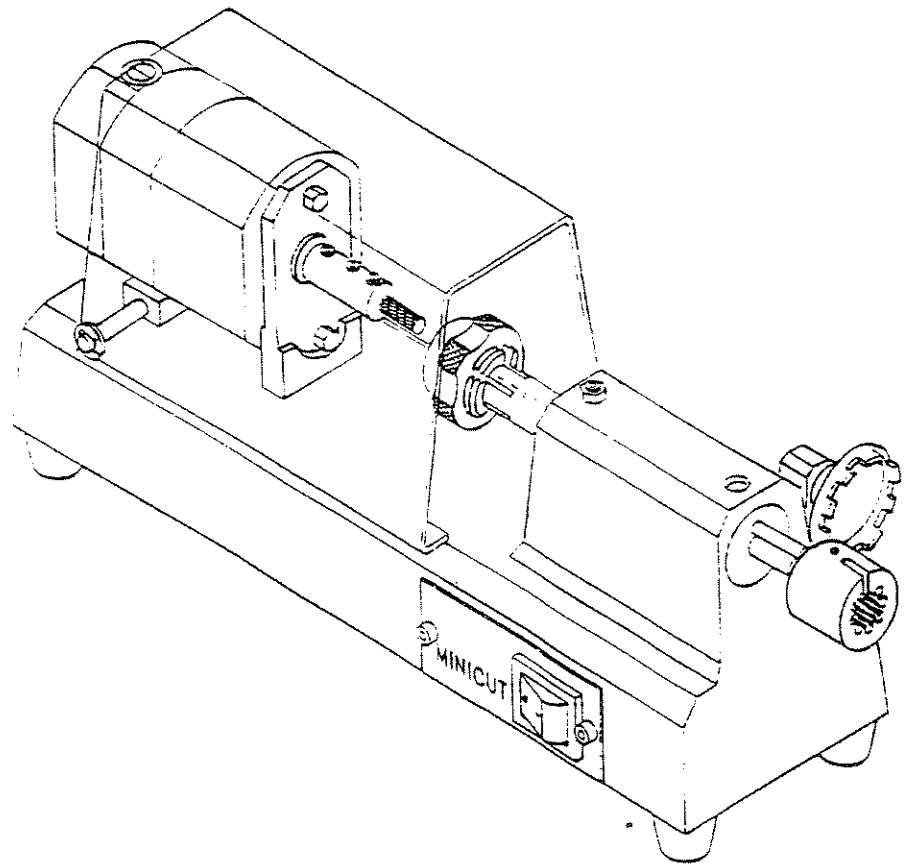


TD95

**ORION**  
OPENS THE WORLD

# MINICUT



1994

**ORION**  
OPENS THE WORLD

Via Mercatelli SanrAnna, 6  
P.O. Box 4  
31030 Colfosco di Susegana  
(Treviso) Italy

Tel. (0438) 780155/6-780308  
Telex 420617 ORION I  
Telefax (0438) 781088



Macchine duplicatrici per chiavi - Chiavi per serrature - Accessori

Key cutting machines - Key blanks - Accessories

## MINICUT INSTRUCTIONS:

### Copying a key :

It is possible to copy keys even with the machine equipped to cut keys by code: in this case before starting to copy a key remember to remove the cam ( Pulling it from its seat) or to turn it so that when the spacing ring is pushed forward it goes to rest against the lower tooth of the cam.

- Insert the key blank in the collet chuck making sure that the key does not protrude from the chuck, then fix it slightly with the screwed ring (Pic. 1).

- Insert in the spacing ring (1, Pic 2) a key blank (2, Pic. 2) and push it forward until it rests against the guide (3, Pic. 2). Keeping the key leaned against the guide loosen the screwed ring until the key (4, Pic. 2) goes to rest against the cutter (5, Pic. 2), then fix the key in that position tightening again the screwed ring.

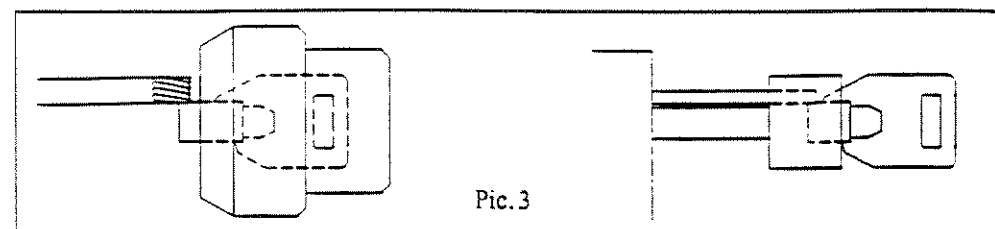
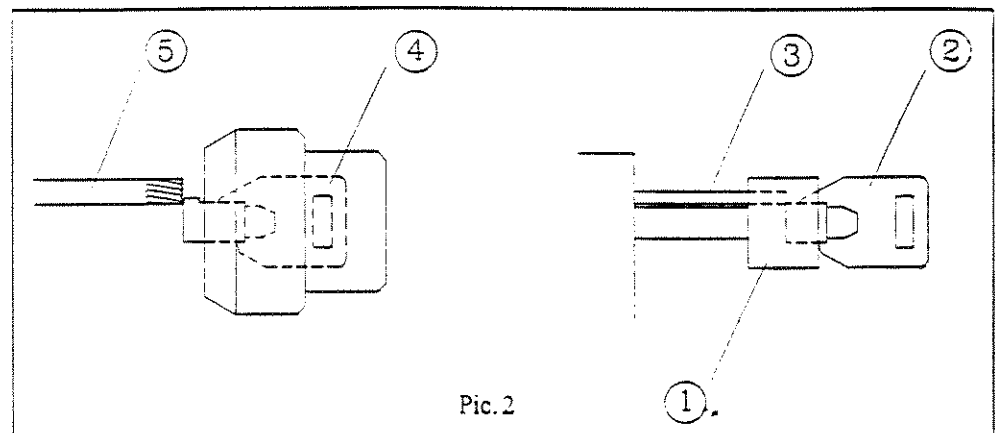
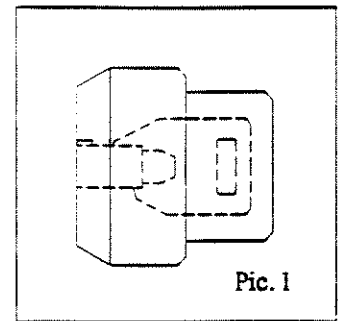
The meaning of this operation is to align transversally the 2 keys.

- Replace the key blank (2, Pic. 2) with the pattern key.

- Start the cutter.

- Push forward the pattern key holding it by the head until the guide enters the first hole and rests against the first cut of the pattern key : correspondently the cutter will cut the key blank (Pic. 3).

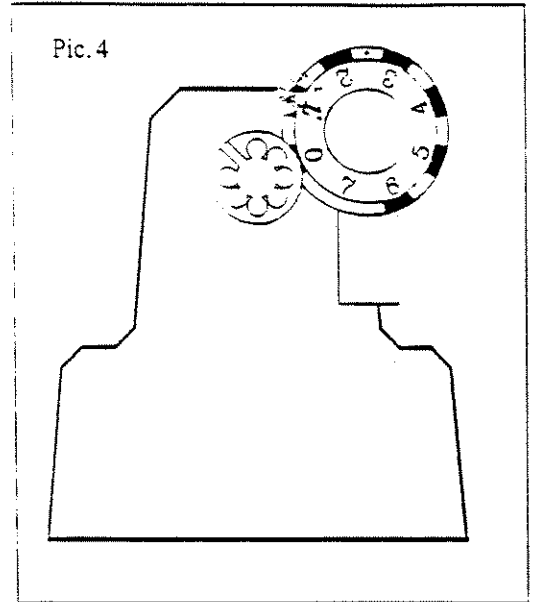
- Repeat this procedure with all the other cuts.



**To cut by code :**

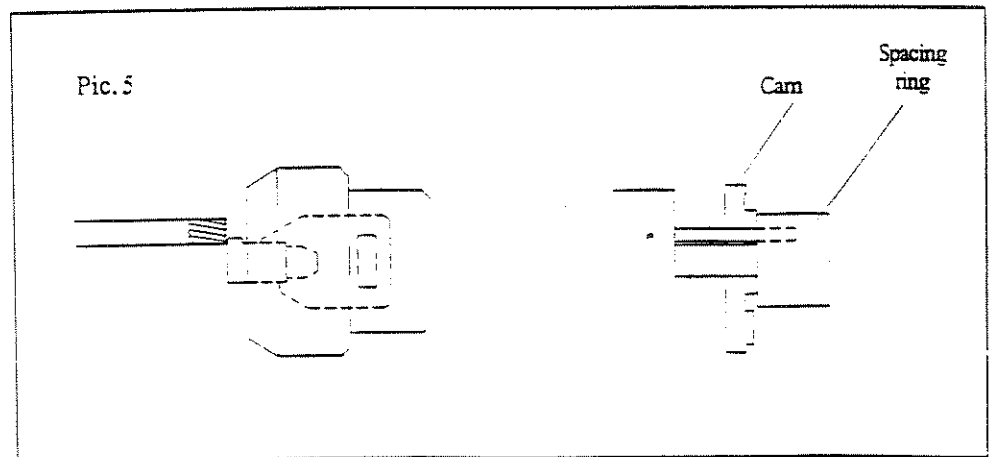
The first thing to do in order to do a proper cut is to align transversally the key blank. Follow these instructions to do it :

- Turn the cam so that when the spacing ring is pushed forward it goes to rest against the higher tooth of the cam (Pic. 4).
- Insert a key blank in the collet chuck making sure that the key does not protrude from the chuck and fix it slightly with the screwed ring (Pic. 1).
- Push forward the spacing ring until it rests against the higher tooth of the cam. Keeping the spacing ring leaned against the cam loosen slightly the screwed ring until the key blank goes to rest against the cutter (Pic. 5), then fix the key blank in that position tightening the screwed ring. The key blank is now correctly aligned and you can proceed with the cutting operations:
- Turn the cam in order to choose the depth corresponding to the first cut.
- Start the cutter.



- Push forward the spacing ring, making sure that the guide enters the first hole. until it rests against the selected tooth : the cutter will correspondently do the first cut on the key blank.
- Repeat the same procedure with the other cuts.

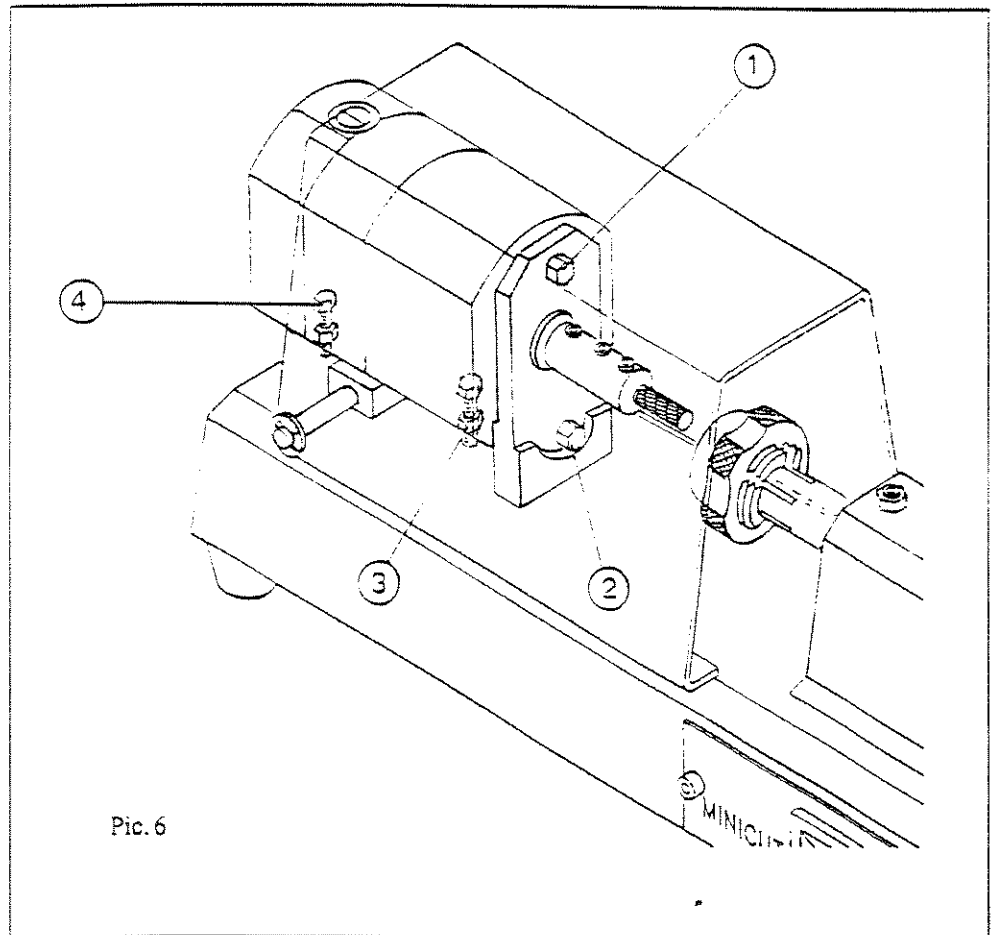
N.B. The direction of the cuts may change from key to key.



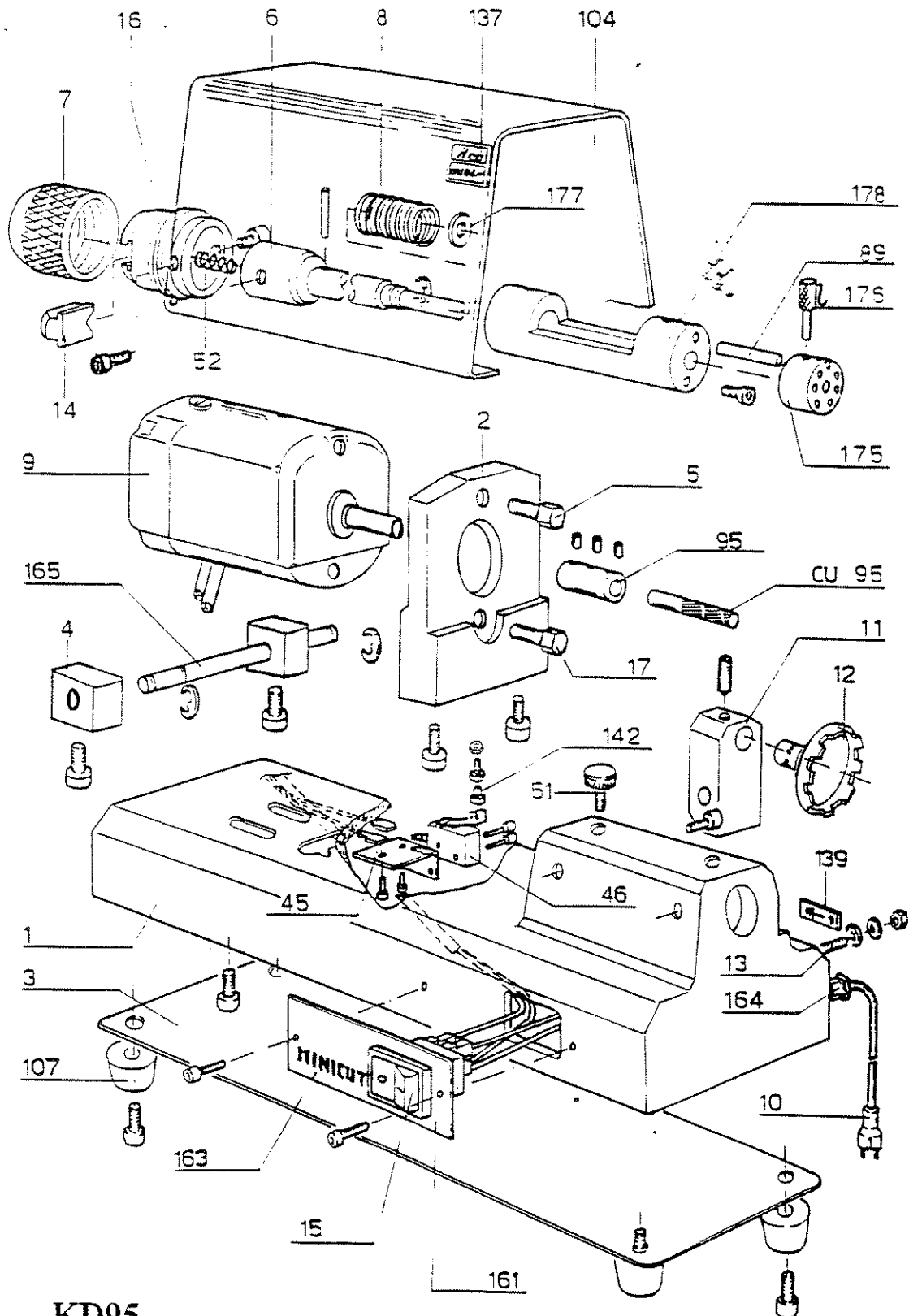
### Vertical adjustment of the cutter :

If a vertical adjustment of the cutter position, and thus of the cutting depth, is necessary, follow these instructions :

- Loosen slightly the 2 motor blocking screws (1-2, Pic. 6).
- Loosen slightly the counternuts of the 2 adjusting screws (3-4, Pic. 6).
- Screw or unscrew, according to necessity, screw 3 (Pic. 6) until the cutter position is adjusted.
- Once the cutter position is correct tighten the 2 motor blocking screws (1-2, Pic. 6).
- Bring screw 4 (Pic. 6) to rest against the motor surface and tighten again the counternuts.



N.B. The Minicut machine allows to duplicate tubular keys with a number of cuts other than 7. To do this it is necessary to remove the spacing ring (pulling the pin which fix it to the shaft). The key must be inserted directly on the shaft and cut accordingly to the instructions contained in the paragraph "Copying a key".



**KD95**  
1994

ORION S.p.a.

## KD95 PARTS LIST

22 feb 1994

Ilco Cod.	Orion Cod.	Description	Pieces
1	MC273001	HOUSING KD95	1
2	MC273002	MOTOR SUPPORT	1
3	MC208038	HOUSING	1
4	MC273004	SUPPORT PROTECTION	1
5	MC273005	BLOCKING MOTOR UPPER SCREW	1
6	MC273006	AXE SUPPORT	1
7	MC273007	BLOCKING SCREW FOR AXE	1
8	MC273008	SETTING SPRING AXE	1
9	MC208058	MOTOR 110V	1
10	MS200213	POWER CORD	1
11	MC273011	CAM SUPPORT	1
12	MC208076	CAM	1
13	MS200064	GROUNDING STUD	2
14	MC273014	CHUCK FOR BLOCKING KEY	2
15	MS200131	GENERAL ON/OFF SWITCH	1
16	MC273015	BUSH FOR CLAMP	1
17	MC273017	BLOCKING MOTOR LOWER SCREW	1
45	MC208056	MICRO SUPPORT	1
46	MC208060	MICRO SWITCH LEVER	1
51	SR216019	CLAMP SCREW	1
52	MC208014	KEY SETTING SPRING	1
89	MC208016	GUIDE FOR MINICUT	1
95	MC273003	WASHER FOR CUTTER	1
104	MC208020	PROTECTION	1
107	MS200135	RUBBER FOOT	1
137	MS200203	ILCO-ORION LOGO	1
139	MS200063	GROUNDING LABEL	1
142	MS208057	MICRO -STUD	1
161	MC208005	SWITCH METAL PLATE	1
163	MC208006	SWITCH PLATE	1
164	MK260078	STRAIN RELIEF BUSHING	1
165	MC208021	SHAFT PROTECTION	1
175	MC208015	DIVISION RING	1
177	MC273010	RING RETAINER SPRING	1
178	MC273009	AXE GUIDE	1
CU95	MK260089	CUTTER	1
176	MC208806	ASS.PLUS	1
12	MC208077	CAM S1	1