

Application note for Die-Slide™ and Die-Slide™ Renovate

Die-Slide™ requires one treatment—a one-step application to the edges and surfaces of dies and cutting tools. Remember, less is better when **Die-Slide** is applied! The **Die-Slide** linking period for initial treatment is five days, and is performed at room ambient temperature. Since tooling wears over time due to use, **Die-Slide™ Renovate** may be required on previously treated, well-worn dies. The refurbishing treatment requires only an overnight linking period to be ready for use. The assessment for refurbishment will depend on the amount of use as well as the nature of the material that has been converted or processed.

ALL EDGES AND SURFACES MUST BE CLEAN! Any existing adhesive, debris, oil or grease, etc. must be removed for the Die-Slide chemical-linking treatment to be effective. You may use denatured alcohol, acetone or MEK as necessary with a clean cloth or swab. Solvents must be allowed to flash-dry before application of Die-Slide. It will be quite evident that proper treatment was not achieved after application, if a spot on the edge or surface continues to attract residue.

WARNING! FLAMMABLE! CANISTER CONTENTS IN THEIR UNLINKED AND LIQUID STATE MAY BE HARMFUL OR FATAL IF INGESTED. SEEK MEDICAL ATTENTION IMMEDIATELY. CONTENTS MAY IRRITATE EYES AND SKIN. USE IN A WELL-VENTILATED AREA. PROTECTIVE EYEWEAR AND GLOVES ARE RECOMMENDED DURING APPLICATION. PLEASE REFER TO SAFETY DATA SHEETS FOR MORE INFORMATION.

Die-Slide is a safe and non-toxic product following its chemical linking period.

Die-Slide may be applied to aluminum; glass: Invar (64FeNi); Molybdenum; stainless steel; steel; and many plastics. Other metals may be possible as well—try Die-Slide out and see! Please be sure to read all directions, since it may be useful to know how **Die-Slide** has been applied to another type of tool that can benefit your application.

- **Steel Rule Dies:** Apply Die-Slide by using a cotton swab. Be sure to apply to both sides of the blade. Dip the swab into the canister and twist and wring against the inside canister wall to remove excess liquid. Gently wipe on a light coat. The chemical linking period is five days at ambient room temperature.

If ejection rubber has been mounted close to the rule and does not allow room for a swab, a rule-pulling device may be necessary to apply directly to the exposed rule, separated from the board and rubber.

Following the linking period, the rule may be re-inserted into the board.

If you are ordering a new steel rule die or a re-ruled board, ask your die maker to provide the tool already treated with Die-Slide for use. Die-Slide will affect the board surface for rubber application so it must be protected temporarily. The die maker can apply Die-Slide either before the rule is bent for insertion, or laminate a temporary pre-mask to the die board material prior to laser cutting the rule pattern. The rule may then be inserted and air-brushed with Die-Slide and allowed to undergo the linking process. Following the linking period, the pre-mask is removed, so that ejection rubber is able to adhere to the board.

- **Class “A”, Male/Female, Matched-Metal Tooling:** Apply Die-Slide to all cutting edges and surfaces which may be affected by unwanted residue. Depending on the intricacy of the tool, it may be applied by swab, or an air brush. Be sure to cover or protect areas where you don't want the treatment to be applied.

- **Machined Flatbed & Rotary Dies and Flexible Dies:** Die-Slide may be applied using a swab to the cutting edge and down the blade slope as far as desired. If the tool is to be foamed or rubbered for use, be careful not to apply too far into a cavity. As with male/female tooling, Die-Slide may be applied to mechanical ejection plungers on rotary tooling.
- **Slitting Blades, Sheeting Knives, Guillotine-Style Shearing Knives, and Plotter Knife Blades:** No matter whether two knives shear or there is a single blade, Die-Slide may be applied with a swab, or air brushed. Be sure to remove excess accumulating liquid. Apply to shearing and crush-cut anvils as well as blades. It may be applied as far up the side of the blade as necessary when cutting through a layered thickness of material, as with log slitters.
- **Hot or Cold Needle Perforation Tools:** Die-Slide is best applied using an air brush, and fogged onto the needles. A new and clean unused tool will perform best.
- **Embossing Dies:** Die-Slide may be swabbed, air-brushed or wiped. Make sure that no excess liquid accumulates in deeper areas of either tool face.
- **Extrusion Dies:** Die-Slide may be air-brushed, swabbed or wiped, depending on accessibility and area to be treated. As with embossing dies, avoid and remove pooling. If possible, stand the tool on end, gravity downward, in agreement with the overall production material flow direction.