

Device to manufacture Manhathan pads PY2XT - CELSO

"ALWAYS USE PERSONAL SAFETY EQUIPMENT, WITH GLOVES AND SAFETY GOGGLES. NEVER TRUST IN LUCK AND ALWAYS HAVE SAFETY AS YOUR DEPARTURE POINT FOR ALL YOUR TASKS"

Work sequence:

- *Block perforation (hole with a 5mm diameter or according to your criteria).*
- *Lateral cut with two saw blades in the same arc (+/- 3mm).*
- *Drill preparation (analyze both ends)*

Iron block with approximate dimensions of 3cm x 3cm x 3cm (these measurements are not critical).

For the pattern's hole, I used a 5mm drill bit and the hole was made more or less 4mm from one of the edges, since with the same iron block I am going to make other holes with different gauges "islands with different diameters, using the same iron block".

The secret of success of the pattern is the HOLE. Look for a shop that has a column drill or a mounted drill. try to attach the iron block using a vise or vise clamp pliers and carefully make the hole, passing through the iron block completely in a single try.

For the cut of the gap on the copper plate, join two saw blades on the same arc as the saw. This will produce a cut approximately 3mm wide, however, do not worry if it is a little too wide. The most important thing is for the cut to be as parallel as possible, but it is also not critical.

In my tests, I verified that the gap should be approximately 8mm deep, because I believe that "islands" with a 5mm diameter are the ideal size for assembly, leaving 1.5mm for each border of the copper plate's tape (5mm for the island + 2 x 1.5mm for the borders). Is not critical.

The arc of the saw I have has long blade attachment pins, sufficient for two blades.

Your die is almost ready, as a punch I used the drill. With the help of a grinder, pass the side of the drill bit that is used to attach the drill bit to the drill until it is parallel and from the other side, run through the grinder to remove the cutting angle, which should also be parallel. A tip to achieve a good parallel position, it to turn the drill bit with your fingers during the grinding process. Careful with your hands and use safety goggles.

To use the die, place it on a solid surface, place the copper strip in the gap with the copper side down, place the drill bit with the ground smooth part facing the bottom on the top hole and use a hammer to strike it in place. You will not believe the quality of the stamp (die).

Every thing quick and easy, my die was ready in less than one hour, without any problems or need for special tools.

I have made island stamps (dies) with several types of copper plates and the finish is excellent. Specially with fiberglass copper plates.