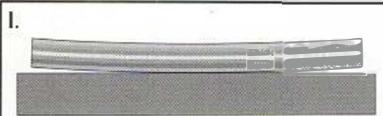


Dieboard Storage

You spend a lot on your dieboards, it pays to store them right!

Considering the investment in laser cut tooling and the importance of optimal performance when the tool is used and reused it is critical to store steel rule dieboards effectively. The problem is how do we store dieboard in such a way they are easily accessible and yet protected from warping, cupping and twisting?



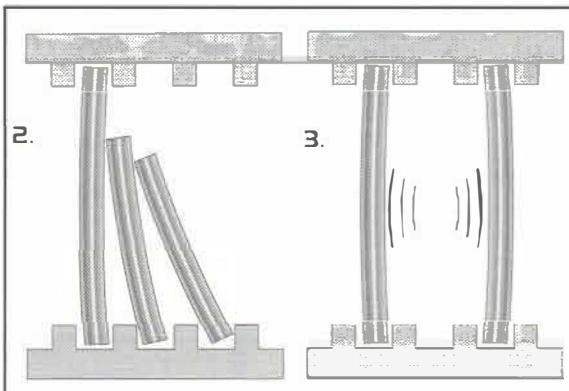
has one surface protected from changes in moisture levels and one surface exposed. The result was the board would generally warp upward as the upper layers of the board gradually dried out, or lost moisture (see illustration 1).

Vertical Storage ➤

The most common approach requires storing dieboards vertically in a rack. The problem in storing the board vertically as shown in *illustration 2* was the great variety in board sizes made the use of the upper and lower track inconvenient and the results were usually as shown in *illustration 3* where multiple dieboards are stored leaning against each other to ensure consistent warping and damage!

◀ Flat Storage

The traditional approach, a legacy of the multi-piece block dieboard era, was to store the dieboard flat on retractable wood shelves in a rack. Although this is convenient when used with an effective record location system, the dieboard

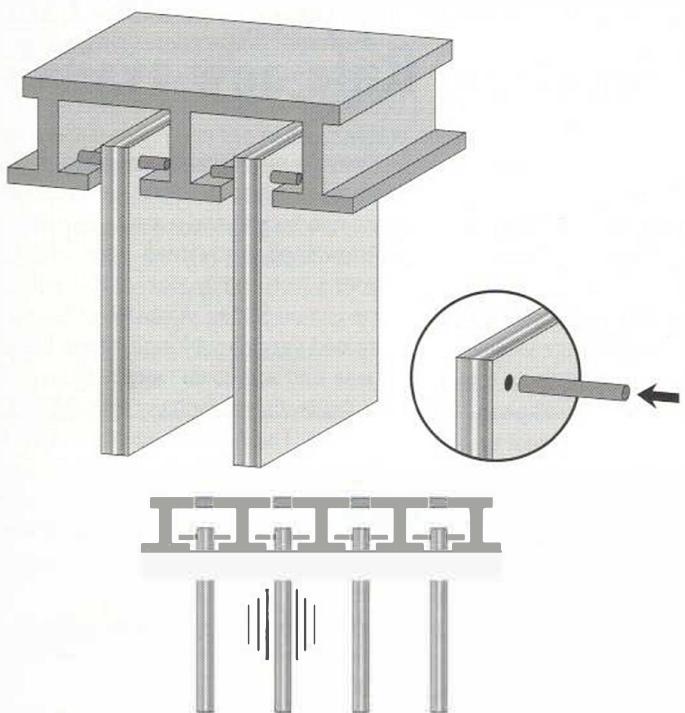


4.

◀ Suspended Storage

The most effective method of storing multiple sized dieboards is to suspend them in a standard racking component using pins inserted through holes laser cut into the dieboard. This has the advantage of easy dieboard insertion and removal, the ability to handle any dieboard size, and the exposure of all surfaces to the atmosphere ensures balanced moisture levels and board flatness. See *illustration 4*.

Dieboard storage tips provided by Kevin Carey publisher of "Packaging Productivity" and "The Diemaker's Resource". For more information about these publications contact Kevin at (802) 362-0062 or by mail at P.O. Box 115, West Road, Manchester, VT 05254.



The Care & Feeding of Plywood

Would you like to eliminate warpage in plywood? We all would. Fortunately, there are some things you can do to help accomplish just that. Basically, what we want to accomplish is this: Eliminate parts of the plywood being exposed to varying levels of moisture, such as one side of the board laying on the floor or leaning against a wall or another piece of plywood.

Some ideas:

- Store your plywood (banded) off the floor and away from outside walls. Some 4 x 4's are sufficient to keep the plywood off the floor; just enough for air to circulate.
- Don't put your new plywood to work right away! Let your boards get acclimated to their new surroundings. Usually a week is fine.
- If you buy your plywood one or two sheets at a time, avoid stacking them against a wall or on a shelf. Instead, suspend them vertically off the floor (again, on a couple of 4 x 4's or a pallet) with space between each sheet, or invest in a good storage system -- like a Henderson Mfg. storage system that uses pins and tracks to suspend the plywood and finished dieboards. The accompanying article on this page explains this type of storage system.

Protecting your investment in plywood pays obvious dividends -- less waste, less down-time, higher quality dies and overall better results!

Plywood storage tips provided by Bob Burke of Die Supply Company of Dallas, Texas. For more information on Henderson Mfg. storage systems, call (800) 423-4478.