

Technical Bulletin

Bulletin No	10	2013-01	Issued: 03/15/13	Revised: 03/18/13	Page 1 of 2
Equipment	1 Gallon Bail-O-Matic				
Topic	Improved Loop Forming Dies & Pivot Pins for .098" or 2.5mm Wire				

Issue

Older style Loop Forming Dies used Pivot Screws that were prone to the thread of the screw bending or snapping off, if the machine parts and settings were not well maintained, resulting in wire jams. Sometimes the snapped off screw threads could not be removed from the curling die, and the die would have to be replaced. These breakages greatly reduced the life of the dies, and damaged other parts as well.

A direct-fit replacement Loop Forming Die using a Pivot Pin is available.

It has been such a resounding success, that it has made die pivot screws obsolete, and broken die pivot screws a thing of the past.

The newer style can be used in any Bail-O-Matic machine that used the older style.

Recommendation

Order Newer Style Curling Dies & Die Pivot Pins

100243-01	Wire Loop Forming Die RH	(Replaces #100243 that used #00553 pivot screw.)
100244-01	Wire Loop Forming Die LH	(Replaces #100244 that used #00553 pivot screw.)
100973	Pin Die Pivot	(Replaces # 00553 Screw Die Pivot.)



Newer Design

Obsolete

100243-01	Die - LH
100244-01	Die - RH
100973	Pivot Pin

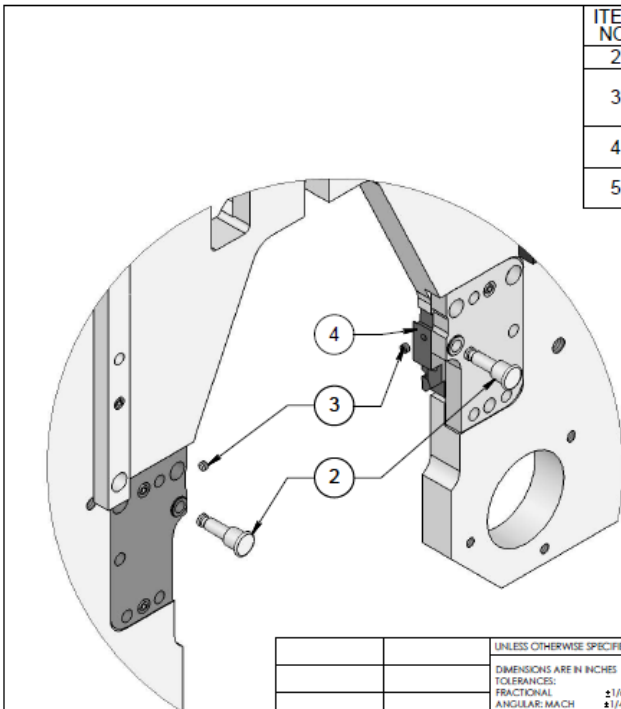
100243	Die - LH
100244	Die - RH
00553	Pivot Screw

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Note: Both designs can be used in mainplates with or without replaceable die pivot pockets.

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
2	100973	PIN	2
3	SSFLATSKT 0.164-32x0.125-HX-C	8-32x1/8" SOCKET SET SCREW FLAT POINT	2
4	100243-01	WIRE LOOP FORMING DIE LH	1
5	100244-01 (NOT SHOWN)	WIRE LOOP FORMING DIE RH	1



PIVOT PIN CAN BE USED IN MAINPLATES WITHOUT REPLACEABLE DIE PIVOT POCKETS.

ZONE	REV.	DESCRIPTION	DATE	BY
REVISIONS				
UNLESS OTHERWISE SPECIFIED:				
DIMENSIONS ARE IN INCHES				
TOLERANCES:				
FRACTIONAL ±1/64				
ANGULAR: MACH ±1/4°				
TWO PLACE DECIMAL ±0.01				
THREE PLACE DECIMAL ±0.005				
INTERPRET GEOMETRIC TOLERANCING PER:				
MATERIAL:				
FINISH:				
NEXT ASSY USED ON:				
APPLICATION DO NOT SCALE DRAWING				

HEISLER INDUSTRIES, INC.	
<small>224 PASSAIC AVENUE FAIRFIELD NJ 07004-3581</small>	
<small>TEL: (973)227-4300 FAX: (973)227-7627</small>	
TITLE: DIE & PIN ASSEMBLY .098 WIRE	
SIZE	DWG. NO.
A	Die Pins AUS
SCALE: 1:4	WEIGHT:
REV	
SHEET 1 OF 1	

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