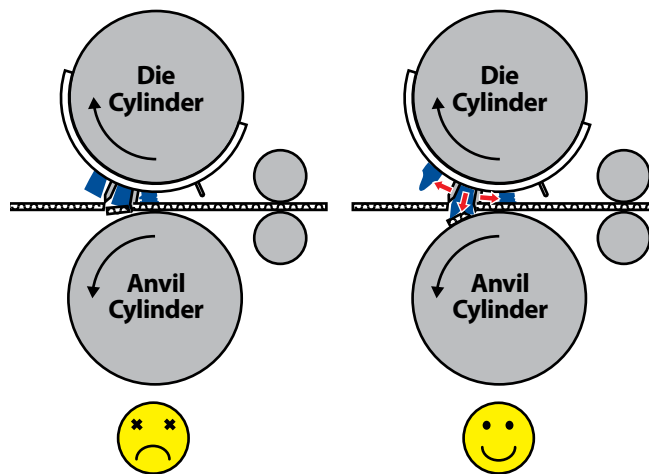
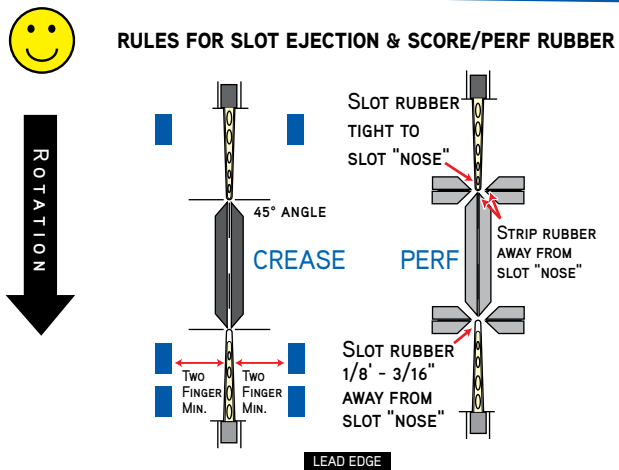


Rubber Selection Guide for DDI Standard High Performance Rotary

- Waste Rubber**
"Shark" Scrap Ejection Rubber (Firm)
1/2" over cutting rule
Closed Cell Sponge
- Lead Edge Trim Ejection Rubber (Soft)**
1/8" over cutting rule.
Closed Cell Sponge
Tight to trim knife, 1/4" away from trim breaker.
- Trail "Trim" Ejection Rubber (Hard)**
1/32" - 1/16" over cutting rule.
Closed Cell Sponge
Tight to trim knife, 1/4" away from trim breaker.
- Slot & Narrow Scrap Ejection Rubber**
1/8" - 3/16" over cutting rule.
Micro Cell (High Density)
"Scalloped" top as shown.
Fill slot length but allow approximately 1/64" at sides for movement.
- Product Rubber**
NFS Product Ejection Rubber (Soft)
1/16" over cutting rule.
Closed Cell Sponge
- Crease Rubber**
Curved Score Rubber - Shoulder-Flex-2
Even with score rule.
- Curved Score Rubber - Cushion Crease**
1/32" below score rule.
Apply continuously along both sides of curved scores.
Cut 45° angle at ends.
- Curved Score Rubber - "Low Crush" (Soft)**
1/16" above score rule.
Closed Cell Sponge Strips
Apply continuously along both sides of curved scores.
Cut 45° angle at ends.

* Allow 1/8" (gap) at end of slot rubber pieces where rotation force will push the rubber toward the "nose" of the slot.

How DDI Rotary Stripping Works



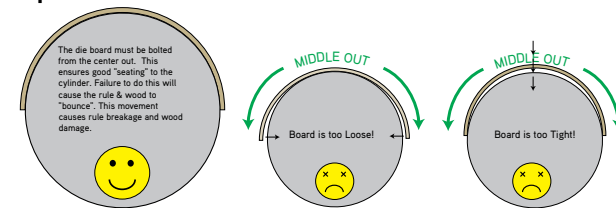
"Old Style" Waste rubber and Box Ejection rubber are the same height and too close together.

NEW "SHARK" Waste Ejection rubber is much HIGHER than Box Ejection rubber.

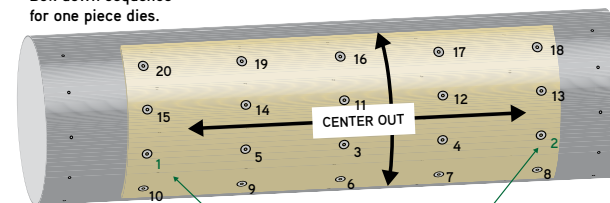
"SHARK" bends and pins waste to anvil. PLUS Box Ejection rubber is spaced AWAY from cut outs.

Bolting Guide for Rotary Dies

Start from the "crown" and work toward the edges. Rotary Die Wood will change size and shape over time!

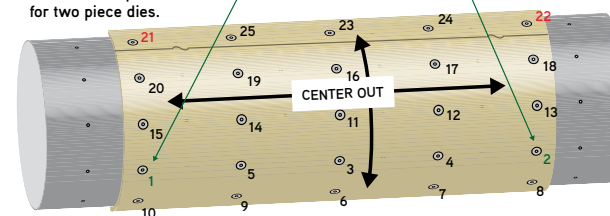


Bolt down sequence for one piece dies.



Start with these bolt holes.

Bolt down sequence for two piece dies.



It is important to be sure the first horizontal row bolted down is "centered" over the cylinder's bolt holes along the entire row!! Misalignment here will cause later rows to be out of position.



To ORDER any of these materials call 419-861-7233-, or ask your DDI CSA or Sales Rep.

Ask about our DynaPro Premium Performance Rotary!

For information, ask your DDI Sales Rep.

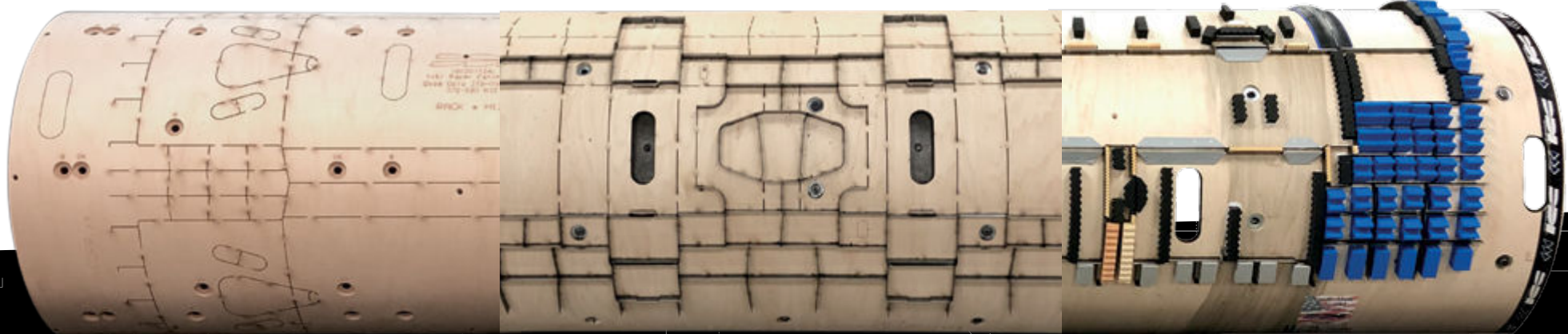
The NEW DDI Rotary Die

The most versatile rotary die on the market is the DDI standard!

This specification optimizes performance over the broadest range of corrugated materials!

To take advantage of the NEW DDI ROTARY DIE:

- 1) Select one of three waste sizes.
 - a.) 1-1/2" x 2-1/4"
 - b.) 2" x 3"
 - c.) 2-1/2" x 4"
- 2) Select one of three crease rubber options.
- 3) Say YES to the DDI specification.



- High Curve Tolerance Premium Wood
- High Performance Pulse Laser, +/- .005"
- Specific Engineering of Laser Cut Widths
- Uniform Bridging for Die Board Strength
- Counter-bored & Reinforced Washers for Bolt Holes

- Special Attention to Rule Joints
- Welded Joints When Needed
- Joint Location Engineered
- Engineered Serrations Specific to Cut Requirement
- Specialized Perforation, Tear and Crease Options

- Shark Rubber Scrap Ejection System
- Soft Product Rubber for Continuous Contact
- Long Lasting High Performance Slot Rubber



The Dynamic Dies Incorporated philosophy is to engineer a rotary cutting die that works over the broadest range of conditions and then standardize around it to capitalize on the efficiencies gained in the process.

Process routines create repeatability that connect to reliability of performance and more speedy delivery! Box makers want and deserve the best die they can buy in a time frame that meets the demand.