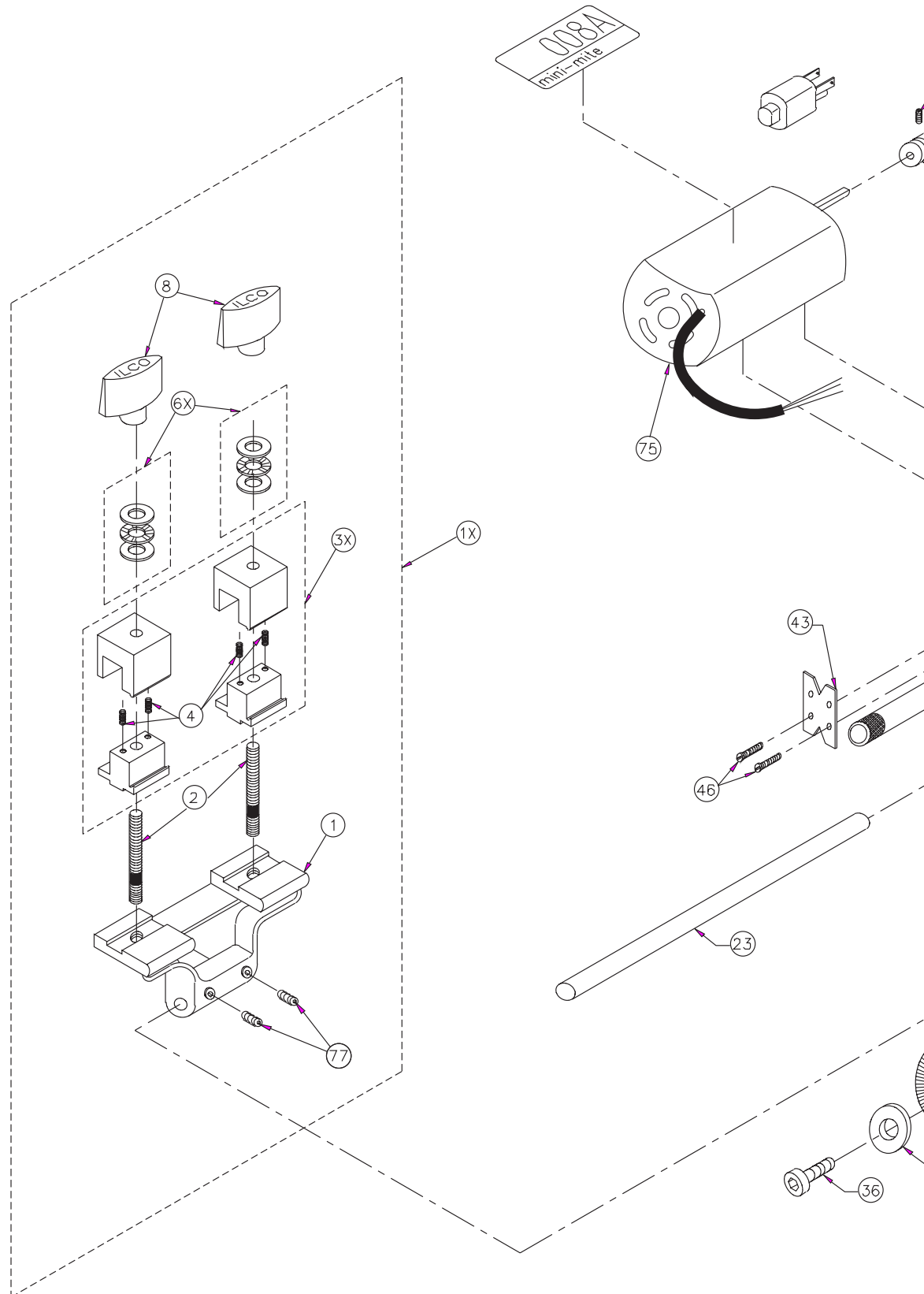


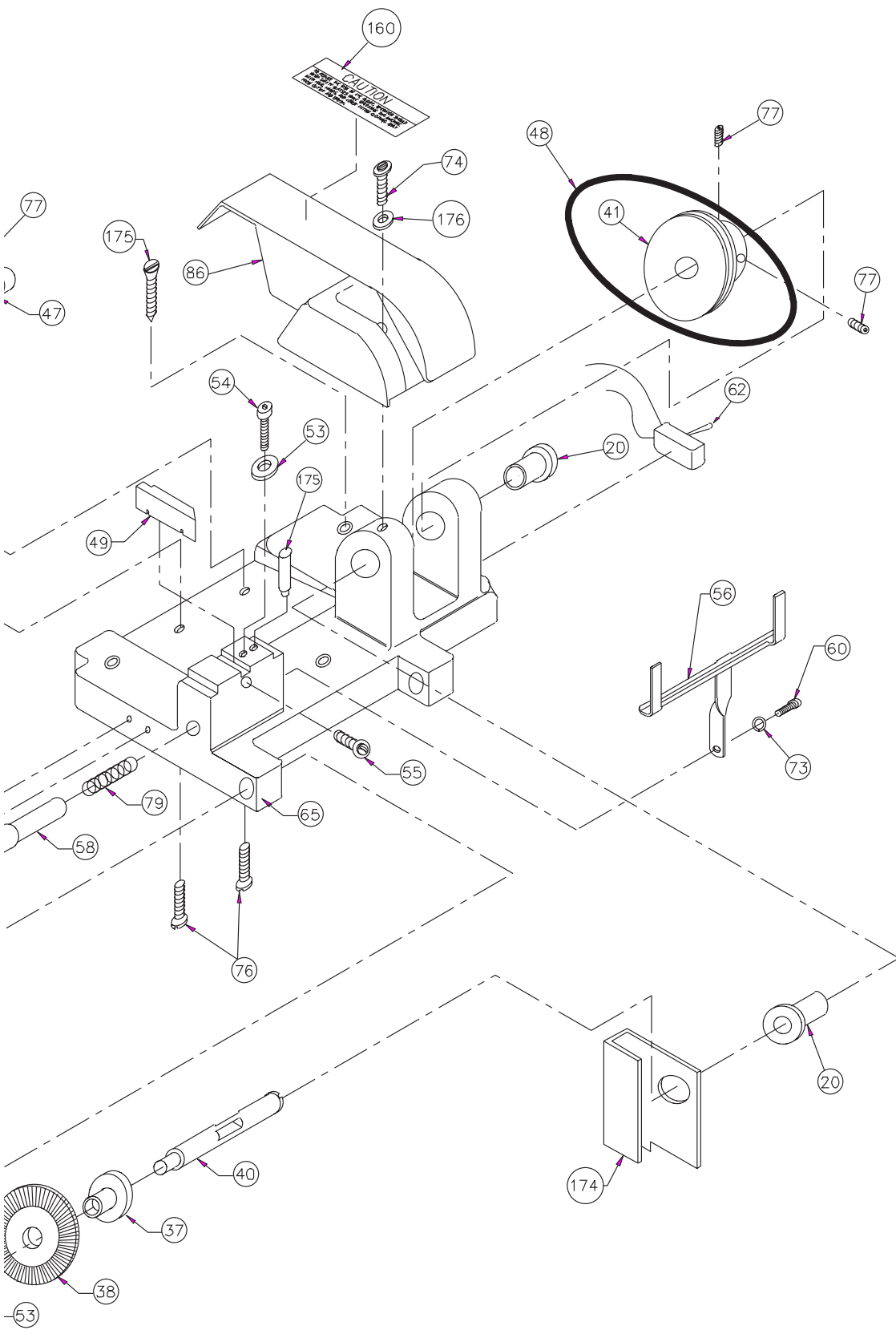
Operating Parts Identification

Part No	Identification
008-1	Carriage
008-3X	Vise jaw assembly (2)
008-8	Wing Nut (2)
008-23	Carriage shaft
008-38	23RF Cutter
008-49	Cutter Guide (stylus)
008-55	Adjusting screw
008-56	Key gauge
008-85	Safety hood
008-48	Drive Belt

EXPLODED VIEW / VISTA EN DETALLE / SCHÉMA ÉCLATÉ



EXPLODED VIEW / VISTA EN DETALLE / SCHÉMA ÉCLATÉ



EXPLODED VIEW PARTS LIST

Refer to pages 6-7 for illustration

Ref.	Part No.	Description	Ref.	Part No.	Description
1	008-1	Carriage	55	008-55	Adjusting Screw
1X	008-1X	Carriage Assembly	56	008-56	Key Gauge
2	008-2	Carriage Stud	58	008-58	Key Gauge Shaft
3X	008-3X	Vise Jaw Assembly	60	008-60	Key Gauge Screw (8-32 x 1/2")
4	008-4	Vise Jaw Spring	62	008A-62	Off/On Power Switch
6X	008-6X	Thrust Bearing Set	65	008-65	Main Base, Machined
8	008-8	Wing Nut	73	008-73	Key Gauge Lockwasher, #8)
20	008-20	Cutter Shaft Bushing	74	008-74	Safety Hood Screw, (10-32 x 3/8")
23	008-23	Carriage Shaft	75	008A-75A	115V Motor Assy. (008A version)
36	008-36	Cutter Shaft Screw (10-32 x 3/4" LH)	76	008-76	Motor Mounting Screw (10-32 x 5/16")
37	008-37	Cutter Spacer	77	008-77	Set Screw (10-32 x 1/4")
38	008-38	23RF Cutter	79	008-79	Key Gauge Spring
40	008-40	Cutter Shaft	86	008A-86A	Safety Hood/Belt Guard
41	008-41	Cutter Shaft Pulley	160	008-160	Caution Label
43	008-43	Key Rake	174	008-174	Chip Deflector
46	008-46	Key Rake Screw (8-32 x 3/8")	175	008-175	Mounting oval head wood screw, (10 x 1 1/4")
47	008-47	Motor Pulley	176	008-176	Cutter Guide Pin
48	008-48	Drive Belt	177	008-177	Safety Hood Washer
49	008-49	Cutter Guide, (stylus)	NS	008-IM	Instruction Manual
53	008-53	Binding Washer	NS		12V motor with connecting cable
54	008-54	Cutter Guide Binding Screw	NS	008A-66	Main Base, machined

Proper key cutting techniques

Even though your 008A key machine is designed to make key cutting efficient and accurate, operator skill is important. The actual mechanics of placing keys within the vise jaws is simple to learn, but there are some basics that must be followed. A properly adjusted key machine, used by someone who ignores good key cutting techniques will NOT produce a good key. The way a person clamps a key into the vise jaws is critical to the accuracy of the duplicated key.

Remember - the real purpose of a duplicate key is to operate the lock for which it was intended. If customers return keys, you should reexamine your cutting techniques and adjustment of the machine.

Here are some important operating tips:

1. Vise jaws - clean them regularly so that no metal chips lie under the keys. It is essential that both keys lie flat across the entire width of each vise jaw. Neither key should be tilted.
2. Do NOT use pliers or other tools to tighten the vise jaws. Firm hand pressure is sufficient.
3. Keep the carriage shaft free of metal chips. A thin film of oil can be applied to it. The carriage should be free to move without binding.

4. NEVER touch the shoulder of a key to the side of the cutter guide. This will cause the shoulder of the key blank to touch the side of the cutting wheel. When this happens, some of the metal will be cut away from the shoulder of the key blank. If the resulting duplicated key is duplicated two, three, four times over, an error will accumulate and cause a non-operating key. Do not grind away the shoulder.
5. Don't run the cutter into the vise jaw; this will dull the cutter, and reduce cutter efficiency.
6. Keep the cutter clean. Don't let any foreign objects or instruments blunt it. This cutter is a precise cutting tool and should be handled with care.
7. Lubrication of moving parts is important. The carriage spindle should be lubricated with a thin film of oil, removing excess with a clean dry cloth. The lubrication procedures should be performed every 2-3 weeks depending upon machine usage. (5-7 drops of a lightweight machine oil such as "3-in-1" or equivalent is sufficient.)