

MicroAdjust MA375 & MA380

Ryтан
INCORPORATED

Adjustable stylus installation instructions

For use on our RY100 & RY200 Semi-Automatic Key Duplicating machines

INSTRUCTIONS

- 1 Use a 3/16" Allen wrench and remove the long bolt, washer, and hex nut. Store these parts safely.
- 2 Use a 5/32" Allen wrench to **loosen** the two screws holding the stylus - about 1 or 2 turns. Set the stylus aside if reusing, or store safely if you've purchased a new MA assembly.
- 3 Use a 1/8" Allen wrench to remove the long set screw and the Stylus Adjustment Knob. Store these parts safely.
- 4 Turn the dial clockwise until it stops. Reverse the dial about two turns back and leave it on ZERO.

Install two new, un-cut keyblanks; one in each jaw.

- 5 Release the carriage and carefully place the right key against the cutter as shown in DETAIL A. You may need to rotate the cutter wheel manually.

- 6 Place your new assembly into the stylus holder and gently press the stylus against the key as shown in DETAIL B. Press the microadjust firmly into the stylus holder and tighten the two screws you loosened in step two, being careful not to overtighten.

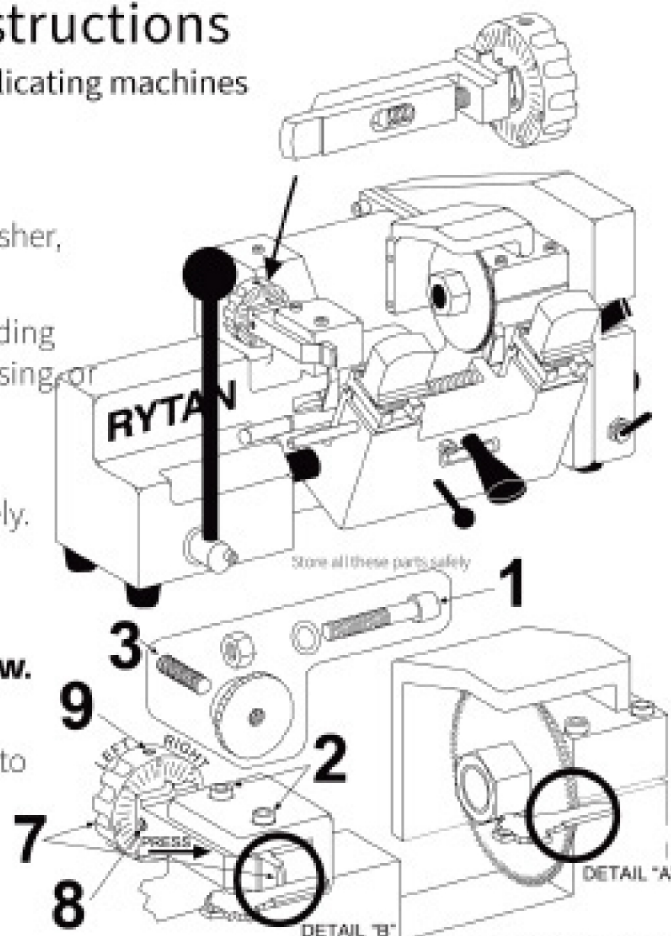
- 7 Lock the carriage back and out of the way. Turn the dial back and forth to confirm the stylus moves in and out properly. Make sure the stylus does NOT move sideways - if it does, release the screws and repeat steps 6 & 7.

Face your machine and turn the dial to the left to "10." Switch your machine on, release the carriage with the two keys still clamped, and position the left key against the stylus. The cutter should NOT cut into the key on the right. Slowly turn the dial back to the right and STOP when you here the cutter just begin to hit the keyblank. This is your new "0" for your MicroAdjust.

- 8 Tighten the set screw shown just a little more than factory set.

- 9 Loosen the set screw in the dial, and turn it to "0." Retighten the set screw on the dial, being careful not to overtighten.

Your new MicroAdjust is now ready for use!



NOTE: Spring must be installed flush

