

# Gym- kana 994

Use and Maintenance Manual  
Manuale d'uso

**GYMKANA 994**



VERS.0.0  
25/10/2018

COD. B410824FG

GYMKANA 994 Key Duplicating Machine

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**DICHIARAZIONE CE DI CONFORMITÀ**  
**(ALL. IIA DIR. 2006/42/CE)**

**IL FABBRICANTE**

Keyline S.p.A.  
Via Camillo Bianchi  
31015 Conegliano (TV) - ITALIA  
Tel. +39.0438.202511 / Fax +39.0438.202520  
e-mail: info@keyline.it / www.keyline.it

**DICHIARA CHE LA MACCHINA**

- Denominazione generica: DUPLICATRICE CHIAVI
- Modello: GYMKANA 994                      - Matricola:
- Anno:    - Rev.: 00
- Denominazione commerciale: MACCHINA DUPLICATRICE
- Uso previsto: La duplicatrice è stata progettata e costruita per effettuare la duplicazione di chiavi.

**È CONFORME ALLE DIRETTIVE**

- Direttiva 2006/42/CE del Parlamento Europeo e del Consiglio del 17 maggio 2006 relativa alle macchine.
- Direttiva 2014/30/UE del Parlamento europeo e del Consiglio, del 26 febbraio 2014, concernente l'armonizzazione delle legislazioni degli Stati membri relative alla compatibilità elettromagnetica.

**E AUTORIZZA**

- Nominativo: Keyline S.p.A.
- Indirizzo: Via Camillo Bianchi
- CAP: 31015
- Provincia: TV
- Città: Conegliano
- Stato: Italia

**A COSTITUIRE IL FASCICOLO TECNICO PER SUO CONTO**

**Luogo e data del documento:**

Conegliano,

**Legale Rappresentante:**



**CE CONFORMITY DECLARATION**  
**(ATTACHMENT II, POINT A DIR. 2006/42/EC)**

**THE MANUFACTURER**

Keyline S.p.A.  
Via Camillo Bianchi  
31015 Conegliano (TV) - ITALIA  
Tel. +39.0438.202511 / Fax +39.0438.202520  
e-mail: info@keyline.it / www.keyline.it

**DECLARES THAT THE MACHINE**

- General name: KEY DUPLICATING MACHINE
- Machine type: GYMKANA 994                      - ID number:
- Year:    - Rev.: 00
- Commercial name: DUPLICATING MACHINE
- Intended use: The key cutting machine has been designed and built for duplicating keys.

**CONFIRMS WITH THE FOLLOWING DIRECTIVES**

- Directive 2006/42/EC of the European Parliament and Council of 17 May 2006 concerning machinery.
- Electromagnetic Compatibility Directive 2014/30/EU of the European Parliament and Council of 26 February 2014 concerning the harmonisation of member states' legislation regarding electromagnetic compatibility.

**AND AUTHORISES**

- Name: Keyline S.p.A.
- Address: Via Camillo Bianchi
- Post code: 31015
- Province: TV
- Town: Conegliano
- Country: Italia

**TO COMPILE THE TECHNICAL DOSSIER ON OUR BEHALF**

**Place & Date:**

Conegliano,

**Legal representative:**

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L'esperienza suggerisce che è praticamente impossibile pubblicare un manuale privo di errori.

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Keyline S.p.A. will thank who may indicate possible mistakes or omissions.

"TRANSLATION OF ORIGINAL INSTRUCTIONS"

## WARRANTY CONDITIONS

1. Keyline S.p.A. guarantees the good operation of the machine for a period of 24 months from the purchase date, and undertakes to replace (if necessary, with a more recent model) or repair the machine or its individual components in case of defects in workmanship.  
This warranty does not cover any defects or damages caused by the user because of negligence, or by repairs, replacement of individual components or maintenance carried out by operators not authorized by Keyline S.p.A., or by any circumstance not under the control of Keyline S.p.A. The industrial use of the machines is regulated by the provisions of Art. 7 below.
2. Any repair or replacement expenses, except transport costs, shall be borne by Keyline S.p.A. Parts subject to normal wear and tear, such as cutters, clamps, brushes, and tracers, are not covered by this warranty.
3. Keyline S.p.A. reserves the right to refuse free service when the requested documents (purchase invoice stating the machine serial number) are not provided or when the information is incomplete, illegible or incompatible with the manufacturing data.
4. At Keyline S.p.A.'s sole discretion, repairs may include the updating of some details and the replacement of components with equivalent parts, new or refurbished. The replaced components and accessories are guaranteed for the residual duration of the original warranty. Replacement of the product or of a part does not extend or restart the warranty period.
5. If a machine still under warranty is equipped with non-original accessories, Keyline S.p.A. shall not be liable for any malfunction and the warranty shall be considered void.  
Keyline S.p.A. does not guarantee the correct operation of the product/machine combination, if the machine is used together with non-original accessories or equipment, and, consequently, shall not accept requests for service under the warranty.  
In order to make use of this warranty, the customer undertakes to notify Keyline S.p.A. of any defect covered by the warranty within 30 days from its manifestation, on pain of this warranty becoming void. In case of non-compliance, for any reason, of this term, the one provided for by Art. 1495 CC will be applied.

### General exclusions

6. The following items are excluded from the warranty:
  - Components subject to normal wear and tear or deterioration as a consequence of a normal use of the product and defects originated by the same cause.
  - Product defects that can be led back to non-compliance with the instructions for use, incorrect

- use, anomalous environmental conditions, non-compliant operating conditions, lack of maintenance or care or industrial use of the machine without service.
- Defects or damages due to transport, humidity, liquids or infiltrations caused by the incorrect use of the product.
- Defects due to an incorrect preservation of the product on unsuitable or inappropriate environmental conditions which differ from the technical specifications of the product, from the instructions for use, from the installation guide;
- Scratches or damages to the surfaces and external parts caused by the normal use of the Product by the customer.
- Defects of the key cutting machine due to the use of non-original Keyline S.p.A. accessories or spare parts.
- Products that have been altered or integrated with no previous agreement.
- Minimal anomalies of the product's characteristics that do not compromise its value and performance.

Except for the right to the elimination of any of the defects mentioned in these warranty terms and conditions, any other rights are explicitly excluded.

Keyline S.p.A. refuses any liability for injury to persons and components deriving from lacking grounding or improper use of the product.

7. Machines subject to industrial use that exceed the set number of work cycles during the validity of the warranty must be subjected to regular maintenance, carried out exclusively by Keyline S.p.A. staff; the costs of regular maintenance are borne by the customer. If no maintenance is carried out, the warranty is to be considered null and void as at the moment in which the machine exceeds the number of work cycles declared by Keyline S.p.A.

The number of cycles that determines the definition of a machine for industrial use is 10,000 cycles per year. Transportation is left to the user to arrange, who may choose the carrier. Transportation costs and risks are borne by the customer.

### Competent court

8. Shall any dispute arise in relation to the validity, interpretation, execution, dissolution or non-fulfilment of this document, the court of competent jurisdiction is located in Treviso, Italy.

Keyline S.p.A.  
Via Camillo Bianchi, 2 - P.O. Box 251  
31015 Conegliano (TV) Italy  
T. +39 0438 202511  
F. +39 0438 202520  
info@keyline.it  
www.keyline.it

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1. Keyline S.p.A. garantisce al Cliente il buon funzionamento della macchina per un periodo di 24 mesi dalla data di acquisto e si impegna a sostituire (eventualmente anche con modello successivo) o riparare la macchina, o i singoli componenti, qualora vengano riscontrati difetti di funzionamento all'origine. Non sono coperti da garanzia i difetti o i danni causati dall'utente a seguito di negligenza nell'uso, ovvero causati da riparazioni, sostituzione di singoli componenti, manutenzioni effettuate da soggetti non autorizzati da Keyline S.p.A., ovvero da qualsivoglia circostanza indipendente da Keyline S.p.A. Per l'uso industriale delle macchine vale quanto stabilito al successivo art.7.
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6. Sono esclusi dalla garanzia:
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  - Difetti del prodotto riconducibili all'inosservanza

delle istruzioni per l'uso, ad un uso improprio, a condizioni ambientali anomale, a condizioni di funzionamento non conformi, mancata manutenzione o cura, un uso industriale senza tagliando di controllo.

- Difetti o danni dovuti al trasporto, ad umidità, liquidi o infiltrazioni causate da un non corretto utilizzo del prodotto.
- Difetti dovuti a una non corretta conservazione del prodotto in condizioni ambientali inadatte o inappropriate che differiscono dalle specifiche tecniche del prodotto, dalle istruzioni operative, dalla guida d'installazione;
- Graffi o danni ad ogni superficie e ad ogni altra parte esterna, causate dal normale utilizzo del Prodotto da parte del Cliente.
- Difetti della duplicatrice provocati dall'utilizzo di accessori o ricambi non originali Keyline S.p.A.
- Prodotti su cui sono state eseguite modifiche o integrazioni non previste.
- Anomalie di minima entità delle caratteristiche del prodotto che non inficiano il valore e le prestazioni della macchina.

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7. Le macchine soggette ad un uso industriale che superano all'interno del periodo di garanzia il numero di cicli stabilito, devono essere sottoposte alla Manutenzione periodica del prodotto, eseguita esclusivamente da personale Keyline S.p.A.; il costo della manutenzione periodica è a carico del cliente. In caso contrario, la garanzia decade al superamento dei cicli dichiarati da Keyline S.p.A.

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Keyline S.p.A.  
Via Camillo Bianchi, 2 - P.O. Box 251  
31015 Conegliano (TV) Italy  
T. +39 0438 202511  
F. +39 0438 202520  
info@keyline.it  
www.keyline.it

*Dear Customer,*

*thank you for choosing a Keyline product.*

*Keyline is particularly careful and determined to create products combining precision mechanical equipment and next generation electronics that excel in terms of performance and are very easy to use.*

*Please remember that this Keyline key-cutting machine, like all professional electronic equipment, requires some technical training in order for its full potential to be developed.*

*It is therefore essential to read this manual carefully before starting to use your new Keyline key-cutting machine. The manual contains a lot of information on the safe use of the machine that will allow the user to work at optimal levels.*

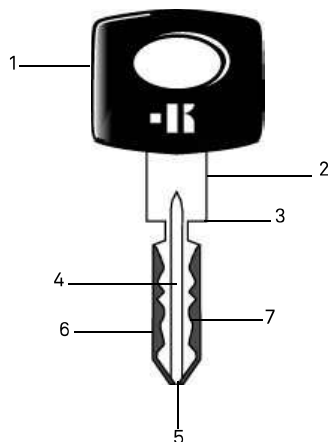
*To guarantee maximum protection and a long life for your key-cutting machine, please follow all the instructions for use and warnings contained in this manual. Failing to do so may cause mechanical failure or the malfunction of the key-cutting machine.*

*We wish you a pleasant work experience with your new Keyline key-cutting machine.*

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## GENERAL INFORMATION AND SAFETY INSTRUCTIONS

### Glossary



- 01. Head
- 02. Neck
- 03. Shoulder
- 04. Blade
- 05. Tip
- 06. Back
- 07. Bitting

<b>Edge cut keys</b>	A "Edge cut" key is a key cut by removing material from the external sides of the stem.
<b>Laser-Style keys</b>	Such keys are called "laser" on account of their special bitting style across the profile.
<b>Key sample</b>	The "original" key from which, through decoding, a duplicate key is obtained.
<b>Key blank</b>	A key with no engraving that is cut following the profile of the key sample.

The user's and maintenance manual of the "Gymkana 994" for the duplication of automotive laser and edge cut keys, contains all operation instructions on the best way to use the machine while guaranteeing the safety of operators.

#### 1.1.0 Scope and contents of the manual

This manual provides basic information on the installation, operation and maintenance of the key duplicating machine. Users must follow the instructions contained in this manual scrupulously, especially those concerning safety norms and ordinary maintenance.

#### 1.1.1 How to store the manual

The manual must always be kept with the machine it refers to. The manual must be stored in a safe place, away from dust and moisture and it must be accessible to all users who shall consult it any time they are in doubt on how to operate the machine.

#### 1.2.0 Manufacturer's address

**Keyline S.p.A.**  
Via Camillo Bianchi  
31015 Conegliano (TV) - ITALY  
Tel.: +39.0438.202511  
Fax: +39.0438.202520  
Website: [www.keyline.it](http://www.keyline.it)  
E-mail: [info@keyline.it](mailto:info@keyline.it)

To facilitate communication please state:

- the name of the customer;
- the machine identification data contained in the machine data plate.

#### 1.3.0 Working conditions

##### 1.3.1 Intended use

The key cutting machine described in this manual has been designed for the electronic code cutting and duplication of automotive laser and edge cut keys, using special adaptors.

#### 1.3.2 Improper Use

The improper use of the machine includes using the tool to perform an operation that it was not intended for. Should this occur the manufacturer shall take no responsibility for damage to materials or persons and shall consider all warranties on the machine void.

#### 1.4.0 Safety legislation

The key duplicating machine was designed and produced in compliance with the harmonised standards from time to time in force and complies with the Essential Health and Safety Requirements of Annex I to the Machinery Directive **2006/42/EC**.

Moreover, key duplicating machines produced by **Keyline S.p.A.** satisfy the requirements of the Low Voltage Directive 2014/35/EU and Electromagnetic Compatibility Directive 2014/30/EU.

**Warning: Important!**



**Users must be informed about the instructions contained in the following screens.**

**Users must carefully follow the instructions contained in this manual.**

#### 1.4.1 General safety requirements

**Warning: Important!**

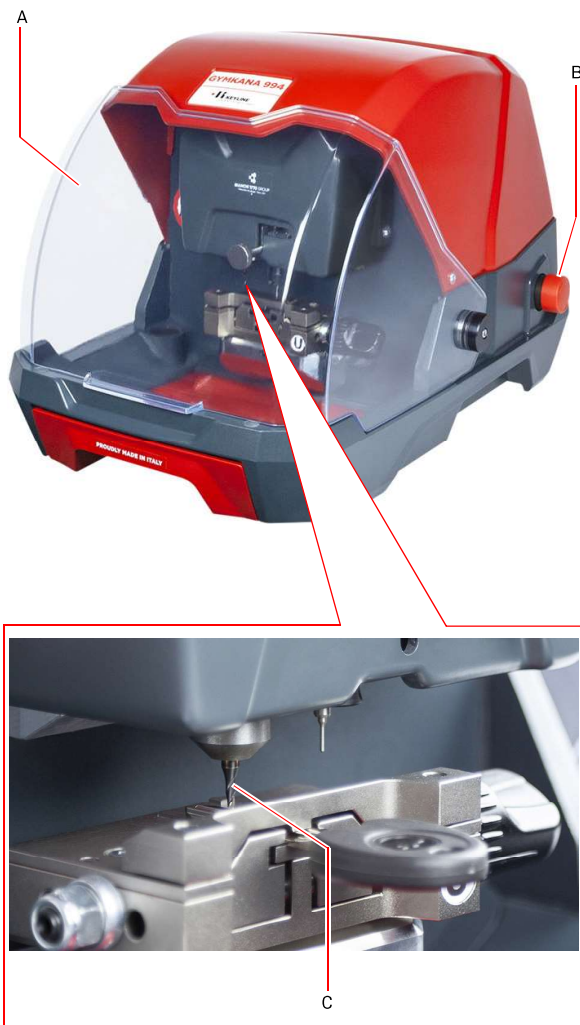


**Make sure that the grounding system is well connected.**

**Always unplug the machine (turn off the main switch) before servicing mobile parts that are electrically operated.**

**Do not pour water or other liquids onto electrical cables and connections.**

## GENERAL INFORMATION AND SAFETY INSTRUCTIONS



### 1.5.0 Protection devices

- A. Protective eye guard
- B. Stop Button

### 1.5.1 Personal protective equipment (PPE)

When using and maintaining the key cutting machine, it is necessary to wear the following PPE:

- |                       |  |
|-----------------------|--|
| <b>Shoes</b>          | In case of slippery floors users must wear safety shoes with anti-slip soles.            |
| <b>Safety glasses</b> | During key cutting operations operators must wear eye protection (glasses or goggles).   |
| <b>Gloves</b>         | If milling cutters are present, operators must wear protective gloves to avoid injuries. |

### 1.6.0 Residual risks

When operating the machine the following residual risks - as well as those connected with its use - must be taken into due consideration:



- **Electrocution hazard**

Since the machine is equipped with electrical devices, in case of faults there might be a risk of electrocution.



- **Mechanical hazard (C)**

The machine is fitted with milling cutters used in key cutting operations. Operators must watch out to avoid cutting their hands when they are cutting keys or changing tools.



## MACHINE DESCRIPTION

### 2.1.0 Technical features

Dimensions	Gymkana 994	Console
Width	300 mm (11.81")	200 mm (7.87")
Height	310 mm (12.20")	150 mm (5.90")
Depth (Length)	440 mm (17.32")	50 mm (1.96")
Weight	17,5 Kg (38.58lbs)	0,8 Kg (1.76lbs)
<b>Gymkana 994 technical features</b>		
Power supply	90-260V 50-60Hz with external power adapter AC/DC	
Absorption	120W (35W in stand-by)	
Motor	Brushless	
Electronic Equipment	Main board with CPU iMX6, 1 GB RAM, 4 GB memory, high resolution motion control	
External connections	1 USB port; 1 LAN	
Key Reading / Decoding system	Electric contact	
Clamps	Unified U clamp for automotive laser and edge cut keys (for additional optional clamps, please refer to par. 2.3.0)	
Cutter	Widia $\varnothing$ 2,0 mm for laser, edge cut and Tibbe keys	
Cutter speed	3000-8000 rpm (speed changes according to programme)	
Movements / Axes	3 axes driven by stepper motors on interpolated linear movements	
Operating temperature	0°C $\div$ + 40°C (32°F $\div$ 104°F)	
Acoustic pressure level $L_p$ (A)	78,5 dB(A)	
Lighting	Working area lighted by LED lights	

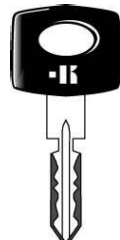



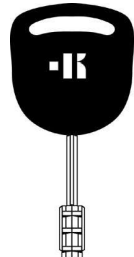
Console technical features	
User Interface	7" industrial colour touch screen, 16:10, resolution 800x480 px, integrated CPU
Power supply	DC 24V (fed by the key cutting machine)

### 2.2.0 Gymkana 994 main features

The **Gymkana 994** electronic key cutting machine is a professional machine that can help the operator in the cutting of automotive laser and edge cut keys.

**Gymkana 994** can be used in mobile mode, through a smartphone or an Android\* tablet, thanks to the new Keyline Duplicating Tool smart App, or through the improved Keyline industrial console, with the Liger software.

The key cutting machine **Gymkana 994** is used to duplicate the following types of keys:

Laser-type keys		
4 External cuts	Double internal bitting	Double external bitting
		
Double bitting edge cut keys	Tibbe-Ford keys (optional)	
		

\* A good and stable Internet connection is always required.

## MACHINE DESCRIPTION

### 2.2.1 Parts- Machine



1. Tracer holder
2. Cutter
3. Jaw
4. Knob to lock jaw
5. Tracer height adjustment knob
6. Container to collect waste
7. Protective eye guard
8. Stop button
9. Mobile support for Console and Smartphone
10. Mobile support fastening latch
11. RJ25 console connector
12. External power supply connector
13. External power supply
14. Console (optional)

### 2.3.0 Optional clamps

The following optional clamps can also be used with **Gymkana 994**:

- H type clamp for Tibbe systems (6 spaces)
- V type clamp for new Volkswagen® laser keys (4 sides)
- S type clamp for simplex keys

## TRANSPORT AND INSTALLATION

### 3.1.0 Packaging

Packaging includes a cardboard box with the following dimensions:

Dimensions	
Width	440 mm (17.3")
Height	500 mm (19.7")
Depth (Length)	540 mm (21.3")
Weight	25 Kg (55.12 lbs)

### 3.1.1 Opening the package



**IMPORTANT!**  
We recommend you to keep the packaging during the warranty period.

Remove the machine from the packing materials following the instructions below:

1. Cut the seals of the closing adhesive and open the box containing the key cutting machine.
2. Remove the packaging that contains the user manual, console (if any), cables and/or clamps/optional and accessories.



3. Remove the four side protections from the box.



4. Grab the two recesses on the long sides of the machine and lift the machine out of the box.



5. Free the machine from its packing.
6. Extract the tool kit from the cardboard shaped packaging placed at the bottom of the box.



### 3.2.0 Transport

The markings on the packing materials indicate how to handle the machine during transport.

#### 3.2.1 Unloading and handling the machine

The machine can be unloaded manually by 2 or 3 persons, or by using a handling equipment (for example a lift truck).



**Avoid dropping the machine, even a small damage could impair its correct functioning.**

#### 3.3.0 Temporary storing

If the installation of the machine does not occur immediately, store the machine in a dry and properly ventilated place.

#### 3.3.1 Characteristics of the place of installation

The key cutting machine must be placed on a smooth level bench about 90 - 110 cm (35 - 43 Inches) high, suitable for bearing the weight of the machine and keep it horizontal, thus avoiding vibrations and stress.

Allow a 30 cm (12 Inches) clearance around and above the key cutting machine for correct functioning and maintenance.

#### 3.3.2 Temperature and humidity

The tool should be used in rooms with a temperature range of 10 and 40 °C (50°F ÷ 104°F) and a relative humidity lower than about 60%.

#### 3.3.3 Working environment

The machine must be used in a place protected from bad weather (rain, hail, snow etc.).



**Do not use the machine in explosive or partially explosive atmospheres or in the presence of inflammable liquids of gases.**

### 3.3.4 Lighting

In the place of installation lighting must be appropriate, in order to allow the correct use and maintenance of the machine.

### 3.4.0 Connections

#### 3.4.1 Grounding

The machine must be grounded through the centralized circuit of the place of installation.

**Warning:**



**Check that the power line voltage is compatible with the machine voltage and that the line is grounded.**

**Use exclusively the power cord supplied with the machine.**



**Do not touch the machine when your hands and/or feet are wet or humid.**

## USING THE MACHINE WITH THE CONSOLE

### 4.1.0 Notice for machine use

In order for the machine to function under optimum conditions and in complete safety at all times:

- Keep the power cable away from sources of heat, humidity, oil, water and sharp objects.
- Keep cutting tools sharpened and clean at all times to ensure better and safer performance.
- Do not expose the machine to inclement weather.
- Disconnect the machines power cable before any maintenance, repairs and whenever the machine is not used for a lengthy period of time.
- Use only original spare parts.

### 4.1.1 Preliminary controls and setup

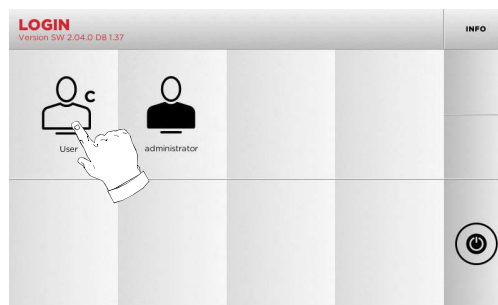
Before proceeding with the start up of the machine:

- Perform a general visual inspection of the machine to ensure that no components have been removed or modified.

### 4.2.0 Starting the machine

To start working with **Gymkana 994**, proceed as follows:

1. Before starting the machine, connect the console to the machine with the RJ25 cable.
2. Check that the stop button has not been activated.
3. Wait for a few minutes for the Touch Screen to display the “LOGIN” page.



4. Select the user for operating with the machine (e.g. USER).
  - With the admin user is possible to enter the Setup Menu for managing calibrations and settings.
  - In the following page enter the password to access the MAIN menu.

**Note:** No password is required for the first start of the machine.

### 4.3.0 Language setting

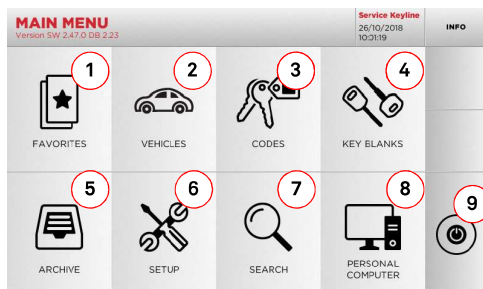
How to proceed:

- From the MAIN menu, select: “A”.
- From the SETUP menu, select: “B”.
- Select “C” and chose the interested language.



## SETUP

### 5.1.0 Main Menu



#### Options displayed:

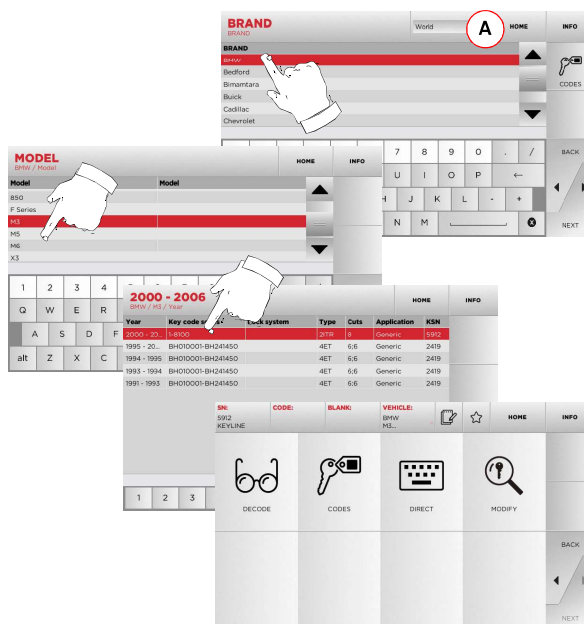
1. This function gives access to a collection of "Bookmarks" previously saved by the user, for faster access to the most frequently saved keys/systems.
2. This allows you to search and select data via the car brand and model.
3. This allows you to search and select data via the original indirect code (profile and series).
4. This allows you to search and select data via the Keyline key article and similar blank keys made by other manufacturers.
5. This function makes it possible to access the archive containing the keys identified during the search and decoding processes, so that they can be retrieved quickly every time the user needs them.
6. To access the menu for adjusting the cutting and decoding process, updating and diagnostics of the machine and calibrating the operating parameters.
7. This function allows access to the database on the machine to search for coded processing data or deciphering.
8. Set of functions used to connect the machine to programmes being executed on remote PCs and import DAT files.
9. Back to login page.

### 5.1.1 Search by car brand

The "CAR" menu makes it possible to search and duplicate a key through a list of car brands included in the database.

#### How to proceed:

- From the MAIN menu, select "CAR".
- Select one of the options in the top drop-down menu (A).
- Input the brand or scroll the menu and select the desired brand (e.g., BMW), then press "►".
- Choose the car model first, then the year of production, and press "►".
- From the operating menu, choose one of the search or key modification options: DECODE, CODES, DIRECT and MODIFY.



Note: From now on, please refer to chapter 7 on page 16.

Note: The "☆" symbol makes it possible to save the selected key in the list of bookmarks. See paragraph 6.2.0.

### 5.1.2 Search by code

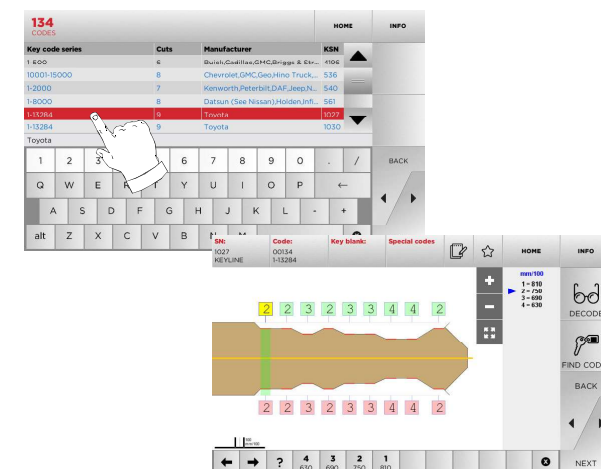
The search by code is made when one wishes to search for a key using the indirect code pertaining to the key's series, as provided by the manufacturer.

#### How to proceed:

- From the MAIN menu, select "CODE".
- Input the complete original code (or part of the same) through the keypad and scroll the list of articles to choose the desired one.

Note: All the series and the records that may contain the inserted code are displayed in ascending order, with attached application / brand of use.

- Press "►" to access the key modify menu.



Note: From now on, please refer to chapter 7 on page 16.

Note: The "☆" symbol makes it possible to save the selected key in the list of bookmarks. See paragraph 6.2.0.

- To go back to the previous page, press the "◀" key.

## SETUP

### 5.1.3 Search by article

Selecting the search by article function allows quick access to the information that refers to a Keyline key article or to other well known brands.

#### How to proceed:

- From the MAIN menu, select:
- Input the article code for the key, then press "►".
- Choose the desired code, or press the "B" button to select the manufacturer of the blank key (e.g. Keyline) then enter it with "►".
- From the operating menu, choose one of the search or key modification options: DECODE, CODES, DIRECT and MODIFY.



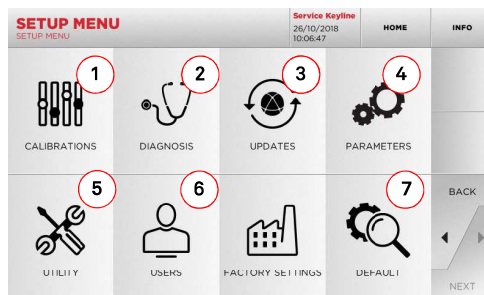
**Note:** From now on, please refer to chapter 7 on page 16.

### 5.2.0 Setup Menu

The MAIN menu allows access to the set-up menu to regulate the cutting and reading devices, to update the machine and use the diagnostic function.

#### How to access the page:

- From the MAIN menu, select:



#### Options displayed:

1. For the calibration of the devices on the machine.
2. To access the status check menus of the main devices of the machine.
3. To access the software and database updating procedure of the machine.
4. To consult and set the operating parameters of the machine.
5. To access the following functions:
  - Network Status: displays the status of the connection.
  - Keys History: to access the database of duplicated keys.
  - Cutter change: guided procedure for cutter change.
  - Tracer point change: guided procedure for tracer point change.
  - Statistics: keeps track of the total number of cut keys and of other useful counters.
  - Format USB drive: to format the USB drive.
  - Date and Time: to set current date and time.
  - Restart: restarts the program automatically.
  - Reboot: restarts the whole system automatically.
  - Machine status: to save or reset the search data.
  - Machine data: displays some useful pieces of information, such as the machine serial number or the software version.

- ON/OFF Monitor: to turn the console on or off.

6. To access the user data management menu described in paragraph 8.1.0 on page 18.
7. To access all predefined settings for some viewing parameters, such as the unit of measure, the preferred vehicle brand, the preset region and numbering system.

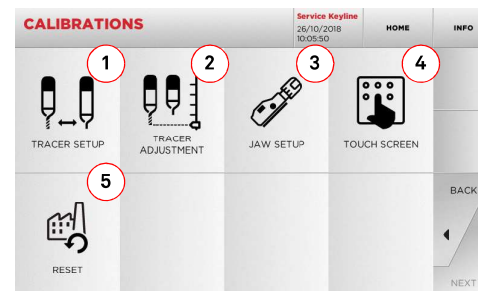
- For further information select "INFO" from the display.

### 5.3.0 Calibrations Menu

Through the CALIBRATIONS menu it is possible to access the calibration functions of the machine's devices, in order to obtain the correct execution of the duplication process.

#### How to access the page:

- From the SETUP menu, select:



#### Options displayed:

1. To calibrate the tracer manually or automatically.
2. To adjust the tracer height.
3. To select the jaw to be installed and to calibrate it according to the type of key to be cut.
4. To regulate the Touch Screen settings.
5. To access the menu that allows the operator to reset the tracer point and jaws.

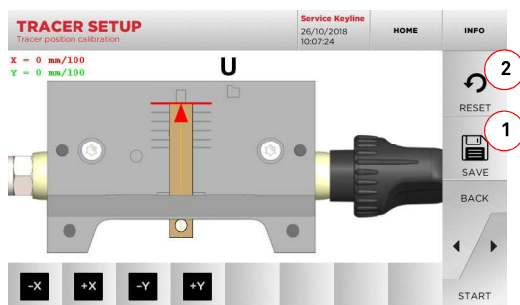
- For further information select "INFO" from the display.

## SETUP

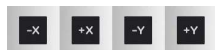
### 5.3.1 Tracer Setup

To calibrate the tracer manually, proceed as follows:

- From the CALIBRATIONS MENU, select: 



- Place the template flush on the clamp.
- Change the position of the X-Y axes with the buttons:



- On the top left of the display it is possible to view the height to be modified.
- Save your changes by pressing "1".

**Note:** If you leave the page without pressing the "1" key, all changes shall be lost.

- To reset the changes and go back to the previous setting, press "2".

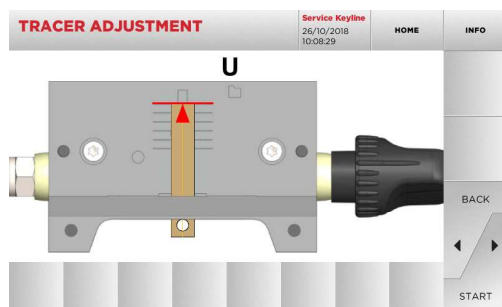
To calibrate the tracer manually, just press START from this page.

### 5.3.2 Tracer Adjustment

For the decoding of car keys (laser or edge cut) the tracer must be set at a specific height.

**How to proceed:**


- From the CALIBRATIONS MENU, select: 

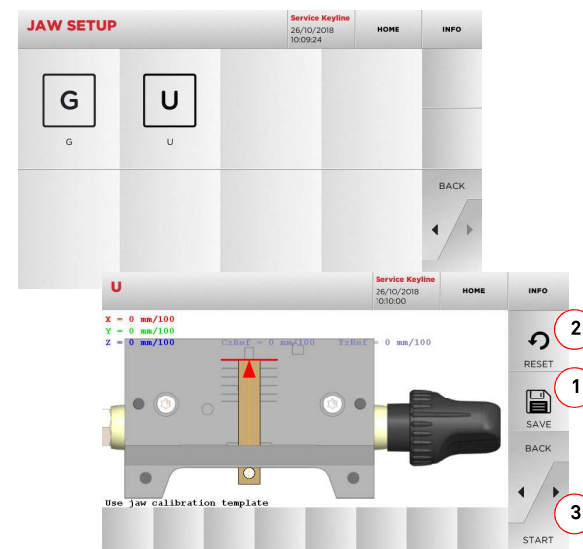


- Place the template flush on the clamp and press START.
- The software will request that the tracer be lifted completely using the adjustment knob (1).
- Then the unit will position the tracer above the template and the system will ask to lower it, again using the adjustment knob (1), and place it on the template itself.
- Now lock the tracer in place.

### 5.3.3 Jaw Setup

**How to proceed:**

- From the CALIBRATIONS MENU, select: 
- Install the required jaw and select the corresponding code from the JAW SETUP menu.



- Place the template flush on the clamp.
- Then press "3" to launch the jaw self-calibration process.
- On the top left of the display it is possible to view the height to be modified.
- Save your changes by pressing "1".

**Note:** If you leave the page without pressing the "1" key, all changes shall be lost.

- To reset the changes and go back to the previous setting, press "2".
- Press "3" and follow the instructions on screen to calibrate the jaw correctly.



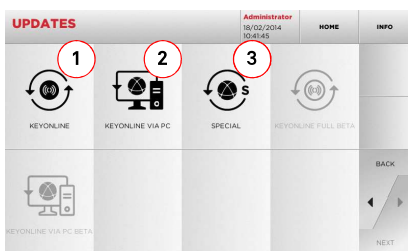
## SETUP

### 5.4.0 Update

It is possible to update the machine through the graphic interface.

How to access the page:

- From the SETUP menu, select:



Options displayed:

- To proceed with the online software and database update, through the "Keyonline" service.
- The update package is downloaded through a normal PC connected to the internet and saved on a USB flash drive, so as to be able to install it later on in the machine.
- To proceed with the software and database update, taking the data from a USB flash drive.

- For further information select "INFO" from the display.

### 5.4.1 Keyonline Update

**Note:** Before updating, check that the console is connected to a LAN Network.

Pressing the "KEYONLINE" key, the programme proceeds to send the necessary information to the Keyonline service and later to download the update package.



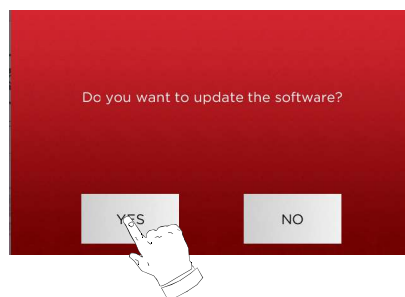
**According to the quantity of the data to be downloaded, the process might require a waiting time.**

**Note:** During this phase, some error messages might appear, stating that the machine is not registered or that it is impossible to download the updates. In such cases, please check that all the preliminary operations have been concluded and that all the network parameters are configured correctly. For further help, please contact the Keyline Service Centre.

How to proceed:



- From the UPDATES menu select:
- Disconnect any USB flash drives connected to the machine and press the "YES" key.
- The programme shall reboot and the update software executed; the user might be required to turn off and reboot the machine.
- Follow the instructions and wait until the end of the procedure, whereupon the most recent versions of the software and database shall be available.
- To annul the operation, press NO.



### 5.4.2 Keyonline via PC Update

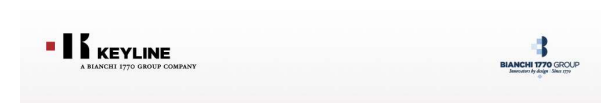
If it is not possible to configure the machine to connect to the internet, this procedure makes it possible to update it by connecting to Keyonline through a PC with internet connection.

How to proceed:



- Press the "KEYONLINE VIA PC" button; a message asking to connect a USB flash drive to the machine shall appear.
- Then, press the "NEXT" button to proceed, or the "CANCEL" one to cancel the operation.
- The program shall copy a file with a .csk extension on the USB flash drive, containing the information to be sent to Keyonline to update the machine.
- After a few seconds a message stating that the operation is finished shall appear and the user will be asked to download the update from Keyonline.
- Interrupt the operation by pressing "CANCEL" or proceed with the following instructions:

- Disconnect the USB flash drive and connect it to a PC with an internet connection.
- Using the browser, connect to the following web page: <http://keyonline.keyline.it/>
- Select the "CHOOSE FILE" button to access the file selection dialogue box.



**KEYONLINE**

Keyline S.p.A.  
Via Camillo Bianchi, 2  
P.O. Box 251  
31015 Conegliano (TV) Italy  
T +39 0438 202511  
F +39 0438 202520

info@keyline.it  
www.keyline.it

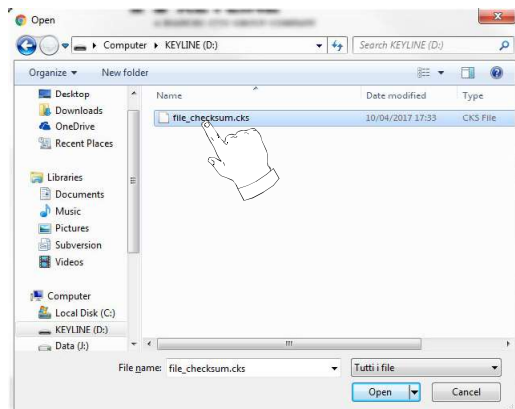


Privacy - Sitemap

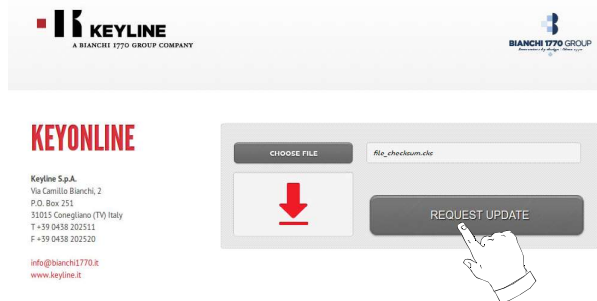
© Keyline S.p.A. - P.I. 02359470263

## SETUP

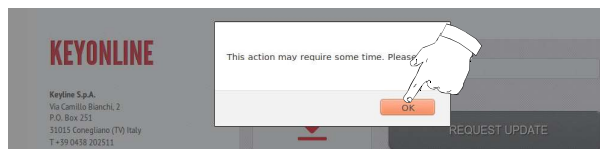
4. Search and select the .csk file previously saved in the flash drive, then press "OPEN".



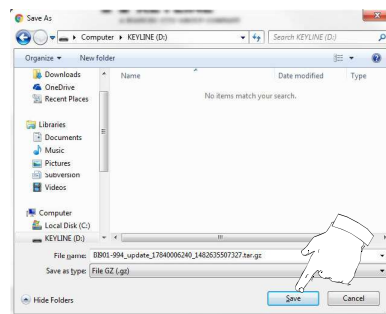
5. Press the "REQUEST UPDATE" button.



6. The following message shall appear:



7. Press "OK" to start downloading the file and when the browser asks where to save it, choose the USB flash drive.



**Note:** The download may require some minutes, it is necessary to wait for the process to end.

8. After copying the file downloaded to the flash drive, remove the flash drive and connect it back to the console.

**Note:** The downloaded package can be used only by the machine with which the update procedure was started.

9. After connecting the USB flash drive to the machine, press OK. The updates shall be analysed and loaded in the machine's memory.



**During this phase, messages may appear stating the presence of errors in the package, the absence or invalidity of the licence. In these cases, check that you have used the same USB flash drive that you connected to the machine at the beginning of the update process. Contact the Service Centre to solve any problems.**

10. The program shall reboot and the update software executed; the user might be required to turn off and reboot the machine.  
11. Follow the instructions and wait until the end of the procedure, whereupon the most recent versions of the software and database shall be available.

### 5.4.3 Special

**Warning:**



**This update procedure may be carried out only upon request by Keyline.**

**How to proceed:**

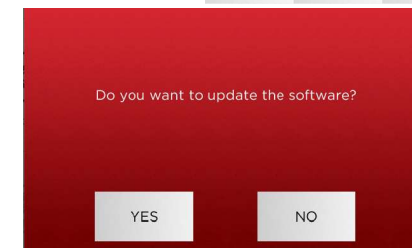
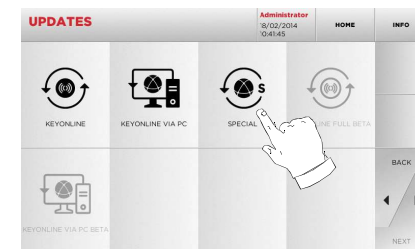
- Pressing the USB button, the programme will ask you to insert a USB flash drive containing the data for the update.

**Note:** The data for this kind of update can be provided **EXCLUSIVELY** by Keyline.



**It is not possible to update the machine with packages downloaded from "Keyonline" or from the Keyline server.**

- After inserting the flash drive, press YES to update the machine.
- To annul the operation, press NO.
- Follow the instructions to the end of the procedure.



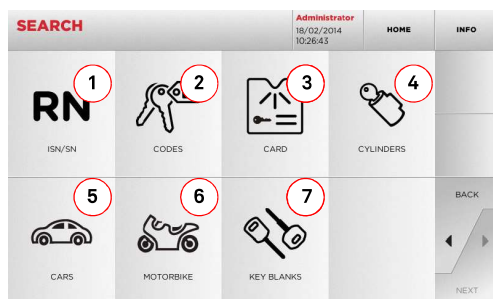
## KEY SEARCH

### 6.1.0 Search menu

This function is used when some details of the key to be duplicated are known, such as the manufacturer of the rough piece, the cylinder, the car or motorcycle brand, the indirect code or the card number. Once the machine's database has been searched, it is possible to input the key code manually, or obtain it through the decoding process.

How to access the page:

- From the MAIN menu, select:



Options displayed:

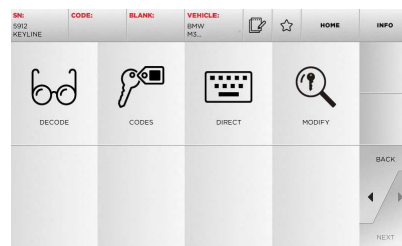
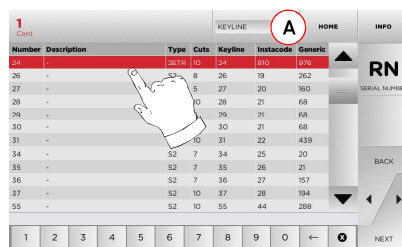
- This allows you to search and quickly select data via the RECORD number attributed by Keyline to a specific series, key and card.
- This allows you to search and select data via the original code (profile and series).
- This allows you to search and quickly select data through the card number, according to the Keyline and other manufacturers numbering system.
- This allows you to search and select data via the lock and/or cylinder manufacturer's brand.
- This allows you to search and select data via the car brand, model and year of manufacture.
- This allows you to search and select data via the motorcycle brand, model and year of manufacture.
- This allows you to search and select data via the Keyline key article and similar blank keys made by other manufacturers.

### 6.1.1 Search by record number

The "RECORD NUMBER" page makes it possible to search for the type of key to be duplicated by inputting the key's system number.

How to proceed:

- From the "SEARCH" page, select "RN".
- Select one of the options in the top drop-down menu (A).
- Input the Record number for the make / model / year / series / profile to be duplicated, then press "►".
- From the operating menu, choose one of the search or key modification options: DECODE, CODES, DIRECT and MODIFY.



Note: From now on, please refer to chapter 7 on page 16.

Note: The "☆" symbol makes it possible to save the selected key in the list of bookmarks. See paragraph 6.2.0.

- To go back to the previous page, press the "◀" key.

### 6.1.2 Search by code

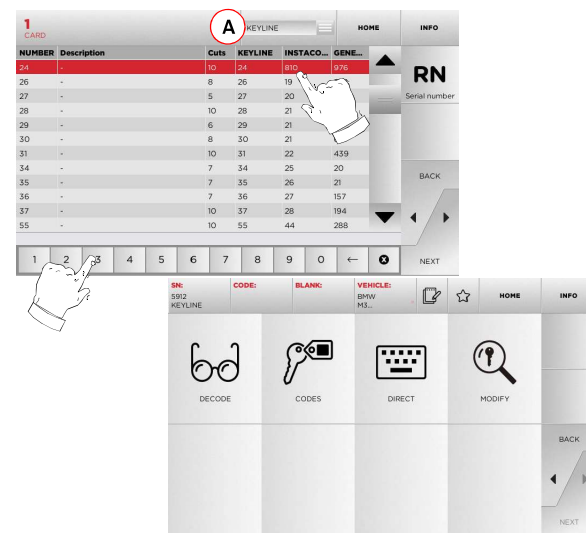
Note: This procedure is described in paragraph 5.1.2 on page 9

### 6.1.3 Search by card

This function makes it possible to obtain quick access to a specific lock system, by choosing the memorised key manufacturer's card.

How to proceed:

- From the "SEARCH" page, select "CARD".
- Select one of the options in the top drop-down menu (A).
- Type in the card number attributed to the key to be cut, then press "►".
- From the operating menu, choose one of the search or key modification options: DECODE, CODES, DIRECT and MODIFY.



Note: From now on, please refer to chapter 7 on page 16.

Note: The "☆" symbol makes it possible to save the selected key in the list of bookmarks. See paragraph 6.2.0.

- To go back to the previous page, press the "◀" key.

## KEY SEARCH

### 6.1.4 Search by cylinder brand

This function is used when you know the biting code of the key to be copied or if you wish to search for it using the decoding process. The menu makes it possible to search through the system's database as described below.

#### How to proceed:

- From the "SEARCH" page, select:
- Select one of the options in the top drop-down menu (A).
- Scroll the menu of available brands or enter the name and choose the required one (e.g.: ACURA).
- Press "▶" to go to the list of blank keys and choose the one most appropriate for the selected brand (e.g. 342), then press "▶".
- From the operating menu, choose one of the search or key modification options: DECODE, CODES, DIRECT and MODIFY.



Note: From now on, please refer to chapter 7 on page 16.

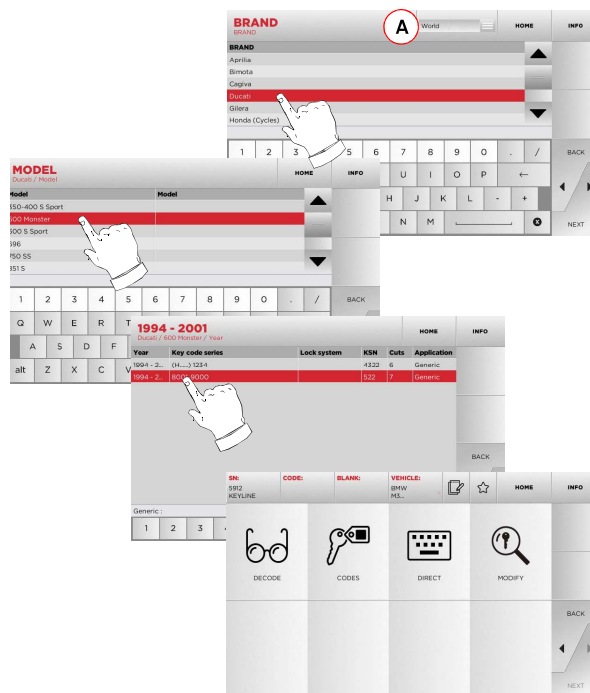
- To go back to the previous page, press the "◀" key.

### 6.1.5 Search by motorbike brand

The "MOTORBIKE" menu makes it possible to search and duplicate a key through a list of brands included in the database.

#### How to proceed:

- From the "SEARCH" page, select:
- Select one of the options in the top drop-down menu (A).
- Enter the brand or scroll the menu and select the required one (e.g.: DUCATI), then press "▶".
- Choose the motorbike model first, then the year of production, and press "▶".
- From the operating menu, choose one of the search or key modification options: DECODE, CODES, DIRECT and MODIFY.



Note: From now on, please refer to chapter 7 on page 16.

### 6.1.6 Search by car brand

Note: This procedure is described in paragraph 5.1.1 on page 9.

### 6.1.7 Search by article

Note: This procedure is described in paragraph 5.1.3 on page 10

### 6.2.0 Bookmarks list

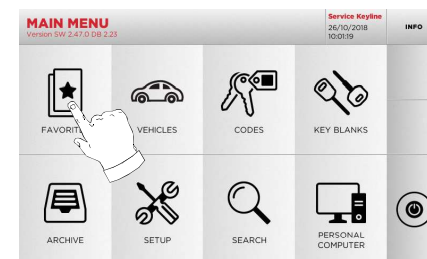
Every time a key is modified, irrespective of which database it comes from, it is possible to save the changes in a specific "favorite keys" database.

#### How to proceed:

- Press the button from "MODIFY" page after making the necessary changes.
- Input the name for the subsequent searches, then press "OK".
- Confirm that you want to save by pressing "YES" and go back to the "MODIFY" page.

The black icon shows that the key has been saved in the "FAVORITES" database.

Later, the user shall be able to look for the key by accessing the "FAVORITES" menu from the main menu:




Note: This function must not be confused with the saving of a key in the archive. The saving concerns all the information that characterise a key (bitting, cutting parameters, material, number of copies, etc.) for both keys found in a database (coded) and read keys. This list, instead, leads directly to a RN, that is to say, a technical card for cutting a key (and so the bitting and other data are not memorised).

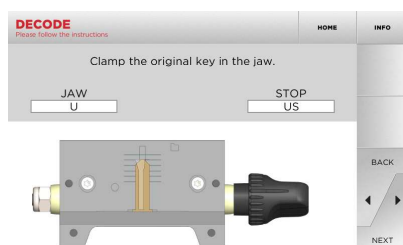
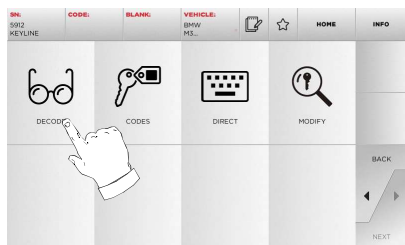
## MODIFY AND CUT

### 7.1.0 Decode

This function makes it possible to decode the key using the selected key system.

#### How to proceed:


- From the key search sub-menu, select “”.
- Insert the original key in the jaws and lock it in place.
- Then follow the instructions on screen until the end of the decoding process.

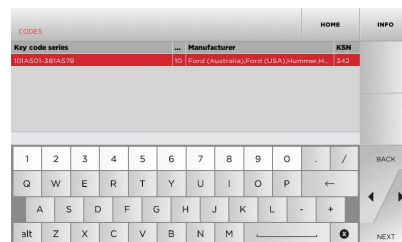
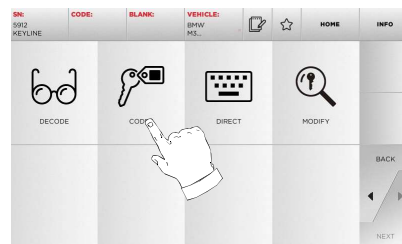


### 7.2.0 Code

This function makes it possible to search for a specific code contained in the data base and obtain the relevant coding.

#### How to proceed:


- From the key search sub-menu, select “”.
- Input the blind code.
- Then press ►” to go to the following screen, the key “CUTTING” one (for additional information, please refer to paragraph 7.5.0 on page 17).

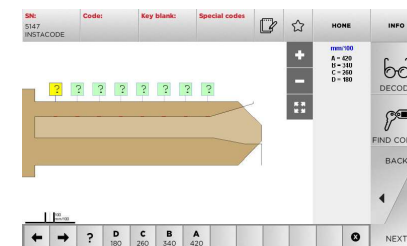
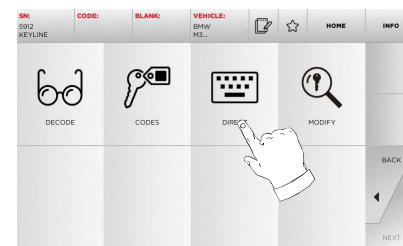


### 7.3.0 Direct

This function makes it possible to insert the biting code for the key directly.

#### How to proceed:

- From the key search sub-menu, select “”.
- Input a value for each cut that shall correspond to the biting code.
- Then press ►” to go to the following screen, the key “CUTTING” one (for additional information, please refer to paragraph 7.5.0 on page 17).



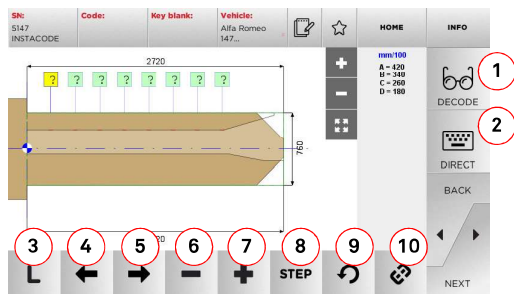
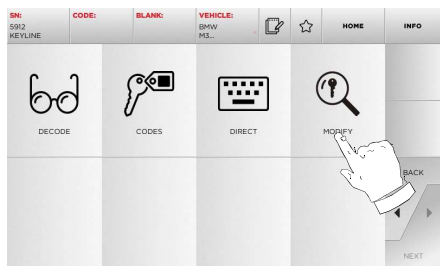
## MODIFY AND CUT

### 7.4.0 Modify menu

The MODIFY menu is used to modify the cut parameters for a key and it also makes it possible to personalise some characteristics of the key, according to the client's specific requirements.

#### How to proceed:

- From the key search sub-menu, select “**MODIFY**”.
- This displays the technical sheet for the selected article and makes it possible to change some of the key characteristics.



#### Options displayed:

1. With this button is possible to decode the key using the selected key system.
2. With this button is possible to insert the cuts directly.
3. With the Cut Type button is possible to select between the possible cut types for the selected key. For edge cut keys cut types are: Normal, Laser and Plane.
4. With the left arrow button is possible to scroll the spaces moving to left direction.

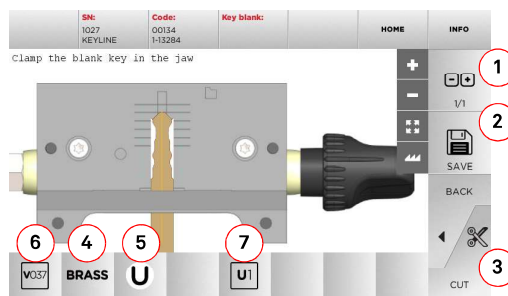
5. With the right arrow button is possible to scroll the spaces moving to right direction.
6. With the minus button is possible to decrement the depth of the highlighted tooth.
7. With the plus button is possible to increment the depth of the highlighted tooth.
8. This makes it possible to select the depth increase or decrease rate when the + or - buttons are pressed. The available options are: one STEP is either 0.1 mm or 0.01 mm.
9. With this button is possible to reset the modifications made on the selected tooth.
10. With this button is possible to modify simultaneously all the teeth.

- For further information select “**INFO**” from the display.

**Note:** The “**☆**” symbol makes it possible to save the selected key in the list of bookmarks. See paragraph 6.2.0.

### 7.5.0 Key cut menu

Once the key to be copied has been searched using the relevant functions in the database menu, the programme will direct the user to the CUT screen, that makes it possible to duplicate the desired key.



#### Options displayed:

1. With this button is possible to set the amount of copies that need to be cut.
2. With this button is possible to save the key.
3. Starts the key cutting process.

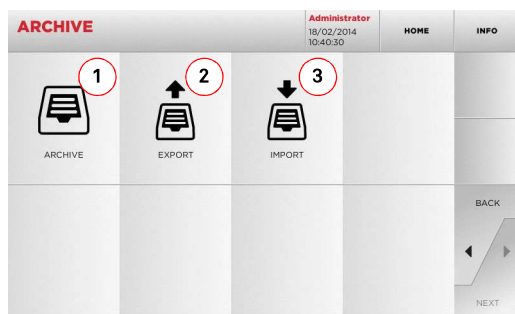
## ARCHIVE, PC AND USER MENU

### 8.1.0 Archive Menu

The ARCHIVE menu makes it possible to manage the user data and the database saved by the user during the key reading, decoding and modification phases. It is also possible to access the import and export functions from and to external supports (USB flash drive).

How to access the page:

- From the MAIN menu, select:



Options displayed:

- This function makes it possible to access the archive containing the keys identified during the search and decoding processes, so that they can be retrieved quickly every time the user needs them.
- This function makes it possible to export a file from the machine's database to a USB flash drive. The export and import functions allow the customer to exchange customised data between machines or create backup copies of the exported archive.
- This function makes it possible to import a file from a USB flash drive to the machine's database. Data imported from the USB flash drive shall be saved in the archive.

- For further information select “ **INFO** ” from the display.

### 8.2.0 Personal Computer Menu

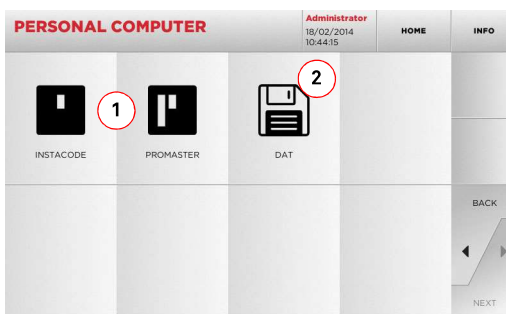
Through this menu it is possible to access the functions to interface **Gymkana 994** with queuing software that might reside in a remote PC or USB flash drive.

It is possible to import job queues containing several processes (JOBS). The JOBS, in turn, contain information for each key to be cut, such as: type of key, type of bitting, and number of copies to be cut.

The programme makes it possible to select and execute only one JOB at a time, until the queue is exhausted.

How to access the page:

- From the MAIN menu, select:



Options displayed:

- These menus manage and process job queues created with Instacode and Promaster key processing software and sent to the machine.
- This menu makes it possible to import, manage and process job queues saved in DAT format files.

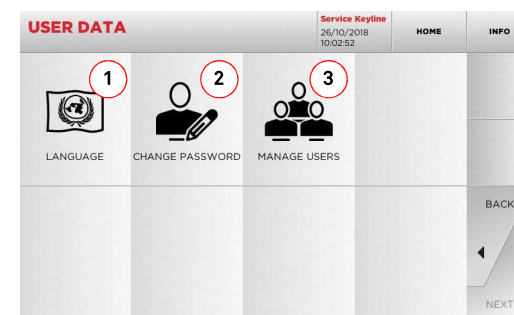
- For further information select “ **INFO** ” from the display.

### 8.3.0 User Menu

The USER menu makes it possible to manage the user data and the database saved by the user during the key reading, decoding and modification phases.

How to access the page:

- From the SETUP menu, select:



Options displayed:

- This allows you to change displayed language (refer to paragraph 4.3.0 on page 8).
- This allows you to change password to existing users.
- This allows you to manage users, add a new user, remove existing users and change information.

- For further information select “ **INFO** ” from the display.

Warning: **IMPORTANT!**



**Disconnect the power supply cord of the machine prior to any maintenance and repair operation, save when otherwise specified.**

**Maintenance operations must be performed by skilled technicians wearing the following PPE:**

- Protective gloves against mechanical hazards.
- Safety shoes
- Protective goggles.

**Always use original Keyline spare parts.**

### 9.1.0 General information

### 9.1.1 Type of Maintenance

#### Ordinary Maintenance

- Servicing operations that must be carried out periodically by the machine operator.
- The purpose of ordinary maintenance is guarantee regular functioning of the machine and a consistent quality of the product.
- The maintenance schedule may vary in relation to work or environmental conditions in the place of installation.

#### Complex Maintenance

- Complex maintenance consists of actions to be taken only when given conditions occur (break downs, failures, replacement of parts).
- Due to the complex nature of such actions and the special tools required, we recommend you should contact qualified personnel from or authorized by **Keyline S.p.A.**

### 9.2.0 Ordinary maintenance

We recommend inspecting the machine periodically and replace worn parts.

### 9.2.1 Cleaning the working area

At the end of each working day clean the machine removing scrap and burrs to ensure proper functioning of the machine and to prevent any damage to its parts. Use the supplied brush and/or an extraction fan.

Empty the shaving collection drawer every time that the work surface is cleaned or whenever it is full of shavings.



**Do not clean the machine with compressed air.**

### 9.2.2 Protective shield and console display cleaning

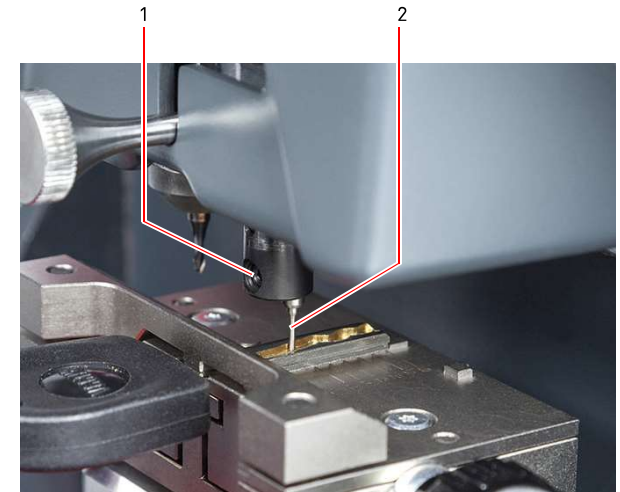
Top clean the clear protective shield and the console display use a microfibre cloth.

**Note: Do not use alcohol-based products or solvents!**

### 9.2.3 Tracer points replacement

**How to proceed:**

- Remove the tracer point grub screw (1).
- Remove the tracer point (2).
- Install the new tracer point, making certain that the groove is aligned with the grub screw hole.
- Replace and tighten the grub screw to fasten the tracer point.





### 9.3.0 Waste disposal

The disposal of waste generated by the machine shall be managed in compliance with the legislation in force in the user's country. In Europe, machine shop rejections are classified as special waste and are assimilated to metal wool when it comes to managing municipal solid waste (MSW).

Such waste must be disposed of according to the legislation in force in the user's country.

If machine shop rejections have been contaminated or contain toxic or harmful substances they are considered as toxic -harmful waste and disposed of accordingly in compliance with the legislation in force.



**The user is responsible for correct waste management.**

### 9.4.0 The WEEE directive

When disposal becomes necessary, the **Gymkana 994** appliance is to be considered as belonging to the WEEE category (Waste Electrical and Electronic Equipment).

**Keyline S.p.A.** has always taken great care to protect the environment and complies with the legislative decree on WEEE that has been in force since 13/08/2005. As a consequence, in accordance with the prescriptions of directive 2002/96/CE, this appliance cannot be disposed of as household waste (in compliance with the special symbol shown below).



- Whoever disposes of this appliance illegally or as household waste will be subject to the sanctions foreseen by current national legislation.
- According to the provisions of current national legislation, this appliance cannot be disposed of as household waste. Therefore, at the end of its lifecycle, after having carried out the operations that are necessary for correct disposal, the appliance must be taken to one of the differentiated waste collection centres for electrical and electronic waste from domestic households. Refer to the collection centre in your own town, which will guarantee the functionality, accessibility and suitability of the differentiated collection systems, so that the final holder and distributors can take the waste that they produce in their area to collection centres, free of charge.

### 9.4.1 Disposal of the packing material

The package containing the key cutting machine for transportation purposes is made of cardboard, nylon and polyurethane foam.

Dispose it in compliance with the law.