

Clamping Keys Properly on the DC-300 or FRA2001 Machine

The key vise on your DC-300 or FRA2001 machine is reversible. To reverse the vise, you need to turn both the top and bottom 180 degrees until it snaps into place. Be sure to turn both the top and bottom, as compression spring damage will result if only the top is rotated. The vise has a wide side and a narrow side (the narrow side has two dots on the top).

To cut keys properly, the key must be loaded correctly in terms of spacing and depth. Spacing refers to the left-right positioning, and depth refers to front-back or toward/away from the user loading. **All keys are to be inserted to the back of the vise for proper depth of cut.** Keys cannot be clamped by the milling on the key blank! Also, all keys are to be inserted with the head of the key at the right and tip at the left.

SINGLE SIDED KEYS

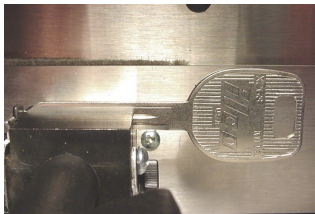
If you are cutting single-sided keys, such as GM 6 cut, you should use the side of the vise with the two dots on top. The dots should face the cutting wheel. Use the shoulder stop on the right side of the vise to align the key.

DOUBLE SIDED KEYS

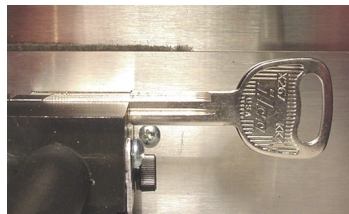
If you are cutting double-sided keys, which are the most popular today, you should be using the side of the vise without the dots. The dots should be toward the user. When you insert a key into this side of the vise, make sure the blade of the key goes all the way to the back of the vise jaw (toward the user). The vise should cover more than half of the key blank if the key is inserted properly.

If the key has a shoulder, you should align the key left-to-right with the bottom shoulder against the right side of the vise. If the key does not have a shoulder, tip stop the key by sliding it into the vise until the tip of the key touches the stop on the left.

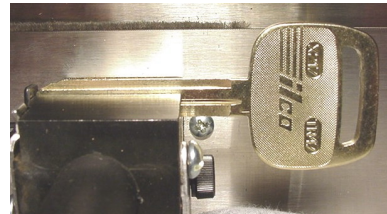
Below are pictures of several different blanks inserted properly. The vise shown below is from the FRA2001 machine, but clamping is identical for the DC-300.



Mitsubishi MIT6



Kia KK4



Toyota TR47