

UP-RIGHT TOOL INSTRUCTION MANUAL

Important:

The Up-Right Tool is designed **exclusively for use with Derraco Engineering Comparator and Headspace Gauge Sets**. It is **not compatible** with comparator tools from other brands.

Assembly

1. Assemble the tool exactly as shown in the reference photo on the right.
2. **Do not overtighten** the bushing adapter; the M2.5 probe thread is delicate and may be damaged if excessive force is applied.
3. The tool can be securely bolted onto the table if desired. Use the two countersunk holes provided for the screws.

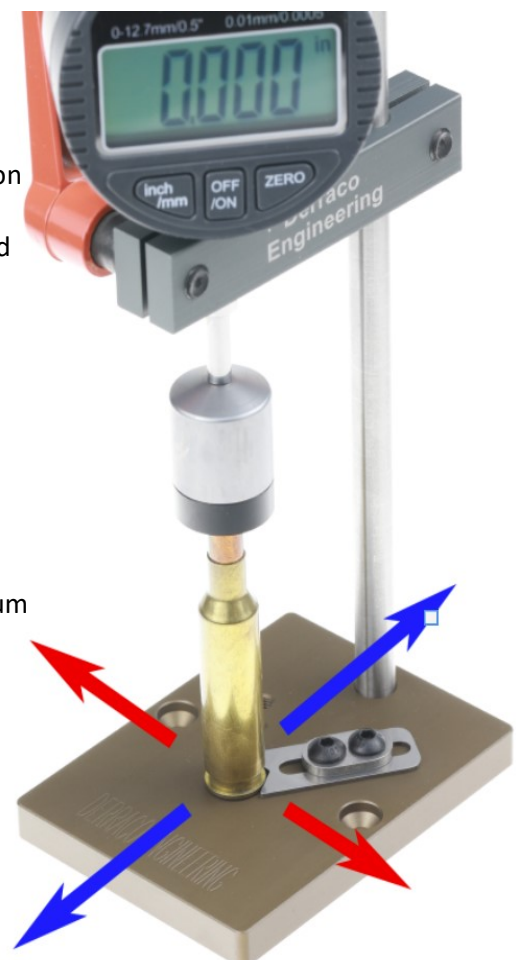
Setup

1. Loosen the two black bolts on the tool base plate.
2. If measuring **Rimmed cases** (e.g., .303 British or 7.62 Russian), place the **Rim-spacer UNDER the V-notch plate** to provide proper rim clearance.
3. If measuring **Rimless cases**, place the **Rim-spacer ABOVE the V-notch plate**.
4. Leave the two black bolts loose for now.
5. Screw the comparator measurement bushing or headspace gauge bushing onto the probe adapter.
6. Position and clamp the dial indicator so that its contact point is **around the middle of its total measurement travel range**.
7. Set the indicator arm so the measurement bushing sits at the **center of the position above the brass standing area**.
8. Lock the orange levers to secure the dial indicator.



9. Turn on the dial indicator.
10. Pull up the measurement bushing and insert the brass or ammunition into position.
11. Move the base of the brass or ammunition as shown by the blue and red arrows in the photo, keeping the brass base **firmly against** the base plate while moving.
12. Observe the dial indicator reading while moving. **Note the lowest reading.** Example: if the reading jumps from -0.65 mm to $+2.68\text{ mm}$, remember -0.65 mm .
13. Adjust the **V-notch plate** against the brass base when the indicator shows the **minimum reading you noted**.
14. Lock the **V-notch plate** with the two black bolts. The dial indicator should still show the **remembered minimum value**.
15. If not, repeat the adjustment process until the remembered minimum value is reached.
16. Zero the dial indicator.

The tool is now ready for use.



For users who wish to supply their own dial indicator, **double-check the specifications before installation:**

Probe thread = **M2.5**,

Dial indicator attaching **shank diameter = 8 mm**.

We have observed that the **.338 ELD projectile may be too long for this tool**. For proper operation with this projectile, an **ELD bushing adapter is available for purchase separately**.

Thank you for purchasing our Up-Right Tool. For questions, assistance, or spare parts, please contact us by email.

Email: derracoppc@gmail.com

Website: www.derraco.com.au

Cheng Fei

DERRACO ENGINEERING AUSTRALIA