

Key Machines

Key Machine Cutters

A Cross Reference and Replacement Guide



The  to your success

ilco
A Member of the Kaba Group

This guide serves as a cross reference and replacement index. Included is a specification chart for all cutters currently available from Kaba Ilco Corp. The cutter replacement guide includes the original cutter as well as optional cutters that may be available for each machine. Page 8 of this guide provides a cross reference for machines manufactured by other companies and the Ilco cutters that are available as replacements.

Ilco cutters are carefully designed, made of the finest materials, and thoroughly inspected for defects in materials or workmanship.

Because cutters are used under conditions over which we have no control, Kaba Ilco Corp. cannot guarantee nor be held responsible for cutters damaged in use.

Table of Contents

Cutter Styles	page 3
Cutter Replacement Guide	pages 4-6
By Model Cutter Replacement Guide	pages 7-8
Cutter Replacement - Silca / Ilco Orion	9-10

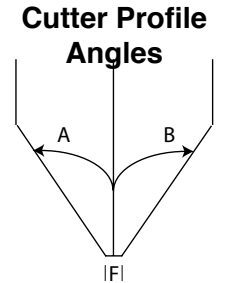


CUTTER STYLES

1. **Slotter** - Designed to cut flat steel and safe deposit keys.
2. **Side Milling Slotter** - Designed to cut flat steel and safe deposit keys. This cutter has teeth along its sides so the key machine can widen cuts with a side to side cutting motion.
3. **Milling** - The teeth on a milling cutter are formed using a grinding or milling machine operation on the basic cutter blank. Ilco milling cutters are manufactured using high-quality steels and offer greater durability than rotary file cutters.
4. **Fine Milling** - Fine milling cutters are manufactured using the same technique for milling cutters. They feature fine, closely spaced teeth, a smooth cutting action, and greater service life compared to the rotary file-type cutter.
5. **T** - Special cutter for side ward cuts on bit keys.
6. **Ward** - Special cutter for sideward cuts on bit keys.
7. **End Mill** - When used on certain machines, an end mill cutter can mill grooves in keys or make cuts in tubular keys. Some end mill cutters may be used on electronic machines for cutting edge cut standard automotive keys (i.e. H158 used with D Clamp on Tri-Code HS).
8. **Laser** - Designed for cutting sidewinder High Security keys. On mechanical duplicating machines, a matching tracer is required.

CUTTER REPLACEMENT GUIDE

Ilico Number	Type	Material	Diameter		Thickness		Hole Diameter		Cutter Profile Angle				Used on Machines
			In.	mm	In.	mm	In.	mm	A°	B°	F In.	mm	
AT-U01	Milling	H.S.S.	2.38	60.4	.207	5.25	.375	9.52	0	80	.004R	.10	Ilico EZ® Code
CU1	Milling	H.S.S.	2.25	57.15	.25	6.35	.5	12.7	0	45	.015R	.381	Ilico 022, 027, 027A; Taylor KD1, KD1A, KD5, KD6, KD6AG, KD8, KD9
3FS-HS	Slotter	H.S.S.	2.5	63.50	.055	1.4	.375	9.52					Ilico 2175-IA, 2177-ID, 2179-IM
3S	Slotter	H.S.S.	2.5	63.50	.04	1.02	.375	9.52					DL 125, 125A, 126, 126M
4S	Slotter	H.S.S.	2.25	57.15	.04	1.02	.5	12.7					DL 136, 136D, 146, 146D
CU5	Milling	H.S.S.	2.25	57.15	.25	6.35	.5	12.7	0	45	.020	.508	Taylor KD1, KD5, KD6, KD20; Curtis - various models
7FS-HS	Slotter	H.S.S.	2.5	63.50	.04	1.02	.375	9.52					Ilico 2175-IA, 2177-ID, 2179-IM
8UC	Milling	H.S.S.	2.375	60.32	.242	6.15	.0375	9.52	45	45	.035F	.889	Ilico 2178U, 2178UA, 2178UC
9MC	Milling	H.S.S.	2.875	73.02	.206	5.23	.5	12.7	30	30	.025R	.635	Ilico 016,017,018
P-9MC*	Milling	H.S.S.	2.875	73.02	.206	5.23	.5	12.7	30	30	.025R	.635	Ilico 016,017,018
9RF	Fine Milling	H.S.S.	2.75	69.85	.25	6.35	.0375	9.52	30	0	.031R	.787	Ilico 2175-IA,2177-ID, Keil OF
10FS	Slotter	H.S.S.	2.5	63.50	.03	.76	.375	9.52					Ilico 2175-IA, 2177-ID, 2179-IM
10MC	Milling	H.S.S.	2.75	69.85	.28	7.11	.875	22.22	30	30	.018F	.45	DL 125A, 128AM, 128SM, 130AM, 132AM, 150AM; Keil 1, 1-1/2
S-10MC	Milling	H.S.S.	2.75	69.85	.24	6.1	.875	22.23	60	60	.020	.508	DL 125, 126M
11	Slotter	H.S.S.	2.063	52.39	.035	.89	.05	12.7					Ilico 2196K; Keil 6-1/2
11FS-24	Slotter	H.S.S.	2.781	70.64	.045	1.14	.375	9.52					Ilico 2179-IM; Keil 0, OF
11MC	Milling	H.S.S.	2.375	60.32	.28	7.11	.5	12.7	30	30	.015F	.38	Ilico 024; DL 144M, 144MA; Taylor 144MT
CU11	Milling	Cobalt	3.15	80	.197	4.97	.63	16	40	40			Ilico KD40, KD50, KD71; Borkey
12	Slotter	H.S.S.	2.063	52.39	.045	1.14	.5	12.7					Ilico 2196K; Keil 6, 6-1/2
13	Slotter	H.S.S.	2.063	52.39	.072	1.83	.5	12.7					Ilico 2196K; Keil 6, 6-1/2
13FS-HS	Slotter	H.S.S.	2.25	57.17	.045	1.14	.437	11.11					Taylor KD10; Segal 815-1815; HPC 6210, 6200, 9310 DKM
14 (14T)	T	H.S.S.	2	50.80	.440 Wide	11.18	.5	12.7					Ilico 2196K; Keil 6-1/2; Taylor KD10
CU14	Milling	Cobalt	2.48	63	.197	5	.63	15	42	42			Ilico KD14
T14MC	Milling	H.S.S.	2.375	60.32	.375	9.52	.375	9.52	50	50	.050F	1.27	Ilico Universal II; HPC 1200CM; Lagard LG1011
15FS-HS	Slotter	H.S.S.	2.5	63.50	.045	1.14	.375	9.52					Ilico 2175-IA, 2177-ID, 2179-IM;
CU15	Slotter	H.S.S.	2.498	63	.039	1	.63	16					Ilico KD15
16CT	End Mill	H.S.S.	.187	4.76									Ilico 009; Taylor KD30, KD90
16TW	End Mill	H.S.S.	.236	6	.234	5.95							Ilico 009B
17	Slotter	H.S.S.	2.063	52.39	.274	6.96	.5	12.7					Ilico 2196K; Keil 6-1/2
CU18-1	Slotter	Carbide	3.15	80	.059	1.5	.866	22					Ilico KD16, KD17, KD18
CU18-2	Slotter	Carbide	3.15	80	.039	1	.866	22					Ilico KD16, KD17, KD18
CU18-3	Ward Slotter	Carbide	1.26	32	.053	1.35							Ilico KD18
19MC	Milling	H.S.S.	2.875	73.02	.28	7.11	.5	12.78	30	30	.031R	.787	Ilico 2183DM, 2183HM, 006, 010; Keil 1, 1-1/2, 10
P-19MC*	Milling	H.S.S.	2.875	73.02	.28	7.11	.5	12.78	30	30	.031R	.787	Ilico 2183DM, 2183HM, 006, 010; Keil 1, 1-1/2, 10
20MC	Milling	H.S.S.	2.375	60.32	.375	9.52	.375	9.52	38	38	.070R	.178	Ilico 2178U, 2178UA, 2178UC, 178U
CU20	Milling	H.S.S.	2.375	60.32	.25	6.35	.5	12.7	0	45	.031R	.787	Ilico 020,024A,024B,040,044
P-CU20*	Milling	H.S.S.	2.375	60.32	.25	6.35	.5	12.7	0	45	.031R	.787	Ilico 020,024A,024B,040,044
TCW-20FM	Fine Milling	H.S.S.	2.375	60.32	.375	9.52	.375	9.52	38	38	.064F	1.6	Ilico Universal II; HPC 1200CM; Lagard LG1011
21MC	Milling	H.S.S.	2.375	60.32	.375	9.52	.375	9.52	39	39	.050	1.27	Ilico 2178U, 2178UA, 2178UC, 178U

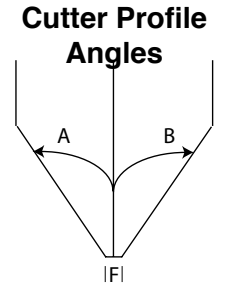


Note: In the above drawing and chart to the left, 'F' refers to the width of the tip of the cutter, measured in thousandths of an inch. When this measurement is followed by 'R' (Example - .015R), it means that the tip of the cutter is .015" wide and it is rounded (or has a radius). When the measurement is followed by 'F' (Example - .010F), it means that the tip of the cutter is .010 wide and is flat.

* Available with Titanium Nitride coating (add prefix "P") • H. S. S. - High Speed Steel

CUTTER REPLACEMENT GUIDE (Con't)

Ilico Number	Type	Material	Diameter		Thickness		Hole Diameter		Cutter Profile Angle				Used on Machines
			In.	mm	In.	mm	In.	mm	A°	B°	F In.	mm	
23RF	Fine Milling	H.S.S.	2.25	57.15	.25	6.35	.5	12.7	45	0	.031R	.787	Ilico 008, 008A, 008B, 2184CD, H2584CV, 2585DU, 190; DL 145, 145M, 147, 149M; HPC 9100, 9110; Taylor KD1, KD5, KD20; Keil 4-1/2, 12-1/2, 13-1/2, 15; Curtis 2000
X23MC	Milling	H.S.S.	2.375	60.32	.104	2.64	.5	12.7	0	45	.081F	2.457	Ilico 023, 025, 045; DL 143M, 145, 145M, 148M; Taylor 143MT, 145MT
P-X23MC*	Milling	H.S.S.	2.375	60.32	.104	2.64	.5	12.7	0	45	.081F	2.457	Ilico 023, 025, 045; DL 143M, 145, 145M, 148M; Taylor 143MT, 145MT
X23MC SPL	Milling	H.S.S. (AlTiN Coated)	2.375	60.32	.104	2.64	.5	12.7	0	45	.081F	2.457	Ilico 023, 025, 045; DL 143M, 145, 145M, 148M; Taylor 143MT, 145MT
25	Slotter	H.S.S.	2.5	63.50	.045	1.14	.5	12.7					Keil 10-1/2
27	Slotter	H.S.S.	2.25	57.15	.045	1.14	.5	12.7					Ilico 2184CD, 2584CV; DL 146, 146M; HPC 9100, 9110; Taylor KD1; Keil 4-1/2, 12-1/2
27-1	Slotter	H.S.S.	2.25	57.15	.03	.76	.5	12.7					Ilico 2184CD, 2584CV; DL 146, 146M; HPC 9100, 9110; Taylor KD1; Keil 4-1/2, 12-1/2
27-2	Slotter	H.S.S.	2.375	60.32	.03	.76	.5	12.7					Ilico 2585DU; Keil 15-1/2
28RF	Fine Milling	H.S.S.	2.063	52.39	.25	6.35	.5	12.7	0	45	.025R	.635	Ilico 2196K
CU29	Milling	H.S.S.	2.375	60.32	.27	6.86	.5	12.7	45	45	.064	1.626	Ilico 029A
SMS30	Side Milling Slotter	H.S.S.	2.375	60.32	.03	.76	.5	12.7					Ilico 2184CD, 2584CV, H2585SMS; HPC 9110; Keil 12S, 12-1/2S, 15S 15-1/2S
CU30-55	Slotter	Carbide	4	101.60	.055	1.4	1	25.4			.055	1.4	Ilico 030, 031; PPI Halftime
CU30-55	Slotter	Carbide	4	101.60	.055	1.4	1	25.4			.055	1.4	Ilico 030, 031; PPI Halftime
CU30-62	Slotter	Carbide	4	101.60	.055	1.4	1	25.4			.062	1.57	Ilico 030, 031; PPI Halftime
CU30-72	Slotter	Carbide	4	101.60	.055	1.4	1	25.4			.072	1.83	Ilico 030, 031; PPI Halftime
CU30-88	Slotter	Carbide	4	101.60	.055	1.4	1	25.4			.088	2.24	Ilico 030, 031
CU30-M	Slotter	Carbide	4	101.60	.055	1.4	1	25.4			.050	1.27	Ilico 030, 031; PPI Halftime
32	Slotter	H.S.S.	2.063	52.39	.03	.76	.5	12.7					Ilico 2196K; Keil 6-1/2
34MC	Milling	H.S.S.	2.25	57.15	.25	6.35	.5	12.7	0	45	.031R	.787	Ilico 2184CD, 2584CV, 2585DU; Keil 4-1/2, 12-1/2
P-34MC*	Milling	H.S.S.	2.25	57.15	.25	6.35	.5	12.7	0	45	.031R	.787	Ilico 2184CD, 2584CV, 2585DU; Keil 4-1/2, 12-1/2
36MC	Milling	H.S.S.	2.375	60.32	.375	9.52	.375	9.52	45	45	.088F	2.24	Ilico 2178U, 2178UA, 2178UC, 178U
37MC	Milling	H.S.S.	2.25	57.15	.20	5.08	.5	12.7	45	45	.025F	.635	Ilico 2184CD, 2585DU; HPC 9100, 9110; DL 135, 135M, 145, 145M; Taylor KD5
CU45	Slotter	H.S.S.	2.48	63	.071	1.8	.63	16					Ilico KD45, KD46, KD83
SMS45	Side Milling Slotter	H.S.S.	2.375	60.32	.045	1.14	.5	12.7					Ilico 046, 046HD, 2584SMS, 2585SMS; HPC 9110; Keil 12S, 12-1/2S, 15S, 15-1/2S
P-45SMS*	Side Milling Slotter	H.S.S.	2.375	60.32	.045	1.14	.5	12.7	42	45	.045	1.143	Ilico 046, 046HD, 2584SMS, 2585SMS; HPC 9110; Keil 12S, 12-1/2S, 15S, 15-1/2S
TCW-47MC	Milling	H.S.S.	2.375	60.32	.375	9.52	.375	9.52	42	45	.035F	.889	Ilico Universal II; HPC 1200CM; Lagard LG1011
CU50A	Milling	Cobalt	3.15	80	.197	5	.63	16	40	40			Ilico KD50A, KD71A, KD50C; Silca Bravo II, Bravo III, Bravo III w/EZ Jaw
57MC	Milling	H.S.S.	2.75	69.85	.281	7.14	.5	12.7	0	30	.020	.508	Sagar SA500, SA500A
58MC	Milling	H.S.S.	2.75	69.85	.281	7.14	.5	12.7	0	30	.020	.508	Sagar SA500, SA500A



Note: In the above drawing and chart to the left, 'F' refers to the width of the tip of the cutter, measured in thousandths of an inch. When this measurement is followed by 'R' (Example - .015R), it means that the tip of the cutter is .015" wide and it is rounded (or has a radius). When the measurement is followed by 'F' (Example - .010F), it means that the tip of the cutter is .010 wide and is flat.

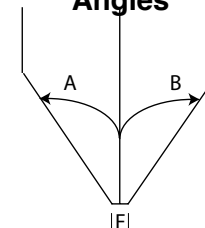
* Available with Titanium Nitride coating (add prefix "P") • H. S. S. - High Speed Steel

CUTTER REPLACEMENT GUIDE (Con't)

Ilco Number	Type	Material	Diameter		Thickness		Hole Diameter		Cutter Profile Angle				Used on Machines
			In.	mm	In.	mm	In.	mm	A°	B°	F In.	mm	
CU82	Milling	Cobalt	3.15	80	.276	7	.63	16	45	45			Ilco KD82
CU84	Slotter	H.S.S.	2.48	63	.094	2.4	.63	16					Ilco KD84, KD84A
CU85	Milling	Cobalt	2.362	60	.374	9.5	.374	9.53	42.75	42.75	.016	.4	Ilco KD85
TCW-90MC	Milling	H.S.S.	2.375	60.32	.375	9.52	.375	9.52	45	45	.052F	1.32	Ilco Universal II; HPC 1200CM; Lagard LG1011
CU94	End Mill	H.S.S.	.225	5.72									Ilco KD94, KD95
P-CU100A*	Milling	H.S.S.	3.15	80	.197	5	.63	16	40	40			Ilco ECM 100
SA160	Milling	H.S.S.	2.25	57.15	.281	7.14	.5	12.7	30	30	.032R	.813	Sagar SA100, SA200
TCW-1011	Milling	H.S.S.	2.375	60.32	.29	7.37	.375	9.52	45	45	.044F	1.12	Ilco Universal II; HPC 1200CM; Lagard LG1011
SACW-1012	Milling	H.S.S.	2.375	60.32	.375	9.52	.375	9.52	43	43	.015F	.381	Ilco Universal II; HPC 1200CM; Lagard LG1011
SACW-1013	Milling	H.S.S.	2.375	60.32	.375	9.52	.375	9.52	50	50	.046F	1.17	Ilco Universal II; HPC 1200CM; Lagard LG1011
TCW-1014	Milling	H.S.S.	2.375	60.32	.375	9.52	.375	9.52	50	50	.08F	2.032	Ilco Universal II; HPC 1200CM; Lagard LG1011
AM7625	Milling	H.S.S.	2.25	57.15	.125	3.18	.5	12.7	0	20	.03R	.762	Cole various model

* Available with Titanium Nitride coating (add prefix "P") • H. S. S. - High Speed Steel

Cutter Profile Angles



Note: In the above drawing and chart to the left, 'F' refers to the width of the tip of the cutter, measured in thousandths of an inch. When this measurement is followed by 'R' (Example - .015R), it means that the tip of the cutter is .015" wide and it is rounded (or has a radius). When the measurement is followed by 'F' (Example - .010F), it means that the tip of the cutter is .010 wide and is flat.

CUTTER REPLACEMENT BY MODEL GUIDE

Machine	Original	Optional
ILCO		
006	19MC	P-19MC
008, 008A, 008B	23RF	27 (Slotter)
009,	16CT	
009A, 009B	16TW	
010	19MC	P-19MC
016, 017, 018	P-9MC	9MC
020, 024A, 024B	CU20	P-CU20
022	CU1	
023, 025	P-X23MC	X23MC
045, 045HD	P-X23MC	X23MC
024	11MC	
026	P-45SMS	45SMS, 30SMS
027, 027A	CU1	
029A	CU29	
030	CU30-55	CU30-62, -72, -88, -M
031	CU30-88	CU30-55, -62, -72, -M
040, 040HD	P-CU20	CU20
044, 044HD	P-CU20	CU20
046, 046HD	P-45SMS	SMS45
057 HS	F22	F44SPL
ECM 100	P-CU100A	
ILCO EZ®-Code	AT-U01/U01 (AL-TiN)	D705933ZB Carbide
Universal II	T14MC	TCW-20FM,
	TCW-1011MC	TCW-47MC, TCW-90MC, TCW1011, SACW1012, SACW1013, SACW1014
2175-IA	9RF or 3FS-HS	7FS-HS, 10FS, 15FS-HS
2177-ID	9RF or 3FS-HS	7FS-HS, 10FS, 15FS-HS
2178U	8UC	20MC, 21MC, 22MC, 36MC
2179-IM	9RF,	7FS-HS, 10FS
	3FS-HS	11FS-24, 15FS-HS
2183DM, 2183HM	19MC	P-19MC
2184CD	23RF	27, 27-1, 34MC, P-34MC, SMS30, 37MC, P-45SMS

Machine	Original	Optional
ILCO (Con't)		
2196K	12, 13, 17, or 32	11, 28RF
2584CV	34MC	27, 27-1, P-34MC, 37MC, SMS30, SMS45
H2584CV	34MC	P-34MC, 37MC, 45SMS,
2584SMS	SMS45	P-45SMS, 27
H2584SMS	27	SMS30, P-45SMS
2585DU	34MC, 37MC, 45SMS	27-2, P-34MC, 37MC
2585SMS	30SMS, SMS45	P-45SMS
SILCA		
AY 100-C	D701652ZB	
Bravo	D700875ZB	
Bravo Master	D700875ZB	
Bravo USA	D700875ZB	
Bravo II	D717898	CU50A, D700875ZB D704861ZB Requires Carbide Pulley Set
Bravo III	D717898	CU50A, D700875ZB D704861ZB Requires Carbide Pulley Set
Bravo III (w/EZ-Jaw)	D717898	CU50A, D700875ZB D704861ZB Requires Carbide Pulley Set
Cadet	D706766ZB	
Club, Club Jr	D705488ZB (F22)	Various types
Crown	D700077ZB	D705407ZB D704541ZB
Delta A/M/S	D911868ZR	
Delta Multicopy	D714448ZB	SG19
Delta 2000 FO	D913645ZR	SG18
Delta Flat Steel	D712505ZB (.045) D412506ZZ (.030)	
Delta Plus	D911868ZR	
Doge	D701089ZB (F11)	Various types

Machine	Original	Optional
SILCA (Con't)		
Futura	D742607ZB (01F)	
	D742606ZB (01L)	D743671ZB (02L) D743672ZB (03L)
	D742267ZB (01D)	D743673 (02D)
GT40	D700080ZB	
GT 40-C	D301744ZZ	
Larus	D706766ZB	
Lancer, Lancer Plus	D705374ZB	D711119ZB (Ward Cutter), D700204ZB
Matrix II	D739973ZB (F22)	Various types
Matrix S, SX, SLX	D705488ZB (F22)	Various types
Poker Plus	D700875ZB	
Prima Laser	D709696ZB	
Quattrocode	D709238ZB (W101)	Various types
Rekord 2000, Rekord Plus	D700875ZB	
Scout	D401866ZZ	
Special Master	D700875ZB	
Speed	D935282ZR	
Sprint	D401647ZA	
Super Special	D700875ZB	
Targa 2000	D300080ZB	
Tech 3 Europa	D700080ZB	
Triax	D708742ZB (H101)	AL/TiN-H101 Cutter Various types
Triax e.code	D708742ZB (H101)	AL/TiN-H101 Cutter Various types
Tri-Code HS	D708742ZB (H101)	AL/TiN-H101 Cutter, D709238ZB W101, D709482ZB W114, D737688ZB W302
Ultracode/ Unocode	D716549ZB (U01)	D705933ZB Carbide, various slotters
UC199	D734910ZB (Carbide)	

CUTTER REPLACEMENT BY MODEL GUIDE (Con't)

Machine	Original	Optional
ILCO/ORION		
KD14	MH234.001	CU14
KD15 (Halley-B)	BH238.008	CU15
KD16, KD17	M202.112	CU18-1
	M202.116	CU18-2
KD18	M202.112	CU18-1
	M202.116	CU18-2
	ME205.056	CU18-3
KD45, KD46, KD83	SC235.044	CU45
KD50	MS200.056	CU11
KD50A, KD50C	D700875ZB	CU50A
KD55		see page 9
KD56		see page 9-10
KD71	MS200.056	Early models CU11, Later models CU50A
KD71A		CU50A
KD82	DA219.055	CU82
KD84, KD84A	SI240.001	CU84
KD85	MD237.039	CU85 or SACW1012
KD94, KD95	M208.019	CU94
Nova 2000		CU56-048
BORKEY		
REXA 1, 11, 111	V8	CU11
954-2 DSB REXA	V8	CU11
972 WASTA-TEX	V8	CU11
CURTIS		
2,2000,3000	CU5	CU5
9		14T
COLE		
200, 3K	AM7625	AM7625
	2277	X23MC
N200	CU5	CU5
DOMINION LOCK		
125, 125A,	S10-MC	S10-MC
126, 126M	3S	3S
128S, 128AM	10MC	10MC
136,146	4S	4S
130AM, 132AM, 150AM	S10-MC	S10-MC
143M	X23MC	X23MC
144M	11MC	11MC

Machine	Original	Optional
DOMINION LOCK (Con't)		
145,145M	X23MC	X23MC
	23RF	23RF
	16MC	23RF
147M	23RF	23RF
148M	X23MC	X23MC
149M	23RF	23RF
	16MC	34MC
ESP		
1000, 3000, 5000, 660,990	34MC	34MC
HPC		
6200,6210	CW33	13FS-HS
9100	CW23RF	23RF
	CW16	27
	CW39	27-1
	CW34MC	34MC
9110	CW23RF	23RF
	CW16	27
	CW39	27-1
	CW30SMS	30SMS
	CW34MC	34MC
9120RM, 9220RM	CW23RM	CU1
9160MC, 9170MC	CW23MC	X23MC
9319	CW33	13FS-HS
1200MC	CW1011	TCW1011
	CW1012	SACW1012
	CW1013	SACW1013
	CW14MC	T-14MC
ONE	CW80	D700875ZB
THREE	CW80	D700875ZB
KEIL		
O	24	11FS-24
OF	24	9RF
	11FS	11FS-24
1, 1-1/2	10	10MC
		19MC, P-19MC
4, 4-1/2	26	23RF
	27	27
6, 6-1/2	11	11
	12	12
	13	13
	14	14
	17	17
9, 9-1/2	30	16CT

Machine	Original	Optional
KEIL (Con't)		
10, 10-1/2	10	19MC*
	25	25
12S, 12-1/2S	27-1	27-1
	27	27
		30SMS
		45SMS
12, 12-1/2	26	23RF
13-1/2	26	23RF
15, 15-1/2	34MC	34MC
	27	27
15S, 15-1/2S	30SMS	30SMS
		45SMS
JENSEN		
MKDC, JMD-4	MDC-2	T-14MC
JMD-5	MDC-8	20MC
	MDC-9	22MC
	MDC-11	36MC
	MDC-12	SMS45
SAGAR		
SA100	SA160	SA160
SA200, SA200B	SA260	SA160
SA400	SA460	8UC
SA500, SA500A	SA578RH	57MC
	SA589RH	58MC
TAYLOR		
KD1	CU1	CU1
	29	27
	29A	27-1, CU5
KD5,8,9	CU1	CU1
KD10	CU4	13FS-HS
KD20	CU5	CU5
KD40, KD50	CU11	CU11
KD90	16CT	16CT
143MT	CU12	X23MC
144MT	11MC	11MC
145MT	CU12	X23MC
MISCELLANEOUS MANUFACTURERS		
Foley Belsaw	6011	6011
Foley Belsaw	6012	6012
Rytan	RY0030	CU11
Yankey	YK1	CU11
Scotsman	22-1	16CT
CEA	80X5X16 (H.S.S)	CU11

CUTTER REPLACEMENT - SILCA / ILCO ORION

Double Angle Cutters

Key Cutting Machines	Model	Material	External Dia. (mm)	Overall Hole Dia. (mm)	Cutter Thickness (mm)	Cutting Angle	Cutter Tip Width (mm)	Inside Edge Number of Teeth	to Cutter Tip (mm)
Ultracode	03	H.S.S	60.4	9.52	6.9	100	1.00	80	2.10
Unocode 299	04	H.S.S	60.4	9.52	7.2	85	1.00	72	2.40
Unocode 399	DK2	H.S.S	60.4	9.52	8.55	105	0.70	80	3.75
UC199	AT-U01	H.S.S	60.4	9.52	5.25	80	0.10	70	0.50
	U01W	Carbide	60.4	9.52	5.25	80	0.10	70	0.50
Bravo	P01	H.S.S	80	16.00	5	84	0.15	110	1.00
KD50C	P01W	Carbide	80	16.00	5	84	0.15	110	1.00
Bravo II/III, Rekord, Poker, Poker Plus	P32 (CU50A)	H.S.S	80	16.00	5	84	0.15	110	0.50
Delta 2000, Delta 2000 FO, Delta Plus	P21	H.S.S	60.4	9.52	5.25	84	0.15	70	0.50
Cadet, Larus	P11	H.S.S	40	7.00	5	84	0.15		0.50

Milling Slot Cutters

Key Cutting Machines	Model	Material	External Dia. (mm)	Hole Dia. (mm)	Cutter Thickness (mm)	Number of Teeth
Delta 2000	SG14	H.S.S	60.4	9.52	1.14	70
Delta 2000 FO	SG15	H.S.S	60.4	9.52	1.14	70
Delta 2000 AY	SG18	H.S.S	64.6	9.52	2.4	40
Delta Plus	SG19	H.S.S	64.6	9.52	1.5	70
Targa 2000	SG1	H.S.S	80	22.00	1.5	100
Tech3	SG1W	Carbide	80	22.00	1.5	100
Unocode	05	H.S.S	60.4	9.52	1.8	66
Unocode 299	06	H.S.S	64.6	9.52	2.4	70
Unocode 399	05W	Carbide	60.4	9.52	1.8	66
Ultracode	06W	Carbide	64.6	9.52	2.4	70

Cutter and Tracer Points for Mechanical Key Cutting Machines*

Dimple Cutters

Key Cutting Machines	Tracer	Cutter	Material	Cutting Angle	Dia. (mm)	Full Length (mm)	# of Cutting Edges	Stem Dia. (mm)
Matrix S/SX/SLX Doge, Doge/C Club, Club Jr	T1	F1	H.S.S	90	0.70	48	1	6
	T6	F6	H.S.S	106	1.00	48	1	6
	T7	F7	H.S.S	72	0.80	48	1	6
	T20	F20	H.S.S	90	0.45	48	2	6
	T26	F26	H.S.S	82	0.80	48	1	6
	T55	F55	H.S.S	90	1.00	48	1	6
KD55		CU55-023	H.S.S	90	0.65	40	1	4
		CU55-167	Carbide	90	1.00	40	1	4
KD56	KD56-046	CU56-045	H.S.S	100	1.8/2.6	40	1	6
	KD56-079		H.S.S	90	0.80	40	1	6
	KD56-084	CU56-083	H.S.S	90	0.50	40	1	6
	KD56-162	CU56-158	H.S.S	80	1.5/2.1	40	1	6
	KD56-160	CU56-159	H.S.S	134	1.00	40	1	6
	KD56-164	CU56-163	H.S.S	80	2.6/3.3	40	1	6
	KD56-088	CU56-087	H.S.S	90	.80/2.3	40	1	6
	KD56-111	CU56-110	H.S.S	90	.65/3.0	40	1	6
		CU56-118	H.S.S	70	.50/4.0	40	1	6

Laser Cutters

Key Cutting Machines	Tracer	Cutter	Material	Cutter Length (mm)	Full Length (mm)	Cutting Dia. (mm)	# of Cutting Edges	Stem Dia. (mm)
Matrix S/SX/SLX Matrix II Doge, Doge/C Club, Club Jr 057 HS	T8	F8	H.S.S	12	48	4	2	6
	T11	F11	H.S.S	5	48	2.5	2	6
	T22	F22	H.S.S	6	42	2.5	2	6
	T22	F22W	Carbide	6	48	2.5	3	6
	T30	F30	H.S.S	6	48	3	2	6
	T30	F30 (AlTiN)	Carbide	6	48	3	2	6
	T44	F44	H.S.S	6	40	2	2	6
	T44	F44SPL (AlTiN)	H.S.S	6	40	2	2	6
	KD55	KD55-147	CU55-146	H.S.S	5.5	40	1.5	
KD55-149		CU55-148	H.S.S	9	40	3		4
KD55-151		CU55-150	H.S.S	15	40	6		4
KD56		CU56-028	H.S.S	1.5	40	1.5		6
	KD56-047	CU56-048	H.S.S	12	40	3		6
		CU56-049	H.S.S	3.5	40	1.5		6
		CU56-091	H.S.S	1.3	40	4		6
	KD56-117	CU56-116	H.S.S	6	40	2.3		6

*The cutters shown are the most popular. Contact Kaba Ilco Corp. for the complete line of specialty cutters.

Cutter and Tracer Points for Mechanical Key Cutting Machines*

End Milling Cutters

Key Cutting Machines	Tracer	Cutter	Material	Cutter Length (mm)	Full Length (mm)	Cutting Dia. (mm)	# of Cutting Edges	Stem Dia. (mm)
Crown		D700772ZB	H.S.S	10	40	5.95	4	6
Crown (T14)		D704541ZB	H.S.S	13	40	3	3	6
Crown (T15)		D705407ZB	H.S.S	13	40	2.5	3	6
KD56	KD56-090	CU56-089	H.S.S	6	40	8		6

*The cutters shown are the most popular. Contact Kaba Ilco Corp. for the complete line of specialty cutters.

Cutters for Electronic Key Cutting Machines*

Dimple Cutters

Key Cutting Machines	Cutter	Material	Cutting Angle	Full Length (mm)	Cutting Dia. (mm)	# of Cutting (mm)	Stem Dia.
Quattrocode	H102	H.S.S	106	40	1.00	2	6
Triax e.Code	W102	Carbide	106	40	1.00	2	6
Triax Quattro	H103	H.S.S	90	40	0.80	2	6
	W103	Carbide	90	40	0.80	2	6
	H104	H.S.S	90	40	1.20	2	6
	W104	Carbide	90	40	1.20	2	6
	W105	Carbide	90	40	0.70	2	6
	W106	Carbide	90	40	0.60	2	6
	H107	H.S.S	90	40	0.90	2	6
	W107	Carbide	90	40	0.90	2	6
	W108	Carbide	82	40	0.90	2	6
	W109	Carbide	110	40	0.40	2	6
	W110	Carbide	30	40	0.60	1	6
	H111	H.S.S	0	40	2.75	2	6
	W111	Carbide	0	40	2.75	2	6
	H112	H.S.S	60	40	1.50	2	6
	W112	Carbide	60	40	1.50	2	6
	W113	Carbide	100	40	0.77	2	6
	W116	Carbide	90	40	1.00	2	6
	W118	Carbide	120	40	0.60	2	6
	W119	Carbide	80	40	0.30	2	6
	W122	Carbide	90	40	0.55	2	6
	W123	Carbide	76	40	0.90	2	6
	W130	Carbide	90	40	1.40	2	6
(Engraving Cutter)	W146	Carbide	60	40	0.25	1	6

*The cutters shown are the most popular. Contact Kaba Ilco Corp. for the complete line of specialty cutters.

Laser Cutters

Key Cutting Machines	Cutter	Material	Cutter Length (mm)	Full Length (mm)	Cutting Dia. (mm)	# of Cutting Edges	Stem Dia. (mm)
Quattrocode	H101	H.S.S	6	40	2.5	3	6
Triax e.Code	H101 (Al-TiN)	H.S.S	6	40	2.5	3	6
Triax Quattro	W101	Carbide	6	40	2.5	3	6
Triax A/T	W114	Carbide	3	40	2	2	6
Tri-Code HS	W129	H.S.S	3	40	3	3	6
	H131	H.S.S	5	40	6	3	6
	W134	Carbide	5	40	4	3	6
	W202	Carbide	6	48	3.5	3	6
	W302	Carbide	6	40	2	2	6