

FLASH *008*

Operating Manual
Translation of original instructions

D445858XA

vers. 7.0

CE

EN



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The Manufacturer reserves the right to alter the information without prior notice, except when they affect safety. This document or any of its parts cannot be copied, altered or reproduced without written authorization from the Manufacturer. Keep the manual and look after it for the entire life cycle of the machine.

The information has been drawn up by the manufacturer in his own language (Italian) to provide users with the necessary indications to use the key-cutting machine independently, economically and safely.

IMPORTANT NOTE: in compliance with current regulations relating to industrial property, we hereby state that the trade-marks or trade names mentioned in our documentation are the exclusive property of authorized manufacturers of locks and users.

Said trade-marks or trade names are nominated only for the purposes of information so that any lock for which our keys are made can be rapidly identified.

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USE OF THE MANUAL

This manual has been drawn up by the Manufacturer and is an integral part of the machine literature. The manual gives information that is obligatory for the operator to know and which makes it possible to use the machine safely.

User's Manual

This user's manual is provided because it is essential for proper use and maintenance of the machine. The manual must be kept carefully throughout the life of the machine, including the decommissioning stage. Keep in a dry place close to the machine where it is always at hand for the operator.



ATTENTION: IT IS OBLIGATORY to read the manual carefully before using the machine.

Readers' characteristics

This manual must be read and its contents acquired by those who will use the machine.

Manufacturer's ID

FLASH 008 has an ID plate located on the right side of the machine, showing the serial number.

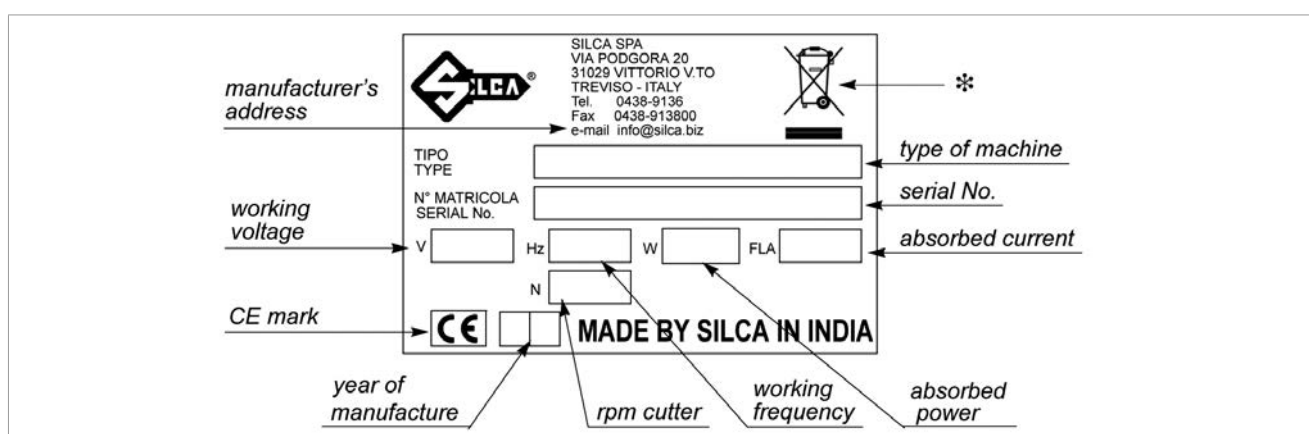


Fig. 1

(*) see chap. 7 DISPOSAL.

How to apply for after-sales service

Silca provides purchasers of the FLASH 008 with After-Sales Service. For the total safety of the operator and machine, any service not described in the manual must be carried out by the manufacturer or in the special Service Centres recommended by Silca.

At the end of the manual there is a list of manufacturers' and authorized Service Centre addresses; if the manual was downloaded is necessary visit the website to see the contacts (www.silca.biz).

The warranty card attached to the machine covers free repairs or replacement of faulty parts for 24 months from the date of purchase*.

All service must be agreed by to by the user with Silca or the Service Centre.

* Damage caused by negligence or wrong use of the machine by the user will null the warranty.

TERMINOLOGY

For those inexperienced in the subject of keys and key cutting, below is an illustration of the most frequently used terms:

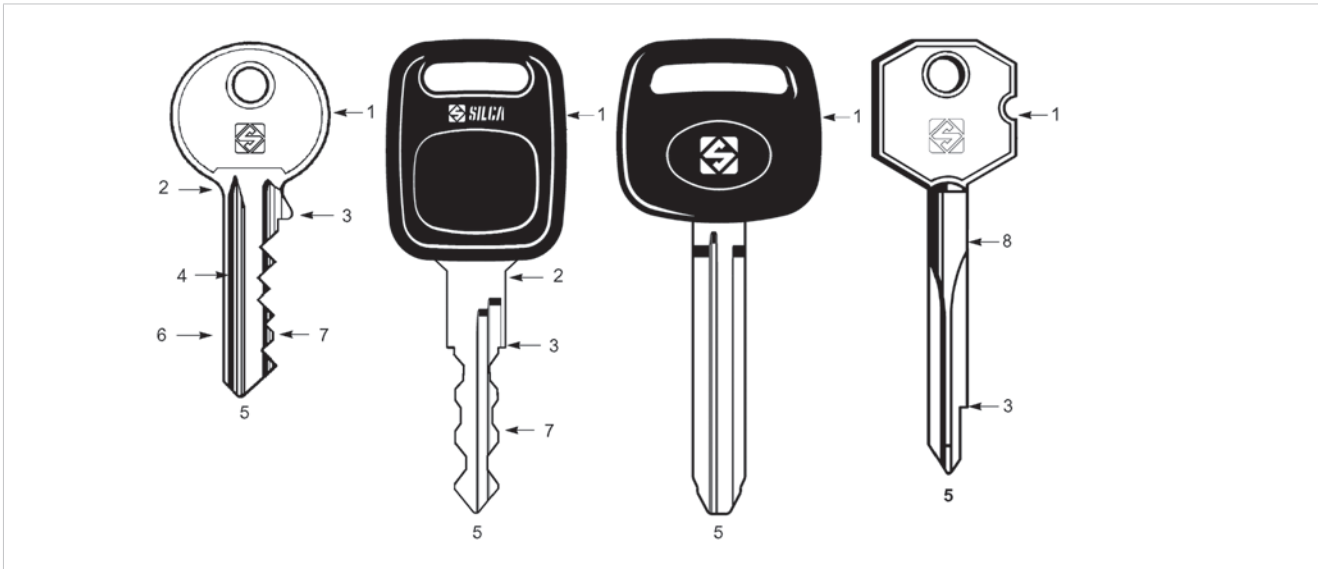


Fig. 2

1) Head	3) Stop	5) Tip	7) Cuts
2) Neck	4) Blade	6) Back	8) Stem

GRAPHICS IN THE USER'S MANUAL

Pay attention	Obligation to read the manual

GRAPHICS ON THE FLASH 008 MACHINE

Obligatory use of safety goggles	Read instructions before use	WARNING! cutting tool in motion	WARNING! presence of electric power
Earth connection (ground)	Caution sticker (only on CSA versions)	Protect from rain (only on CSA versions)	

GENERAL WARNINGS

FLASH 008 is designed to the principles of European Standards (CE). Right from the design stage solutions have been adopted to eliminate hazards for the operator in all the stages of use: handling, regulation, use and maintenance.

The materials used in manufacture and the components employed in using FLASH 008 are not dangerous and ensure that the machine complies with current standards.

Silca S.p.A. has also experimented and applied numerous technical solutions that allow the key-cutting machine to optimize the quality of the cut keys.

To guarantee maintaining these results over time, please follow the instructions below:

- **Observe the procedures described in this manual;**
- **Always use Original Silca Tools as they are designed to make the best of FLASH 008 and provide quality key-cutting;**
- **Use Silca key blanks, made with top quality materials;**
- **Have the key-cutting machine checked periodically by an authorized Silca After-Sales Service Centre;**
- **Always use Silca Original Spare Parts. Beware of imitations!**

NORMAL USE

FLASH 008 key-cutting machine must be installed and used according to the rules and specifications established by the manufacturer.

The key-cutting machine must be used only by skilled personnel (professional use).

The FLASH 008 key-cutting machine is designed for use on business or industrial premises (e.g. hardware shops, key cutting centers, etc...).

Any other use different from that indicated in this manual will cause the forfeiture of all customers' rights to make claims on Silca S.p.A. and may be an unknown source of hazard for the operator or third parties.



ATTENTION: negligent use or failure by the operator to observe the instructions in this manual are not covered by the warranty and the manufacturer declines any responsibility in such cases.

SAFETY

The key-cutting machine is built entirely to standards. The operations for which it has been designed are easily carried out at no risk to the operator.

The adoption of general safety precautions (wearing protective goggles) and observation of the instructions provided by the manufacturer in this manual eliminate all human error, unless deliberate.

The key-cutting machine is designed with features which make it completely safe in all its parts.

RESIDUAL RISKS

There are no further risks arising from the use of the machine.

SAFETY REGULATIONS

- **Always disconnect the machine when it is not in use or when performing maintenance operations.**
- **Check the electrical wiring periodically; replace any wires that show signs of wear.**
- **Always work with dry hands free of grease or oil.**
- **Never pull hard on the power lead and the ferrite cable and make sure they don't come into contact with oil, sharp objects or heat. Never remove the earth (ground) wire from the plug. Make sure the earth (ground) wire connection is sound.**
- **Do not use the machine in dangerous environments (wet or damp).**
- **All visitors, especially children, must stay at a safe distance from the machine and must never come into contact with the electric wiring. This equipment should not be used where children may be present.**

US and Canadian users should read the following instructions with particular attention

GROUNDING INSTRUCTIONS

1. All grounded cord-connected tools:

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Do not modify the plug provided - if it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded.

Use only 3-wire extension cords that have 3-prong grounding plugs and 3-pole receptacles that accept the tool's plug.

Repair or replace damaged or worn cord immediately.

2. Grounded, cord-connected tools intended for use on a supply circuit having a nominal rating less than 150V:

This tool is intended for use on a circuit that has an outlet that looks like the one illustrated in sketch A in Fig. 3. The tool has a grounding plug that looks like the plug illustrated in Sketch A in Fig. 3. A temporary adapter, which looks like the adapter illustrated in Sketches B and C, may be used to connect this plug to a 2-pole receptacle as shown in Sketch B if a properly grounded outlet is not available. The temporary adapter should be used only until a properly grounded outlet can be installed by a qualified electrician. The green-colored rigid ear, lug and the like, extending from the adapter must be connected to a permanent ground such as a properly grounded outlet box.



Exception: in Canada, the use of a temporary adapter is not permitted by Canadian Electrical Code (CEC) C22.1.

3. Grounded, cord-connected tools intended for use on a supply circuit having a nominal rating between 150 - 250 V, inclusive:

This tool is intended for use on a circuit that has an outlet that looks like the one illustrated in Sketch D in Fig. 3. The tool has a grounding plug that looks like the plug illustrated in Sketch D in Fig. 3. Make sure the tool is connected to an outlet having the same configuration as the plug. No adapter is available or should be used with this tool. If the tool must be reconnected for use on a different type of electric circuit, the reconnection should be made by qualified service personnel; and after reconnection, the tool should comply with all local codes and ordinances.

GENERAL INSTRUCTIONS

1. Use original spare parts, accessories and attachments. Contact your local distributor/retailer for a full list of recommended components. Check chapter "Accessories Provided" for the complete list of the accessories provided with this machine and their proper use.



The installation and use of accessories not recommended by the manufacturer may cause harm to people and/or may damage the machine.



Read and observe with attention the instructions included in this manual on the use and handling of the accessories provided with this machine (chapter "Accessories Provided"). Negligent use or failure by the operator to observe the instructions in this manual may be dangerous for the operator, for nearby people and may cause damage to the machine.

2. KEEP GUARDS IN PLACE and in working order.

3. REMOVE ADJUSTING KEYS AND WRENCHES. Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.

4. KEEP WORK AREA CLEAN. Cluttered areas and benches invite accidents.

5. DON'T USE IN DANGEROUS ENVIRONMENT. Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well lighted.

6. KEEP CHILDREN AWAY. All visitors should be kept safe distance from work area.

7. MAKE WORKSHOP KID PROOF with padlocks, master switches, or by removing starter keys.

8. **DON'T FORCE TOOL.** It will do the job better and safer at the rate for which it was designed.
9. **USE RIGHT TOOL.** Don't force tool or attachment to do a job for which it was not designed.
10. **USE PROPER EXTENSION CORD.** Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Table "A" shows the correct size to use depending on cord length and nameplate ampere rating. If in doubt, use the next heavier gage. The smaller the gage number, the heavier the cord.
11. **WEAR PROPER APPAREL.** Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Nonslip footwear is recommended. Wear protective hair covering to contain long hair.
12. **ALWAYS USE SAFETY GLASSES.** Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
13. **SECURE WORK.** Use clamps or a vise to hold work when practical. It's safer than using your hand and it frees both hands to operate tool.
14. **DON'T OVERREACH.** Keep proper footing and balance at all times.
15. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
16. **DISCONNECT TOOLS** before servicing; when changing accessories, such as blades, bits, cutters, and the like.
17. **REDUCE THE RISK OF UNINTENTIONAL STARTING.** Make sure switch is in off position before plugging in.
18. **USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury to persons.
19. **NEVER STAND ON TOOL.** Serious injury could occur if the tool is tipped or if the cutting tool is unintentionally contacted.
20. **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function - check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
21. **DIRECTION OF FEED.** Feed work into a blade or cutter against the direction of rotation of the blade or cutter only.
22. **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** Don't leave tool until it comes to a complete stop.

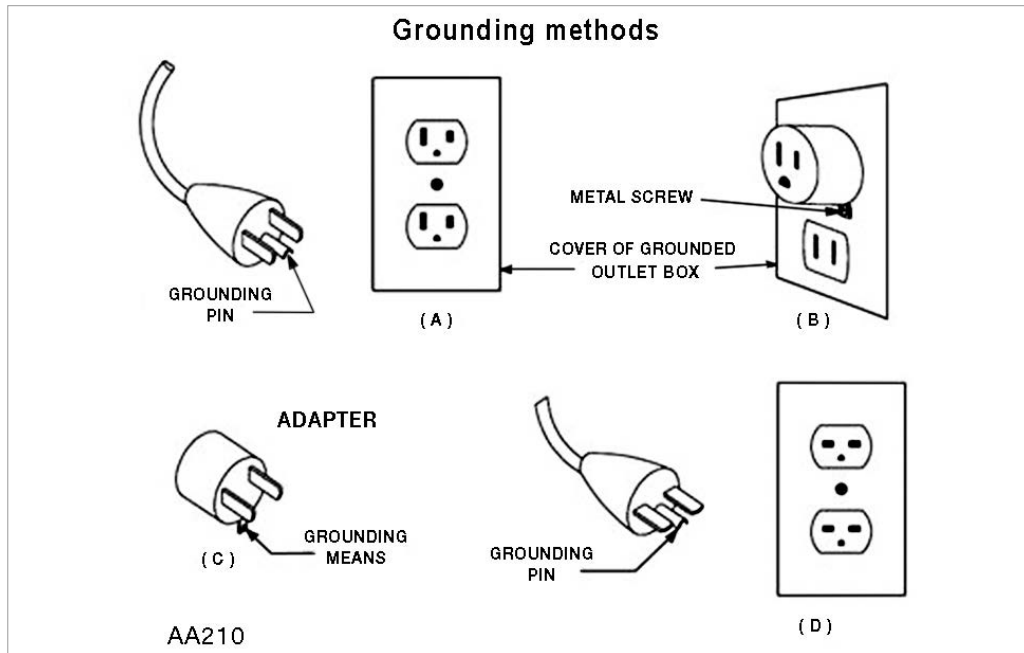


Fig. 3

Ampere Rating		Volts	Total length of cord in feet		
		120 V	25 ft	50 ft	100 ft
More Than	Not more than	AWG			
0	6		18	16	16

Table "A" - minimum gage for cord

1 MACHINE DESCRIPTION

FLASH 008 is a professional cutting machine for duplicating flat keys used with cylinder, car locks and cruciform keys.

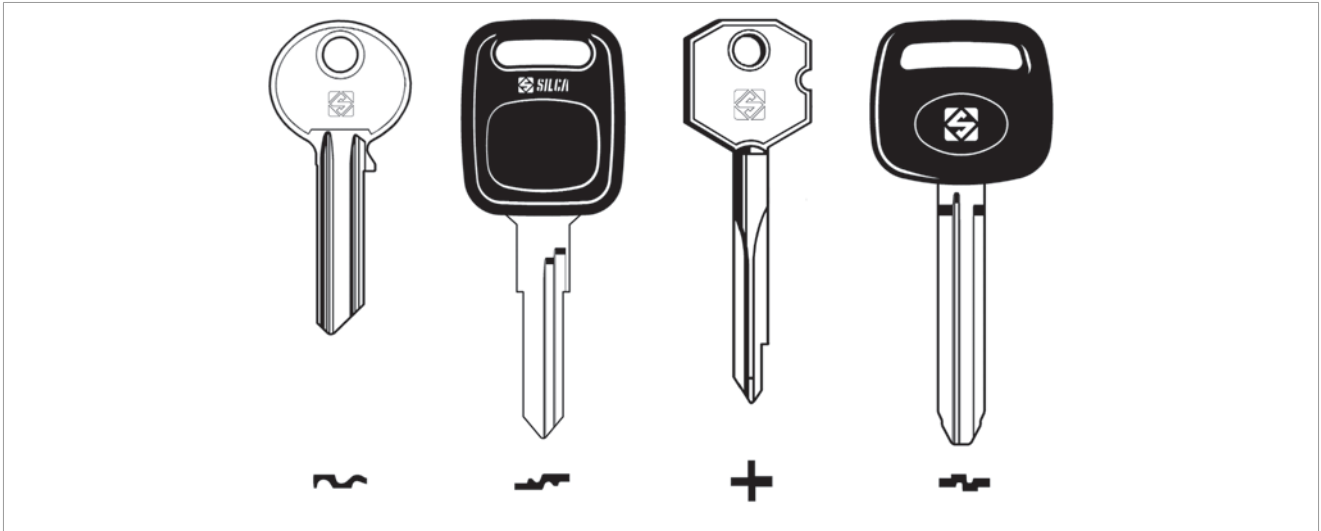


Fig. 4

The main parts of the machine are described below:

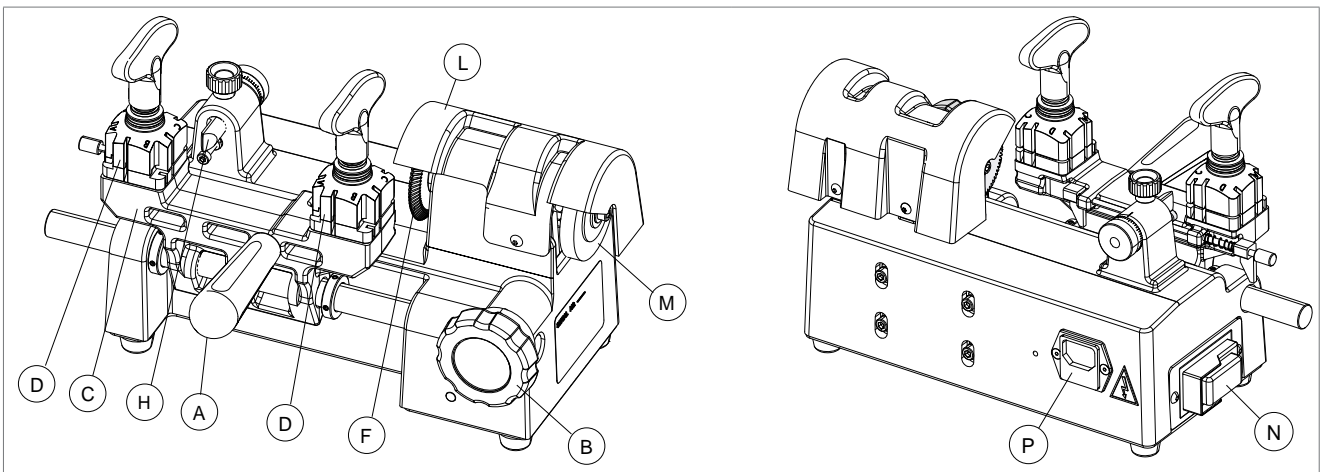


Fig. 5

- **Main switch**

The key-cutting machine is connected to a power socket provided with a differential switch (ch.3.4.3 and ch.3.5). The machine is turned on by means of the switch (N) located on its left-hand side.



ATTENTION: switch (N) is electromagnetic, in the event of a power failure it goes out automatically. When electricity is restored it must be reset manually to power the machine again by means of the plug.

- **Motor and transmission unit**

Motor transmission takes place by belt. On the right-hand side of the motor there is the transmission shaft which moves the cutting tool (F) and the brush (M). These components are protected by the protective cover (L):

- **Clamp carriages**

Carriage (C) is moved horizontally by means of knob (B). The carriage holds 2 clamps (D) and has a handle (A) for front movement.

- **Cutting unit**

The cutting unit contains the actual working parts of the FLASH 008 key-cutting machine, which operate together to cut and finish keys “read” from the originals. The working parts are described below:

- **Cutting Tool**

The cutting tool (F) is the part of the FLASH 008 used for cutting key blanks. The cutting tool is in HSS super rapid steel and is protected by a special cover (L) to ensure safe operation.

- **Tracer point**

The tracer point (H), dedicated to reading the cuts on keys to be copied is housed on the left-hand side of the machine. Depth is easily regulated by means of the relevant centesimal ring nut (G).

- **Clamps**

The clamps (D) are rotating and four-sided to allow perfect closure of the key placed on its back or profile in the case of keys with symmetrical cuts (ch.5.1).

- **Clamp knobs**

The clamps are locked by two ergonomic knobs (E), which ensure perfect grip on the keys with only slightly locking force.

- **Gauges**

Next to the clamps there is a rod with two gauge tabs to control key alignment for shoulder gauged keys.

- **Brush**

The purpose of the brush (M) is to deburr the keys after cutting. It is made of accident proof material and is protected by a shield (L).

1.1 Main working parts

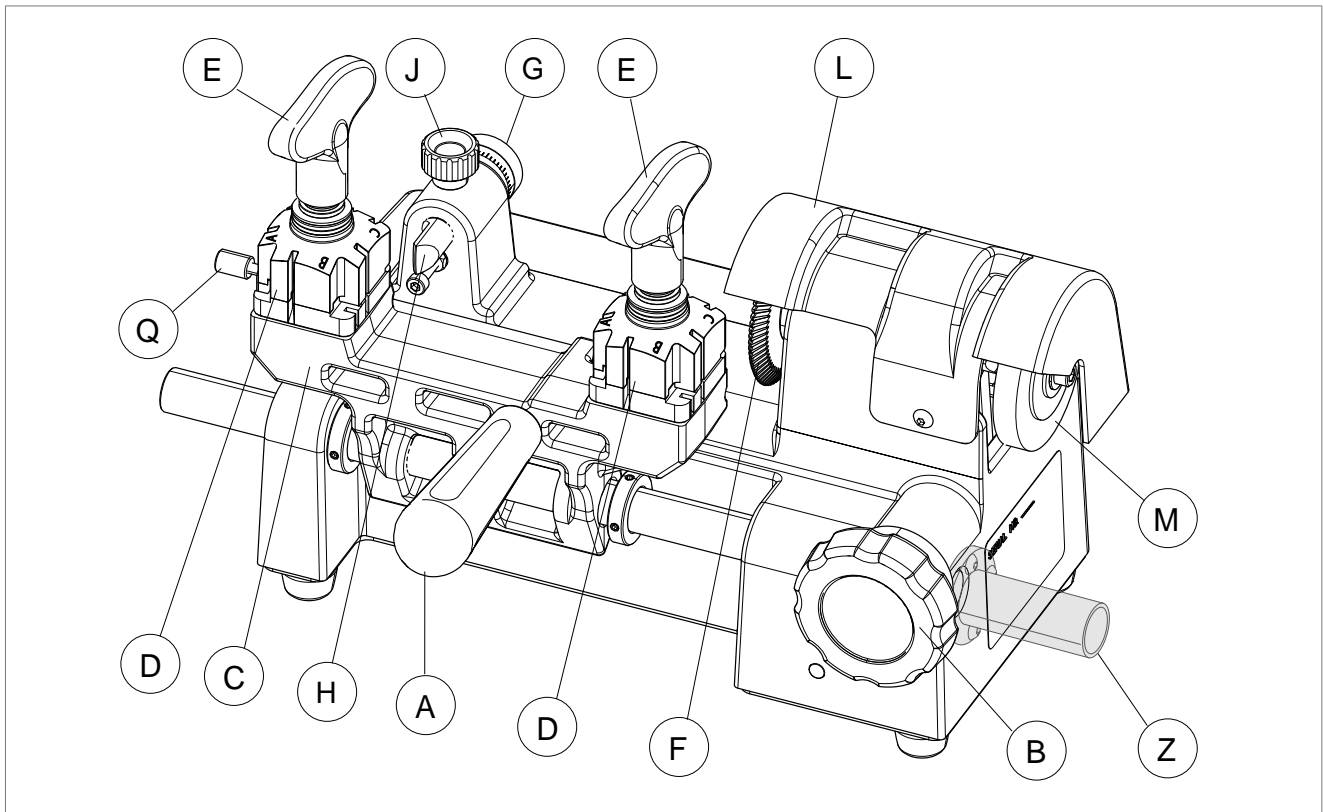


Fig. 6

- A - carriage handle
- B - carriage movement knob
- C - clamp carriage
- D - clamps
- E - clamp knobs
- F - cutting tool
- G - tracer point ring nut
- H - tracer point
- J - tracer point locking knob
- L - cutter/brush cover
- M - brush
- N - main switch
- P - power supply socket
- Q - gauges knob
- Z - carriage shaft protection (only on Flash 008 120V Nord America version)

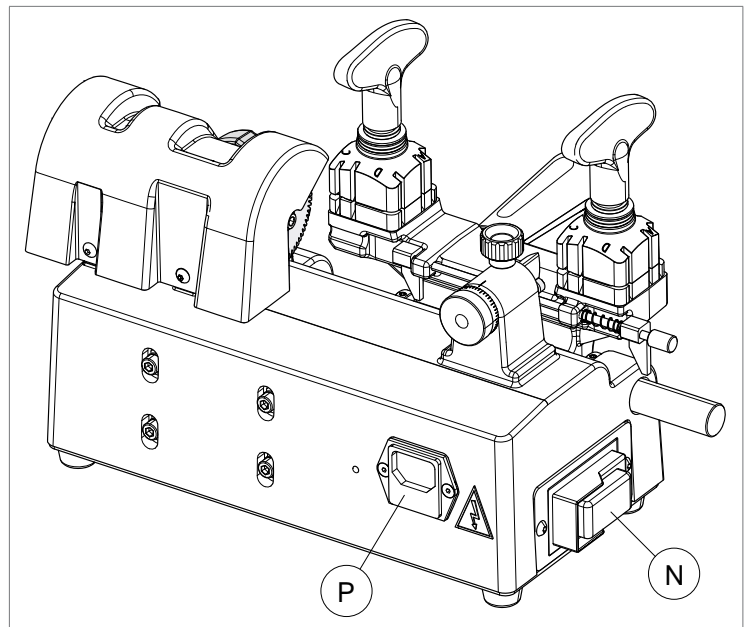


Fig. 7

1.2 Technical Data

Power supply:	230V - 50/60Hz 120V - 60Hz
Maximum absorbed power:	230V: 1.0 Amp. 130 Watt 120V: 1,2 Amp. 130 Watt
Cutter motor:	single phase and speed
Movements:	by rectified carriage shaft and rack
Cutting tool:	HSS Super Rapid Steel
Tool speed:	50Hz: 2900 rpm 60Hz: 2900 rpm
Runs (maximum length of cuts):	42 mm (1,65")
Dimensions:	width: 310 mm (12,2") - depth: 240 mm (9,5") - height: 220 mm (8,7")
Mass:	Kg. 6,4
Noise level:	sound pressure Lp(A) = 56 dB(A)

1.3 Electric circuit

The main parts of the electric circuit on the key-cutting machine are listed below:

- 1) Power supply socket
- 2) Fuses 2 Amp rapid (230V) - 4 Amp rapid (120V)
- 3) Master switch
- 4) AC to DC Rectifier
- 5) DC Motor: 230V-50/60Hz (120V-50/60Hz)

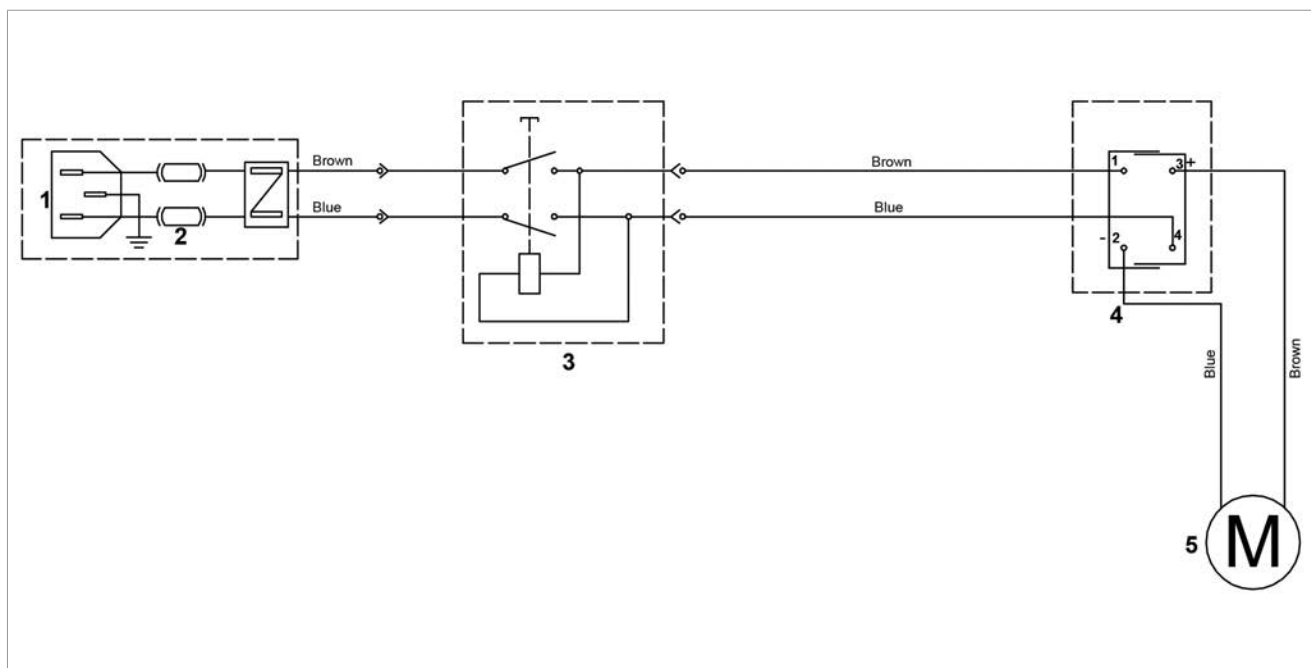

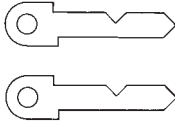



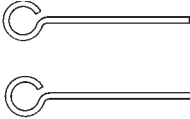

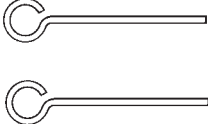


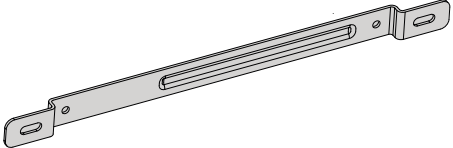


Fig. 8

1.4 Accessories provided

FLASH 008 comes with a set of accessories for its operation and maintenance (tools, hex wrenches, fuses) supplied in a special tool kit comprising:

<p>allen key 2,5 mm</p> 	<p>adjusting keys (2 pcs)</p> 
<p>allen key 3 mm</p> 	<p>steel bars (2 pcs)</p> 
<p>allen key 4 mm</p> 	<p>steel pin Ø 1,20 mm</p> 
<p>cutter release rod</p> 	<p>steel pin Ø 1,70 mm</p> 
<p>fuses 2 Amp rapid (230V) fuses 4 Amp rapid (120V)</p> 	<p>Separately: cable with ferrite</p> 
<p>Separately: fixing bracket</p> 	

2 TRANSPORT

FLASH 008 key-cutting machine is easily transported and is not dangerous to handle. The packed machine can be carried by one person.

2.1 Packing

The FLASH 008 is packed in a strong cardboard box, the dimensions of which are shown in Fig. 9, sufficiently robust to be used for storing the machine for long periods.

Inside the box the machine is enclosed in expanded polymer shells. The shells and cardboard box ensure safe transportation and protect the machine and all its parts.

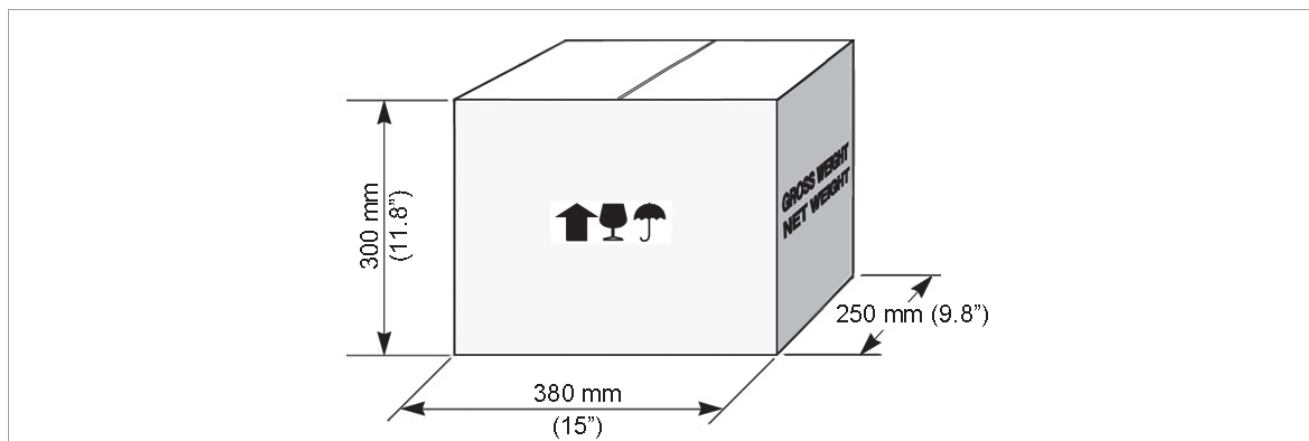


Fig. 9



Keep dry



Handle with care



This side up

NOTE: to avoid damaging the key-cutting machine it must always be transported in its packing case. This will prevent sudden movements or rough handling from damaging the machine, persons or things.

2.2 Unpacking

To remove the machine from the packing box:

- 1) Cut the straps with scissors and remove,
- 2) Open the box without damaging it as it may be used again (e.g. removals, dispatch to the manufacturers for repairs or servicing),
- 3) Check the contents of the box, which should comprise:
 - 1 FLASH 008 key-cutting machine packed in a protective shell;
 - 1 set of documents, including: operating manual, spare parts list and warranty;
 - 1 carriage handle;
 - 1 power cable
 - 1 cable with ferrite
 - 1 tool set;
 - 1 fixing bracket
- 4) Remove the key-cutting machine from the protective shell.

2.3 Handling the machine

When the FLASH 008 has been unpacked, place it directly on its workbench.

This operation can be carried out by one person.



ATTENTION: firmly hold the base, and no other part, to lift and carry the machine.

3 MACHINE INSTALLATION AND PREPARATION

The key-cutting machine can be installed by the purchaser and does not require any special skills. However, some checks and preparation for use need to be carried out by the operator.

3.1 Checking for damage

FLASH 008 key-cutting machine is solid and compact and will not normally damage if transport, unpacking and installation have all been carried out according to the instructions in this manual.

However, it is always advisable to check that the machine has not suffered any damage.

3.2 Environmental conditions

To ensure that the best use is made of the key-cutting machine, certain parameters must be borne in mind: damp, badly ventilated sites should be avoided.

The ideal conditions for the machine are:

- temperature: between 10°C and 40°C (50°F and 104°F);
- relative humidity: 60% ; room illumination: approximately 500 Lux.

3.3 Positioning

- 1) Place the key-cutting machine on a horizontal surface, solid enough to take the weight (6,4 Kg).

- to work with ease, we suggest that the workbench be approximately the height of the operator's hip.
- it is important to leave clearance of at least 30cm (12") behind the machine and on each side to ensure proper ventilation (Fig. 10).

- 2) Ensure that the machines voltage is the same as that of the mains power supply, which must be properly earthed (grounded) and provided with a differential switch.
- 3) Connect the power supply cable to the power supply socket (ch.3.4.3 and ch.3.5)

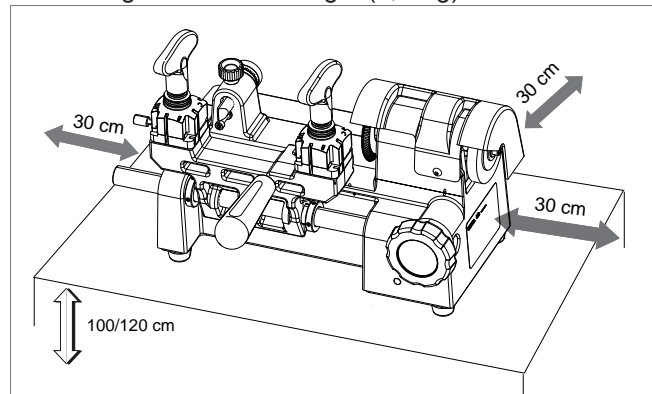


Fig. 10

3.4 Separate parts

The separately packed parts must be installed on the FLASH 008 key-cutting machine by the purchaser, as follows:

3.4.1 Carriage handle

Screw the handle (A) onto the carriage (Fig. 11).

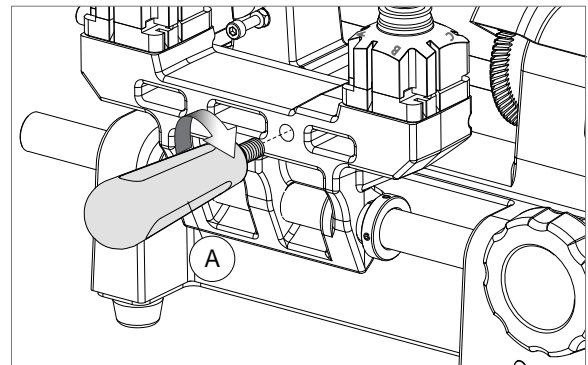


Fig. 11

3.4.2 Fixing bracket

The machine can be fixed to the workbench with a special bracket (provided). Proceed as follows:

⚠ ATTENTION: remove the mains plug.

- 1) Paying attention turn the machine slowly onto its back.
- 2) Loosen and remove the 2 front screws (R1) with the feet (Fig. 12).
- 3) Fix the bracket to the machine with feet and the 2 screws (R1).
- 4) Return the machine to its upright position and fix it on the work top (Fig. 13).

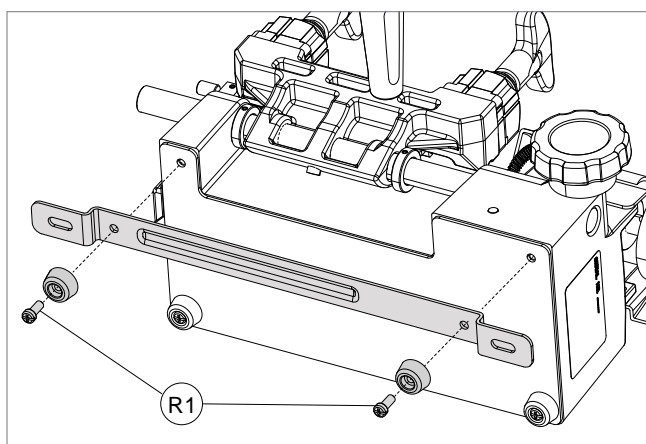


Fig. 12

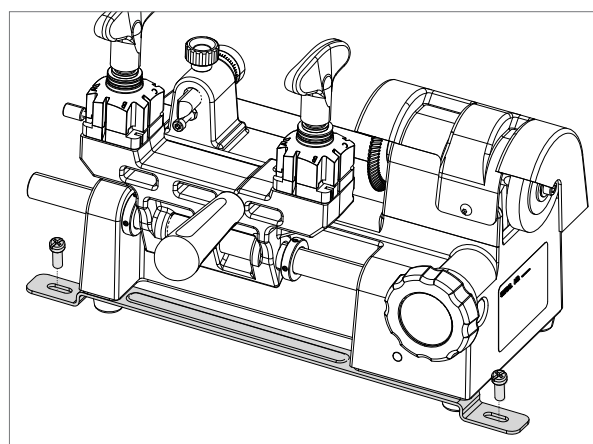


Fig. 13

3.4.3 Cable with ferrite and power cable

- 1) Connect the cable with ferrite (Y) to the key-cutting machine (Fig. 14).
- 2) Connect the power cable (W) to the cable with ferrite (Y).



Fig. 14

3.5 Connection to the mains

Connect the key-cutting machine power cable (W) to the electricity mains.

For the safety of the operator and the machine it is important to ensure that the machine is connected to the proper mains voltage **by means of an earthed (grounded) differential switch.**

3.6 Description of work station

The key-cutting machine needs only one operator, who has the following controls at his/her disposal (Fig. 6):

- Main switch (N)
- Carriage movement knob (B)
- Carriage handle (A)
- Clamps (D)
- Clamps knobs (E)

4 MACHINE REGULATION AND UTILIZATION

4.1 Checking and calibration

The cutting tool on the machine is the part used to cut the key blanks and should be periodically checked and replaced, if necessary.

Every time the cutting tool is changed, and during periodical operational tests, check calibration.

4.2 Calibration

The FLASH 008 key-cutting machine requires two types of calibration: **axis** and **depth**.

Axis calibration:

Axis calibration is regulation of the space between cutting and the stop (Fig. 15 and Fig. 16).

The axis setting for the FLASH 008 is fixed and is established on assembly in our workshops.

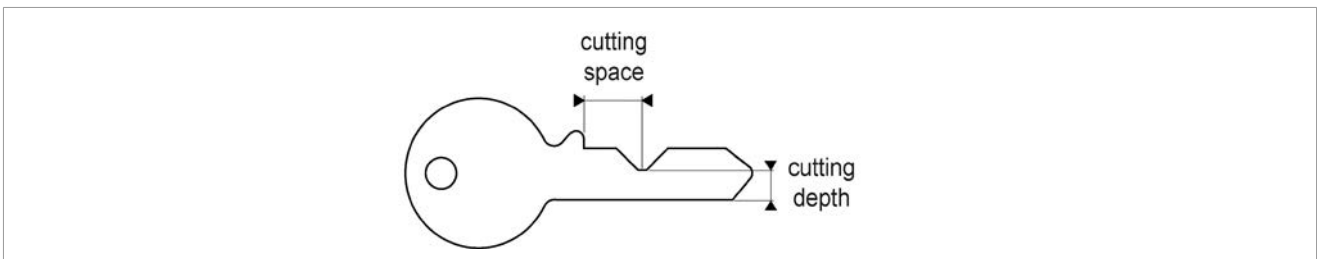


Fig. 15

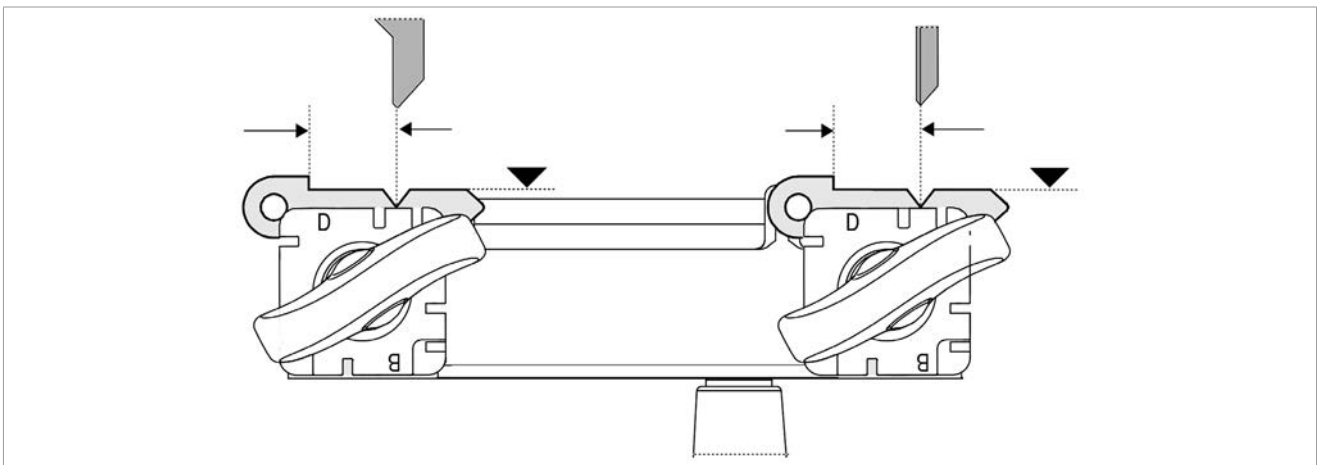


Fig. 16

Depth calibration:

Depth calibration is regulation of the cutting depth (Fig. 15). Proceed as follows:

- 1) Ensure that the key-cutting machine is off by unplugging the power cable.
- 2) Place the adjustment keys (provided) on the clamps (Fig. 17).
- 3) Check that the adjustment plates adhere properly to the clamps.
- 4) Turn the shoulder gauge rod towards the operator so that the gauges (Q1) are in contact with the adjusting plates (Fig. 17).
- 5) Lower the gauge rod.

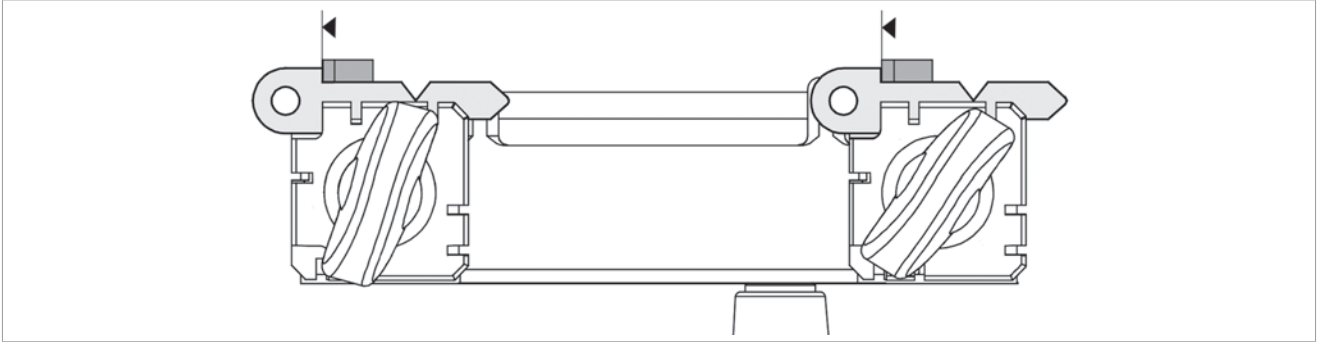


Fig. 17

- 6) Raise the carriage up to the cutting tool.
- 7) Move the keys into contact with the cutting tool and tracer point (Fig. 18).
- 8) Turn the cutting tool counterclockwise manually and check that it skims the adjusting keys in several places.
- 9) If necessary, regulate the depth of the cut with the micrometric tracer point, as follows:
 - a) loosen the tracer point locking knob (J).
 - b) turn the ring nut (G) clockwise to advance the tracer point (shallower cuts) (Fig. 19).
 - c) turn the ring nut (G) counterclockwise to return (deeper cuts) (Fig. 20).

NOTE: each notch on the centesimal ring corresponds to 0,025 mm (.00098") (Fig. 18).

- 10) Repeat these operations until regulation is complete, then tighten the tracer point locking knob (J).

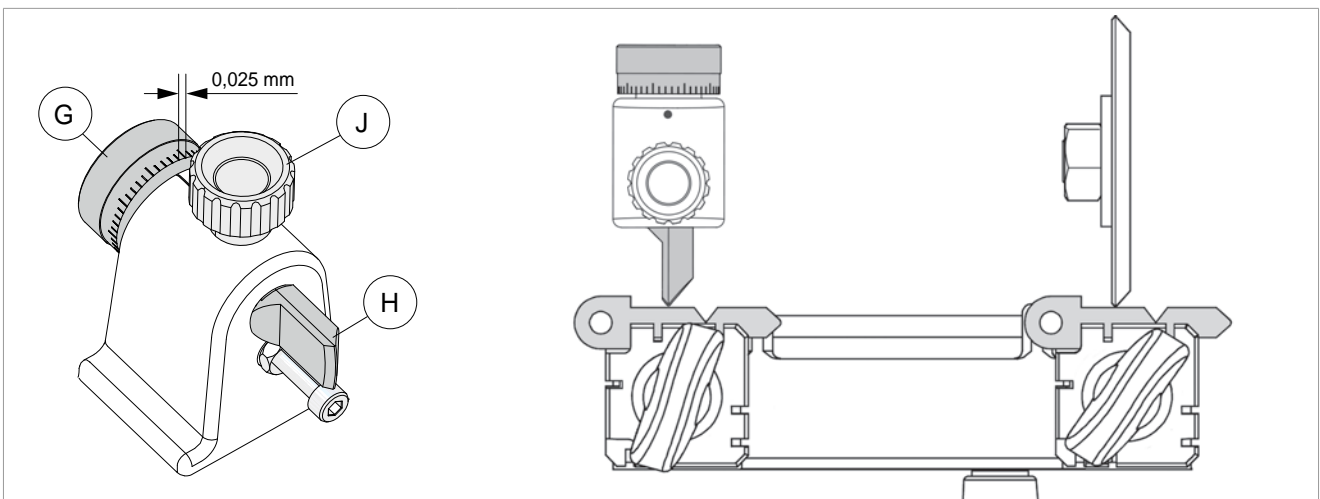


Fig. 18

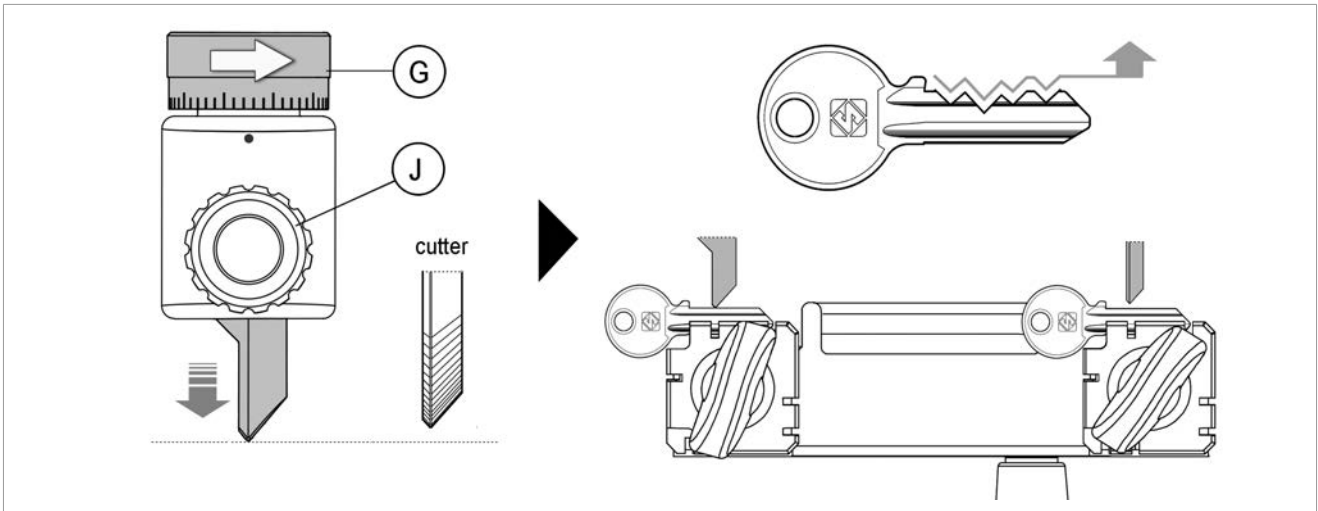


Fig. 19

- Turn the nut to the RIGHT (clockwise) to move the tracer point out. Result: SHALLOWER CUTS.

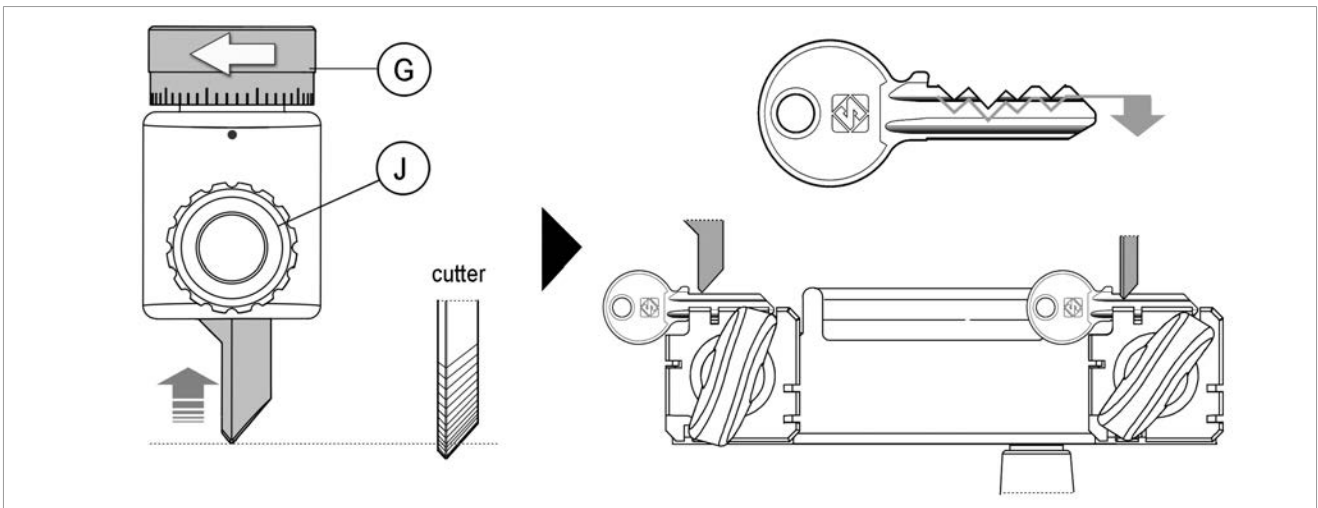


Fig. 20

- Turn the nut to the LEFT (counterclockwise) to return the tracer point. Result: DEEPER CUTS.

5 CUTTING OPERATIONS



ATTENTION: for complete safety during the cutting operations, take the following precautions:

- Always work with dry hands.
- Check that the machine is properly earthed.
- Wear protective goggles even if the machine has a protective shield over the cutting tool.
- Turn on switch (N) only after completing the operations on the carriage (securing the keys,...).
- Keep hands away from the cutting tool in motion.
- Before duplicating, remove the gauges.

5.1 Key cutting



Fig. 21

Place the clamps on the required side (see chap.5.1.1):

- **Side A** of the clamp: for keys to be fitted on their backs, keys with double cuts without groove and cruciform keys (Fig. 22);
- **Side B** of the clamp: for keys placed on their backs and having cuts with a depth of less than 3,9 mm (Fig. 22);
- **Side C and D** of the clamp: for keys to be cut on both sides and locked on the groove (Fig. 22).

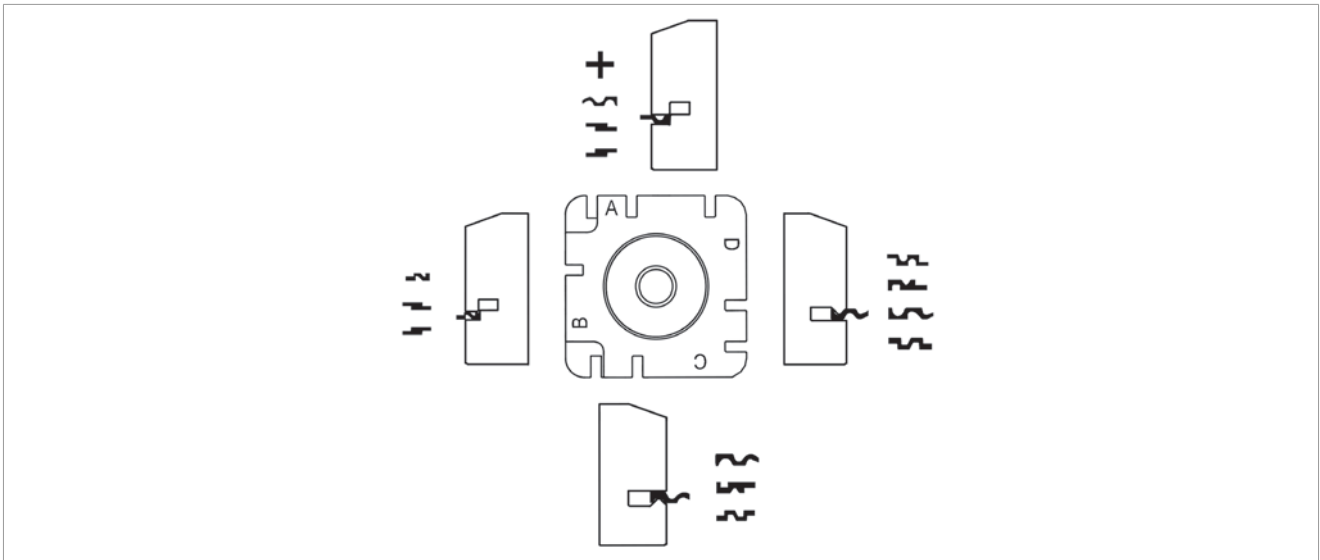


Fig. 22

5.1.1 Clamp rotation

- 1) Loosen the clamp closing knob by a few turns.
- 2) Turn the clamp so that the required side is facing the tracer point and cutter.

NOTE: carry out the operation for both clamps.

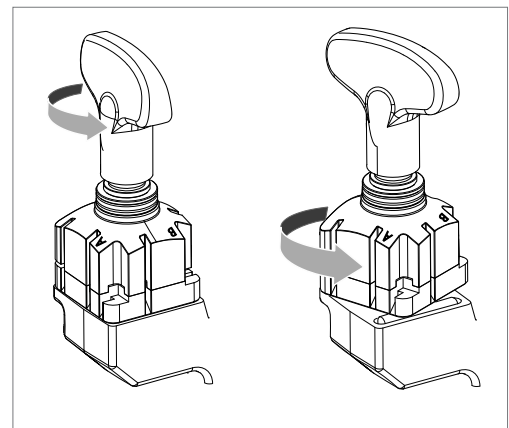


Fig. 23

5.1.2 Securing the keys in the clamps

- 1) Position the original key (left-hand jaw) and key blank (right-hand jaw), ensuring that:
 - a) the keys are well positioned and secured in the clamp;
 - b) the key stop is resting against the calibration tab (Q1);
- 2) Secure the keys by closing the clamps with knobs (E).
- 3) Lower the gauge rod by turning knob (Q).

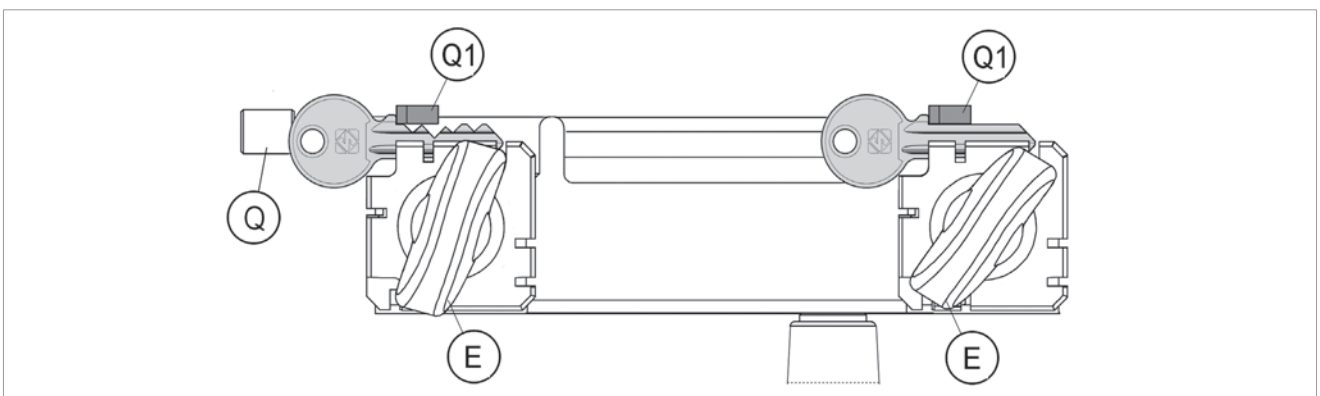


Fig. 24

5.1.3 Key cutting



ATTENTION: make sure the gauges (Q1) have been lowered.

When the key-cutting machine has been turned on by means of main switch (N) it is ready for cutting:

- 1) Use handle (A) to take the carriage towards the tracer/cutter and hold the tracer against the cut, starting at the key stop (Fig. 25).
- 2) To make a copy of the key, move the carriage from right to left with knob (B). In case of double cuts repeat the operation in the second side of the key.
- 3) Turn off the machine with switch (N) before removing the duplicated key.
- 4) Remove the keys from the clamps.
- 5) Turn on the machine with switch (N) and smooth off the key edges by means of the brush (M).

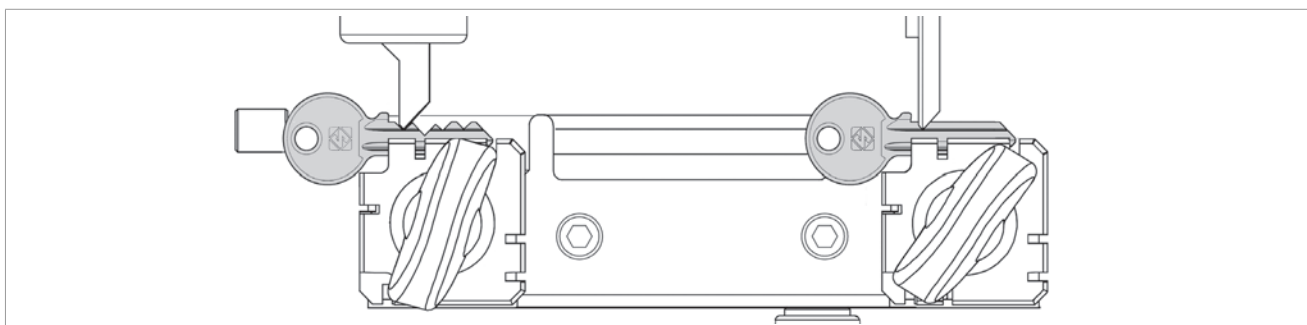


Fig. 25

5.2 Using the accessories

The accessories provided with machine to assist key-cutting are:

- pins
- bars

Using the pins

The pins must be inserted between the bottom of the jaw and the back of the key for keys with narrow stems, and their purpose is to ensure that the key protrudes sufficiently to be cut properly (Fig. 26-B, Fig. 26-C).

For keys with narrow, thin stems, two pins must be used (Fig. 26-B), the second one to give a secure grip on the key.

If the key thickness is too fine to guarantee a good grip in the clamps, a pin must be used (Fig. 26-A).



ATTENTION: the pins provided have two different diameters: 1,20 mm and 1,70 mm; It is essential to use pins with the same diameters for locking both the original and the key blank.

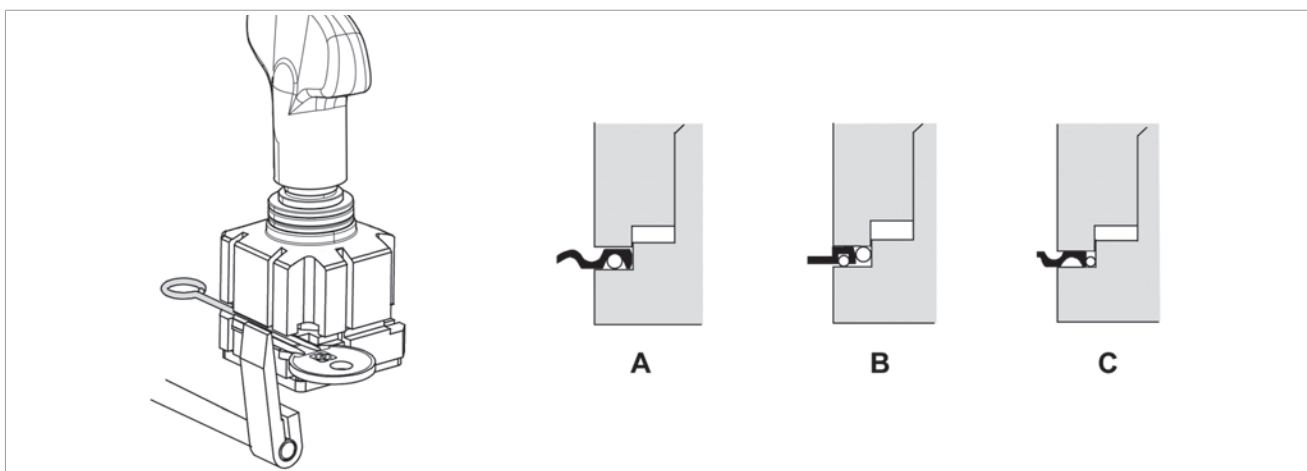


Fig. 26

Using the bars

The bars provided are used for cutting cruciform keys (Fig. 27) and as a tip rest for gauging keys without shoulders (Fig. 28).

Cutting cruciform keys using bars

The cruciform keys (90°) can be cut with the clamps and the aid of the bars.

Positioning cruciform keys:

- 1) Leave the gauges (Q1) in the idle position.
- 2) Insert the bars into the slot in the clamps.
- 3) Butt the key stop against the bars.
- 4) Secure the keys in the clamps.
- 5) Remove the bars from the clamp grooves to prevent it being touched by the tracer point or cutting tool.
- 6) Cut the first side.
- 7) Repeat the operation, turning both keys in the same direction for the other positions.

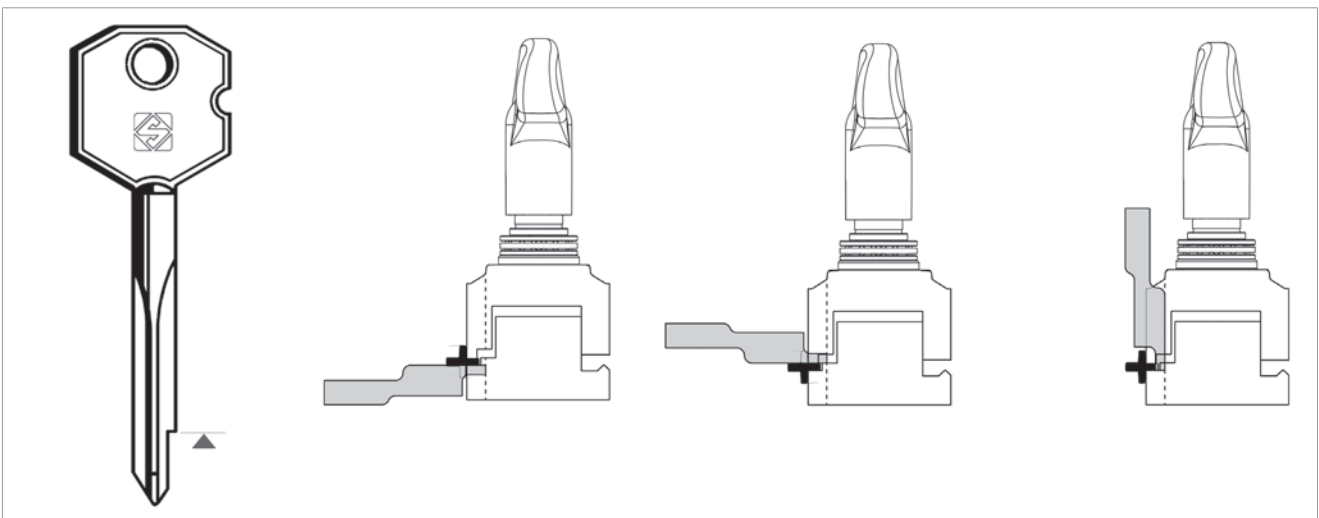


Fig. 27

Tip stop with a bar

The bars can be used with keys without shoulders (Fig. 28). Proceed as follows:

- 1) Leave the gauges (Q1) in the idle position.
- 2) Insert the bars into the slot in the clamps.
- 3) Rest the tip of the key against the bar.
- 4) Secure the key and remove the bar.

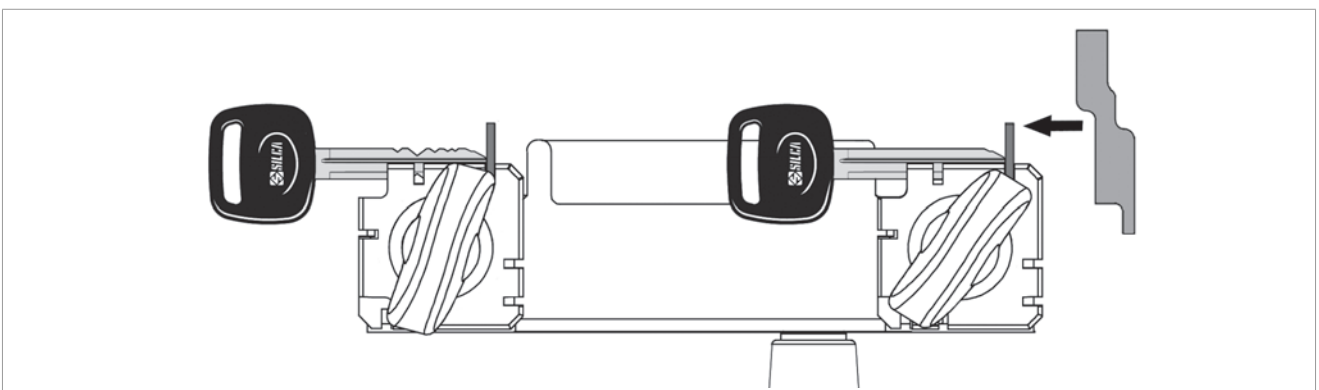


Fig. 28

6 MAINTENANCE

⚠ ATTENTION: for repairs or replacement of parts for maintenance, the 'CE' mark is guaranteed only if original spare parts provided by the manufacturer are used.

Although the key-cutting machine does not require special maintenance, it is advisable to check and, if necessary, replace the parts subject to wear, such as: the belt, cutting tool, brush, tracer point. Replacement is simple and can be carried out by the operator.

CLEANING: Keep the carriage and clamps free of chippings from the cutting operations by cleaning with a dry brush.

⚠ ATTENTION: do not use compressed air!

⚠ ATTENTION: to keep the machine well maintained we recommend using protective oil, e.g. WD40 or similar, applied to the burnished mechanical parts. This prevents oxidation of the parts in question (clamps, guides, carriages...).

Before starting any type of maintenance (checks or replacements), read the instructions below:

- Never carry out maintenance or servicing with the machine switched on.
- Always remove the mains plug.
- Follow all the instructions in the manual to the letter.
- Use original spare parts.
- Always check that any screws or nuts removed when replacing a piece are properly tightened.

6.1 Replacing the brush

When the brush no longer cleans off the burrs it must be replaced as follows:

⚠ ATTENTION: remove the mains plug.

- 1) Remove the cover (L) by loosening the 3 screws (L1) (Fig. 29).
- 2) Slot the locking rod (provided) into the hole (K) of the cutting tool shaft (Fig. 30).
- 3) Use the Allen wrench to loosen the screw (M1) holding the brush (M) in place (Fig. 30).
- 4) Replace the brush and tighten the screw (M1) with the Allen key.
- 5) Remove the locking rod from the cutting tool shaft.
- 6) Install the protective cover (L) and secure with the 3 screws (L1).

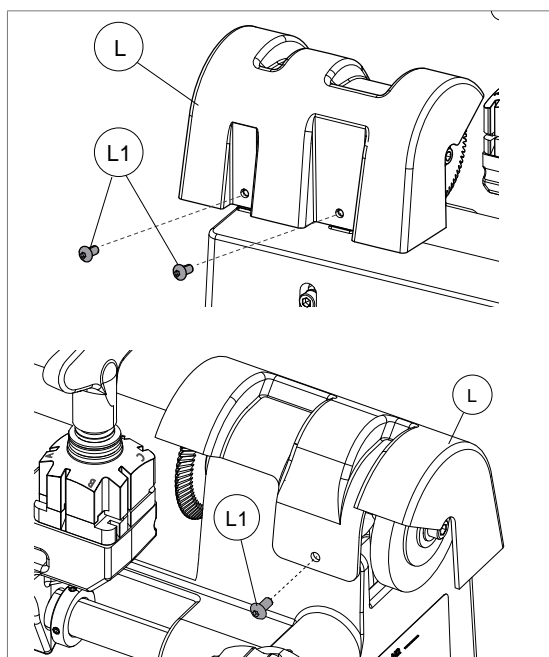


Fig. 29

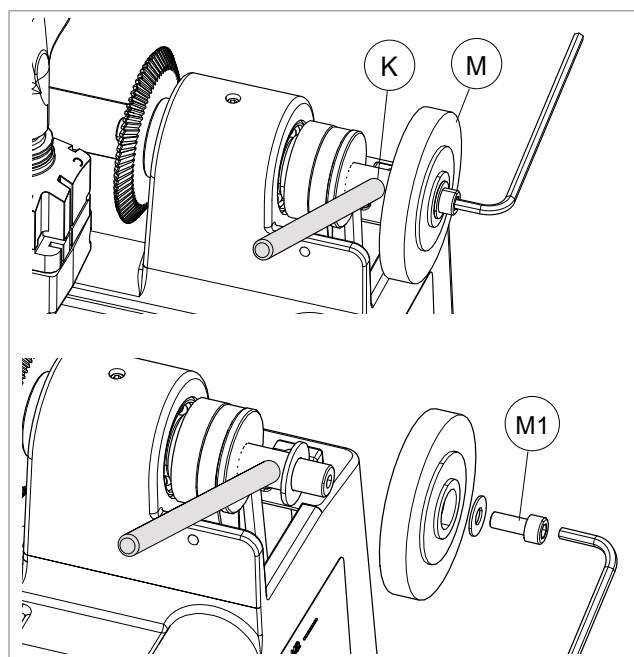


Fig. 30

6.2 Replacing the cutting tool

In order to substitute the cutting tool you need to remove the cutting tool protective cover (L). To replace a worn cutting tool, proceed as follows:

! **ATTENTION: remove the mains plug.**

- 1) Remove the cover (L) by loosening the 3 screws (L1) (Fig. 29).
- 2) Slot the locking rod (provided) into the hole (K) of the cutting tool shaft (Fig. 31).
- 3) Unscrew (clockwise) the cutting tool locking screw (F1).

! **ATTENTION: the thread is left-handed.**

- 1) Remove the worn cutting tool.
- 2) Carefully clean the new cutting tool and its seat.
- 3) Install the new cutting tool (pay attention to the rotation direction), place the washer and tighten screw (F1) anticlockwise.
- 4) Remove the locking rod.
- 5) Re-place the protective cover (L).
- 6) Check calibration (see chap.4.2).

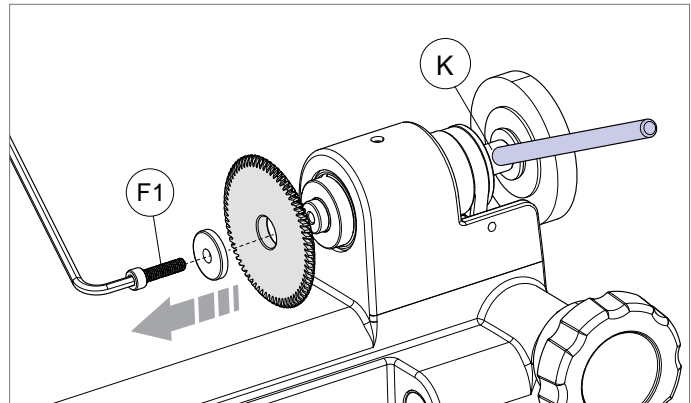


Fig. 31

6.3 Replacing the tracer point

! **ATTENTION: remove the mains plug.**

- 1) Loosen the knob (J) (Fig. 32).
- 2) Loosen the ring nut (G) completely and remove the tracer. Attention: the spring may stay in place.
- 3) Fit a new tracer and tighten the ring nut (G).
- 4) Check calibration (see chap. 4.2).

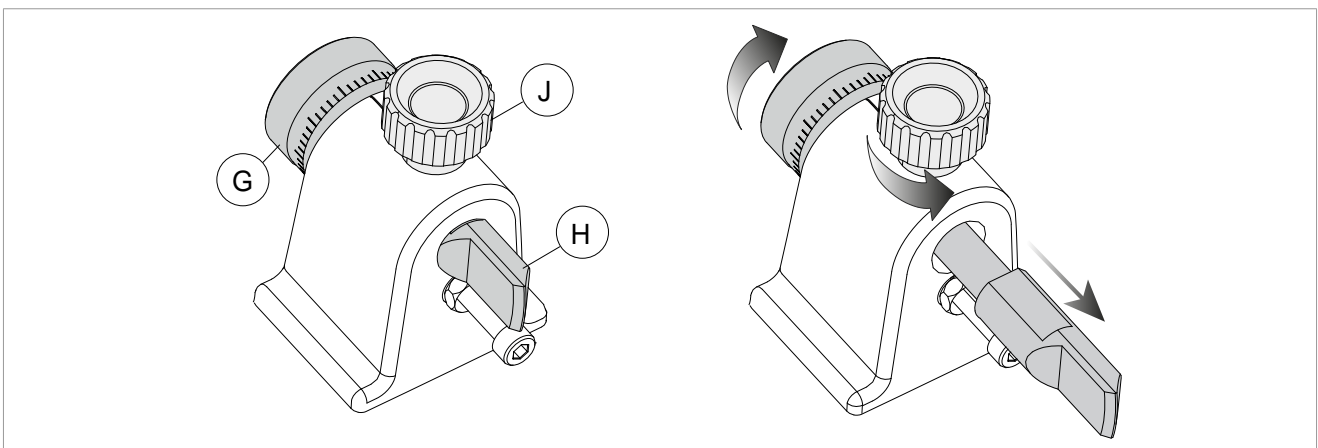


Fig. 32

6.4 Depth regulation (clamp protection)

FLASH 008 incorporates regulation to safeguard the clamps from the possibility of scraping against the tracer point and cutter.

! **ATTENTION:** the play between cutting tool/tracer point and clamps must be 0.2 mm.

Should it be different from this, proceed as follows:

! **ATTENTION:** remove the mains plug.

- 1) Raise the carriage and carry the clamps to the end of its run towards tracer point and cutting tool (Fig. 33)
- 2) Release the nut (X1) with the spanner.
- 3) Use the Allen wrench to screw or unscrew the screw (X2) in order to move the carriage away towards or from the tracer point and cutting tool.
- 4) Tighten the nut (X1).

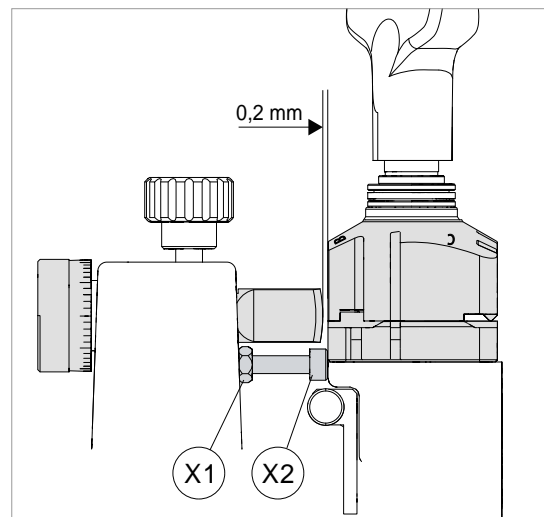


Fig. 33

6.5 Replacing the fuses

! **ATTENTION:** disconnect the power lead from the mains and machine.

- 1) Open the fuses box from the key-cutting machine socket (P) (Fig. 34).
- 2) Replace the fuses (P1).
- 3) Close the fuses box and connect the power cable.

! **ATTENTION:** fuses must always be replaced with others of the same type and with the same Amps (2 Amp rapid for 230V - 4 Amp rapid for 120V).

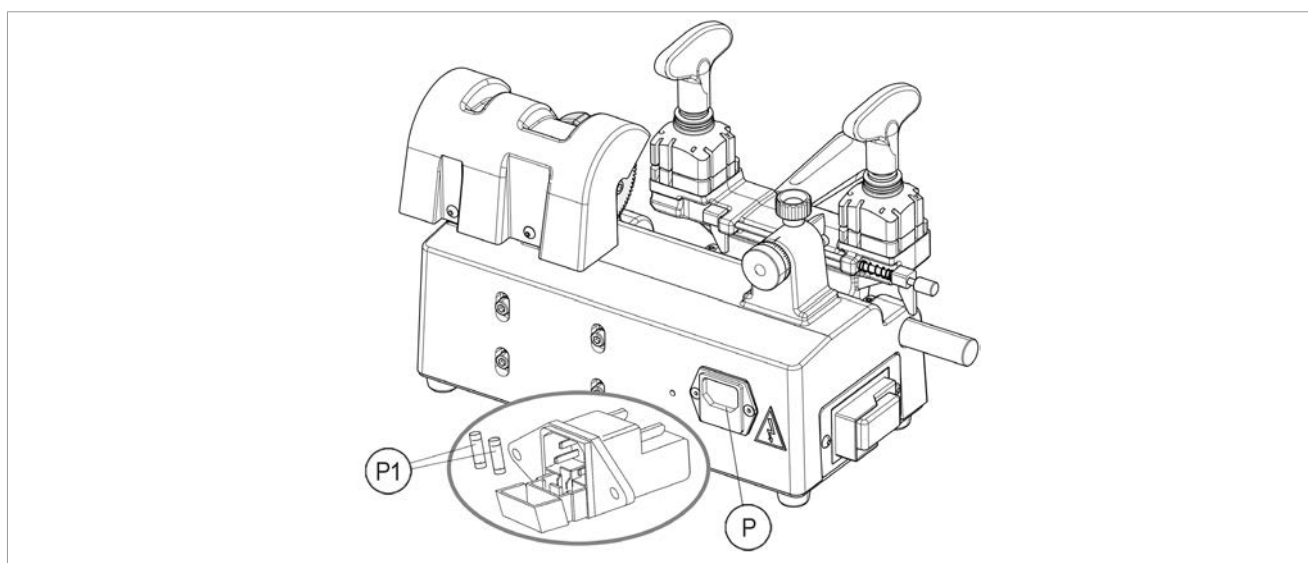


Fig. 34

6.6 Access to the lower compartment

! **ATTENTION:** remove the mains plug.

- 1) Detach the wire from the key-cutting machine socket.
- 2) Paying attention turn the machine slowly onto its back.
- 3) Loosen the 4 screws (R1) and remove feet and bottom plate (R) (Fig. 35).

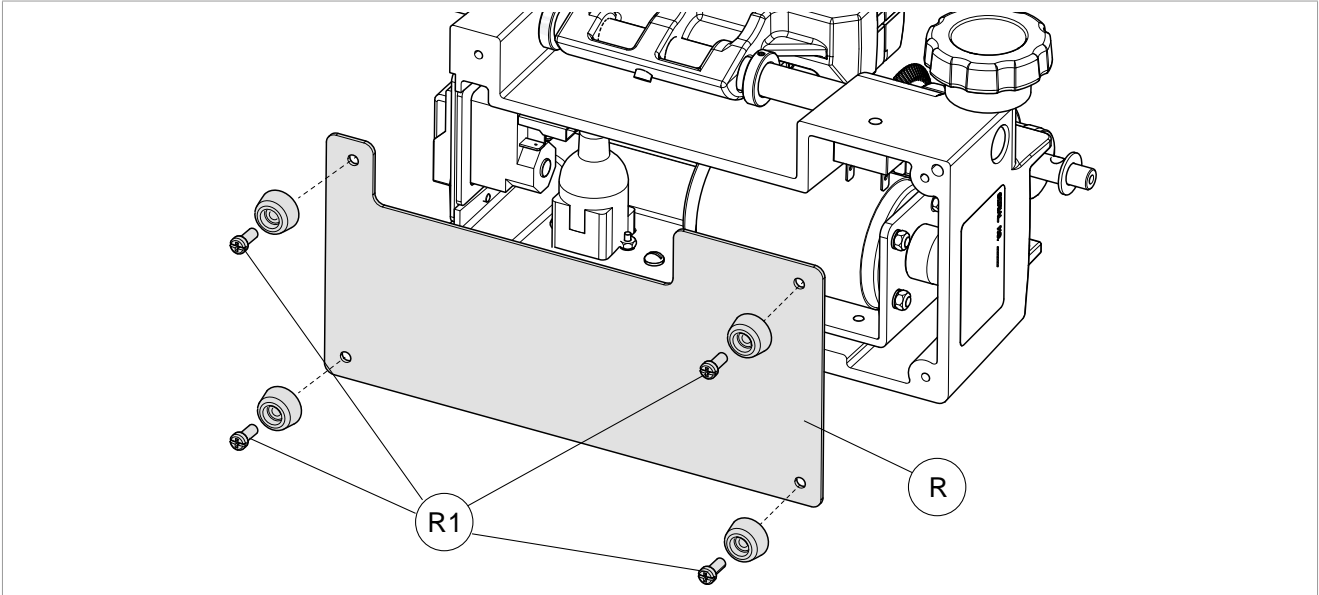


Fig. 35

6.7 Replacing the main switch

! **ATTENTION:** remove the mains plug.

- 1) Access the lower compartment (see chap.6.6).
- 2) Detach the 4 connectors (N1) and (N2) paying special attention to their position (Fig. 36).
- 3) Remove the switch making pressure on the tabs with a screwdriver (Fig. 37).
- 4) Fit the new main switch.
- 5) Reconnect the 4 connectors (N1) and (N2).

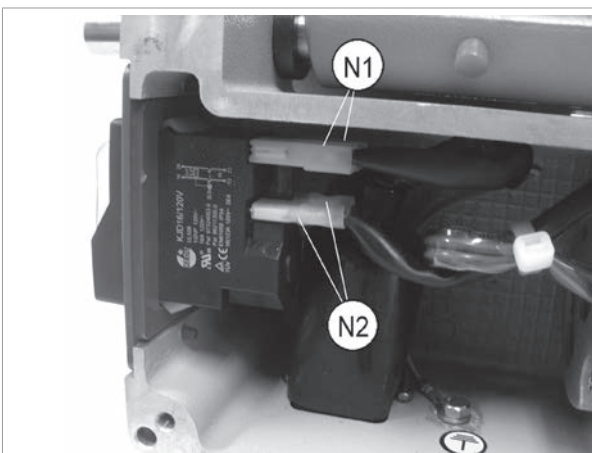


Fig. 36

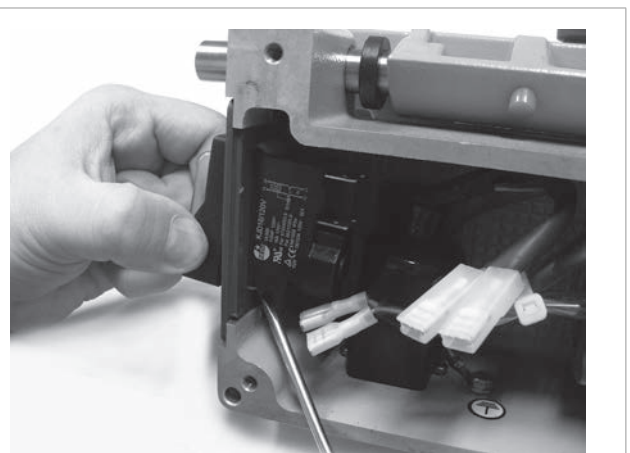


Fig. 37

6.8 Replacing the rectifier

! **ATTENTION:** remove the mains plug.

- 1) Access the lower compartment (see chap.6.6).
- 2) Detach the 4 connectors (V1) and (V2) paying special attention to their position (Fig. 38).
- 3) Loosen and remove screw (V3).
- 4) Replace the rectifier with the new one and secure it with screw (V3).
- 5) Reconnect the 4 connectors (V1) and (V2).

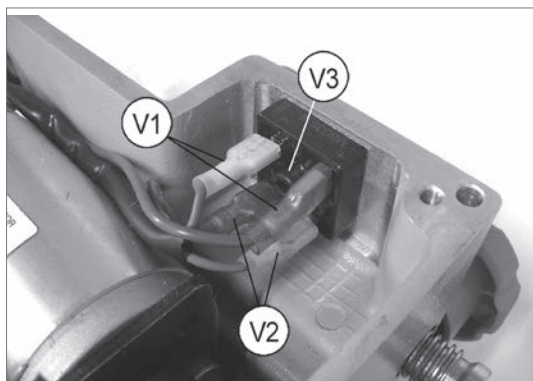


Fig. 38

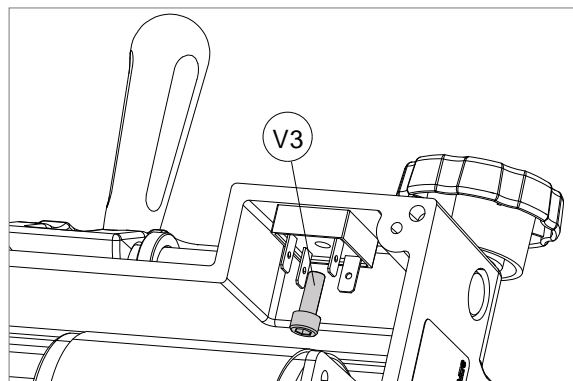


Fig. 39

6.9 Replacing and/or adjusting tension on the belt

Worn or loose belts must be replaced or adjusted so as to ensure safe and proper operation of the cutting tool/brush.

! **ATTENTION:** remove the mains plug.

- 1) Remove the cover (L) by loosening the 3 screws (L1) (Fig. 29).
- 2) Loosen the 4 motor fixing screws (W1).
- 3) Access the lower compartment (see chap.6.6).
- 4) Push the motor towards cutting tool and remove the worn belt.
- 5) Fit the new belt.
- 6) Pull the motor towards the machine bottom until the belt has the right tension. Tighten the 4 screws (W1).
- 7) Place the bottom plate.
- 8) Return the machine to its upright position and place the protective cover (L).

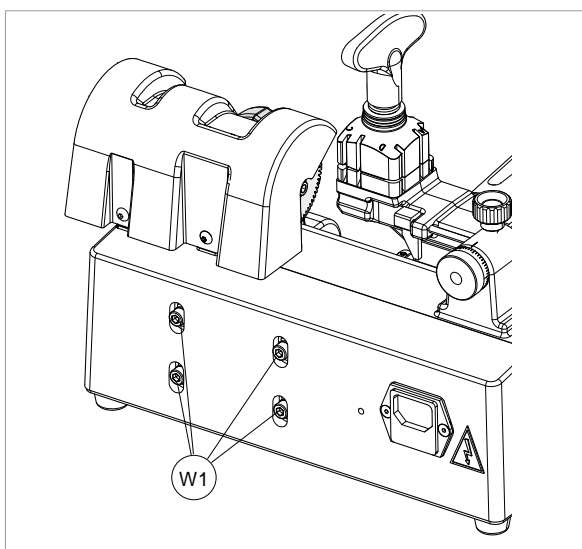


Fig. 40

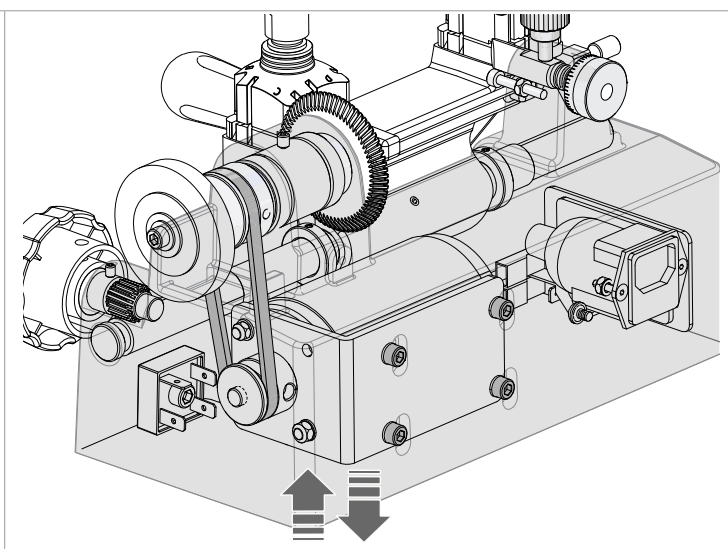


Fig. 41

7 DISPOSAL

For correct disposal please refer to current standards.

INFORMATION FOR USERS OF PROFESSIONAL EQUIPMENT



From “Actuation of Directive 2012/19/EU regarding Waste Electrical and Electronic Equipment (WEEE)”

The symbol of a crossed waste bin found on equipment or its packing indicates that at the end of the product's useful life it must be collected separately from other waste so that it can be properly treated and recycled.

In particular, separate collection of this professional equipment when no longer in use is organised and managed:

- a) directly by the user when the equipment was placed on the market before 31 December 2010 and the user personally decides to eliminate it without replacing it with new equivalent equipment designed for the same use;
- b) by the manufacturer, that is to say the subject which was the first to introduce and market new equipment that replaces previous equipment, when the user decides to eliminate equipment placed on the market before 31 December 2010 at the end of its useful life and replace it with an equivalent product designed for the same use. In this latter case the user may ask the manufacturer to collect the existing equipment;
- c) by the manufacturer, that is to say the subject which was the first to introduce and market new equipment that replaces previous equipment, if it was placed on the market after 31 December 2010;

Suitable separate collection for the purpose of forwarding discarded equipment for recycling, treatment or disposal in an environmentally friendly way helps to avoid possible negative effects on the environment and human health and encourages re-use and/or recycling of the materials making up the equipment.

The sanctions currently provided for by law shall apply to users who dispose of products in unauthorised ways.

8 ASSISTANCE

Silca provides full assistance to purchasers of the key-cutting machine. To ensure complete safety for the operator, any job not specified in this manual should be carried out by the manufacturer or in the special Service Centres recommended by Silca.

At the end of the manual there is a list of manufacturers' and authorized Service Centre addresses; if the manual was downloaded it's necessary visit the website to see the contacts (www.silca.biz).

Silca undertakes to make consumables, optional items and spare parts available for the limited time defined in its product obsolescence policy.

8.1 How to request service

The guarantee attached to the key-cutting machines ensures free repairs or replacements of faulty parts within 24 months of purchase. All other service calls must be arranged by the customer with Silca or with a Silca service centre.



VITTORIO VENETO 05/02/2016

CE DECLARATION OF MACHINE COMPLIANCE

**SILCA S.p.A. - VIA PODGORA 20 (Z.I.)
31029 VITTORIO VENETO (TV) - (ITALY)
TEL. 0438 9136 - FAX. 0438 913800**

Declares under its own responsibility that the **Key-cutting machine** model

FLASH 008

complies with the requirements of the following European Directives:

European Union **DIRECTIVE 2006/42/CE** (Machines)

European Union **DIRECTIVE 2004/108/CE** (Electromagnetic Compatibility)

European Union **DIRECTIVE 2006/95/CE** (Low Voltage) | 16 |

and with the EN ISO 12100 :2010
EN 60204-1 : 2006 / A1 : 2009
EN 60034 – 1 : 2010
Standards

Claudio Tomasella of the Silca S.p.A. Research & Development Division is authorized to create a Technical File.

General Manager Basic Production Center

Stefano Setti

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Società soggetta a direzione e coordinamento di Kaba Holding AG, con sede in Rümlang (Svizzera),
Hofwisenstrasse 24, ai sensi e per gli effetti degli articoli 2497 - 2497sexies del Codice Civile.

