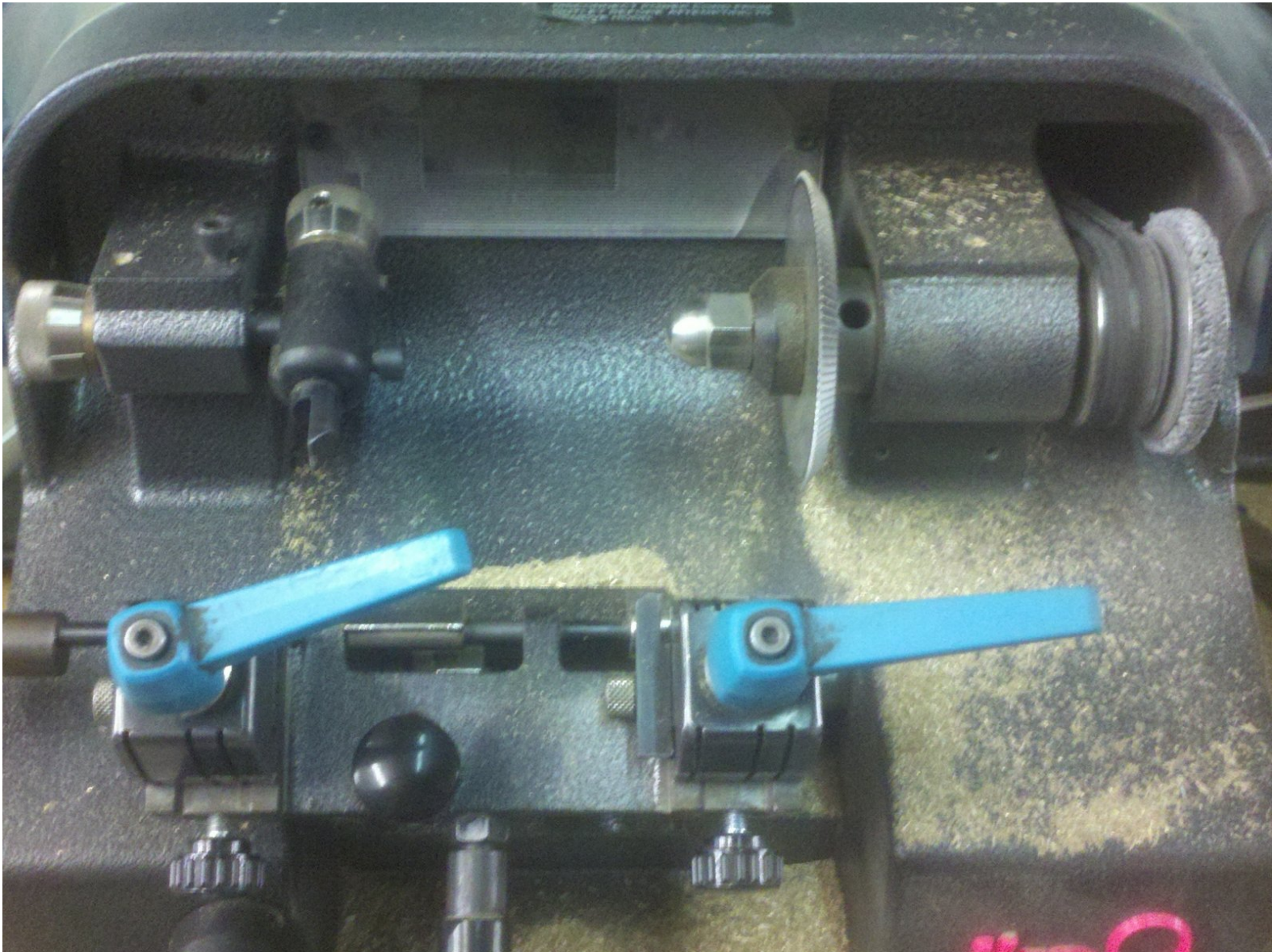




Ilco Orion Key Machine deburring wheel replacement

Keep the burrs off your freshly cut keys by replacing - what else? - the deburring wheel!

Written By: Jerry Orr



INTRODUCTION

This is a semi-automatic key duplicating machine – meaning operation requires the user to manually engage the carriage while using a lever to pass it along the cutting guide (and cutter). The deburring wheel can be operated by simply engaging (lifting up) the carriage and leaving it in place.

As its name implies, the deburring wheel helps smooth away any burrs, or sharp edges, from a freshly cut key. With frequent usage, this part will need replacing. This guide will demonstrate how to do just that!



TOOLS:

- [Macro Bit Set](#) (1)
- 6mm Allen Wrench



PARTS:

- [KD50A-102B Nylon Brush](#) (1)

Step 1 — deburring wheel



- As you can see, the deburring wheel on this machine is quite worn down. Time to replace!

Step 2



- Using an M6 allen wrench (circled in red), remove the old wheel.
- ⓘ Use another allen wrench, strategically placed in a hole next to the cutting wheel, to provide torque in the clockwise direction. The size of the wrench does not matter, so long as it fits reasonably within the hole. This is to prevent the whole assembly from turning while loosening the bolt that holds the wheel in place.

Step 3



- Add washers, as necessary, and replace the wheel.

To reassemble your device, follow these instructions in reverse order.