

**MACHINE CARE:** Keep machine clean. Use light machine oil in oil cups, and to lubricate sliding parts.

**ADJUSTMENTS:** *To adjust depth of large cutter and guide*, put two identical flat blanks in the flat jaws of the machine. Adjust vise assembly height as if you were cutting a key. Loosen set screw at top of key guide, and move guide until it and cutter both just touch blanks. Tighten set screw.

*To adjust spacing of large cutter and guide*, remove keys from jaws and adjust cutter and guide to right sides of empty jaws.

*To adjust spacing of small cutter and guide*, remove keys from jaws and adjust cutter and guide to left sides of empty jaws.

The Steel King is distributed by:

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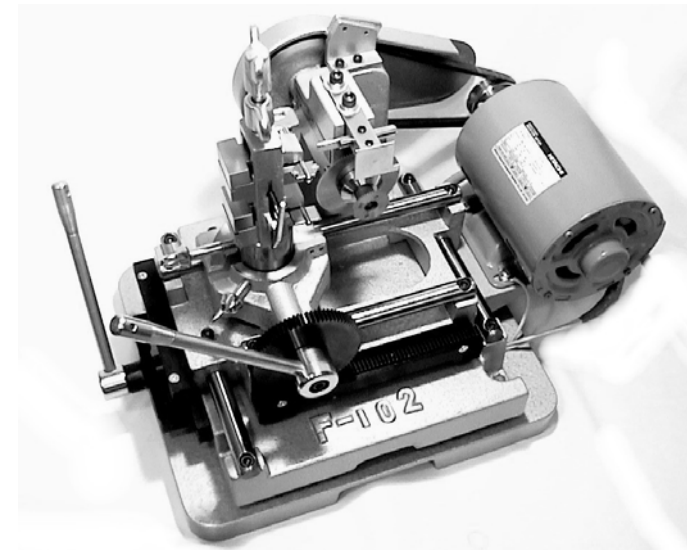
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CONGRATULATIONS ON  
YOUR PURCHASE OF THE

## STEEL KING™

Key Duplicating Machine



This machine is designed to duplicate safe deposit keys, warded padlock keys, and bit type keys. Through the use of two cutters and extremely versatile key vises, keys can receive cuts on different edges without being removed from the vise.

**RELEASING THE CARRIAGE:** The machine is shipped with the carriage locked down to prevent damage. Loosen the two screws that lock the carriage to permit full travel.

**KEY VISE ASSEMBLY:** Note there are two large wing nuts atop the key vise assembly. The upper nut operates the lower jaw, and the lower nut operates the upper jaw.



The entire vise assembly can be rotated to various positions and locked in place. One side of each jaw is designed for flat steel keys; the opposite side is for bit keys.

*The bar stock that is shipped in the jaws*

*must remain in place when cutting flat keys in the opposing jaws.*

In addition to rotating, the height of the vise assembly can be adjusted and locked in place using the small wing nut at the base of the assembly.



## CUTTING KEYS

**CAUTION: WEAR EYE PROTECTION WHEN CUTTING KEYS, AND TURN MOTOR OFF WHEN INSERTING OR REMOVING KEYS FROM VISES.**

**FLAT KEYS:** Rotate vise assembly so the flat jaws are facing the cutter and tracer. Make sure the round rods are in the jaws facing you. Mount the keys in the jaws with the bows to your left, using the cutter and copy guide for alignment. Raise or lower the vise assembly so the blank meets the cutter exactly on center.

Use straight in and out motions to move keys towards and away from cutter.

**BIT KEYS:** Rotate vise assembly so the round jaws are facing the cutter and tracer. (Make sure the rods are removed.) Mount the keys in the jaws with the bows to your left, using the cutter and copy guide for alignment. (Keys longer than 4 inches may have to be mounted with the bows to the right, making it necessary to remount the keys for additional ward cuts.)

Raise or lower the vise assembly so the blank meets the cutter exactly on center.

Additional end and side cuts can be made by turning machine off, then rotating and locking key vise assembly to required position. Restart machine and complete cutting process.