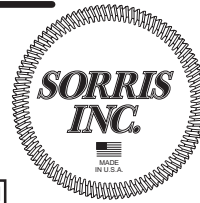


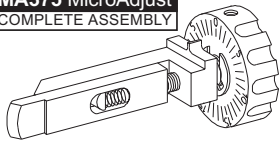
MicroAdjust

ADJUSTABLE STYLUS

INSTALLATION INSTRUCTIONS

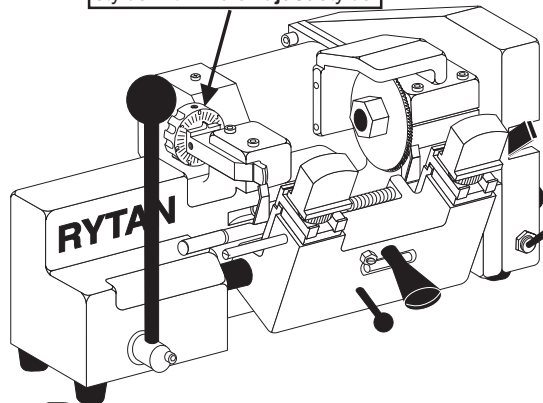


MA375 MicroAdjust
COMPLETE ASSEMBLY



ADJUST TO BETTER THAN 1/2 THOUSANTH - THAT'S .0005"!
Easy to install - ANYTIME.
Easy to calibrate and adjust.
Adjust stylus more than $\pm 0.015"$ from your zero point.
Built Exclusively for the Rytan Heavy-Duty RY100 Key Machine.

Replace your RY100 standard stylus with MicroAdjust stylus.



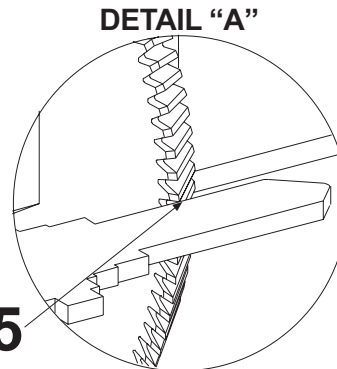
Ryтан RY100 Universal High-Speed Semi-Automatic Key Duplicating Machine

INSTRUCTIONS

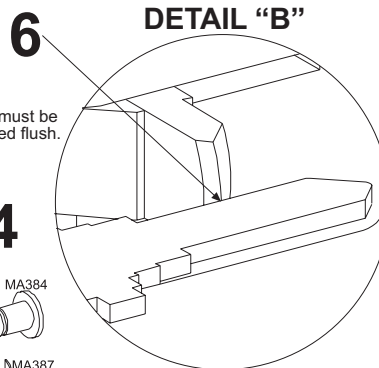
- 1** Use 3/16" Allen wrench and remove the long bolt, washer and hex nut. Store these parts in a safe place.
- 2** Use 5/32" Allen wrench to loosen (1-2 turns) the two screws holding the stylus. Remove the stylus and store it in a safe place.
- 3** Use 1/8" Allen wrench to remove the long set screw and Stylus Adjustment Knob and store these in a safe place.
- 4** Run MicroAdjust DIAL in (clockwise) until it stops. Reverse (unscrew) the DIAL two turns back and leave the DIAL on "0" zero.

Install two new un-cut key blanks; one in the right vise jaw and the other in the left vise jaw. Please use your top shoulder gauge and leave a small gap between the bottom shoulder of the keys and the left edges of both bottom vise jaws.

- 5** Carefully release the key machine Carriage and **CAREFULLY** place the right key against one of the teeth of the Cutter Wheel as illustrated in DETAIL "A". You may have to rotate the cutter wheel with your fingers to position the cutter tooth as illustrated. Please be careful not to cut into the key blank when rotating the cutter wheel into position. Leave the Carriage with its key resting against the Cutter Wheel.

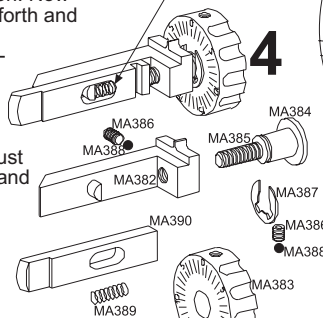


- 6** Now place your new MicroAdjust assembly into the Stylus Holder as illustrated and **GENTLY** press the stylus against the key as illustrated. Press (→) or tap the MicroAdjust firmly into the Stylus Holder and tightened the two screws that you loosened in step 2. **DO NOT OVERTIGHTEN THESE TWO SCREWS.**



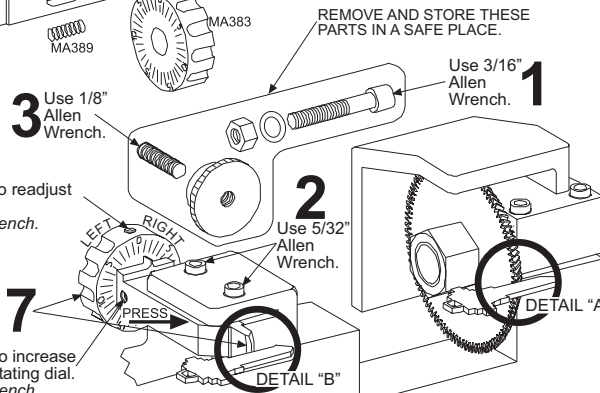
NOTE: Spring must be installed flush.

- 7** Pull the Carriage all-the-way back and lock it in position. Now turn the MicroAdjust DIAL about a half-turn back and forth and verify that the Stylus moves in-and-out properly. Next use your fingers and try to move the Stylus sideways - the Stylus should not move sideways when you try to move it. NOTE: If your Stylus sticks in the MicroAdjust holder when you back off the DIAL or if the Stylus can be moved sideways when you apply finger pressure you will have to readjust the MicroAdjust assembly by loosening the two Stylus Holder screws and repeat steps 6 and 7.



Facing the Key Machine turn the MicroAdjust DIAL to your left to about "10" on the dial. Switch ON your Key Machine, release the carriage with the two keys still clamped in their vises and gently position the LEFT key in the carriage against the MicroAdjust STYLUS - the spinning Cutter should not cut into the key on the RIGHT. Now **SLOWLY** turn the MicroAdjust DIAL back to the right and **STOP** when you hear the spinning Cutter Wheel just "tick" the key blank. This is your new "0" zero for your MicroAdjust.

- 8** Tighten the set screw **8** just a little more than "factory set".
- 9** Loosen set screw to readjust dial to "0" zero. Use 3/32" Allen Wrench.
- 9** Now loosen the set screw **9** and turn the *loosened* DIAL to "0" zero. Retighten (moderately) the set screw in the DIAL. **DO NOT OVERTIGHTEN.**



YOUR NEW MICROADJUST IS READY FOR USE!

- 8** Tighten set screw to increase resistance when rotating dial. Use 3/32" Allen Wrench.