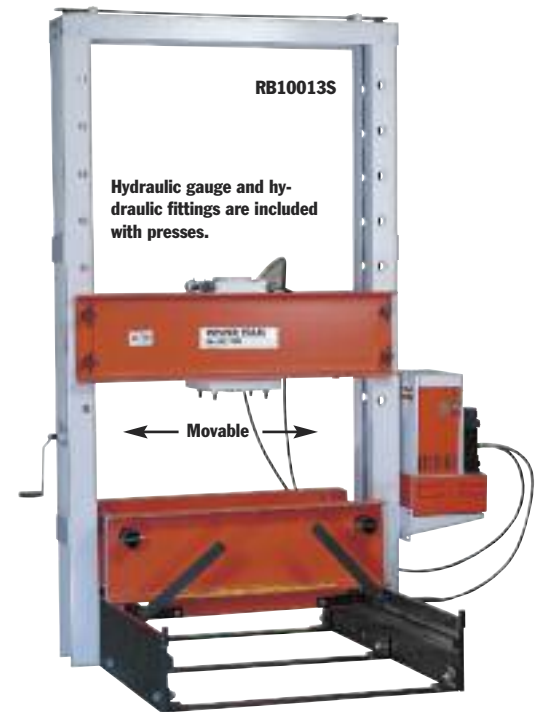


# ROLL-BED® PRESS

80-200 Ton

H Frame



## Heavy-Duty Straightening Fixtures



**No. SF50** – Fixtures for use with 80-ton Roll-Bed® presses or 55-ton heavy-duty shop presses. (2 ea.). Wt. 104 lbs. **Not part of press, order separately.**



**No. SF150** – Fixtures for use with 100-, 150- and 200-ton Roll-Bed® presses and 100-ton shop presses only (1 pr.). Wt. 196 lbs. **Not part of press, order separately.**



- The original, patented Roll-Bed® design. Bed rolls out for easy loading and unloading with a crane or other lifting device.
- Movable workhead glides easily side-to-side for full off-center load capacity across width of upper frame.
- “Daylight” is 50½" x 60" for 80- and 100-ton models; 51¼" x 64" on 150- and 200-ton presses.
- Fast approach of double-acting, 13⅜" stroke cylinder is provided by PQ1204S “Quiet” electric/hydraulic pump with remote control hand switch. Operator can view work from all sides with fingertip control of cylinder piston travel.

## PRESS FEATURES:

- **Roll-Bed® design** – Bed glides in or out on bearings to make loading and unloading fast and easy.
- **Adjustable lower bed width** – For secure balancing and centering of heavy jobs. Loosen adjusting bolts to adjust bed from 4" to more than 27". See dimension “H.”
- **Movable workhead** – For off-center pressing jobs, workhead moves on bearings across upper bolster. Presses can be used at full capacity, regardless of where workhead is placed.
- **Lifting mechanism** – Simply turn crank handle to raise or lower upper bolster. Screw mechanism raises or lowers both sides evenly (a heavy-duty ½" drill motor can replace handle for automatic adjustment). Four locking pins hold bolster in place for pressing.

- **Optional heavy-duty straightening fixtures** – Make straightening jobs easy and accurate to within .004"! Rollers are ball bearing mounted and handle raises or lowers for easy turning of the work.

## PUMP ELECTRICAL SPECIFICATIONS

**PQ120 Series** – 3 hp, 460 volt, 60 cycle, three phase. Available in 220/380 volt, 50 cycle, add suffix “-380” to order no.

**NOTE:** To order press with a 230 volt, 60 cycle, single phase pump, order press less PQ1204S. Order pump No. PQ604S separately.

**NOTE:** Different voltage and valve options can be obtained by substituting certain PA, PE or PQ series pumps. Consult the factory.



Lifting screw and locking pins make bolster raising a one-man job.



Bearings make bed positioning smooth and easy.



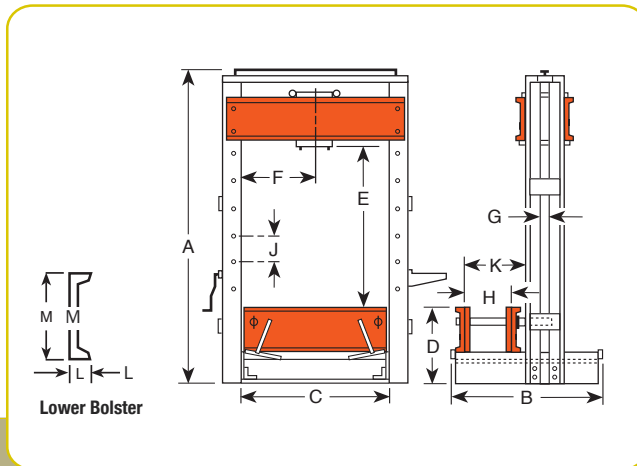
Lever lowers bed for pressing, raises it for rolling.



Cylinder is easily moved across width of upper bolster.



Width adjusts from 4" to over 27"; is secured with locking bolts.



Lower Bolster



SHOP EQUIPMENT

### DIMENSIONS

Cap Tons	A (in.)	B (in.)	C (in.)	D (in.)	E (in.)	F (in.)	G (in.)	H (in.)	J (in.)	K (in.)	L (in.)	M (in.)	Floor Space
80	112 <sup>5</sup> / <sub>8</sub>	64 <sup>1</sup> / <sub>4</sub>	50 <sup>1</sup> / <sub>2</sub>	27	12 - 60	14 <sup>1</sup> / <sub>2</sub> - 36	3	4 - 27 <sup>1</sup> / <sub>4</sub>	8	36 <sup>1</sup> / <sub>2</sub>	3 <sup>3</sup> / <sub>8</sub>	15	64 <sup>1</sup> / <sub>4</sub> x 60 <sup>1</sup> / <sub>2</sub>
100	112 <sup>5</sup> / <sub>8</sub>	64 <sup>1</sup> / <sub>4</sub>	50 <sup>1</sup> / <sub>2</sub>	27	12 - 60	14 <sup>1</sup> / <sub>2</sub> - 36	3	4 - 27 <sup>1</sup> / <sub>4</sub>	8	36 <sup>1</sup> / <sub>2</sub>	3 <sup>3</sup> / <sub>8</sub>	15	64 <sup>1</sup> / <sub>4</sub> x 60 <sup>1</sup> / <sub>2</sub>
150	123 <sup>3</sup> / <sub>4</sub>	68 <sup>3</sup> / <sub>4</sub>	51 <sup>1</sup> / <sub>4</sub>	30	9 - 64	13 <sup>7</sup> / <sub>8</sub> - 37 <sup>3</sup> / <sub>8</sub>	3	4 - 27 <sup>1</sup> / <sub>8</sub>	11	37 <sup>1</sup> / <sub>4</sub>	4 <sup>1</sup> / <sub>8</sub>	18	68 <sup>3</sup> / <sub>4</sub> x 63 <sup>1</sup> / <sub>4</sub>
200	123 <sup>3</sup> / <sub>4</sub>	68 <sup>3</sup> / <sub>4</sub>	51 <sup>1</sup> / <sub>4</sub>	30	9 - 64	15 <sup>1</sup> / <sub>8</sub> - 36 <sup>1</sup> / <sub>8</sub>	3	4 - 27 <sup>1</sup> / <sub>8</sub>	11	37 <sup>1</sup> / <sub>4</sub>	4 <sup>1</sup> / <sub>8</sub>	18	68 <sup>3</sup> / <sub>4</sub> x 63 <sup>1</sup> / <sub>4</sub>

### ORDERING INFORMATION

Capacity (tons)†	Type of Cylinder Used	Stroke	Cylinder Model	Order No.	Speed (in./min.)††	Type Pump	Valve Type	Pump‡ Model	Prod. Wt. (lbs.)
80	Double-Acting	13 <sup>1</sup> / <sub>8</sub> "	RD8013	<b>RB8013S</b>	46    7.5	Elec.	4-way*	PQ1204S	2,886
100	Double-Acting	13 <sup>1</sup> / <sub>8</sub> "	RD10013	<b>RB10013S</b>	35    5.8	Elec.	4-way*	PQ1204S	2,944
150	Double-Acting	13 <sup>1</sup> / <sub>8</sub> "	RD15013	<b>RB15013S</b>	24    3.9	Elec.	4-way*	PQ1204S	4,458
200	Double-Acting	13 <sup>1</sup> / <sub>8</sub> "	RD20013	<b>RB20013S</b>	18    2.9	Elec.	4-way*	PQ1204S	4,546

\* Solenoid valve with 24 volt remote control hand switch.

† Frame is shipped assembled.

‡ Pump standard with press. Other Power Team pumps can be substituted. dBA at idle and 10,000 psi: PQ120-73/78; measured at 3 foot distance, all sides.

†† Typical performance based on 100 psi and 10,000 psi pump specifications. Actual speeds may vary with operating conditions.

3,000 lbs maximum load can be supported on bed when raised on the rollers.