



Instruction Sheet

KKT316 KEYWAY CUTTER

IMPORTANT: RECEIVING INSTRUCTIONS: Visually inspect all components for shipping damage. If any shipping damage is found, notify carrier at once.

Shipping damage is NOT covered by warranty. The carrier is responsible for all repair or replacement costs resulting from damage in shipment.

SAFETY FIRST

IMPORTANT—USER SAFETY AND PROTECTION: In setting up systems, take care to select the proper components and design to ensure appropriate integration with your existing operations and equipment. Observe all safety measures to avoid the risk of personal injury and damage to property and equipment through improper usage.

GB ELECTRICAL CANNOT BE RESPONSIBLE FOR DAMAGE OR INJURY CAUSED BY UNSAFE USE, MAINTENANCE OR APPLICATION OF ITS PRODUCTS. Please contact GB's technical service department for assistance if you are in doubt as to the proper safety precautions essential to designing and setting up your particular application.

WARNING

To prevent injury, keep hands away from punches, dies and keyway cutting tools.

To avoid equipment damage and personal injury, do not use the keyway cutting tool on glass, plastic or wood. These materials could shatter and produce splinters which could cause injuries.

NOTE: To ensure smooth assembly, keep all threads clean and lightly oiled.

CAUTION

When using the keyway cutter with a hydraulic cylinder, be sure the cutting tool is fully threaded into the cylinder pull rod to avoid thread damage.

The keyway cutting tool is designed for use with a 1" socket drive or a hydraulic knockout cylinder. Do not use open end wrenches, pliers or vise grip type tools which can slip off the nut and cause damage to the nut drive or personal injury.

DESCRIPTION

Keyway cutter tools are designed to punch a $\frac{3}{16}$ " slot in steel panels up to 10-gauge. The cutter blade is $\frac{3}{16}$ " x $\frac{3}{4}$ " long, SAE 01 tool steel. A pilot shoulder on the die surface is $1\frac{1}{32}$ " diameter and fits holes produced by a $1\frac{1}{32}$ " knockout punch (KOM1732). The cutter tool can be hand operated or attached to a hydraulic knockout cylinder.



Operation

Prior to using the keyway cutter, a 1 $\frac{1}{32}$ " hole must be made for the switch or component mounting (KOM1732).

Keyway Cutter Using Hydraulic Knockout Cylinder

1. Remove the punch and die from the punch cylinder. Remove the cylinder pull stud.
2. Remove the large jam nut from the keyway cutter.
3. Thread the tool into the cylinder pull rod until the cutter die rests against the cylinder.
4. Insert the cutter tool into the 1 $\frac{1}{32}$ " panel opening until the pilot shoulder fits into the hole and the die is against the panel (Figure 1).

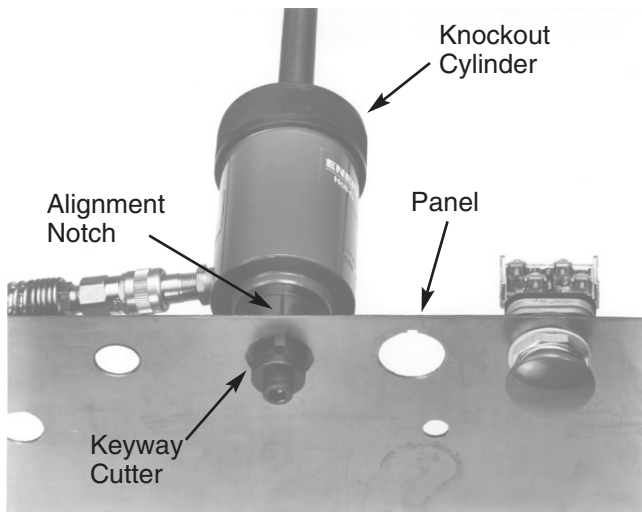


Figure 1

5. Turn the cutting tool until the alignment notch is located where the keyway is desired.
6. Activate the hydraulic pump until the cylinder pulls the cutter blade through the panel material.

Keyway Cutter with 1" Socket Wrench

1. Loosen the cutter jam nut, 2 or 3 turns. Insert the cutting tool into the 1 $\frac{1}{32}$ " panel opening until the pilot shoulder extends into the hole and the die rests against the panel. (Figure 2)

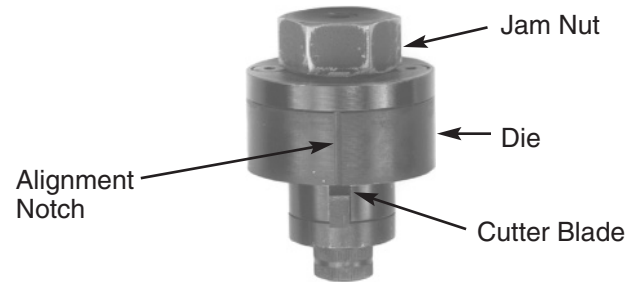


Figure 2

2. Hand tighten the jam nut to draw the cutter blade against the panel. Position the alignment notch at the location where the keyway is required.
3. Install a 1" socket and handle over the jam nut. Turn the handle until the cutter blade makes a clean cut through the panel. (Figure 3)

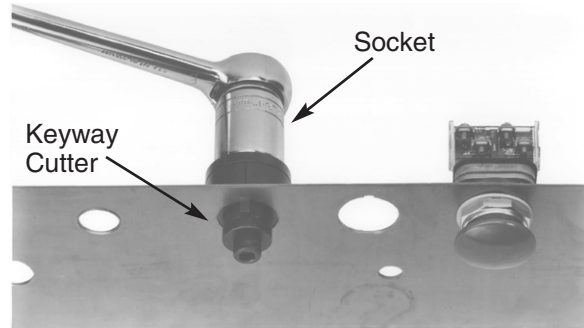


Figure 3

Maintenance

1. Keep all threads clean and lightly oiled to prevent rust and enable smooth operation.
2. If keyway cutting blade becomes dull or damaged, replace it immediately.
3. Keyway cutter replacement parts are available from your closest GB Service Center.

REPAIR AND SERVICE INSTRUCTIONS: For repair service and parts contact your nearest GB ELECTRICAL Service Center. The Service Center will provide complete and prompt service on all GB ELECTRICAL products.

PARTS AND SERVICE: For quality workmanship and genuine GB ELECTRICAL parts, select an Authorized GB Service Center for your repair needs. Only repairs performed by an Authorized Service Center displaying the official GB Authorized sign are backed with full factory warranty. Contact GB Electrical (414) 352-4160 for the name of the nearest GB Authorized Service Center.

WARRANTY: GB ELECTRICAL, INC. warrants its products against defects in workmanship and materials for 1 year from date of delivery to user. Chain is not warranted. Warranty does not cover ordinary wear and tear, abuse, misuse, overloading, altered products or use of improper fluid.

WARRANTY RETURN PROCEDURE: When question of warranty claim arises, send the unit to the nearest GB Authorized Service Center for inspection, transportation prepaid. Furnish evidence of purchase date. If the claim comes under the terms of our warranty the Authorized Service Center will REPAIR OR REPLACE PARTS AFFECTED and return the unit prepaid.

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