

# Operating Instructions for CD517 Core Capping/Decapping Press



dormakaba Group

Thank you for purchasing the BEST Core Capping/Decapping Press. We're sure you will be pleased with the features it offers along with the quality you've come to know and expect from BEST.

When you unpack the press you should find the following items:

- 1 Core Capping/Decapping Press
- 1 Segment cup, part number A60506.
- 1 Decapping tool assembly, A60507, made from the following parts:

Qty	Part number	Description
1	A60503	Decapping block (no pins or set screws)
7	A60502	Decapping block pins
7	A02220	Set screws for decapping block pins

If any of these parts are missing, please contact your local Best Access Systems Representative.

## Capping instructions

### 1 Prepare to use capping press

- 1 Place the core capping/decapping press on a flat stable surface.
- 2 Mount the press by placing bolts through two holes at the rear of the press (bolts not included). Tighten securely.
- 3 Rotate the handle up until it rests on the handle stop pin and the pin block and pins are at their highest point. See Figure 1.

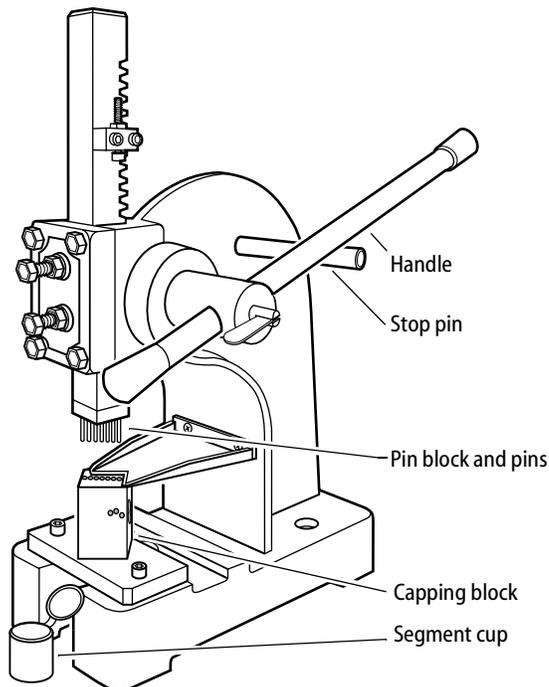


Figure 1 — CD517 Core Capping/Decapping Press

- 4 Determine the pin size of your core and then insert the pin that is attached by wire to the capping block into one of the three holes located at the back of the block.

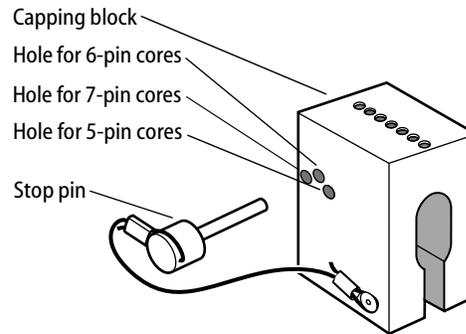


Figure 2 — Inserting the stop pin (capping block shown separately from the press).

### 2 Insert combined core

- 1 Place the *combined* core (without springs), large holes on top, into the capping block as shown in Figure 3.

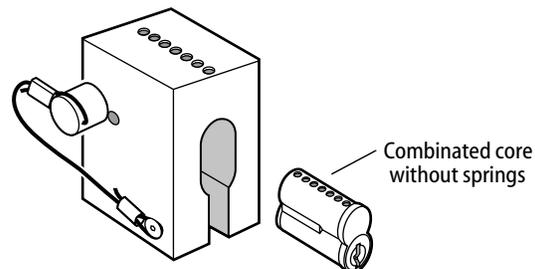


Figure 3 — Inserting a combined core into the capping block

- 2 Push the core into the capping block until the rear of the core touches the pin.

### 3 Insert springs & caps

- 1 Starting at the front open hole of the capping block, insert springs into each hole. Put as many springs as there are pins, for example, for a 6-pin core, put six springs into the first six holes. See Figure 4.

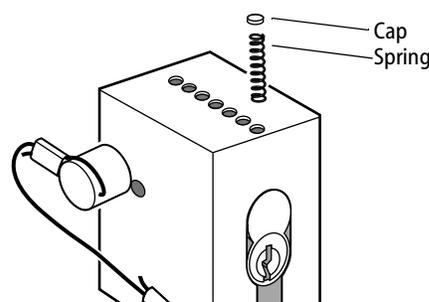


Figure 4 — Placing springs and caps into a combined core

- 2 Make sure all of the springs are seated inside the capping block. No spring should protrude above the top of the capping block. Make sure that all springs look even.
- 3 Empty a bag of core caps onto the thin metal tray that rests on the capping block.
- 4 Slide a cap onto each open hole that holds a spring. See Figure 4.

**Caution:** Make sure to **NOT** place more than one cap into a single hole. Placing more than one cap causes excess spring tension that could cause difficulty in turning a key in the completed core.

## 4 Cap core

- 1 Remove your fingers from the core block area and pull the handle firmly downward until it bottoms out, seating all of the core caps into the core. See Figure 1.
- 2 Place the handle back into its original position and remove the completed *capped core*.

## Decapping Instructions

### 1 Prepare to use decapping press

- 1 Unless you've already done so, follow the steps to, *Prepare to use capping press* on side 1.
- 2 Remove the stop pin from the capping block. See Figure 2.
- 3 Put the segment cup under the capping block and inside the open hole at the front of the press so it will catch the old segments. See Figure 1.
- 4 Using a key and a CD548 Ejector pin tool or similar tool, make sure that the holes in the bottom of the core are aligned.
- 5 Using the Decapping tool (see Figure 6), insert the pins into the holes in the bottom of the core to make sure that the decapping operation will be successful.

### 2 Insert capped core

- 1 Put the capped, combined core into the capping block in the upside-down position, large holes on the bottom. See Figure 5.

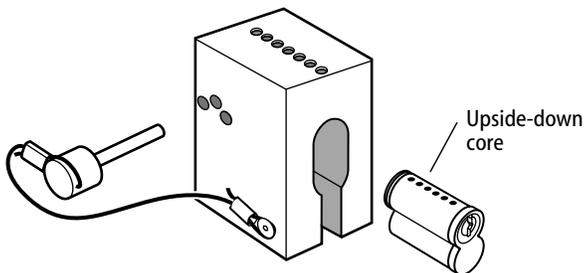


Figure 5— Inserting a combined, capped core upside-down

- 2 Push the core into the capping block until it stops.

#### For 5-pin and 6-pin cores only

- For 5-pin cores remove two ejector pins by loosening two set screws at one end of the tool. See Figure 6.

- For 6-pin cores remove one ejector pin by loosening one set screw at one end of the tool. See Figure 6.

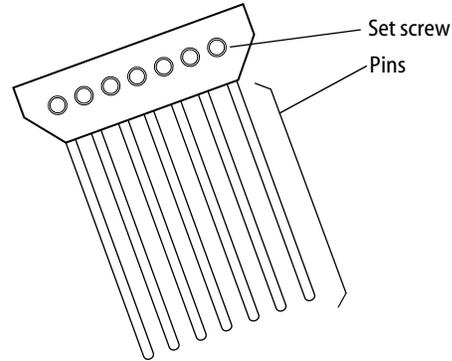


Figure 6— Decapping tool

### 3 Eject the pin segments, springs & caps

- 1 Put the decapping tool ejector pins into the holes of the capping block, starting with the first hole.
- 2 Move the tool back and forth, pressing firmly downward until you feel the ejector pins go through the small holes of the core and rest on the pin segments. You will feel slight spring tension when this happens.
- 3 Remove your fingers from the core block area and pull the handle firmly downward until it bottoms out, ejecting all core pin segments through the capping block and into the segment cup.

**Caution:** Be careful not to force the handle down too hard if you feel resistance. If you do feel resistance, adjust the decapping tool until the ejector pins are seated properly.

- 4 Place the handle back into its original position and remove the completed *decapped core*.