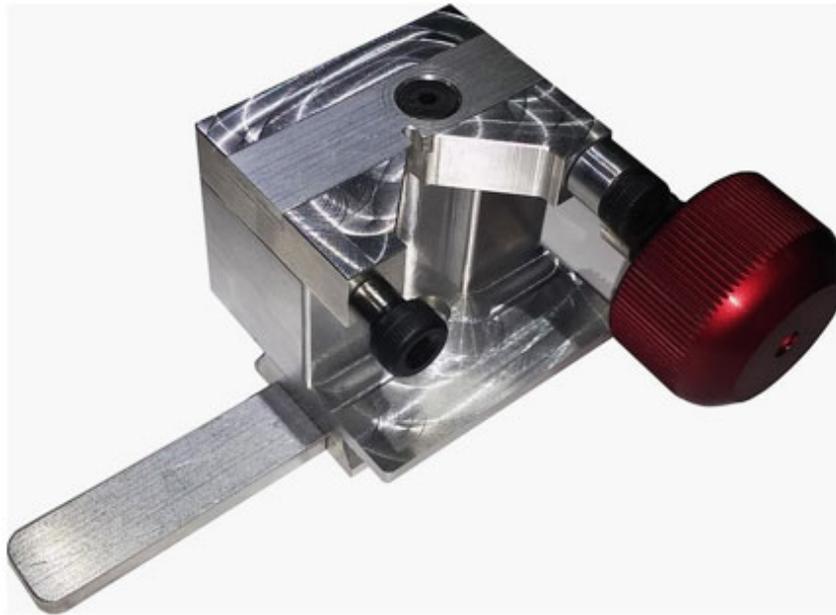


# 3D Xtreme Tubular Jaw



Tubular Cutter (Cutter 4)

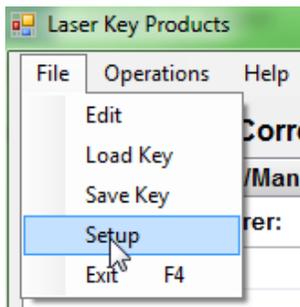


Tubular Tracer

## Software Setup

For software v15 or above:  
To check the software version go to  
'Help > About' The Tubular Jaw is  
supported by **v5.38.8 or higher**

In the 3D Xtreme software go  
to 'File > Setup'



Change both 'Calibration X1'  
and 'Calibration X2' to **1450**

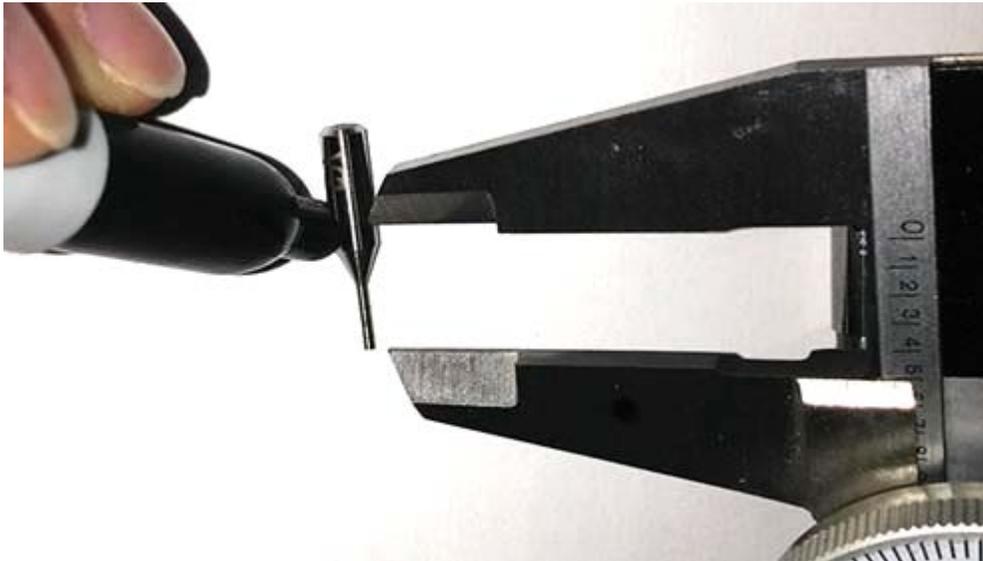
And then click 'Master Update'  
at the top right, press yes and OK  
and click 'File > Exit'

Jaw 1			Jaw 2		
<b>Cutter:</b>			<b>Cutter:</b>		
X-Start	Y-Start	Z-Start	X-Start	Y-Start	Z-Start
1763	1895	786	559	2333	0
Step 1(x)	Step 1(y)	Step 1(z)	Step 1(x)	Step 1(y)	Step 1(z)
-50	1400	125	300	-700	0
Calibration X1	Calibration Y1	Calibration Z1	Calibration X1	Calibration Y1	Calibration Z1
1950	1350	50	1800	2000	0
Calibration X2	Calibration Y2	Calibration Z2	Calibration X2	Calibration Y2	Calibration Z2
1950	2000	40	1800	1960	0
X-Start Offset	Y-Start Offset		X-Start Offset	Y-Start Offset	
0	0		0	0	
<b>Tracer:</b>			<b>Tracer:</b>		
X-Start	start	Z-Start	X-Start	Y-Start	Z-Start
1278	1857	528	1278	1857	528
Step 1(x)	Step 1(y)	Step 1(z)	Step 1(x)	Step 1(y)	Step 1(z)
-50	1400	90	0	0	0
Calibration X1	Calibration Y1	Calibration Z1	Calibration X1	Calibration Y1	Calibration Z1
1450	1400	35	600	60	0
Calibration X2	Calibration Y2	Calibration Z2	Calibration X2	Calibration Y2	Calibration Z2
1450	2000	20	-400	800	0
X-Start Offset	Y-Start Offset		X-Start Offset	Y-Start Offset	
0	0		0	0	

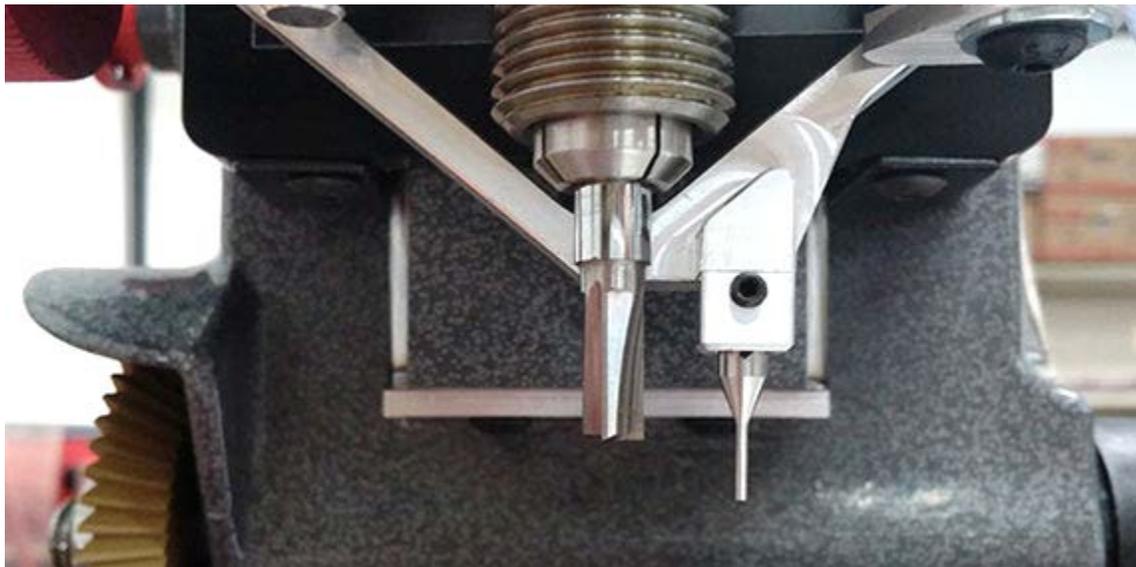
## Installing the Tubular Tracer and Cutter

Loosen set screw on tracer swing arm and remove current tracer.

On the tubular tracer tip, measure half an inch from the tip and make a mark.



Install the Tubular Tracer into the Tracer Swing Arm just under where the mark was made to where the tracer tip is just under half an inch sticking out of the swing arm. Insert the Tubular Cutter.



After installing the Tubular Tracer CALIBRATE THE TUBULAR TRACER ON JAW 1

(Tubular settings are shared with Jaw 1 calibration settings)

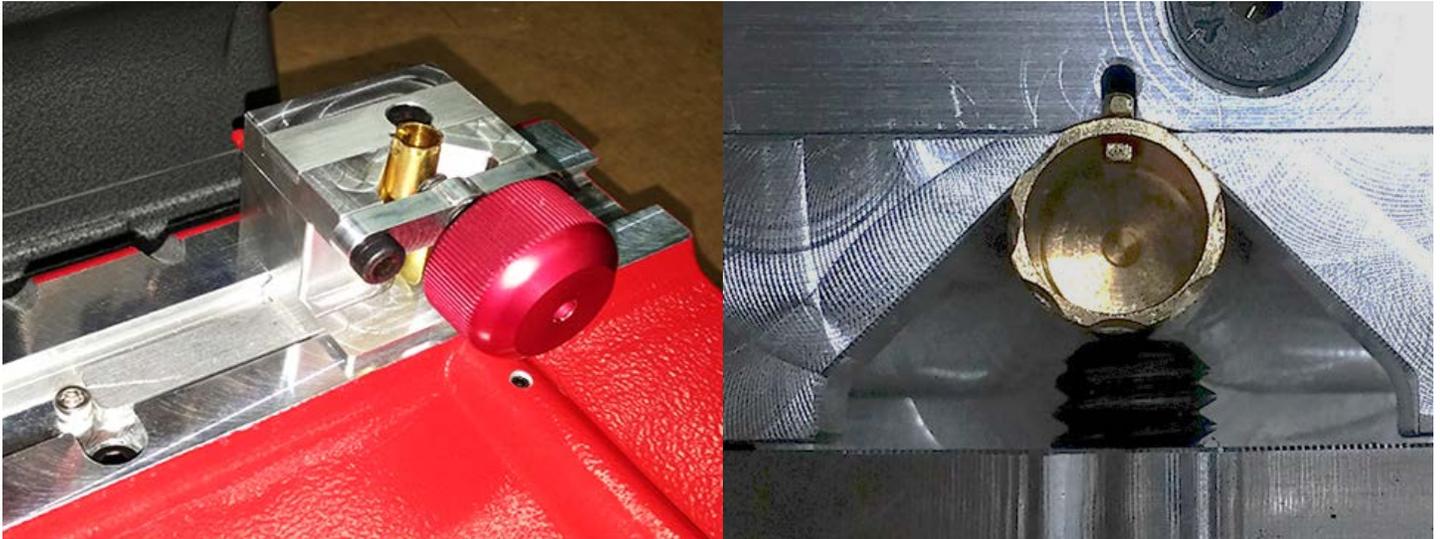
The Tubular tracer can be used to trace all keys, it is not necessary change out the tracer when changing jaws.

If you alternate between tracers you will have to calibrate each time

You will have to calibrate tracer for Jaw 3 also unless you plan to alternate between tracer types then you only have to calibrate for Jaw 1

## Using the Tubular Jaw

Loosen the red t-knob behind the main jaw assembly, slide off the main jaw assembly, and slide on the Tubular Jaw. There is a spacer on the left side of the Tubular Jaw that stops on the silver screw. Tighten the red t-knob to lock the Tubular Jaw into place.



### Supported Blanks:

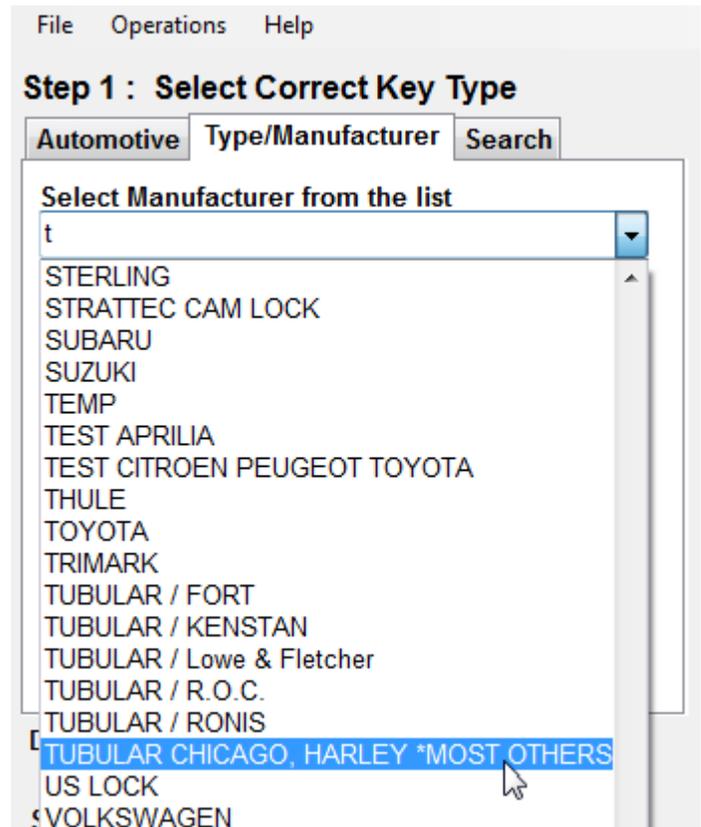
ILCO 1137B  
LSDA 1137B  
JMA CHI-1T



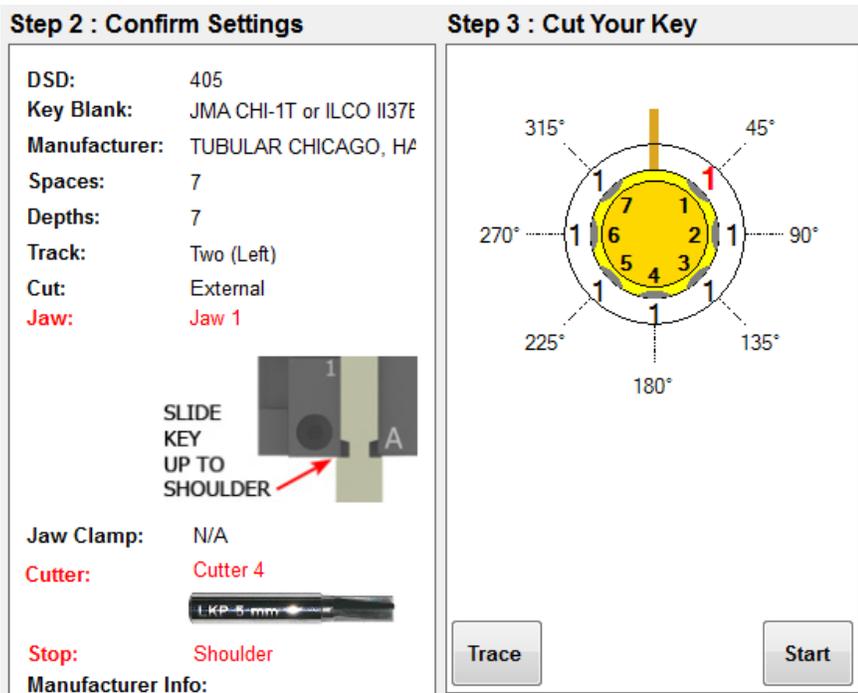
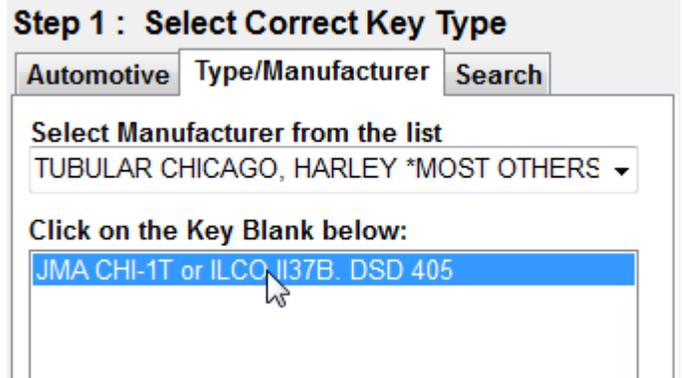
**Clamp keys** in the jaw with the notch of the key placed into the cut out at the back of the jaw. Tighten the red knob on the front until the screw is firmly holding the key in place.

## Selecting Tubular Keys in the Software

To select A Tubular key click the 'Type/Manufacturer' tab under 'Step 1: Select Correct Key Type' and choose the type of Tubular to use.



Then select the key blank being used.



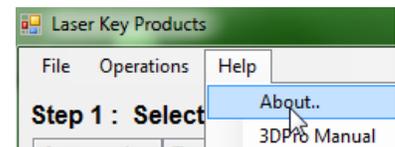
After placing the tubular key in the tubular jaw then click 'Trace' or enter cuts using the keyboard and click 'Start' when ready to cut.

Tubular Key DSDs

405, 406, 410, 411, 412, 413, 414, 415, 416

To search by DSD click 'Search' at the top left, enter a DSD number and click 'Search'

To check your software version go to 'Help > About'



The Tubular Jaw is supported by **v5.38.8 or higher** (v15 or above)



A video on how to use the Tubular Jaw can be found at [laserkeyproducts.com](http://laserkeyproducts.com)