



## Fairly Common Reasons Glass Dies Break

- 1) Glass die ID is nominal or under but to spec, tubing is at high end of tolerance and expands – could break die.
- 2) Older tubing – could be stiffer and needs more pressure to form – could possibly break die.
- 3) Using a mandrel inside of the tubing that is tight fitting, after expansion from heat – could break die.
- 4) Heating or cooling the glass die too rapidly – could crack the die.
- 5) Hot Box/Tip Former could have too much insertion pressure – that could break the die.
- 6) Hot Box/Tip Former may be bending mandrel, which could break die. Mandrels need to be lined up perfectly and rod must be straight.
- 7) If die is over torqued in the clamp or holder, with insertion force – could break die.
- 8) New operators on a machine are notorious for breaking dies.