

Some of the early Framon #1 Code machines have a lower vise center than the later machines. Do not attempt to remove and raise the slides. This will prove to be the most difficult means of obtaining the correct center height.

If you have one of these older machines and your conversion kit spindle is too high, please use the following procedure:

Place a Medeco blank in the vise with shims under the blank until the correct center is obtained. Flat steel blanks of different thicknesses are ideal for shims.

When the correct center is obtained, measure the thickness of the shims. This will establish the correction that must be made.

If the base of the spindle must be cut off, the spindle can be taken to any good machine shop or you can return the spindle base to Framon Mfg. Co. with the correct measurements and we will make the corrections and return the base. We can usually return parts via UPS within 24 hours.

Before installing the tilting spindle head on your machine, it is important to know that machines with numbers up to 75225 may need this shim to insure proper height of cutter.

Center of cutter and center of key blank must be at the same height.

Machines with a step cut on the top of the key block carriage will not need this shim.

Machines without a step cut in the key block carriage will need this shim.

To check the height after the conversion is complete, follow these instructions.

Insert a Medeco blank in the key vise; make a slight cut on the blade of the key blank at all three angle settings. Do not change spacing. If the height is correct, all three cuts will intersect at the center of the blade.

Cutter too high

Cutter correct

Cutter too low

Instructions to convert Framon #1 Code machine to cut Medeco and Emhart keys.

1. Remove belt guard, belt and cutter FC8445.
2. Remove old spindle bracket.
3. Place new spindle bracket on machine.
4. Replace 4 cap screws and tighten only to the point that allows movement of new bracket. Push bracket rearward against screws. While holding bracket in this position, tighten all screws.
5. Install new pulley, belt and cutter FC8445.
6. Replace belt guard using a ¼-28x1/2 cap screw at rear and a ¼-28x1-½ cap screw at front. Be sure 1" riser block is used under front leg of guard. Raising the front of the guard allows room to tilt arbor.
7. Remove old spacing block and install new spacing block, which has .170 spacing for Medeco and .156 for Emhart. Readjust machine as per instructions in Depth and Space book.

To install unit on your code machine, the following instructions should be used.

1. Remove belt guard.
2. Drill 4 holes at positions shown on drawing (use a #3 drill). Tap holes with ¼-28 tap.
3. Install the unit using ¼-28 x ½ cap screws.
4. Mount motor to unit using 4 ¼-28-x ½ cap screws with washers.
5. Install line switch to cord and motor wiring and plug in unit.

Note: If motor runs in reverse direction, rotate plug in power supply and motor will run in proper direction (rotating plug changes polarity). To change from 110 to 12v simply change belt from one motor to the other.