

Cutawl Saw



Cutawl Dieboard Blades

Blade No.	Point	Tooth Height	Material Thickness	TPI
32	2	.120	.025	8
33	3	.120	.035	8
34	4	.120	.035	8
34HD	4	.120	.042	10.5
42	2	.175	.025	10
43	3	.175	.035	10
44	4	.175	.035	10
44HD	4	.175	.042	10
44HDL	4	.175	.042	10

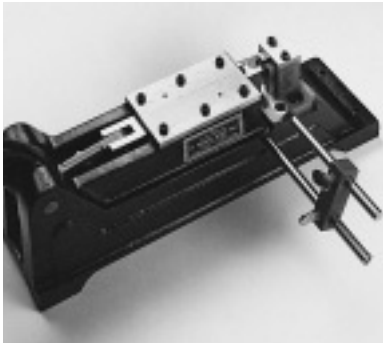
The Cutawl K-12 is the diemaker's saw

This high-speed, portable, precision saw is specially designed for making rotary and flat dies. It cuts hard maple or birch dieboards quickly and easily. Straight lines, curves, or intricate patterns are simple to cut with the free-floating 360 degree swivel head. The curved base plate for making rotary dies is of high quality, one-piece cast aluminum. The flat base plate is made of stainless steel.

The Cutawl model K-12C for rotary dieboard is supplied with a curved base plate for cutting either 66" or 50" circumference rotary dieboard. The Cutawl model K-12F has a flat base plate for cutting flat dieboard. Both models will accommodate blades to cut 2, 3, or 4 point kerf.

Both models have standard 115V, 50-60 HZ motors, but are available with optional 230V, 50-60 HZ motors. An optional Radio Frequency Interference Suppressor is also available.

Helmold Single Miter Machine



The Helmold Single Miter Machine

Easily Miters the Edges of Cutting Rule

In order to guarantee that the edges of your cutting rule will meet and that no die cut material is left hanging, you need a Helmold Miter Machine. This level of perfection is especially important in the production of automatically filled food cartons. It is not necessary to change blades for different thickness rule with this machine, but shims are required for rule over 2 pt. thickness and under 0.937" high.

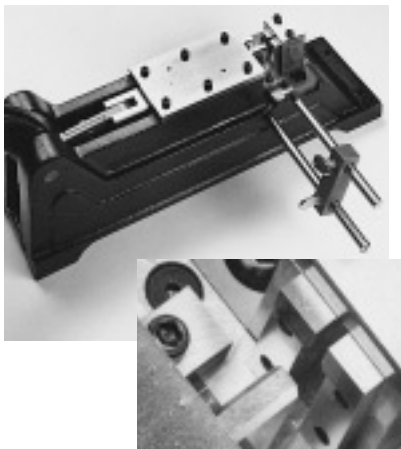
The width of each female knife must be kept at 0.310". As the female knives are sharpened, shims are required between the sides of the female miter house and the outside vertical edges of the female knives to hold the 0.310" dimensions.

Shipping weight is 55 lbs.

For best results, keep your knives sharp. See page 48 of this brochure for details on Helmold's sharpening service.

Shim Requirements			
2 pt. CF, 0.937" height	2 pt. CF, 0.923" height	2 pt. CF, 0.918" height	3 pt. CF
no shim required	0.014" shim	0.019" shim	0.007" shim

Helmold Right and Left Hand Miter Machine



The Helmold Right and Left Hand Miter Machine

Save Time and Effort – Miter Two Ends At Once

When mitering bent pieces of rule, it is sometimes desirable to miter from the opposite end of the formed piece. Our Right and Left Hand Miter Machine can miter two ends at once – thus eliminating the extra steps involved in cutting lengths on a cutter, trimming one end of the miter, and setting up once again to trim the other

end. In addition, this machine allows mitering of small lengths on both ends with ease.

Shipping weight is 55 lbs.

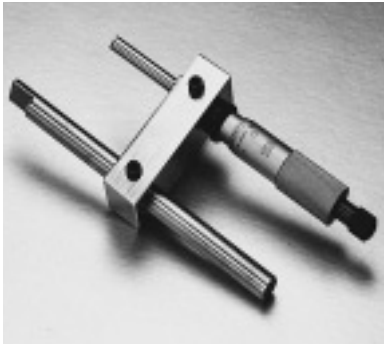
For best results, keep your knives sharp. See page 48 of this brochure for details on Helmold's sharpening service.

Note: The knives for this machine are not compatible with machines prior to number 500M.



Helmold recommends purchasing spare miter knives. This eliminates down time when sending dull knives out for sharpening.

Die Room Supplies and Tools



Micrometer Side Gauge

This micrometer may be adjusted to 0.0001" for side gauge measurements of rule as a final adjustment when setting up your Hel mold bending, notching, cutting or miter machines. Available with 1" travel for close tolerance measurement adjustment requirements. Please specify type of machine being used.



Cutawl Saw

For rotary dies, this is the leading saw. Unlike other sabre-type saws, the Cutawl is made especially for maple and birch dieboards – materials that would cause commercially available sabre-type saws to burn out quickly. The Cutawl easily and accurately saws curved rotary dieboards, flat dieboards and stripping boards. We offer

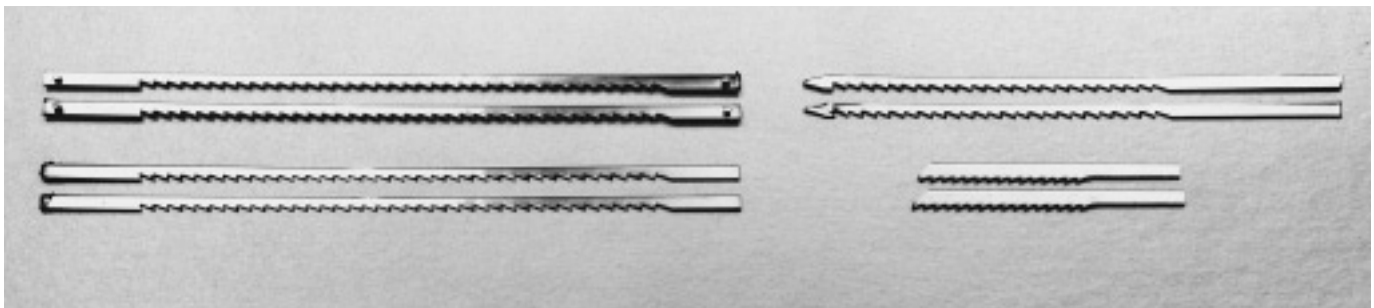
three models. Optional equipment includes: a 230V, 50-60 Hz motor; a radio frequency interference suppresser; and a safety gauge (required in Canada). Cutawl saw blades are available for 2, 3 and 4 pt. sawing.

Model Number	Recommended Use
K-12F	Flat dieboards
K-12C-66	66" rotary dieboards
K-12C-50	50" rotary dieboards

Jig Saw Blades

All our jig saw blades are high carbon and high quality. We offer sizes for all types of saws used in diemaking applications, including: standard non-retractable jig saws (blades with and without pins); and the Laborsaber jig saw (retractable blades).

All our jig saw blades are available for 1½", 2, 3, 4 and 6 pt. rule in a variety of widths, lengths and tooth specifications. Some 2 and 3 pt. jig saw blades are available with "reverse teeth" which are designed for cleaner sawing on the bottom of the





Rule Puller

Our rule pullers have specially hardened 1" jaws with a $\frac{5}{8}$ " deep throat. A double action power grip guarantees greater leverage.



Carbide Saw Blades

Our carbide saw blades have a special tooth design that reduces splintering. Available in 7" or 8" diameters with 48 teeth. Our 8" blade is available with a 1" or 1 $\frac{1}{8}$ " center hole. Our 7" blade is available with a 1 $\frac{1}{8}$ " center hole only.



Rawhide Mallets

These mallets were designed specifically for the die maker to use to pound steel rule into the dieboard. They are tough, durable, and will not damage rule. Available in three sizes for varying levels of use.

Size	Use
3	light duty
4	medium duty
5	heavy duty



Hand Cutter

This versatile cutter is ideal for trimming pieces of rule from coils prior to bending.



Nicker Tool

This convenient hand tool securely holds pieces of extra hard 2 pt. cutting rule so that they can be used to nick dies.

Die Room Supplies and Tools



Grinding Wheels

Helmold grinding wheels are available in a variety of thicknesses in diameters of 1½" and 2". These grinding wheels can be used to nick dies before or after the die is rubbered without damaging the cutting rule. The larger diameter grinding wheels can make a nick that is straight and square to the cutting edge of the rule. All are available with ⅛" center hole. A #39 mandrel is

required for ⅛" shank and center hole. *Note: Use only with grinders rated for a maximum speed of 22,000 RPM. Always wear protective eye glasses when using nicking grinders.*

Available Thicknesses
0.015", 0.020", 0.025", 0.031", 0.040", 0.045", 0.062", 0.093", 0.125"



Dremel Moto-Tool, Model 275

This easy-to-use, highly accurate nicking grinder comes with a ⅛" mandrel and collet, but also accommodates optional ¼", ⅜", and ½" collets. It has a convenient storage hook. *Note: Use only with Dremel #409 grinding wheels. Always wear protective eye glasses when using nicking grinders.*

Specifications	
Power	110/120 V, 8 amp AC or DC
Speed	30,000 RPM
Weight	11 oz.



DuMore Hand Grinder, Model 10-351

This rugged grinder is used for nicking steel rule dies. It is accurate and easy to use. Supplied with ¼" collet and ⅛" reducing bushing. *Note: Use only with appropriately rated grinding wheels. Always wear protective eye glasses when using nicking grinders.*

Specifications	
Length	Under 10"
Horsepower	¼ hp at 22,000 RPM
Weight	3 lbs.



DuMore Hand Grinder, Model 1-141

This highly accurate and easy-to-use nicking grinder has a cool-running flexible shaft with a ⅜" diameter hand piece. It can be mounted to the bench or suspended at press. *Note: Use only with appropriately rated grinding wheels. Always wear protective eye glasses when using nicking grinders.*

Specifications	
Shaft Length	36"
Horsepower	¼ hp at 15,000 RPM
Ship Weight	8 lbs.



Laborsaber Jig Saw, Model DJ-36

This new jig saw has design innovations that greatly increase sawing speed yet retain the accuracies you need and expect. Available in four throat sizes: 36", 48", 60" and 70". Drill and vacuum are standard. Options include a jig head set at 90° to arm for larger dieboards, magnifying glasses and table

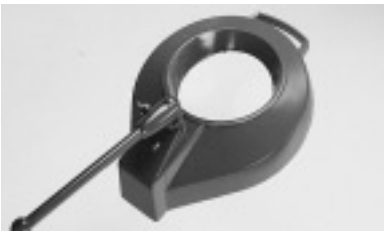
extension arms with ball bearing surfaces. Our drills are non-splintering for making cleaner bridge holes. *Note: We stock rebuilt and new jig units, blade guides, jig saw blades and parts for all these at our facilities.*



Laborsaber Jig Saw, Model E-42

A smaller version of the Laborsaber DJ-series, this model is available in three throat sizes: 42", 52" and 62". Options include drills, vacuum, jig head set at 90° to arm for larger dieboards, magnifying glasses

and table extension arms with ball bearing surfaces. *Note: We stock rebuilt and new jig units, blade guides, jig saw blades and parts for all these at our facilities.*



Mag Light

This accessory was specifically designed to fit the Laborsaber. It consists of a magnifying glass surrounded by a high intensity light and greatly improves visibility

of the saw line. An adjustable, locking arm allows operator to set the mag light to the optimal position and lock it in place.



Jig Unit

We recommend using this rebuild for quick changes of the Laborsaber jig unit. To replace your old jig unit, simply remove

four bolts, align the new unit and replaces the bolts – your jig saw is good as new.



Handee Air Grinder

These lightweight nicking grinders can be used at the work table, on the diecutting press, or wherever compressed air is available. We offer two models: the Standard 8000 and the Super 8500. The Standard comes with a 1/8" collet. The Super comes with a 1/4" collet, but can also use an optional 1/8" collet. *Note: Use only with*

appropriately rated grinding wheels. Always wear protective eye glasses when using nicking grinders.

Specifications	
Length	5"
Compression	High stall torque
Optimum PSI	90
Speed	17,500 RPM at 90 PSI
Weight	9 oz.

Die Room Supplies and Tools



Creasing Matrix

We offer two brands of ready-made, self-locating creasing matrix: X-Press and Shreiner. Both efficiently and accurately register creasing rule and matrix. And all are color-coded for ease in size selection and use. These matrices can be used on most Platen and cylinder presses and can be placed on the die before being installed on the press. Both are available for a range of board thicknesses, from 0.005" to 0.072".

Optional accessories include: Easi Crease™ die cushion, Euro Rubba™, steel shim tape, mitering bench press, mitering pliers, files, and skivers. *Note: When choosing a creasing matrix, be sure to select the proper height. This depends on both creasing rule height and board thickness. See the equation and chart below for details.*

Equation:	Example:
Cutting Rule Height	0.937"
Board Thickness	0.025"
- <u>Matrix Base Thickness</u>	- <u>0.009"</u>
= Creasing Rule Height	= 0.903"

Board Thickness	Required Creasing Rule Thickness
0.025"	2 pt.
0.040"	3 pt.
0.055"	4 pt.
0.070"	6 pt.



Ejection Rubber

We offer ejection rubber for all types of die-cutting and stripping applications. Choose from sponge, neoprene, cork neoprene, gum, rick rack, straight and foam (for stripping jigs). We recommend ordering ejection rubber that is 1/16" above the cutting rule. Ask your Helmold distributor for information on size availability.