



DIE CHART

TO BE COMPLETED & SENT WITH DIE ORDER

CUSTOMER
ADDRESS

Customer Authorisation
Customers Order Reference

Position
Account No.

Optional Safety Frame / False Table Supplied at Cost. If Not Required Please Sign Here :-

Die Equipment For Which Machine?

PRODUCT PROFILE	DETAILS	all measurements in millimetres	
		BLOCKING DIE	LIDDING DIE
<p>OPEN</p> <p>LIDDED WITH DOME</p> <p>LIDDED WITH INTERNAL PIE CRIMP AND DOME</p>	Foil No.		
	TIN or HOOP No.		
	CRIMP STYLE		
	DIE TO CUT OFF <small>(state YES or NO)</small>		
	CUT OFF DIAMETER 'A'		
	CRIMP WIDTH		
	CRIMP HEIGHT 'C'		
	PASTE THICKNESS 'D' <small>with 1 thick platform washer = 1.1/2mm</small>		
	DOMES HEIGHT 'E'		
	DEPTH OF CRIMP 'F' <small>(when below edge of tin)</small>		
	NUMBER OF DOCKING PINS		
	NUMBER OR AIR VENT PINS		
PLATFORM PROFILE		PLATFORMS	
<p>Dimensions 'P' and 'T' are necessary only where a moulding or lidding die is ordered for use with existing platforms or additional platforms are required.</p>			

BASIC CRIMP STYLES



Custard



Pie



Plain



Rope



Raw Edge



Marguerite

NOTES FOR GUIDANCE WHEN COMPLETING DIE CHARTS

THE PURPOSE OF THE DIE CHART IS TO TELL US HOW YOU WANT THE UNCOOKED PASTRY TO LOOK WHEN IT IS BLOCKED OUT IN YOUR CHOSEN CONTAINER. ALL PASTRY-MOULDING DIES ARE MADE SPECIALLY TO ORDER, AND ONCE MADE CANNOT BE CHANGED. - SO IT IS IMPORTANT YOU TELL US EXACTLY WHAT YOU WANT!

1. CHECK THAT YOUR NAME AND ADDRESS ETC. IS CORRECTLY GIVEN IN THE TOP LEFT-HAND BOX.
2. STATE THE MACHINE TYPE, EITHER 'HANDAMATIC', OMATIC MINOR, OMATIC STANDARD, OR LINAMATIC. (FOR THE OMATIC STANDARD, STATE THE NUMBER OF STATIONS ON THE TABLE).
3. ENTER THE REFERENCE NUMBER FOR THE CHOSEN FOIL OR TIN.
Note - on each die chart there is space for you to specify up to 3 blocking dies and up to 3 lidding dies.
4. **CRIMP STYLE.** For the BLOCKING DIE and the LIDDING DIE (if you want one) you may chose different styles of crimp, but please bear in mind that if your chosen container is RAW EDGE type, i.e. it has no horizontal rim around the top edge, then no crimp style is possible, we simply cut the pastry off level with the top edge.
5. **DIE TO CUT OFF?** If you plan to make LIDDED pies only, then it is best if you have no cut-off on the blocking die, so that you obtain an overhang of paste which will give maximum surface contact with the lids. But if you plan to use the blocking die to make open tarts, then please state the crimp style you would like for the blocking die, and the crimp for the lidding die (which may be a different crimp style if you wish).
6. **CUT-OFF DIAMETER.** (see 'A' on Product Profile drawing shown on the left).
If you answered 'NO' to question 5, enter 'NIL'.
If you answered 'YES' to question 5, enter the diameter you prefer to see for your finished product, but please note that the diameter cannot be less than the top inside diameter of your container, and it cannot be more than the top outside diameter of your container minus 4 mm, because we need at least 2 mm of clear rim all round on which to locate the die pins which will hold your container down in the platforms.
7. **CRIMP WIDTH** (See 'B' on the Product Profile drawing shown on the left).
Normally you can leave this blank, and we will fill it in, because it is determined logically by reference to your chosen cut-off diameter 'A'. and your chosen paste thickness 'B'.
8. **CRIMP HEIGHT.** (See 'C' oil the Product Profile drawing shown on the left).
Your preference for height of crimp is needed only if you have chosen PLAIN style of crimp. For all other styles, we will take the crimp to what we consider looks best on the product, although if you do have any definite preference, you should of course state it.
9. **PASTE THICKNESS.** (See 'D' on the Product Profile drawing shown on the left).
We shall make the side walls to be the same thickness as you indicate for the base, unless you wish to have a different thickness on the walls, in which case you must say so.
The thickness you indicate must be measured from your UNBAKED paste.
We shall make the die so that the thickness you indicate will be achieved when you place under the platform the thicker of the two fibre platform washers which you will automatically receive with each platform. In this way, by adding or subtracting these washers, you will be able to vary the thickness of your paste
(See separate memorandum about possible paste thickness variation).
Paste thickness does not apply to the lids - you control this when you make the pastry for your lids on a separate machine, except for the crimp (see paragraphs '7' and '8' above).
NOTE - if your containers have a wavy (crinkled) side wall, then you must please indicate thickness of paste you wish to see at its thinnest point.

- if your containers side walls are at 90-degrees angle to the base, then it will be necessary for us to taper the side walls, thicker at the bottom, thinner at the top, to ensure the smooth withdrawal of the die plunger. In this event, please ask us for advice.

10. **DOME HEIGHT.** (see 'B' on the Product Profile drawing, shown on the left).
This will normally be 10 mm, unless you want it otherwise in which case you must please say so.
11. **DEPTH OF CRIMP.** (See 'F' on the Product Profile drawing shown on the left).
This normally applies only to meat pies with a 'Pie' style of crisp.
12. **DOCKING PINS.** Only recommended when producing empty shells. Paste thickness must not be reduced.
Charged as an extra.
13. **AIR VENT PINS.** For making a hole in the pastry lid to allow steam to escape during baking.
Charged as an extra.
14. **NUMBER OF PLATFORMS.** We need your confirmation as to the number of platforms you wish to order, because sometimes one or more new platforms may be required for use with in old die, or a replacement die is ordered to suit platforms which are already in existence, in which case we must have at least one platform on loan from you, or make one and charge you, to enable us to test the new die.
15. **TRIGGER PLATFORMS.** Required to enable the operator to lift the product out of the platform in rare cases where the die has been made to cut off the pastry over the extreme edge of the container.
Charged as an extra.
16. **SPRING-LOADED PLATFORMS.** Only necessary where the container is a 'raw edge' type and in made of aluminium foil or waxed cardboard or very thin metal. Charged an extra.
17. **PLATFORM HEIGHT.** (See note under 'Platform Profile' shown on the left). In such case, you must state exact height of 'P' (foil in platform) or 'T' (tin in platforms) in mm.

PLEASE ANSWER 'YES' OR 'NO' TO THE NEXT QUESTIONS ON THE DIE CHART, AND IF YOU ARE INTENDING TO ORDER AN EXACT REPLICA OF A DIE YOU ALREADY HAVE, THE ONLY WAY WE CAN GUARANTEE TO DO THIS IS IF YOU PROVIDE US WITH A SAMPLE MOULDING TAKEN FROM THE EXISTING DIE IN DENTAL WAX OR A SIMILAR MATERIAL WHICH DOES NOT SHRINK OR BREAK.

THE FALSE TABLE COVER IS NORMALLY REQUIRED ONLY IN THE U.K.. WHERE THE FACTORY INSPECTORS INSIST THAT THE SPACE BETWEEN THE PLATFORMS IS FILLED IN ON THE TABLE OF THE O'MATIC MINOR AND O'MATIC STANDARD MACHINES.

FINALLY, PLEASE ANSWER 'YES' OR 'NO' TO THE QUESTIONS ABOUT THE TYPE OF HEATING ARRANGEMENTS FOR THE DIE YOU ARE ORDERING.

SIGN AND DATE THE DIE CHART, AND SEND IT TO US WITH SAMPLES OF THE RELEVANT TINS AND/OR FOILS:

**IF TINS, SEND 3 SAMPLES OF EACH SIZE (unless you are ordering tins from us at the same time).
IF FOILS, SEND 10 SAMPLES OF EACH SIZE, CAREFULLY PACKED IN A VERY RIGID BOX SO AS TO ARRIVE IN PERFECT CONDITION, AS WE HAVE TO TAKE PRECISE MEASUREMENTS TO ENSURE THAT YOUR FINISHED DIE WILL WORK PERFECTLY AND TO YOUR COMPLETE SATISFACTION.**

THANK YOU FOR THE TIME YOU HAVE GIVEN TO THESE IMPORTANT MATTERS.