



Since 1931

New Method Steel Stamps, Inc

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Setup Instructions for OD Marking Tools in Automatic Screw Machines.

1. Index the part to be marked to the selected marking position.
2. Advance the Marking Tool slide to highest point of its cam. This should be as far forward as possible, using any standard cam with an advance of slide per revolution, not in excess of .005", but more than .0015".
3. Insert Marking Tool in slide and move it forward until starting cam or die contacts the part. Strap, or lock marking tool in this position.
4. Set up tripping mechanism to assure automatic tripping of the ratchet pawl after each marking cycle.
5. Start machine to mark part. IF MARKING APPEARS TO BE TOO LIGHT OR TOO DEEP, MAKE ADJUSTMENTS IN POWER PAK OF TOOL. See below.
6. After the part is marked, and when the tool slide is fully retracted, it may be adjusted forward .005" to .010" to assure marking of undersized parts.

NOTE

Should the tool fail to mark after adjustments are made as instructed above, the slide may be advanced but only at the maximum rate of .010" on each test cycle until marking appears on part. If marking does not appear after the slide has been advanced a distance of .030", repeat stops 3 through 6.

NOTE

Increase or decrease of marking depth can only be made with the CAM ADJUSTING SCREW in the Power Pak of the marking tool and NOT by adjusting the tool slide. Turn cam adjusting screw (either 1/4-20 x 2" or 10-32 x 1-1/2" depending on Model No.) in for lighter impression and back screw off for deeper impression. You may have to adjust slide travel in if you back off screw in order to make contact with part. Marking depth is controlled by where starting cam on die (tapered surface prior to first character) makes contact with part O.D.. By starting down on cam you get more rise, more pressure and deeper impression. And the reverse if starting close to first character.