



THE SETABLE KEY...YOU CAN FREELY ROTATE THE DOP--AND STILL HAVE IT KEYED.

The body of the Ultra Tec V2 Owner's Manual describes a very simple way of over-riding the keying feature of the dop--a matter of just pulling the dop forward about 1/8 inch, at which point it can be rotated freely.

This, however, describes how you can have free rotation of the dop AND retain keying--so that you could remove the freely aligned dopped stone from the Spindle, and later reinsert it to the same position--for example, you might want to work on the table of the freely-aligned stone, and afterwards reinsert the stone to the prior position to touch up the crown facets.

It would be a "**setable key**"--your Ultra Tec does offer that feature--here's how:

You have a stone dopped, and you want to rotate it freely to some special position, and then key it in that position--so you can remove and later reinsert the dopped stone to the same place. Here's what you do:

1. Insert the dop so that the dop seats fully and firmly--engaging the cross-pin in the Spindle ("keying it"). Lock it there.
2. Set the Index Gear to the 0 position--the Detent is engaged with the 0 on the Index Gear (yes, at this point the stone does not line up to the lap the way you'd like it to--but we'll get there). Now, loosen the set screw that holds the Index Gear to the Spindle, allowing the Spindle to slip--to rotate freely--within the Index Gear.
3. Now you can rotate the Spindle freely until you have the stone lined up the way you want it. Then, retighten the set screw on the Index Gear--simple (incidentally, the set screw has a brass tip which holds tightly without harming the steel spindle).
4. OK--you've done it--you've set a "special" keyed position. You can now remove the dop if you wish and then reinsert it to its special keyed position.

To reset the standard 0-cross-pin key position, use the Calibration Bar and line up the Index Gear--the same as putting on a new Index Gear.

You don't always have to set a keyed "special position"--if you have a long thin stone--like a tourmaline--it's easy to reset the stone's radial position by lining up the stone itself on the lap --so, in those cases, you can use the "pull-forward" over-ride of the key.