

UniLock-Up® Micro Adjuster



UniLock-Up Die Adjustment Procedure

Note: Wear appropriate PPE for heated applications.

1. Remove the nut from one of the die attachment locations.
2. Thread the adjuster post over the stud (Fig. A). 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.
3. Insert a $\frac{5}{64}$ " allen wrench through opening at the top of the post (Fig. B) and tighten the set screw inside the post against the stud.
4. Screw out the adjustment screws in the adjuster body so they are flush with the inside diameter of the body.
5. 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 UniLock-Up die.
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 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 (Fig. C). **Note:** Tightening the adjustment screws pulls the die in the direction of movement.

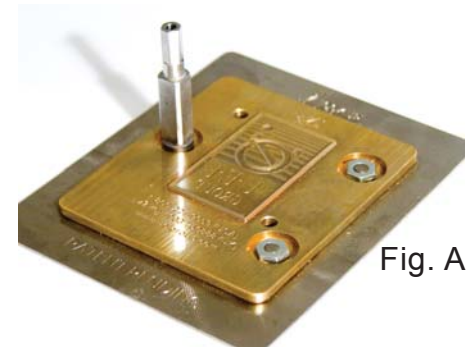


Fig. A

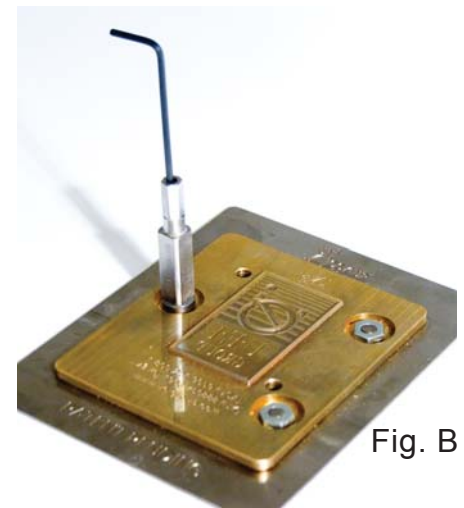


Fig. B

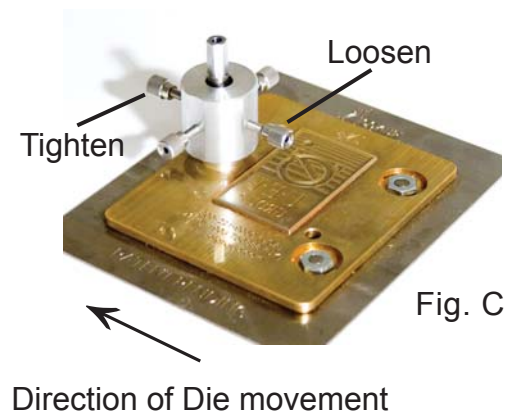


Fig. C

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10. Tighten the die attachment nuts with a torque wrench (Fig. C) to 19 in-lbs.
11. Loosen the adjuster screws and remove the adjuster body.
12. Using the $\frac{5}{64}$ " allen wrench (Fig. D), loosen the internal set screw in the adjuster post.
13. Unscrew the adjuster post.
14. Install the die attachment nut (Fig. E) and torque down to 19 in-lbs.
15. Validate alignment.
16. Repeat steps 1-15 as necessary.

