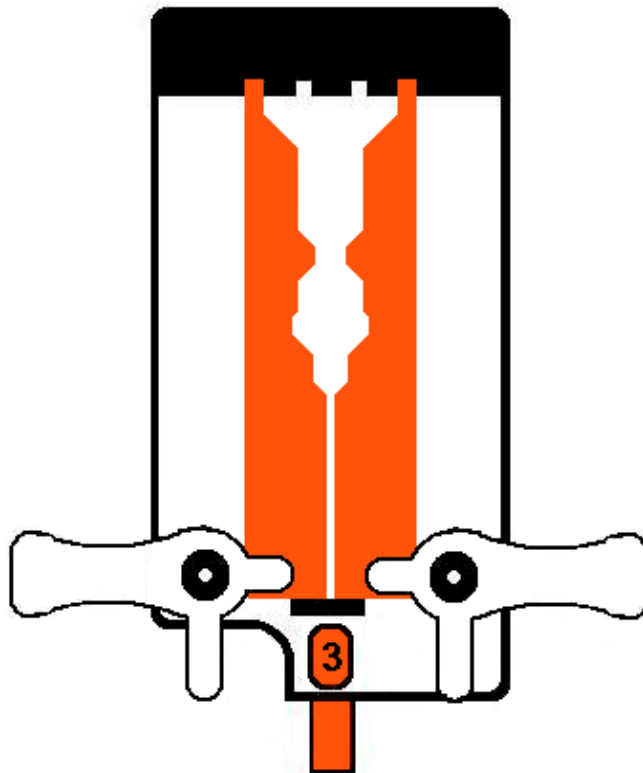


# CODE JAW



**Laser Security Products**

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## Introduction

Thank you for choosing the Laser Security Products “**Code Jaw**” for your high security automotive code cutting needs.

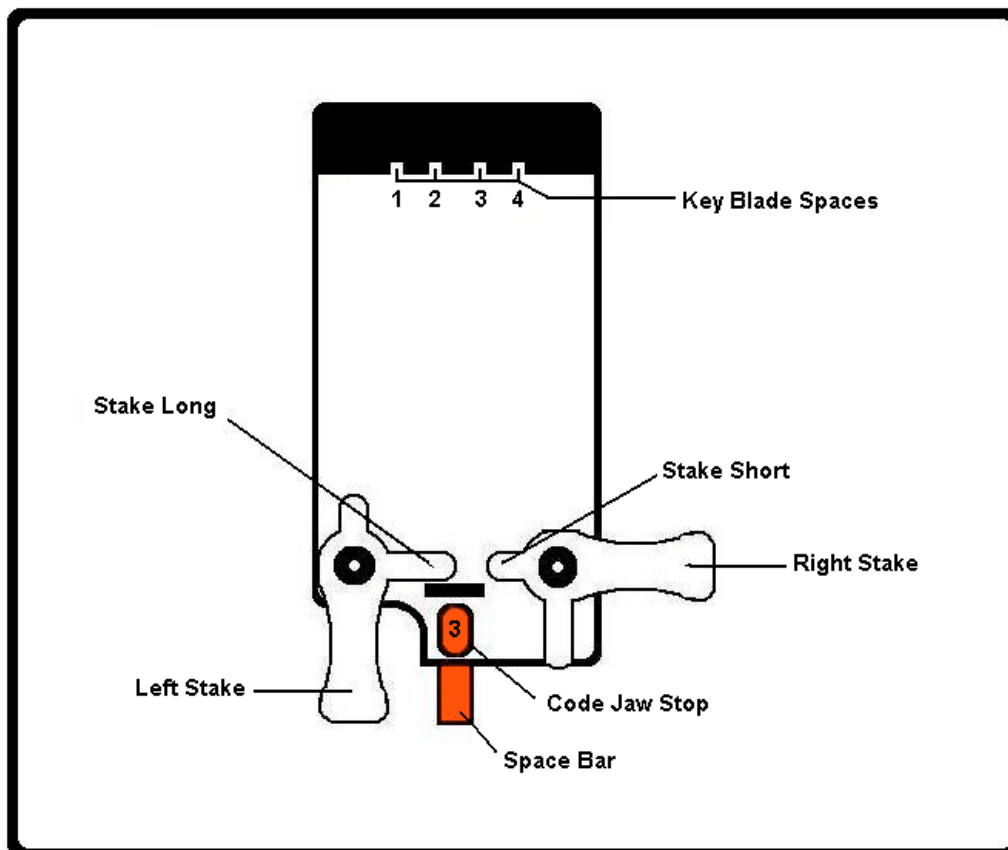
Say goodbye to those bulky space and depth keys that are not only time consuming, but also produce a key that is unattractive and unprofessional in appearance.

The Laser Security Products “**Code Jaw**” will enable you to quickly and accurately code cut high security automotive keys, producing an attractive contour/laser cut key that looks factory, while using your existing code machine and a high security duplicator.

Read the instructions carefully, make sure you fully understand the procedure and in no time you will be zipping out a code cut key in minutes.

## CODE JAW DESCRIPTION

### Parts List



### Key Blades

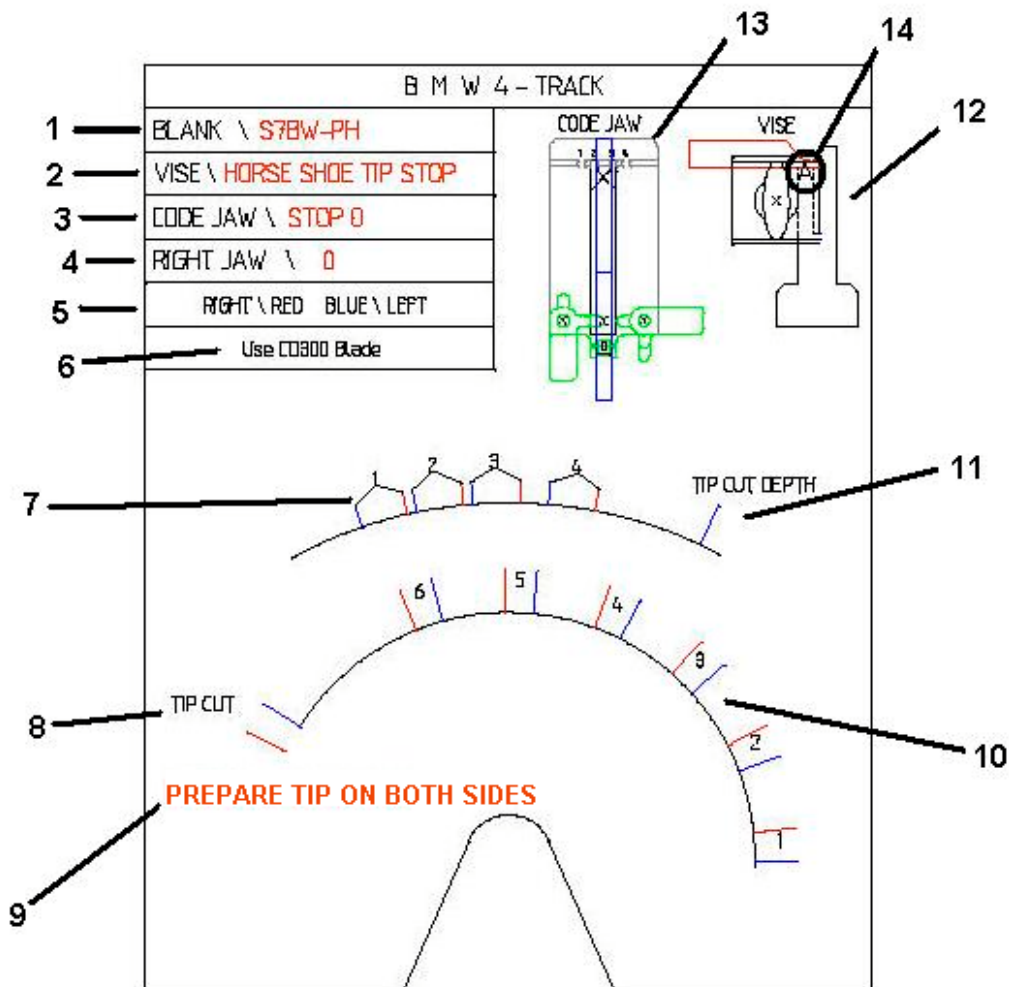
CD300

CD350

The key blades are designed to fit into the jaw and be used as a pattern. They are **not** reusable, so keep enough in stock for future code keys.

The CD300 key blade will be used more often than the CD350. The code card will indicate what blade to use in each application.

## CODE CARD DESCRIPTION



At first appearance the card may look intimidating, but if you study the illustration and it's descriptions, you should have no problem understanding.

1. Proper key blank number
2. This designates how to properly gauge the key blade in the 1200 code machine.
3. Indicates the Space Bar position on the Code Jaw. (There are 5 positions)
4. Indicates the correct position to stop the key blank in the duplicator.
5. Most cards will have red and blue depth/space marks. When cutting the right track, use the red marks and when cutting the left track, use the blue marks.
6. Indicates the proper key blade(s).
7. These are the depth marks.

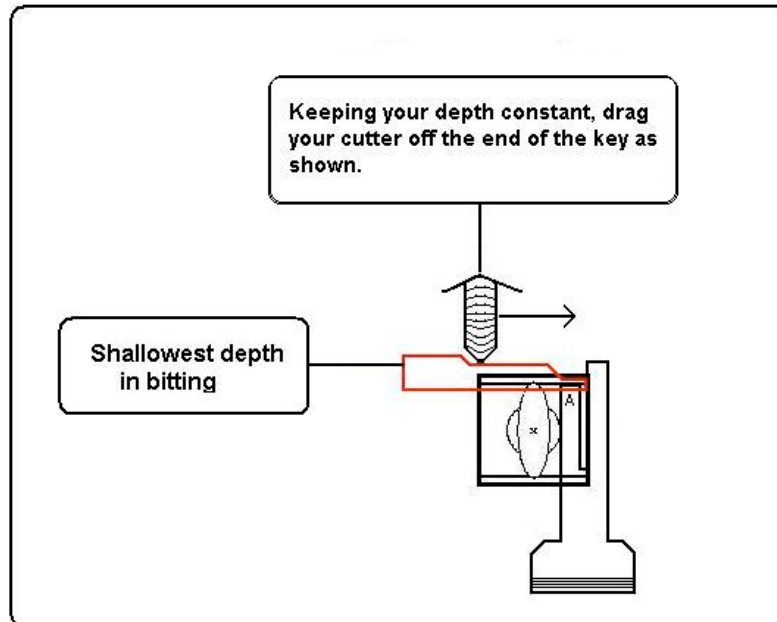
*Remember:* **Red** is for the right track – **Blue** is for the left track.

## CODE CARD DESCRIPTION (continued)

8. Tip cut space indicator: It will be necessary on some keys to prepare the tip slope onto the key blade, the card will indicate as shown when to do so. Pay attention to the notes, some keys require you to tip slope only the left track and not the right, etc.
9. Special notes you must pay attention to.
10. These are the space marks.  
  
*Again remember, **Red** is for the right track – **Blue** is for the left track.*
11. Tip cut depth indicator: When required to prepare the tip slope, this is the depth at which you will make the cut.
12. 1200 Vise illustration. We have included an illustration of the proper way to hold the blades in the 1200 machine. To ensure your understanding, we have included a detailed description later in the instructions.
13. Code Jaw illustration: This illustration will give you the proper space(s) to insert the cut key blade as well as the proper spacebar position.
14. Most keys will require the use of Vise Jaw A, but always check to make sure.

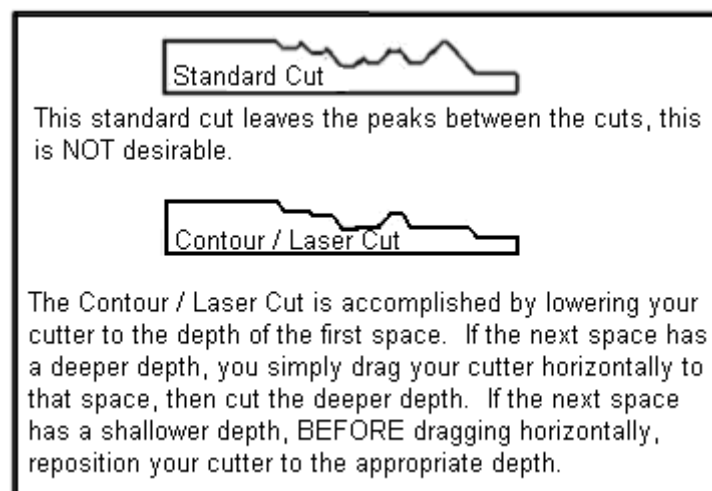
## CUTTING THE KEY BLADE

Once you have obtained the proper bitting for the key, it's time to cut the key blade. Install the proper key blade in the code machine (CD 300 or CD350, check the card) and ensure you are gauging it properly. Determine the shallowest depth in the key, (example: for a bitting that is 235424, the shallowest depth is a #2). Starting at the #1 space cut down to a #2 depth and drag the cutter all the way off the tip of the key. This will prepare all spaces to the shallowest depth of the key you are cutting. See illustration below.



## Contour / Laser Cut Explained

Once you have prepared the key as shown, go back to the #1 space and “contour / laser” cut the bittings. A “contour / laser” cut will enable the finished key to work smoother and look better. If you are not familiar with this technique, see the illustration below for an example.

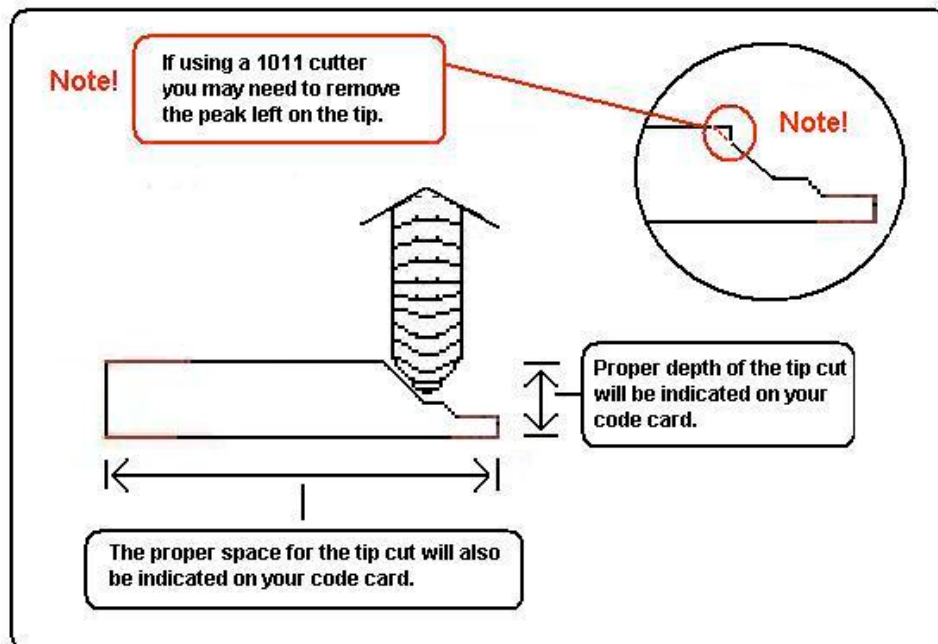


## Tip Slope Cuts

Because some high security keys are wider than others, the tip slope will not line up in the correct position for some keys. When this happens, you will be required to pre-cut a tip slope on the CD300 or CD350 key blade. The code card will indicate when and where to cut this slope.

NOTE: Some keys require the tip slope cut on one side, while others may require the tip slope cut on both sides.

Here is an illustration of how to cut the tip and what it will look like.

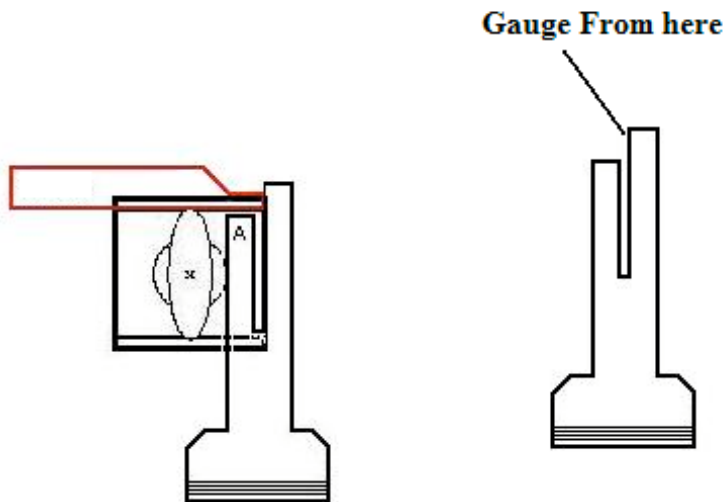




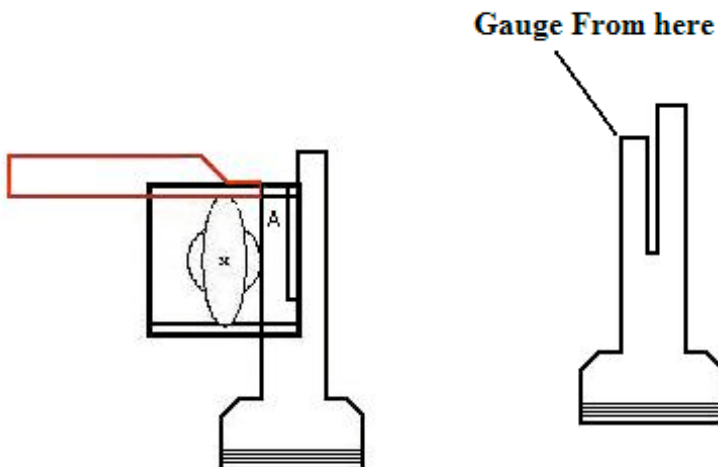
## GAUGING KEY IN THE 1200 CODE MACHINE

Some high security keys have quite a few bittings on them, so in order to reach the first space; we had to come up with 2 custom gauging points. The following illustrations will explain the procedure. The code card will indicate which gauge / stop to use.

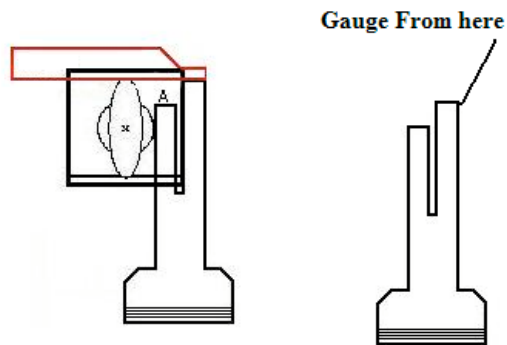
### Horseshoe Tip stop



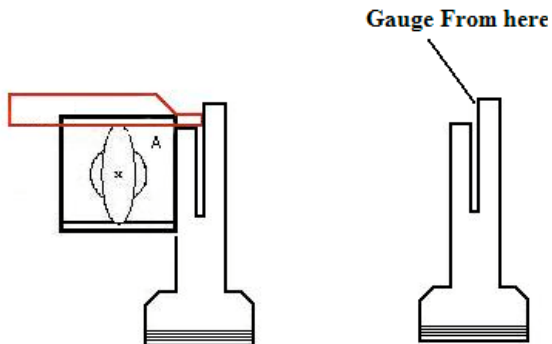
### Red Horseshoe tip stop



### Stop 3

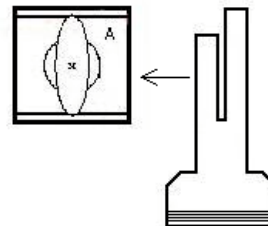


### Stop 4



#### **\*Note\***

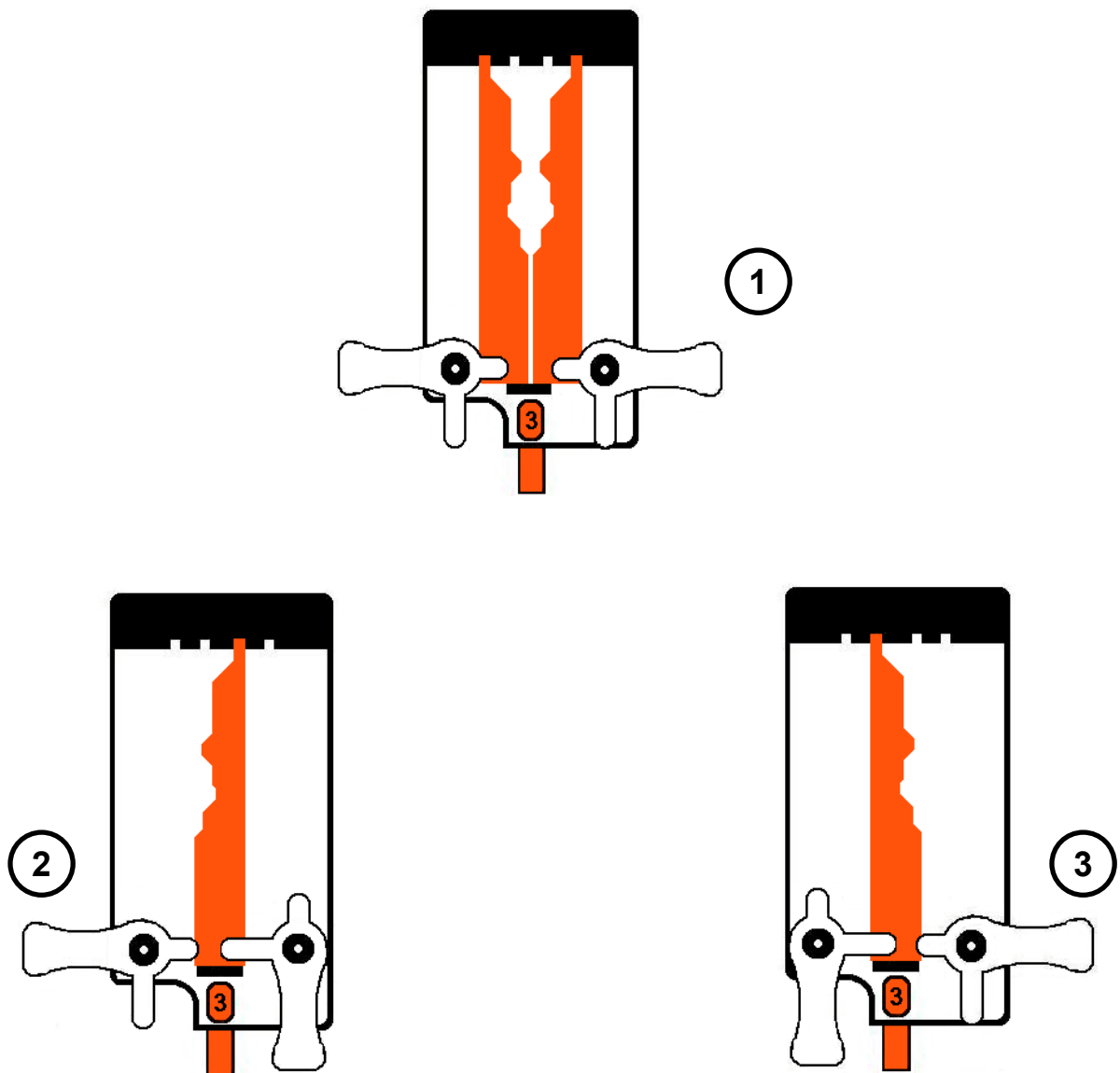
The horseshoe stop just sits on the side of the jaw



## SECURING KEY BLADE IN CODE JAW

Place tip of key blade into the appropriate Key Blade Space (1,2,3, or 4). To ensure proper alignment, the un-cut side of the key blade must be firmly against the stake while tightening with the enclosed Allen Wrench.

NOTES: The Code Jaw is designed with four Key Blade Spaces for key placement. The stakes located on the lower right and left side of the Code Jaw are designed to hold the key blade securely and accurately. The Short Stake is used with Spaces 1 & 4 (illustration #1). The Long Stake is used with Spaces 2 & 3 (illustrations #2 & #3).



## SPACE BAR POSITIONING – CODE JAW STOP

Refer to the code card, which corresponds to the particular key you are cutting to find the appropriate Code Jaw Stop position. The selected position will be displayed in the Code Jaw Stop window. (possible settings are 0 through 4).

## ADJUSTING DUPLICATOR GUIDE AND CUTTER ALIGNMENT

Clamp the Code Jaw in the duplicator (the Space Bar Stop should rest lightly against the jaw of the duplicator) then, lower the guide until it touches the surface of the Code Jaw. Place a shim on the cutter jaw (a sheet of typing paper is perfect) and lower the cutter to the shim (surface of the paper).

Note: The purpose of the paper shim is to allow just enough clearance to avoid cutting into the cutter jaw.

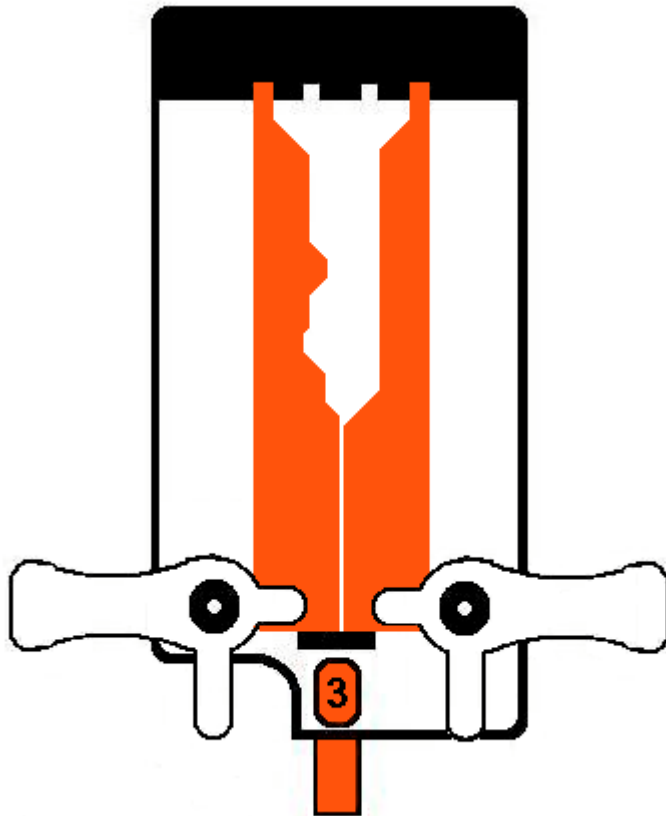


## CUTTING (TRACING) THE KEY

The cutter rotation only allows you to cut smoothly in one direction. If you are cutting internal cuts, always start on the right side and then end on the left side of the cut. This will cut a smooth key. On external cuts, also start on the right side.

## HELPFUL HINTS – TIPS

1. When cutting a Lexus short key, widen your #3 depths slightly.
2. When cutting VW keys, we suggest a key blade be prepared to all #3 depths (to act as a guide). This key blade tip should be placed in the #4 position. (see illustration below).



**PRODUCT REGISTRATION  
CODE JAW**

Name: \_\_\_\_\_

Company Name: \_\_\_\_\_

Address: \_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

Phone #: \_\_\_\_\_

Fax #: \_\_\_\_\_

Email Address: \_\_\_\_\_

**Return this form by fax or mail:**

Laser Security Products

Fax#: \_\_\_\_\_

*Address*

*City, State Zip*

**in order to receive updated product information, access to upcoming web site,  
and product support.**

## ITL – Code Jaw

### Space & Depth Information

Lexus 4-Track										
40,000-50,000										
LEFT					RIGHT					
DSD	Space		Depth			DSD	Space		Depth	
801	1	.801	0	200		801	1	.801	0	200
	2	.707	1	201			2	.707	1	201
	3	.613	2	200			3	.613	2	200
	4	.519	3	232			4	.519	3	232
	5	.425	4	200			5	.425	4	200
			5	263					5	263
CODE JAW		MATRIX RIGHT JAW			BLADE SPACES			INSERT		
STOP 2		STOP 2			1 & 4			2		

Lexus 4-Track										
1-5000										
LEFT					RIGHT					
DSD	Space		Depth			DSD	Space		Depth	
803	1	1083	0	300		803	1	1083	0	300
	2	984	1	180			2	984	1	180
	3	985	2	200			3	985	2	200
	4	801	3	223			4	801	3	223
	5	707	4	247			5	707	4	247
	6	613	5	270			6	613	5	270
	7	519					7	519		
	8	425					8	425		
CODE JAW		MATRIX RIGHT JAW			BLADE SPACES			INSERT		
STOP 3		STOP 3			1 & 4			2		

## ITL – Code Jaw

### Space & Depth Information

Honda 4-Track										
LEFT					RIGHT					
DSD	Space		Depth			DSD	Space		Depth	
807	1	1065	0	363		806	1	1065	0	305
	2	940	1	278			2	940	1	305
	3	825	2	260			3	825	2	289
	4	705	3	246			4	705	3	275
	5	585	4	232			5	585	4	262
	6	290 *	5	217			6	290 *	5	245
			6	203					6	232
			7	150 *						
CODE JAW		MATRIX RIGHT JAW			BLADE SPACES			INSERT		
STOP 4		STOP 3			2 & 3			2		

**\* SEE NOTE ON PAGE 5**

Volvo 4-Track 1V-5V										
LEFT					RIGHT					
DSD	Space		Depth			DSD	Space		Depth	
808	1	1040	0	295		809	1	955	1	285
	2	865	1	295			2	790	2	256
	3	705	2	270			3	620	3	232
	4	525	3	245			4	455	4	210
			4	220						
CODE JAW			MATRIX RIGHT JAW			BLADE SPACES			INSERT	
STOP 2			STOP 2			2 & 3			2	



# ITL – Code Jaw Space & Depth Information

BMW 4-Track 1V-5V									
<i>LEFT</i>					<i>RIGHT</i>				
DSD	Space		Depth		DSD	Space		Depth	
812	1	1180	0	302	813	1	1118	0	302
	2	1050	1	302		2	1000	1	284
	3	920	2	275		3	878	2	257
	4	802	3	254		4	753	3	233
	5	675	4	221		5	623	4	202
	6	545	5	150 *		6	503	5	106 *
	7	275 *				7	260 *		
CODE JAW				MATRIX RIGHT JAW			BLADE SPACES		INSERT
STOP 0				STOP 0			2 & 3		2

\* SEE NOTE ON PAGE 5

Mercedes 2-Track (10 & 93 Plus)									
<i>LEFT</i>					<i>RIGHT</i>				
DSD	Space		Depth		DSD	Space		Depth	
814	1	1204	0	248	814	1	1225	1	248
	2	1113	1	248	Bow Cut	2		2	
	3	1022	2	224	&	3		3	
	4	931	3	200	Tip Cut	4		4	
	5	840	4	176		5		5	
	6	749	5	152		6		6	
	7	650				7		7	
	8	567				8		8	
	9	476				9		9	
	10	305				10		10	
CODE JAW				MATRIX RIGHT JAW			BLADE SPACES		INSERT
Up to 92 STOP 1				STOP 2			3		2
93 plus Stop 2									

## ITL – Code Jaw

### Space & Depth Information

Volks 4-Track									
LEFT					RIGHT				
DSD	Space		Depth			DSD	Space		Depth
817	1	1281	0						
	2	1163	1	258					
	3	1045	2	234					
	4	927	3	210					
	5	809	4	186					
	6	691							
	7	573							
	8	455							
CODE JAW		MATRIX RIGHT JAW			BLADE SPACES			INSERT	
STOP 0		STOP 0			1			2	

Mercedes 4-Track									
LEFT					RIGHT				
DSD	Space		Depth			DSD	Space		Depth
802	1	1180	0	300					
	2	1078	1	300					
	3	960	2	279					
	4	858	3	256					
	5	748	4	233					
	6	657	5	210					
	7	566	6	200					
	8	475							
CODE JAW		MATRIX RIGHT JAW			BLADE SPACES			INSERT	
STOP 0		STOP 0			2 & 3			2	

## ITL – Code Jaw

### Space & Depth Information

Infiniti										
LEFT					RIGHT					
DSD	Space		Depth			DSD	Space		Depth	
804	1	1035	0	300		805	1	1035	0	300
	2	910	1	310			2	910	1	288
	3	790	2	285			3	790	2	262
	4	670	3	260			4	670	3	243
	5	550	4	240			5	550	4	215
CODE JAW		MATRIX RIGHT JAW			BLADE SPACES			INSERT		
STOP 1		STOP 1			2 & 3			3		

\* Represents the ramp cut at the end of the key. If it has a ramp cut the last cut of the code should be the last cut and the deepest. Example: Honda 21334-7 (seven) is the tip cut and the sixth space, for example: the new code would be 213347.