



Wagner Die Supply[®]
Diemaking & Diecutting Source and Resource

die-casting

News & Information from America's Die Supply Leader.

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Upcoming Events:



TAPPI & AICC present:
Super CorrEXPO 2016
OCTOBER 17-20, 2016
ORLANDO, FLORIDA
For more info., please visit:
www.supercorrexpo.org



Diemaking & Diecutting Source and Resource

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New items at Wagner!

NEW products that maximize value & performance!



From left to right, New Red Urethane Mallets, SpeedySet™ adhesive, Type Perf & Track in Large, Medium and Small sizes and Die Matte Film for plotters, are all new at Wagner and will help improve your bottom line!

Wagner is constantly improving and refining its product line, its part of our on-going effort to give our customers the best in quality, service and value. Below are recent additions that will help your bottom line!

First off, our new **Red Urethane Mallets**, currently available in two sizes #4L (2" dia. x 5-1/8" L) and #6 (2-3/4" dia. x 4-3/4" L). Both versions are made from durable Urethane and feature tough hardwood handles. A long-handled version (of the #6) is in the works, and should be joining the line-up soon.

SpeedySet is Wagner's newest adhesive, it's a cyanoacrylate adhesive that is economically-priced, and is available in two viscosities thin, (5 CPS) and medium (100 CPS). Both are designed for a tight bond on ejection material, or anywhere a tough, resilient bond is needed.

Wagner has carried **Type Perf and Tracks** for a while now, but recently we added Type Perf and Tracks in the **medium size or 1/2" tall letters**. Letters in the large (1") and small (or mini - 3/8") are also available. Tracks are also available in a wide selection of sizes base thicknesses, as are recycled logos, please contact us for more information.

Last but not least is our **Die Matte Film**, now being offered at a **special price**. It's not a new-comer, but the new pricing definitely qualifies it as a great value for our customers.

We're always maximizing value, so visit www.wagnerdiesupply.com often to see the latest values we have for you!

Ejection Selection!

High quality closed and open cell die ejectors from the industry's best manufacturers!


At Wagner, we work closely with our team of suppliers to ensure that our customers get the very latest and greatest products available, and ejection materials are no exception.

Our close association with Kodiak Rubber Corporation and Monroe Rubber and Plastic, Inc. allows us to offer our customers with the widest selection of top-quality ejection materials in the industry. From open cell to closed cell, in a wide variety of pads, sheets, strips, blocks and pieces as well as kiss-cut profiles, we have a selection that is second to none! All backed by the industry's leader in customer service and technical support.

Kodiak Rubber Corporation

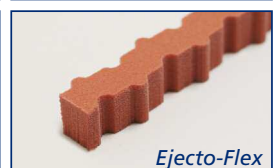
Kodiak has a wide selection of ejector styles, in both Open and Close Cell formulations. Kodiak can custom-cut just about any size or shape needed, and they have an extensive collection of stock sheet/pad sizes and profiles. Kodiak has the traditional open cell products like their KO-18 and KO-10 popular in both folding carton and corrugated flat die applications. They also feature their specialty line of closed cell and micro cell ejectors like Blue Frontier, KO-15, Red Grizz, Green Grizz and KO-20T. All available in pads, sheets, blocks, pieces and in specially-kiss-cut profiles like Trap Cut, Bear Claw and Side Wave. 100% cork and cork and rubber combo ejectors are also available. All Kodiak products are available with or without PSA.

Monroe Rubber and Plastic, Inc.

Monroe has been a partner with Wagner for several decades now, they offer some of the most technically-advanced ejectors in the industry today. Monroe specializes in Closed Cell ejection materials which are extremely durable and virtually void-free. Monroe's MR75, based on microcellular technology, is an example of how a traditional specification can be improved. Designed as a replacement for old standard 75 rubber, MR75 can outperform and outlast standard rubber while still being competitively-priced. Monroe's closed cell 12000 and 22000 series feature long die life and consistent ejection force throughout the job run, 22000 series ejectors are rated to produce up to 1.4 million impressions! Both 12000 and 22000 series are available in blue, black, grey, red, tan and orange. Also available are Monroe exclusives like Green G'rilla™ and Red Rhino™ ejectors popular in the corrugated die industry. All Monroe products are available with or without PSA. 



Kodiak's line of specialty closed and microcell ejectors.



Monroe's line of special profiles for a wide variety of applications, also includes grooved profiles for slot applications.

The 'Ins and Outs' of Wagner Punches.

The proper installation of punches can save you time and money on every run.

Article concept and illustrations by Kevin Carey.

Wagner punches are tough, they're designed and manufactured to provide the very best performance in the industry. The fact is, our punches take a lot of abuse and keep on producing quality results, in spite of issues that would cripple, or render useless, other brands of punches with lower quality standards.

That being said, there are benefits in taking measures that protect the punch at a critical stage – its installation into the die. **Remember: machined seamless tubing punches are engineered tools.** And, as with any other precision instrument, should be used with the same care and attention to detail that went into its design and manufacture. Handle them with care, protect the cutting edge as much as possible. **Even though a Wagner Punch is tough, handling them with care will help to protect the cutting edge, and in-turn, increase their effective life in the die.**

The first sign of trouble with punches is often encountered as incomplete diecut punch holes (see illustration 1). When examined, the cutting edge will often show partial compressive damage in sections. (see illustration 2). At the end of the production run, the cutting plate will show uneven wear (see illustration 3). **In many cases, the root of these problems can be traced to the way the punch was installed.**

The most important element to installing a punch into a steel rule die is **verticality** (see illustration 4). **Is the cavity for the punch truly vertical? If it isn't, the punch won't be vertical either.** Also, if the punch cavity is too small, or not cleanly cut, the punch will not enter or seat properly. If it's too large, the punch won't be secure or hold its seat. **Then, care must be taken when inserting and seating the punch or damage to the cutting edge can result from careless handling (especially on Straight O.D. style punches, see photo below).**

The goal should be perfect vertical punch seating, with no damage to the walls of the cavity, nor to the cutting edge of the punch (see illustration 6).

The best and most efficient way to achieve perfect vertical punch seating, with no damage to the cutting edge, is to install punches from the back of the dieboard.

(continued next page)

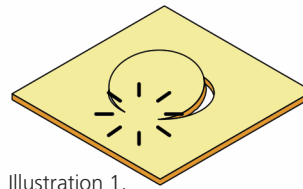


Illustration 1.



Illustration 2.

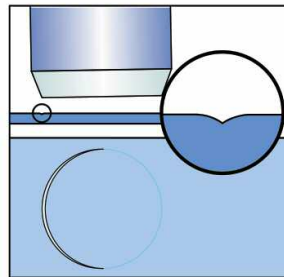


Illustration 3.

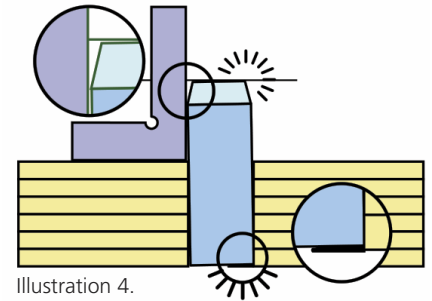


Illustration 4.

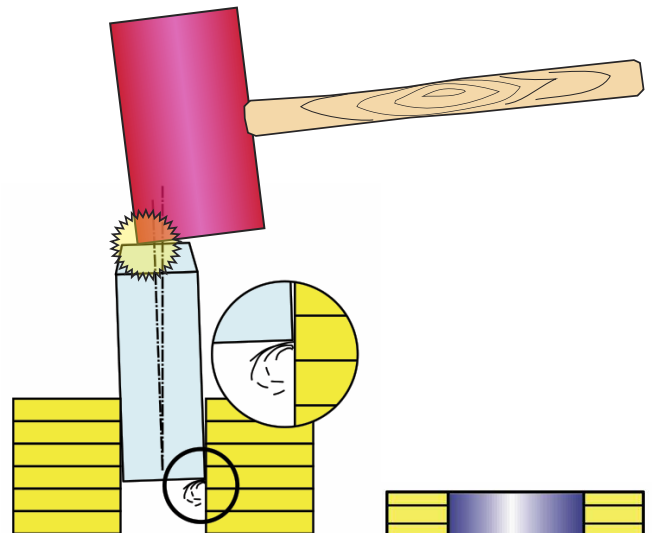


Illustration 5.

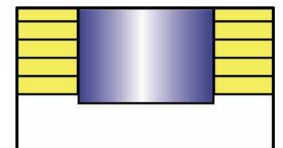


Illustration 6.



Punch cutting edge damage on a Straight Outside Diameter Punch prompted by uneven mallet blows to edge during insertion into die board.

The 'Ins and Outs' of Wagner Punches.

(Continued from page 3)

When a punch is hammered into the dieboard from the top of the dieboard, the cutting edge takes the direct force of the mallet blows, then as the punch is driven down, the plywood layers and veneers are deflected downward. This can also result in the depositing of wood debris at the base of the punch, which if not removed, could cause alignment issues with the dieboard on the press. This tension can also make it harder to properly seat the punch, and can act to push the punch out of the cavity (see Illustration 7).

However, when a punch is inserted from the back of the dieboard, the tension of the plywood and veneers tend to push the punch back down, in the direction it was inserted, helping to hold and more easily seat the punch (see illustration 8). The natural taper of the cutting edge, also makes it easier to start the punch (see illustration 9) and to keep it vertical as it is driven-in. Proper seating is also easier because the base of the punch is always visible in the process (see Illustration 10).

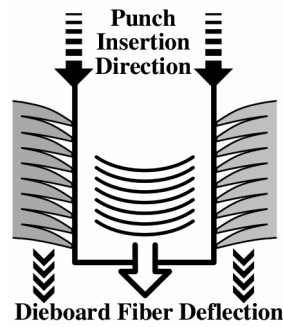


Illustration 7.

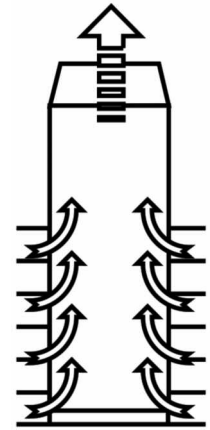


Illustration 8.

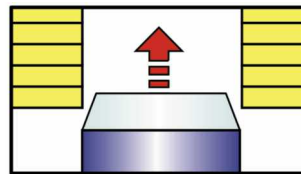


Illustration 9.

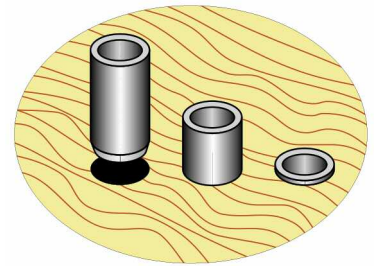


Illustration 10.

When a punch is inserted from the back of the dieboard, the cutting edge is not subjected to direct impacts from a mallet, eliminating the chances of deformity and damage that impacts can cause – especially to straight outside diameter punches.

The bottom line: many issues associated with punch performance and die life can be addressed by:

1. Making sure the punch cavity is cleanly-cut and truly vertical or perpendicular to the dieboard surface.
2. Installing punches from the back of the dieboard whenever possible, to help achieve true verticality and proper punch seating, and to eliminate cutting edge damage from direct mallet impacts.



Trade Tech, Tips & Tricks.

Heating steel rule before bending can sometimes get you out of "hot water."

One of the great things that our industry is known for is improvisation and resourcefulness under pressure.

Sometimes die makers and die cutters are asked to do the 'impossible,' yet time and time again, the 'impossible' gets done. Recently a customer came to us with a unique problem, he was attempting to put a tight bend on some 1.250 tall 2 pt. CB Serrated 12 tooth SNN. Kind of an uncommon specification, and the customer had to bend this at more of an angle than usual to get this job done. The customer had not been successful trying to bend the rule, having it crack or break before achieving the desired bend.

A quick call to Wagner Service Team member **Keith Puyear** at our Dallas location, netted a nifty solution.

Keith suggested that the customer heat the rule using a propane torch, not to red hot or anything, but for about 5-10 seconds, or just enough to soften it slightly without altering the edge or the temper. You can repeat the process, and increase time as needed to do the trick.

The heating indeed did the trick, and the customer was able to perform the bends using a #1 dieset (this rule normally would be bent with nothing smaller than a #21 or #22 dieset!)

Keith can't guarantee this will work all of the time, but this time his suggestion got the client through a tough spot. Proof that when you need Tech, a Tip or a Trick, call us at Wagner Die Supply and we'll do what we can to help! 