

# GYMKANA 994

## QUICK-START GUIDE



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**Watch the Gymkana  
Training Course for Free!**

[www.keylineacademy.com](http://www.keylineacademy.com)



*Where Customers Become Experts*

**\* IMPORTANT \***

# REGISTERING YOUR MACHINE

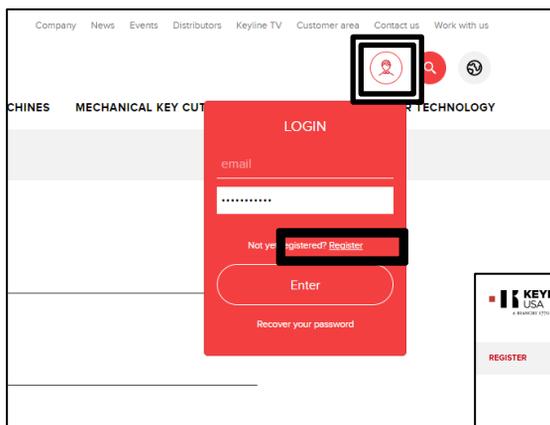
Thank you for your purchase of the Keyline Gymkana 994.

Before continuing with machine setup and use, please complete the following;

## REGISTER YOUR MACHINE ON THE WEB

Select the LOGIN icon on [www.keyline-usa.com](http://www.keyline-usa.com) (see person icon at the top right of the web page) then select the **Register**. Complete the online form as shown below. Once complete your profile will be set up. You will also use these login credentials to register on your actual machine during initial setup.

**PLEASE NOTE:** YOU MUST REGISTER YOUR MACHINE ONLINE TO HAVE ACCESS TO SOFTWARE UPDATES, MANUALS & QUICK START GUIDES.



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CHINES MECHANICAL KEY CUTTING MACHINES TRANSPONDER TECHNOLOGY

LOGIN

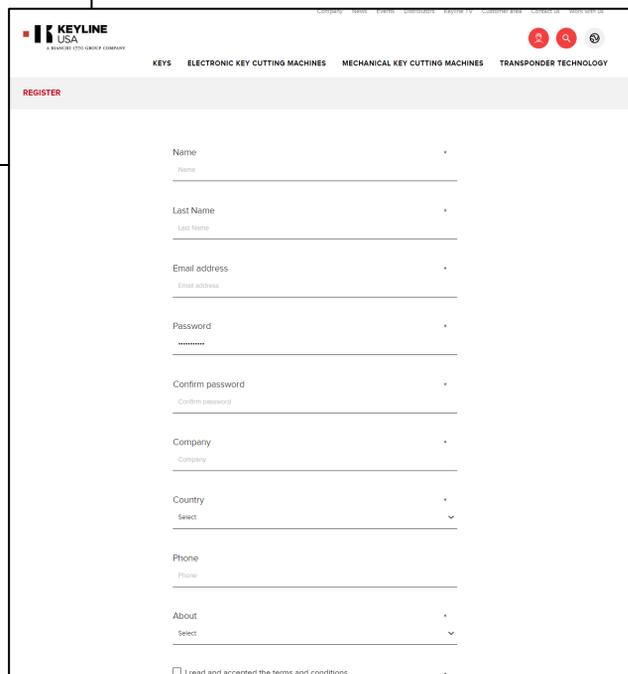
email

\*\*\*\*\*

Not yet registered? **Register**

Enter

Recover your password



KEYLINE USA  
A KEYLINE LTD GROUP COMPANY

KEYS ELECTRONIC KEY CUTTING MACHINES MECHANICAL KEY CUTTING MACHINES TRANSPONDER TECHNOLOGY

REGISTER

Name

Last Name

Email address

Password

Confirm password

Company

Country

Phone

About

I read and accepted the [terms and conditions](#)

# POWERING MACHINE ON/OFF

## Cable Connection & Powering Machine ON

**\*MOBILE USERS: YOU MUST USE A PURE SINE WAVE INVERTER WITH 1100 WATTS (or greater) TO POWER THE MACHINE OR MACHINE MOTOR WILL NOT WORK PROPERLY**

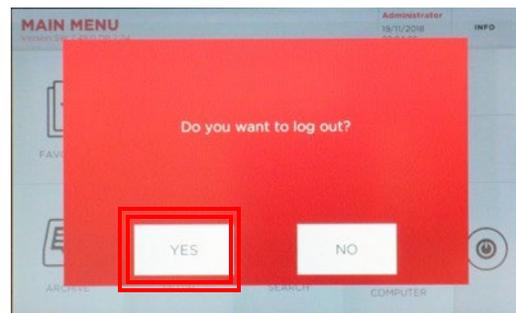
1. Attach power cord to back of machine and plug into a properly grounded outlet.
2. Attached phone jack cables to console and to back of machine.
3. Rotate the red Emergency Stop/Power button towards the back right of the machine until it releases outward. The machine will now begin to start-up.



## Powering Machine OFF



At **MAIN MENU**, select **Power** button



Select **YES** to log out, then select Power button again at Login screen

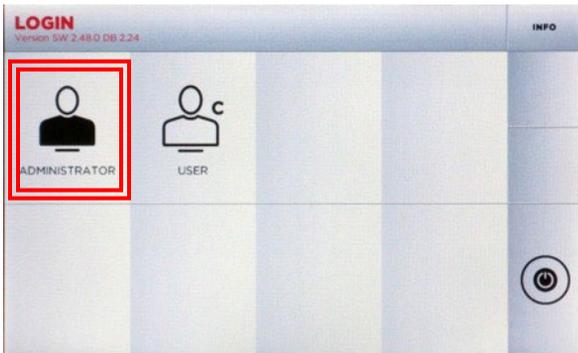


Select **YES** to exit



# LOGIN / PASSWORD ENTRY

**TIP:** Use included stylus with touch screen to ensure accurate selections

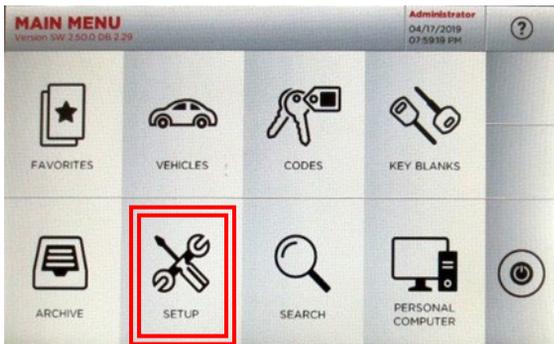


Select **ADMINISTRATOR**



Leave password screen blank, no default password is set, Select **NEXT**.  
To create password, see below.

## PASSWORD CREATION (OPTIONAL) -Skip this section if you do not want a password-

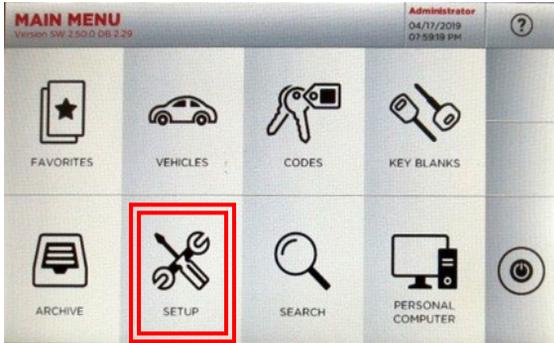


From Main Menu, Select **SETUP**, **USERS** and then **CHANGE PASSWORD**. At the Change Password screen **enter in your new password and confirm** (leave Old Password line blank) then select **NEXT**. Administrator password is now set.

# CALIBRATION

**TIP:** Use included stylus with touch screen to ensure accurate selections

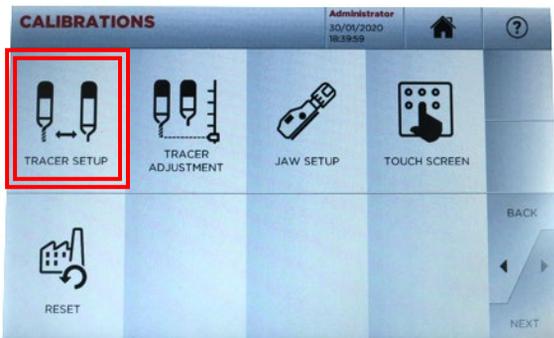
Follow the steps below



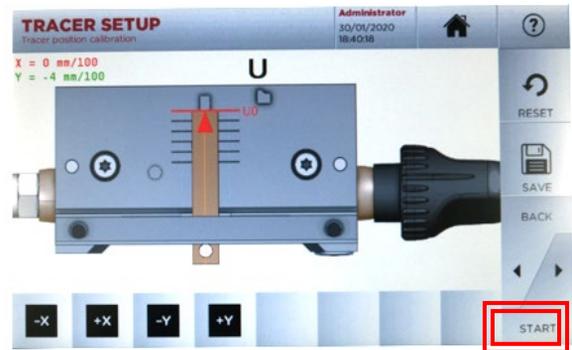
Select **SETUP**.



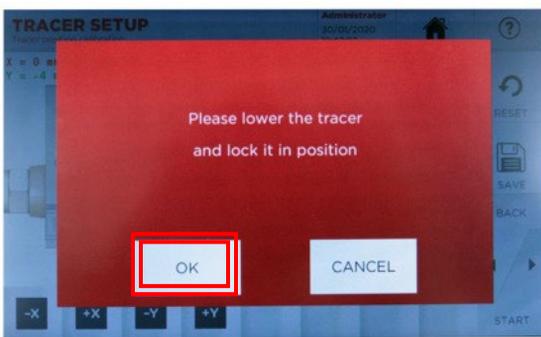
Select **CALIBRATIONS**.



Select **TRACER SETUP**.

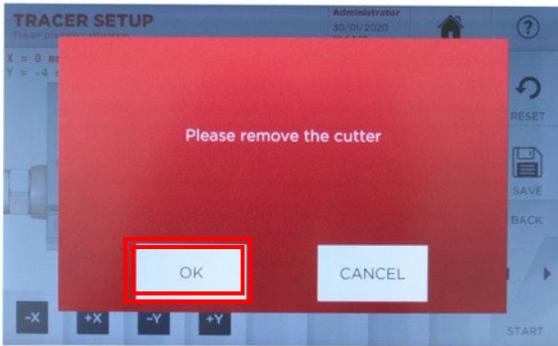


Insert the calibration template as shown.  
**PRESS START.**

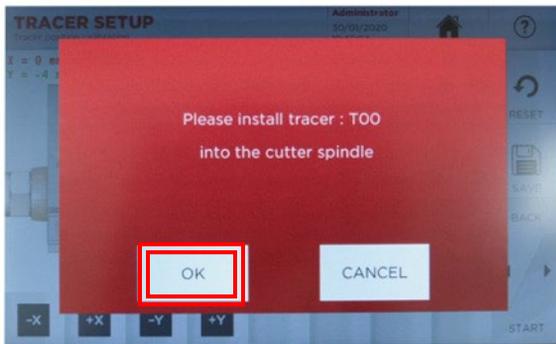


Loosen the tracer knob, lower the **TRACER** and tighten the knob. **PRESS OK**

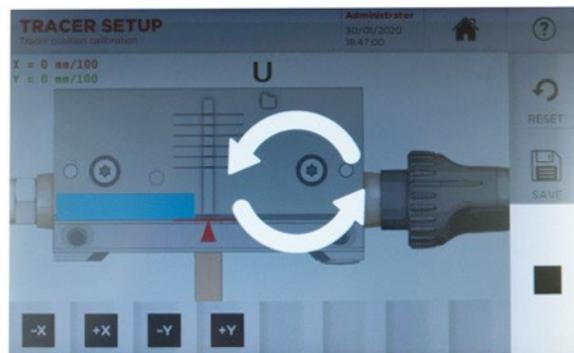
# CALIBRATION, cont.



REMOVE the V037 CUTTER. PRESS OK

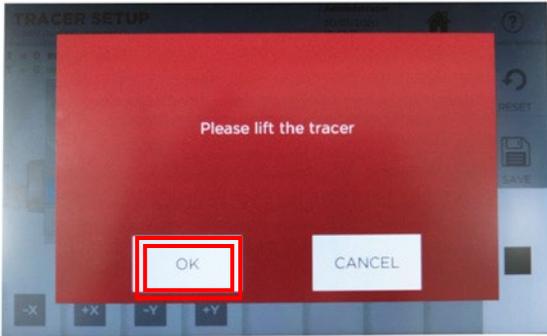


Install the T00 Calibration **TRACER** into the cutter spindle. Tighten the set screw and **CLOSE THE SHIELD. PRESS OK**

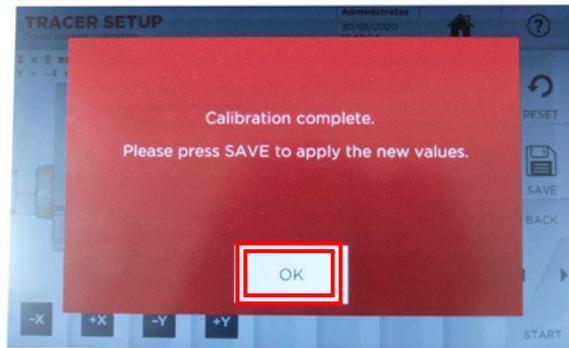


The **MACHINE** will **START** the setup process.

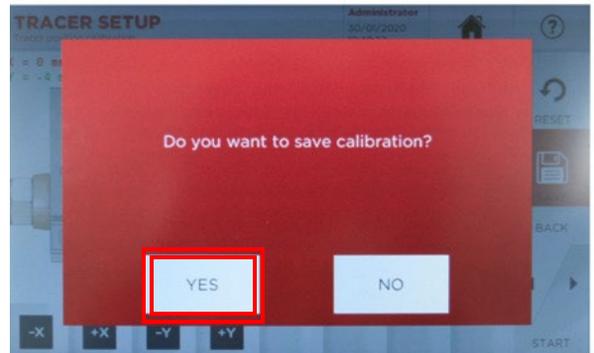
# CALIBRATION, cont.



When prompted, loosen the tracer knob, **LIFT THE TRACER** and **MOVE IT TO THE RIGHT**. Close the shield. **PRESS OK**



**PRESS OK.**



Write down the X & Y values and **PRESS THE SAVE BUTTON**. **PRESS YES** to save the results. **PRESS THE BACK BUTTON** after checking their values (see next page).

# CALIBRATION, cont.

## IMPORTANT

Run the Tracer Setup process a second time and compare the X & Y values of this process with the previous set. The values should not change more than +/- 3.

EXAMPLE:

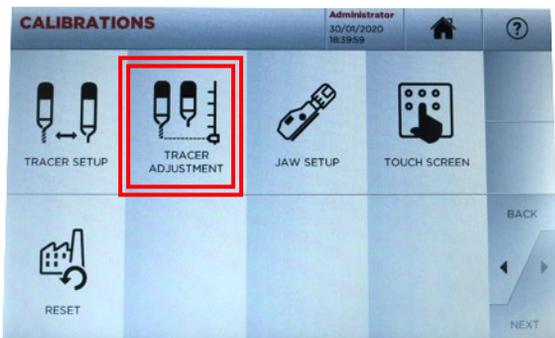
If during the first calibration process  $X = 0$  and  $Y = -4$ .

In the second calibration process:

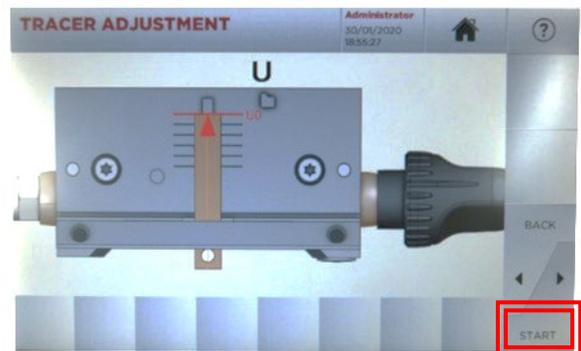
X must be between values -3 and +3

Y must be between values -7 and -1.

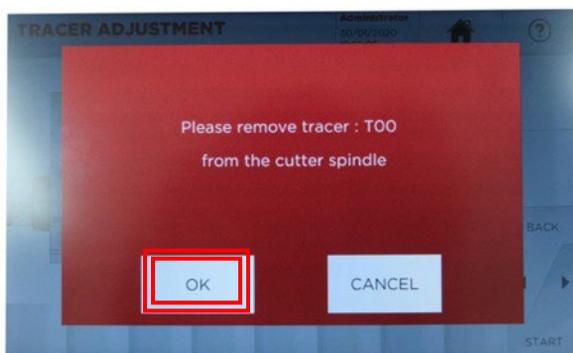
If the values are outside the +/- 3 variation run the calibration process a third time and compare the second set of numbers to the third. Press the **BACK** button.



Press **TRACER ADJUSTMENT**.



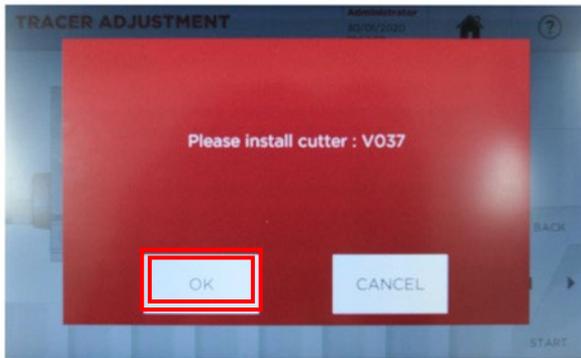
**PRESS START.**



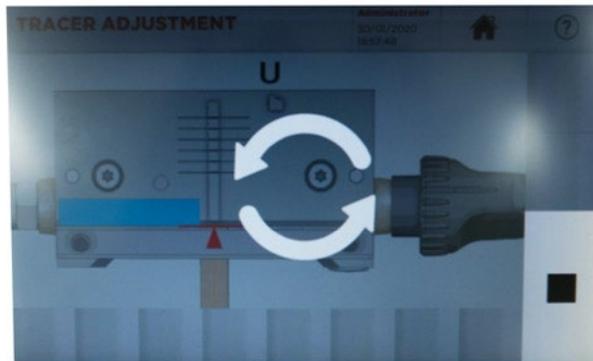
**REMOVE CALIBRATION TRACER T00 from the cutter spindle. PRESS OK**



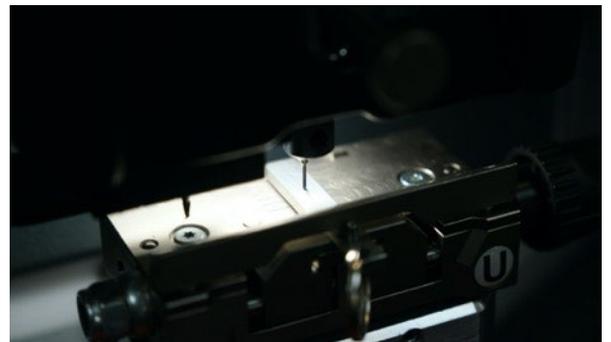
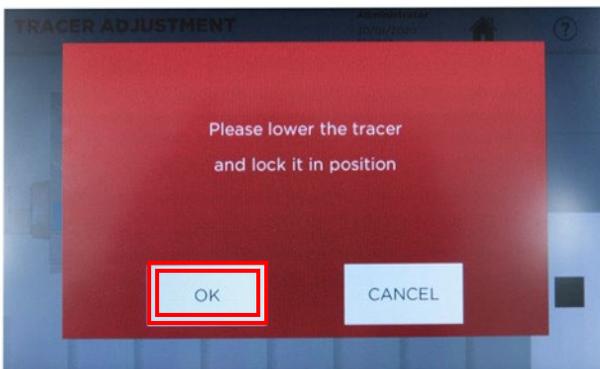
# CALIBRATION, cont.



Install the **CUTTER V037**. PRESS **OK**

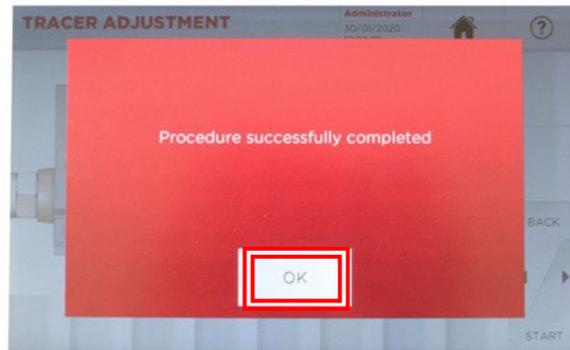


The machine will move the tracer over the jaw.

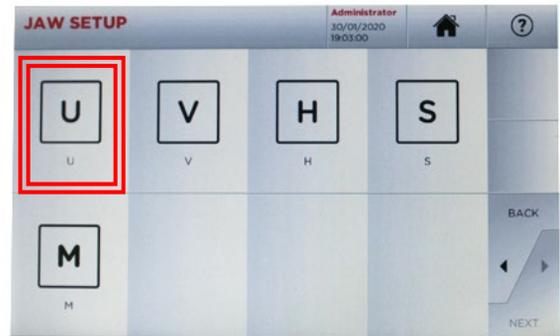


Loosen the tracer knob, lower the **TRACER**, tighten the **KNOB**. PRESS **OK**

# CALIBRATION, cont.



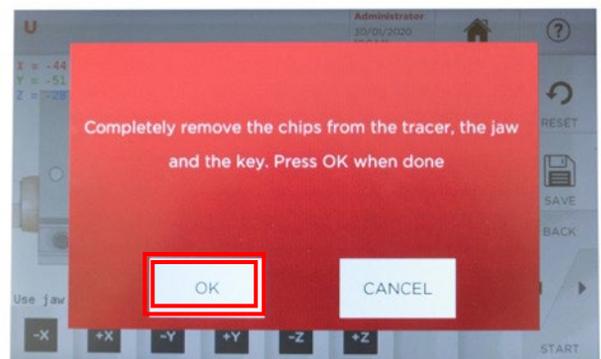
**PRESS OK** and then **PRESS BACK**.



Press **JAW SETUP** and **SELECT U JAW**

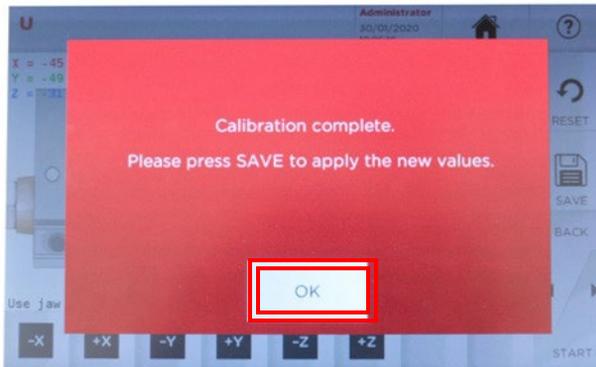


Make note of the values of **X,Y,Z**.  
**PRESS START**.



Completely remove the **CHIPS** from the **TRACER**, the **JAW** and the **KEY**.  
**PRESS OK**.

# CALIBRATION, cont.



**PRESS OK.**



**PRESS SAVE.**

## IMPORTANT

Run the calibration a second time and compare the X, Y & Z values with the first set of numbers and make sure that they do not change more than +/- 3.

EXAMPLE:

If the first calibration values are X= -44, Y= -51 and Z= -28

In the second calibration values can be:

X must be between -47 and -41

Y must be between -54 and -48

Z must be between -31 and -25

If the values are outside the +/- 3 variation run the calibration process a third time and compare the second set of numbers to the third.

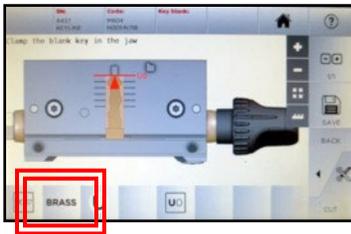
# IMPORTANT

## SAFETY SHIELD

The safety shield works in conjunction with the software prompts. The software, before starting some cut and decode procedures, requires the closing of the safety shield. If it is not closed when requested, it will continue to ask its closing. If the user opens the safety shield during an operating phase (for example, when the machine is cutting or decoding a key) it will stop immediately and, at the closing of the shield, the machine will reset the operation and go back to the beginning of the procedure. Make sure to complete all parts of the process at one time, then close the shield before proceeding to the next step. This will avoid having to replicate steps.

## KEY MATERIAL

The Gymkana 994 defaults to cutting brass keys as the key material type. If you are cutting a different type of metal key, such as steel, nickel silver or aluminum, you can make the selection in the cutting screen. Please note the Gymkana 994 cannot cut or decode any type of plastic key, painted keys or keys made of non-conductive materials.



To change the material type, simply touch the BRASS icon on the screen until you reach the desired material; **BRASS**, **STEEL**, **NiSi** (Nickel Silver) or **ALU** (aluminum)

## USE OF AFTERMARKET SPARE PARTS

Keyline machines require the use of factory original parts. Aftermarket cutters, tracers and adaptors are not recommended and may cause product damage that will void your machine warranty.

## MACHINE PACKAGING

Please retain all machine packaging for transportation purposes. Packaging is specially designed to safely transport the machine and it's components. Keyline is not responsible for providing additional packing material if original boxes are lost, damaged or discarded.

## WARRANTY INFORMATION

**In Warranty (within 90 days of purchase):** Customer will return machine and Keyline USA will the reimburse shipping charges. Keyline USA will pay the return shipping back to the customer

**In Warranty (91+ days of purchase):** Customer will pay to return the machine to Keyline USA. Keyline USA will pay the return shipping back to the customer

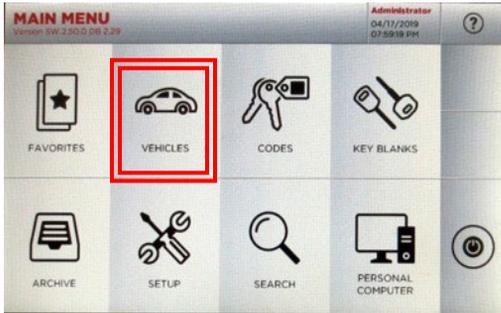
**Out of Warranty:** Customer will pay to return the machine to Keyline USA. Customer will pay the return shipping back to the customer

## TEMPERATURE

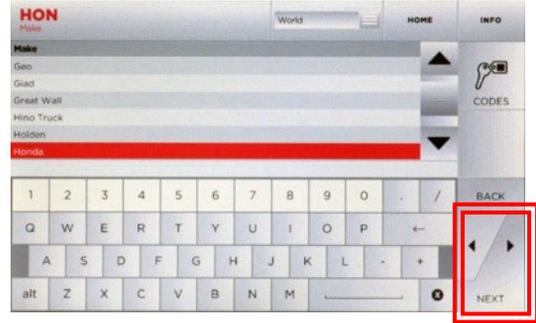
Machine operating temperature is between 32 and 104 degrees Fahrenheit.

# CUT BY DECODE

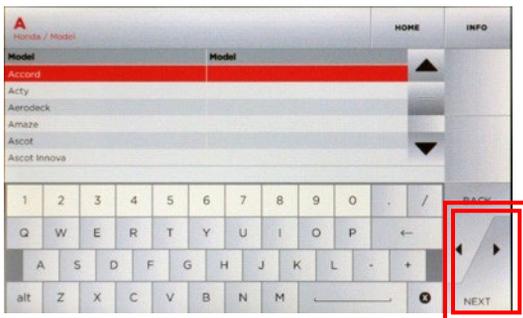
**TIP: DO NOT DECODE PLASTIC KEYS!** Only metal keys can be decoded and cut on the Gymkana 994. **IMPORTANT:** Make sure to clean the jaw, cutter and tracer of all chips before decoding or cutting keys by code.



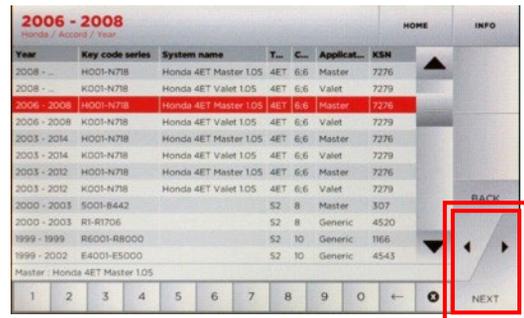
Select **VEHICLES**



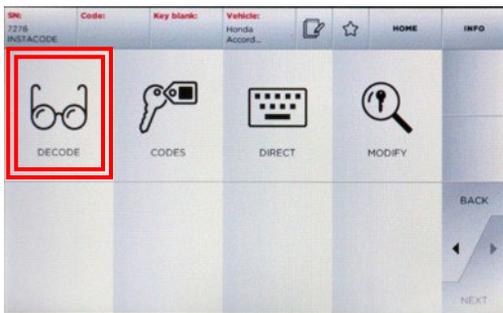
Select **MAKE**, then **NEXT**



Select **MODEL**, then **NEXT**



Select **YEAR RANGE**, then **NEXT**



Select **DECODE**, then select **NEXT**

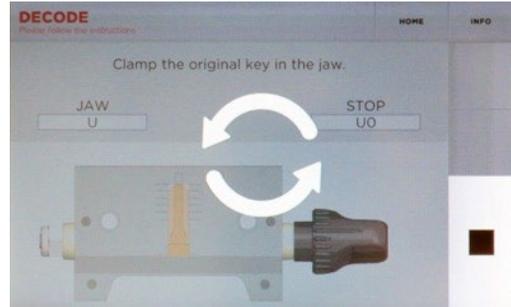


Insert key on jaw as shown

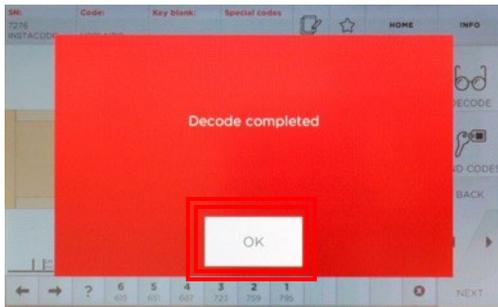
# CUT BY DECODE, cont.



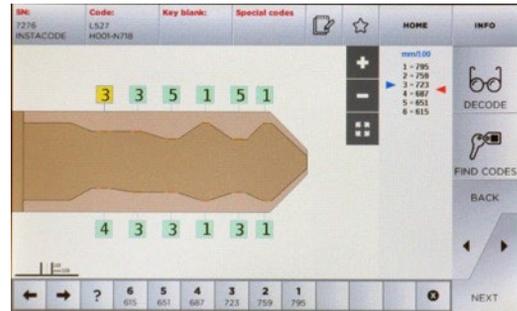
Confirm key is clamped as shown, then select **NEXT**



Decoding in process



Decode complete; Select **OK**

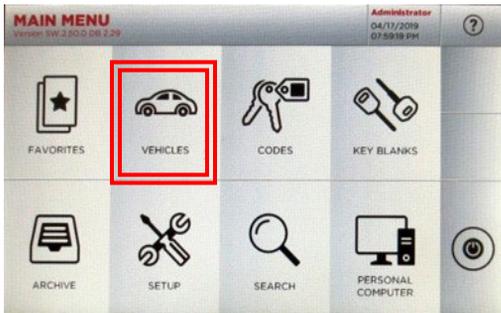


Depths and key code displayed

Select **NEXT**, then proceed with cutting the key by code (refer to Page 8 – CUT BY CODE, cont. to proceed with cutting)

# CUT BY CODE

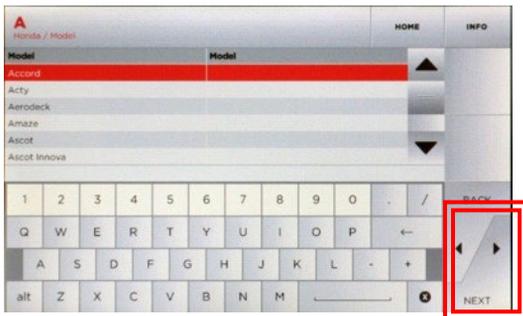
**TIP:** Cutting a test key is also recommended on first use to verify correct key cutting procedure. **IMPORTANT:** Make sure to clean the jaw, cutter and tracer of all chips before decoding or cutting keys by code.



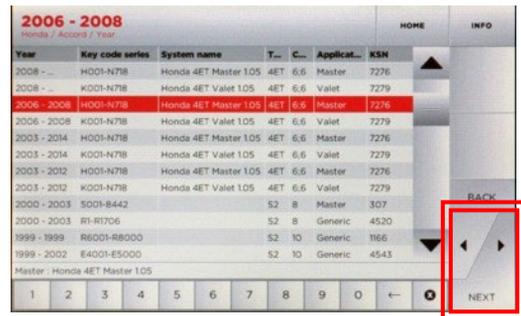
Select **VEHICLES**



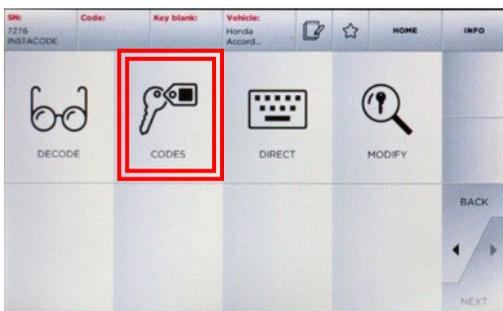
Select **MAKE**, then **NEXT**



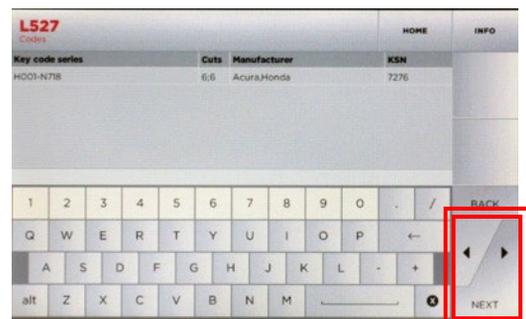
Select **MODEL**, then **NEXT**



Select **YEAR RANGE**, then **NEXT**

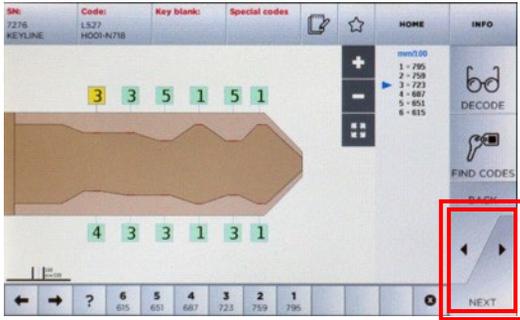


Select **CODES**, then select **NEXT**

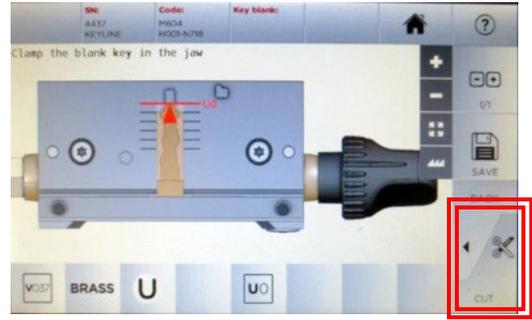


Enter code, (ex. L527), select **NEXT**

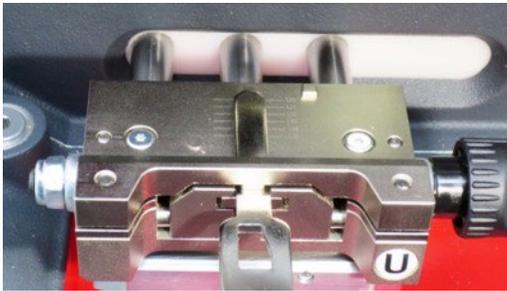
# CUT BY CODE, cont.



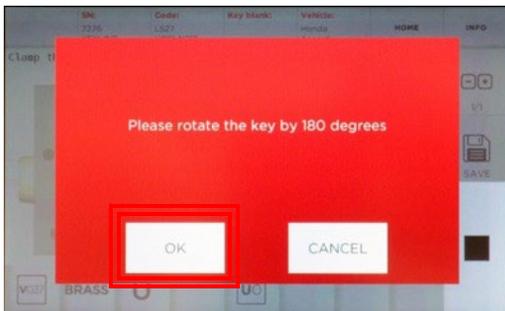
Key depths appear, select **NEXT**



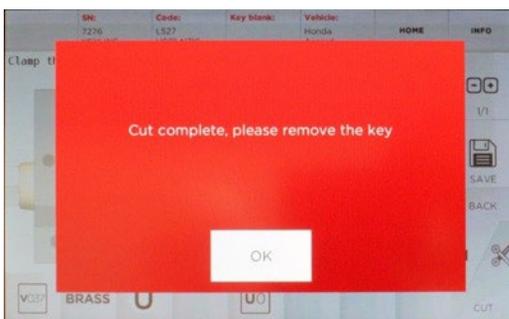
Clamp the key in the jaw, select **CUT**



Confirm the key is properly installed on the jaw and select **OK**

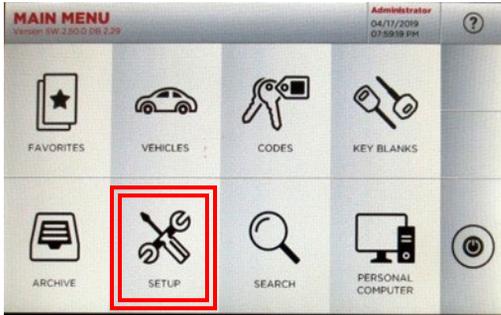


Flip key in jaw, removing key shavings with brush, select **OK**



Cut complete

# CUTTER REPLACEMENT



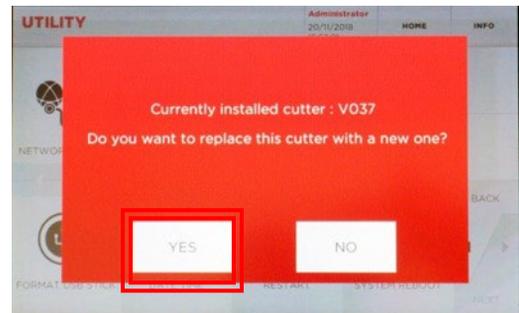
Select **SETUP**



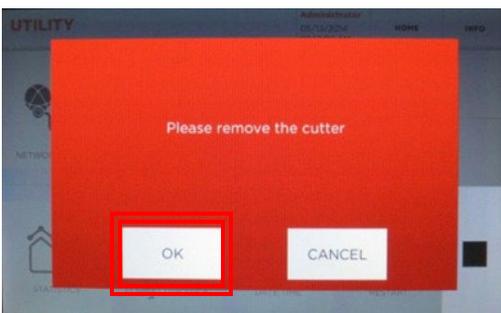
Select **UTILITY**



Select **REPLACE CUTTER**



Current cutter installed displays, select **YES** to continue



## TO REMOVE CUTTER:

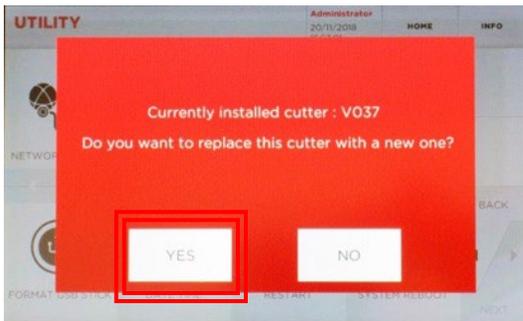
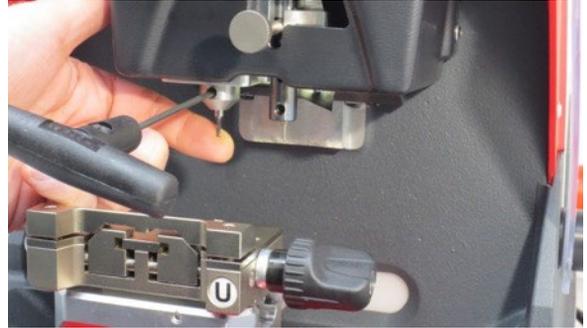
1. Insert 2.5mm Allen tool into set screw and once initial release, loosen  $\frac{1}{2}$  turn. Remove Allen tool.
2. Remove old cutter.



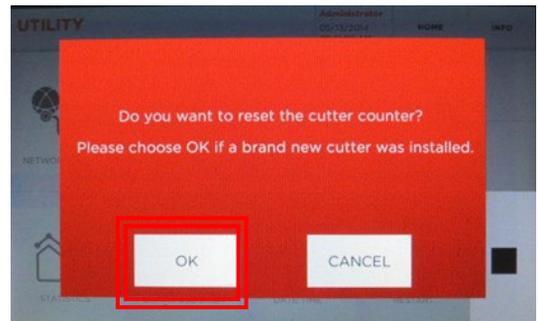
# CUTTER REPLACEMENT, cont.

## TO INSTALL NEW CUTTER:

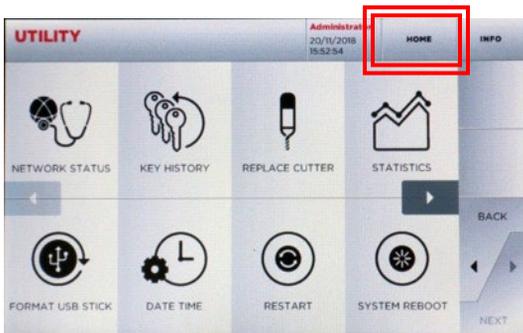
1. Insert new cutter until it stops.
2. Tighten set screw with 2.5mm Allen tool.



Select **YES** once complete

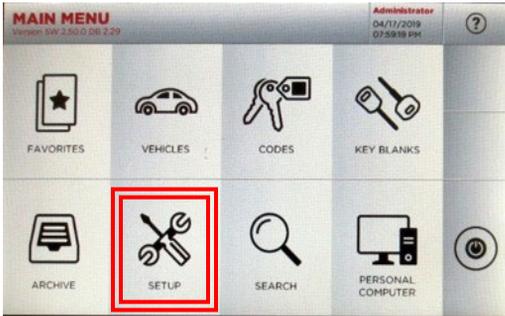


Select **OK** to reset cutter counter



Utility screen appears, select **HOME** to go to Main Menu

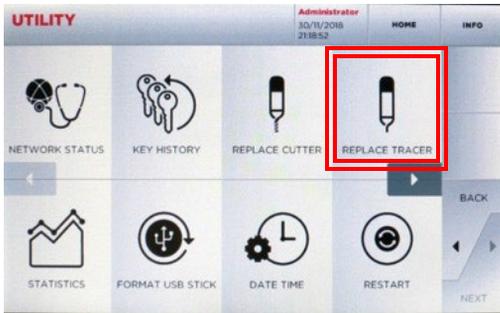
# TRACER REPLACEMENT



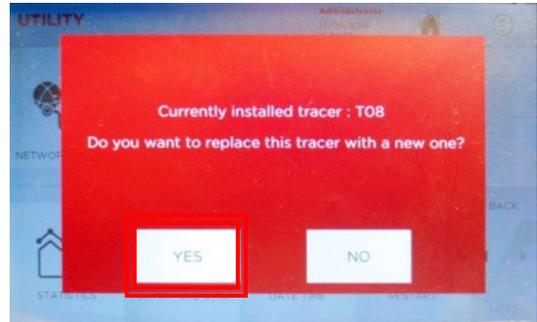
Select **SETUP**



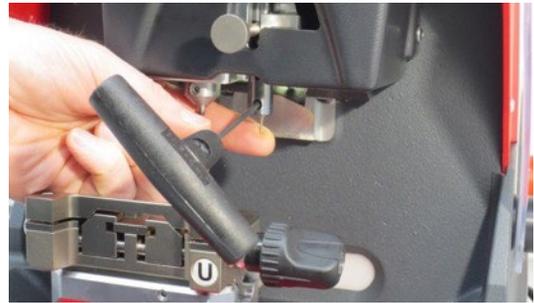
Select **UTILITY**



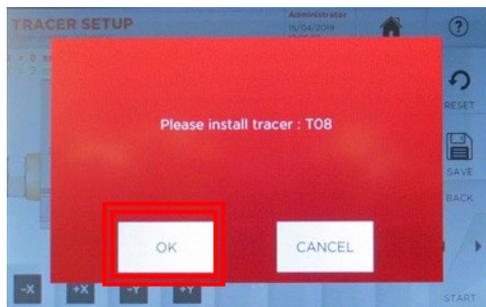
Select **REPLACE TRACER**



Current tracer installed displays, select **YES** to continue



Remove tracer using 2.5mm allen tool, then select **OK**



Install new tracer until it stops and tighten down set screw with 2.5mm allen tool

***You must perform the tracer setup, tracer adjustment and jaw calibration***

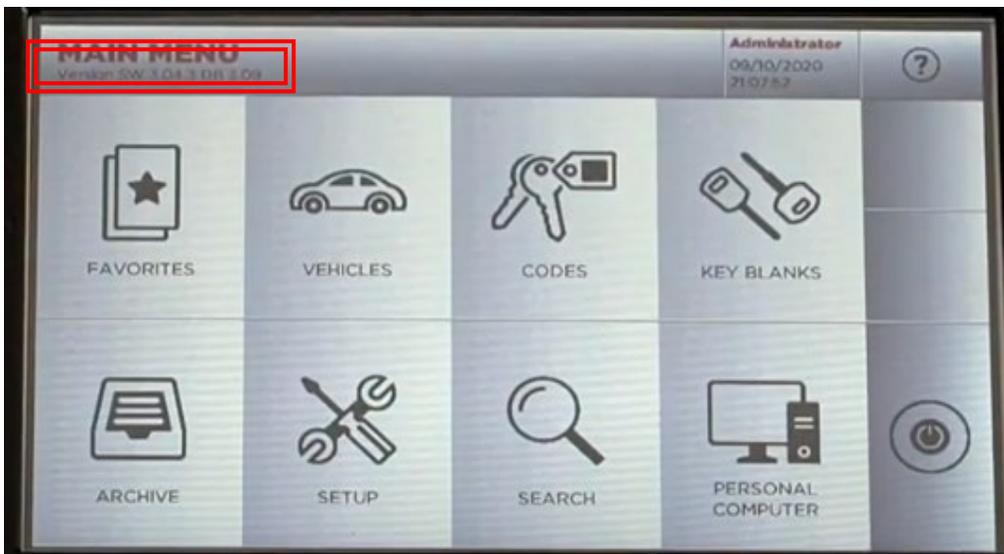
# SOFTWARE UPDATE INSTRUCTIONS

## SOFTWARE UPDATE VIA ETHERNET CABLE

### WHAT YOU WILL NEED:

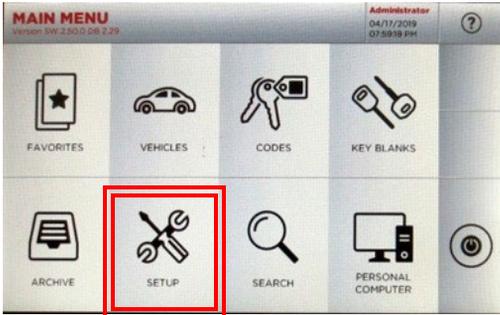


Console, Ethernet Cable and Internet Connection



To check your current software version, see 'Version SW' below the Main Menu tab

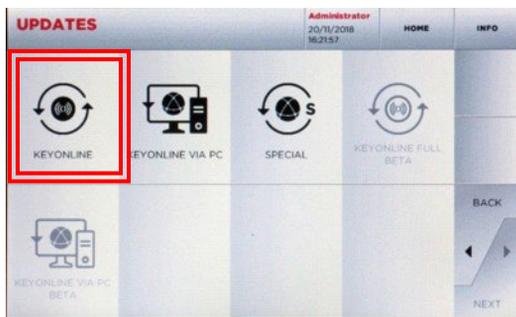
# STEP 1: Plug Ethernet Cable into Console from Internet



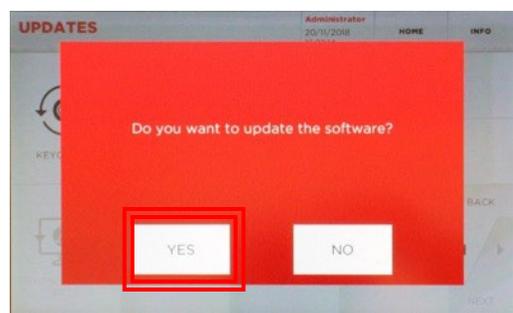
At **MAIN MENU**, select **SETUP**



At **SETUP MENU**, select **UPDATES**



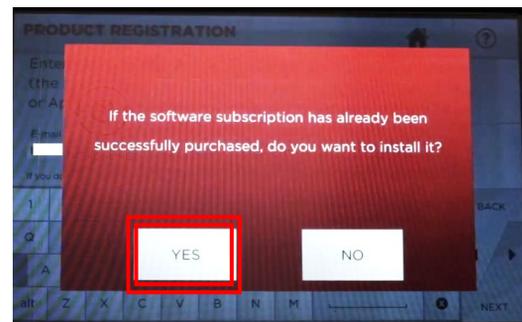
Then select **KEYONLINE**



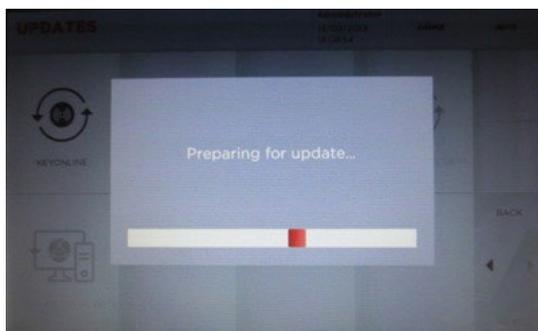
Select **YES** to update the software



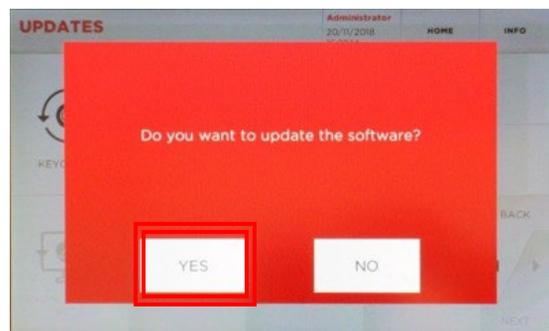
Internet test in progress



Select **YES**



Console prepares software file



Select **YES** to update the software

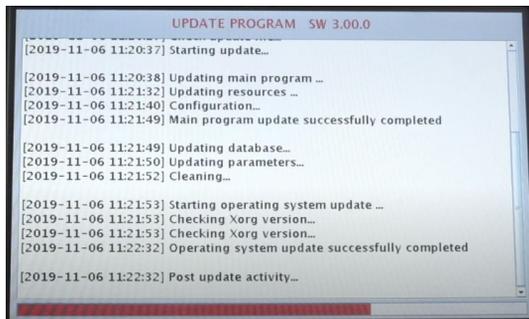
## STEP 2: Complete Software Installation on Console



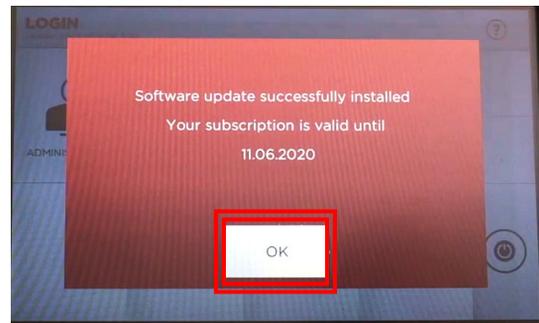
Wait for the update to finish



The system will reboot & finish the installation process



Update continues; progress bar on bottom

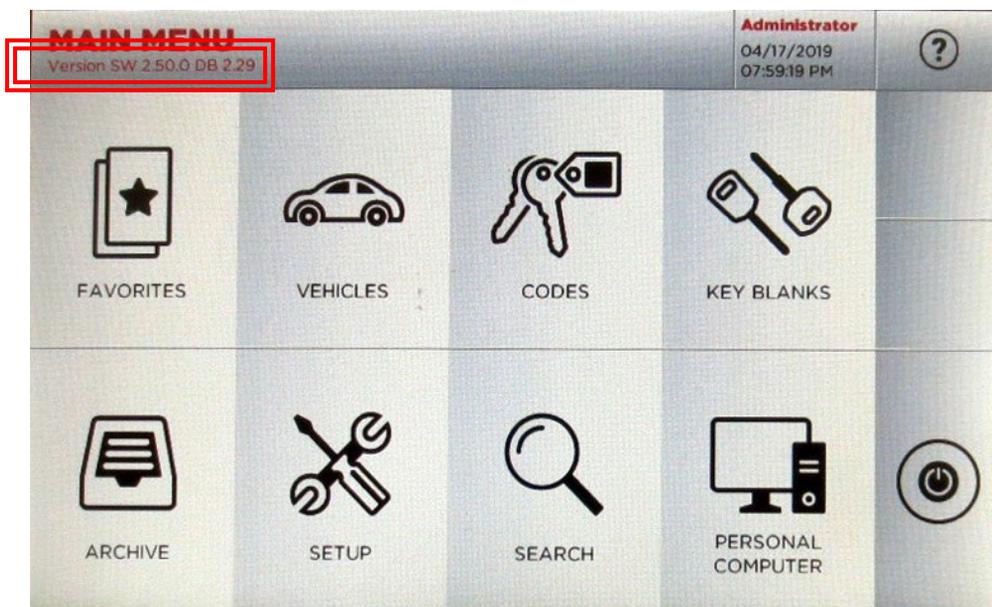


Update successful; select **OK**

# SOFTWARE UPDATE INSTRUCTIONS

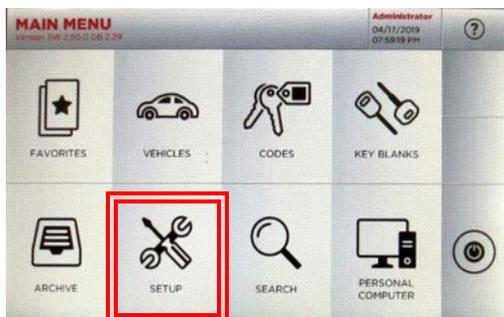
## SOFTWARE UPDATE VIA USB MEMORY STICK & KEYONLINE WEBSITE

### WHAT YOU WILL NEED:



To check your current software version, see 'Version SW' below the Main Menu tab

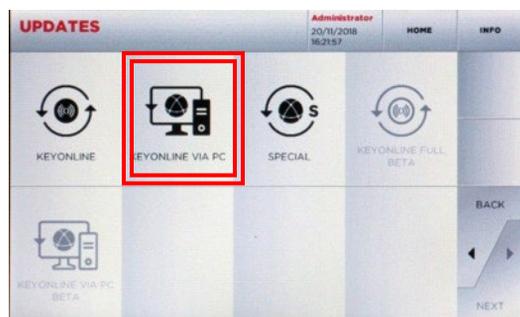
## STEP 1: Prepare USB Memory Stick with Update File



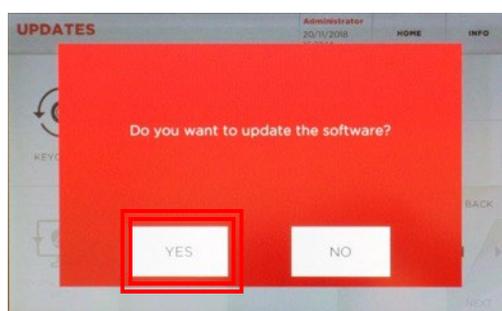
At **MAIN MENU**, select **SETUP**



At **SETUP MENU**, select **UPDATES**



Then select **KEYONLINE VIA PC**



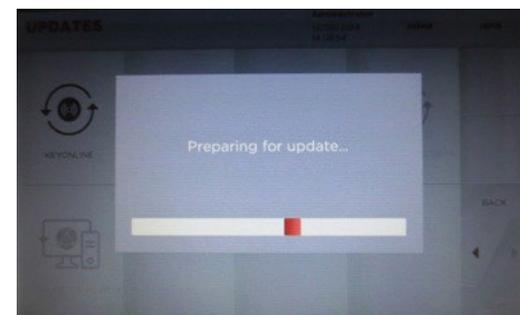
Select **YES** to Software Update



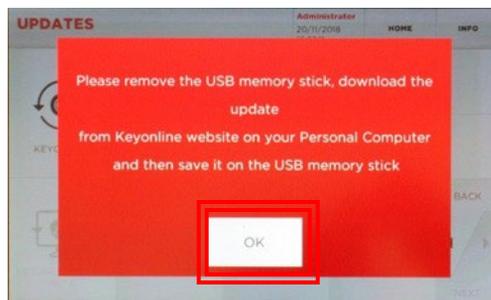
Insert USB Memory Stick, select **OK**



USB stick inserts on left side of console



Console prepares software file

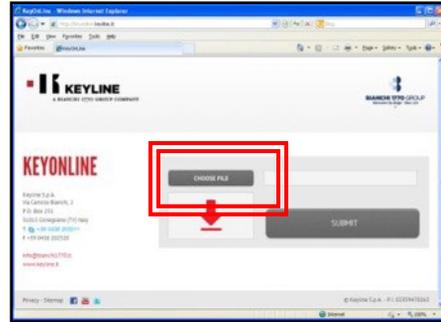


Remove USB stick, Select **OK**

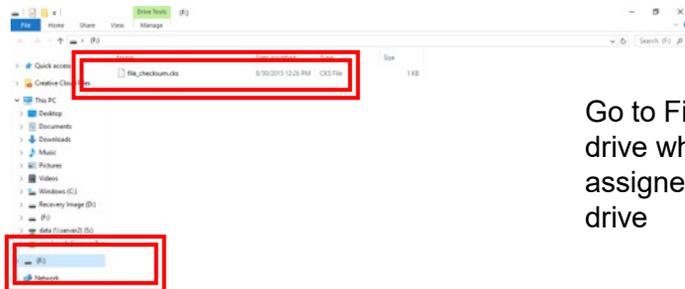
## STEP 2: Install Update File on USB from PC



Insert USB stick into USB port on PC then go to <http://keyonline.keyline.it>

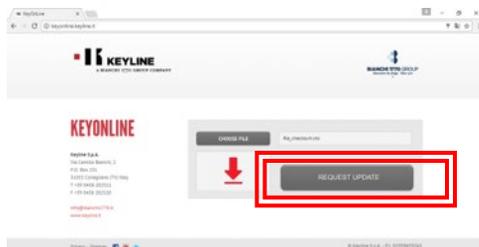


On site, double-click **CHOOSE FILE**



Go to File Explorer, locate the drive where the USB stick is assigned and double-click the drive

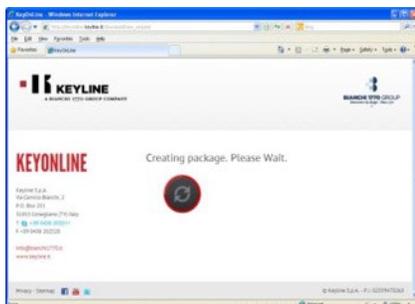
Highlight the '.cks' file listed and click **OPEN**



The '.cks' file now appears in the box on the Keyonline site, then click **REQUEST UPDATE**

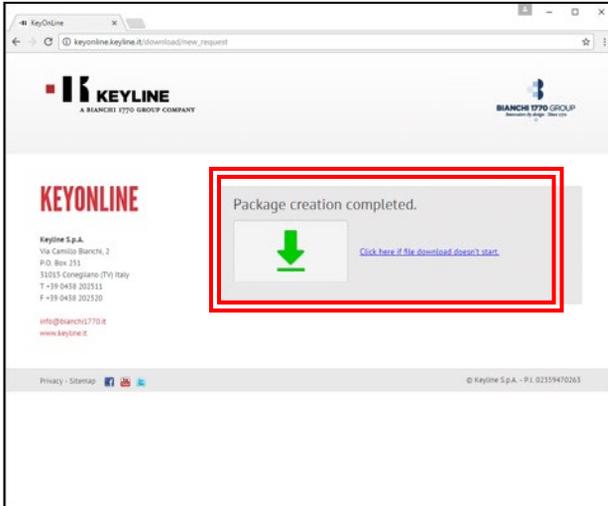
A pop-up box will appear that says **"This action may take some time"**

Click **OK** when this message appears

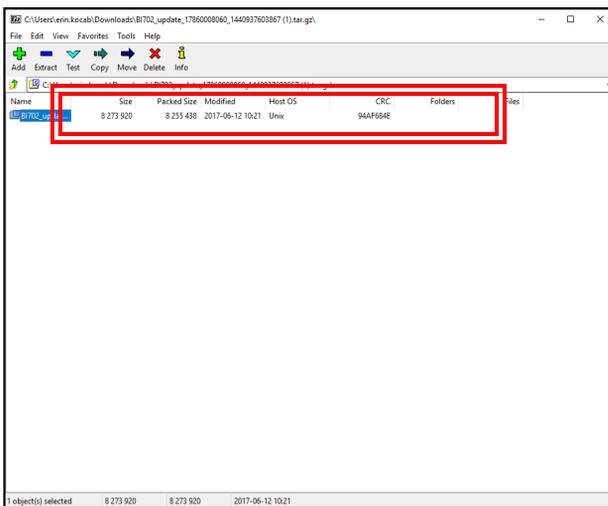


Software package creation will begin. This take up to a few minutes depending on your Internet speed.

## STEP 2, cont: Install Update File on USB from PC



Package creation completed should appear. You will be prompted with a pop up at the bottom of the screen, that shows the downloaded file. Click on the drop down arrow to the right of the download file and select **OPEN IN FOLDER**



Once you have the downloaded file folder up, locate the USB drive with the original file you downloaded from the Gymkana 994 console. Drag the new file that you created from Keyonline to the USB drive (NOTE: Do not extract the file – just drag and drop). The file will begin downloading to the USB stick.

Once the update file has finished installing you will then have two items on your USB stick. The original .cks file you downloaded from the USB and the file you downloaded from Keyonline.

Safely eject the Removable Disk from your drive. To eject, right click on the drive letter and select Eject. You can now take the USB memory stick back to your console to complete the software update.

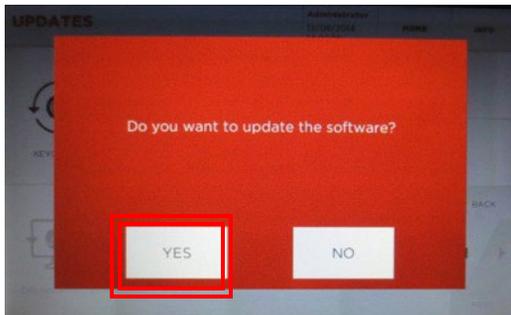
## STEP 3: Complete Software Installation on Console



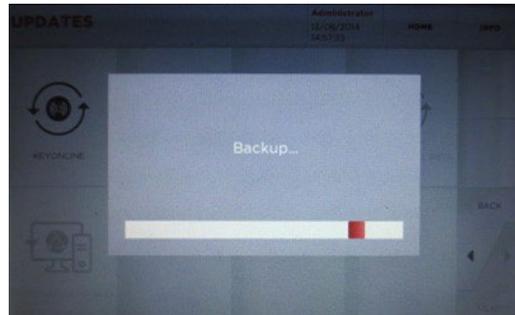
Insert USB into console and select **OK**



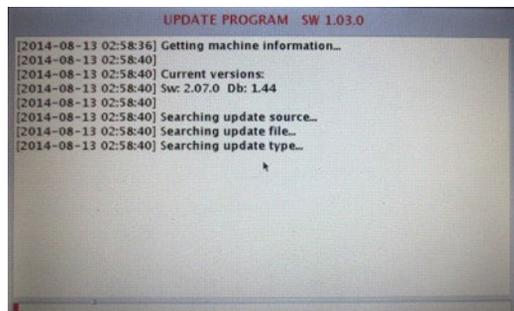
Update begins



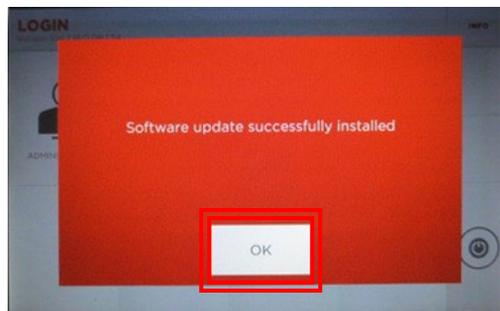
Select **YES** to confirm update



Machine will re-boot and power back up as update continues



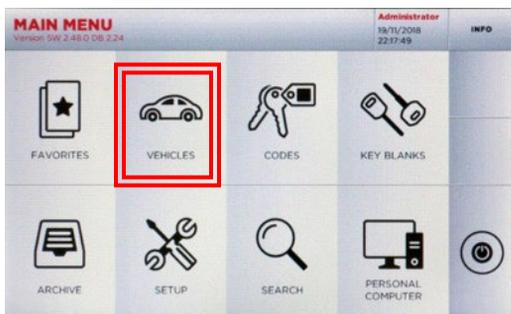
Update continues; progress bar on bottom



Update successful; select **OK**

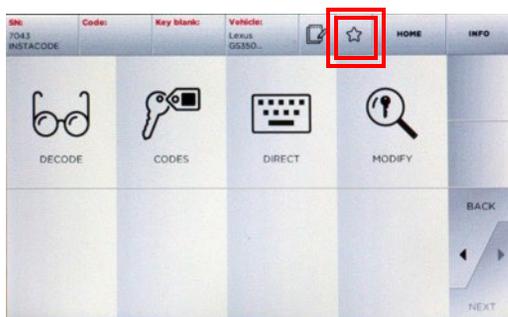
# FAVORITES

Selecting Favorites helps bypass Make, Model and Year selections that you most commonly use to get you right to the Code/Decode/Direct screen

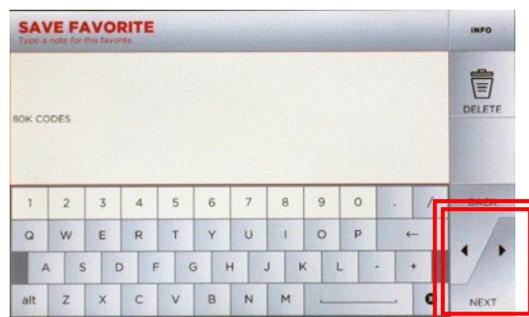


At Main Menu, select **VEHICLES**

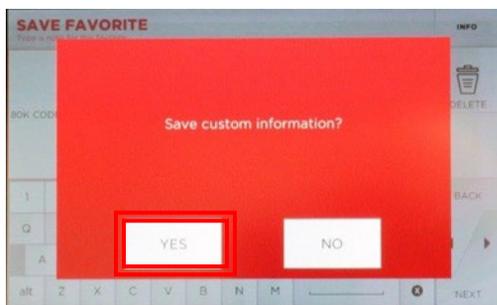
Go through the menu and select the Make, then the Model, then the Year and Code Series range of the vehicle you want to save a favorite for



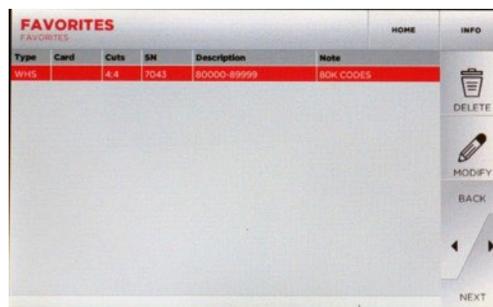
Select the Star icon from the top Menu bar



Enter the text for the Favorite you are adding, then select Next



Select **YES** to save custom info



From the Main Menu select Favorites and the saved favorite will now be listed. This can be selected for future keys to bypass the Make, Model and Year selection and go right to Decode/Codes/Direct menu

# GYMKANA 994 SPARE PARTS

Description	Part Number
2mm cutter – V037	RIC07786B
Tracer – T08	RIC11110B
1.5mm cutter – V012 (for use with V clamp and for Ford internal track on U clamp)	RIC05274B
4mm cutter – V055 – for Honda stainless steel keys (for use with K clamp)	RIC11109B
Calibration Tracer – T00	RIC05350B
Jaw calibration template	RIC10952B
V Clamp – Audi/VW, Jeep Wrangler	OPZ10260B
H Clamp (orange) – 6-cut Tibbe	OPZ09523B
J Clamp – 8-cut Tibbe	OPZ08099B
U Clamp (replacement)	OPZ11114B
M Clamp w/ A & B Adaptor	OPZ11088B-BS
SV/DV Adaptor for VATS keys	OPZ11086B
Tool Kit	RIC111204B
Gymkana cutter belt	RIC10876B
Anti-glare console screen protector	B9979
USB Flash Drive for Software Updates	PROMO-15
U Clamp Tip Stop	RIC08515B
Console Mounting Bracket (replacement)	RIC10744B
Gymkana Mounting Kit	B9980