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OPERATING INSTRUCTIONS FOR DIE SHARPENING FIXTURES

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INTRODUCTION:

The DSF line of tooling is used to re-sharpen cutting edges and maintain reliability of Panduit CD-800 and CD9 Cutter Dies. DSF-NP is for use with nickel-plated dies and DSF-RS is for use with black oxide dies.

Operation of DSF Sharpening Fixtures:

1. Place cutter die (1) into slot on the appropriate fixture (2), in the upright position, as shown in Figure A.
2. Apply four drops of lubricant (supplied with fixture) to the surface of sharpening stone (3).
3. Place sharpening stone flat on angled surface of fixture, as shown in Figure A.
4. While applying slight upward pressure to the cutter die, slide sharpening stone back and forth in the direction of the arrows until tip is sharp. Make sure that the sharpening stone remains flat against the surface of the sharpening fixture.
5. Rotate the cutter die 180° to sharpen other cutting blade surface, and repeat Steps 3 and 4.

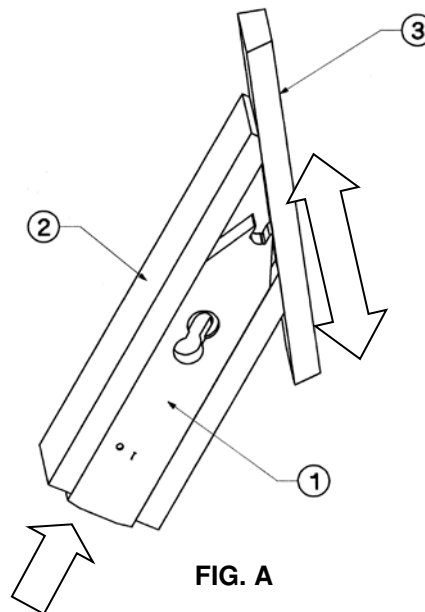


FIG. A

NOTE: Sharpening of the cutter die may leave a very small burr, which should be removed from the die cutting edges.

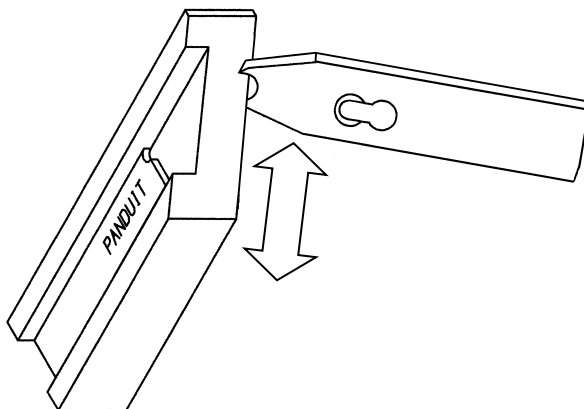


FIG. B

6. Place the cutting edges of the die against the angled end of the die sharpening fixture, as shown in Figure B. Slide the die back and forth along the end of the die sharpening fixture at least 25 times.

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