



TO: ALL GLASS MASTER CUSTOMERS

RE: NEW TOOLING METHOD

Many years ago, Glass Master discovered the widely recognized "Standard Method" of tooling does not provide the most logical way to groove fiberglass ductboard. We now offer another method called the "**Preferred Method**" which eliminated many problems and makes better sense. Please take a few moments to read the following discussion about the two tooling methods. Glass Master highly recommends changing to Preferred Tooling in order to achieve better productivity and to save material.

1. The FLAP BLADE (#5 in the Standard Setup of #8/A in the Preferred Setup) must ride ON the cutting roller. In fact, it should be slightly spring-loaded against the roller to insure a clean flap for proper stapling. **MORE LABOR IS WASTED BY NEEDLESSLY HAND-CLEANING STAPLE FLAPS THAN ANY OTHER SINGLE FACET OF FIBERGLASS DUCT FABRICATION.** In the Standard Tool Setup the #5 blade is constantly moving as size changes are made. Worse yet, it is located toward the mid-section of the machine where any roller deflection caused by the compression of the ductboard (or any imperfection in the straightness of either the tool bar OR the roller) will make it impossible to guarantee that the FLAP BLADE properly seats against the roller. In the preferred Tooling Setup, however, the #8/A tool is ALWAYS stationary against the left-hand side bearings. **ONCE SET UP, IT NEVER MOVERS, GUARANTEEING A CLEAN FLAP EVERY TIME!**
2. The CUTOFF blade (SCO) and the FLAP blade (#5 or #8/A) will dull faster than any other blades on the machine, causing "board drag" if left in this condition. Additionally the FLAP blades will inherently have the most drag due to the tremendous blade surface area. In the Standard Tool Setup, both the SCO and the #5 blades are located side-by-side so that the highest concentration of friction is in one small area. In the Preferred Tooling Setup, the #8/A and the **SCO BLADES ARE SEPARATED BY THE DUCT "STRETCH-OUT" DIMENSION, MORE EVENLY DISTRIBUTING AND THE LOAD!** Preferred tooling also prevents tearing the foil facing when drop-off is very short, saving many sections of duct. In preferred tooling the glass is attached to the foil at the cut-off point. In standard tooling the #5 tool cleans all the glass from the foil, leaving only the bare foil to go through the cut-off blade. The facing can easily be torn, especially when drop-off is short. Preferred tooling **COMPLETELY ELIMINATED THIS PROBLEM.**

OVER

3. When a Closure Machine such as a Glass Master CM-48, CM-64 or DC-36 is used to close the duct, you must feed the FEMALE SHIPLAP end of the duct section into the machine FIRST because the loose MALE FLAP can cause problems with initial tape tack. **THE ONLY WAY TO ACCOMPLISH THIS IS TO USE THE PREFERRED TOOLING SETUP SO THAT THE STAPLE FLAP IS PROPERLY LOCATED!**

The only difference in the operation of the Preferred Method is that the first measurement made is that of the inside duct HEIGHT dimension rather than the WIDTH as with the Standard Method. In other words, the order of measurement is:

HEIGHT X WIDTH X HEIGHT X WIDTH

This conversion has always been one of the easiest ways to save labor and material. To convert from Standard to Preferred tooling some additional tools may be needed, **but the cost is quickly absorbed in labor and material savings.** Standard Tooling arranges the tools in numeric order: #1 through #5, followed by the Cutoff. In Preferred Tooling Setup an extra Right Hand Shiplap Tool is needed and the tools must be arranged in the following order:

<u>A</u>	<u>B</u>	<u>C</u>	<u>D</u>	<u>E</u>
#8	#3	#2	#3	#R1 CUTOFF (SCO)

We hope that this will explain why you should consider converting to the “**Preferred Tooling**” method of grooving as soon as possible. If we can help, please do not hesitate to call Glass Master.