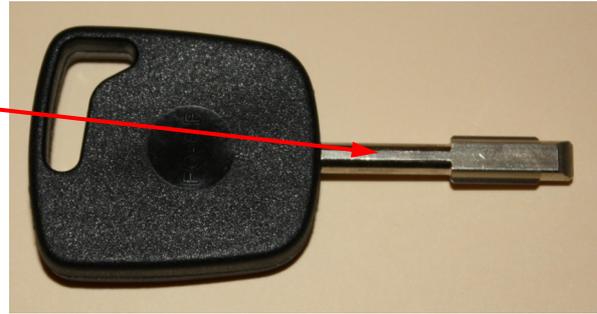
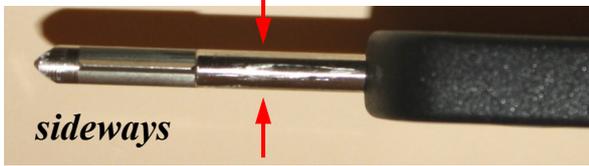


## Tibbe Key and Tibbe Adaptor

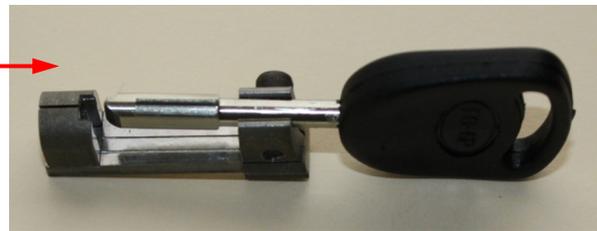
You will notice that the Tibbe Key has a flat section on the side



This enables us to insert the key blank into the adaptor “*sideways*” and rotate 90° into place.

## Cutting a FORD “Tibbe” Key ..... Silca FO21 (DSD 358)

Insert the Key Blank “*sideways*” into the Tibbe Adaptor

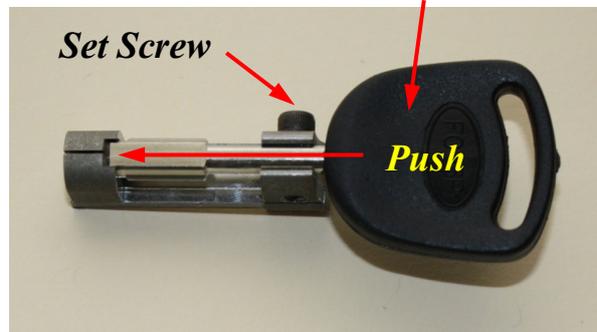


Then rotate the key 90°, and push home into the tip of the adaptor

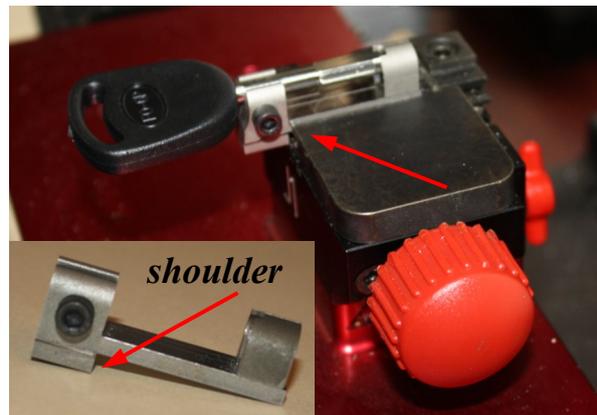
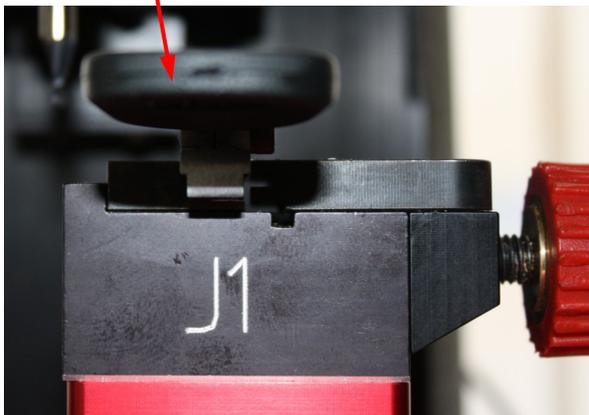
Make sure that the key is sitting square in the adaptor.



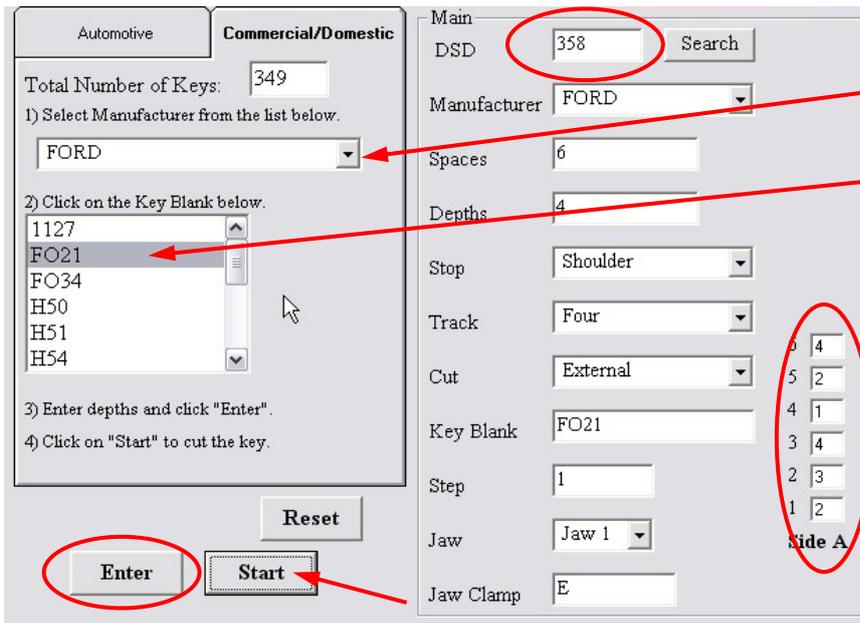
Then lock the key in place by tightening the “*Set Screw*” (do not over tighten)



The Adaptor is then clamped into “*Jaw 1*” making sure the “*shoulder*” is sitting against the jaw.



On the main screen you will see two tabs **“Commercial/Domestic”** and **“Automotive”**



Click on **“Commercial/Domestic”** and choose **“Ford”** from the drop down menu.

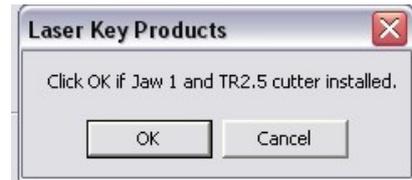
Now click on **“FO21” (DSD 358)** to open up the **“Main cutting screen”**

Enter the depth of your cuts starting with “1” as the cut nearest the shoulder of the key.

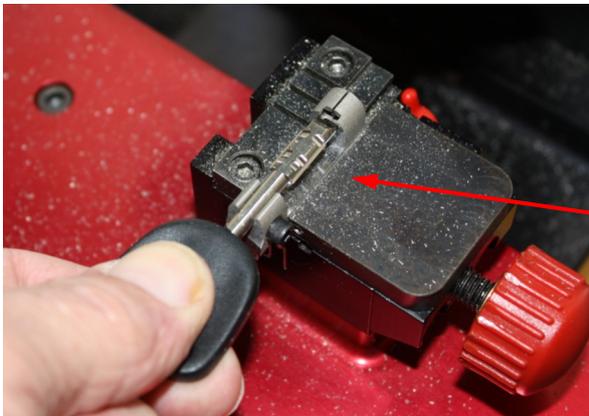
Once you have entered the cuts, click **“Enter”** and the **“Start”** button will appear.

Click on the start button and you will get a check box **“Click OK if Jaw 1 and TR2.5 cutter installed”**

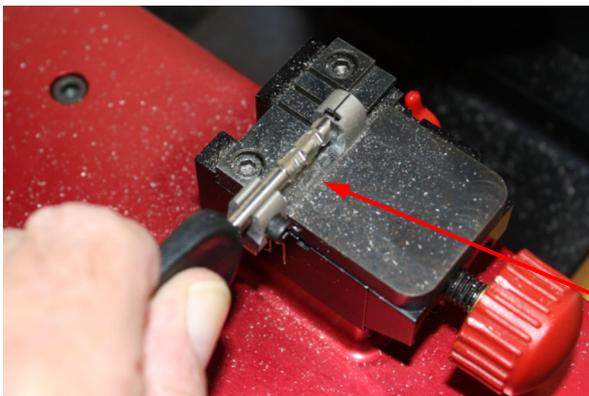
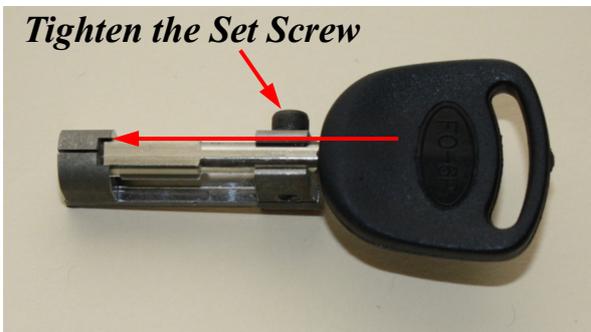
If you have the correct jaw and cutter installed, click **“OK”** to cut the key.



The **“first side”** of the key will now be cut automatically.



When the first side of the key has been cut, loosen the **“Set Screw”** and slide the key back out of the tip of the adaptor just far enough to rotate it a full 180°. Push the key back into the adaptor tip and lock the key in place by tightening the **“Set Screw”** (do not over tighten)



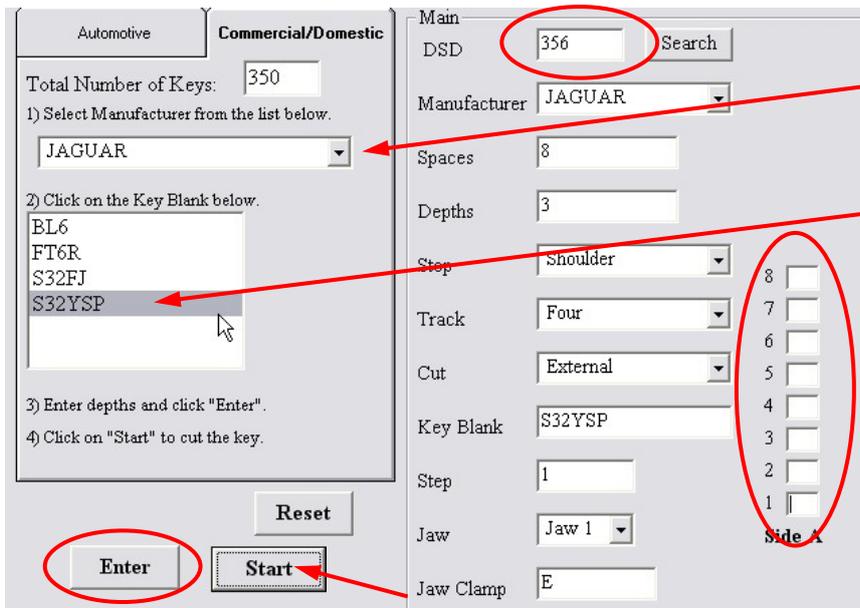
When the key has been cut, loosen the **“Set Screw”** and slide the key back out of the tip of the adaptor, rotate 90° and remove the finished key.

## Cutting a JAGUAR “Tibbe” Key ..... Silca TBE1 (DSD 356)

Inserting the Jaguar Tibbe Key into the “*Tibbe Adaptor*” is exactly the same as inserting the Ford Tibbe Key. (see page 1)

You would then choose the Jaguar from the main menu

On the main screen you will see two tabs “*Commercial/Domestic*” and “*Automotive*”



Click on “*Commercial/Domestic*” and choose “*Jaguar*” from the drop down menu.

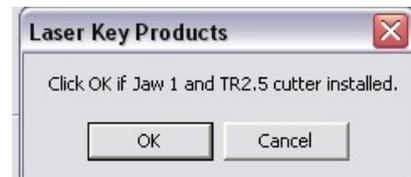
Now click on “*S32YSP*” (*DSD 356*) to open up the “*Main cutting screen*”

Enter the depth of your cuts starting with “1” as the cut nearest the shoulder of the key.

Once you have entered the cuts, click “*Enter*” and the “*Start*” button will appear.

Click on the start button and you will get a check box “*Click OK if Jaw 1 and TR2.5 cutter installed*”

If you have the correct jaw and cutter installed, click “*OK*” to cut the key.



The “*first side*” of the key will now be cut automatically.

When the first side of the key has been cut, loosen the “*Set Screw*” and slide the key back out of the tip of the adaptor just far enough to rotate it a full 180°.

Push the key back into the adaptor tip and lock the key in place by tightening the “*Set Screw*” (*do not over tighten*)

When the key has been cut, loosen the “*Set Screw*” and slide the key back out of the tip of the adaptor, rotate 90° and remove the finished key.