Key Duplicating Machine
Model 598B

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Key Duplicating Machine Diagram

Knob to clamp keys

Jaw with Key Clamps

Power and Cycle Start Switches

Crank Lever

1 – 1/8” Hex Key
1 – 5/32” Hex Key
1 – Crank Handle
Step 1: Lock the Jaw in place for loading

MACHINE SHOULD BE OFF

A. Prepare the Jaw for loading by sliding it to the left and pulling it down towards you. It will lock in place automatically.

Step 2: Load the Original Key

MACHINE SHOULD BE OFF

A. Place the key to be copied in the LEFT key clamp.
   1. Align as shown
   2. Turn Knob to clamp the key in

B. Slide Jaw to the RIGHT and raise it up so the key aligns with the Key Tracer.
For Automotive Keys: MACHINE SHOULD BE OFF

A. Bring key stop up and tighten it in place with a 1/8 Alan Wrench.
B. Load the Tracer Automotive Key on LEFT key clamp.
C. Line up the key’s tip with the key stop.
D. Turn Knob to clamp the key in
Step 3: Load the Key Blank
MACHINE SHOULD BE OFF

A. Pull Jaw down and slide to the LEFT to lock down again.

B. Load the Key Blank on RIGHT key clamp.
   1. Align so it matches the original key, as shown.
   2. Turn Knob to clamp the key in

C. Slide Jaw to the RIGHT and raise it up so the key aligns with the Key Tracer

D. Make sure Key Blank aligns with the key cutting wheel as shown.
Step 4: Turn Machine On

A. Pull Crank Lever Out

B. Turn Power Switch ON

C. Press Cycle Start Switch
Machine will begin tracing automatically

Use the de-bur brush to de-bur keys BEFORE removing key from the machine.
For Manual Trace

A. Turn Machine OFF
B. UNPLUG Machine

C. Follow Steps 1 through 3 to prepare the machine
D. Turn Crank Lever clockwise (follow the direction of the arrow) until the key is fully traced
To Adjust Cutting Depth

To make a deeper cut on the key, adjust the TRACER:

A. Loosen the 2 Hexnut screws (1 & 2 shown)
B. Turn the Philips Head screw located under the Tracer (3) until the desired depth is reached.