



Since 1931

New Method Steel Stamps, Inc

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Setup Instructions for 900-A, 901-A, & 900-C End Face Marking Tools

The Following Instructions Should be Thoroughly Read and Understood Before Attempting to Setup the End Face Marking Tool.

1. Before installing the end face marking tool, the screw machine should be completely set up for the part.
2. Place mounting block for marking tool in main slide with machine stopped and main end slide at the high point of cam.
3. Place 900-A, 901-A, or 900-C tool in mounting block.
4. Advance tool and mounting block within .020 to .030 from part. IN THIS POSITION THE TOOL SHOULD NOT MARK UNDER ANY CIRCUMSTANCES.
5. Jog through cycle to be sure Item 4 is correct (NOT MARKING).
6. If true (NOT MARKING), advance 900-A, 901-A, or 900-C tool using CIRCULAR NUT (No. 1195 in 900-A and 901-A; No. 1112 in 900-C tool) a distance of approximately .040 - jog through cycle - tool should mark.
7. If marking is not deep enough turn DIE CAM ADJUSTING SCREW (No. 1215 in 900-A and 901-A; No. 1114 in 900-C) COUNTER CLOCKWISE.
8. If marking is too deep turn DIE CAM ADJUSTING SCREW; CLOCKWISE.
9. In both steps 7 and 8 - jog through cycle to be sure of correct marking depth.
10. If after step 7, the die does not mark, re-adjust the CIRCULAR NUT until marking appears and then repeat step 7.
11. **SPECIAL WARNING:** Marking depth can only be adjusted by using DIE CAM ADJUSTING SCREW in head of tool and must not under any circumstances be adjusted by circular knurled nut on shank of tool, or by adjusting main slide forward.

**After marking, rapid out as fast as possible.