

◆ MetalLife® NEWS ◆

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Odds & Ends

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Badger Metal provides a standard 3-5 day turn around on received tooling. Here are some items that can be done to assure that we not only turn your tooling around quickly but also that it comes to us intact with no damage during shipment.

Preparation for shipment - When preparing your tooling for shipment, make sure it has been cleaned to **remove all grease and solder**. Even though we clean all tooling prior to processing an excessive build-up of grease or cosmoline could cause delays in getting your tooling into our processing production schedule and could contaminate our machinery. Solder on hot spots that is not removed may come off during heat stress tempering or could be removed during Metalife processing. There is no guarantee of this, however, since Metalife is not an abrasive process.

Shipments - If possible, make sure that a **casting is included** for all die inserts sent to us. This **assures** that all die surface **casting areas** will be **identified and processed**. Also the casting gives us a "finger print" of the die indicating areas where heat checking is prevalent. We maintain a rotating inventory of castings for about a one year period. In the case of repeated applications of Metalife on the same tool or additional cavities of the same tool, it may not be necessary to include a casting. It is best to call us on our 300 number prior to shipment to assure we have a casting in our inventory.



Small Item Packaging - Items that are small enough to ship in cardboard boxes via UPS, Emery, Federal Express, etc., should be wrapped in protective material. We recommend bubble or Styrofoam packaging. The shipment should then be **double boxed** encapsulating the box with polypropylene tape to prevent splitting of the box. **IPS**



Truck Shipments Items should be two way banded to a skid and framed with 2" x 2" or 2" x 4" boards protect all sides from damage, movement, or shifting during shipment. These boards should be screwed or nailed to the pallet. Smaller items are best



shipped in wooden crates or boxes. **Thin wall wood boxes** should be placed and banded to a skid pallet. Items placed in these boxes should be packaged to prevent moving, shifting, or damage during shipment. Packaging material or wooden spacers between the inserts, cores, or slides should be used. If your shipping container is not reusable, Badger will ship in a 2' x 6' constructed container (shown) with either a heavy corrugated or plywood top.



Miscellaneous - If heat stress tempering is desired prior to Metalife, this should be indicated on paperwork or call us to inform us of this prior to shipment. **Dies that have been previously nitrided are not good candidates for crack closure** due to the high hardness the surface. Badger should be advised of welded areas on the tooling. Cracks that exist in these areas are sometimes difficult to close due to the higher hardness of the weld. Have you lost or misplaced our newsletters? If so, **download them or print them directly from our website at www.badgermetal.com**. We plan to start emailing future issues once a significant number of our customers get email addresses.

In our July 1997 issue we will continue our examination

now has a 150lb limit, however, packaging items of this weight in cardboard boxes is not recommended.

of the "Modes and Causes of Die Failure" address **Soldering and Erosion problems.**

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