

Instructions



Pocket Cut-Up™

No. TKM-90



HPC's Pocket Cut-Up™ is a compact, portable tubular key machine. It is hand-operated, so it does not need electricity. By turning the knob, the carbide cutter easily cuts brass and steel key blanks. It cuts standard-size tubular keys by code with spacing for 7-pin center, right offset, and left offset, as well as 8-pin keys. It comes with the HPC Tubular Key & Pick Decoder.

The Pocket Cut-Up™ cuts depths with the standard .016-inch increment. The Depth Plate is marked with numbers 0 – 7. Numbers 1 – 7 correspond to Chicago Ace depths 1 – 7. The 0 is the starting point for setting depths and equates to a Chicago Ace 8 depth. The depths can be translated to Fort Lock depths using the following chart.



Center



Right Offset



Left Offset



8-Pin

Pocket Cut-Up™ Depth Knob	equals→	Chicago Ace depth	equals→	Fort Lock depth	equals→	Depth (in inches)	equals→	Depth (in mm)
1		1		0		0.016		0.41
2		2		1		0.032		0.81
3		3		2		0.048		1.22
4		4		3		0.064		1.63
5		5		4		0.080		2.03
6		6		5		0.096		2.44
7		7		6		0.112		2.84
0		8		7		0.128		3.25

Pocket Cut-Up™ Instructions (continued)



Cutting A Key

Remove the Key Retaining Plate from the base (Fig. 1).

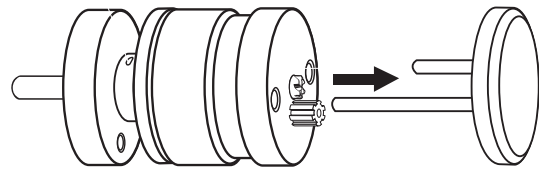


Fig. 1.

Place the key blank on the Key Positioning Post with the first space of the blank positioned at the cutter. Take note of the proper starting point and sequence for the key you are cutting (fig. 2).

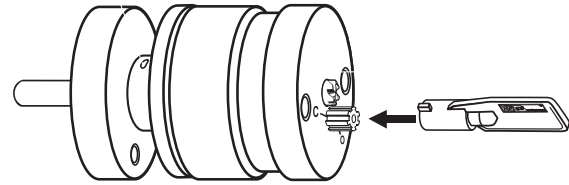
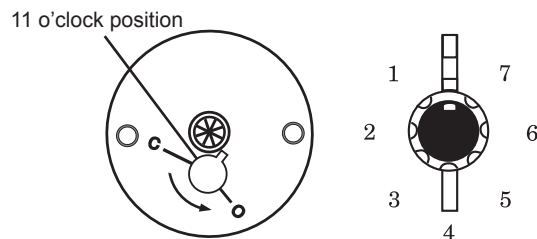


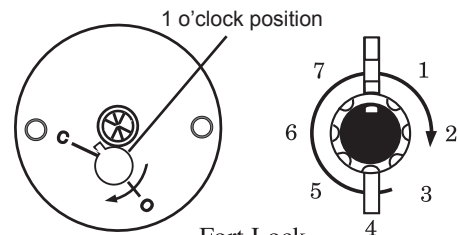
Fig. 2.

For Chicago Ace the first space is at the 11 o'clock position when looking at the barrel of the key blank. The tang on the blank will be to the right of the cutter and the key will be rotated counter clockwise (Fig.3).



Chicago Ace®
Fig. 3.

For Fort Lock the first space is at the 1 o'clock position when looking at the barrel of the blank. The tang will be to the left of the cutter, and the key will be rotated clockwise (Fig. 4).



Fort Lock
Fig. 4.

To set the depth of each cut, turn the depth plate clockwise until it touches the main housing. The indicator line on the main housing should read between a "0" and a "1" in this position. If it does not, recalibration may be necessary as described later in these instructions (Fig.5).

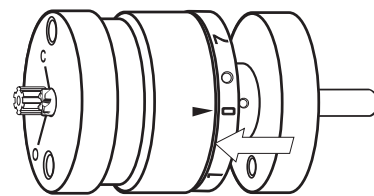


Fig. 5.

Then turn the depth plate counterclockwise to line up the desired depth with the indicator line. As you turn counterclockwise the first number you reach will be a "0" which is actually an "8" (the deepest cut). The other numbers correspond to the Chicago Ace depths 1 through 7 (Fig. 6).

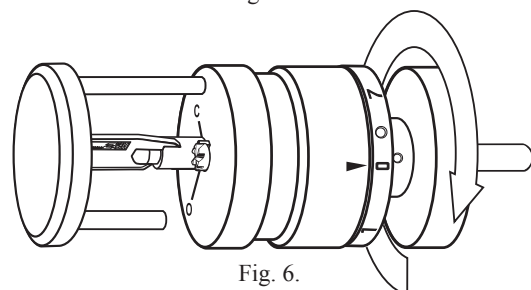


Fig. 6.

(continued)

Pocket Cut-Up™ Instructions (continued)



With the key on the positioning post, and set in the first position to be cut, place the long post on the key retainer into the hole closest to the "C" mark and the short post into the other hole. The long post will lock the depth plate into position to eliminate movement during the cutting process (Fig. 7).

Holding the unit horizontally as shown, you will notice a small space between the depth plate and the cutter handle that indicates the actual depth of the cut (Fig. 8).

Turning the cutter handle in a clockwise direction, (turning in opposite direction may damage the cutter) while pressing slightly on the cutter handle will cut the key. The space between the depth plate and the cutter handle will close. When the cut is complete the handle will turn freely (Fig. 9).

Raise the Key Retaining Plate, rotate the key blank to the next space, (Fig. 10) and set the depth to the appropriate number for the second space (Fig. 11). Lock the Depth Plate into position (Fig. 7). Push in and turn the cutter handle until the cut is completed (Fig. 9). Repeat this procedure for all spaces to complete the key.

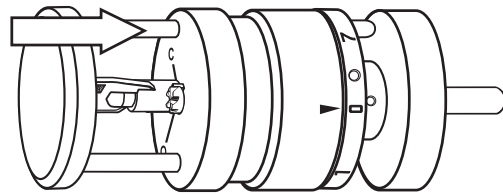


Fig. 7.

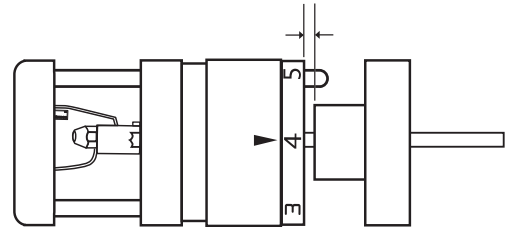


Fig. 8.

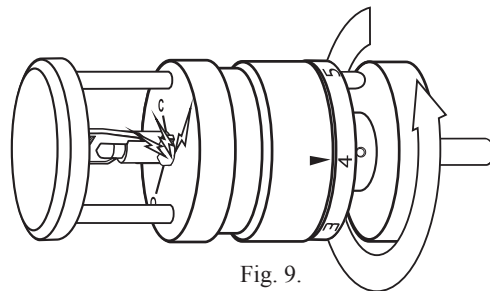


Fig. 9.

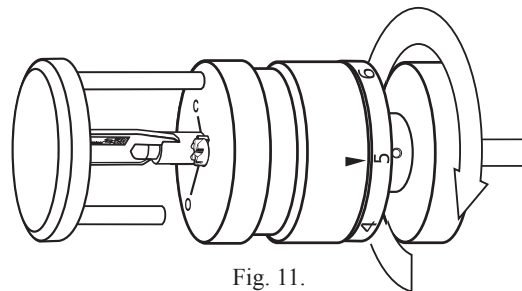


Fig. 11.

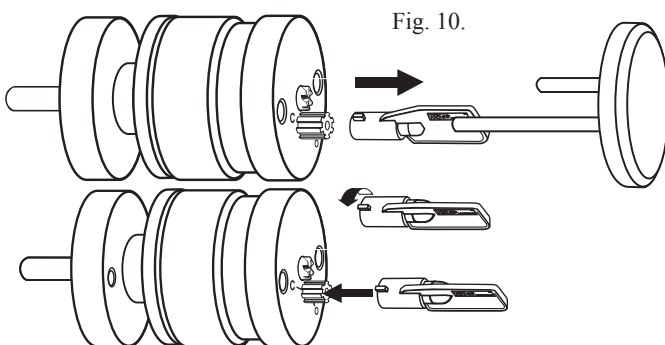
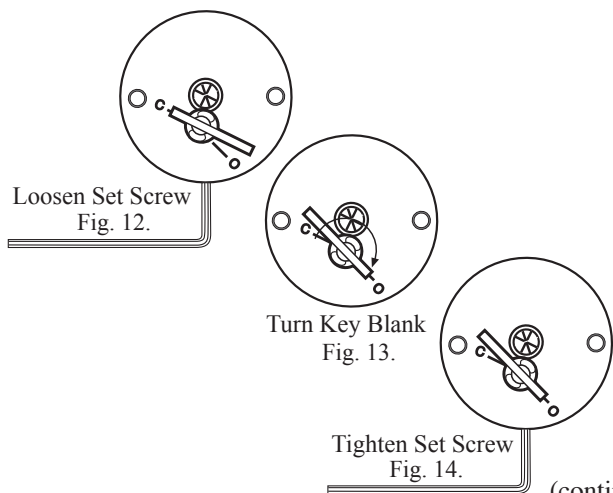


Fig. 10.

Changing From Center to Offset

The Pocket Cut-Up™ was set for center cut keys at the factory. To change the machine to cut offset, place the key blank on the Key Positioning Post with the tip (tang) of the blank pointing to the letter C for center (Fig. 12). Use the Allen wrench to loosen the set screw, then turn the blank so that the tip (tang) is pointing to the O for offset (Fig. 13). Then tighten the set screw. (Fig. 14). To go back to center cutting, simply reverse this procedure.



Loosen Set Screw
Fig. 12.

Turn Key Blank
Fig. 13.

Tighten Set Screw
Fig. 14.

(continued)

Replacing the Cutter

To replace the cutter, remove the cutter handle with cutter from the base. Loosen the set screw, remove the old cutter and insert the new cutter. The end of the cutter should protrude approximately 1-inch (2.54 cm) from the bottom (outside) of the cutter handle. (Fig. 15). Replace the cutter handle onto the base. Calibrate the depths as needed using the following procedures.)

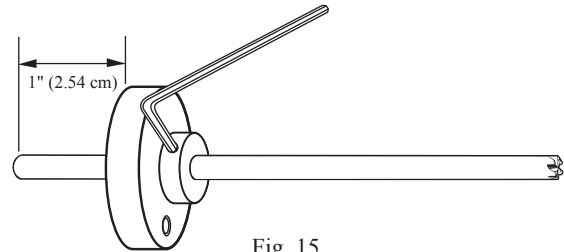


Fig. 15.

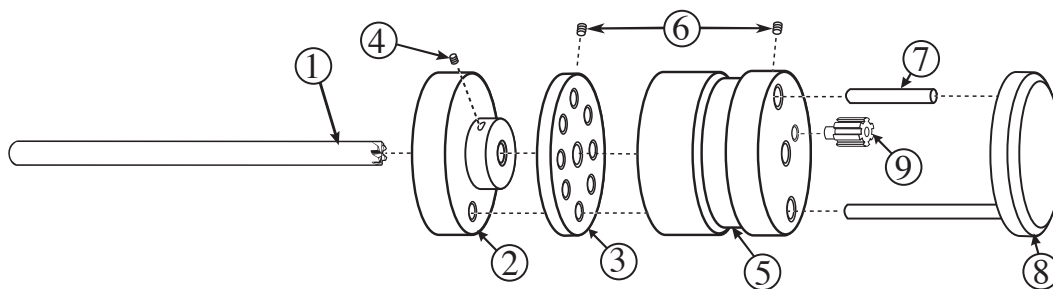
Calibrating the Depths

If calibration becomes necessary, due to cutter replacement or other means, you must first turn the depth plate clockwise until it touches the main housing and take a reading to ensure that the indicator line on the main housing reads between a "0" and a "1". If not, then loosen the set screw and rotate the depth plate while maintaining pressure against the main housing and tighten in the proper position. Then insert a blank (uncut) key into the unit with the tang positioned at the "C" position, and turn the depth plate one full revolution to a "0" (not the deepest cut, but a NO cut position). Install the

key retainer to hold your depth position during recalibration of the cutter.

Loosen the set screw on the cutter shaft, holding the cutter handle against the depth plate, and push or pull the cutter until it just barely scrapes the key blank (in effect a zero or NO cut). Tighten the cutter set screw in this position. Be sure to engage the flat on the cutter shaft before tightening. Test cut some keys to ensure proper depths are achieved as per the chart listed earlier in these instructions.

Components



1. Cutter	CW-TKM	6. Set Screws (2)	TKM-08
2. Cutter Handle	TKM-02	7. Short Key Retaining Post	TKM-11
3. Depth Plate	TKM-03	8. Key Retaining Face Plate	TKM-12
4. Cutter Retaining Screw	TKM-04	9. Key Positioning Post	TKM-09
5. Main Housing	TKM-07		