Read instructions before cutting these keys.
Use 0.065 carbide slotter furnished with Toffee Kit.
Boring is 4 cups at each space (42 cups total).

No of Angles: 3
No of Spaces: 8
Block #: 3
Spacing: 0.80
Set Depth at 2.40 (see instructions)
Set Start at 0.60 Tip End
Blanks: S3ZFP, S33FP
Models: Jaguar

Higher: Toffee St. Wafter
Procedure until all cuts are made:

1. Make a #2 cut on all four sides in the same manner. Follow this spacing crack closely to the next mark on the spacing block and opposite side of the blank. After all 4 cuts are made, turn the blank 90° and make 2 cuts in the same manner on the edge of the blank. Make the second cut, loosen the clamp nut and release the clamp and remove the blank to align mark #5 on the other

NOTE: The g water blank is used on Jaguar.

NOTE: The g water keys have 4 angles and 6 cuts.

A NOTE ON SPACING:

- g water keys have 3 angles and 6 cuts.

remain the same for all type keys.

Depth measurements are obtained for your machine, they will be 2 1/4" from the tip of the blank if the key is not cutting properly, change the spacing cut to suit your machine. The center of the first cut is 2 1/4" from the tip of the blank. If the key

FIGURE 1A

D.R. #2
Once the depth and space settings have been made, you are ready to:

- Make a note of 0′. This will be your depth setting for all three keys.
- Have the depth corrector (see Figure 1A) and all other angle cuts will be made. If you do not have a combination of 0′C or 0′D, from tip to back.
- Release the clamp unit and remove the blank to the 7.5 mark on the X-scale. If you have a combination of 0′C or 0′D, from tip to back.
- Make a note of the angle setting for all three keys.
- Use the spacing block to space the angles correctly.
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