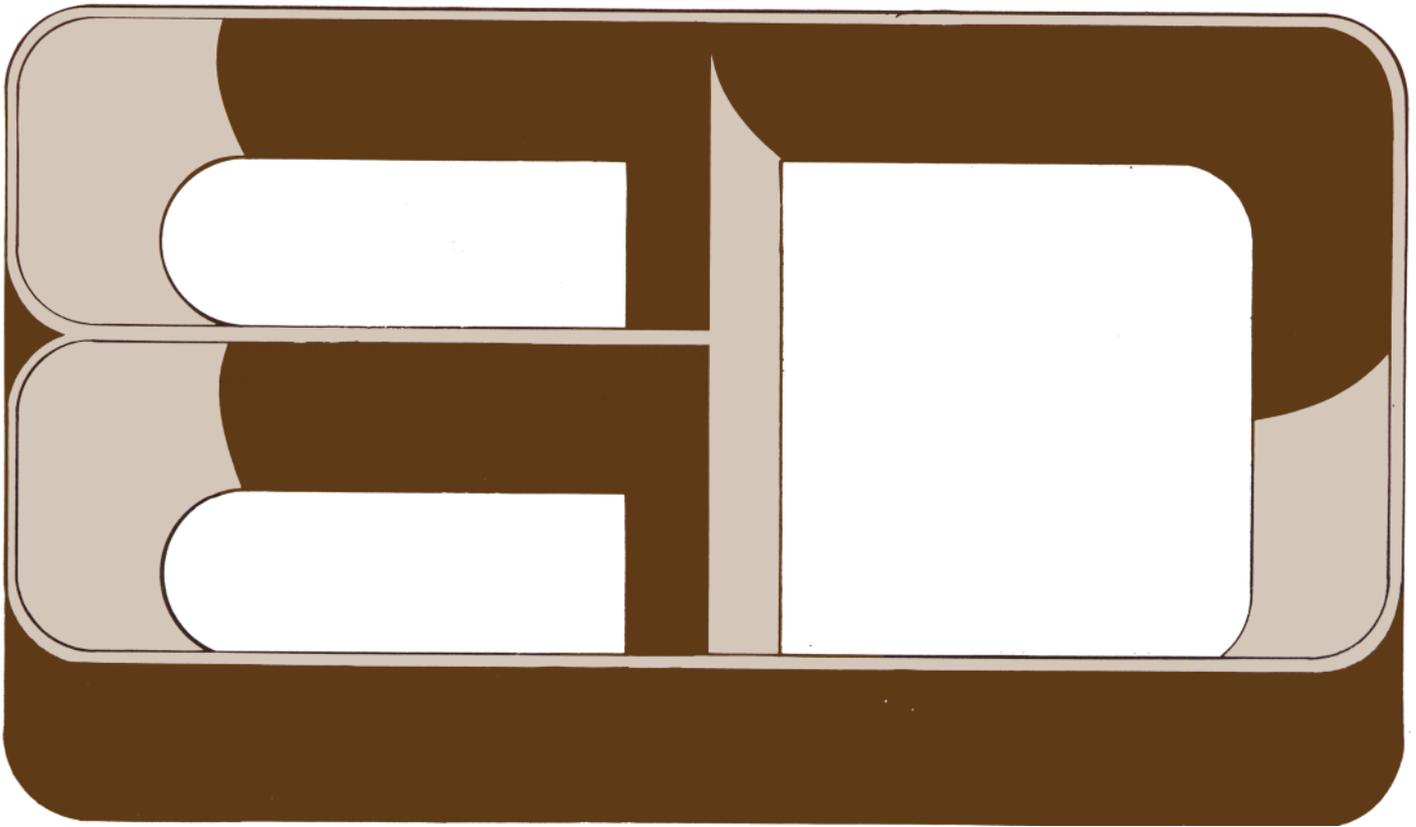


BELGIUM DIECRAFT



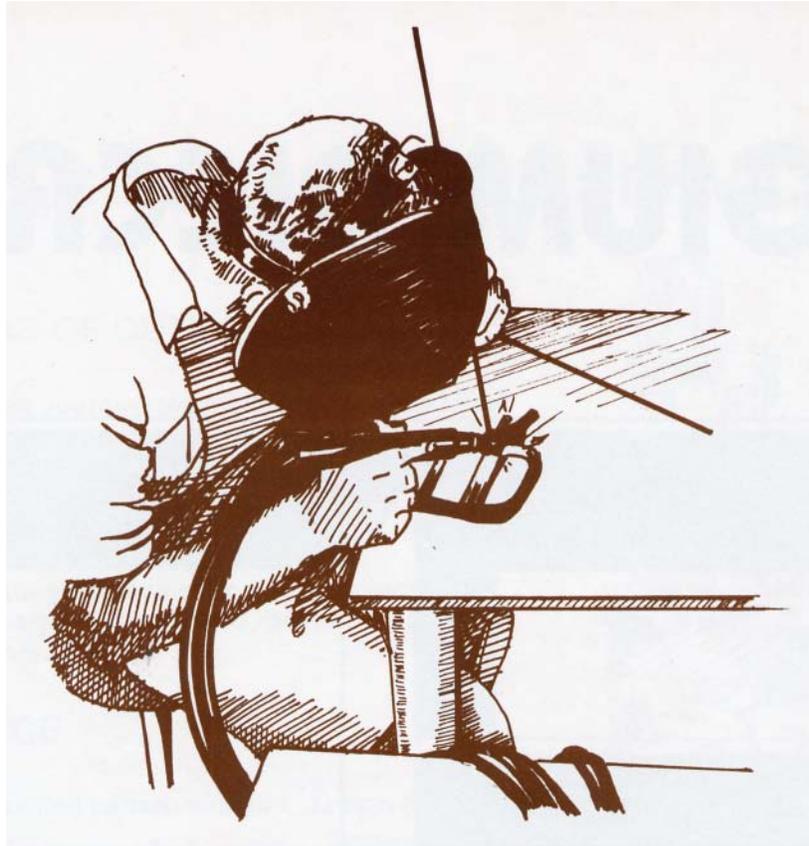
**OLD WORLD DIE CRAFTSMANSHIP FOR
QUALITY CUTTING DIES**

***REBUILT AND NEW CLICKERS FOR YOUR
CUTTING NEEDS***

**SUBCONTRACT CUTTING OF YOUR
PRODUCT IN LEATHER, VINYL,
CANVASS OR FELT.**

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BELGIUM DIECRAFT PRECISION CUTTING DIES



BELGIUM DIECRAFT
DIVISION OF LEATHER UNLIMITED CORPORATION
P.O. BOX 342, 7155 HWY B
BELGIUM, WISCONSIN 53004
920-994-9464

Belgium Diecraft is a full service cutting die manufacturer. It is our primary goal to provide our customers with the right die for any cutting situation.

Our service includes the following:

- **Consultation for any cutting or trimming application.**

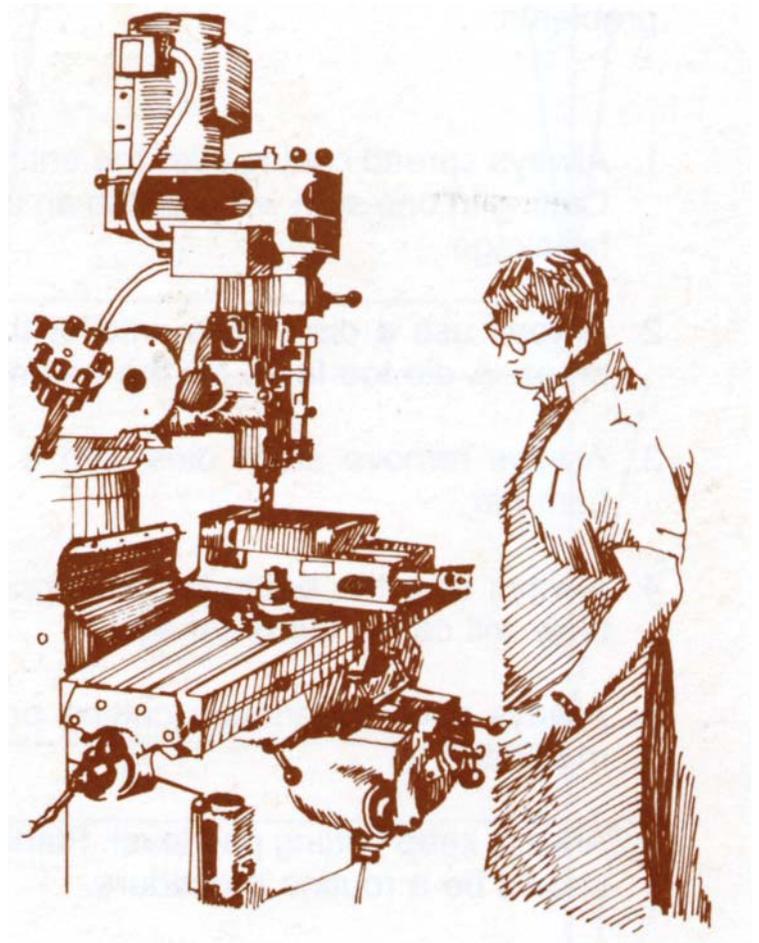
- **Pattern Service** - Our firm has available skilled pattern makers if pattern or layout work is needed. If you do your own pattern work, you make FAX us your pattern for a quick quote.

- **Manufacture of most types of cutting Dies-** Belgium Diecraft feature journeymen and the latest modern equipment to fabricate most types of cutting dies.

- **Die repair service** - Belgium Diecraft offers cutting die repair service. This includes welding broken dies, sharpening dies, and resurfacing and re sharpening if necessary.

- **Custom parts Service**

- **Cutting Pads** - We will plane your cutting pad or we are a distributor of new cutting pads at competitive prices.

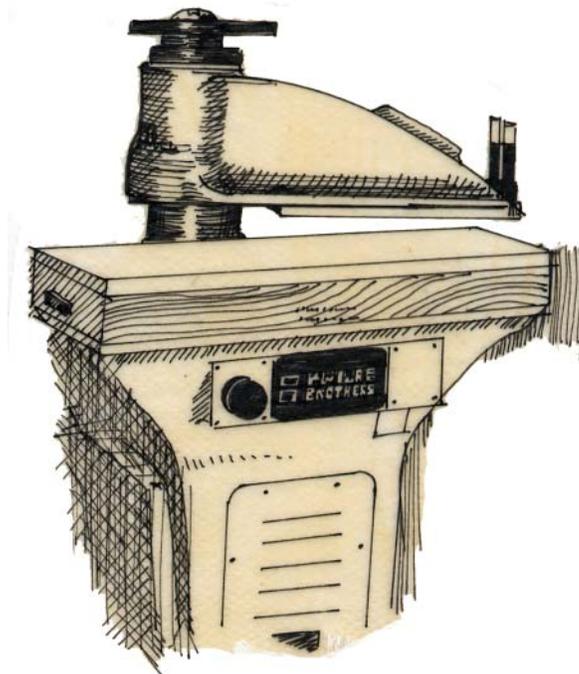


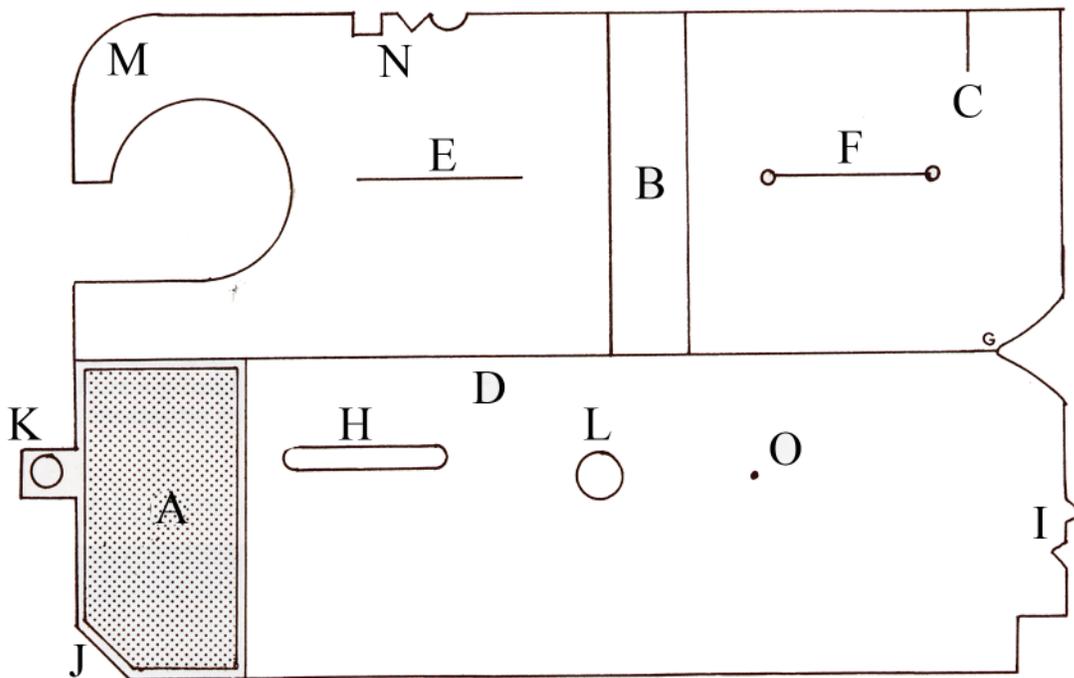
BASIC INFORMATION

The following information is required to order the right die for your particular cutting application:

- A. PATTERN** - An accurately detailed pattern, blueprint or sample piece to be cut.
- B. TYPE** - The type and height of die, for example 3/4" by 1/8" Beverly die.
- D. MATERIAL**- The type of material and number of layers to be cut. A sample is very helpful.
- D. CUTTING PRESS** - The type of cutting press and cutting pad for this application.
- E. IDENTIFICATION** - The stamped marking necessary for this die such as size, style, model, part number, date, etc.

The cutting die, cutting surface and cutting press as a system should be considered for an efficient cutting room operation.





THE FOLLOWING IS A GLOSSARY OF TERMS EXPLAINING THE FEATURES AVAILABLE IN CUTTING DIES. AND SHOULD BE CONSIDERED IF NEEDED.

- A. BACKPLATE** - Certain dies may be fitted with backplate and loaded with ejection rubber to facilitate easy ejection of material. This method also solved over and under cutting.
- B. BRACES** - Braces are added to strengthen the die. Unless specific brace locations are indicated we will brace your die for optimal strength.
- C. CHISEL** - Places a slice effect into the piece being cut
- D. COMMON CHISEL** - Used to separate two cut parts in a die.
- E. FLOATING CHISEL** - A slash mark in the interior of a die.
- F. CHISEL WITH TUBES** - A slash with a tube on one or both ends to strengthen the cut.
- G. CHISEL Y FEATURE** - Used to join two cavities of a die, also enables easier removal of die cut pieces.
- CUT OFF CHISELS** - This option is used in the outside area of the die to reduce cutting pressure and to allow easier removal of rigid material such as plywood or plastics.
- H. CUTOUTS, SLOT OR TUBES** - Both permanent and removable cut-outs can be added to your cutting die. A removable coutout can be interchangeable with a number of dies.

I. LOCATION NOTCHES - These location notches or slashes can be placed at desired intervals to aid the stitcher for proper alignment or folding of component parts.

J. MITERED CORNER - A 45 degree corner.

K. MOUNTING LUGS - Welded on the inside or outside of die. These lugs make it easier to mount a die on a press for long runs.

L. CUTOUTS, SLOT OR TUBES - Both permanent and removable cut-outs can be added to your cutting die. A removable cutout can be interchangeable with a number of dies.

M. ROUND CORNER - It is important to indicate your desired radius on rounded corners.

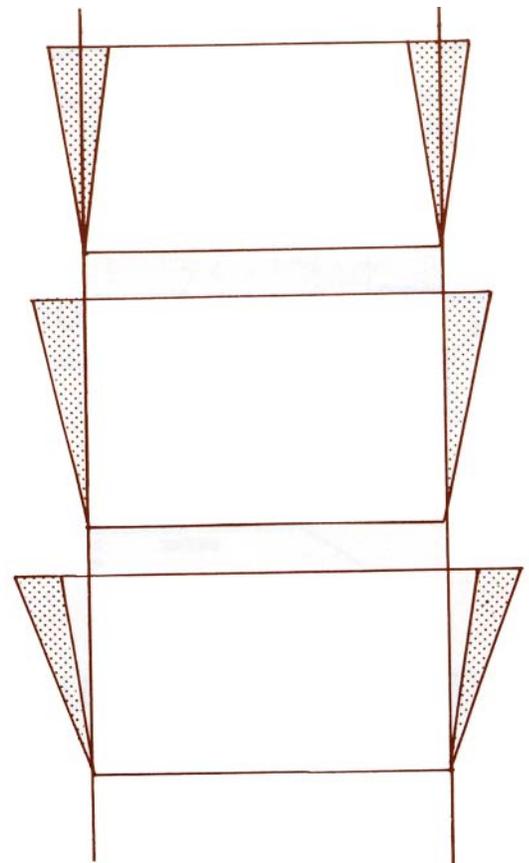
N. SIZE NICKS - Also known as size notches, used to identify different sizes of die cut parts.

O. STABS- This sharp point may be added to show sewing or fitting reference locations.

PINKING- To eliminate fraying a section of cutting die may have pinked edges added.

CLICKER DIE WALL CONSTRUCTION

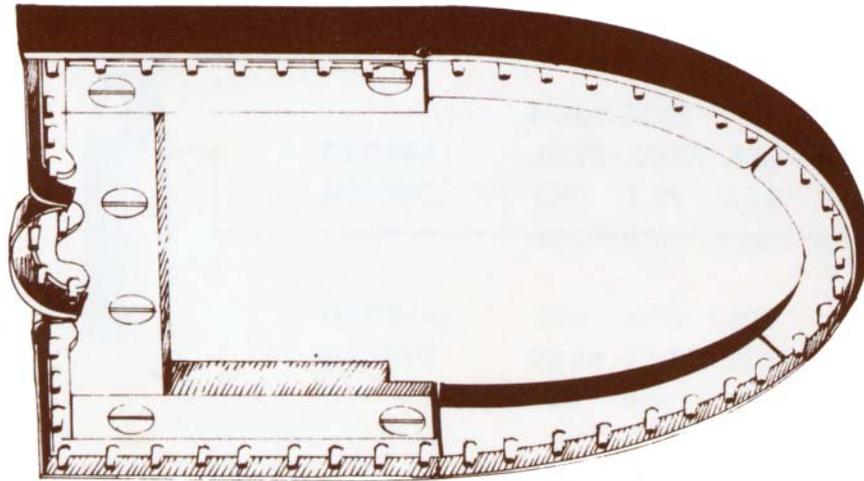
There are three basic wall types in clicker die construction. The most common is the regular wall die used for fabrics and soft materials. A straight wall die is used with rigid materials. A clearance all die is used for ease in ejection of material.



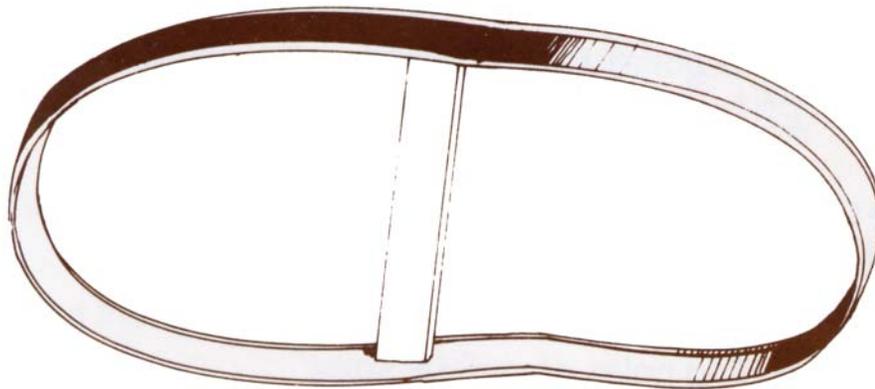
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BASIC TYPES OF CUTTING DIES



SINGLE EDGE DIE



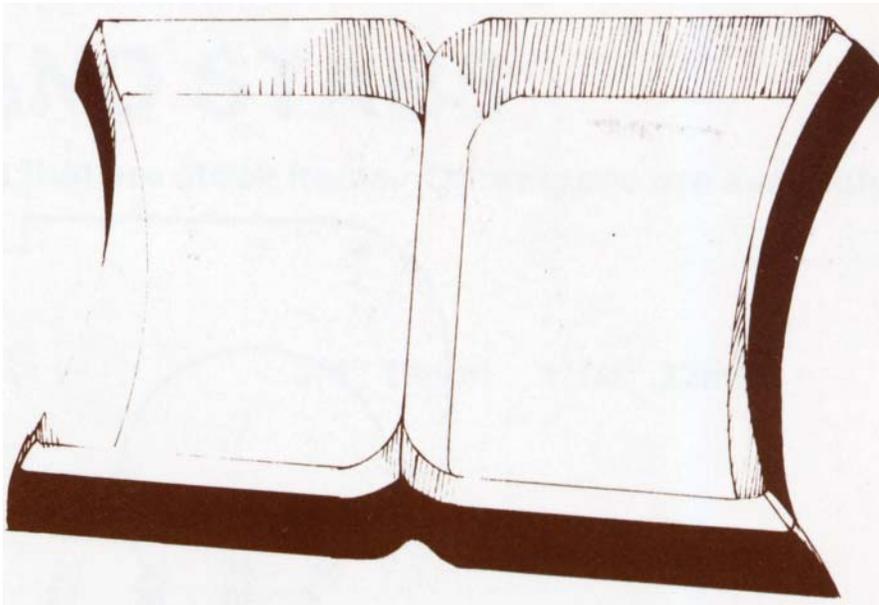
DOUBLE EDGE DIE

SINGLE OR DOUBLE EDGE DIES

In applications with an identical right and left piece a double edge die may be used to greatly reduce die cost. Such applications would be the shoe and glove trades.

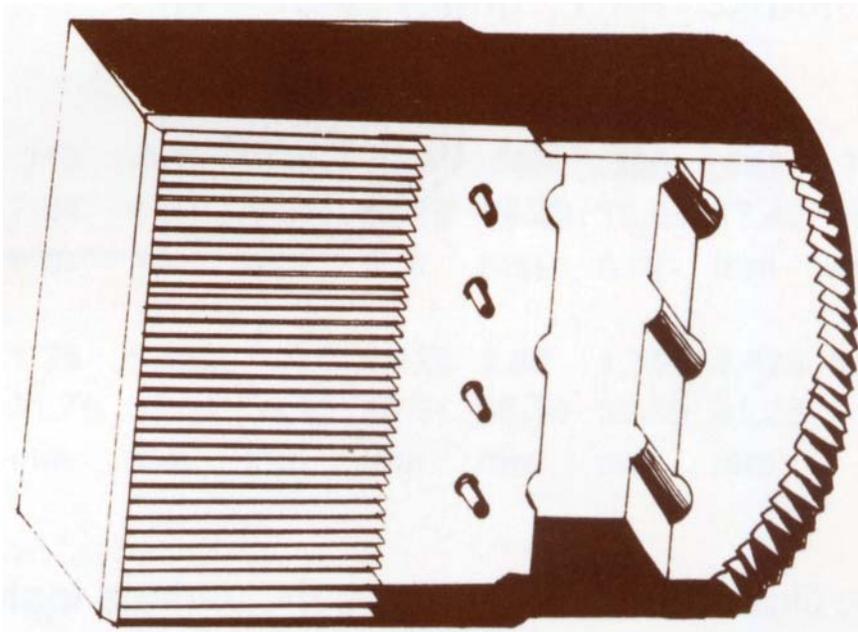
SERRATED EDGE DIES

New technology in cutting dies features a serrated edge that allows the die to penetrate multiple layers of materials much easier than conventional edged cutting dies. These special edged dies also help eliminate fusing with many materials.



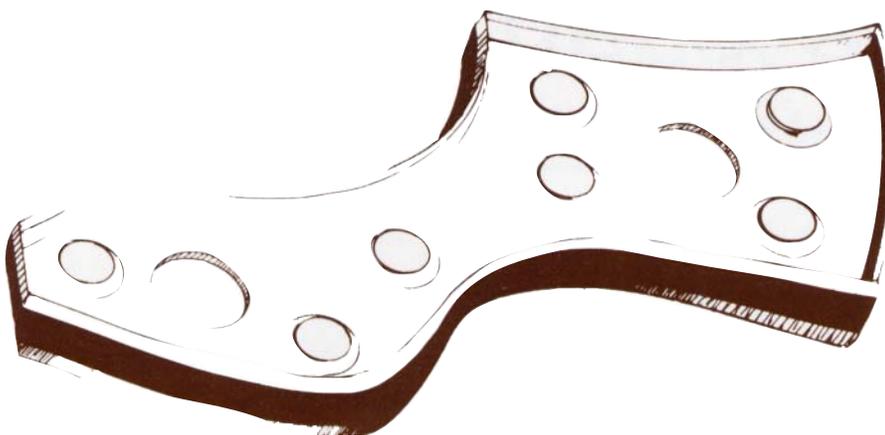
GANG DIES

Gang dies are primarily standard clicker dies in multiple configurations for high volume or multiple part situations.



PRECISION MILLED DIES

This is an extremely accurate die milled from high grade tool steel. The solid steel milled die is best used in very close tolerance high production situations.

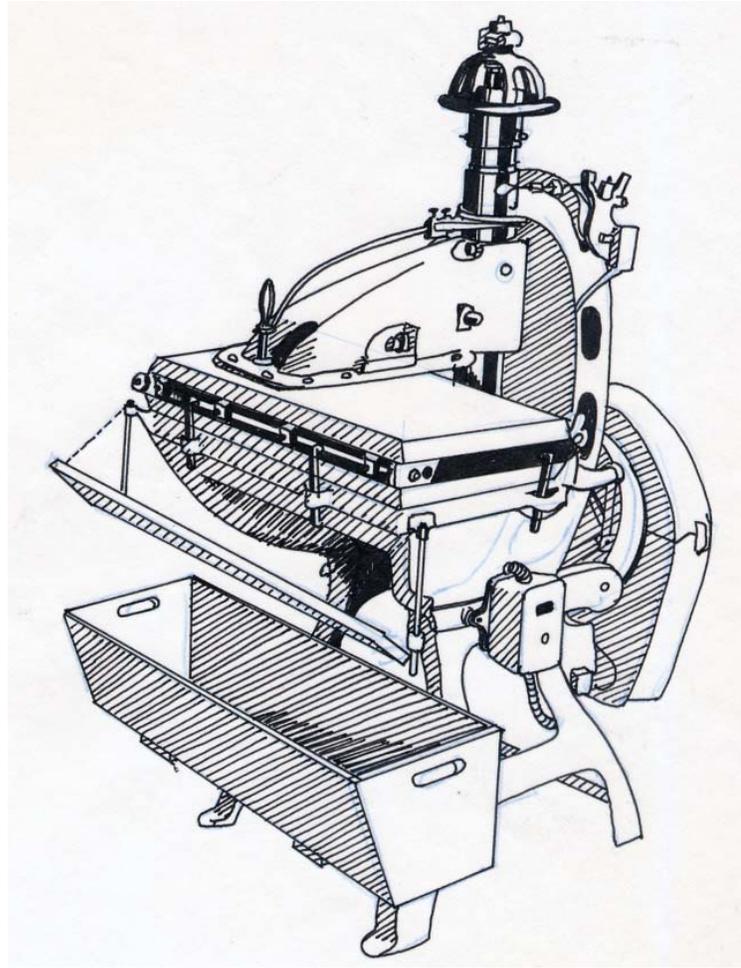


BEVERLY CLICKER DIES

The Beverly die is used primarily in the Shoe and Leather Garment industries. It is simply a clicker die constructed around a center plate, which acts as a brace like reinforcement, creating a very strong and durable die.

CARE AND MAINTENANCE OF YOUR DIES

Basic common sense procedures will mean longer cutting life for your dies.



1. Always spread cutting over the entire surface of the cutting pad. Cutting in one spot will result in an uneven pad and possible die breakage.
2. Always use a die that is smaller than the beam of the clinker press. A die too large for the beam will bow like a banana.
3. Always remove stuck dies with a rawhide mallet, not a steel hammer.
4. Always top the beam before tripping the press as a glancing blow will cause die breakage.
5. Always use just enough cutting pressure to cut through your material.
6. Always keep cutting pad level. Planing or dressing a cutting pad should be a routine procedure.
7. Always store dies properly.

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