



**PLASTIC WELD  
SYSTEMS, INC.**

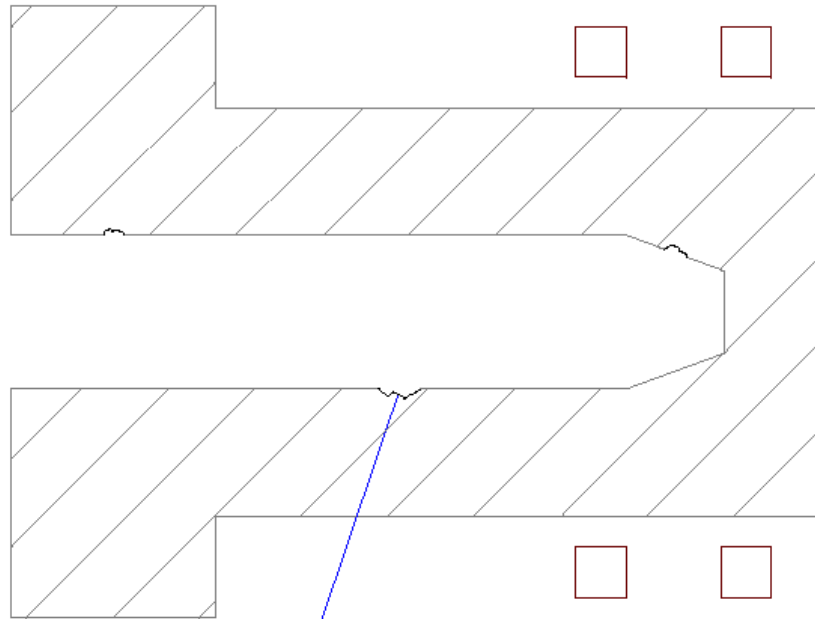
**Precision Catheter Manufacturing Equipment**

# Tipping Die Material

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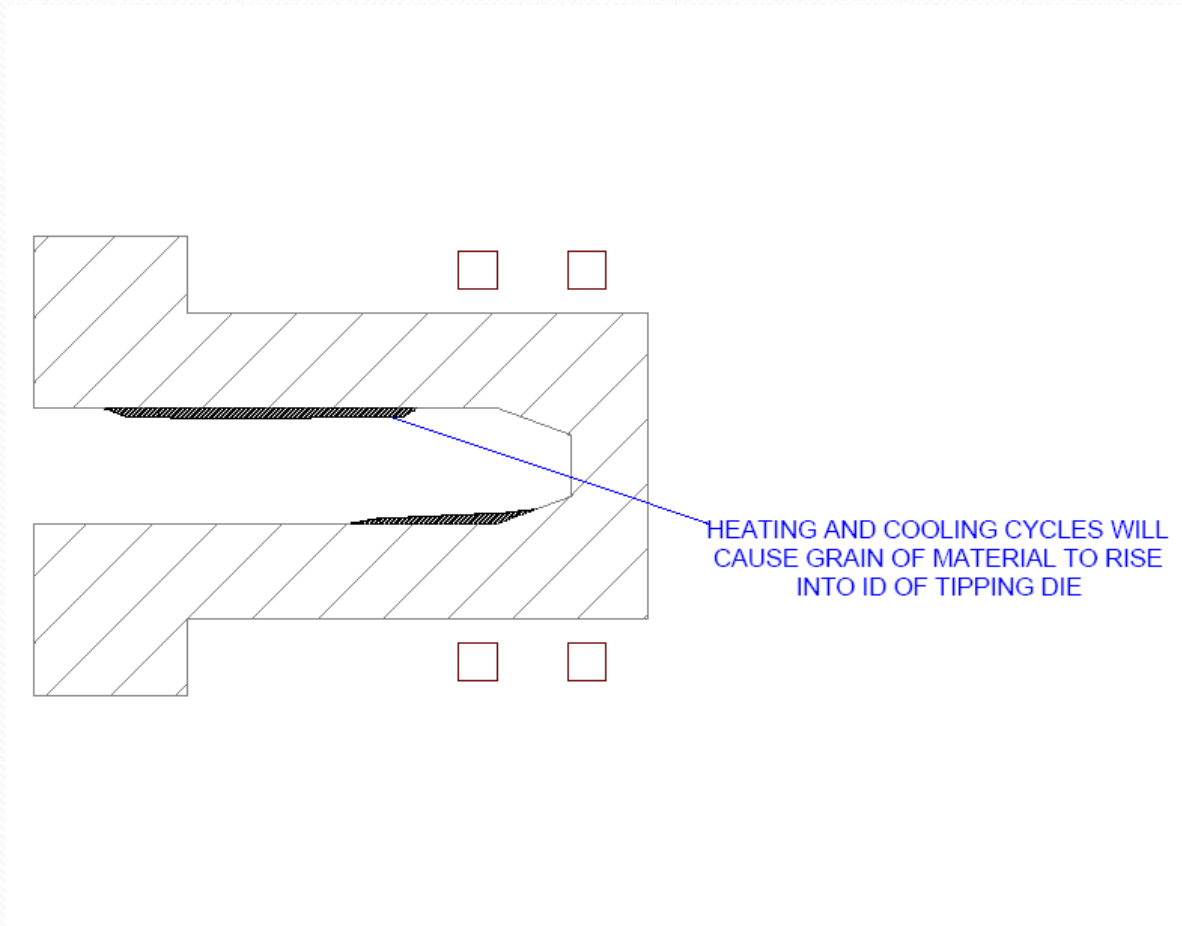
- 300 Series Stainless – Non-Magnetic
  - Heats by Eddy Current effect only
- 400 Series Stainless – Magnetic
  - Heats by Hysteresis and Eddy Current effect
  - 400 Series Standard Grade Stainless - can contain impurities.
- 420 Mold Grade Stainless - impurities are removed.

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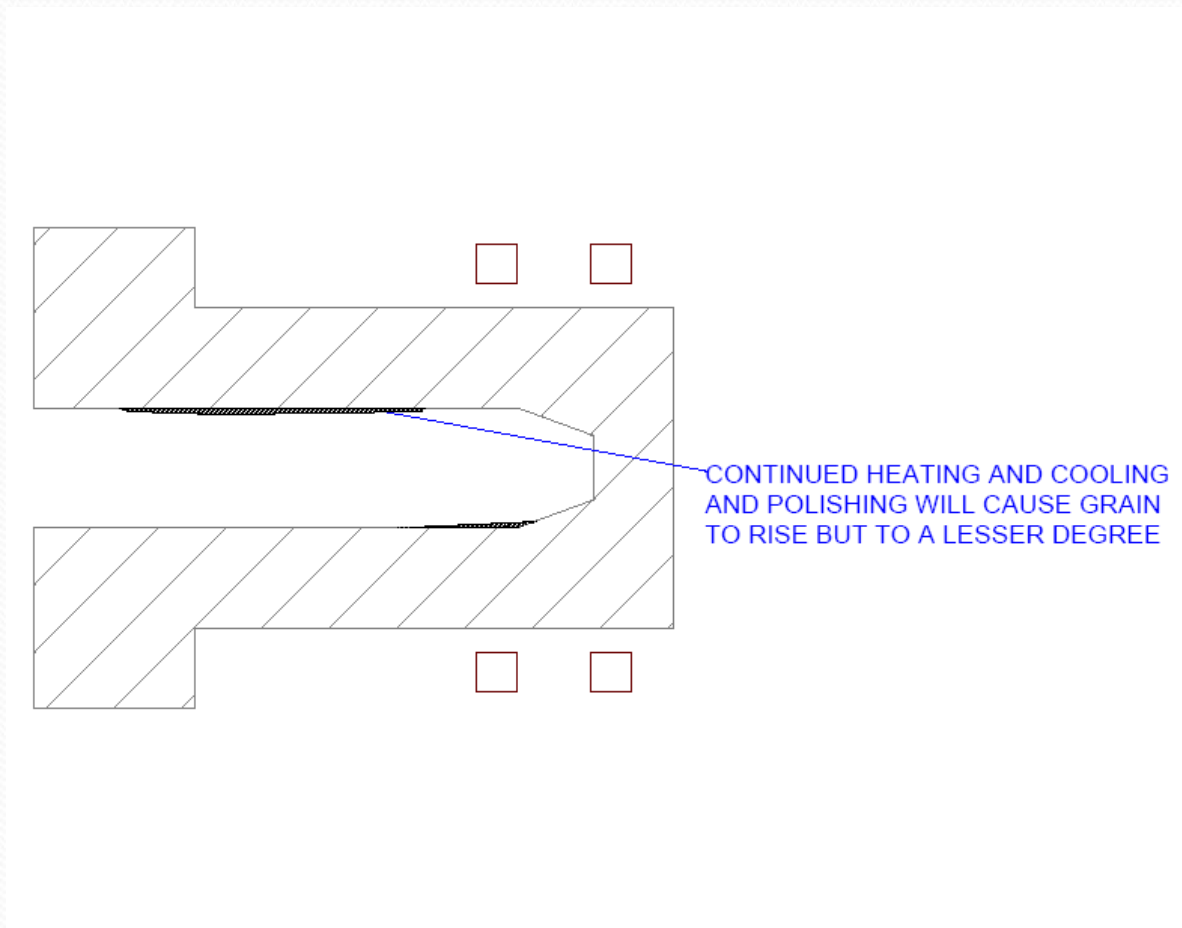


STANDARD GRADE OF STAINLESS  
STEEL CAN HAVE IMPURITIES WHICH  
WILL BE APPARENT AFTER THE TIPPING  
DIE MACHINING IS COMPLETE. THESE WILL  
MAKE THE DIE UNUSABLE

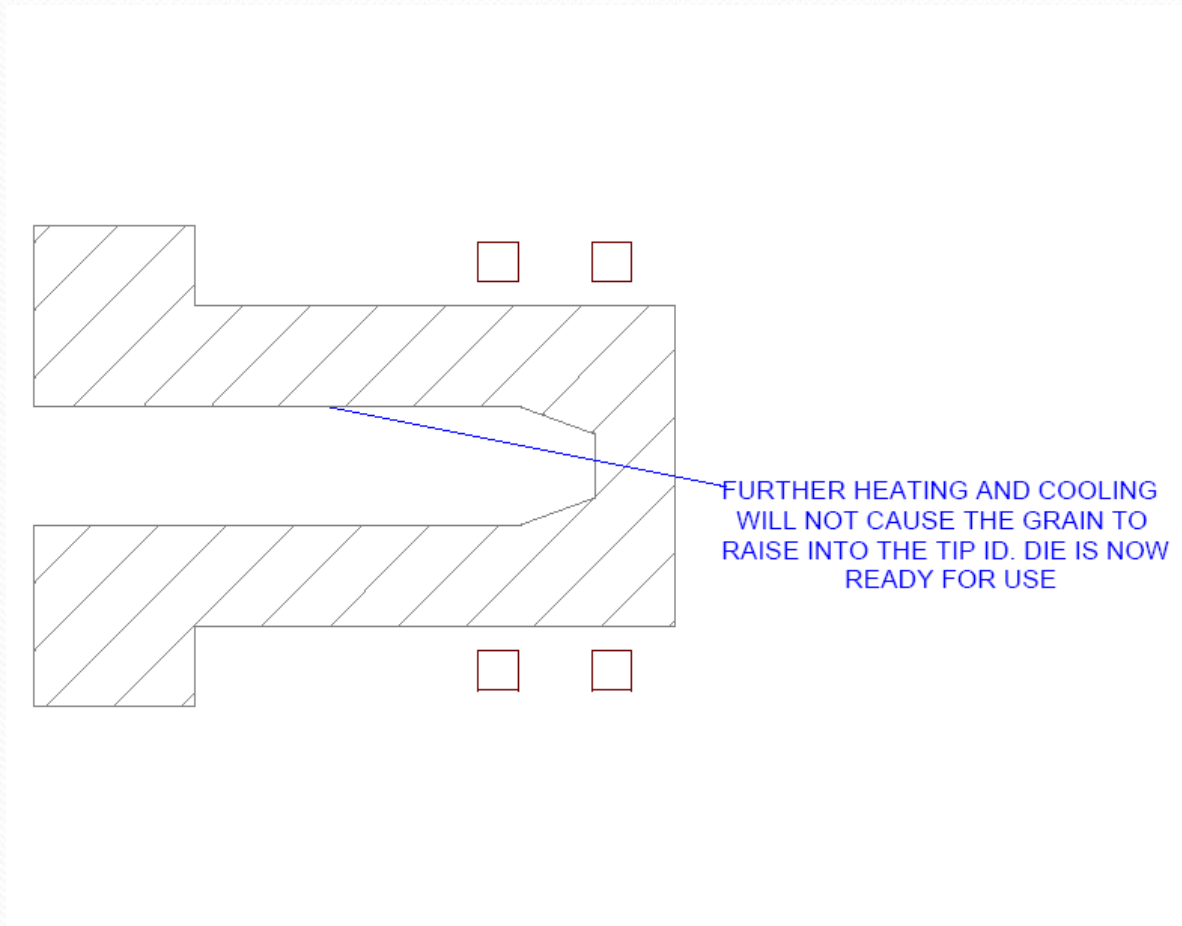
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**Formed Nickel Dies**

# Die Maintenance

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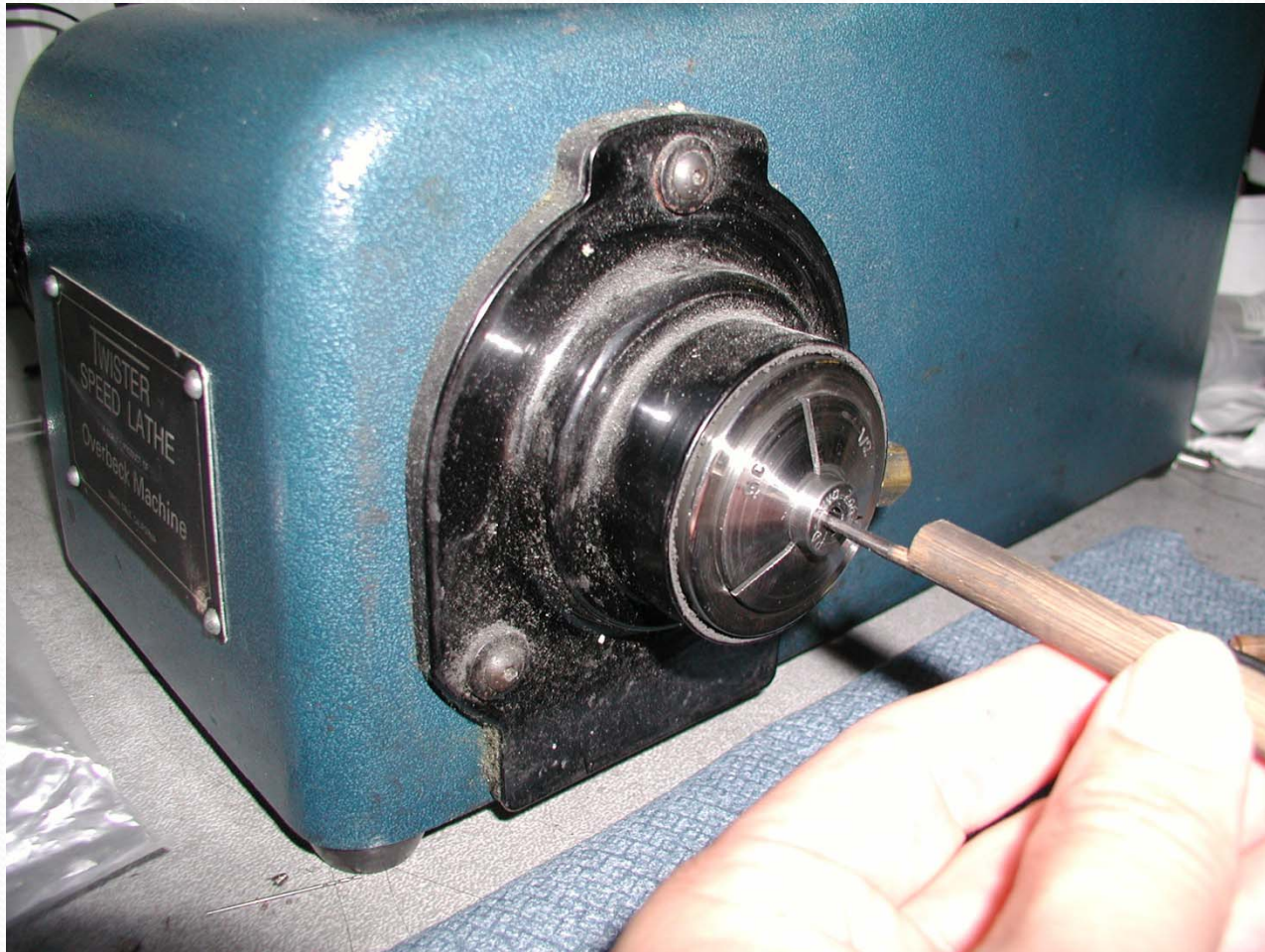
- TIPPING DIE CLEANING INSTRUCTIONS:
- Follow proper lockdown/tag out procedure before removing die from die holder.
- DO NOT insert any metal object in an attempt to clean dies or remove stuck material as this will damage or possibly destroy the tool.
- Dies should only be cleaned as follows:
- Materials needed:
  - 100,000 Grit Luster-Lap Diamond Lapping Compound, Light Concentrations found in McMaster-Carr Supply part number 4776A48. Website:[www.mcmaster.com](http://www.mcmaster.com).
  - Wooden dowel turned down to approximately 10% under the ID of the tipping die with a radiused end or tip. See example below.



# Die Maintenance

- For Open Tip Dies – remove the pin. Place die in a lathe and spin @ approximately 3,000 RPM.
- Put a small amount of polishing compound on the tip of the stick, insert into spinning die until it touches the bottom. Slowly and gently move the stick in and out of the die.
- **NOTE: DO NOT APPLY EXCESSIVE PRESSURE AS THIS MAY DEFORM THE DIE.**
- Periodically check remove the die and check the ID under a lighted scope to view the progress of the cleaning.
- Any questions or concerns, contact PlasticWeld Systems, Inc. at 716-778-7691.

# Die Maintenance



[www.plasticweldsystems.com](http://www.plasticweldsystems.com)

**PlasticWeld Systems, Inc.**

3600 Coomer Road  
Newfane, NY 14108

USA

Ph. 716-778-7691

Fax 716-778-5671

Email: [techsupport@plasticweldsystems.com](mailto:techsupport@plasticweldsystems.com)

-or-

[info@plasticweldsystems.com](mailto:info@plasticweldsystems.com)