



SMARTY 2000

Operating manual

D430568XA

vers. 3.0



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GUIDE TO THE MANUAL

This manual has been produced to serve as a guide for users of the SMARTY 2000 key-cutting machine. Read it carefully; it is essential if you wish to operate your machine safely and efficiently.

Consultation

The contents of the manual are divided into sections relating to:

- Transport and handling
- Description of machine and safety devices
- Proper use of machine
- Maintenance

Technical terms

Common technical terms are used in this manual. To assist those with little experience of key cutting, below is an illustration of the terms used for the different parts of keys:

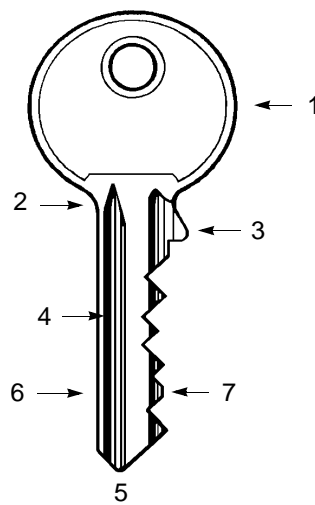


Fig. 1

- 1) Head
- 2) Rim
- 3) Stop
- 4) Stem
- 5) Tip
- 6) Back
- 7) Cuts

GENERAL INTRODUCTIONS

The SMARTY 2000 key-cutting machine has been designed according to the specifications of the Machine Directives. From the design stage risks for the operator have been eliminated in all areas: transport, key-cutting, regulation and maintenance.

A special adhesive label is attached to the machine warning the operator to use goggles during the cutting operations, and this is strongly recommended in this manual.

The material used in the manufacture of this machine and the components employed during use of the machine are not dangerous and their use complies with standards.

Use

The SMARTY 2000 must be installed and used in the way laid down by the manufacturer.

If the key-cutting machine is used differently or for purposes different from those described in this manual, the customer will forego any rights he may have over ILCO ORION. Furthermore, unforeseen danger to the operator or any third parties may arise from incorrect use of the machine.

Negligence in the use of the machine or failure on the part of the operator to observe the instructions given in this manual are not covered by the guarantee and the manufacturer declines all responsibility in such cases.

It is therefore indispensable to read the operating manual carefully in order to make the best use of the SMARTY 2000 and benefit from its potential.

Further Risks

There are no further risks arising from the use of the machine.

Protection and safety precautions for the operator

The SMARTY 2000 key-cutting machine is built entirely to standards. The operations for which it has been designed are easily carried out at no risk to the operator.

The adoption of general safety precautions (wearing protective goggles) and observation of the instructions provided by the manufacturer in this manual eliminate all human error, unless deliberate.

The SMARTY 2000 key-cutting machine is designed with features which make it completely safe in all its parts.

- **Power supply**

The key-cutting machine must be supplied with electricity by means of a safety device (standard with 230V key-cutting machines, on request for other voltages). The plug must be earthed.

- **Start-up**

The machine is started up by means of:

- 1) the main switch on the safety device (supplied with the 230V machines);
- 2) the ON switch, situated on the machine, which activates the machine motor.

- **Maintenance**

The operations to regulate, service, repair and clean the machine have been devised in the simplest and safest way possible. There is no danger of removable parts being replaced wrongly or unsafely.

- **Machine Identification**

The SMARTY 2000 key-cutting machine is provided with an identification label which shows the serial number (fig.2).

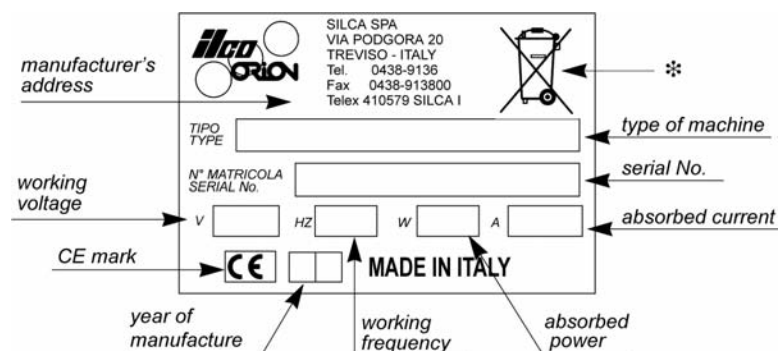


Fig. 2

(*) see chap. 9 DISPOSING OF MACHINE, page 21.

1 TRANSPORT

The SMARTY 2000 key-cutting machine is easily transported and is not dangerous to handle. The packed machine can be carried by one person.

1.1 Packing

The SMARTY 2000 is packed in a strong cardboard box, the dimensions of which are shown in fig.3, sufficiently robust to be used for storing the machine for long periods. Inside the box the machine is enclosed in two expanded polymer shells. The shells and cardboard box ensure safe transportation and protect the machine and all its parts.

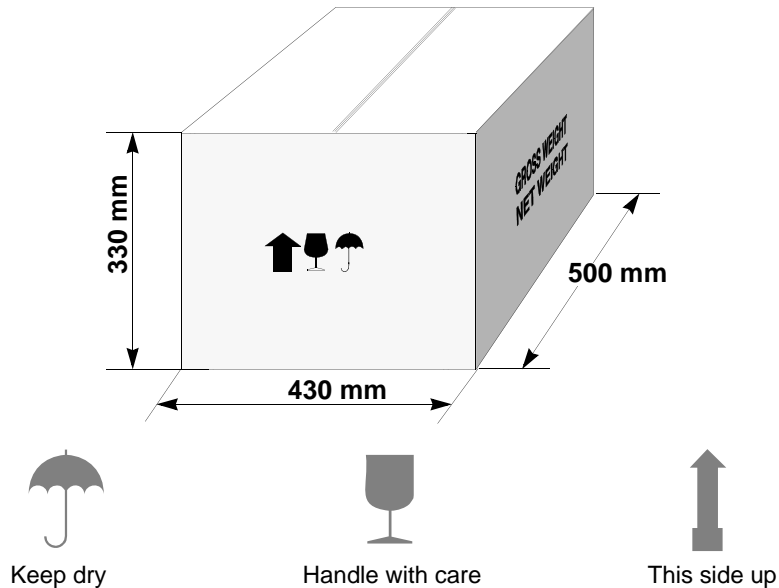


Fig. 3

1.2 Transport

To avoid damaging the SMARTY 2000 it must always be transported in its packing case. This will prevent sudden movements or rough handling from damaging the machine, persons or things.

1.3 Unpacking

To remove the machine from the packing box:

- 1) cut the straps with scissors and remove,
- 2) open the box without damaging it as it may be used again (e.g. removals, dispatch to the manufacturers for repairs or servicing).
- 3) check the contents of the box, which should comprise:
 - 1 SMARTY 2000 key-cutting machine packed in a protective shell;
 - 1 set of documents, including: operating manual, spare parts list and guarantee;
 - 1 carriage lever handle;
 - tools;
 - 1 safety device (supplied with the 230V machines);
- 4) remove the key-cutting machine from the protective shell.

1.4 Handling the machine

When the SMARTY 2000 has been unpacked, place it directly on its workbench.

This operation can be carried out by one person, **firmly holding the base, and no other part, to lift and carry the machine.**

2 MAIN WORKING PARTS

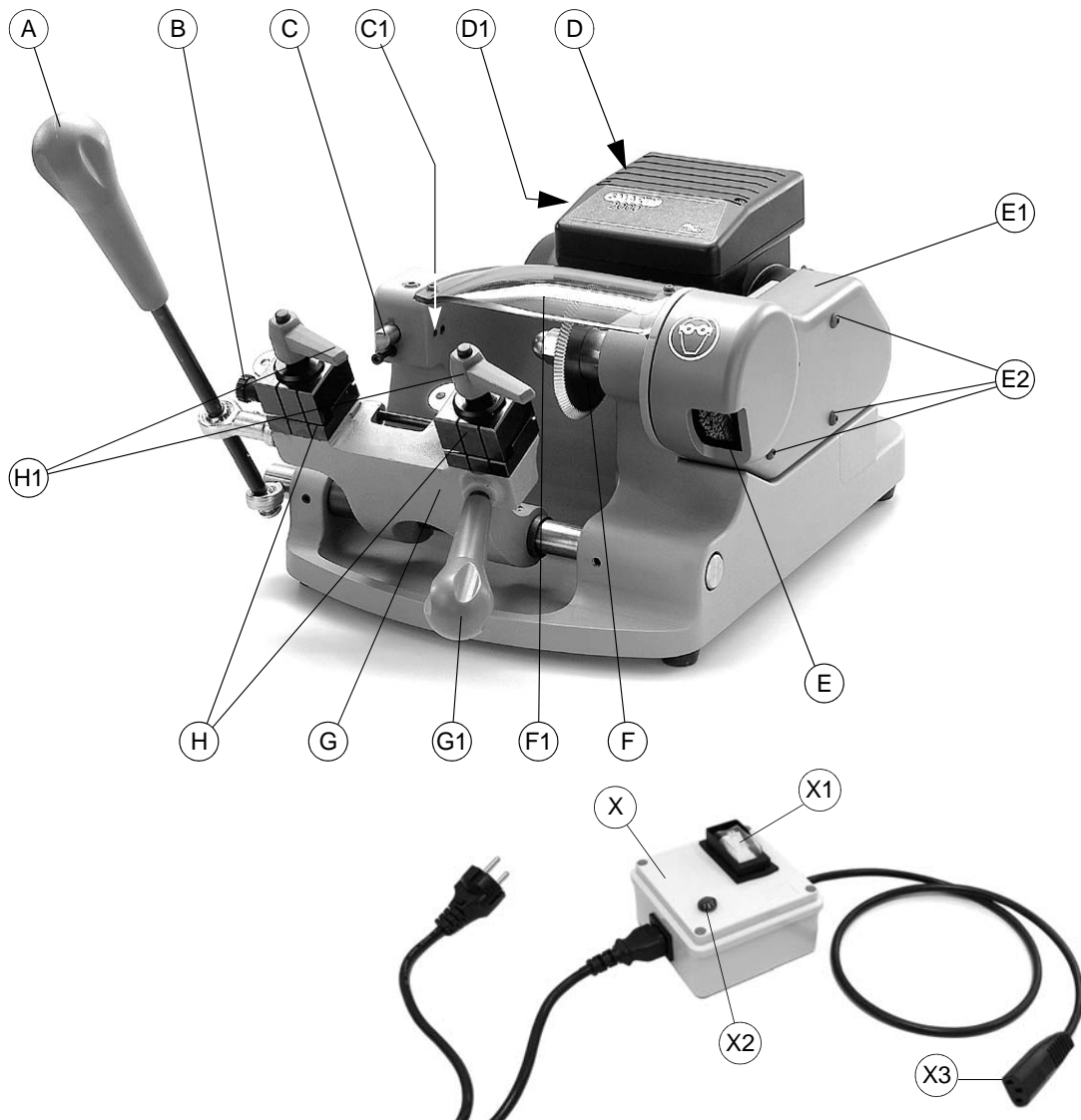


Fig. 4

- A - carriage movement lever
- B - gauge knobs
- C - tracer point
- C1- tracer point locking grub screw
- D - motor
- D1- motor start switch
- E - brush
- E1- brush cover
- E2- cover fixing Allen screw
- F - cutting tool
- F1- cutting tool cover
- G - clamp carriage
- G1- carriage handle lever
- H - clamps
- H1- clamp knobs

- X - safety device (supplied with the 230V machines)
- X1- main switch
- X2- warning light
- X3- plug

3 MACHINE DESCRIPTION

SMARTY 2000 is a professional cutting machine for flat keys used with cylinder, car locks and cruciform keys. The main parts of the machine are described below:

Safety device

The device is connected to a power plug with a differential switch, power the key-cutting machine by pressing the switch (X1).

The warning light (X2) illuminates to indicate voltage in the plug (X3).

ATTENTION: switch (X1) is electromagnetic, in the event of a power failure it goes out automatically. When electricity is restored it must be reset manually to power the machine again by means of the plug (X3).

Motor start-up switch

The motor start-up switch (D1) is placed on the left-hand side of the SMARTY 2000 key-cutting machine.

ATTENTION: the illuminated switch is always lit to show that the key-cutting machine is live.

Motor and transmission unit

The motor has belt transmission. The transmission unit is placed on the left of the motor and activates the brush (E) and cutting tool (F). These components are protected by three covers:

- brush cover (E1),
- cutting tool cover (F1).

Clamp carriage

The clamp carriage (G) consisting of two clamps (H), is fitted to the horizontal movement carriage, controlled by lever (A) and is provided with a handle (G1).

Cutting unit

The cutting unit contains the actual working parts of the SMARTY 2000 key-cutting machine, which operate together to cut and finish keys "read" from the originals.

The working parts are described below:

- **Brush**

The brush (E) is used to eliminate burrs from the cuts and is made of non-abrasive material.

- **Cutting Tool**

The cutting tool (F) is the part of the SMARTY 2000 used for cutting key blanks. The cutting tool is in TiAl super rapid steel and is protected by a special cover (F1) to ensure safe operation.

- **Tracer point**

The tracer point (C), used for reading the profile of the key to be copied, is housed on the right-hand side of the machine base. Assures regulation of the depth.

- **Clamps**

The clamps (H) have two sides (fig. 9 - pag. 14), which rotate to allow the key to be perfectly secured on its back or in profile.

- **Clamp knobs**

The clamps are locked by two anatomical knobs (H1) which ensure perfect grip on the keys with only slight locking pressure.

- **Calibration tabs**

The clamps have two gauge tabs, with which to adjust key alignment.

3.1 Technical Data

ELECTRICAL PROPERTIES:

- 230V-50Hz 190W- 1,5A
- 110V-60Hz 250W -3,5A

CUTTING TOOL: HSS (Super Rapid Steel)

MOTOR: One-speed single phase

MOVEMENTS: by ball joint on rectified carriage.

CLAMP: rotating with two sides, high precision.

MAXIMUM LENGTH OF CUTS: 45 mm

DIMENSIONS: width: 360 mm; depth: 450 mm; height: 290 mm

CUTTING NOISE:

- L_p(A) = max. 92,9 dB(A) (steel)
- L_p(A) = max. 85 dB(A) (brass)

WEIGHT: Kg. 23

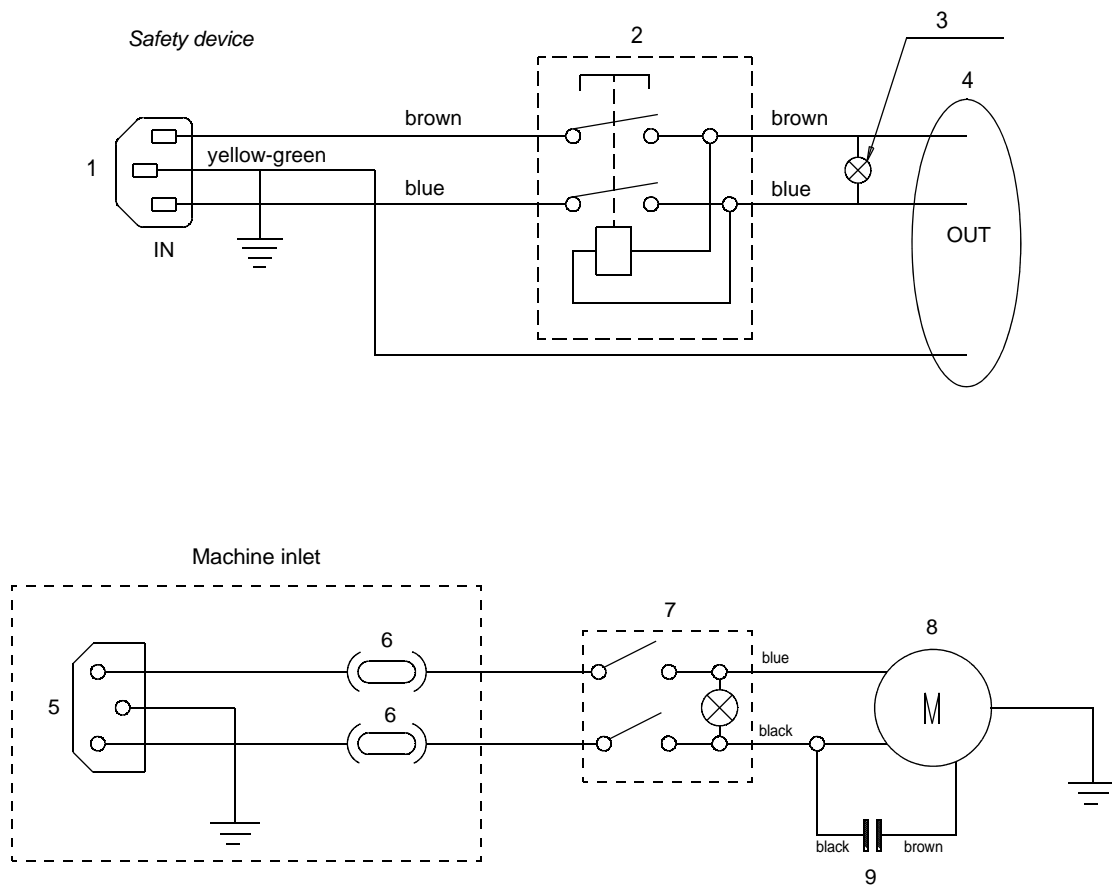
3.2 Electrical system

The SMARTY 2000 key-cutting machine is provided with a single phase one-speed motor:

- 1350 rpm, consumes approximately 0.18 Kw, absorption 1,5A on 230V version;
- 1680 rpm, consumes approximately 0.18 Kw, absorption 3,5A on 110V version.

The main parts of the electric circuit on the SMARTY 2000 are listed below:

- 1) Safety device inlet.
- 2) Safety main switch
- 3) Warning light
- 4) Wiring clip
- 5) Machine inlet
- 6) Fuses 4A (230V) - 6,3A (110V)
- 7) Illuminated switch
- 8) Motor: 230V a.c. 50Hz / 230V a.c. - 60Hz / 110V a.c. 60Hz
- 9) Condenser 8 μ F

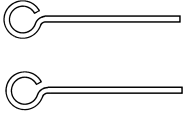

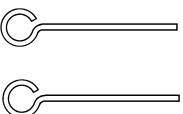

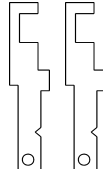







4 ACCESSORIES PROVIDED

To ensure trouble-free working with the SMARTY 2000, it is advisable to always have certain spare parts on hand. It is advisable to always have a tool box containing: tools, cutting tools, brushes, belts and small replacement parts.

SMARTY 2000 is supplied with a full range of accessories.

The accessories provided by ilco Orion are all that is necessary to carry out the operations for which the machine is designed.

 <p>code D401224ZZ Ø 1,20 mm steel pin 2 pcs</p>	 <p>code D300224ZZ 4 mm allen key</p>
 <p>code D401225ZZ Ø 1,70 mm steel pin 2 pcs</p>	 <p>code D300225ZZ 5 mm allen key</p>
 <p>code DMS200080 adjusting bar 2 pcs</p>	 <p>code DMS200340 spanner 13/17/19 mm</p>
 <p>code D300222ZZ 2,5 mm allen key</p>	 <p>code DMS200042 Cutting tool unclamping pin</p>
 <p>code D300223ZZ 3 mm allen key</p>	 <p>code D301185ZZ (230V) Fuses 5x20 4A-rapid code D306748ZZ (110V) Fuses 5x20 6,3A-rapid</p>

5 MACHINE INSTALLATION AND PREPARATION

The SMARTY 2000 key-cutting machine can be installed by the purchaser and does not require any special skills.

However, some checks and preparation for use need to be carried out by the operator.

5.1 Checking for damage

The SMARTY 2000 key-cutting machine is solid and compact and will not normally damage if transport, unpacking and installation have all been carried out according to the instructions in this manual.

However, it is always advisable to check that the machine has not suffered any damage.

5.2 Environmental conditions

To ensure that the best use is made of the SMARTY 2000 key-cutting machine, certain parameters must be borne in mind:

- damp, badly ventilated sites should be avoided.
- The ideal conditions for the machine are:
 - temperature: between 0 and 40°C;
 - relative humidity: 60% circa

5.3 Positioning

Place the key-cutting machine on a horizontal surface, solid enough to take the weight (23 Kg). To facilitate operation and maintenance, install the machine with a space of at least 300 mm on all sides (fig.5).

Ensure that the machine stands perfectly balanced on the four feet. Vibration is avoided when the machine is properly set on the horizontal plane.

ATTENTION: ensure that the machine voltage is the same as that of the mains, which must be properly earthed and provided with a differential switch.

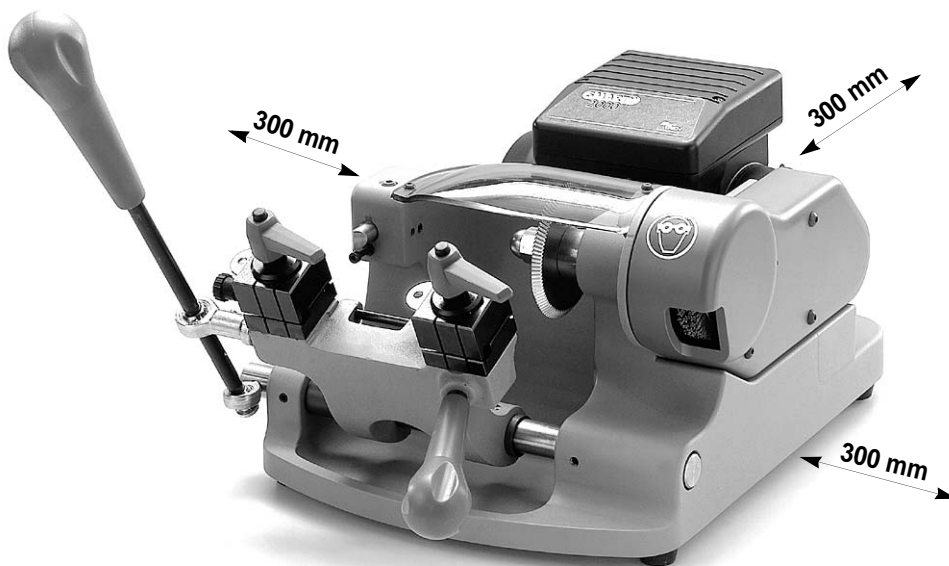


Fig. 5

5.4 Description of work station

The key-cutting machine needs only one operator, who has the following controls at his/her disposal:

- **Safety device (X) (standard with 230V key-cutting machines).**
- **Motor start switch (D1) (fig.4, page 8), placed on the left-hand side of the machine; illuminated to show that the machine is live.**
- **Carriage movement lever (A).**
- **Carriage handle lever (G1).**
- **Gauge knob (B).**

5.5 Graphics



THE USE OF PROTECTIVE GOGGLES
IS COMPULSORY

5.6 Separate parts

The separately packed parts must be installed on the SMARTY 2000 key-cutting machine by the purchaser, as follows:

Carriage lever handle

Screw the handle (G1) onto the carriage lever (fig.4, page 8).

Power cable

First connect the safety device (X) (supplied with the 230V machines) to the key-cutting machine and the power cable then connect the free end of the power cable to the power mains (fig.6).

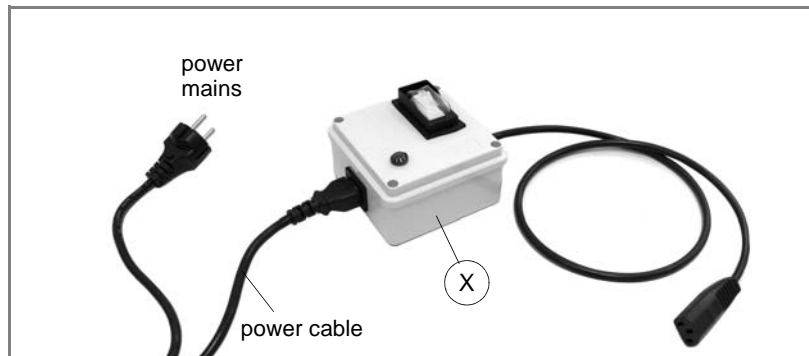


Fig. 6

5.7 Removing the blocks

Remove the plastic block between the carriage and the machine body.

5.8 Connection to the mains

For the safety of the operator and the machine it is important to ensure that the machine is connected to the proper mains voltage by means of an earthed differential switch.

6 REGULATION AND USE OF THE MACHINE

6.1 Checking and setting

The cutting tool on the SMARTY 2000 is the part used to cut the key blanks and should be periodically checked and replaced, if necessary.

Every time the cutting tool is changed, and during periodical operational tests, check calibration.

6.2 Calibration

The SMARTY 2000 key-cutting machine requires two types of calibration: axis and depth.

Axis calibration:

Axis calibration is regulation of the space between the stop and the cuts (fig.7). The axis setting for the SMARTY 2000 is fixed and is established on assembly in our workshops.

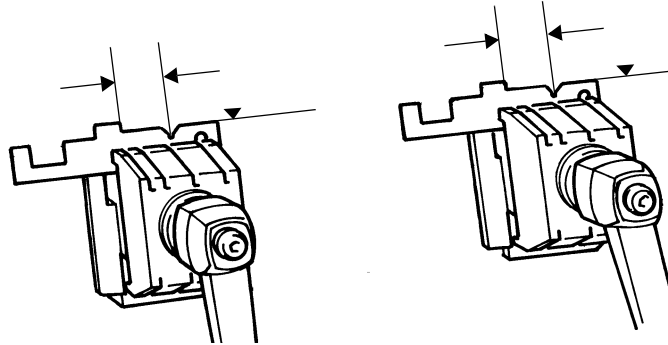


Fig. 7

Depth calibration:

Depth calibration is regulation of the cutting depth (fig.8-A).

Proceed as follows:

- 1) ensure that the key-cutting machine is off by unplugging the power cable.
- 2) place the adjustment plates (provided) on the clamps (fig.8-B).
- 3) check that the adjustment plates adhere properly to the clamps (fig.8-B).
- 4) turn the calibration rod towards the operator so that the gauges (B1) come into contact with the adjusting keys (fig.8-B).
- 5) raise the carriage and take up to the cutting tool (F).
- 6) take the keys into contact with the cutting tool and tracer point.
- 7) turn the cutting tool anticlockwise manually and check that it skims the adjusting keys in several places.
- 8) if necessary, regulate the depth of the cut with the micrometric tracer point, as follows (fig.14, page 20):
 - a) loosen the screw (C1) holding the tracer point (C) (fig.14, page 20).
 - b) turn the grub screw (C2) clockwise to advance the tracer point.
 - c) turn the grub screw (C2) anticlockwise to return.
- 9) repeat these operations until regulation is complete, then tighten the tracer point locking grub screw (C1).

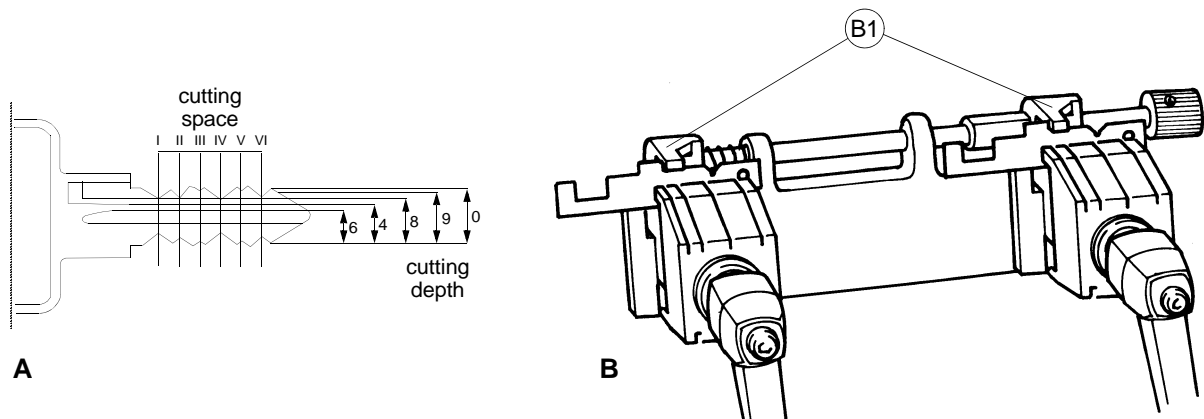


Fig. 8

7 KEY CUTTING

ATTENTION: for complete safety during the cutting operations, take the following precautions:

- Always work with dry hands.
- Check that the machine is properly earthed.
- Use the protective goggles, even if the cutting tool is fitted with a protective shield.
- Start the motor only when all the operations with the carriage have been carried out (securing keys, etc...).
- Keep hands away from the cutting tool when in motion.
- Before duplicating, remove the gauges.

7.1 Key cutting

- 1) turn the clamps to find the appropriate side for securing the key (fig.9)
- 2) loosen the knobs (H1) (fig.9) by a couple of turns.
- 3) raise the lower part of the clamps and turn to the required position:
 - **Side A:** for keys to be fitted on their backs (fig.9-B);
 - **Side B:** for keys to be cut on both sides and locked on the groove (fig.9-B).

Securing the keys in the jaws

- 1) position the original key (left-hand jaw) and key blank (right-hand jaw), ensuring that:
 - a) the keys are positioned and secured;
 - b) the key stop is resting against the calibration tabs (B1) (fig.8-B);
- 2) secure the keys by closing the clamps with the knobs (H1) (fig.9).

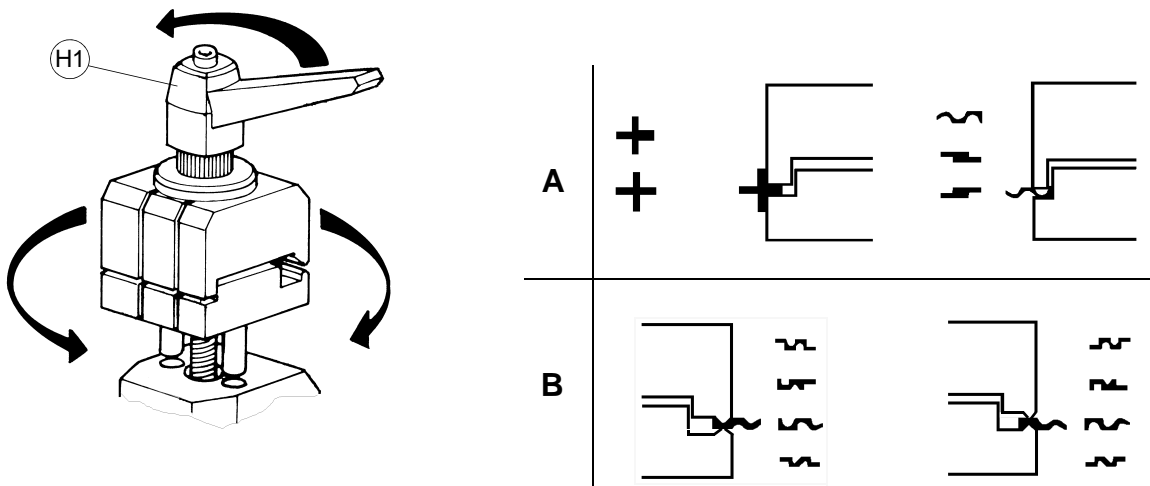


Fig. 9

Key cutting

When the SMARTY 2000 key-cutting machine has been turned on by means of switch (D1) it is ready for cutting:

- 1) take the carriage up to the tracer point and cutting tool.
- 2) to copy the key, move the carriage sideways from right to left by means of the lever (A).
- 3) turn off the machine with switch (D1) (fig.4, page 8) before removing the duplicated key.
- 4) remove the keys from the clamps.
- 5) turn on the machine with switch (D1) and smooth off the key edges by means of the brush (E) (fig.4, page 8).

7.2 Using the accessories

The accessories provided with the SMARTY 2000 to assist key-cutting are:

- pins
- bars.

Using the pins

The pins must be inserted between the bottom of the jaw and the back of the key for keys with narrow stems, and their purpose is to ensure that the key protrudes sufficiently to be cut properly (fig.10, fig.10-C).

For keys with narrow, thin stems, two pins must be used (fig.10-B), the second one to give a secure grip on the key.

If the key thickness is too fine to guarantee a good grip in the clamps, a pin must be used (fig.10-A).

ATTENTION: the pins provided have two different diameters: 1,20 mm and 1,70 mm. It is essential to use pins with the same diameters for locking both the original and the key blank.

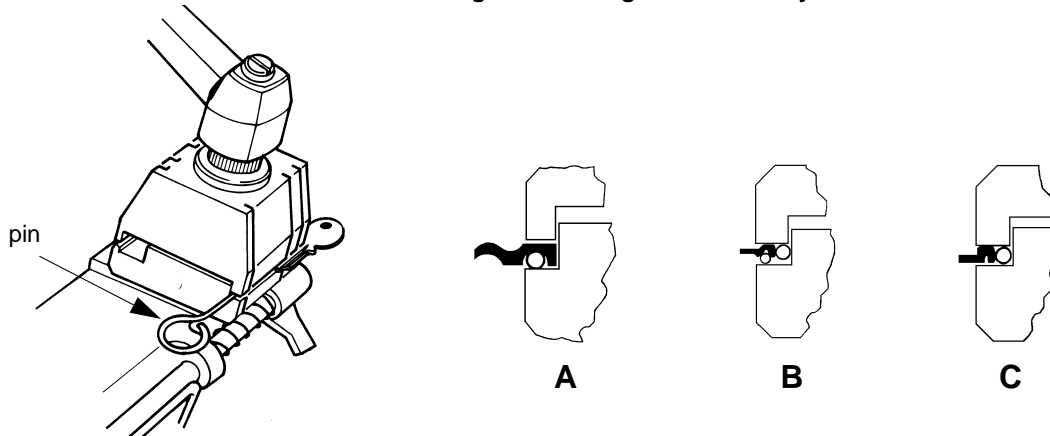


Fig. 10

Using the bars

The bars provided (P) (fig.11) are used for cutting pin keys and as a tip rest for locking keys with no stop (fig.12).

Cutting pin keys using bars

All types of pin keys (90°) can be cut with the SMARTY 2000 clamps and the aid of the bars.

Positioning pin keys:

- 1) leave the gauges in the idle position.
- 2) insert the bars with neck into the slot in the clamps.
- 3) butt the key stop against the bars (P) (fig.11).
- 4) secure the keys in the clamps.
- 5) remove the bars (P) from the clamp grooves to prevent it being touched by the tracer point or cutting tool.
- 6) cut the first side.
- 7) repeat the operation, turning the keys in the same direction for the other positions.

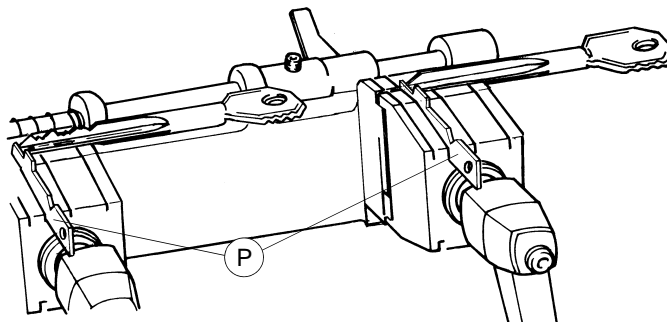


Fig. 11

Tip stop with a bar

The bars (P) can be used with keys which have no stop (fig.12). Proceed as follows:

- 1) leave the gauges (B1) in the idle position;
- 2) insert the bars (P) into the slot in the clamps;
- 3) rest the tip of the key against the bar (P);
- 4) secure the key and remove the bar (P).

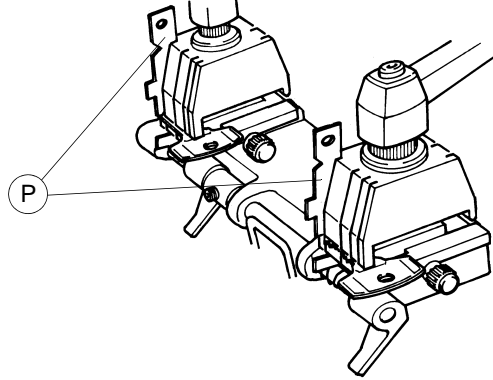


Fig. 12

8 MAINTENANCE

Although the SMARTY 2000 key-cutting machine does not require special maintenance, it is advisable to check and, if necessary, replace the parts subject to wear, such as: the belt, cutting tool, brush, tracer point. Replacement is simple and can be carried out by the operator.

CLEANING: keep the carriage and clamps free of chippings from the cutting operations by cleaning with a dry brush.

ATTENTION: do not use compressed air!

Before starting any type of maintenance (checks or replacements), read the instructions below:

- **never carry out maintenance or servicing with the machine switched on.**
- **always remove the mains plug.**
- **follow all the instructions in the manual to the letter.**
- **use original spare parts.**
- **always check that any screws or nuts removed when replacing a piece are properly tightened.**

8.1 Replacing the cutting tool

In order to substitute the cutting tool you don't need to remove the cutting tool cover (F1) (fig.4, page 8).

ATTENTION: remove the mains plug.

- 1) slot the locking rod (standard) into the hole of the cutting tool shaft (fig.13).
- 2) use the spanner provided to loosen the cutting tool locking nut.

ATTENTION: the thread is left-handed.

- 3) remove the worn cutting tool.
- 4) carefully clean the new cutting tool and its seat.
- 5) install the new cutting tool and tighten the nut.

ATTENTION: the tool rotates clockwise.

- 6) remove the locking rod.

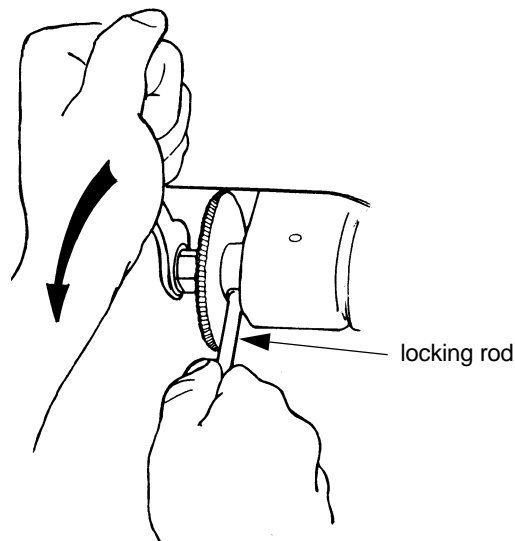


Fig. 13

8.2 Replacing the brush

When the brush (E) no longer cleans off the burrs it must be replaced as follows:

ATTENTION: remove the mains plug.

- 1) remove the motor cover (E1) by loosening the screws (E2) (fig.4, page 8).
- 2) place the spanner provided in position on the motor shaft.
- 3) use the Allen wrench to loosen the screw holding the brush (E) in place.
- 4) replace the brush (E) and tighten the screw with the Allen wrench.
- 5) remove the spanner from the motor shaft.
- 6) place the motor cover (E1).

8.3 Replacing the belt

Worn or loose belt must be replaced or adjusted so as to ensure safe and proper operation of the cutting tool/ brush. Proceed as follows:

ATTENTION: remove the mains plug.

- 1) remove the motor cover (E1) by loosening the screws (E2) (fig.4, page 8).
- 2) loosen the four screws which fix the motor to the base.
- 3) raise the motor and remove the worn belt.
- 4) fit the new belt.
- 5) push the motor down until the proper belt tension is obtained.
- 6) tighten the four screws.

8.4 Replacing the tracer point

To replace the tracer point (C) proceed as follows (fig.14):

ATTENTION: remove the mains plug.

- 1) loosen the screw (C1).
- 2) loosen the screw (C2) until the tracer point (C) is fully released.
- 3) fit the new tracer point.
- 4) tighten the screw (C1) and secure the tracer point.
- 5) re-set the machine as described in this manual (ch.6, page 15).

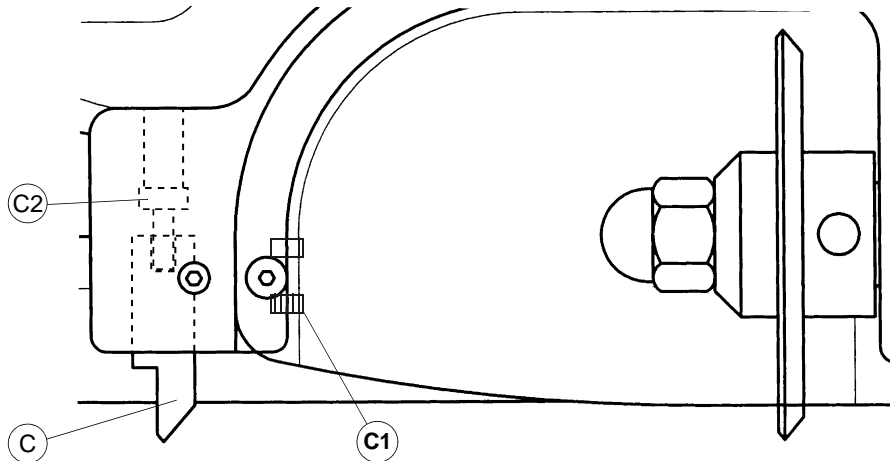


Fig. 14

8.5 Replacing the fuses

ATTENTION: remove the mains plug.

- 1) turn the key-cutting machine so that the fuse box is easily reached.
- 2) remove the fuses box placed below the key-cutting machine socket (fig.15).
- 3) replace the fuses (U).
- 4) close the fuses box and connect the power cable.

ATTENTION: fuses must always be replaced with others of the same type (rapid) and with the same Amps (4 Amps for 230V machines, 6,3 Amps for 110V machines).

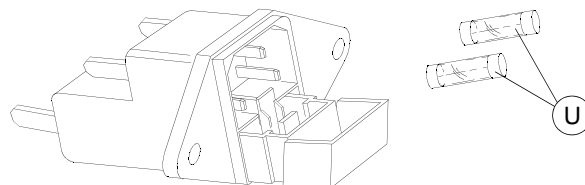


Fig. 15

9 DISPOSING OF MACHINE

To dispose the machine, it must be rendered unusable by carrying out the operations listed below:

- deactivation of the electricity supply;
- separation of the plastic and metal parts;

When these operations have been carried out, the machine can be disposed of according to the current regulations in the country of use.

Waste disposal

As CEE norms refer to specific waste (**) disposal methods for each country, the regulations current in the country where the machine is installed must be observed.

Machine

The SMARTY 2000 is made up of recyclable parts.
Recycling is ecologically recommended.

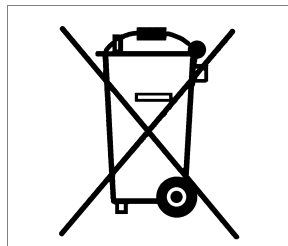
Packing

The SMARTY 2000 is consigned in a cardboard packing box which can be re-used if undamaged. When it is to be thrown away it is classified as solid urban waste and should be placed in the special paper collecting bins.

The protective shell containing the machine is in polymer, classified as SUW, and can therefore be placed in an ordinary waste bin.

Waste deriving from key cutting

The waste deriving from key cutting is classified special waste, but is still classified as solid urban waste, as metal wool. Such waste must be disposed of in special collection centres according to the classification assigned to them by the current EEC law. The circumstances which transform metal residue from solid urban waste into contaminated or toxic noxious waste are listed in the appendices to the current European Union regulations regarding disposal of such waste.



INFORMATION FOR USERS

*as per art. 10 of Directive 2002/96/CE of 27/01/2003
regarding waste from electric and electronic appliances (RAEE),*

- The symbol illustrated above, also found on the machine, indicates that it has been placed on the market and must be included in separate rubbish collection when the user wishes to dispose of it (including all components, sub-assemblies and consumables that are integrated in the product).
- For information about the collection system for such appliances please contact SILCA S.p.A. or another subject registered in the various National Rolls for other countries in the European Union. Household waste (or of similar origin) can be included in the separate collection system for urban waste.
- On purchasing a new appliance of equivalent type, the old one can be consigned to the dealer. The dealer will then contact whoever is responsible for collecting the appliance.
- Suitable separate collection of the unused appliance and its dispatch for treatment, recovery and environmentally compatible disposal, makes it possible to avoid potential negative effects on the environment and human health, and aids recycling and the recovery of the materials used.
- Unauthorised disposal of the product by users involves the application of the sanctions provided for in received Directives 91/156/CE and 91/689/CE.

(**) Waste is any substance or object deriving from human activity or natural cycles, disposed off or to be disposed off.

10 AFTER-SALES SERVICE

Ilco Orion provides full service to purchasers of the SMARTY 2000 key-cutting machine. To ensure complete safety to the operator and machine, any job not specified in this manual should only be carried out by the manufacturer or recommended Ilco Orion Service Centres.

On the back cover of this manual is a list of the manufacturer's addresses; listed below are the addresses of specialized service centres.

10.1 How to request service

The guarantee attached to the SMARTY 2000 ensures free repairs or replacements of faulty parts within 12 months of the date of purchase. All other service calls must be arranged by the customer with Ilco Orion or specialized Ilco Orion service centres.



VITTORIO VENETO 11/11/2005

CE DECLARATION OF MACHINE COMPLIANCE

**SILCA S.p.A. - VIA PODGORA 20 (Z.I.)
31029 VITTORIO VENETO (TV) - (ITALY)
TEL. 0438 9136 - FAX. 0438 913800**

Declares under its own responsibility that the **Key-cutting machine** model

SMARTY

complies with the requirements of the following European Directives:

European Union **DIRECTIVE 98/37/CEE** (Machines)
and with the EN 292/1 – EN 292/2 Standards

European Union **DIRECTIVE 89/336/CEE** (Electromagnetic Compatibility)
and with the EN 55014-1 / EN 61000 – 3 – 2 / EN 61000 – 3 – 3 Standards

European Union **DIRECTIVE 73/23/CEE** (Low Voltage) | **02** |
and with the EN 60204-1 (sections 20.2 – 20.3 – 20.4) Standards

General Manager Basic Production Center

Corrado Fischer