

Script

	Time	Video	Audio
1.	00:00	<p>360 view of machine</p> <p>Shot of slug pulling</p> <p>Shot of slug on die mold</p> <p>Worker sorting through parts; Shot of box w parts, CG: "REJECTED"</p> <p>Cut back to shot of SK Machine in action</p> <p>Shot of press running</p>	<p>Congratulations on your recent purchase of DTC Products' Slug Keeper Machine!</p> <p>In the stamping environment, one of the biggest problems is slugs pulling during the production process. This small – but significant – problem can cause damage to both parts and the die. Slugs can also cause additional costs by the rejection of stamped parts and the painstaking process of sorting parts by hand.</p> <p>This machine will help to eliminate the problem of slugs pulling during stamping operations by putting precise grooves into die openings, keeping slugs in the die opening where they belong. This allows you to keep your presses running, making you <i>MONEY</i>.</p>
⌘ ☞		<p>Shot of Jeff taking case to work area; in press; on the grinder</p>	<p>The portable Slug Retention Machine can be used anywhere you need it! Whether in a stamping press, in the tool room, or on a surface grinder, the Slug Keeper is easy to set up and gets the job done quickly and accurately!</p>
⌘⌘ ☞		<p>CUs of each part mentioned</p> <p>CG: Installing and uninstalling the grinding bit</p>	<p>Step one is to select the proper slug retention grinding bit. Your new Slug Keeper Machine comes with 3 borzon wheels for all steels and 3 diamond wheels for carbide material. Grinding bits are thirty-five thousandths, sixty-two thousandths, and ninety-three thousandths diameter. Special wrenches, which are attached to the top of the Slug Keeper for easy retrieval, are used for installing the grinding bits.</p> <p>Depending on the material thickness you are stamping, choose the bit that is right. Then, to install the bit, loosen the screw knob and remove the two wrenches. Put the wrenches on the flats and loosen the screw.</p> <p>This will allow the current bit to slide out, and a new one put in. Again, put the wrench on the flat, snug it with your fingers, and then tighten it with the wrench, locking it in position. Then take the two wrenches, and place them back in the wrench holder</p>

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		<p>position, screwing the knob back on. As you have seen, installing or replacing the grinding bit is simple and quick.</p> <p>Use the handy position-able LED light that comes with your Slug Keeper, as well as two attached lights, to illuminate your grinding surface precisely.</p>
2.	<p>CG: Adjusting the air-grinder height:</p> <p>CU of screw being loosened</p> <p>Shot of air-grinder moving up and down</p> <p>Shot of SK on die block</p> <p>Shot of SK on surface</p> <p>Shot of Side stop</p> <p>Back to CU of screws, hand tightening them</p>	<p>The second step in preparing to use the Slug Keeper machine is adjusting the air-grinder height. Using the same wrenches used for the installation of the grinding bits (or just your fingers) to loosen the front knob. This will allow the air grinder to slide up or down so you can get the grinding wheel positioned close to the work pieces. Then, lock the grinder in place by using one of the wrenches to be sure the air grinder does not slide up or down during the grinding operation.</p> <p>Now you can fine-tune the stop position by using the side stop. Loosen the 2 screws and push the spring-loaded plugger head down until the wheel is into the opening at the desired depth. We recommend you go the full depth allowed on DTC Products' grinding bit, approximately three-sixteenths of an inch deep.</p> <p>Now, slide the stop against the plugger and hand-tighten the screws. Check the stop position by pushing the plugger unit up and down, verifying the grind depth looks correct.</p>
3.	<p>Using the SK in the press, putting it on press – using it – taking it off & starting production back up</p> <p>Shot of cutting strip and</p> <p>Removal of strip</p>	<p>Keeping your press running all day – without slugs pulling and stopping valuable production time – is essential for a profitable business. Your new Slug Keeper Machine is small enough to be used inside a press, saving you the time of pulling the die out of the press and taking it to the tool room when slug problems arise. Simply begin by cutting</p>


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		the strip and removing the strip from the tool.
4.	<p>Shot of slug keeper on die Shot of positioning the grinder</p> <p>Adjust top of machine back and forth; Graphic: Zero to 5 degrees movement</p> <p>Check grinding wheel position</p> <p>Turn magnet on</p> <p>Plug in air hose</p> <p>Turn on grinder [get some nat sound]</p> <p>CU of grinder making groove in die</p> <p>Turn on micrometer, set to zero</p> <p>Adjust the grinder, up and down</p> <p>Graphic: about 3% to 5% of Material thickness</p>	<p>Place the slug keeper machine into the die, on a flat surface, positioning it perpendicular to the edge you want to grind.</p> <p>Adjust the grinder to the position you want before you grind.</p> <p>Move it close, so that the grinding bit is near the edge. Turn the magnet on to hold it in position. Verify that the grinding wheel will go deep enough, approximately a 3/16 of an inch below the top of your die surface. At that point, plug in your air hose and turn on your air grinder.</p> <p>Using the micrometer adjustment, move the grinding wheel close to the edge of the die block. At the same time, move it up and down until you see a slight groove on the edge of the block.</p> <p>Turn on the micrometer and set it to zero by holding the on /off /zero set button in for about 30 seconds – you will see the numbers change to all zeros. BE SURE THE MICROMETER LOCK IS SNUG or the micrometer can vibrate, causing it to move on its own. Now, you want to adjust the wheel into the edge of the die opening a few tenths at a time, while pushing the plunger unit down and allowing it to come up, causing the grinding bit to go up and down – grinding</p>

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			a precision retention groove into the die edge. The recommended depth is shown in the operation manual. The deeper you can go without causing a burr on the final stamped part, the better.
5.		<p>Shot of row of surface grinders</p> <p>Shot of SK Machine on surface grinder, long shot; CU shot</p> <p>Place bushing on magnet</p>	The Slug Keeper Machine can be used on any standard surface grinder. Place the Machine and the die insert or bushing on the magnet; the surface grinder magnet will hold the insert or bushing in place while the Slug Keeper Machine is putting the slug retention groove into the opening.
6.		<p>Show SK Machine in action on surface grinder wide</p> <p>Shot of bushing on magnet</p> <p>CU of groove in bushing</p>	With the slug keeper machine magnet on, we now place the die insert or bushing in position under the grinding wheel. Position it close to the edge that you would like to grind. Turn on the surface grinder magnet and move the grinding wheel, using the micrometer to closely position where you want to grind. At this time, turn on the grinding wheel, and begin to move it up and down until you see a slight groove on the die opening edge. Once that is accomplished, reset the micrometer to zero, and – adjusting a few tenths at a time – come up and down until you get the groove the desired depth shown on the micrometer readout.
7.		<p>Shot on Tool bench</p> <p>Close lid of case...?</p>	Because the Slug Retention Machine is lightweight and portable, you can use it anywhere in your shop, anytime! Return your Machine to the handy carrying case that holds and protects your Machine when it's

Company: DTC Products
 Project: **User Manual/Slug Keeper**

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			not in use.
8.		Hand holding damaged part Beauty shot of SK Machine	Slugs are small – but can cost your company big money. Use your Slug Keeper Machine to make sure your dies and stamped parts are free of this nuisance, every time!
✕ 		Logo, website, phone number	Contact DTC Products at 630-513-3323 if you have any questions or need additional information.