

UniLock-Up® Micro Adjuster Adjustment Procedure

UniLock-Up is a patented die lock-up system. Engraved dies are pre-mounted to a specially designed steel plate in register to the press layout, making setup quick, easy and efficient.

If necessary, each engraved die has the capability to be slightly adjusted before final lock-up to ensure perfect registration. Follow these instructions:

Note: Wear appropriate PPE for heated applications.

1. Remove the nut from one of the die attachment locations. (Figure A)
2. Screw out the adjustment screws in the adjuster so they are flush with the inside diameter of the adjuster body and set aside.
3. Thread the adjuster post over the stud. (Figure B) Tighten until snug, then back off $\frac{1}{8}$ to $\frac{1}{4}$ turn to align one of the flats with the desired direction of movement.
4. Place the adjuster body over the adjuster post and align the flats on the post to the adjustment screws. The lower portion of the adjuster body should fit inside the counter bore on the engraved die.
5. Insert the thumbscrew through opening at the top of the post (Figure C) and tighten against the stud.
6. Tighten the adjustment screws until they are snug against the adjuster post.
7. Crack loose the other die attachment nuts.
Note: If you loosen them too much, the engraved die may move without the aid of the adjuster.
8. Loosen the adjuster screw on the side opposite the direction of movement. Each full turn of the microadjustment screw is 0.010" [0.25mm] of movement. So, if you need to move the die 0.005" [0.13mm], only loosen the screw by $\frac{1}{2}$ turn.
9. While holding down on the top of the adjuster body, tighten the adjustment screw on the side corresponding to the direction of movement until snug. (Figure C) **Note:** Tightening the adjustment screws pulls the die in the direction of movement.

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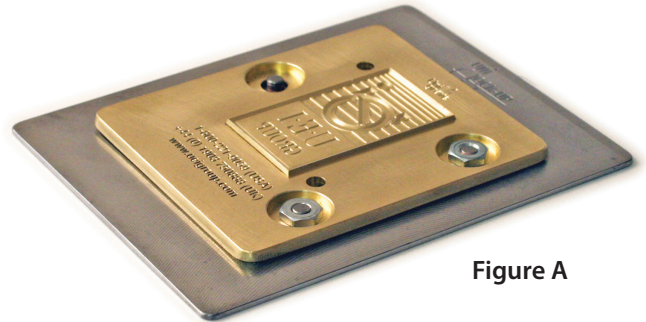


Figure A

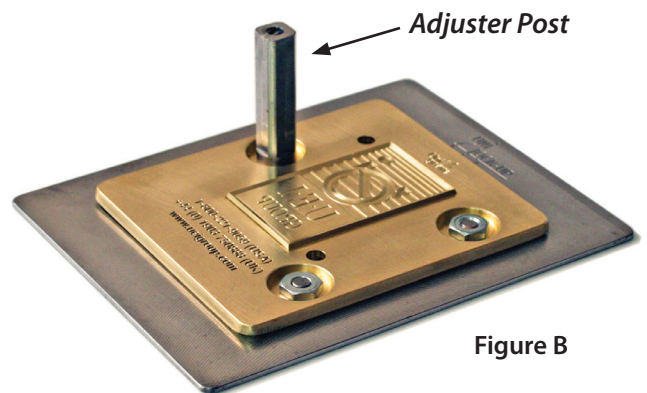


Figure B

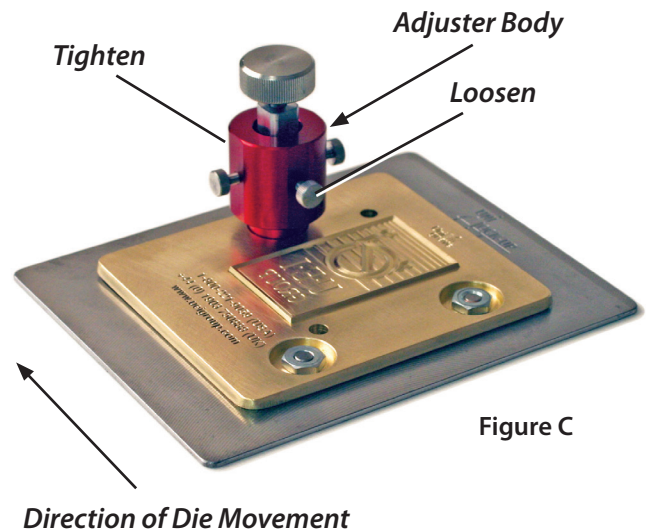


Figure C



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10. Tighten the engraved die attachment nuts with a torque wrench (*Figure D*) to 19 in-lbs.

11. Loosen and remove the thumbscrew in the adjuster post.

12. Loosen the adjuster screws and remove the adjuster body. (*Figure E*)

13. Unscrew the adjuster post.

14. Install the die attachment nut (*Figure F*) and torque down to 19 in-lbs.

15. Validate alignment.

16. Repeat steps 1–15 as necessary.

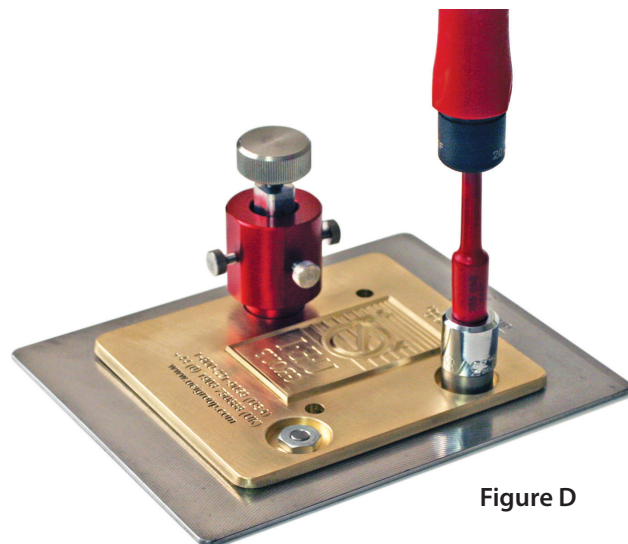


Figure D

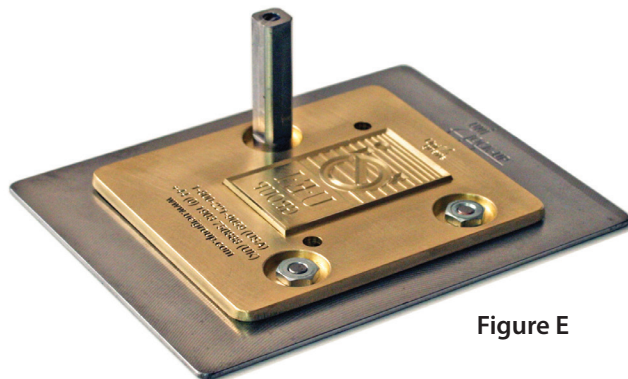


Figure E

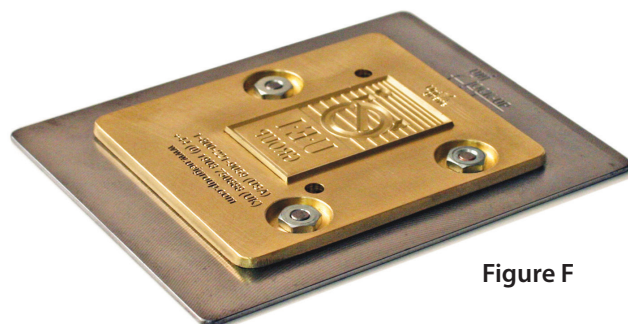


Figure F



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