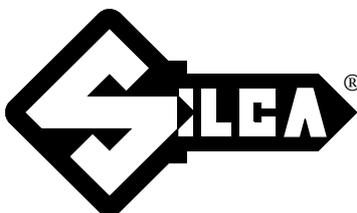


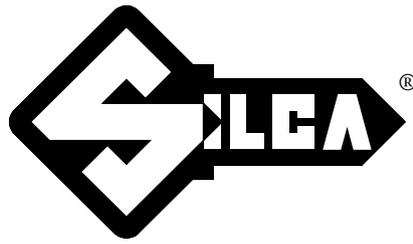
D737406ZB

R13 Motorized tilting clamp

D435301XA

vers.2.0





**R13 motorized tilting clamp
for TRIAX QUATTRO key-cutting machines**

Operating manual

Code: D435301XA - vers.2.0

9B

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1 R13 CLAMP

The R13 tilting clamp is used for cutting and decoding keys on a surface that varies from 0 to $\pm 45^\circ$ and can be employed to produce all types of keys with sloping cuts, such as Kaba®, Keso®, Lips® and Vachette Radial® (fig. 1).

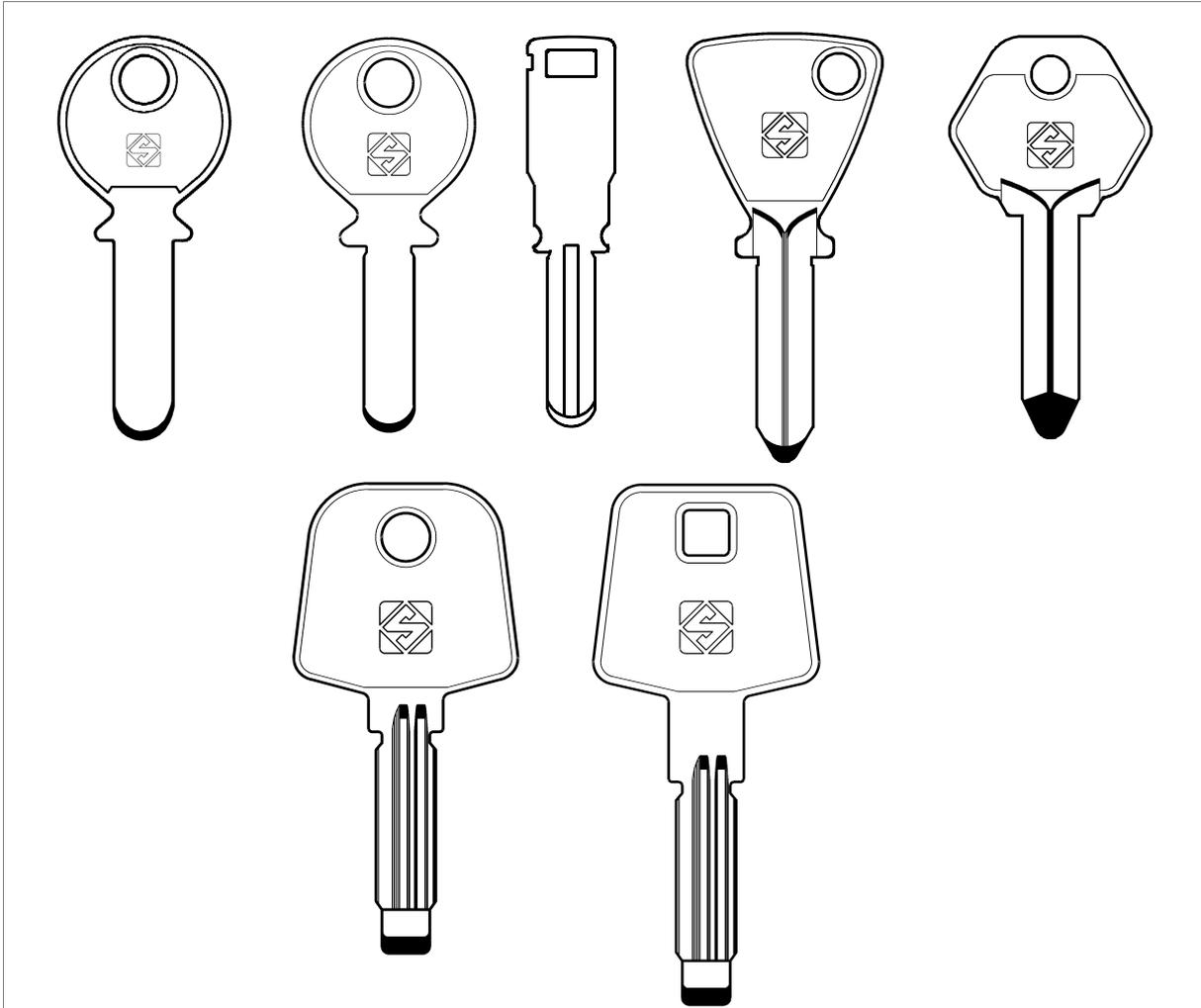


Fig. 1

1.1 Main operating parts

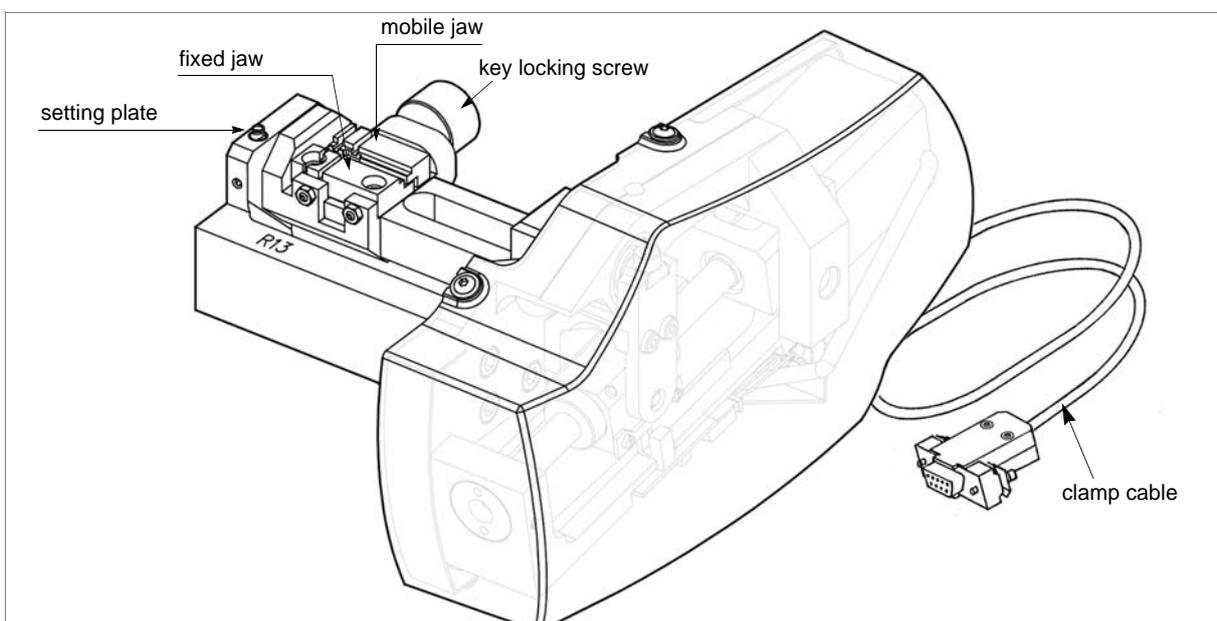


Fig. 2

2 INSTALLATION

ATTENTION: NEVER fit or remove the R13 clamp with the key-cutting machine in motion.

To remove the clamp:

- loosen the handle (A9) (fig. 3) and pull the clamp out of the dovetail guide.

To fit the clamp to the machine:

- insert the clamp into the dovetail guide, push all the way in and lock by turning the knob handle (A9).

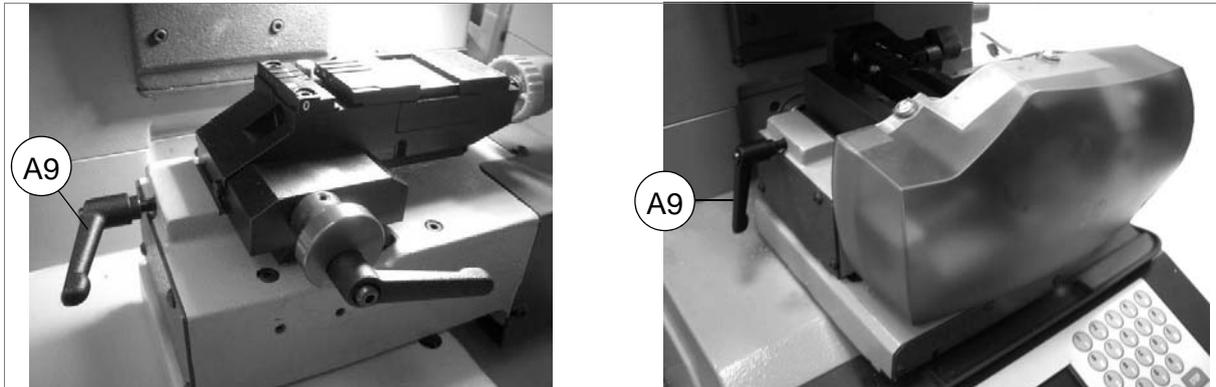


Fig. 3

- Connect the R13 clamp cable to the “axis B” receptacle (M) on the machine.

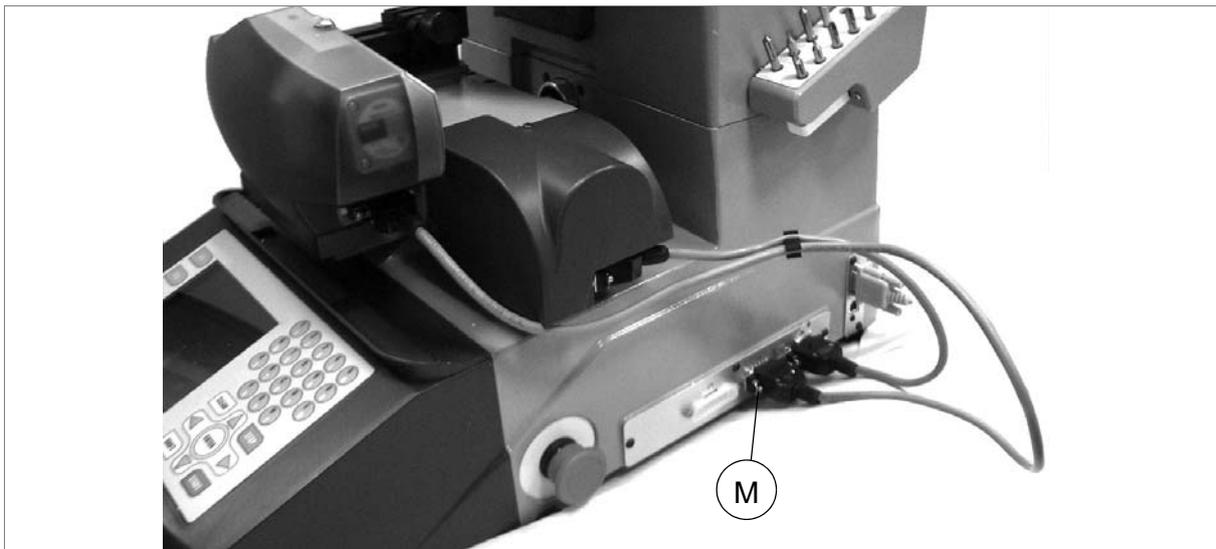
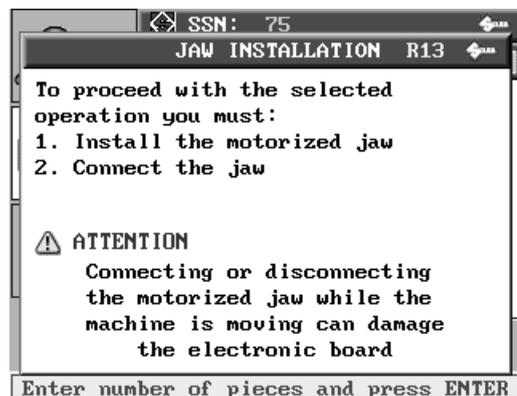


Fig. 4

WARNING MESSAGES

- **Installation R13 clamp**

This message appears on the machine display if the selected job requires the R13 clamp and it is not installed.



3 CALIBRATION

Before the R13 clamp can be used it must be calibrated automatically by the key-cutting machine, using the U103 tracer point on the TRIAX.

Follow the instructions below to gauge the clamp:

- Select CALIBRATION function from the main menu;
- Enter the CLAMP CALIBRATION menu and select R13 clamp; Press ENTER.
- A window will appear showing the adjustments to be made; proceed with START;
- Fit the U103 tracer and make sure the clamp is clean, press START;
- An automatic calibration procedure will begin, at the end of which a window will appear showing the gauging data. To save the data press ENTER (see Triax Quattro operation manual).

4 DECODING AND CUTTING

See the instructions for DECODING and CUTTING operations in the Triax Quattro manual.

4.1 AXES AND CUTTING SIDES

The cutting sides of the key are shown below, and the axes vary in number and position on the sides according to the type of system involved.

To use the clamp and carry out cutting it is sufficient to know the position of the side of the key.
See fig. 5.

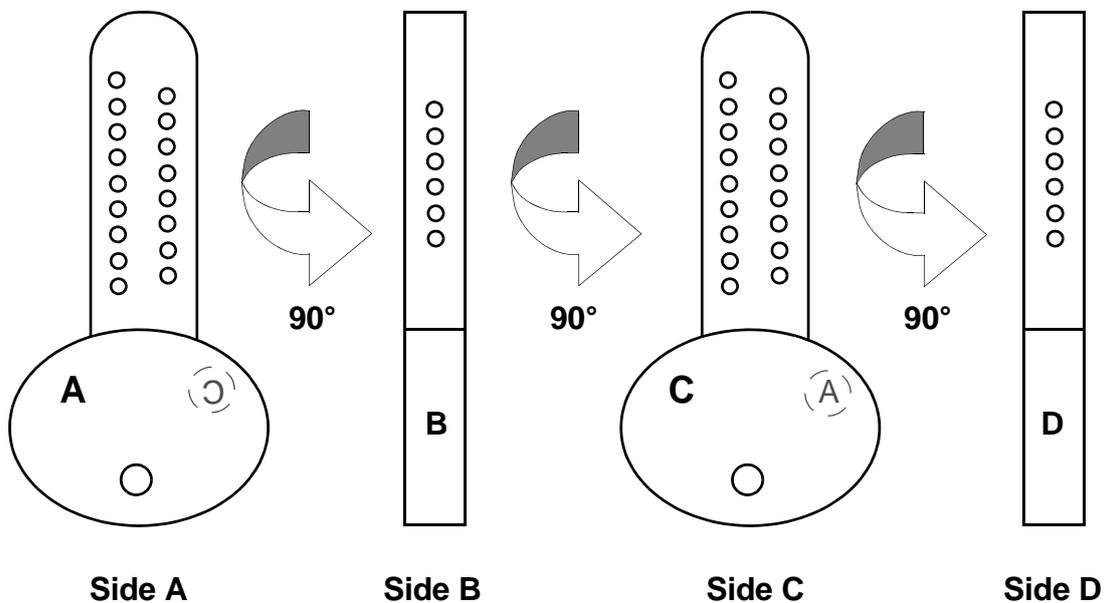


Fig. 5

KEY SIDES:

the key is to be positioned by the operator.

CUTTING AXES:

the key is positioned automatically by the clamp.

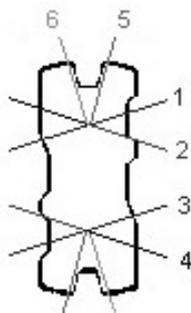


Fig. 6