
Cut-off Die Maintenance

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Cut-off Die Maintenance

- When dies come in to the shop from a production run, the following should be done:
 - A. Each time a die is taken off line, have production include a couple of samples that were cut from the die at the end of the production run. Examine the parts to see if there are any problems with the cuts.
 - B. Clean die of all dust, excess grease, and plastic slugs.
 - C. Check all cutting edges for sharpness and condition.
 - D. Repair or re-sharpen all needed parts
 - E. Check all fasteners for tightness. Tighten any loose bolts or fasteners.
 - Set all cutting edge clearance at .0015-.004 gap.
 - All cutting edges should be sharp and free from burrs and rolled edges.
 - Self-Lube Bushings and Slide Plates: When first installing self-lubricating wear plate and bushings, apply a thin coat of 20 weight oil to the wear surfaces to help start the self-lubricating process. Further lubrication is not necessary.
 - All grease points on the cut-off die should be tied together, and lubrication should be done using the press auto-lube system.
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