



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.