

Machine does not run when switch is turned on.

- A. Make sure power cord is plugged in and that the wall outlet has power.
- B. With the machine unplugged, make sure all wires are connected to the on/off switch.
- C. If the machine still does not work, then replace the on/off switch.
Note: Unplug the machine before replacing the switch.
- D. If the switch is in good condition, check the fuses. If the fuses are blown, then replace. Note: Unplug the machine before checking or replacing the fuses.
- E. If machine still does not run, arrange to send the machine in for repair.

Machine makes a loud knocking sound (like a bad bearing in the motor).

- A. Make sure hood is mounted properly to key machine.
- B. If the noise continues, the motor may need to be replaced.
- C. Make arrangements to send the machine in for repair.

Cutter starts to pull the keys out of the clamp when cutting.

- A. A dull cutter will try to pull the keys from the clamp.
Replace the cutter if necessary.
- B. Three signs of a dull cutter:
 - A dull cutter will take longer to make cuts.
 - A dull cutter will emit a shrill sound as it cuts the key.
 - A dull cutter will leave a heavy build up of burrs on the key.

Spacing of cuts on duplicated key are not correct.

- A. First make sure that the depth of cut is adjusted correctly. Refer to your owners manual for this procedure.
- B. Make sure keys are properly positioned into the clamps by contacting both keys shoulder stops to the key gauge.
- C. Make sure that the cutting tool installed on the machine is the right one (D700875ZB in HSS for standard versions, or D704861ZB for Widia versions).
- D. To check the alignment of the key gauge, begin by clamping two identical blank keys in the clamps. Raise the carriage up towards cutter and guide; adjust the keys in the clamps so the shoulders of keys are flush against the left side of cutter guide.
Clamp the keys firmly in this position. Lower the carriage and bring the key gauge down to contact the shoulders of both keys. If the key gauge aligns flush on the shoulders of both keys then the spacing is correct. If there is a gap between the key gauge and the shoulder of either key, adjustment of the key gauge will be necessary. If the gap occurs on the right side of the key, adjust the left side of the left tip of the key gauge. If the gap occurs on the left side key, adjust the left side of the right tip of the key gauge.
Only adjust enough to eliminate the gap that exists between the key shoulder and the edge of key gauge.

Depth of cut is adjusted and correct for Universal keys, but not for automotive keys.

- A. Take a close look at the cutter guide (tracer) and see if a groove has become worn in the tip. If a groove is present, the cutter guide (tracer) should be replaced.
- B. Inspect both clamps for excessive wear. Assure that brass chips are not collecting on or in the clamps clamping surfaces.

Single-sided keys do not sit flat in clamps. (The head of the key is lower than the tip of the key).

- A. First make sure clamps are cleaned of all brass chip build up (top and bottom).
- B. Make sure the base of the clamp is seated properly.
- C. Keys are inserted into the clamps from the left side to the right, therefore with time the left side of the clamps (where the keys back rest) will wear, causing the base to be uneven and the keys not to be perfectly aligned. If this is the case the clamps must be replaced.

Keys are sticking in clamp or are hard to remove after cutting.

- A. Remove clamps from machine and clean them of key chippings and shavings.
- B. Make sure clamps springs are present.

**Carriage is hard to move right and left with carriage lever.**

- A. Make sure that the carriage is locked in safety position and unplugged.
- B. Flush carriage shaft bushings with WD-40 and work carriage back and forth to remove all key chipping and shavings, wipe shaft of excess WD-40.

Cutter is not activated when the carriage is moved into the forward cutting position or the cutter is not deactivated when the carriage is moved backwards into the safety position.**(For Bravo Super, Master & Europe)**

Make sure that the machine is unplugged before attempting any repairs

- A. Check fuse and replace if blown.
- B. Remove plastic side cover, making sure that the carriage is locked in safety position.

Loosen screw which holds brass tab in place.

Reposition brass tab according to symptom. If cutter does not turn on with carriage in forward position, the tab must be moved slightly clockwise. If cutter is not turning off when the carriage is in the safety position, then the tab must be moved counter clockwise.

The screw can then be tightened, and the movement of the carriage checked. Reinstall cover.

- C. If cutter is still not activated, machine may need to be sent in for repair.

(For Bravo Professional, Evolution & Maxima)

Make sure that the machine is unplugged before attempting any repairs.

- A. Check fuse and replace if blown.
- B. Remove the bottom cover and feet, making sure that the carriage is locked in safety position.

Loosen screw which holds the cam that switches micro-switch on /off.

Regulate the cam so that the micro-switch switches on & off in the correct position.

If cutter does not turn on with carriage in forward position, the cam must be moved slightly clockwise. If cutter is not turning off when the carriage is in the safety position, then the cam must be moved counter clockwise.

The screw can then be tightened, and the movement of the carriage checked. Reinstall cover.

- C. If cutter is still not activated, machine may need to be sent in for repair or fuse may need to be replaced.

The depths in a key that has just been cut are shallower than the original key, even though the machine is perfectly calibrated. The carriage feels like it has no spring load to it.

- A. Usually this is caused by a broken carriage spring. With the machine unplugged replace the broken carriage spring (D904915ZR) with a new one, or arrange to send machine in for repair.

When the clamp knob is turned to secure the key, it suddenly starts idling.

- A. The knob is probably broken at the point where the metal part is inserted into the plastic part, or the thread is damaged. Replace the knob and/or the clamp pin.

Series II

The latest re-styling of BRAVO key-cutting machines includes the use of dynamometrical knobs for opening and closing the clamp. This type of knob is predisposed to exert a maximum pressure set by Silca to guarantee optimal locking of the key. This safeguards the duration of the clamp and its components. The situation described above is therefore normal.