

EXACTA

CODE KEY CUTTER OPERATING INSTRUCTIONS

YOUR CODE KEY CUTTER
IS A PRECISION
INSTRUMENT. PLEASE
TREAT IT AS SUCH...

- KEEP IT CLEAN
- DO NOT FORCE DEPTH KNOB,
SPACING LEVER OR CARRIAGE LEVER.
- READ INSTRUCTIONS BEFORE USING.

GENERAL INSTRUCTIONS

The Exacta Code Key Cutter is designed to give you many years of trouble free service with a minimum of care. The only danger to the machine is dirt. Keep your equipment clean. That is the only maintenance required. This may be done with a soft brush to make sure that the key insert slot, key insert and punch and die assembly in particular, are kept free of chips and dust.

The plastic chip box should be emptied occasionally. Lubrication should be unnecessary as all moving parts are treated with a permanent lubricant.

SETTING-UP INSTRUCTIONS

- Select proper depth knob P-10, spacing plate P-11, key insert P-12 and key blank from your code book.
- Assemble depth knob by sliding on shaft and over pin, keying it to shaft. Insert screw and tighten until knob is resting against shoulder.
- Install spacing plate by placing on dowel pin and swing into position where it will be held by detent.
- Slide key insert into slot of carriage from right or left side of carriage according to instruction in your code book.
- In order to cut some keys, punch and die assembly P-13 must be replaced. Select proper punch and die from code book. Remove lever P-20 by unfastening and removing hand lever screw P-23 and die screw P-24. Pull out punch and die assembly. Slide proper punch and die assembly in position, making sure that the frontal flat portion of the die is lined parallel to carriage. Tighten screw, P-24. Replace lever and lever screw, P-23.

OPERATING INSTRUCTIONS

- Place spacing lever P-15 into extreme left hole of spacing plate P-11.
- Set depth knob P-10 to extreme C.W. position.
- Insert key blank on carriage P-18 from same side the key insert P-12 was installed or according to code book instruction.
- Locate key blank with right hand shoulder guide or one of the following methods according to instructions in code book.
 - Left hand shoulder guide.
 - Tip of key against stop on insert.
 - Shoulder of key against insert.
- Lock key blank of carriage by tightening carriage lever. Be sure that blank is level and straight with insert P-12. **DO NOT overtighten lever or carriage could be hard to move.**
- **Return shoulder guide to rest position against side of carriage.**
- Set spacing lever P-15 in position 1 on spacing plate.
- Set depth knob to required depth.
- Press lever P-20 firmly, to complete cut.
- Return depth knob to extreme C.W. position before attempting to advance spacing lever to next position.
- Set spacing lever in subsequent positions and repeat procedure for all cuts.
- When all cuts have been made return spacing lever to the extreme left position of spacing plate.
- Loosen carriage lever and remove key.
- For keys cut on two sides, repeat procedure on second side.
- For keys inserted from right hand side only. When key is inserted from left side, spacing lever P-15 is moved to extreme right hole in spacing plate P-11.

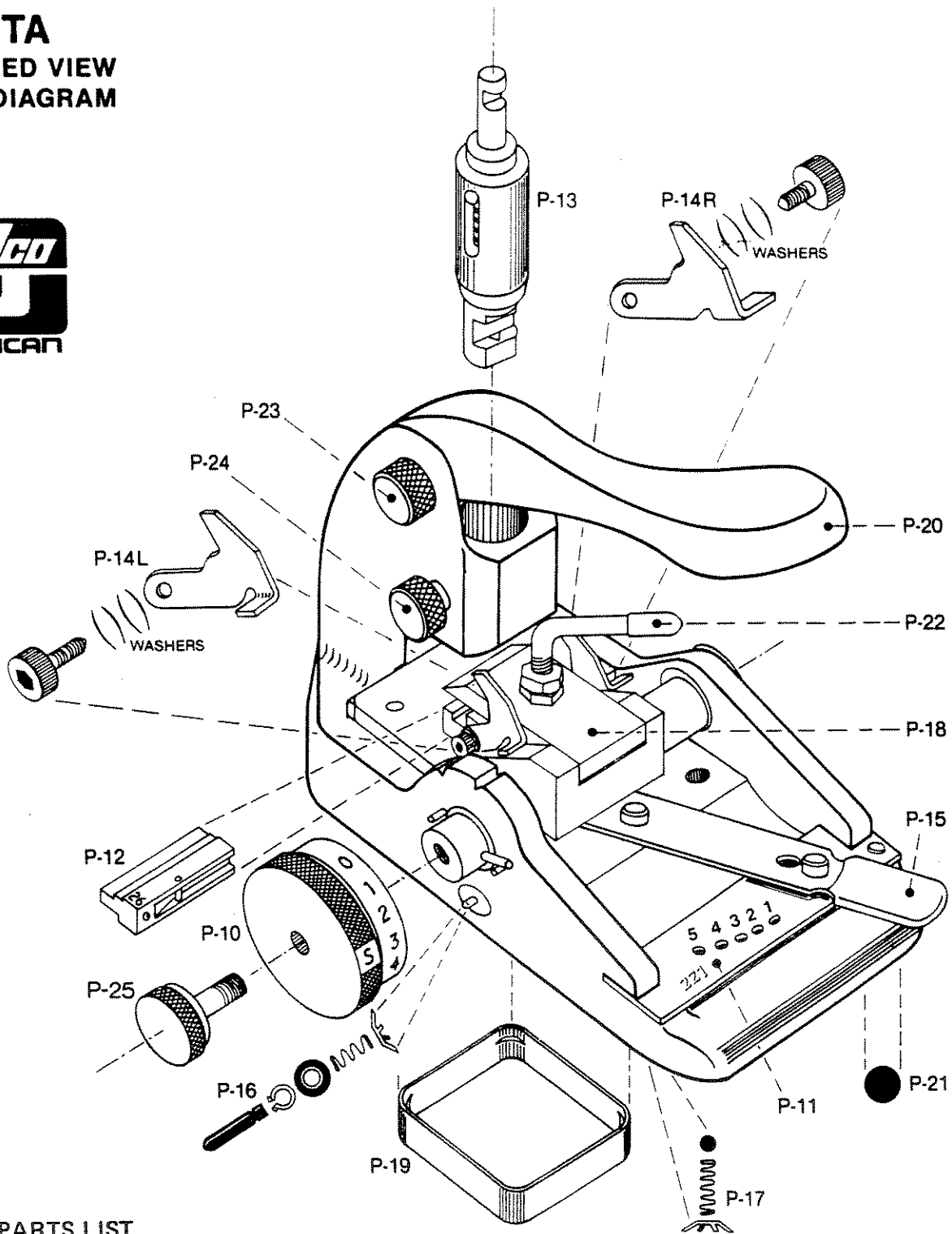


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EXACTA

EXPLODED VIEW PARTS DIAGRAM



SPARE PARTS LIST

- | | | | |
|-------|---|------|-----------------------------------|
| P-10 | Depth knob (knobs for different makes are identified by letters A, B, etc.) | P-17 | Detent assembly for spacing plate |
| P-11 | Spacing plate (plates for different makes are identified by numbers 100, 101, etc.) | P-18 | Carriage assembly |
| P-12 | Key insert (inserts for different makes are identified by numbers 1, 2, etc.) | P-19 | Plastic box |
| P-13 | Punch and die assembly | P-20 | Lever |
| P-14R | Shoulder guide assembly — Right side | P-21 | Felt pads (set of 4) |
| P-14L | Shoulder guide assembly — Left side | P-22 | Carriage lever |
| P-15 | Spacing lever assembly | P-23 | Lever screw |
| P-16 | Detent assembly for depth knob | P-24 | Knob set screw |
| | | P-25 | Depth knob screw |