



Rack Systems for Die Storage
for safe and efficient die change



Advantages

- Safe, force-saving and wear-free die storage
- Time-saving die change
- High level of safety due to docking station and semi-automatic, secured front bars or safety bolts as fall protection on the front side
- Optimum transfer height into the rack system and changing carts
- Optimised for ROEMHELD die changing carts

Application examples



Die changing cart RW 500 with semi-automatic docking hooks and safety bolts

Application

Rack systems with special roller conveyors or ball tables enable the user to change heavy dies safely, with less effort and in less time. Mounted docking hooks or bars on the rack system enable precise positioning and safe docking on the rack system. An additional mechanical safety bolt or bar is automatically activated after docking to prevent dies from rolling out unintentionally after they have been stored.

Design and further technical details in the project and according to customer-specific requirements. Please contact us!

Description

The die changing cart is hooked into the docking hooks or front bar at the front of the rack. The safety bar or bolt is only lowered by successfully docking to the front of the rack. The table on the die changing cart is equipped with ball inserts or ball bars that facilitate manual or semi-automatic die insertion. The rack system can be equipped with roller conveyors or ball tables.

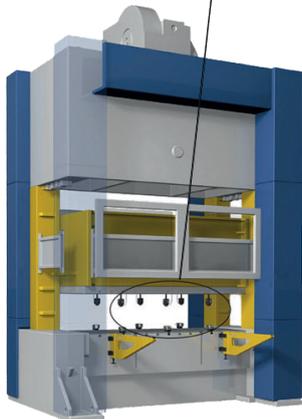
When the die changing cart leaves the docking hooks, safety bars or bolts on the rack system are activated and the die is secured against falling out.



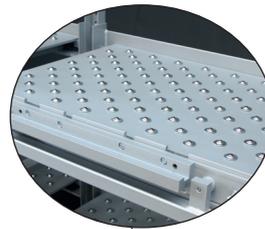
Die changing cart RWA 4000 with docking bar and pull-push chain



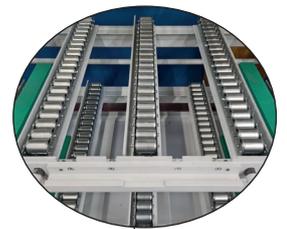
Clamping and positioning in the press



Die transport with die changing cart of type RW 500 to RWA 4000



Rack with ball table and docking bar

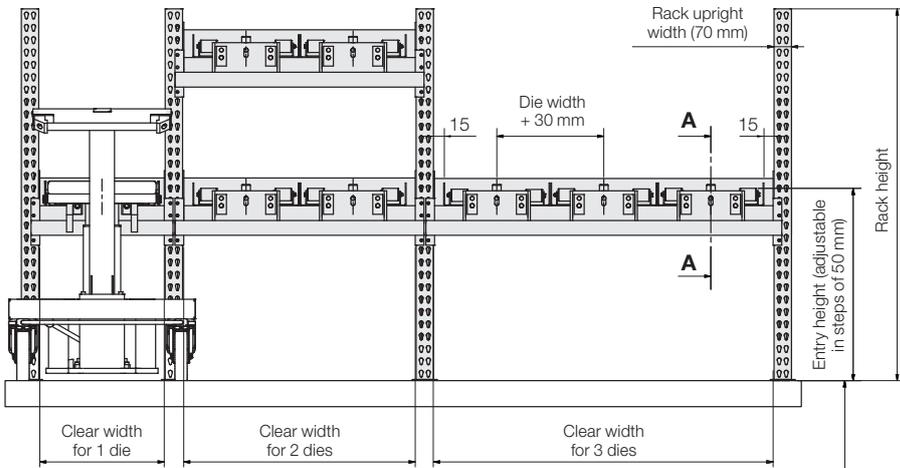


Rack with roller conveyors and docking bar

Rack systems for die changing cart RW 500

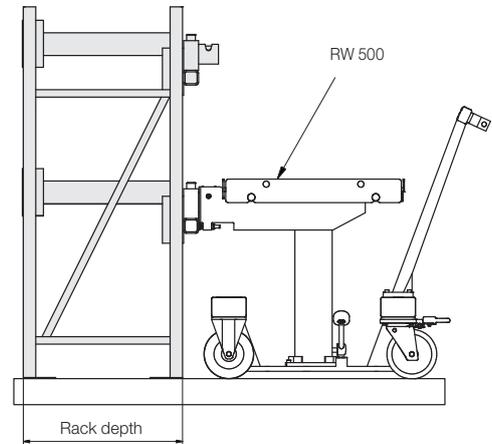
Version for die changing cart RW 500

Rack system with roller conveyors or ball table. On the rack with docking hooks, mechanical lock and end stop at the back. Suitable docking system for a die changing cart size RW 500 for die weights up to 500 kg.



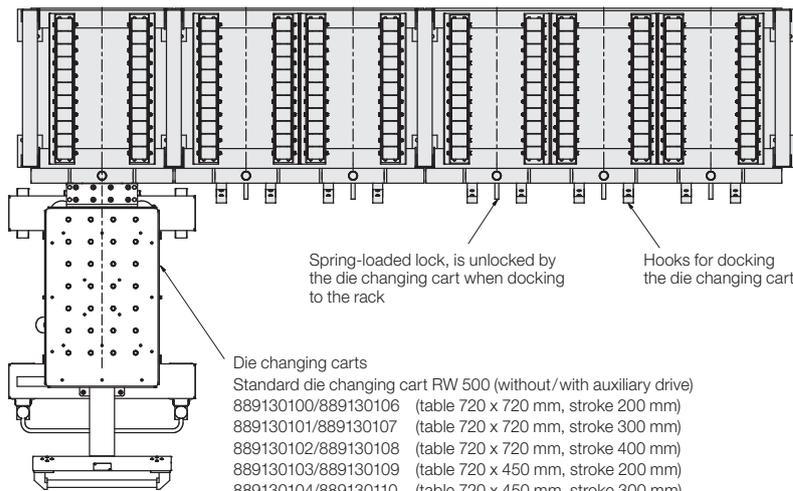
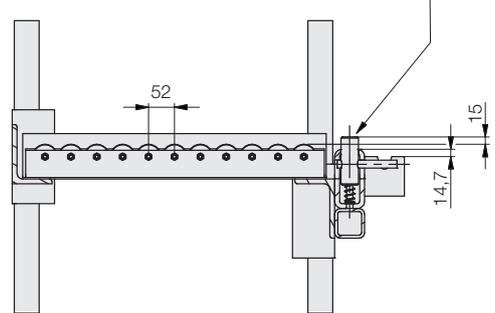
Min. entry height when using RW 500 with 200 mm stroke as 889130100 = 578.5 mm
 Min. entry height when using RW 500 with 300 mm stroke as 889130101 = 678.5 mm
 Min. entry height when using RW 500 with 400 mm stroke as 889130102 = 778.5 mm

Minimum distance of the dies: 285 mm (on the table)



Unlocking the lock by pressing down the spring pin
 Spring force until unlocked approx. 375 N

A - A



Die changing carts

- Standard die changing cart RW 500 (without/with auxiliary drive)
- 889130100/889130106 (table 720 x 720 mm, stroke 200 mm)
- 889130101/889130107 (table 720 x 720 mm, stroke 300 mm)
- 889130102/889130108 (table 720 x 720 mm, stroke 400 mm)
- 889130103/889130109 (table 720 x 450 mm, stroke 200 mm)
- 889130104/889130110 (table 720 x 450 mm, stroke 300 mm)
- 889130104/889130111 (table 720 x 450 mm, stroke 400 mm)

Max. possible entry heights into the rack depending on the stroke

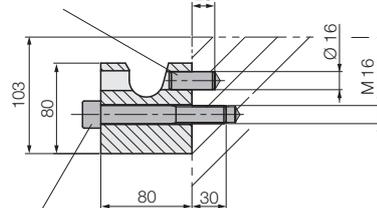
Die changing cart RW 500

see catalogue sheet WZ 8.8900

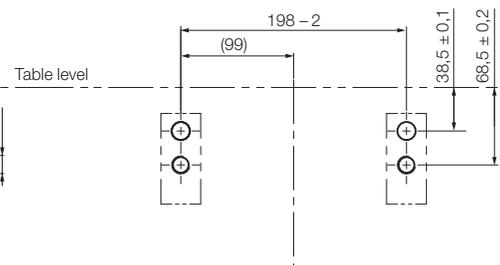
Accessories

Docking hooks (1 set = 2 off)
 to position and lock the die changing cart
Part no. 789130001

Dowel pin
 DIN 1481 Ø16x40



Socket head cap screw
 DIN 912-M 16 x 110 - 8.8
 Ma = 120 Nm



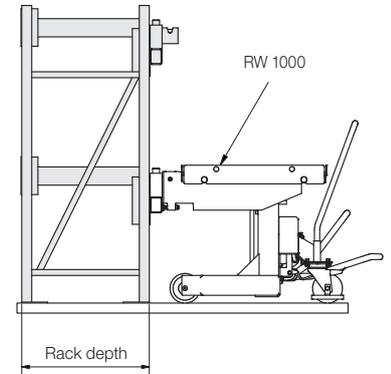
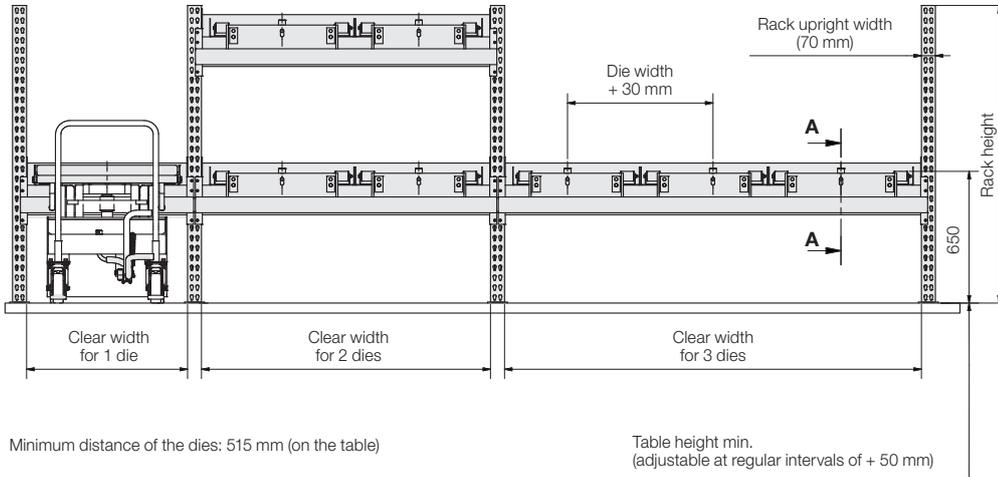
Dimensions are valid for the infed height of the die 1.5 mm above the machine table

Rack systems for die changing cart RW 1000

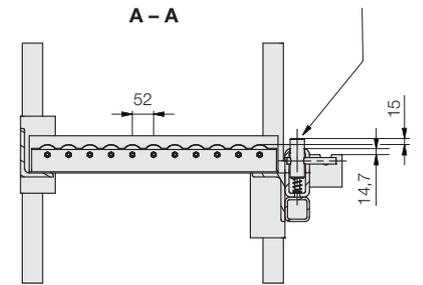
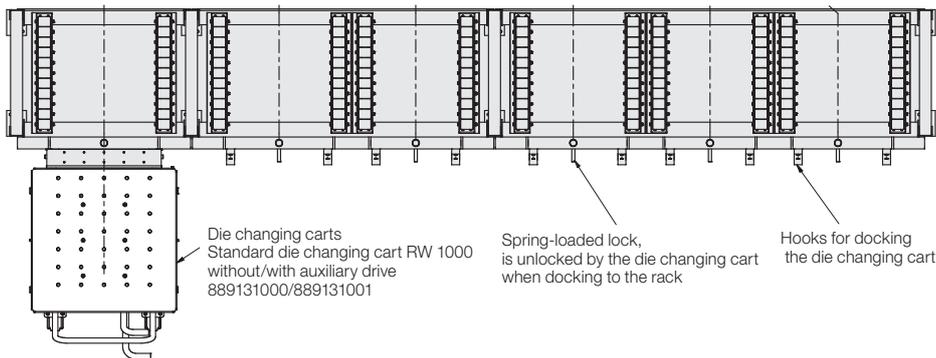
Version for die changing cart RW 1000

Rack system with roller conveyors or ball table. Suitable docking system for a die changing cart size RW 1000 for die weights up to 1,000 kg.

On the rack with docking hooks, mechanical lock and end stop at the back. The field widths, the rack depths and the number of roller conveyors are supplied according to the customer's dies.



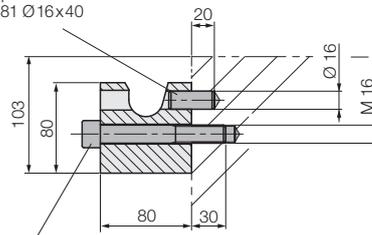
Unlocking the lock by pressing down the spring pin
Spring force until unlocked approx. 375 N



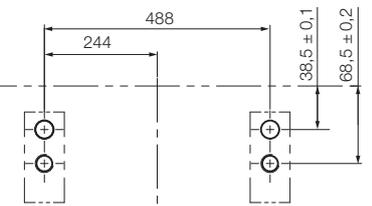
Accessories

Docking hooks (1 set = 2 off)
to position and lock the die changing cart
Part no. 789130001

Dowel pin
DIN 1481 Ø16x40



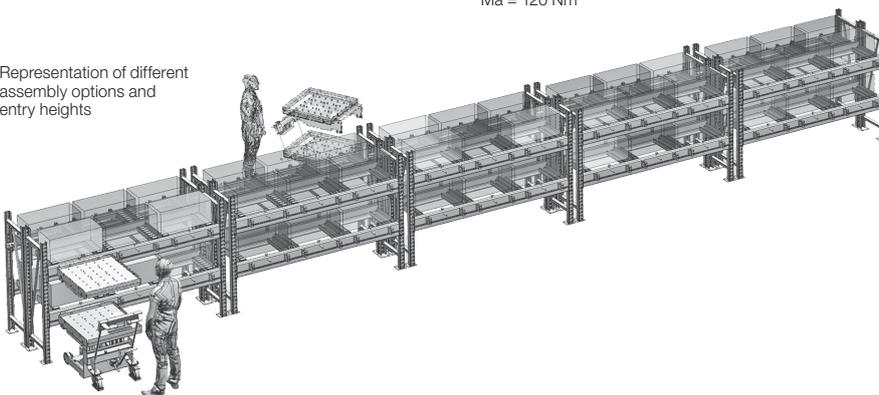
Socket head cap screw
DIN 912-M 16 x 110 - 8.8
Ma = 120 Nm



Dimensions are valid for the infeed height of the die 1.5 mm above the machine table

All dimensions in [mm]

Representation of different assembly options and entry heights

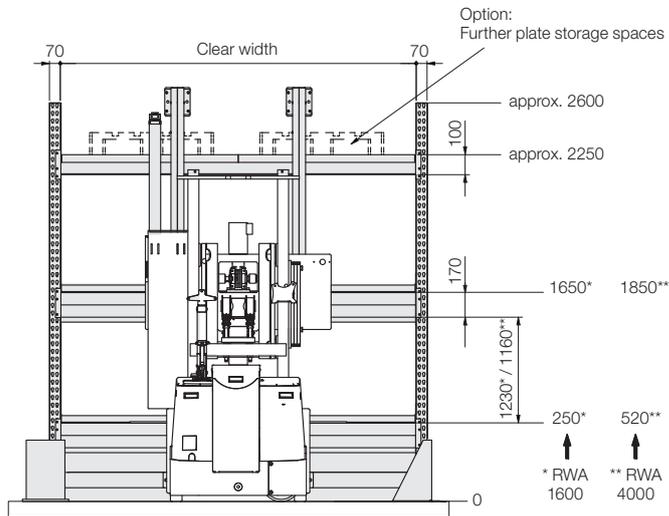


Die changing cart RW 1000
see catalogue sheet WZ 8.8901

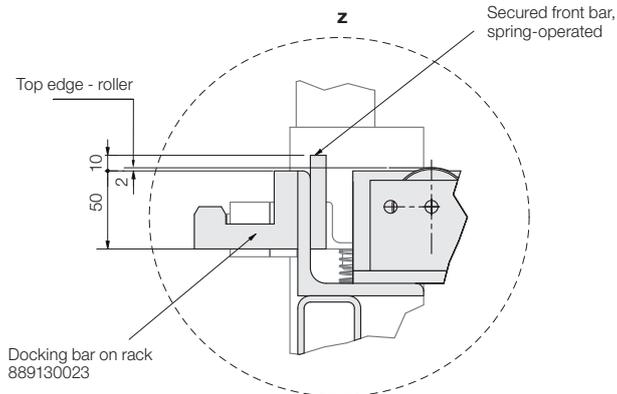
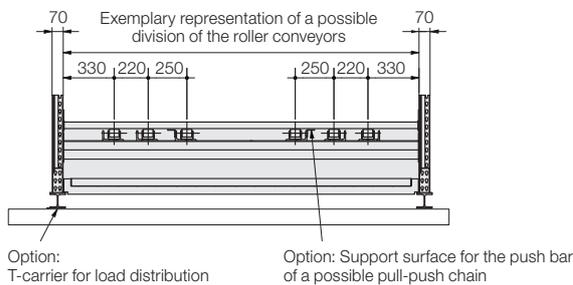
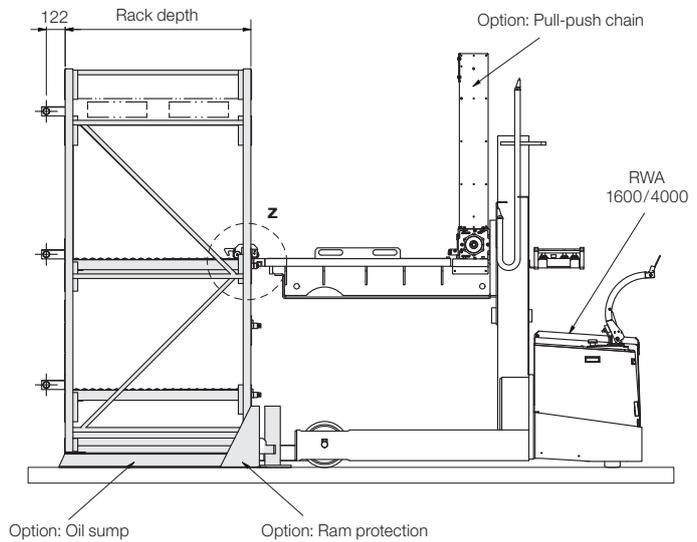
Version for die changing cart RWA 1600 and RWA 4000

Rack system with roller conveyors. Suitable docking system for a die changing cart size RWA 1600 or 4000 for die weights up to 4000 kg.
On the rack with docking bar, mechanical lock and end stop at the back Option with support

plates for using a pull-push chain from the changing cart.
The field widths, the rack depths and the number of roller conveyors are supplied according to the customer's dies.



* Min. entry height when using RWA 1600 = 250 mm
** Min. entry height when using RWA 4000 = 520 mm



Accessories

Docking bars

The lifting platform and rack system must be provided with a docking bar to obtain the exact insertion height at the rack.

Docking bars

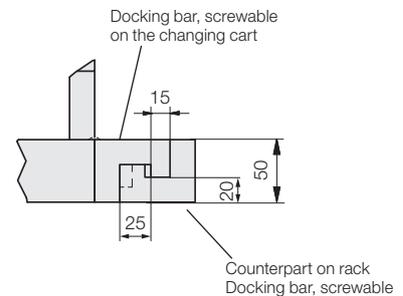
for fixing on the changing cart
L = 1150 mm

Part no. 889130022

Docking bars

for fixing on the rack
L = 576 mm

Part no. 889130023



Die changing cart RWA 1600

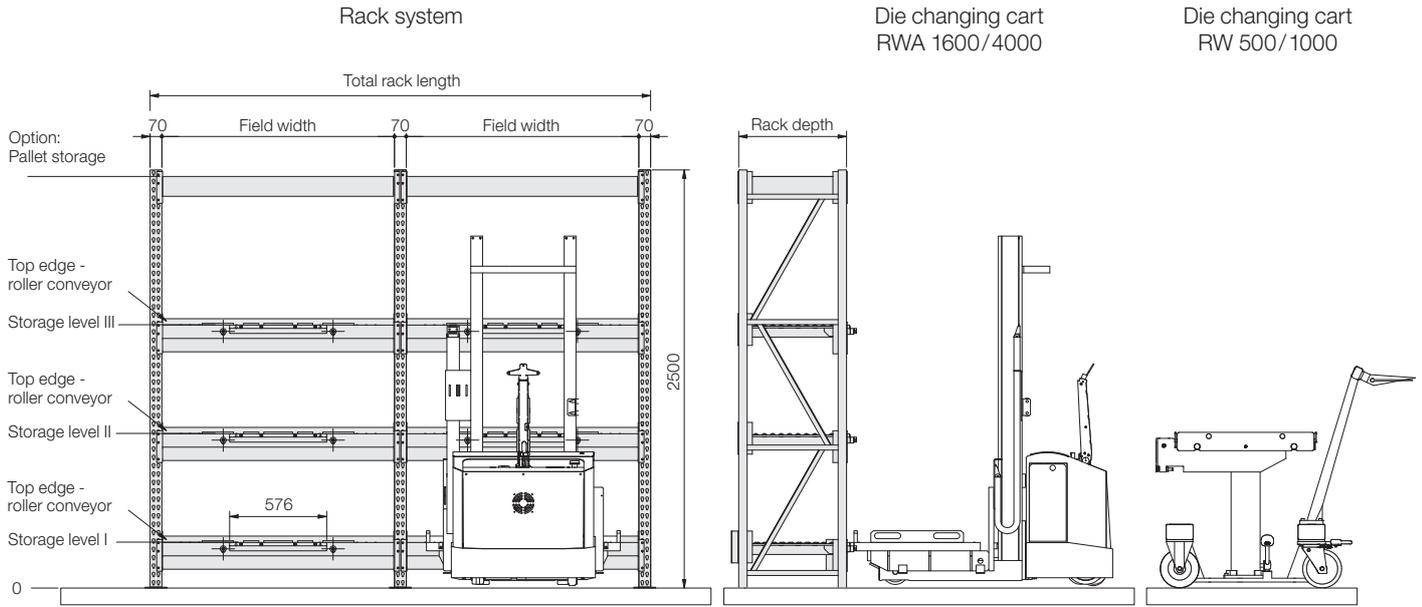
see catalogue sheet WZ 8.8902

Die changing cart RWA 4000

Max. load capacity 4000 kg on request

Rack system for die storage

Dimensioning of the rack system



Die weight [kg]

Die dimensions in mm [width x depth x height]

Number of dies next to each other

Number of dies on top of each other

Available space (max. possible rack length)

Loading with changing carts type (which design)

Special requests

Sketch (if required)



Roller conveyors



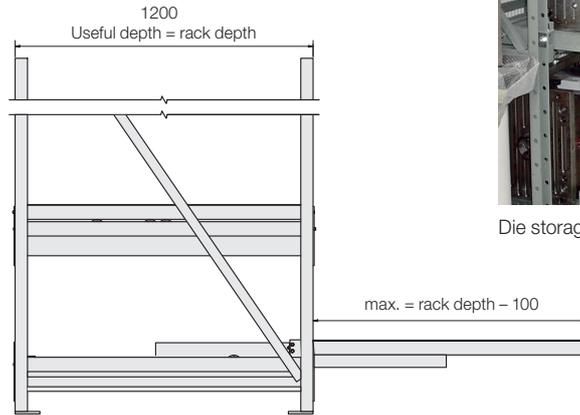
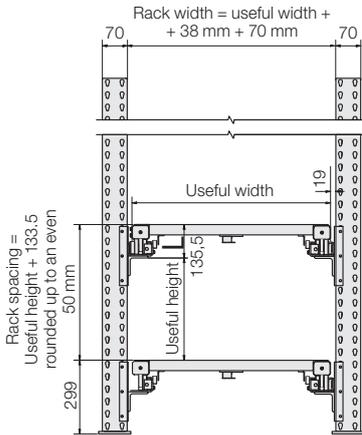
Ball table

Special design for crane unloading

Heavy-duty pull-out

The heavy-duty pull-outs are roller guided and suitable for loads up to 1,500 kg for partial pull-outs or 1,200 kg for full pull-outs. Individual dies can be removed safely and user-friendly from the top of the rack using a crane and transported to a transfer station for a die change.

Heavy-duty pull-outs are supplied with individual locks. Usually, these are fitted one-sided on the left. Different profile thicknesses are used depending on the load capacity and pull-out depth. The dimensions are determined as per the customer's specifications.



Die storage with full extension

System with rolling racks

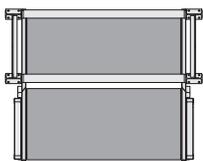
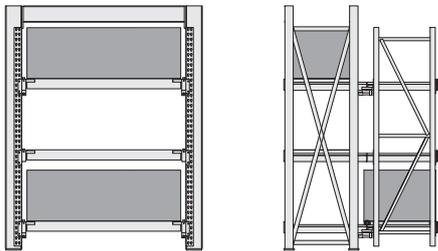
Heavy dies (up to 3,000 kg manually, larger load capacities with electric drives) can be conveniently stored on the rolling racks from above using a crane or forklift. The side guides can be rigidly attached. In confined spaces, e.g. on roadways, the side guides can also be folded onto the rolling rack systems.

Depending on the requirements, the rack level can be fitted with smooth sheet metal covering, with edges as an oil sump at any height on one or more sides, with centring corners, centring rails or as a grating.



Die storage with laterally retractable side guides

Rack extended



Rack retracted (top view)

