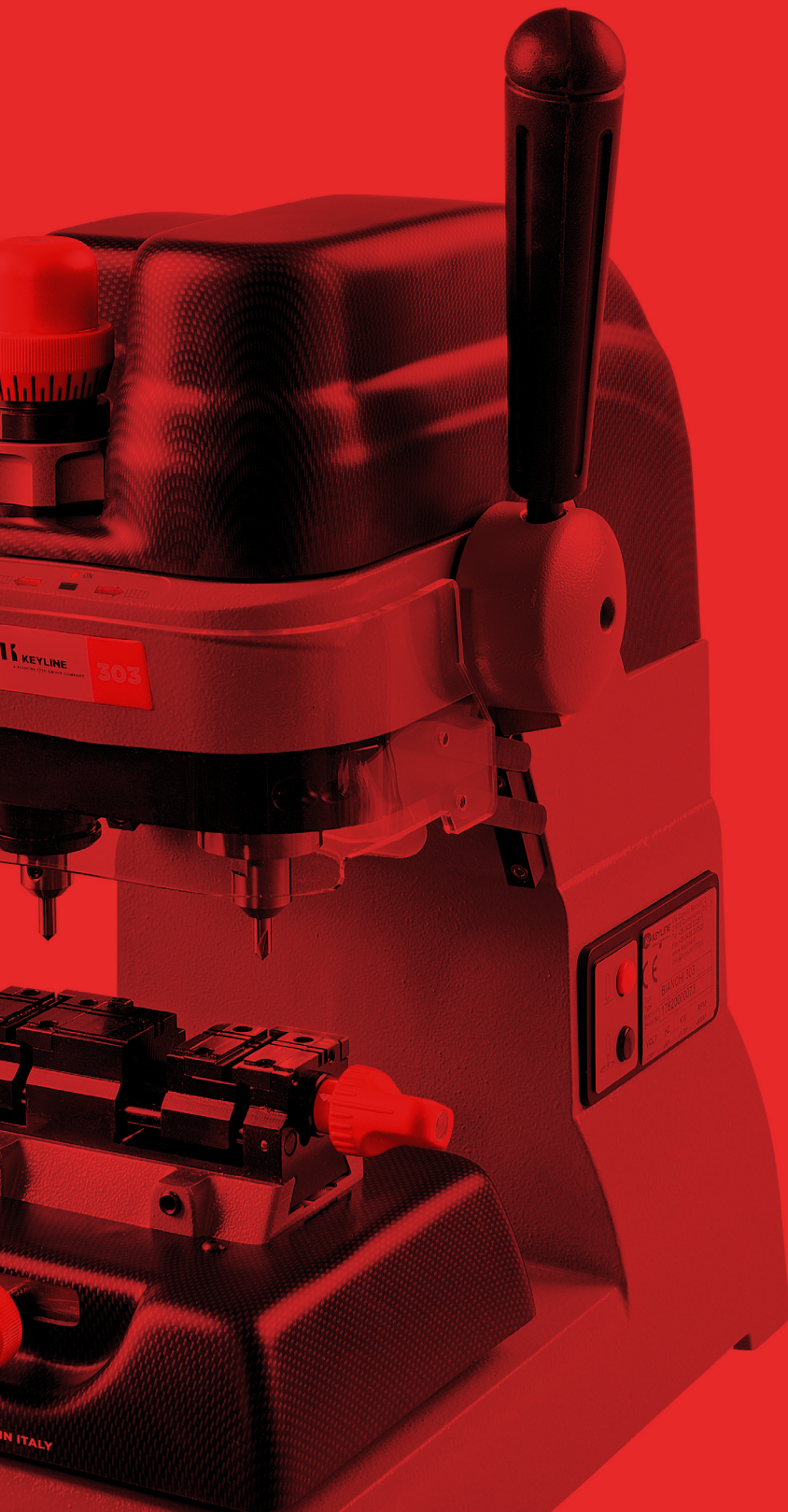




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303

calibration



303 CALIBRATION

1. Turn on the main switch. Now the machine is ready for electromechanical calibration.
2. Press the red button to start the calibration system; the yellow led will turn on.
3. Next de-activate the spring mechanism by lifting the gray collar on the tracer assembly in the up or “locked” position. (The pins should be pulled up and out of the slots and turned sideways to make sure they do not fall back into the slots. This locks the spring mechanism so there is no play in the tracer assembly).
4. Use the vertical carriage lever to move the milling cutter/tracer assembly close to a non-cut area of the key.
5. Turn the tracer assembly knob in the direction indicated by the arrows until the green light turns on and the acoustic chime becomes active.
6. Ideal calibration is received when there is a green light and chime when hard pressure is placed on the carriage handle, but the red arrow pointing to the right is lit with light pressure.