

# Trumpf Non-Marking Solutions.

What can you do;

- 1./ Use Urethane pads
- 2./ Use Slug Free dies
- 3./ Use Brush Dies
- 4./ Moving the tables a little bit up, so that the sheet does not touch the die
- 5./ Making a bigger radius on top of the dies after grinding, and maybe before grinding too
- 6./ Using pocket brushes onto the slitting dies with inserts
- 7./ Having die adapters #2 to accept #1 dies with small pocket brushes
- 8./ Designing a new type of die with small pocket brushes next to the form, and they can be taken out for grinding and put back after grinding
- 9./.....

## Tips for practical operation

### Adhesive urethane pads

- Fix adhesive urethane pads to strippers and dies.

### Daily cleaning

- Proper care of tools is of crucial importance.
- Clean the following daily: table surfaces, brushes, brush segments and the sheet support points on the machine.

### Working with the active presser foot

- You can choose between active or passive presser foot. The active presser foot holds the sheet down during the punching operation. This prevents scratches being formed due to sheet deformation. Adhesive pads can also be used with the active presser foot.

### Elevated working height

- Select the working height (stripper 1mm higher). This helps to eliminate scratches on the upper side of the sheet caused by the stripper, especially when working uneven sheets.

### Additional measures

- Keep tools sharp at all times.
- Use Slug Free dies, turn the slug vacuum off.
- Punch and die must be precision aligned to each other to prevent burring. QuickLock gives you the best solution.
- Check alignment between upper and lower tool adapter.
- Check the setting of the brush fields close to the die; if necessary, re-adjust or replace. Setting: 0.5–1 mm above the die surface.
- Polish the dies, strippers and repositioning surfaces (grain size min. P360).
- Make sure the brushes are set correctly on the dies and intermediate rings.
- Use polyamide-coated strippers.
- Use foil-coated sheets (e.g. polyethylene PE). No adhesive pads are needed in this case.
- Ample tool lubrication prevents cold welding effects, built-up edges on the punch, and premature or excessive burr formation.
- As an additional measure, oil can be brushed on the underside of the sheet (machines with roller tables only).