



## PAK-A-PUNCH™

#PAK-3T/ #PAK-1C/ #PAK-3S/ #PAK-3K

HAVE YOU COMPLETED YOUR REGISTRATION CARD?

Please help us to meet your ongoing needs. Complete and return the enclosed card Today and A-1 will inform you of NEW Kits and Accessories as they are developed. You will be notified of new applications for your equipment.

### INSTRUCTIONS

Thank you for purchasing A1's PAK-A-PUNCH We hope that you will take as much pride in using this American made product as we have in designing and manufacturing it. With proper care and use, you are assured of trouble-free, accurate, and economical operation.

**REGISTRATION:** Please complete and return the enclosed REGISTRATION CARD. A-1 will be developing new QUICKCHANGE KITS to accommodate additional automotive and commercial keys. On occasion, we provide SPECIAL SAVINGS OFFERS as well as updated AUTOMOTIVE APPLICATION information. This information can only be provided if you HAVE REGISTERED.

**WARNING:** The PAK-A-PUNCH produces flying chips when cutting keys. ALWAYS point the unit downward when in use. NEVER aim the punch at another person or toward yourself. A chip guard is installed on the machine and should not be removed for any reason.

**QUICKCHANGE KITS:** Your PAK-A-PUNCH is designed to cut various styles of key blanks. Please order the appropriate "QUICKCHANGE" Kits from your Distributor. Kits include the Vise Assembly and the Depth Knob. Please note that while Model 3T is primarily designed for Automotive Key blanks, it may also be equipped for Schlage (order #PK3-CV1), Kwikset (order #PK3-CV2) and I.C.Core (order #PK3-CV3). Use your PAK-A-PUNCH "AUTOMOTIVE APPLICATIONS" brochure or the new QUICK REFERENCE GUIDE to determine which QUICKCHANGE KIT you need.

#### AVAILABLE COMMERCIAL KEY MODELS

**PAK-3S:** Model 3S is fully equipped to Punch Schlage. No other QUICKCHANGE Kits are required for Model 3S. Owners of Model 3S can punch all 90° Automotive Applications by just ordering the appropriate QUICKCHANGE Kit. When the Automotive Application specifies a 90T, 88T or 90V Punch & Die, the Schlage 90° punch & die must be replaced with the correct Punch/Die combination.

**PAK-3K:** Model 3K is fully equipped to Punch Kwikset. No other QUICKCHANGE Kits are required for Model 3K. Owners of Model 3K must order the appropriate Punch/Die set and QUICKCHANGE Kit to punch Automotive Keys.

**PAK-1C:** Model 1C is fully equipped to Punch I/C Core. No other QUICKCHANGE Kits are required for Model 1C. Owners of Model 1C can punch all 90° Automotive Applications by just ordering the appropriate QUICKCHANGE Kit. When the Automotive Application specifies a 90T or 90V Punch & Die, the I/C Core 90° punch must be replaced with the required Punch. If the Application specifies an 88T Punch & Die, than the I/C Core 90° punch & die must be replaced with the correct Punch/Die combination.

## **PUNCH AND DIE COLOR CODE IDENTIFICATION**

The final column identifies the correct punch/die for the application being punched. When ordering Quickchange Kits, make certain you have the correct punch/die or order them with your Quickchange Kit.

Color	Punch	No. of Dots	Die	No. of Dots
Black	PAK-90T (STD.)	2 on rear of punch	PK2-007 (STD.)	1 on left side
	PAK-90 (ACCES.)	1 on rear of punch		
	PAK-90V (ACCES.)	3 on rear of punch		
White	PKS-88T (SET)	1 on rear of punch	(Incl. in PKS-88)	1 on left side
Orange	Incl. in PK3-CV1	1 on rear of punch	(Incl. in PK3-CV1)	1 on left side
Red	Incl. in PK3-CV2	1 on rear of punch	(Incl. in PK3-CV2)	1 on left side

Punches and Dies will work ONLY within their own color group

## **INITIAL MACHINE SET-UP                      SEE ILLUSTRATIONS**

**INSTALLING DEPTH KNOB:** Verify that the 3-digit I.D. # stamped on the face of the Depth Knob agrees with the stamped number on the back right-hand side of the Lower Vise being used. With thumb pressure, move the entire Tower Assembly to its upper limit. Point the machine toward the floor and keeping the Tower Assembly at its upper limit, place the 1/4" Depth Ball into the upper hole of the bored seat in the Tower. With the Tower Assembly still up, insert the appropriate Depth Knob. Install System Change Screw and firmly hand tighten.

## **CHANGING DEPTH KNOB**

Remove the System Change Screw. Elevate the Tower Assembly while pointing the machine toward the floor as above, and gradually remove the existing Depth knob being careful not to lose the 1/4" Precision Depth Ball located in the recess. Install a new Depth Knob by following the directions above.

## **INSERTING KEY BLANK**

It is extremely important that the key is properly seated in the appropriate Vise Assembly. While keys can be loaded with the Vise Assembly in the machine, superior results will be achieved by loading keys with the Vise out of the machine.

Keys load from the left or right, depending on the particular blank. Keys cannot be loaded incorrectly.

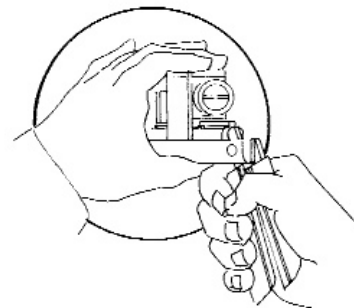
Tighten the Clamp Screw and insert the Vise Assembly into the machine. (Vise Assemblies load from the same direction as the Key blank and cannot be loaded incorrectly).

## **READY TO PUNCH**

Punch keys from Bow to Tip (l/core - Tip to Bow). Holding machine in your best hand, turn Spacing Knob until the No.1 position mark on the back of the Vise is aligned with the edge of the Tower Assembly. Next, turn Depth Knob so that the desired cut depth number is at the 12 o'clock position and aligned with the depth mark. Squeeze handle with a quick punching action. Advance the spacing and repeat for remaining cuts.

**Double Sided Keys:** After Punching the first side, remove the key, turn it, and reinsert to finish the 2nd. side.

**IMPORTANT:** When Punching, apply moderate squeeze pressure to the Tower Assembly as shown in the insert. If necessary, deburr with a wire brush or flat file.



**ADJUSTMENTS :** Only depth of cut is adjustable and it is FACTORY PRE-SET. However, if you must adjust



## **WARRANTY**

A-1 Security Manufacturing Corp. (herein "A-1") warrants that the PAK-A-PUNCH Model 3T manufactured by A-1 and sold to Buyer will be free from defects in material and workmanship for a period of one year from the date of purchase. Unless otherwise agreed, notice of a warranty claim shall be in writing delivered to A-1 and identifying the defective item and such other information as A-1 may reasonably request. Notice may also be given by telephone and promptly by letter.

A-1's obligation under this warranty shall be limited to the repair or, at A-1's option, the replacement of any component or assembly which proves upon examination by an employee, agent or representative of A-1 to have been defective at the time of delivery to Buyer. Any defective parts or components shall be returned by Buyer or the owner to A-1 as a condition to their repair or replacement and any replaced parts or components shall become the property of A-1.

This Warranty Shall Not Apply To The Following:

1. Items that have been repaired or altered outside A-1's factory without written notice to, or authorization by A-1.
2. Items that have been mis-used, neglected or improperly maintained.
3. Items which have not been properly stored or installed, or which have not been operated under normal conditions as may be customary for such equipment.
4. Normal wear.

THIS WARRANTY IS IN LIEU OF ANY AND ALL OTHER WARRANTIES EXPRESSED OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANT ABILITY AND FITNESS FOR A PARTICULAR PURPOSE. A-1 SHALL NOT BE LIABLE FOR ANY INCIDENTAL OR CONSEQUENTIAL DAMAGES WHICH MAY ARISE IN CONNECTION WITH THE ITEMS SUBJECT TO THIS WARRANTY.

### **ADDITIONAL WARRANTY**

QUICKCHANGE KITS (VISES & DEPTH KNOBS) ARE UNCONDITIONALLY WARRANTED FOR 10 YEARS FROM THE DATE OF PURCHASE.

**A-1 Security Manufacturing Corp.  
3001 West Moore Street  
Richmond, Virginia  
(804) 359-9003  
WWW.DEMANDA1.COM**