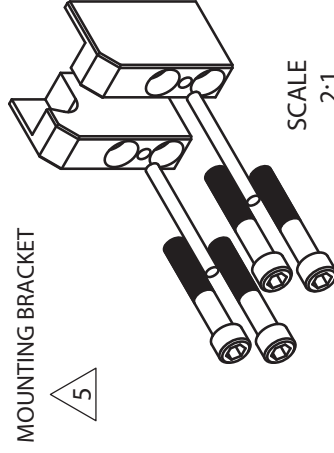
5. REFER TO INSTALLATION INSTRUCTIONS AND DWG. #910 FOR MOUNTING SPECIFICATIONS.

4. MINIMUM BOLSTER THICKNESS TO ACCOMMODATE ILLUSTRATED MOUNTING BRACKET IS 4.50. SPECIAL BRACKETS FOR THINNER BOLSTERS ARE AVAILABLE (PART# 6088 BRACKET ASSEMBLY).

3. INSTALL MOUNTING BRACKETS ON SEVERAL PRESSES FOR MAXIMUM UTILITY. IF THE 'B' DIMENSION EXCEEDS BOLSTER THICKNESS, USE PRESS BED OR FABRICATED SOLID STRUCTURE TO SUPPORT BOLSTER EXTENSION AT THE LEVEL ADJUSTMENT POINT.

2. LOAD/UNLOAD DIES USING FORKLIFT, DIE CART OR CRANE. THE FORCE REQUIRED TO ROLL DIES ON/OFF THE BOLSTER EXTENSIONS IS IN THE RANGE OF 1% TO 3% OF THE DIE WEIGHT.

1. THE MODEL-520 IS A LIFT-OFF BOLSTER EXTENSION WHICH ALLOWS CONVENIENT LOADING AND UNLOADING OF DIES ONTO/FROM PRESS BOLSTERS. DIE WEIGHT CAPACITY PER PAIR IS 6000 LBS. SEVERAL OTHER MODELS WITH GREATER LOAD CAPACITY ARE AVAILABLE.



MODEL 520 BOLSTER EXTENSION

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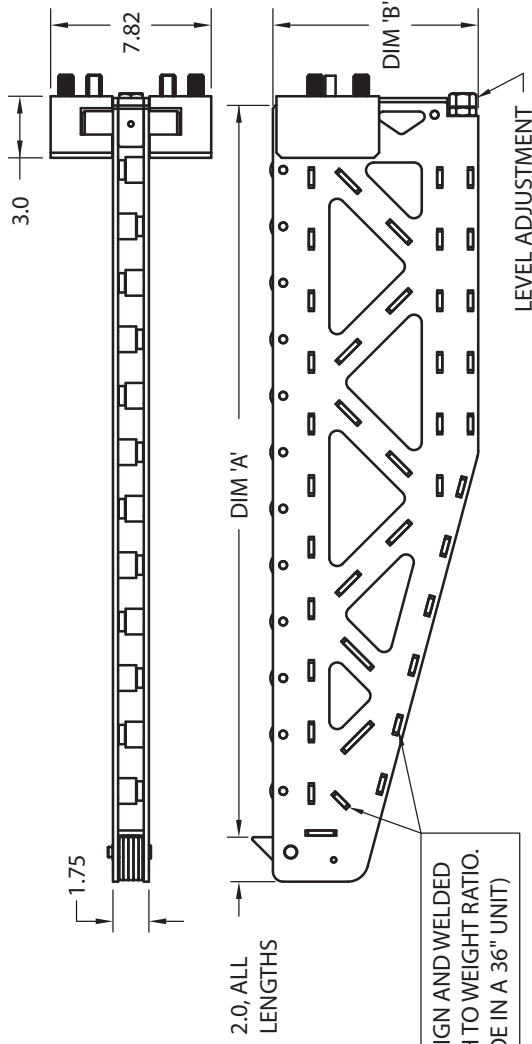
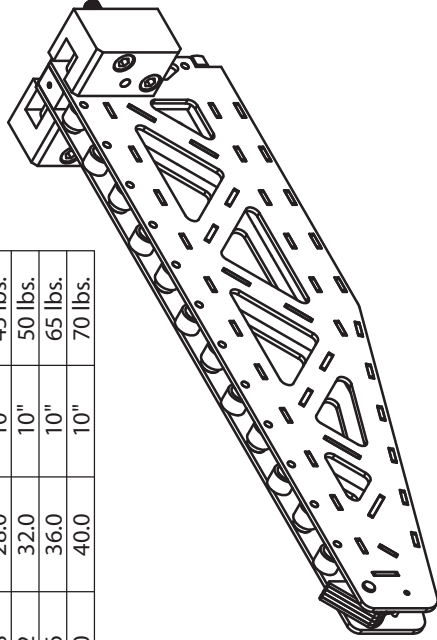
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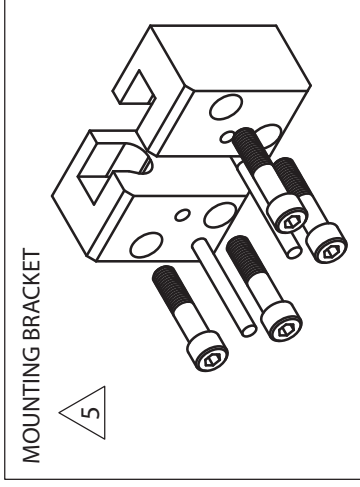
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MODEL#	DIM 'A'	DIM 'B'	WEIGHT
540-24	24.0	10"	40 lbs.
540-28	28.0	10"	45 lbs.
540-32	32.0	10"	50 lbs.
540-36	36.0	10"	65 lbs.
540-40	40.0	10"	70 lbs.



INTERLOCKED TRUSS DESIGN AND WELDED FOR SUPERIOR STRENGTH TO WEIGHT RATIO. (36 INTERLOCKS EACH SIDE IN A 36" UNIT)

5. REFER TO INSTALLATION INSTRUCTIONS AND DWG. #918 FOR MOUNTING SPECIFICATIONS.
4. MINIMUM BOLSTER THICKNESS TO ACCOMMODATE MOUNTING BRACKET IS 5.00.
3. INSTALL MOUNTING BRACKETS ON SEVERAL PRESSES FOR MAXIMUM UTILITY. IF THE 'B' DIMENSION EXCEEDS BOLSTER THICKNESS USE PRESS BED OR FABRICATED SOLID STRUCTURE TO SUPPORT BOLSTER EXTENSION AT THE LEVEL ADJUSTMENT POINT.
2. LOAD/UNLOAD DIES USING FORKLIFT, DIE CART OR CRANE. THE FORCE REQUIRED TO ROLL DIES ON/OFF THE BOLSTER EXTENSIONS IS IN THE RANGE OF 1% TO 3% OF THE DIE WEIGHT.
1. THE MODEL-540 IS A LIFT-OFF BOLSTER EXTENSION WHICH ALLOWS CONVENIENT LOADING AND UNLOADING OF DIES ONTO/FROM PRESS BOLSTERS. DIE WEIGHT CAPACITY PER PAIR IS 8000 LBS. SEVERAL OTHER MODELS WITH GREATER LOAD CAPACITY ARE AVAILABLE.

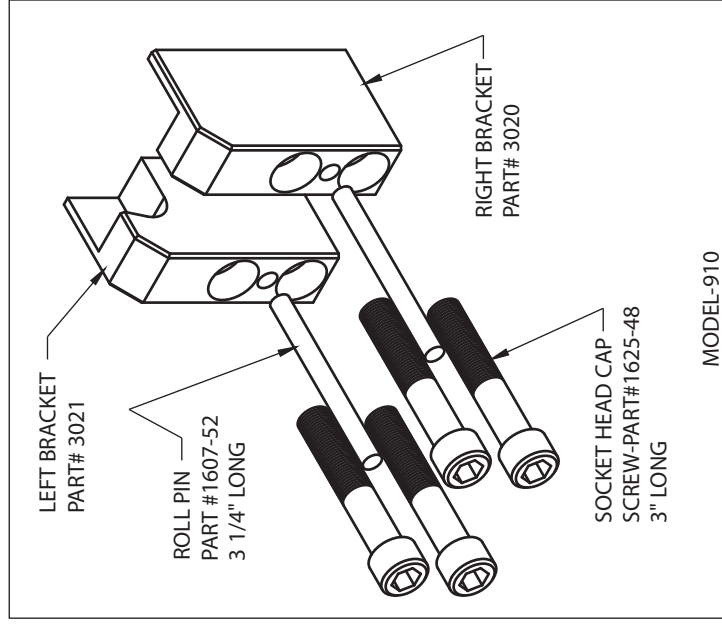
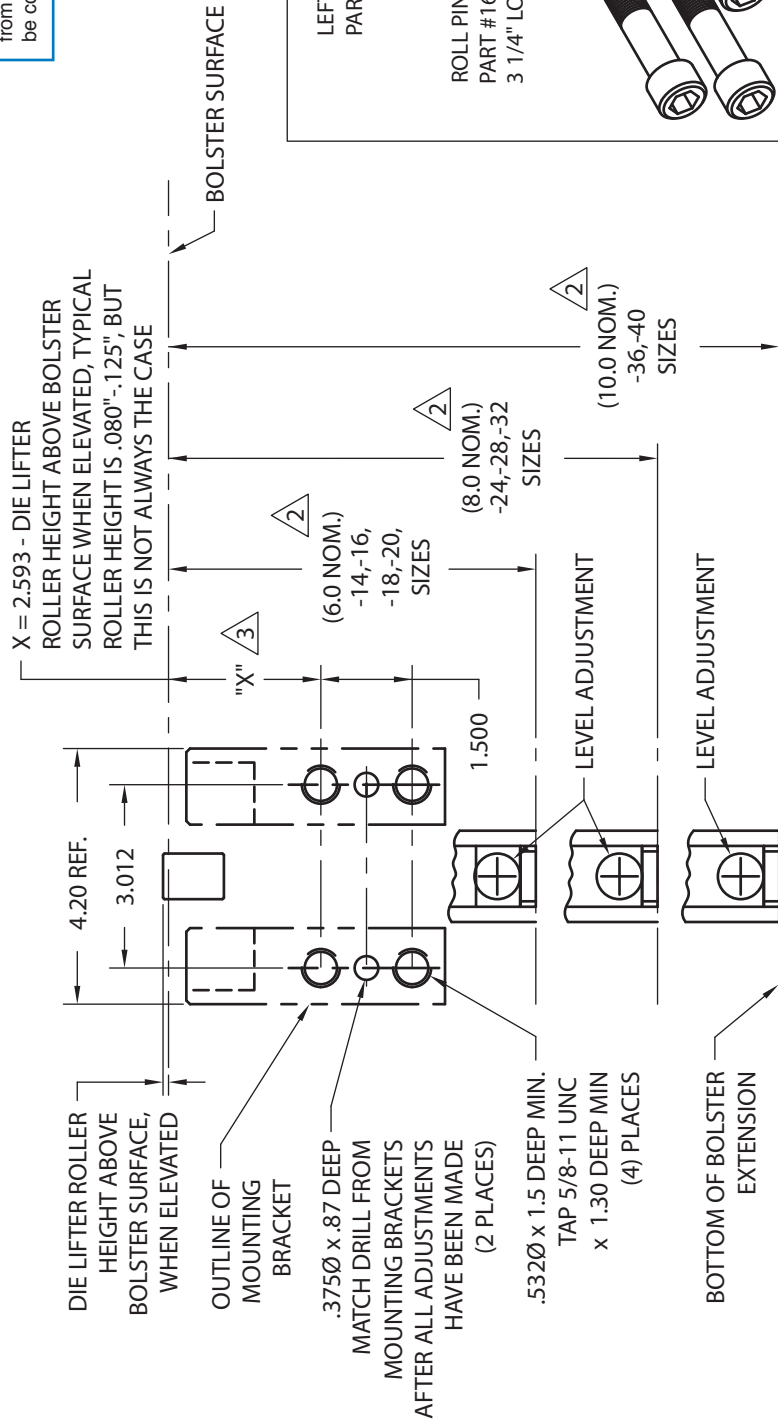


MODEL 540 BOLSTER EXTENSION

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3. DIMENSION FROM BOLSTER SURFACE TO UPPER BRACKET MOUNTING HOLE IS 2.593 MINUS THE DIE LIFTER ROLLER ELEVATION ABOVE THE BOLSTER SURFACE WHEN RAISED. FOR EXAMPLE, IF THE DIE LIFTERS RAISED .080" ABOVE THE BOLSTER SURFACE, THEN 2.593" - .080" = 2.513", SO THE DIMENSION FROM THE BOLSTER SURFACE TO THE UPPER BRACKET MOUNTING HOLE WOULD EQUAL 2.513". ADJUST THIS LOCATION AS NECESSARY TO MATCH THE DIE LIFTER ELEVATED HEIGHT.

NOTE: IF THIS DIMENSION IS LESS THAN 2.210 THE MOUNTING BRACKET WILL PROTRUDE ABOVE THE BOLSTER SURFACE.

2. THIS DIMENSION REFLECTS BOTTOM OF INSTALLED BOLSTER EXTENSION AND SHOWS WHERE SUPPORT IS NECESSARY FOR THE LEVEL ADJUSTMENT SCREW. IF THIS DIMENSION EXCEEDS BOLSTER THICKNESS, USE PRESS BED OR FABRICATED SOLID STRUCTURE TO SUPPORT BOLSTER EXTENSION AT THE LEVEL ADJUSTMENT POINT.

1. THIS MOUNTING HOLE PATTERN IS FOR MODEL 910 MOUNTING BRACKET, FOR USE WITH MODEL 520 BOLSTER EXTENSIONS.



MODEL 910 MOUNTING BRACKET

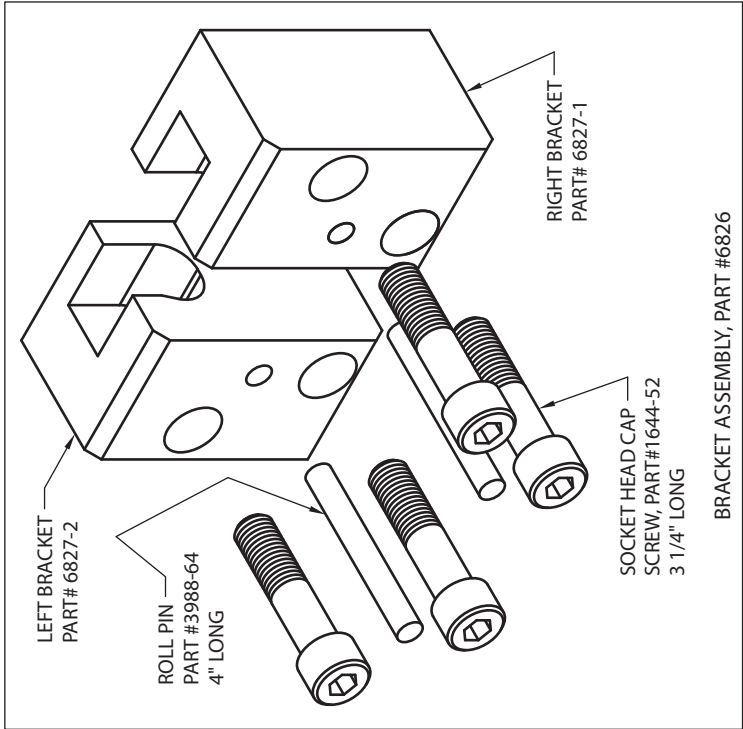
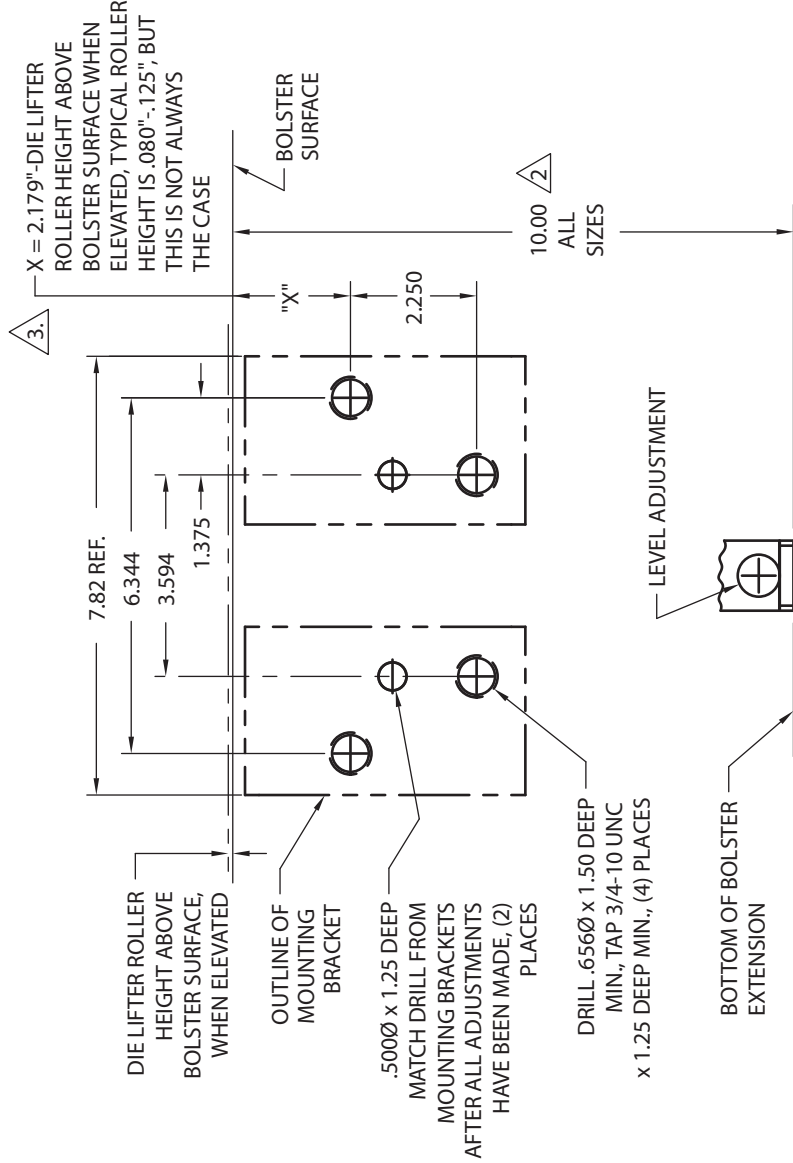
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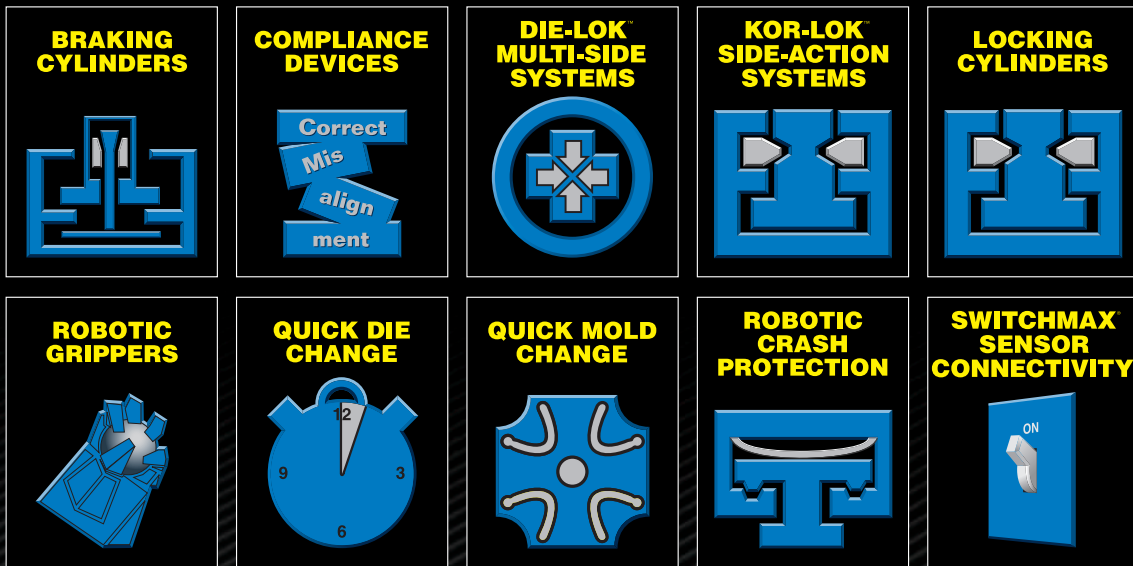
- 3. REFER TO INSTALLATION INSTRUCTIONS FOR MOUNTING SPECIFICATIONS. MOUNTING HOLE LOCATIONS ARE CALCULATED USING THE ELEVATED DIE LIFTER ROLLER HEIGHT AS A REFERENCE.
- 2. THIS DIMENSION REFLECTS WHERE SUPPORT IS NECESSARY FOR THE LEVEL ADJUSTMENT SCREW. IF THIS DIMENSION EXCEEDS BOLSTER THICKNESS, USE PRESS BED OR FABRICATED SOLID STRUCTURE TO SUPPORT BOLSTER EXTENSION AT THE LEVEL ADJUSTMENT POINT.
- 1. THIS MOUNTING HOLE PATTERN IS FOR P/N 6826 MOUNTING BRACKET FOR USE WITH MODEL 540 BOLSTER EXTENSIONS.

(REFERENCE, FORMERLY DWG. #540-6826BRK)



MODEL 918 MOUNTING BRACKET

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