



HUDSON 6666HQT Fully Automatic Key Duplicator User Guide

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HUDSON

HUDSON 6666HQT Fully Automatic Key Duplicator



Product Information

Specifications

- **Product Name:** Automate™ Fully-Automatic Key Duplicator
- **Model Number:** 6666HQT
- **Cutter:** CW-42HQT (standard duplication)
- **Optional Cutter:** CW-41HQC (carbide cutter for longer life and cutting harder blanks)
- **Operating Hours:** Monday – Friday, 8:00AM – 3:30PM
- **Contact Numbers:** 800.323.3295 (HPC), 800.435.8960 (Hudson Lock Company) (USA & Canada)

Description

- Congratulations on your smart purchase of an HPC Automate™ (Model No. 6666HQT). With proper care, this machine will cut keys accurately for many years. The Automate™ duplicates most cylinder keys, many of the popular double-sided keys, and even the largest of keys like hotel/motel room keys.
- For durability, the cutter shaft rotates with sealed ball bearings, enabling the machine to maintain excellent accuracy with minimal care. The Automate™ is a workhorse – a fully automatic duplicator that is both sturdy and practical.

Usage Instructions

Key Insertion

The HPC Automate™ is very easy to use. Follow these steps to insert keys properly

1. Ensure that the 4-way jaws are in the correct position.
2. Use the standard tip gauge or the best/short tip gauge to calibrate the key's tip.
3. Seat the key flush with the back of the bottom jaw.

4. For standard keys, use typical shoulder gauging.
5. For different key styles, refer to the appropriate tip gauging method (typical tip gauging, best style tip gauging, easy-to-hold double-sided key tip gauging, hard-to-hold double-sided key tip gauging).

FAQ

- **Q: What is the model number of the key cutter?**

A: The model number of the key cutter is CW-42HQT for standard duplication. An optional carbide cutter (No. CW-41HQC) is available separately for longer cutter life and cutting harder blanks.

- **Q: How do I contact HPC for assistance?**

A: You can call HPC at 800.323.3295 or Hudson Lock Company at 800.435.8960 (USA & Canada) from Monday to Friday, 8:00AM – 3:30PM.

- **Q: What types of keys can the Automate™ duplicate?**

A: The Automate™ can duplicate most cylinder keys, popular double-sided keys, and even large keys like hotel/motel room keys.

- **Q: Does the machine require any maintenance?**

A: Yes, please read the entire manual and follow the preventive maintenance suggestions to help prolong the life of your key machine.

Automate™

Fully-Automatic Key Duplicator

No. 6666HQT

Exploded View & Parts List Inside

091416 36666-000-00

Congratulations on your smart purchase of an HPC Automate™

(Model No. 6666HQT). With proper care this machine will cut keys accurately for many years.

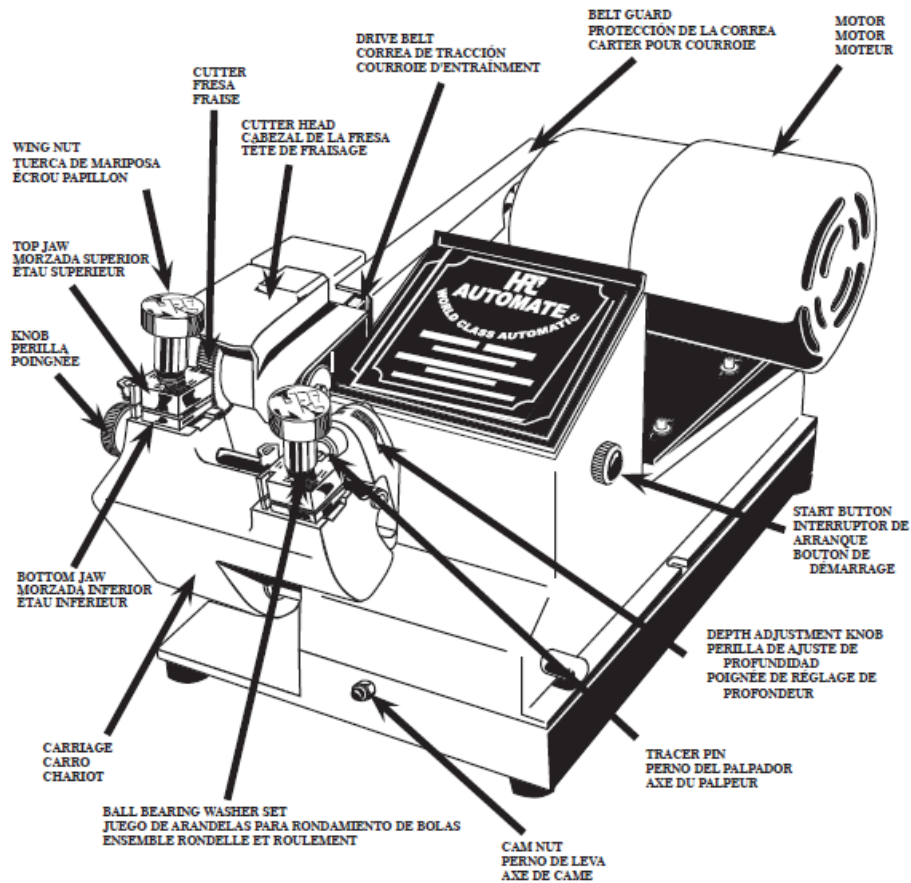
The Automate™ duplicates most cylinder keys, many of the popular double-sided keys, and even the largest of keys like hotel/motel room keys.

For durability the cutter shaft rotates with sealed ball bearings; this enables the machine to maintain excellent accuracy with minimal care.

The HPC Automate™ is very easy to use. The operator only needs to know how to insert keys properly in the jaws to run the machine successfully.

6666HQT Automate™

Parts Designation



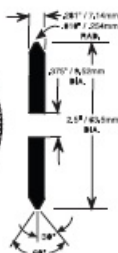
Packing Checklist



AUTOMATE®
INSTRUCTION MANUAL



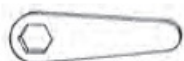
DOUBLE-ANGLE
TOOL STEEL CUTTER
No. CW-42HQT



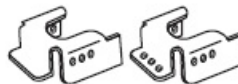
CUTTER/ADJUSTMENT WRENCH
No. WRENCH-1



ALLEN WRENCHES
No. WRENCH-2 5/64-inch
No. WRENCH-4 3/32-inch



CUTTER WRENCH
No. WRENCH-3

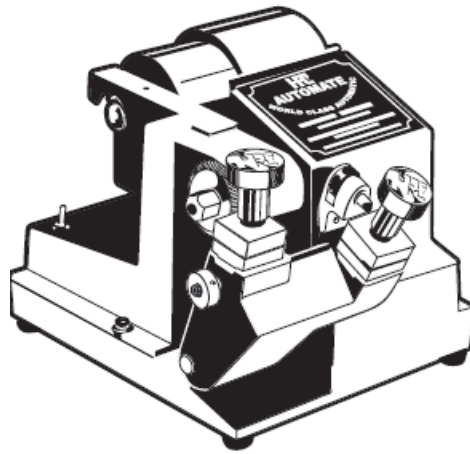


STANDARD TIP GAUGE
No. ST-4



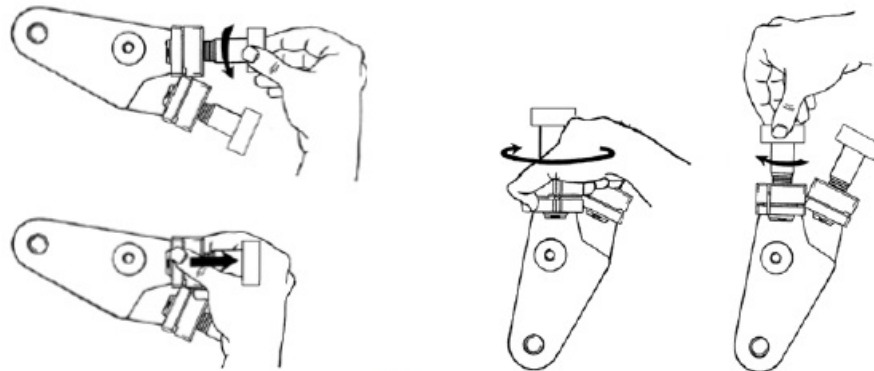
BEST TIP GAUGE
No. BT-4

Gauging and Holding Keys



Gauging and Holding Keys

- 4-way jaws are in position as shown.



1.1

- Standard tip gauge.



1.2a

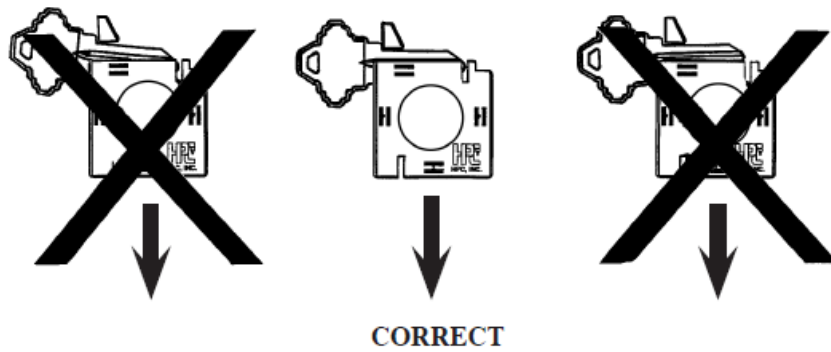
- Best/Short tip gauge.



1.2b

Gauging and Holding Keys

- Be sure to seat key flush with the back of the bottom jaw.



1.3

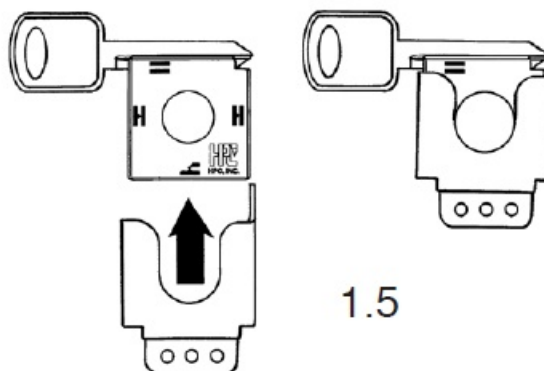
Bow is not flush with back of jaw. Tip is not flush with back of jaw.

- Typical shoulder gauging for standard keys.



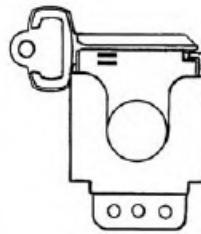
1.4

- Typical tip gauging.



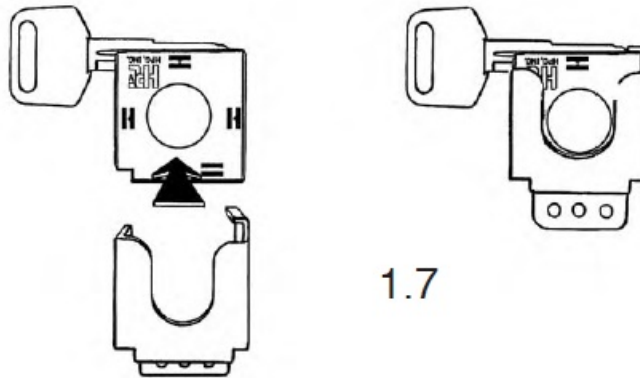
1.5

- Best style tip gauging.



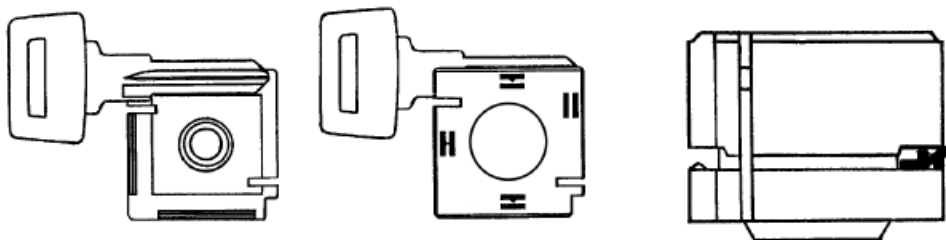
1.6

- Easy to-hold double sided key tip gauging.



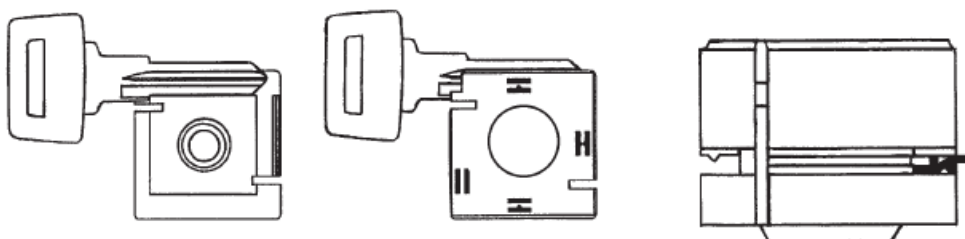
1.7

- Hard-to-hold double sided key tip gauging. (Top "V" jaw side shown.)



1.8

- Hard-to-hold double sided key tip gauging. (Bottom "V" jaw side shown.)



1.9

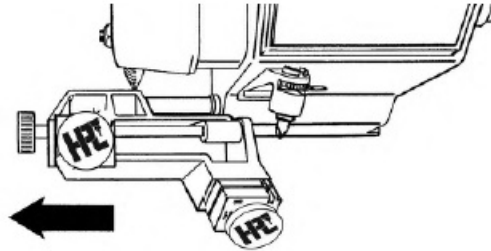
- Find out more about the entire line of HPC Key Machines,
- Software,
- Key Cabinets,
- Lock Picks,
- Car Opening Kits,

- Locksmithing Tools, and much more at
- www.hudsonlock.com

Cutting the Key

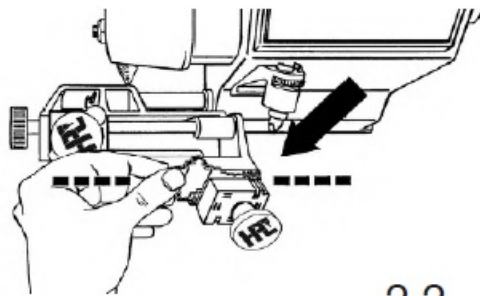
Cutting the Key

- Carriage should have returned to the “load/unload” position after the end of the last cycle. This position is all the way to the left and out of the way, for ease of insertion during gauging of keys.

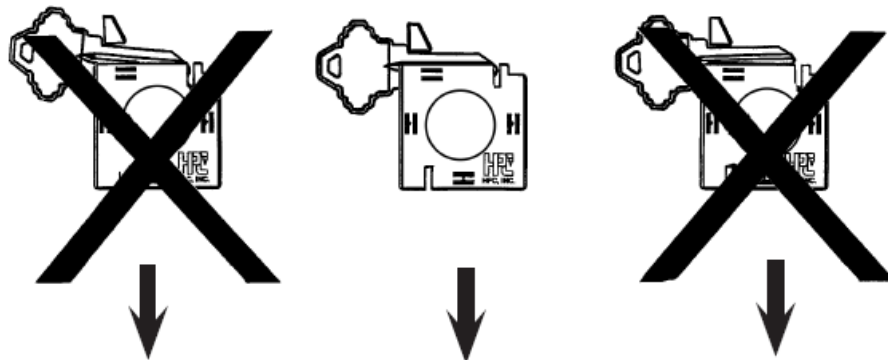


2.1

- Insert the key to be duplicated.



2.2

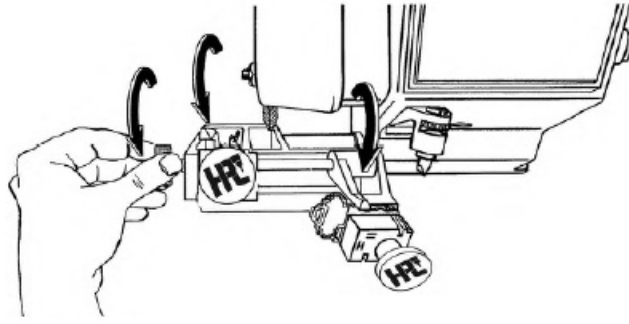


Bow is not flush with the back of the jaw.

CORRECT
2.3

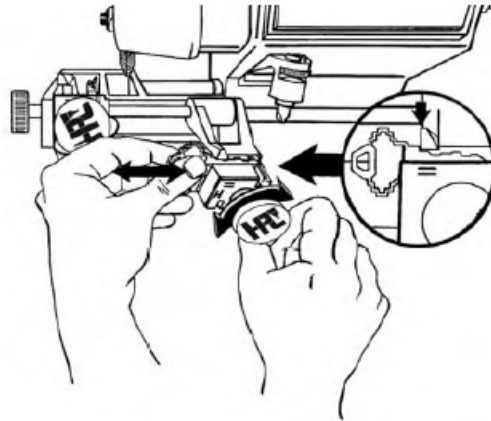
Tip is not flush with the back of the jaw.

- Be sure to seat key flush with the back of the jaw.
- Turn the knob toward you to move the shoulder gauges into position.



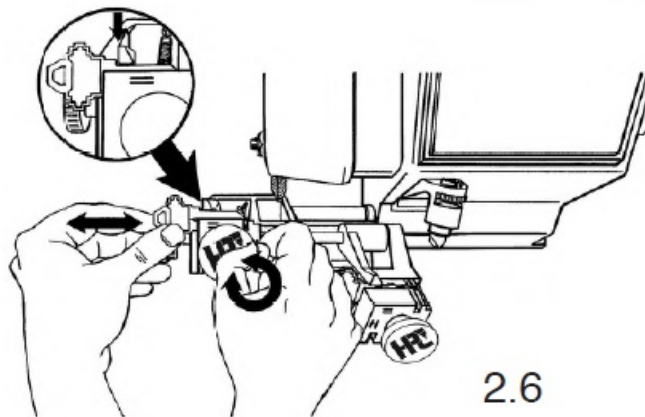
2.4

- Adjust the key shoulder, making it flush with the gauge as shown, and tighten.



2.5

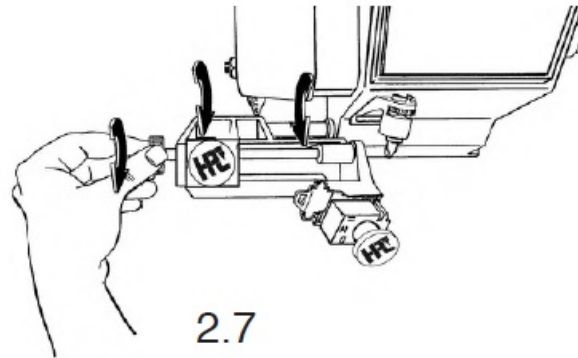
- Insert the key blank to be cut, also flush to gauge, and tighten.



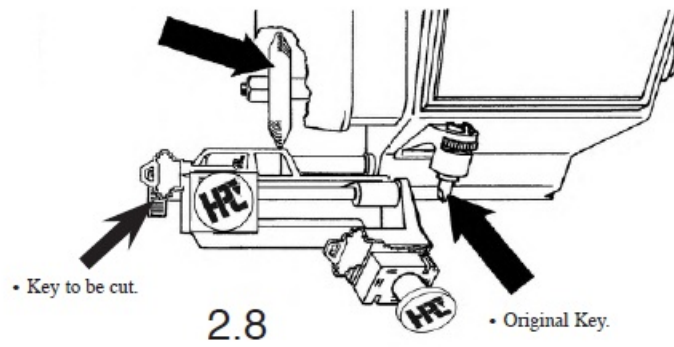
2.6

• **IMPORTANT!**

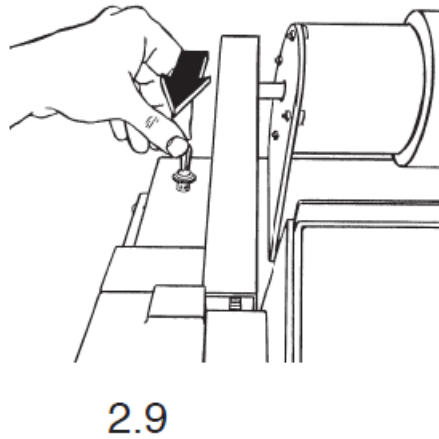
Turn the knob to move the gauges down before cutting.



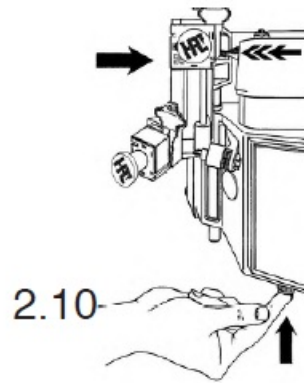
- Note the proper position of the keys before duplicating.



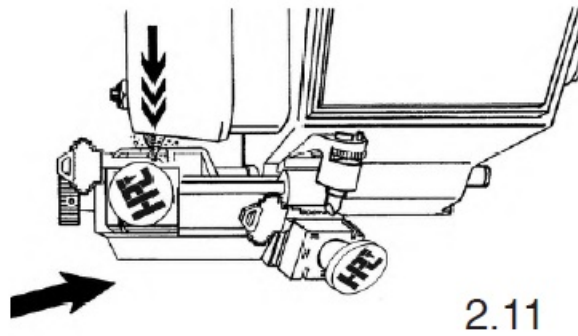
- Flip switch to turn on the machine.



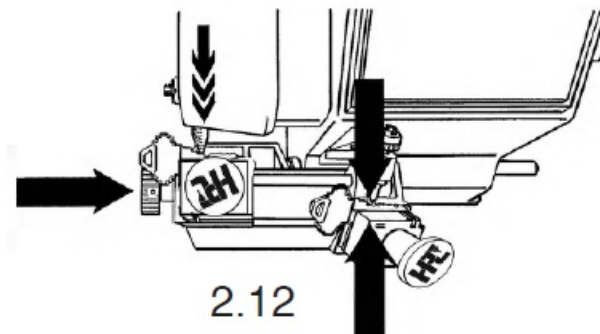
- Push button to start cycle.



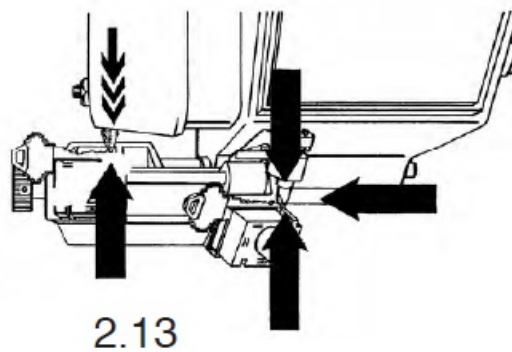
- Machine will begin to automatically duplicate key.



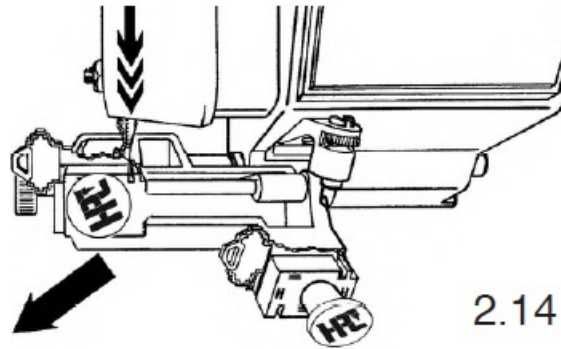
- When it has reached the shoulder of the key, it will return to cut a finishing, clean-up pass.



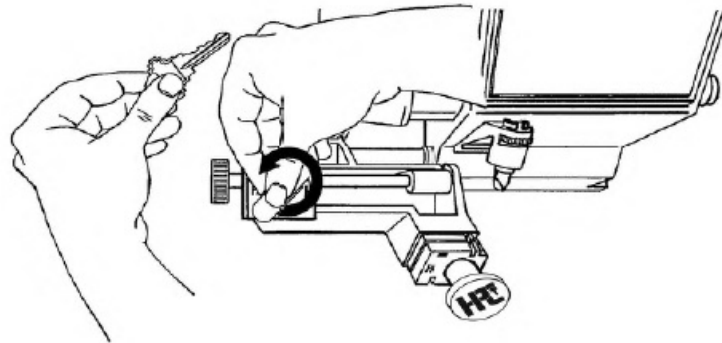
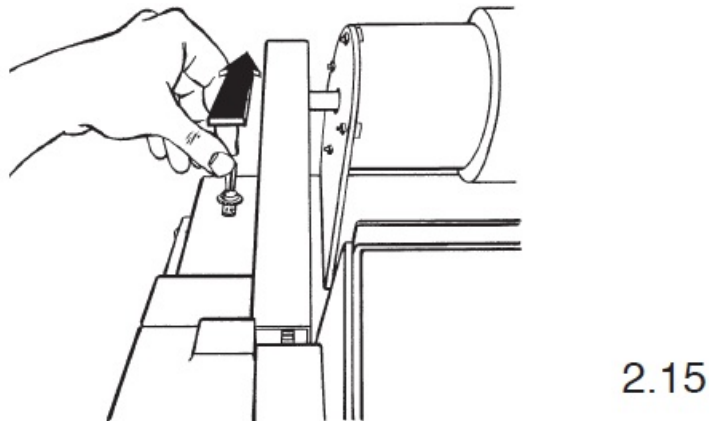
- After the last cut carriage will automatically move away from key.



- When done cutting, machine will automatically return to the “load/unload position.”



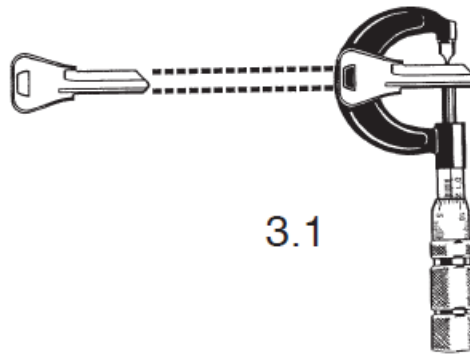
- Turn off machine.
- Unclamp the keys and brush the duplicate key when necessary.



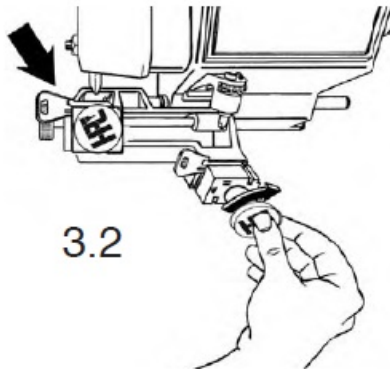
Depth Adjustment

Depth Adjustment

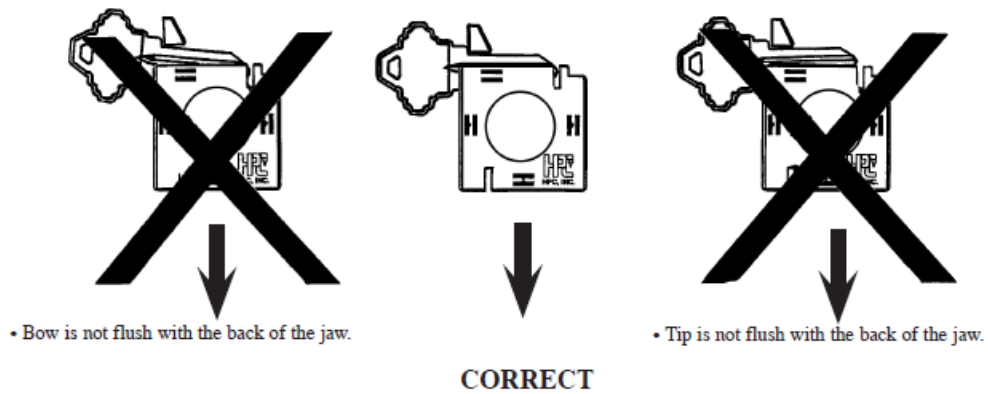
- Select two key blanks of the same width and thickness.



- Clamp both keys into clean jaws.

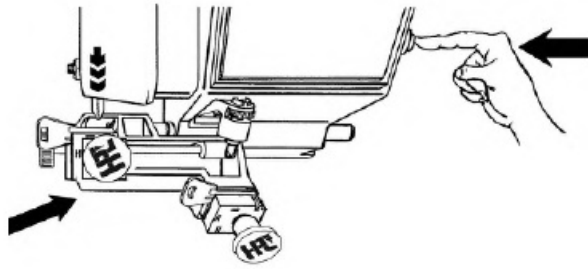


- Be sure to seat key flush with the back of the jaw.



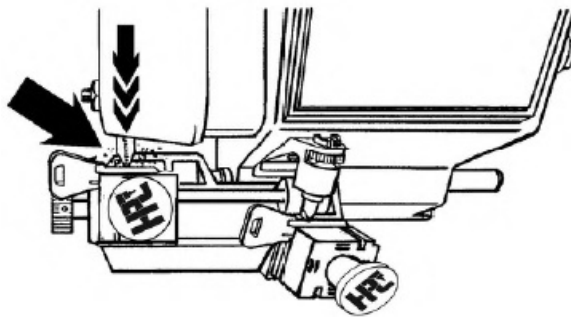
3.3

- Push button to start cycle.



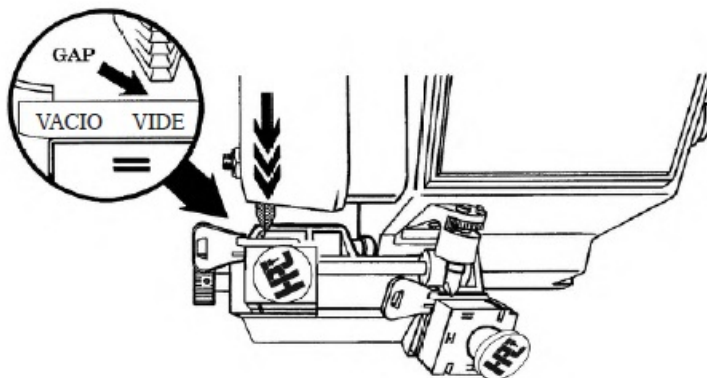
3.4

- Begin to cut and note the condition of the key. If the key is cut into more than .002", then the machine is cutting too deep.



3.5

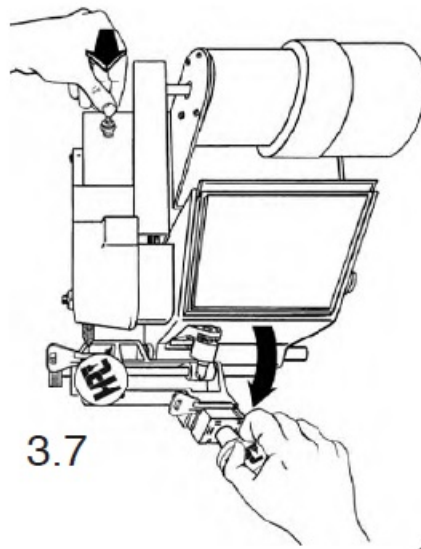
- If the cutter does not contact the key, then the machine is cutting too shallow.



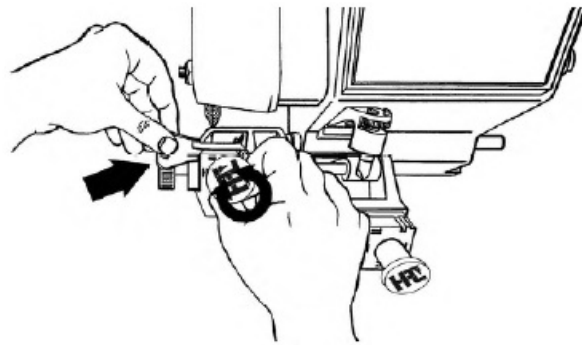
3.6

• **IMPORTANT!**

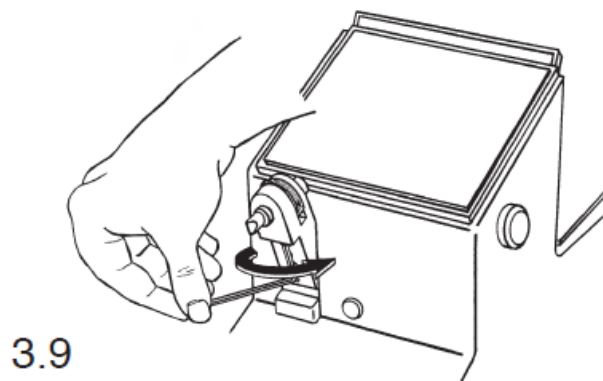
Turn off machine at the halfway point and pull back on carriage as shown.



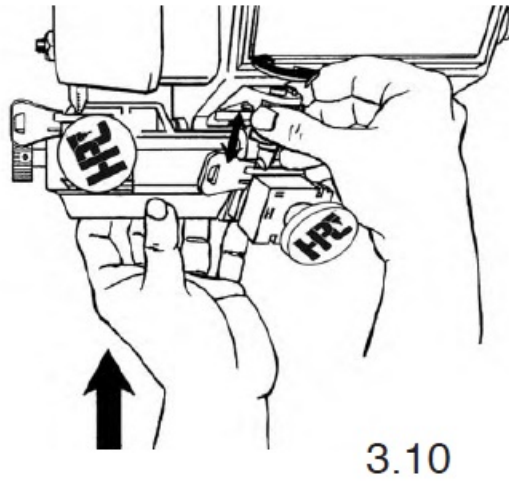
- Loosen and remove blank key from cutter side and replace with new blank key only if key had been cut.



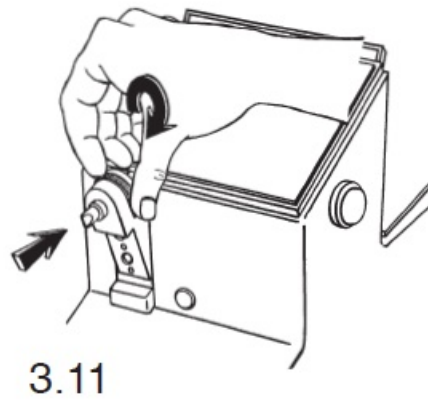
- Loosen dog screw to allow adjustment of tracer pin.



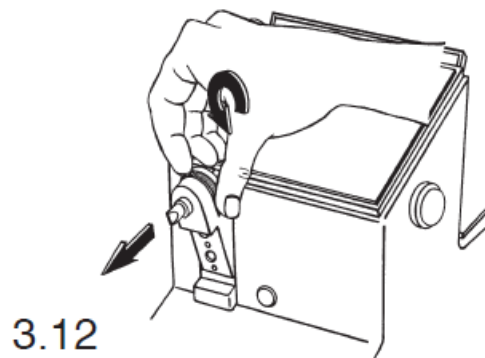
- With machine off, turn the depth adjustment knob while rotating the cutter with your other hand until the cutter just barely begins to scrape the key blank.



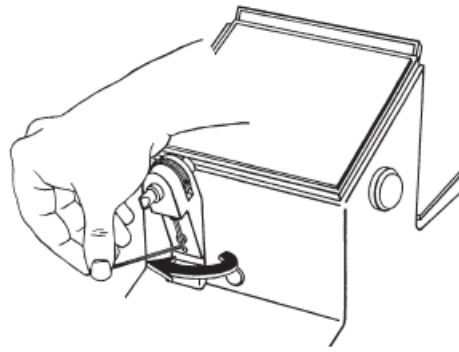
- To correct a cut that is too deep, turn the depth adjustment knob clockwise for a shallower cut.



- To correct a cut that is too shallow, turn the depth adjustment knob counterclockwise for a deeper cut.



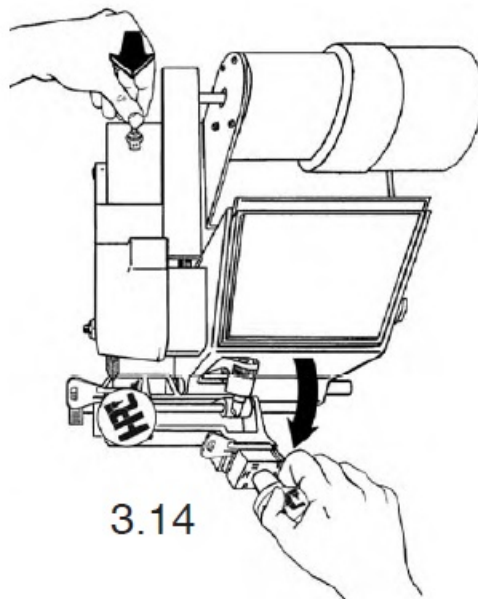
- If everything seems okay, tighten the set screw.



3.13

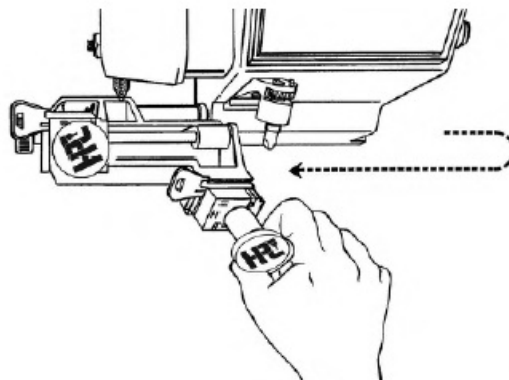
- **IMPORTANT!**

Pull back and hold carriage when turning machine back on. (Remember that the machine was stopped halfway through the cutting cycle.)



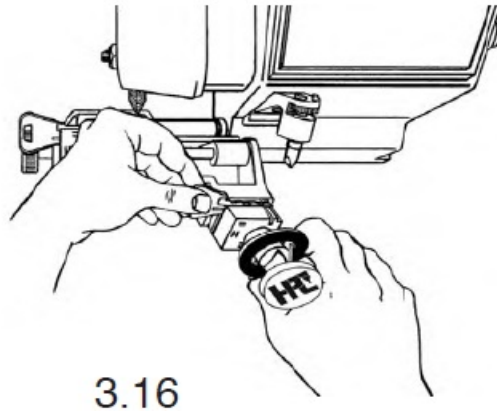
3.14

- While holding back on carriage as shown, allow machine to complete cycle and return to “load/unload” position..

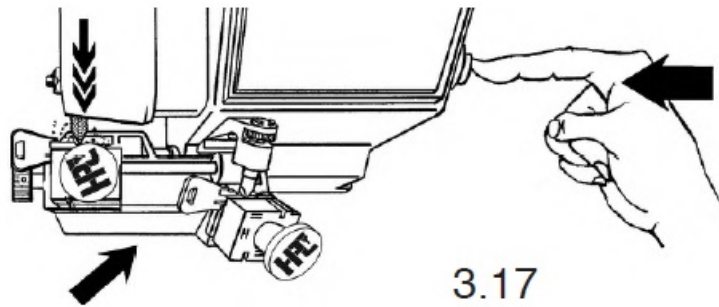


.15

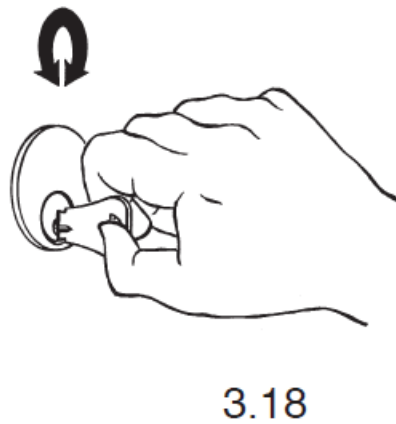
- Insert the test key to be duplicated into the tracer side.



- Make a test cut.



- Check the test key in the lock to see that the key works smoothly.

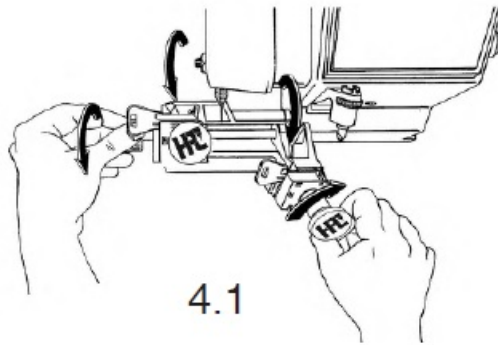


NOTE: If duplicate key turns “tight”, adjust the tracer slightly inward for deeper cut. If duplicate key “clicks”, adjust the tracer slightly outward for shallower cut.

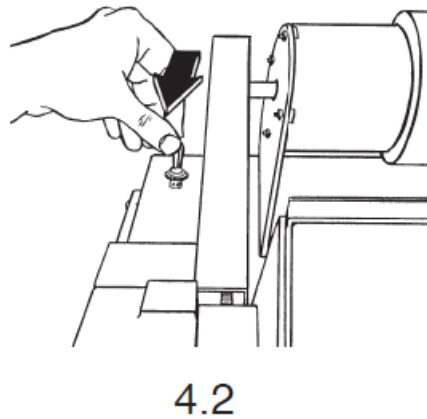
Space Adjustment

Space Adjustment

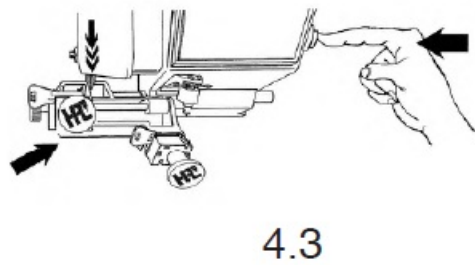
- Carefully install two identical key blanks to be used to adjust spacing.



- Turn on machine.

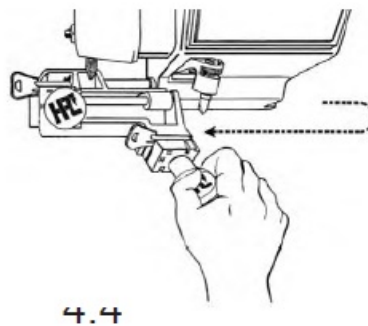


- Push button to begin cutting cycle.



- **IMPORTANT!**

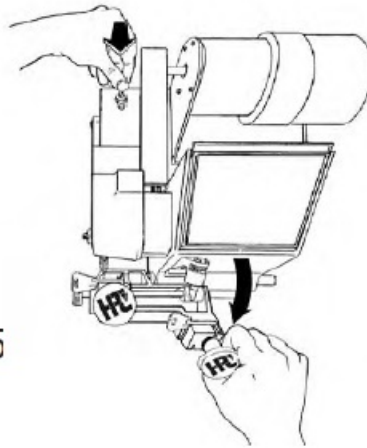
Hold back on carriage assembly as shown while machine cutting cycle starts and moves to halfway point.



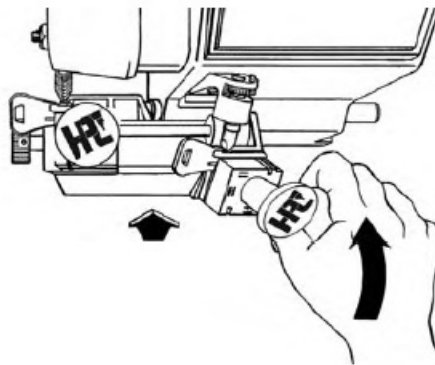
- **IMPORTANT!**

At the halfway point, turn off the machine.

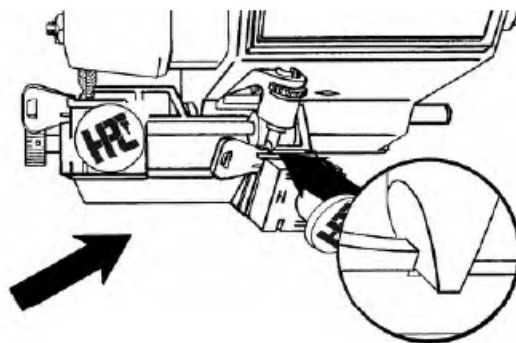
4.5



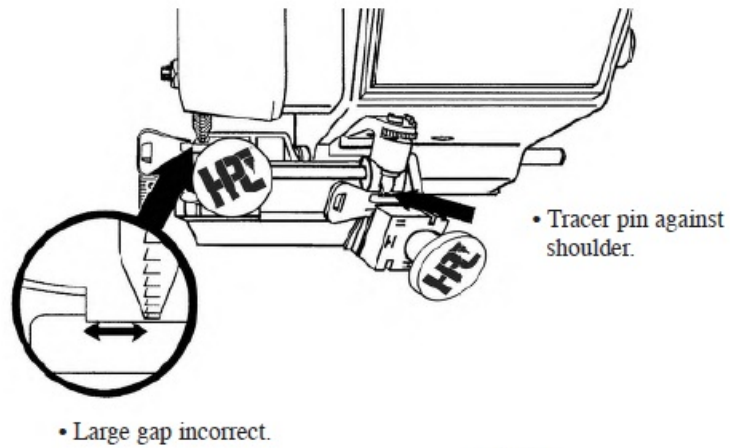
- With machine in off position, gently release carriage and check to be sure that the key shoulder engages the tracer pin. (You may flicker the ON/OFF switch to slowly reach this point.)



- Note position of tracer in relation to key shoulder.

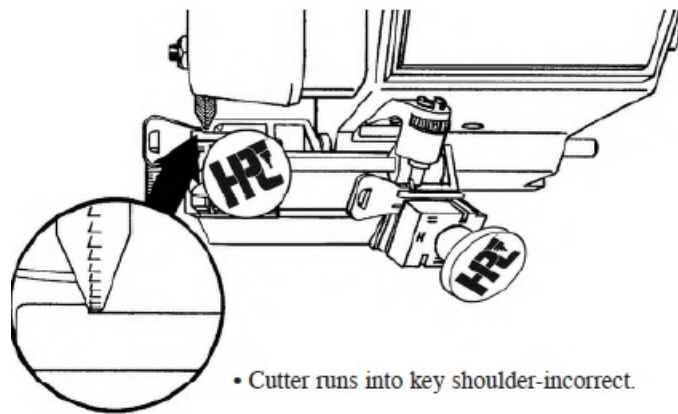


- Note the possible incorrect position of key to be cut.



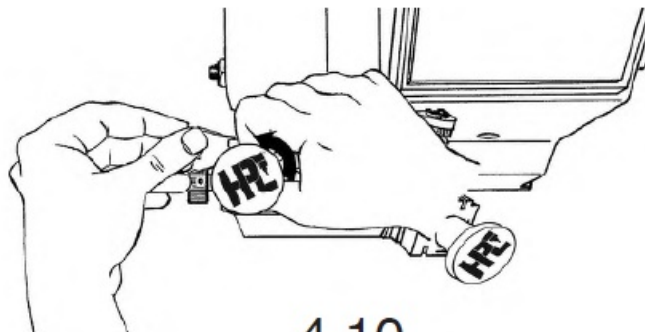
4.8

- Note the other possible incorrect position of key to be cut.



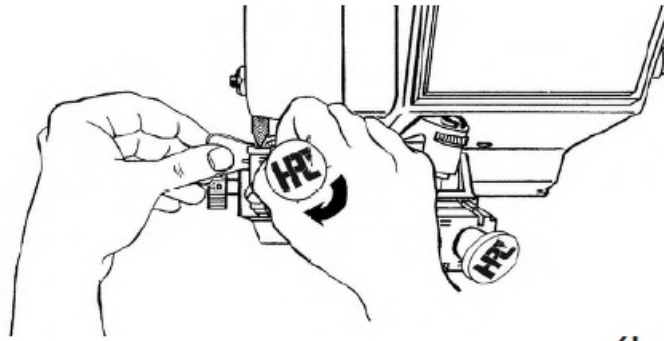
4.9

- Remove key from cutter side if shoulder had been cut into.



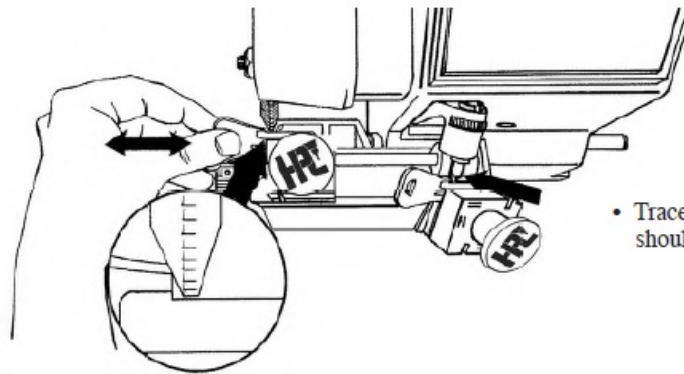
4.10

- Replace with new blank only if key had been cut into.



4.11

- Load new blank and place in proper position as shown.



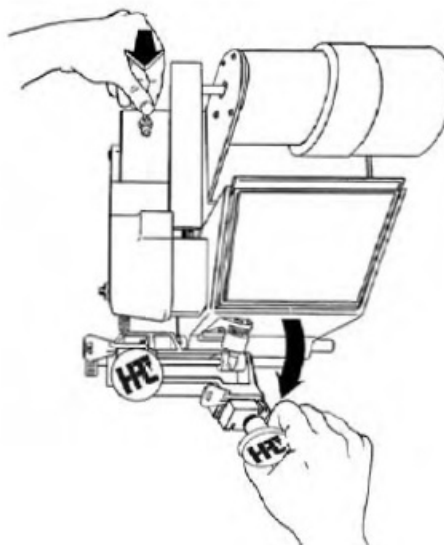
- Tracer pin against shoulder.

- .003 to .005 gap.

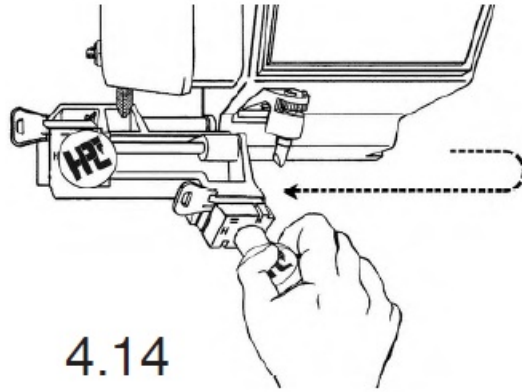
4.12

• **IMPORTANT!**

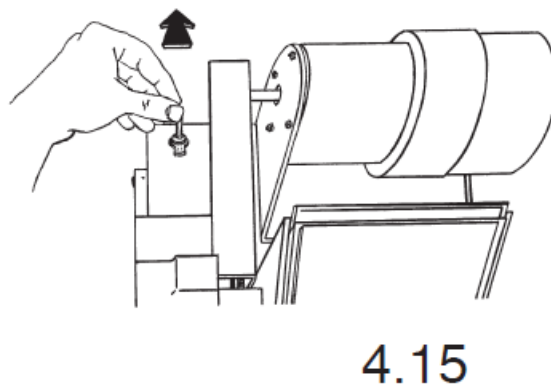
Leave keys in jaws loaded in proper position- then pull back on carriage assembly and turn on machine.



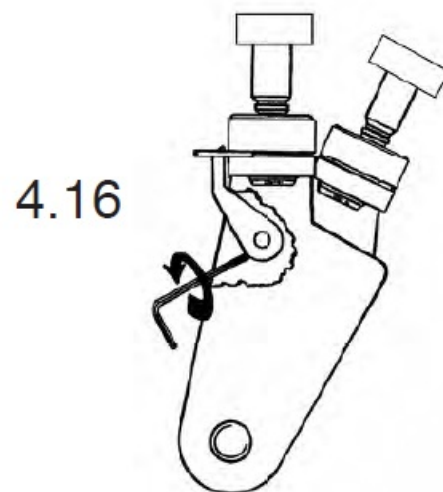
- Allow machine to cycle and return to “load/unload” position.



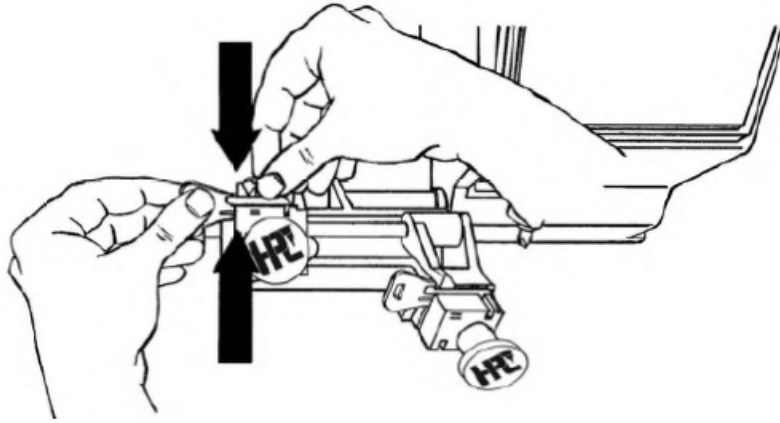
- Turn off machine.



- Loosen cutter side shoulder gauge by turning set screw as shown.



- Do not move key, but, rather, move gauge to proper position against key shoulder.

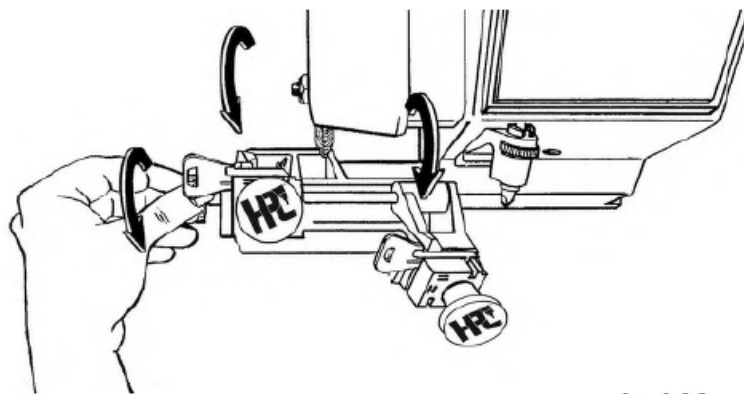


- With gauge in proper position, tighten set screw.



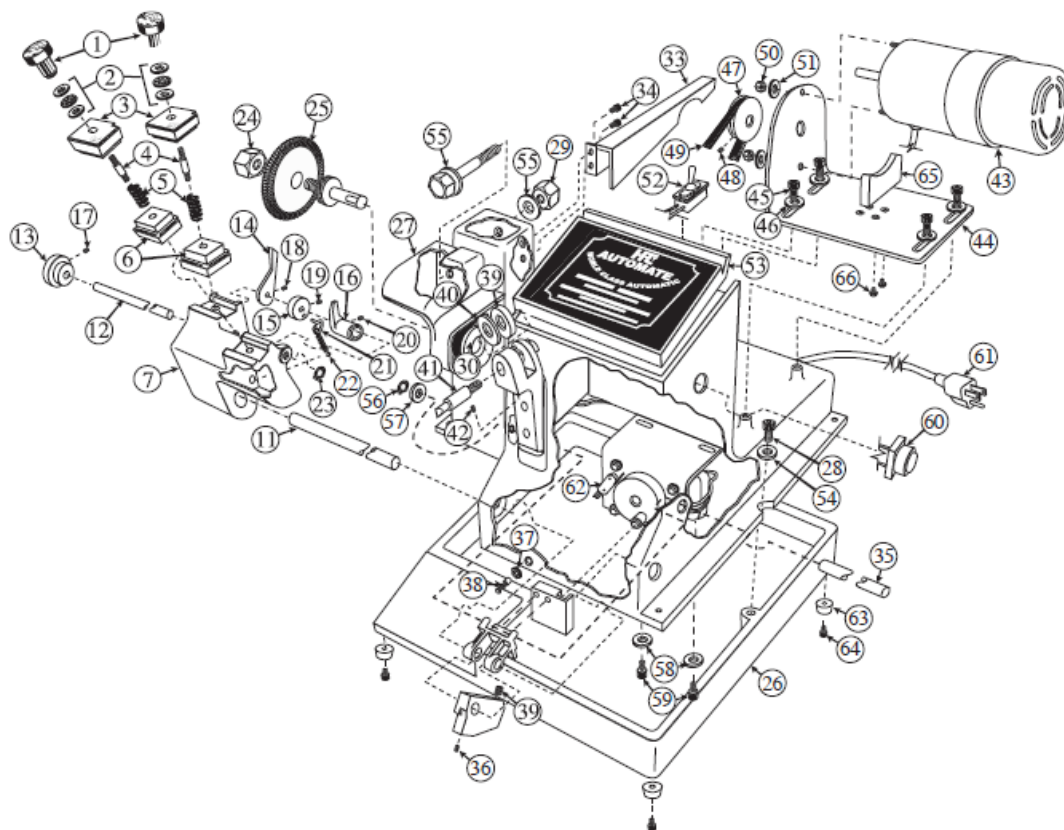
4.18

- Reload new key blanks and repeat procedure to verify that gauges have been set properly.



1.1.10

Exploded View And Parts List, Preventive Maintenance, Warranty and Service Information



#	Description	Stock #	#	Description	Stock #
1.	Easy Grip Wing Nut	EGN-1	36.	Set Screw	9100-11
2.	Ball Bearing Washers	BBW-2	37.	Hex Nut	CM-1375
3.	Top Jaw-Key Vise	TJAW-4S	38.	Set Screw	CM-1376
4.	Key Vise Stud	STUD-4	39.	Depth Adjustment Knob	CM-1275-1
5.	Spring	9100-13	40.	Locator Block	CM-1266-1
6.	Bottom Jaw-Key Vise	BJAW-4S	41.	Tracer Pin	CM-1371
7.	Pivot Arm	CM-1251F4	42.	Set Screw	CM-1390
10.	Pivot Arm Handle	CM-1283	43.	Motor (110 V)	CM-1080MA
11.	Pivot Arm Shaft	CM-1267MAO	44.	Motor Bracket	CM-1040MA
12.	Key Gauge Shaft	CM-1269-1	45.	Cap Screw	CM-50167
13.	Knob-Knurled	CM-1256	46.	Washer	CM-50167-1
14.	Key Positioner (left side)	CM-1260-1	47.	Motor Pulley	CM-1060MA
15.	Cam	CM-1277	48.	Spring Washer	CM-1286
16.	Key Positioner (right side)	CM-1261-1	49.	Belt	CM-1083MA
17.	Set Screw	CM-50139	50.	Hex Nut	CM-50148
18.	Set Screw	CM-50139	51.	Washer	CM-50149
19.	Set Screw	CM-50139	52A.	AC Switch	CM-1099MA
20.	Set Screw	CM-50139	53.	Nameplate	N/A
21.	Spring Hook	CM-1252MAO	54.	Cap Screw	9100-28
22.	Extension Spring	CM-1263MAO	56.	Snap-Ring	CM-50117
23.	Retaining Ring	TRU-1	57.	Washer	CM-50100
24.	Cutter Nut	CM-1039MA	58.	Washer	9100-26
25.	Cutter	CW-42HQT	59.	Screw	CM-1377
26.	Base	CM-1255MAO	60.	Push Button Switch	CM-203R
27.	Cutter Head Assembly	CM-1259F4	61.	Power Cord	CM-1294MAO
28.	Screw	CM-50176	62.	Micro Switch	CM-1284A
29.	Hex Nut	CM-50157	63.	Rubber Foot	CM-50133MA
30.	Pulley Cutter Head	CM-1059	64.	Cap Screw	CM-50134
33.	Belt Guard	CM-1014MA	65.	Motor Support	CM-50186
34.	Cap Screw	CM-50158	66.	Motor Support Screws	CM-50188
35.	Spring	CM-1289			

LUBRICATION, PREVENTIVE MAINTENANCE, WARRANTY and REPAIRS

- WARRANTY** – The machine is fully warranted for 90 days from the date of purchase, against factory defects in material and workmanship. Mail the warranty card and a copy of your invoice to HPC immediately to validate your warranty. Should your machine require factory repairs, please contact the HPC Service Center.

During the 90 day warranty period, you will be billed for the handling and shipping only

2. **BEARINGS and SLIDING SURFACES** – These are to be given a light coat of a light grease at least every six months.
3. **EXPOSED STEEL SURFACES** – All remaining exposed steel shafts, etc., should be sprayed with WD-40 or equivalent light oil every six months. Wipe off any excess.
4. **CLEANING** – Remove all brass chips, dirt, and grit from the surface of your machine daily with a soft bristle brush. Take particular care in keeping the key vise jaw area clean and free of all residue build-up.
5. **CUTTER SHAFT AREA** – The bearings used are “OIL-LITE” and require no additional lubrication.

HPC SERVICE CENTER

If your HPC Key Machine should require service, please note the following information

- **HOURS:** The HPC Service Center answers questions involving key machine repair and replacement parts Monday through Friday from 8:00 am to 3:30 pm .
Please call 800-323-3295 (HPC) or 800-434-8960 (Hudson Lock Company) from the U.S. and Canada.
- **REPAIRS:** We recommend the replacement of cutters, brushes and external parts, the preventive maintenance and recalibration (as outlined in this manual) be the only repairs or adjustments that are done by the user. Internal parts and mechanisms should be factory-repaired only. Additional repair charges may be incurred by attempting to make these types of repairs by yourself.
- **FACTORY SERVICE:** If you need to send your HPC key machine in for repair, first call the HPC Service Center to obtain a Repair Order number, then follow these instructions:
Include a letter explaining the problem you are having, as well as any other work you want done on the machine. Make sure your business name, address and phone number, as well as the name of the contact person are on the letter.
Your machine should be equipped with an HPC cutter when it is sent in for repairs. If you are sending in a Blitz™ or CodeMax™ machine also include the Black Horseshoe Tip Stop to insure proper tip gauge calibration. Please do not send in any other accessories (such as other cutters and code cards).
Pack the machine securely in a box strong enough to prevent damage during shipping (preferably the original box).
The Repair Order Number should be marked on the outside of the box.
All machines must be shipped prepaid. Collect shipments will not be accepted.
- **REPAIR CHARGES & ESTIMATES:** Upon receipt and evaluation of your machine our technicians will provide a written estimate (by fax) of the repair charges. Some problems may be detected only while the repair work is being done. If after informing you of the repair estimate it becomes apparent that the cost will be higher, you will be notified of the additional charges before any additional work is done.
- **REPLACEMENT PARTS:** Key machine parts can be purchased through an Authorized HPC Distributor or directly from the HPC Service Center. When ordering parts over the phone, please have the part numbers and descriptions ready to expedite the ordering process. A parts listing and an exploded view drawing is included in this manual. If the parts are needed urgently, express processing is available at an additional charge.
PAYMENT: Payment for parts and repair is required at the time of repair and before the parts are shipped. We accept payment by credit card (Visa, Mastercard or Discover) or by check. Repaired machines and parts can also be sent C.O.D. with an extra charge. If you wish to have your Authorized HPC Distributor billed for the parts or repairs, the distributor must call us with approval of the billing and provide a purchase order number for the parts or work being done, before the machine is repaired or parts are shipped.

Unless otherwise specified, key machines that are not under warranty will be shipped C.O.D. with an extra charge after the repairs have been made.

- **LOANER MACHINES:** Sorry, but we do not have loaner machines available.

Hudson Lock, LLC 81 Apsley Street Hudson, MA 01749

1-800-434-8960

1-800-323-3295


fax: 978.562.9859

sales@hudsonlock.com



- Find out more about the entire line of HPC Key Machines,
- Software,
- Key Cabinets,
- Lock Picks, Car Opening Kits,
- Locksmithing Tools, and much more at:
- www.hudsonlock.com

Documents / Resources

	<p>HUDSON 6666HQT Fully Automatic Key Duplicator [pdf] User Guide 6666HQT Fully Automatic Key Duplicator, 6666HQT, Fully Automatic Key Duplicator, Automatic Key Duplicator, Key Duplicator, Duplicator</p>
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References

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- [User Manual](#)

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