

## New Procedures for Easing Keys



The following procedures for easing keys have now become the standard approach for both the piano manufacturing and service industries. With reamers and the successful development and application of Pianotek's VS-98 Profelt, the procedure is much faster, consistent, accurate, and longer lasting than the traditional approach using pliers and tapered easers.

Many dealerships are performing this procedure on all new instruments. Total working time should be less than two hours and can be performed by a non-technician if desired.

As many dealers have discovered, call backs for sticking keys or problems resulting in inconsistency of key friction is greatly reduced or eliminated altogether.

### PROCEDURES

- 1. Balance rail test:** Hold the front of the key top to bottom, and rotate left to right to observe key motion prior to pin movement. The key must move to the left and right without moving the pin. This process takes the weight of the key (i.e. lead) out of the test.
- 2. Hole height:** Insert our #KCS-1B Reamer through the bushing mortise and establish the height of the balance hole at 3/16".
- 3. Balance hole diameter** Use our straight reamer (see description and sizes at right) to ream the hole from the key bottom. Clean up the mortise and hole with compressed air. Our pin vise (#PV-93) is an excellent handle for the reamers.
- 4. Final easing:** Using a balance hole burnisher (easer), rotate 360 degrees lightly to radius the top edge, then ease normally at 9 o'clock and 3 o'clock and increase as needed.
- 5. Profelt balance rail:** Apply 3 drops of Profelt (#VS-98) to each side of the bushing cloth. Insert a key bushing caul .001" over pin diameter and leave overnight. This will size and lubricate the bushing cloth resulting in little or no further easing.
- 6. Balance hole test:** Gently raise the key up approximately 3/16" at the front. The key should return to its rest position freely without resistance.
- 7. Profelt front rail:** Apply 3 drops of Profelt to each side and insert a key bushing caul .005" to .006" over pin diameter and leave overnight. This will leave enough play in the front for better upweight, allowing faster repetition.
- 8. Front rail test:** Hold the front of the key lightly top to bottom and gently move the key side to side. You should feel .010" play on each side.