



Wagner Die Supply
 Diemaking & Diecutting Source and Resource

die-quest

News & Information from America's Die Supply Leader.

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Help keep press speeds fast!

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We have them all at Wagner!

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Great steel rule value!

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Upcoming Events:

■ **I.A.D.D. General Meeting**

Sept. 22-24, Omni Ft. Worth, TX

■ **G.F.A. Semi-Annual Meeting**

Sept. 27-29, Rancho Bernardo, CA



TAPPI & AICC present:

Super CorrEXPO 2016

OCTOBER 17-20, ORLANDO, FL

For more info., please visit:

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New Products at Wagner

New Quoins and hex key, plus a new cleaner/degreaser!

2" Mini Quoin and 6mm T-handle Hex Key



Wagner's new 2" quoin measures 2" long by 5/8" tall and has a 6mm hex-head tightening bolt.

Above new 2" Quoin and 6mm T-Handle Hex Key, the new 2" key is a cost-effective solution for die lock-up.

T-handle 6mm Hex Key features a "speed sleeve" for quick sinch-up of loose quoins.



Quoins can be expensive, and compact units can be difficult to find. Not at Wagner, we now have a **2" long compact quoin** that can do effective lock-up in even the tightest of situations. These versatile little units are 5/8" high and have a 6mm hex-head tightening/loosening bolt. They're easy to use and will fit just about anywhere! Together with our new **T-handle 6mm hex key**, it's a fast and cost effective lock-up solution. **Call or e-mail us for low pricing!**



CITRI-FLO citrus-based cleaner/solvent

CITRI-FLO, new at Wagner, is a powerful heavy duty citrus cleaner and degreaser that is made with a non-hazardous citrus-based solvent. CITRI-FLO makes quick work of adhesives, even those that are set, as well as oil, grease and grime. It dissolves messes, and allows for quick water clean-up. Perfect for cleaning gluers or other equipment. CITRI-FLO cleans deep, rinses clean and leaves a fresh citrus scent. Available in 16 oz. sprayer, 1-gallon jugs and 5-gallon pails, from all Wagner Die Supply locations.



Multi-Purpose Citrus Solvent



Stripping Pins & Claws

What you do on the stripping end can either speed-up or slow-down your operations!

Article concept and illustrations by Kevin Carey.

A critical feature of almost every form of diecutting is the ability to strip waste material from the diecut product, and to efficiently separate and stack the converted parts. The dilemma and the challenge of course, is to be able to strip consistently at maximum press speed.

To ensure optimal performance in platen diecutting required a three-part system. See illustration 1.

This consisted of an upper male pin; a female board with the cavities matching the waste shapes cut into it, and a lower telescopic pin system, which literally assisted the upper pin, by pulling the waste through the cavity in the stripping board.

The argument in favor of this upper and lower pin stripping system was the incident of part Hinging, Trap-Dooring, Pivoting, and Twisting, see illustration 2, which undermine almost every production run.

Unfortunately this system of stripping is labor intensive, it's expensive, and for the majority of jobs, the lower part of the system must be disassembled for the next production job.

Multi-point or "barbed" pins from Wagner.

The use of a Pointed Pin System has been common for a while now, and although the pin is successful, unless it is positioned in the center of effort, see illustration 3, it can become part of the problem rather than the solution it was intended for.

The innovation of the Wagner Multi-Point, Multi-Barb Stripping pin has changed the entire focus of the stripping discussion. See Photo A. The stripping pin provides "Grip & Strip" precision, and has proven successful in stripping the smallest shapes without the aid of bottom pins, see Illustration 4, or complex shapes, which have a tendency to "hang-up" in the cavity. See Illustration 5.

The positive stability of this multi barbed pin, which eliminates lateral stripping and movement, is the ideal choice when combined with nicking breaking or the technique of stripping trapping. See Illustration 6.

This is a highly flexible and effective system because the pins are made in many sizes, see Photo A, which provides the ability to adapt to almost every stripping challenge.

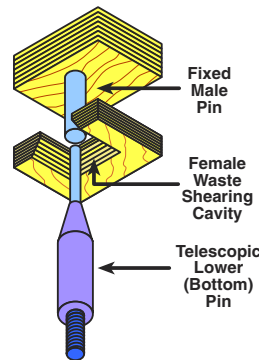


Illustration 1.

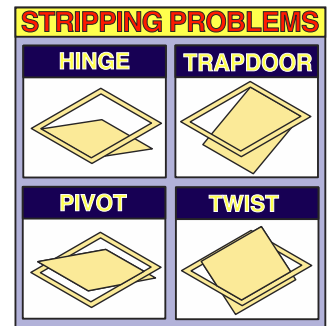


Illustration 2.

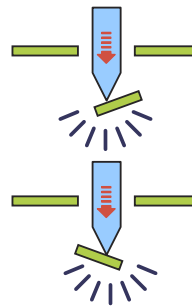
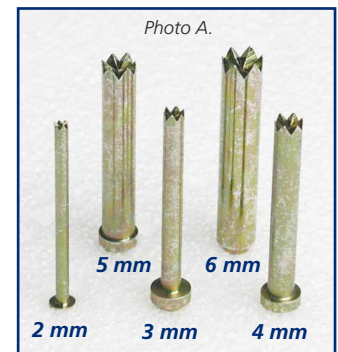


Illustration 3.



Also available in 8 mm and 10 mm sizes.

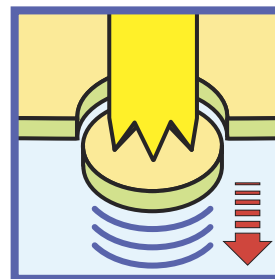


Illustration 4.

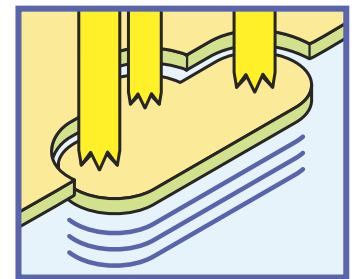


Illustration 5.

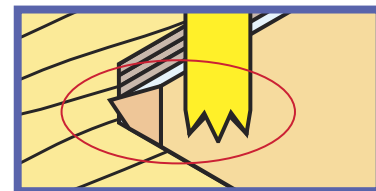


Illustration 6.

(Continued next page)

Stripping Pins & Claws *(Continued from page 2)*

Stripping Claws

Also known as waste strippers, these specialized devices provide another reliable method to create a multi-barbed male pin layout, eliminating the need for most bottom pins, thus greatly reducing makeready time. These barbed Stripping Claws from Wagner (see Photo B & C). are compact and flat and feature special barbs at the ends to snag or capture waste and guide it securely during the stripping process. Wagner Stripping Claws prevent scrap from bouncing back, and allow for fast lock-up.

Wagner Stripping Claws are 50mm tall and available in various sizes (see chart below) in right or left variations. The various sizes allow for optimal positioning, maximizing their effective handling of the waste to be stripped – without compromising press speed. Perfect for use in small scrap areas or narrow or hairpin slot areas. Easy to integrate, their positions can be easily programmed into the stripper layout at the time it is lasered or routed.

Call or email today for more information on the wide variety of stripping pin and stripping claw options at Wagner!

| Available sizes: | |
|--------------------|--------------------|
| 7mm x 50mm, left | 7mm x 50mm, right |
| 11mm x 50mm, left | 11mm x 50mm, right |
| 15mm x 50 mm, left | 15mm x 50mm, right |
| 20mm x 50mm, left | 20mm x 50mm, right |
| 25mm x 50mm, left | 25mm x 50mm, right |



Photo B.
A close-up of the 'barbed' end of a Wagner Stripping Claw, these barbs help to securely direct the waste through the female side of the stripping unit, without the need for bottom pins.

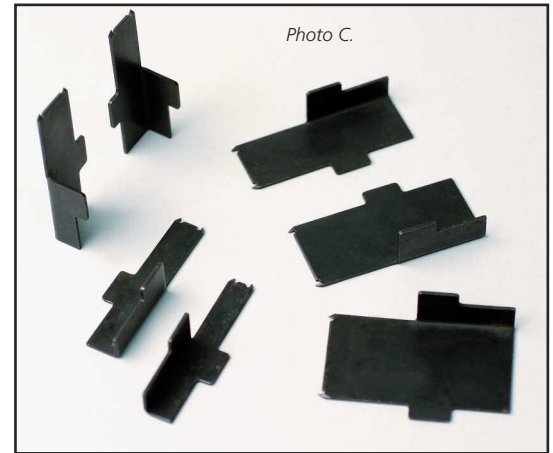


Photo C.
Wagner Stripping Claws are easy to use, and can be installed in close proximity to ensure effective waste stripping and removal.



More Pins!

Registration Pins, Retract Pins, Stop Pins and Pin Points!

While on the subject of pins, we have more than just those used in stripping! We have a large inventory of Registration Pins, Aluminum Retract Pins, Stop Pins and even our Pin Point Punches!

These pins are important accessories that have a wide range of uses to many of our customers. And, sometimes they're overlooked; they're not new or very exciting, but their functions are fundamental to achieving quality results.

Call or e-mail us, or visit www.wagnerdiesupply.com for more information and pricing on these items as well as the entire family of Wagner quality products!



More pins... from left to right, Stop Pins, Registration Pins, Aluminum Retract Pins and Pin Points.

ValuEdge Dieflex 380

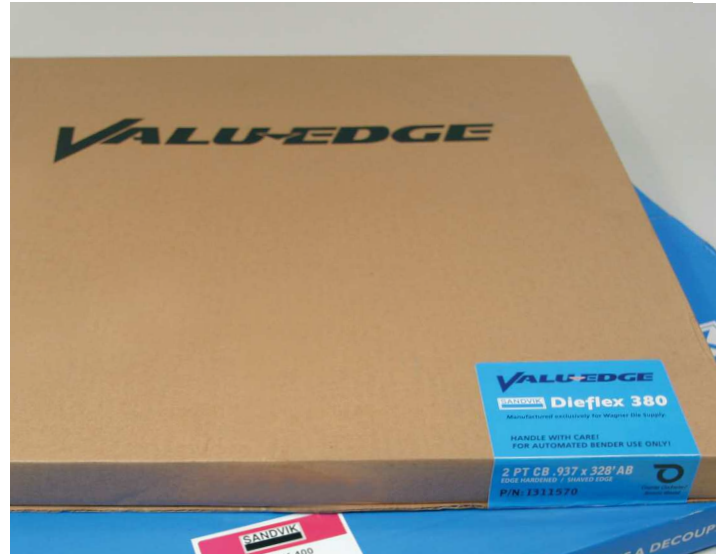
It's Sandvik's famous Dieflex 380 Steel Rule, the only difference is the ValuEdge name.

Sandvik exited the steel rule business in 2015, there still remain many diemakers that remain loyal to Sandvik due to their quality and innovation.

Before they shut down steel rule operations, Wagner requested that Sandvik produce a version of their Dieflex 380 labelled exclusively for Wagner Die Supply as "ValuEdge."

Wagner still has remaining stock of ValuEdge rule, in 2 PT., Center Bevel (CB) .937 x 328' AB (reverse wound) coils. ValuEdge is Dieflex 380, made from the same European Steel, with an edge hardness of 640 HV (59 HRC) and a body hardness of 380 HV (39 HRC). ValuEdge has a shaved edge with a 52° angle. It's Dieflex 380 by Sandvik - the only difference is it says "ValuEdge" on the box and on the rule itself.

Call or e-mail Wagner today to take advantage of special pricing on this great steel rule, it's one of the best values out there on top quality steel rule today!



ValuEdge steel rule from Wagner, manufactured exclusively by Sandvik in 2015 for Wagner Die Supply. Stock is available, and priced to move. Call or e-mail your Wagner Customer Service Representative for more information!



Trade Tech, Tips & Tricks

Always overlap steel rule joints!

Designing, cutting and installing ejection materials on steel rule dies seems to be a simple process. In principle, steel rule die ejection is a simple process, however it's important to know proper procedures to avoid potential pitfalls that can cause costly delays and on press problems.

An obvious and very effective technique to reducing on-press issues is to use **the overlap method** of installing die ejection material onto steel rule dies. This method allows for proper support of rule joints by the ejection material itself, by carefully positioning the ejection material gaps or joints away from steel rule joints. This method prevents the knife from flexing at the joint under compressive load, and prevents the ejection material from blowing out, and becoming

part of a problem, rather than an effective solution. Positioning ejection material in this manner not only prevents on-press problems, but will increase die life and on-press performance. See the illustration below.

