

Mfg: Tibbe 6 Wafer

Series: 1-1060

Models: Scorpio

Blank: S30FDIP

Set Start at: .060 Tip end

Set Depth at: .240 (see instructions)

Spacing: .080

Block #: 3

No of Spaces: 6

No of Angles: 4

Bitting is 4 cuts at each space (24 cuts total).

Use .088 carbide slotter furnished with Tibbe kit.

Read instructions before cutting these keys.

Mfg: Tibbe 8 Wafer

Models: Jaguar

Blanks: S32FJ-P, S33FJ-P

Set Start at: .060 Tip end

Set Depth at: .240 (see instructions)

Spacing: .080

Block #: 3

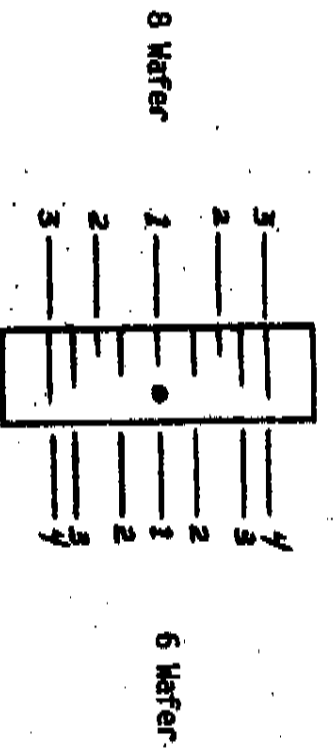
No of Spaces: 8

No of Angles: 3

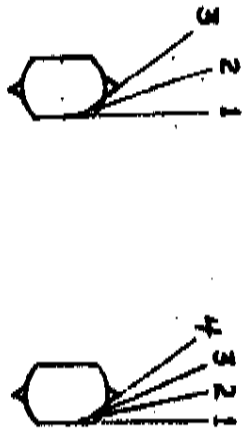
Bitting is 4 cuts at each space (32 cuts total).

Use .088 carbide slotter furnished with Tibbe kit.

Read instructions before cutting these keys.



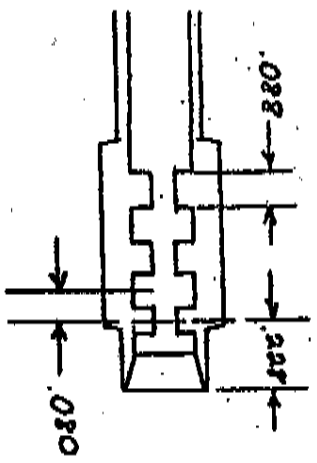
Drawing #2



8 Wafer Angles

6 Wafer Angles

Drawing #3



Drawing #4

Spacing Measurements for both 6 wafer and 8 wafer.

Release the clamp and rotate the blank to align mark #3 on the other side of dot and make the second cut. Loosen the clamp nut and rotate the blank 180 and make 2 cuts in the same manner on the opposite side of the blank. After all 4 cuts are made, turn the spacing crank clockwise to the next mark on the spacing block and make a #2 cut on all four sides in the same manner. Follow this procedure until all cuts are made.

NOTE The 6 wafer blank is used on Ford.

The 8 wafer blank is used on Jaguar.

6 wafer keys have 4 angles and 6 cuts.
8 wafer keys have 3 angles and 8 cuts.

A NOTE ON SPACING:

The center of the first cut is .228 from the tip of the blank. If the key is not cutting properly, change the starting cut to suit your machine. Drawing #4 shows points to measure from. Once the starting cut and depth measurements are obtained for your machine, they will remain the same for all Tibbe keys.



Drawing #1



Figure 1A



Figure 1B

The Tibbe fixture for the Framon Code Machine is designed to cut both 6 wafer keys and 8 wafer keys. The only difference in the blanks is the length of the cutting surface.

To install the fixture on your machine, remove the standard vise and replace it with the Tibbe fixture. The calibrated ring goes to the operator's right. Tibbe keys are inserted from the left side of the vise (see drawing #1).

The cutter on the machine must be replaced with the .088 slotter furnished with the fixture. This is a solid carbide cutter and can also be used to cut locker and safety deposit box keys on the machine. Remove whatever cutter is on the spindle. Install the wide spacer, the .088 slotter, washer and nut in this order onto spindle.

Insert the blank from the left side of the vise. The tip of the blank must be in the slot of the indicator ring. Be sure the blank is in all the way and tighten the vise clamp nut. The number one cut position must be aligned with the white mark on the fixture (#1 cut is the one with the dot next to it - see drawing #1).

Turn the spacing crank counterclockwise to move the vise all the way over to the left to stop, then back to "0" start - this is the same spacing position you would use to cut any key. Turn the spacing crank clockwise until the blank is in approximate position shown in Figure 1. NOTE: Count all your turns. This procedure will give each machine a starting cut for all Tibbe keys. The right hand side of the cutter is close to alignment with the left side of the indicator hub (the hub is the part that the tip of the key fits into). Go slightly beyond the cutter and pull the feed handle to bring the cutter to the position shown in Figure 1A. Rotate the crank counter-clockwise until the hub just touches the right hand side of the cutter. Rotate the spacing crank clockwise .060 and make a note of this measurement. This will be your starting cut for all Tibbe keys. Use the spacing block with .080 spacing (#3) and align the spacing block to the pointer.

Set the depth setting at .240, pull the feed handle up to the stop and hold it there. Rotate the pulley in reverse of the cutting rotation. If the cutter touches the blank, back off slightly until the cutter is as close to the blank as possible without touching it. NOTE: The #1 cut is a no cut. If any material is removed from a #1 cut, the key will not operate properly and all other angle cuts will be wrong. Once you have the depth correct, read the depth setting for your machine and make a note of it. This will be your depth setting for all Tibbe keys - both 6 & 8 wafer.

Once the depth and space settings have been made, you are ready to cut keys. If you have a combination of 321234 from tip to bow, release the clamp nut and rotate the blank to the #3 mark on the indicator (see drawing #2) and pull the feed handle to make the cut.