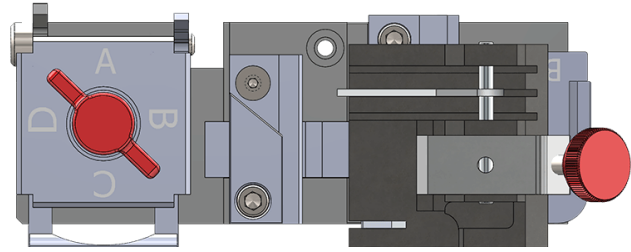


# Standard Tracing Adapter

Before using the Standard Tracing Adapter:  
Open the 3D Pro control software with the machine powered on and connected and go to **File > Setup** at the top left of the main software screen.



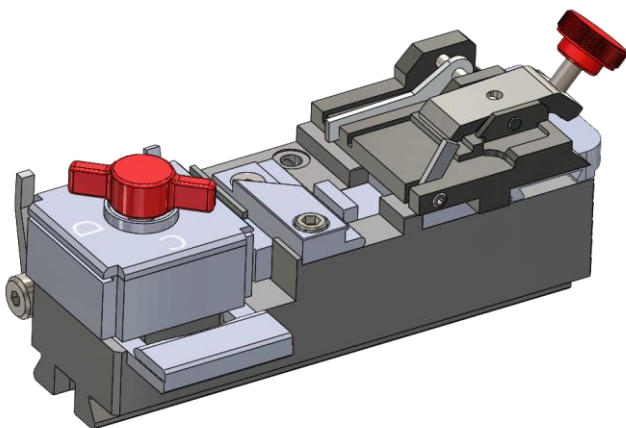
Look under the middle column for **Jaw 2** and find the **Tracer** section under the Cutter section.

File

Backup to PC      Read from PC      Master Update

Height and Jaw Calibration

Jaw 1			Jaw 2			Jaw 3		
<b>Cutter:</b>			<b>Cutter:</b>			<b>Cutter:</b>		
X-Start	Y-Start	Z-Start	X-Start	Y-Start	Z-Start	X-Start	Y-Start	Z-Start
1756	1790	762	479	2223	0	561	1778	883
Step 1(x)	Step 1(y)	Step 1(z)	Step 1(x)	Step 1(y)	Step 1(z)	Step 1(x)	Step 1(y)	Step 1(z)
-50	1400	125	300	-700	0	-300	900	200
Calibration X1	Calibration Y1	Calibration Z1	Calibration X1	Calibration Y1	Calibration Z1	Calibration X1	Calibration Y1	Calibration Z1
1950	1350	35	1800	2000	0	700	900	20
Calibration X2	Calibration Y2	Calibration Z2	Calibration X2	Calibration Y2	Calibration Z2	Calibration X2	Calibration Y2	Calibration Z2
1950	2100	40	1800	1960	0	400	2100	-100
X-Start Offset	Y-Start Offset		X-Start Offset	Y-Start Offset		X-Start Offset	Y-Start Offset	
0	0		0	0		0	0	
<b>Tracer:</b>			<b>Tracer:</b>			<b>Tracer:</b>		
X-Start	Start	Z-Start	X-Start	Y-Start	Z-Start	X-Start	Y-Start	Z-Start
1278	1825	582	1278	1825	582	85	1790	702
Step 1(x)	Step 1(y)	Step 1(z)	Step 1(x)	Step 1(y)	Step 1(z)	Step 1(x)	Step 1(y)	Step 1(z)
-50	1400	90	0	0	0	120	1400	100
Calibration X1	Calibration Y1	Calibration Z1	Calibration X1	Calibration Y1	Calibration Z1	Calibration X1	Calibration Y1	Calibration Z1
1450	1400	35	600	60	15	255	800	10
Calibration X2	Calibration Y2	Calibration Z2	Calibration X2	Calibration Y2	Calibration Z2	Calibration X2	Calibration Y2	Calibration Z2
1450	2100	20	-400	800	0	20	2100	-90
X-Start Offset	Y-Start Offset		X-Start Offset	Y-Start Offset		X-Start Offset	Y-Start Offset	
0	0		0	0		0	0	



Jaw 2 Tracer settings must match Jaw 1 Tracer settings for X, Y and Z Start. If not, then **copy the Jaw 1 Tracer settings to the Jaw 2 Tracer settings for X, Y and Z Start.**

Check that your settings for **Jaw 2 Tracer** match those in the above image for:  
Calibration X1 (600), Calibration Y1 (60)  
Calibration X2 (-400), Calibration Y2 (800)  
Calibration Z1 (15)

Make any necessary changes and click the **“Master Update”** button at the top right.

Click File > Exit to exit when finished.

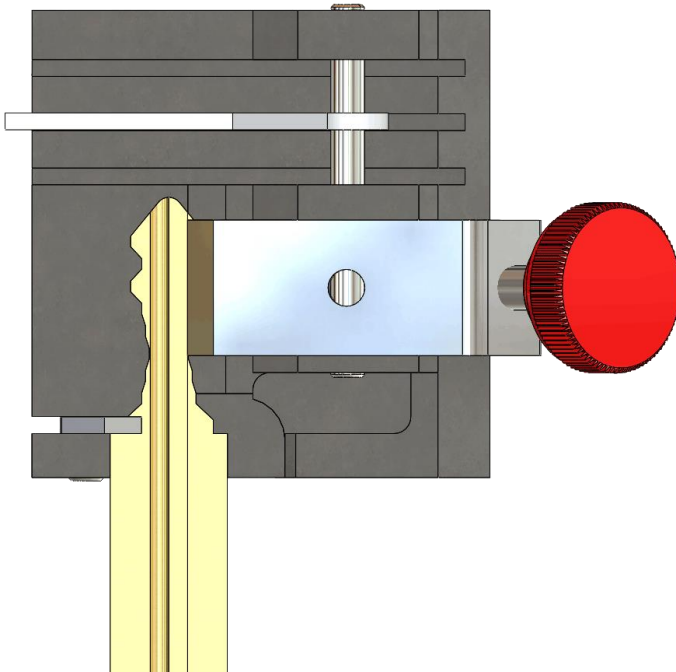
## Using the Standard Tracing Adapter

Slide the lip on the bottom of the Standard Tracing Adapter up to the front of the Jaw 1 and clamp the adapter in Jaw 1.



When clamping Standard Security keys in the Standard Security Adapter it doesn't matter if you clamp on the milling or on the top of the key. The machine detects how the key is clamped and traces accordingly.

## Clamping Shoulder Stop Keys



Press down on the red knob to open the key clamp.

This is an example of how to clamp a double sided shoulder stop key.

The clamp is spring loaded and can be tightened with the knob. Since this adapter is only used for tracing it is not necessary to clamp key very tight.

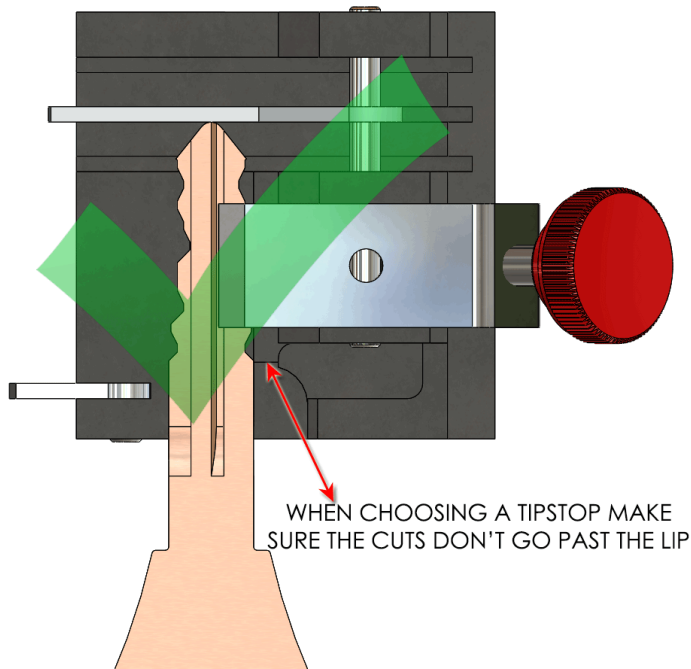
When clamping a double sided shoulder stop key such as a TR46, the **software will ask you to insert a key blank first**, trace the blank, and then trace the cut key that you want to duplicate.

Be sure to clamp the cut key the same way that you clamped the key blank.

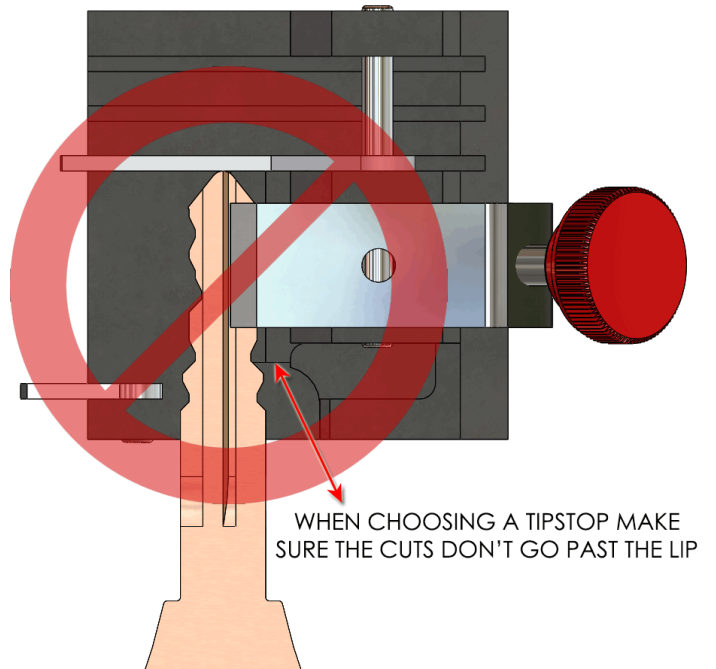
## Clamping Tip Stop Keys

Clamp tip stop keys so that they don't go past the lip that the keys clamp on. Clamp on milling when possible. Leave tipstop down when tracing tipstop keys.

### Correct Clamping:



### Incorrect Clamping:



## Initiating a trace from the software

After the key is clamped, select the key to be duplicated in the 3D Pro software and **click Single Trace for single sided keys and Double Trace for double sided keys.**

Single trace will work for double sided keys most of the time but Trace Double can be more accurate by getting parameters from a blank.

