

2 Care & Maintenance of Helmold Dieroom Equipment



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Helmold has been a leading source for diemaking equipment for many years. Over the past few years we have made improvements to our equipment while still making many of the parts interchangeable.

The Standard and Heavy Duty Equipment is still designed, except for a few parts, to be repaired/serviced by the customer. One area that will wear and should be checked periodically by the customer are the Links and Pins that hold the handle to the slide block. These parts should be checked regularly for wear and replaced when necessary, ensuring maximum equipment life. The holes in the handle can also become enlarged, if this happens then the handle should be replaced.

The Front Dovetail Post on the Standard Bender and Bendall are also designed so they can be removed and replaced when worn. The Dovetail can wear out not allowing the bending dies to fit tightly. The Dovetail post is held in with an Allen head bolt making it simple to replace.

Bending dies can also experience wear on the Dovetail and face sides of the die. As dies wear they will become less efficient at making the desired bend and should be replaced.

Helmold has a sharpening service to sharpen all the knives we make for our equipment. **It is strongly recommended that when Helmold Rule Cutter and Miter Knives need sharpening, customers should contact their Wagner Die Supply location for information.** The sharpening of these components can be complicated and requires that tolerances and angles be maintained. Improper sharpening can cause excessive wear and premature dulling of the knife. Improper tolerances can also result in poor quality cuts and excessive burr. Female miter knives measure .310" across the face when new. This dimension should be checked when new. This dimension should be checked and a shim placed beside the knife to ensure proper clearance. When replacing Rule Cutter Knives the diemaker should test the knives by cutting a piece of paper about .004"/.005" before cutting any rule. This will assure proper clearance between the knives. Diemakers should avoid double-notching rule. The second or half notch can cause the female knife to break. Helmold has made several sizes of

notches available, as well as some special sizes, that eliminate the need for double notching.

The latest product introduced by Helmold for hand equipment is the E-Z Bender and Notcher. This new equipment requires 1/3 the force to make bends or notches as compared to our standard equipment. The new E-Z design changes the castings and some of the parts. Due to this, some of the parts are not interchangeable with the Standard and Heavy Duty Benders and Notch machines. Helmold's latest catalog has complete drawings and parts lists for proper ordering, or contact your Wagner Die Supply location for assistance.

Remember, your Helmold Equipment will last longer when properly maintained.



Helmold Rule Cutter



Helmold Cutter knives.

At Wagner Die Supply we have the experience, know-how and follow-through to work with your diecutting and diemaking team. Contact us for assistance when you need to service your Helmold dieroom equipment.

For more information, please contact us at:

(800) 423-4478 toll free

or visit our website at

www.wagnerdiesupply.com



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