



Since 1931

New Method Steel Stamps, Inc

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Setup Instructions for New Method Steel Stamps OD Roll Marking Attachments for use on CNC Turning Centers

New Method OD Roll Marking attachments for CNC Turning Center consist of 3 major components:

1. Shank
2. Power Pak
3. Roll Marking Die

The Shank is to be mounted into machine's turret as any OD turning tool would be. The Roll Marking Die should be closer to the chuck than the Power Pak (the return mechanism).

The machine should be programmed to operate the roll marking attachment as follows:

1. Program a rapid traverse move of Turret to position marking die to within approximately .020 to .050 of part diameter.
2. Program a feed rate of .005 to .010 IPR to a point .010 smaller than part diameter. Do not worry about creating a wreck situation between marking die and part. This move below part diameter surface is to create enough pressure to overcome the resistance of the roll return spring. Once this point of resistance is overcome, the roll die will rotate and mark part.
3. At this point of maximum "x" travel into part program a fraction of a second dwell. This is to insure that all characters on die have time to be rolled on to OD of part. 4. Next, program a rapid traverse back in "x" way from part OD. This will allow marking die to return to its resting position and thus be ready to roll next part.

CONTROLLING MARKING DEPTH

The depth of impression of the characters into the part is not a function of how far you feed the roll marking die into your part. Marking depth is controlled only by the adjusting screw (1/4-20 x 2" or 10.32 x 1/2 ") that acts as the stop pin against which the serrated cap returns to after marking pressure has been relieved. By turning the adjusting screw either in or out, you will change the position of the die and its starting cam relative to your part. The starting cam is the tapered surface approximately 1/2" long that precedes the characters on the die. Depending on where you make contact with your part on the starting cam will determine the depth of impression. The further away from the characters the deeper the impression and the reverse is true for starting closer to the characters.