

Thank you for your purchase of DMS Precision Rotary Hot Stamping Tooling. The following instructions are designed to assist you with the mounting and handling of your new DMS hot stamping die. While every attempt has been made to be as complete as possible in our instructions, it is possible that you will find situation specific to your application that is not covered here. In those cases please contact DMS directly and we will be happy to assist you further.



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Econofoil Die Mounting Instructions

1. Place your aluminum Die Base or Mandrel in a freezer or refrigerator for an hour or more to make the metal contract as much as possible. This will help make it easier to slide on the Econofoil Die later. Remember to save the box that your aluminum Die Base came in so you use it for storage later.
2. Place the Econofoil Hot Stamping Sleeve Die in as warm a place as possible while the aluminum Die Base is cooling down. This will help make it easier to slide on the Econofoil Die later. Remember to save the shipping tube that your Econofoil Die came in so you can use it to safely store your die later.
3. Prepare an area to mount the Econofoil Die to the die base. Choose a bench area that is clean and free of items that could damage the engraving on your Econofoil Die. Poor handling is the number 1 reason for hot stamping die damage, so you want to take care whenever handling engraved hot stamping dies of any type.
4. After a sufficient time has passed and the aluminum Die Base has cooled and contracted, remove it and place it on your bench. Position the die base so the locating pin is down, and in the front facing you. There should be visible a small scribe line in the surface of the Die Base rising from the pin position, all the way up (across) the face of the Die Base to the other end, which is where you will start to slide on the Econofoil Die.
5. Remove any rings or jewelry from your fingers or hands that could come in contact with the engraving on your Econofoil Die. Position and hold the Econofoil Die over the Die Base with the slot for the pin pointing down. If the Econofoil die has a pin slot at each end, be sure to position the correct pin slot down so the die will be in the right direction in your press.

6. Lower the Econofoil Die until it makes contact with the die base, and the pin slot is lined up on the scribe line on the Die Base. Carefully start to slide the Econofoil onto the Die Base making sure it is sliding on evenly.
7. Continue to slide the Econofoil Die down the Die Base making sure to keep the pin slot lined up with the scribe line. Try to keep the Econofoil Die continually moving until the die slides all the way on and the pin slot engages the pin at the far end of the Die Base.
8. Now that the Econofoil Die is completely on the Die Base and located on the pin, you are ready to mount the Die Base onto your hot stamping system.
9. At this point, follow your hot stamping system manufacturers instructions for mounting the Die Base onto the system. Always be careful when handling the Die Base to not damage the engraving on the Econofoil Die.

Econofoil Die Removal / Changeover

1. To remove the Econofoil Die, start by cooling down the entire Die Base and Econofoil Die assembly. After removing the Die Base from your hot stamping system, place the assembly in a freezer or refrigerator. Cool for as long a time as necessary to allow the aluminum Die Base to contract. In this process, the Die Base will contract more than the Econofoil Die when in the freezer or refrigerator. This will make removing the Econofoil Die easier.
2. Remove any rings or jewelry from your fingers or hands that could come in contact with the engraving on your Econofoil Die. Place the Die Base on your clean bench. Grip the Econofoil Die with your hands and start to slide it up and off of the Die Base. It may be necessary to have another person assist you by holding down the Die Base while you remove the Econofoil Die. After you have removed the Econofoil Die, carefully wrap and store the die in its original shipping tube. If you are done using the aluminum Die Base, store it in the original shipping box.
3. If you are changing over jobs, and wish to mount another Econofoil Die, refer to the directions for Econofoil Die mounting above.