



NEW METHOD STEEL STAMPS, INC.

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Model 909 End Face Marking Attachment Checklist and Setup

1. Check and see if sleeve that tool is being put into is indicated in.
2. Make sure bar is clamped tight in chuck so that it does not push back.
3. Come in on zero zero.
4. Feed fast to depth .008 (or desired depth).
5. Rapid in. Rapid out.
6. Suggested RPM 600-800.

* Tool is already greased. You do not need to add until after extensive use.

* When adding lubricant, use spindle oil.

* Angle of tool should be pointed down