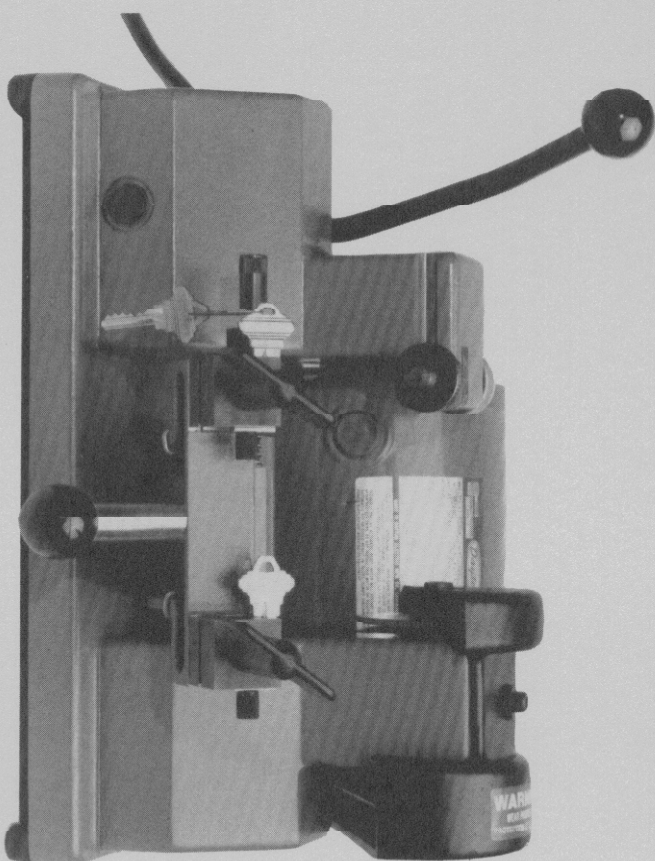


The FRAMON

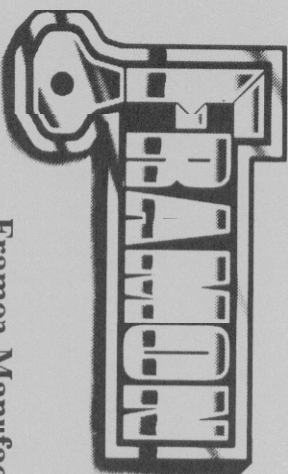
EX PRES S

The Duplicator For A Lifetime



Semi-Automatic Duplicator

**Instruction Manual
&
Parts Book**



(517) 354-5623

FAX: (517) 354-4238

Framon Manufacturing Co., Inc.
909 Washington Ave., Alpena, MI 49707

NOTES

INTRODUCTION

Congratulations on the purchase of your new Framon EXPRESS semi-automatic duplicator. You now own what we believe is one of the finest duplicators available today. We are sure you will find the same built-in quality and precision enjoyed by Framon owners the world over.

MACHINE SET UP

CAUTION: Do not attempt to lower yoke before completing these set-up instructions. Damage to machine may result.

For shipping reasons, the lever handle, ball detent plunger, and the yoke handle assembly have been removed. Prior to machine operation, these items must be installed:

1. Install lever handle in rear of machine with $1/4 \times 28 \times 1/2$ " socket head cap screw.
2. Install ball detent plunger assembly in yoke (See Fig. 1) with $5/16$ " wrench.

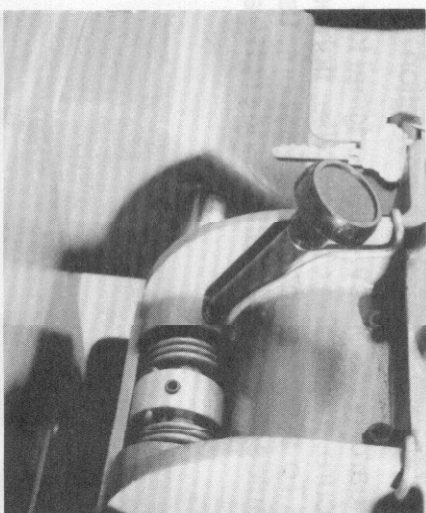


FIGURE 1

3. Screw in yoke handle (See Fig. 2)
4. To check for proper installation of ball detent assembly, lower yoke slowly to assure ball detent is seated properly. The yoke should now lock in the key load position.



FIGURE 2

- Included with your Farnon EXPRESS are three rubber foot pads. Install these on the bottom of the machine, two in the front, one in the rear.

OPERATING PROCEDURE

CAUTION: Always use proper eye protection.

To cut a standard cylinder key, insert original key in left vise, tighten to secure. Insert blank in right vise, tighten to secure (See Fig. 3). To assure proper key alignment, use shoulder stop. Filp shoulder stop to original key and align blank accordingly.

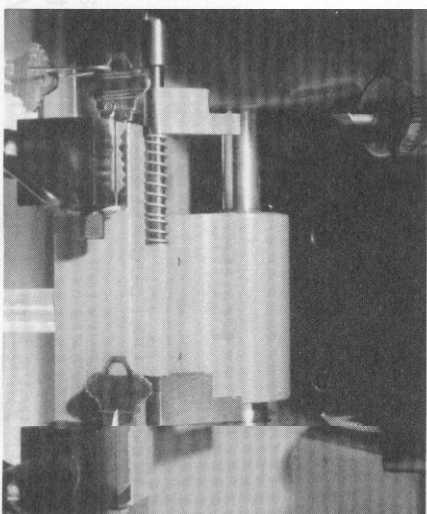


FIGURE 3

NOTES

[illegible]

SHOULDERLESS KEYS

A unique feature of the EXPRESS is the built-in tip stops for shoulderless keys. When cutting a key such as a Ford, the long side of the tip stop, affixed to the right side of the vise with thumb screws, should be used. Slidekey in vise until it touches the tip stop and tighten vise. Use normal cutting procedure explained above.

To cut a Best key, loosen thumb screw on tip stop and rotate so that the short side is aligned with vise and tighten thumb screw. Slidekey in until notch of keyblank touches tip stop.

USING THE ROTATING VISE TOP

The vise top can be rotated so that no shimming is required when cutting narrow keys such as the Maser 1092B. Loosen vise clamp nut enough so that the vise top can be raised and turned 180 degrees. Insert key onto step of vise top and tighten. Follow normal cutting procedure.

In the rare case a key cannot be held by the milling and tips in the vise, two brass shims are provided. These can be cut above or below the blank depending on how they tip in the vise. If the key tips down, place shim under key. If the key tips up, place shim on top of key.

DEEP CUTS

The EXPRESS is adjusted so the cutter and guide will not hit the vises when in the cutting position. If an extremely deep cut is found on a key, push the yoke forward while cutting to reach the proper depth of cut.

ADJUSTMENTS

In the rare case that the machine needs adjustment for spacing or depth follow these procedures.

SPACING

1. Unplug the machine.
2. Remove guarc with allen wrenches provided.
3. Remove belt.
4. Loosen (do not remove) two 1/4 x 28 x 3/4" cap screws located in counterbores to the rear of the casting.

SEMI-AUTOMATIC DUPLICATOR

Part No.	Description
DBSH012	Calibrated Ring
FZSH015	Vise Clamp Nut
FZSH035	Spacing Washer
LM84S	Cutter
LKMS051	Lift Knob
LKMS052	Lever Knob
LKMS053	Plastic Ball Handle
LMSS551	Tip Stop
LKMS601	O Ring Belt
LKMS602	Recessed Bumper
LKMT001	1/4 H.P. Motor
LKSC002	3/8-24 x 1" Left Hand SHCS
LKSH001	Base Casting
LKSH002	Guide Casting
LKSH003	Spindle Casting
LKSH004	Yoke Casting
LKSH007	Detent Rod
LKSH008	Detent Sleeve
LKSH010	Lever Handle
LKSH012	KeyStop Knob
LKSH014	KeyStop
LKSH015	KeyStop Block
LKSH020	Lock Knob
LKSH022	Guide
LKSH023	Vise Bottom
LKSH024	Vise Top
LKSH025	Guard
LKSH027	Thumb Nut

NOTES

ГКН003	Дипирит	
ГКН004	Спид	
ГКН005	Алс 100	
ГКН006	Алс 200	
ГКН007	Спид	
ГКН008	Горк кюр	
ГКН009	Кел 200 блок	
ГКН010	Кел 200	
ГКН011	Кел 200 кюр	
ГКН012	Горк кюр	
ГКН013	Спид 200	
ГКН014	Спид 200	
ГКН015	Спид 200	
ГКН016	Спид 200	
ГКН017	Спид 200	
ГКН018	Спид 200	
ГКН019	Спид 200	
ГКН020	Спид 200	
ГКН021	Спид 200	
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ГКН099	Спид 200	
ГКН100	Спид 200	

CAUTION: Cutter damage may result if shoulder stop is not lowered.

Turn on the machine with on/off switch which is located in the rear of the machine, affixed to the motor.

Once keys are properly aligned, grasp yoke handle and pull out ball detent knob. The yoke is spring loaded and care should be taken not to release yoke handle. Damage could occur if yoke hits cutter or guide. Slowly raise yoke, lining up guide and first cut on original key with lever handle (See Fig. 4).

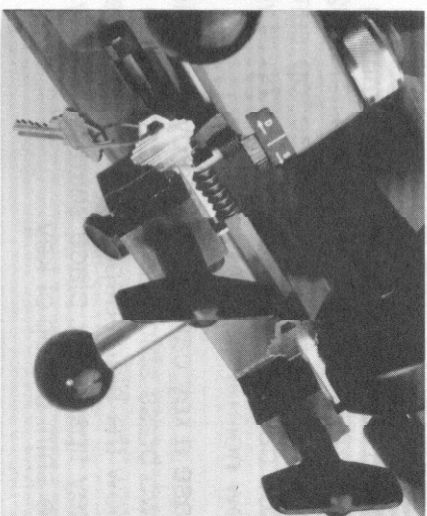


FIGURE 4

NOTE: The EXPRESS cuts at a very high speed. Due to varying blank thicknesses, it may cut some keys faster than others. With some practice, you will acquire an ear for proper cutting speed.

The first pass of a key should always be from left to right, or bow to tip. Grasp lever handle and move carriage through all cuts on the key, stopping at tip of key. Make a second pass from right to left, stopping after the number one cut is completed. Due to the thickness of some blanks, an additional pass may be required, or a slower first pass.

This procedure should be followed to cut all keys. Please read on for cutting tips for shoulderless keys, deep-cut keys, and small keys that fall below the edge of the vise.

WARRANTY

The warranty on the Framon EXPRESS machine is in effect for a period of one year from the date of purchase. Framon Mfg. will replace all or any part of the machine proven to be defective in material or workmanship. If any machine is returned to us in the first year, Framon Mfg. will absorb all cost for repairs, including freight. After one year Framon Mfg. will charge the customer for parts, freight and a flat service rate for labor. Machines will be repaired and shipped within two days of receipt. This warranty is valid to the original purchaser only. Cutters are not covered by this warranty. Framon cutters are among the finest cutters made today, but we have no control over their use.

5. Loosen 10/32x 3/8" cap screw.
6. Load two identical blanks, one in each vise and raise yoke so guide is resting on tip of key.
7. With slight pressure, move bearing assembly so that cutter rests or tip of key blank.
8. Tighten 10/32x 3/8" cap screw, maintaining proper alignment.
9. Tighten 1/4 x 28 x 3/4" cap screws.
10. Reinstall belt and guard.

DEPTH

1. Unplug machine.
2. Loosen jam stop (See Fig. 5).

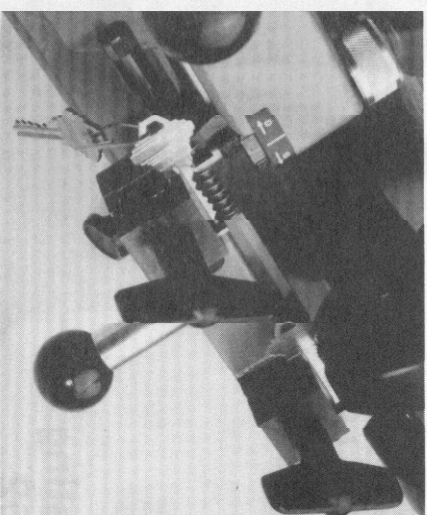


FIGURE 5

3. Push jam stop towards front of machine to relieve pressure on depth dial.
4. The depth dial is graduated in thousandths of an inch. Rotate dial deeper or shallower accordingly.
5. Tighten jam stop, maintaining proper depth.

If you encounter any problems adjusting your machine, feel free to call Framon Manufacturing at (517) 354-5323, 8 a.m. to 4:30 p.m. EST.

Lever Knob
LKMS052

Calibrated Ring
DBSH012

Lever Handle
LKSH010

Key Stop Knob - LKSH012
Key Stop - LKSH014
Key Stop Block - LKSH015

Guide Casting
LKSH002

CARTON INCLUDES:

- 1 Express Duplicator
- 1 Instruction Manual
- 1 LKMS401 5/16" Allen Wrench
- 1 ASMS003 3/16" Allen Wrench
- 1 TKMS403 5/32" Allen Wrench
- 1 LKMS402 1/8" Allen Wrench
- 2 LKMS410 Shims

1/4 H.P. Motor
LKMT001

3/8 x 24 x 1" Left Hand SHCS
LKSC002

Spacing Washer
F2SH035

Guide
LKSH022

Cutter
LK84S

Guard
LKSH025

O Ring Belt
LKMS601

Vise Clamp Nut
F2SH015

Spindle Casting
LKSH003

Thumb Nut
LKSH027

Base Casting
LKSH001

Recessed Bumper
LKMS602

Plastic Ball Handle
LKMS053

Yoke Casting
LKSH004

Tip Stop
LKMS551

Detent Rod - LKSH007
Detent Sleeve - LKSH008
Lift Knob - LKMS051

Vise Bottom
LKSH023

Vise Top
LKSH024

