

Lock Depot Inc

HPC Key Machine Maintenance & Calibration Guide

Overview

Proper maintenance extends machine life and ensures consistent key quality. Scheduled preventive maintenance eliminates costly downtime.

Cutter Replacement Schedule

Blitz: Replace every 3-6 months heavy use (50+ keys daily). Replace immediately if keys show rough edges. CodeMax: Factory cutters every 6-12 months depending on volume. Monitor cutting quality; replace proactively.

Jaw Alignment Verification

Misaligned jaws cause inaccurate key depths. Weekly: place test key in machine, cut halfway. Remove, measure depth with calipers. Should match specification within 0.002". If variance exceeds tolerance, realign per manual instructions.

Calibration with Test Key

Master test key provided with machine. Run test key monthly. Compare cutting accuracy. All dimensions should fall within 0.001" tolerance. If not, recalibrate depth stops and spacing mechanisms.

Cleaning Procedure

Remove key dust accumulation weekly. Use compressed air (40 psi maximum) to dislodge debris. Wipe exterior with soft cloth. Avoid heavy solvents on painted surfaces. Lubricate moving parts per manufacturer specifications.

Depth Key Checking

Depth key controls cutting depth per profile. Worn depth keys reduce accuracy. Inspect quarterly. Replace when wear exceeds 0.005". Depth keys are precision components; use manufacturer-approved replacements only.

Space Key Inspection

Space key positions blank horizontally. Wear causes inconsistent spacing. Check annually. Replacement parts available from HPC. Proper spacing critical for key functionality.

Common Issues & Solutions

Keys binding during cut: clean jaws, verify alignment. Rough key edges: replace cutter. Inconsistent depths: calibrate with test key. Machine noise: lubricate bearings per manual.

Documentation

Maintain service log: dates, maintenance performed, technician. Document cutter replacement schedule. Track key machine ROI (revenue vs maintenance cost). Justifies future equipment investment.