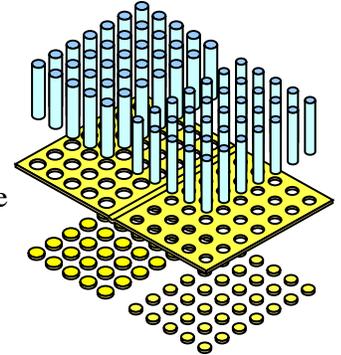


Category: **Stripping** Problem Title: **Concentration of Small Holes!**

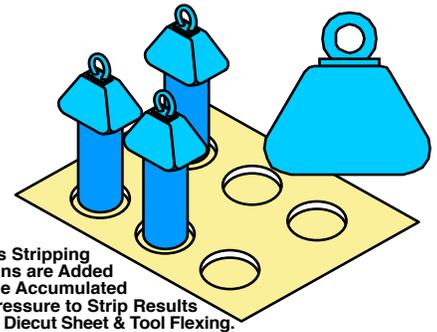
PROBLEM

When sheet fed stripping on a high speed press, a concentration of small holes can present a very difficult diecutting problem. *See right.* Stripping small shapes is difficult, as the waste is often improperly sheared, and many waste pieces ends up on the surface of the stripping tool, or it is carried forward into the delivery of the press. This causes three key problems. The first is premature diecut sheet break-up in the stripping unit of the press. The second, is the operator is forced to slow the speed of the press, to reduce the lateral stress on the sheet. The third is, the flow of air in and out of the female stripping tool holes as the press cycles open and close, causes a suction effect, which will cause any parts not completely punched through the female cavities, to be sucked back up through the cavity in the female board and back onto the surface of the tool.



CAUSE

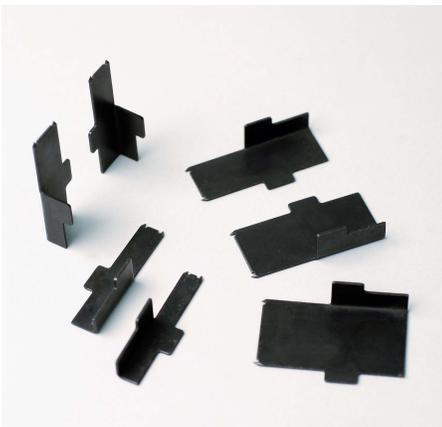
When stripping any part from any material it is important to remember, that every piece of waste requires a degree of force to fully separate the waste from the diecut sheet, and to force it through the cavity in the female board. The force or pressure required to strip any part is a function of the size of the part, the number of parts in a specific area, and the caliper and fiber characteristics of the material. This is an important factor in stripping and it means that every male pin and every cavity, adds pressure, and obviously as more and more pins are added, the degree of overall pressure increases. *See right.*



The accumulation of pressure causes the female board to deflect under the pressure, and it results in poor separation of parts, and excess tensile stress or draw on the diecut sheet. Inevitably the sheet breaks apart under the unbalanced stress of stripping.

SOLUTION

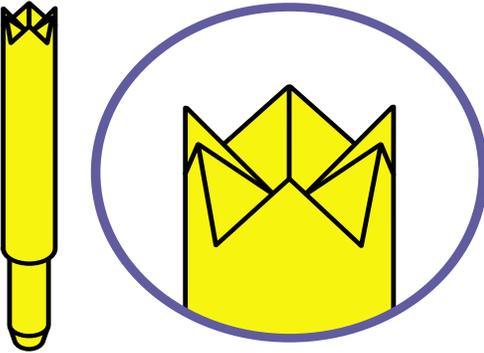
Use Multi-Point Male Strip-ping Claws, which are available from Wagner Die Supply. These specialized stripping claws come in a variety of widths and feature sharp "barbs or claws" on the top. Wagner Stripping Claws are 50mm tall and come in a variety of widths from 7mm to 25mm, in both right and left 90 degree profiles. Easy to program into your stripper layout, these Stripping Claws offer an effective solution ensuring waste pieces are accurately stripped and pushed through the female stripping board.



Close up of Wagner Stripping Claw shows the sharp "claws" or "barbs" on the end, to securely hold waste as it is forced through and out of the female stripping board.

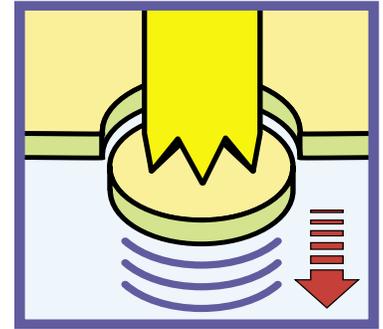
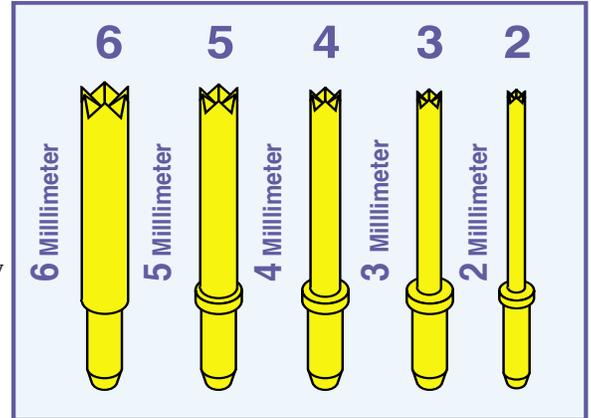
SOLUTION & INNOVATION

Multi-Point Stripping Pins. *See right.* They come in multiple sizes and can be used individually or in gangs, depending upon the shape and the size of the waste to be stripped. They are particularly adept at stripping small, difficult shapes, as the multi-



point tip, *see left*, ensures each waste piece is evenly sheared from the diecut sheet, and driven cleanly through the female cavity. *See below right.*

These pins are easy to use, and they have proven remarkably effective in use. Wagner Multi-Point Stripping Pins are available from all Wagner Die Supply locations Across the USA!



Wagner Die Supply carries a wide selection of stripping pins, from old favorites like Inca Nails and Spring Pins to later technology stripping pins, flat top, to single point, and multi-point stripping pins. Wagner's Stripping Claws are the latest addition to Wagner's collection of stripping accessories.

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