



## KEYS 800 TREADMILL

# OWNER'S MANUAL

Model Name: PRO 800. \_\_\_\_\_

Serial Number \_\_\_\_\_

Purchase Date \_\_\_\_\_

Write down for future reference.  
Model Name & Serial Number located  
on frame opposite the power cord.

Keys Technical Service, (888) 340-0482

Proudly made in the USA by:

**KEYS Fitness Products, LP**

P.O. Box 551239

Dallas, Texas 75239

[www.keysfitness.com](http://www.keysfitness.com)

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# Important Safety Information



- 1) **WARNING:** Before using this treadmill or starting any exercise program, consult your physician. This is especially important for persons over the age of 35 and/or persons with pre-existing health problems. The manufacturer or distributor assumes no responsibility for personal injury or property damage sustained by or through the use of this product.
- 2) **WARNING:** To reduce the risk of electrical shock, burns, fire, or other possible injuries to the user, it is important to review this manual and the following precautions *before* operation.

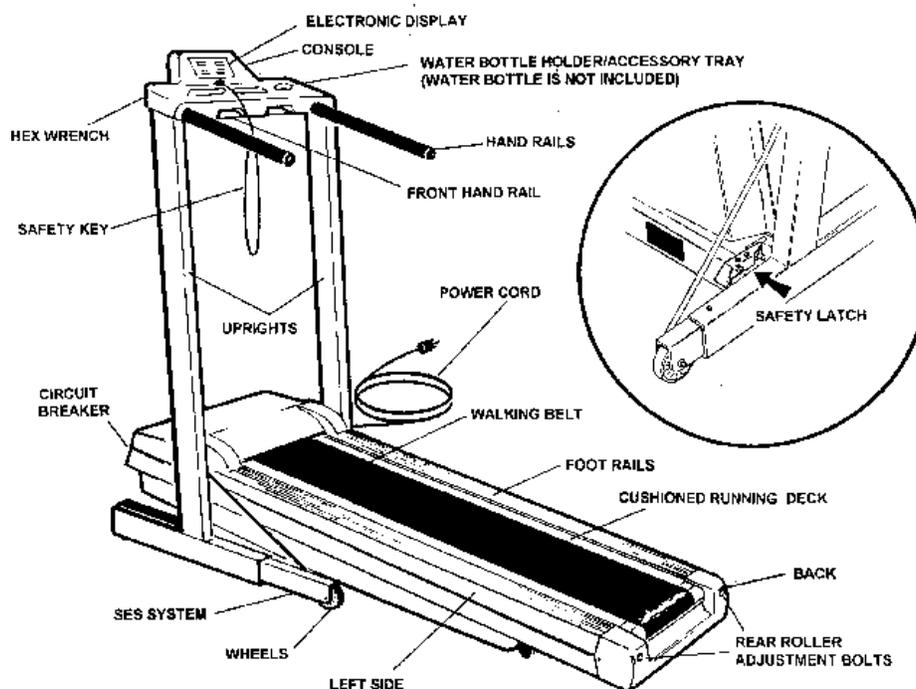
## SAFETY PRECAUTIONS AND TIPS

- It is the owner's responsibility to ensure that all users of this treadmill have read the Owner's Manual and are familiar with warnings and safety precautions.
- This treadmill has a user maximum capacity of 275 pounds.
- The treadmill should only be used on a level surface and is intended for indoor use only. The treadmill should not be placed in a garage, patio, or near water and should never be used while you are wet. Keys Fitness recommends a treadmill mat be placed under the treadmill to protect floor or carpet and for easier cleaning.
- Follow safety information in regards to plugging in your treadmill. Keep the power cord away from the incline wheels and do not run the power cord underneath your treadmill. Do not operate the treadmill with a damaged or frayed power cord.
- Wear comfortable, good-quality walking or running shoes and appropriate clothing. Do not use the treadmill with bare feet, sandals, socks or stockings.
- Always straddle the belt and allow it to start moving before stepping onto the belt.
- Hold on to handrails when adjusting speed, incline, or other controls.
- Always examine your treadmill before using to ensure all parts are in working order.
- Allow the belt to fully stop before dismounting.
- Pets should be never be allowed near or on the treadmill.
- Do not leave children unsupervised near or on the treadmill.
- Never operate the treadmill where oxygen is being administered, or where aerosol products are being used.
- Never insert any object or body parts into any opening.
- For safety and to prevent damage to your treadmill, no more than one person should use the treadmill at a time.
- Always unplug the treadmill before cleaning and/or servicing. Service to your treadmill should only be performed by an authorized service representative, unless authorized and/or instructed by the manufacturer. Failure to follow these instructions will void the treadmill warranty.
- Never leave the treadmill unattended while it is running.

# Before You Start

Thank you for purchasing a KEYS treadmill! This quality product you have chosen was designed to meet your needs for cardiovascular exercise.

- Before you start, please read the Owner's Manual and become familiar with the operation of your new treadmill.
- **Remember to take the time to perform the stretching exercises provided to avoid injury.**
- Do not stand on the walking belt while pressing the Power button or Start/Stop button.
- Always adjust the speed of the treadmill in small increments as this treadmill is capable of high speeds.
- If you are taking medication, consult your physician to see if the medication will affect your exercise heart rate.
- If you have heart problems, you are not active, and/or are over the age of 50 years, do not use the pre-set treadmill programs or start an exercise program without first contacting and receiving approval from your physician.
- To avoid the risk of electrical shock, always keep the console dry. Do not spill liquids on the console. KEYS recommends a sealed water bottle for beverages consumed while using the treadmill.
- **Please review the following drawing below to familiarize yourself with the listed parts. This manual covers several treadmills, so the one pictured below may not be identical to your particular model.**



# Warm Up Exercises

## WARM UP FIRST !

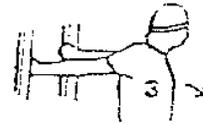
Warming up prepares the body for exercise by increasing circulation, supplying more oxygen to the muscles and raising body temperature. Begin each workout with 5 to 10 minutes of stretching and light exercise to warm up. The drawings on this page show several forms of basic stretching you may perform before your workouts. Again, consult a physician before starting this or any other exercise program.



15 Seconds for each



20 Seconds



20 Seconds



25 Seconds



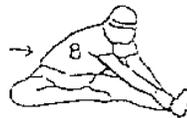
20 Seconds



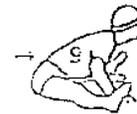
20 Seconds



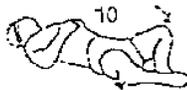
30 Seconds



25 Seconds each leg



30 Seconds



20 Seconds



5 Seconds X 3 times



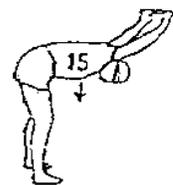
20 Seconds



25 Seconds each leg



5 Times



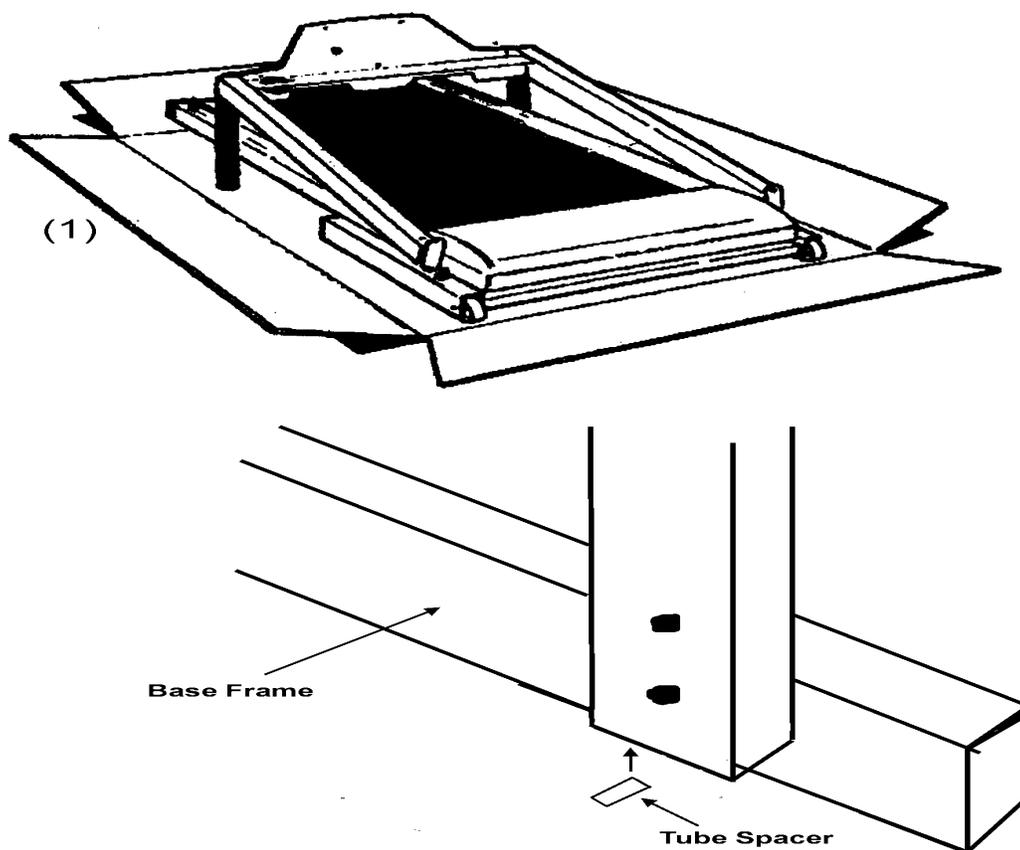
15 Seconds

# Assembly Instructions

## Assembly

KEYS treadmills are shipped in one piece to make assembly easy. After opening the box, remove any packing materials from the treadmill. Do not throw away any packing materials until the unit is working properly. Place the base on a clean, level surface. Make sure the electrical cord will easily reach an electrical outlet.

- 1) Have a second person raise the console to the upright position and hold.
- 2) Insert the TUBE SPACER inside the upright frame and line up with the bottom hole. Hold tube spacer while inserting the 1 1/2" Button Head Bolt and lightly tighten. Repeat for opposite side.
- 3) After completing opposite side, **TIGHTEN ALL FOUR BOLTS SECURELY**. Assembly is now complete.
- 4) Be sure to use the **RED SAFETY KEY** before turning the power on.



# Power Requirements

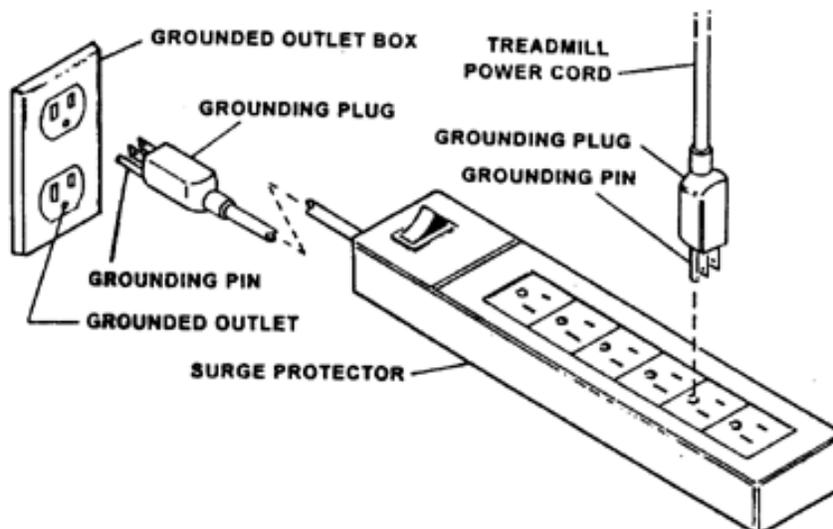
IMPROPER CONNECTION OF THE EQUIPMENT GROUNDING CONNECTOR CAN RESULT IN A RISK OF AN ELECTRIC SHOCK. CHECK WITH A QUALIFIED ELECTRICIAN OR SERVICE MAN IF YOU ARE IN DOUBT AS TO WHETHER THE PRODUCT IS PROPERLY GROUNDED. DO NOT MODIFY THE PLUG PROVIDED WITH THE PRODUCT, IF IT WILL NOT FIT THE OUTLET, HAVE A PROPER OUTLET INSTALLED BY A QUALIFIED ELECTRICIAN.

This treadmill can be seriously damaged by sudden voltage changes in your home's electrical power. Voltage spikes, surges, and noise interference can result from weather conditions or from other appliances being turned on or off. To reduce the possibility of treadmill damage, always use a surge protector (not included) with your treadmill.

Surge protectors can be purchased at most hardware stores. Keys Fitness recommends a single outlet surge protector with a UL 1449 rating as a Transient Voltage Surge Suppressor (TVSS) with a UL suppressed voltage rating of 400V or less and an electrical rating of 120VAC, 15 amps.

This treadmill must be grounded to reduce the risk of electrical shock. Grounding provides a path of least resistance for electric current, should the treadmill malfunction. This treadmill comes with an electrical cord having an equipment-grounding conductor and a grounding plug. Always plug the power cord into a surge protector, and plug the surge protector into an appropriate outlet that is properly installed and grounded in accordance with all local codes and ordinances.

This product is for use on a nominal 120-volt circuit, and has a grounding plug that looks like the plug illustrated in the drawing (1) below.



# Console Functions and Descriptions

There are five display windows on the control panel to provide feedback information.

## TIME WINDOW

- **TIME:** Indicates elapsed time after pressing start in minutes and seconds (0-99 minutes, 0-59 seconds)
- **INTERVAL TIME:** Indicates countdown in seconds to the next interval starting at 5 seconds and counting to 0 seconds

## SPEED WINDOW

- **SPEED:** Indicates MPH up to 10MPH (miles per hour) or KMH (kilometer per hour) in .1 increments

## DISTANCE / CALORIES WINDOW

- **DISTANCE:** Indicates Miles or Kilometers traveled in .01 increments up to 9.99 and .1 increments starting at 10.0
- **CALORIES:** Indicates estimated calories used based on 150 lb. person at the indicated speed, incline, and time

## INCLINE WINDOW

- **INCLINE:** Indicates incline in percent of grade 0-12% in 1 increments

## CENTER BRICKYARD WINDOW

- Displays quarter mile track in Manual mode. Indicates position on track by a blink. In program mode, shows the change in speed profile across the interval range (1-10) and shows position with a blinking action.
- The treadmill console will display the name of the program selected, showing on the left hand side of the window. The LAP counter will appear in manual mode in the center of the window.

# Program and Operating Instructions

## QUICK START / MANUAL MODE

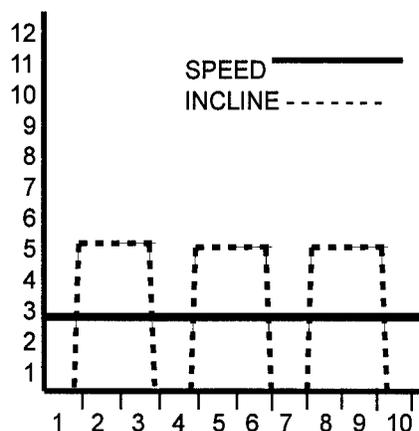
- Plug into a standard wall outlet (110-Volt AC, 15-amp circuit).
- **Attach RED Safety Key to treadmill console.**
- Stand on the treadmill and straddle belt.
- Press **POWER** button. There will be an eight (8) second delay after pressing the POWER button before data can be entered. The TIME window will flash.
- Press **START/STOP** button. Belt will begin to move after 4 seconds. Step on belt slowly after the belt starts moving. Speed or incline may be adjusted by using the appropriate + (increase) or – (decrease) buttons.
- **To end your workout**, press START/STOP button. Belt will gradually slow to zero.
- **To pause your workout**, press PAUSE.
- **To re-start after pausing:** Press the PAUSE button. **WARNING:** The treadmill belt will resume at the speed the treadmill was moving before pausing.
- **Countdown Time, Preset Speed and/or Incline:** Time, Speed, and Incline may be preset prior to getting started. After pressing the POWER button, the time window will blink. Use the SPEED/TIME + or – arrows to select your workout time, then press the ENTER PROGRAM button. The SPEED/TIME window will now be flashing. Using the same + or – arrows, select the speed for your workout, then press ENTER PROGRAM. Now the INCLINE window will be flashing. Use the INCLINE + or – arrows to set your workout incline, then press ENTER PROGRAM. To start, press the START/STOP button.

# Program and Operating Instructions

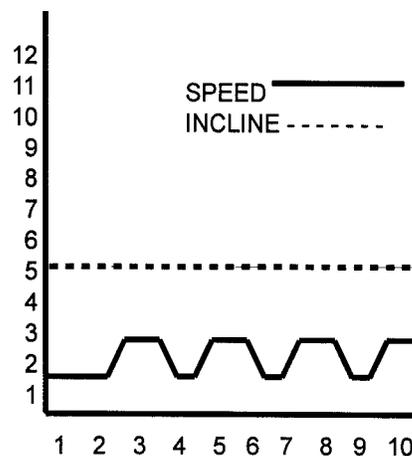
## PROGRAM MODE

- Plug into a standard wall outlet (110-Volt AC, 15-amp circuit).
- **Attach RED Safety Key to treadmill console.**
- Stand on the treadmill and straddle belt.
- Press POWER button. There will be an eight (8) second delay after pressing the POWER button before data can be entered. The TIME window will flash.
- There are three (3) pre-set programs on the Keys 800, Fat Burn, Cardio, and Warm Up programs (see the program profiles later in this manual). Select the program by pressing the appropriate button.
- Press START/STOP button. Belt will begin to move after 4 seconds. Step on belt slowly after the belt starts moving.
- **Each of the pre-set programs can also be customized. Follow the instructions below for your particular model.**
- **Customizing programs in P1 and P2 Mode:** Each pre-set program can be customized in the P1 or P2 mode. After making the program selection, the center window will read "OP." "OP" refers to "original program" and is preset. Press the same program button once more, and the center window will read P1. The "P1" mode is now accessed. You can now program the Time, Speed, and Incline in P1 mode, which will save your entered information for future use. The time window will blink. Use the SPEED/TIME + or – arrows to select your workout time, then press the ENTER PROGRAM button. The SPEED/TIME window will now be flashing. Using the same + or – arrows, select the speed for your workout, then press ENTER PROGRAM. Now the INCLINE window will be flashing. Use the INCLINE + or – arrows to set your workout incline, then press ENTER PROGRAM. To start, press the START/STOP button. To access P2 mode, press the selected program button three times (once for OP, twice for P1, three times for P2). Follow the above procedure to customize.
- **TO CHANGE A PREVIOUSLY PROGRAMMED P1, P2, or user program:** Once you have programmed the P1 or P2 modes, you will need to use the PAUSE button to change the program you previously entered. For instance, if P1 in Fat Burn has been programmed, to change to a new setting, press the Fat Burn button twice to access P1. Then press the PAUSE button to get the TIME window to flash. Follow the directions above to continue to change the program.

# Program Profiles

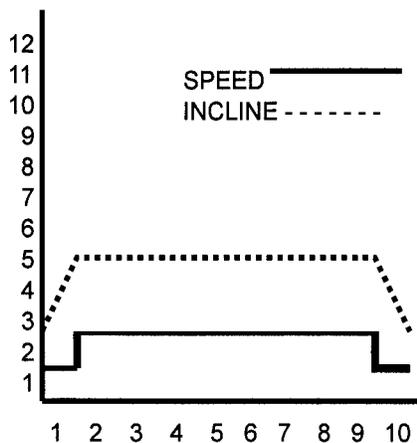


The FAT BURN program is designed to vary treadmill elevation while maintaining a constant walking speed. Set the desired maximum speed and incline, and the treadmill will automatically change the incline to the set amount, alternating in segments 2-3, 5-6, and 8-9.



The CARDIO program is designed to vary treadmill speed while maintaining a constant walking incline. Set the desired maximum speed and incline, and the treadmill will automatically change the speed to the set amount, alternating in each segment.

*EACH PROGRAM HAS 10 SEGMENTS. THE LENGTH OF TIME FOR EACH SEGMENT IS BASED ON THE TIME LENGTH OF THE PROGRAM. IF YOU SET THE PROGRAM TO 30 MINUTES, EACH SEGMENT IS 3 MINUTES LONG (TIME divided by 10 SEGMENTS).*



The WARM UP program is designed to gradually increase treadmill speed and incline (warm up) in the first segment to the set maximum speed and incline. The program will then plateau at the set speed and incline maximums. At the end of the program, the treadmill will gradually decrease speed and incline to half of the maximum set (cool down) in segments 9-10.

# Belt Adjustment and Tension

**WARNING! Do not overtighten rollers! This will cause premature roller bearing failure!**

Belt adjustment and tension performs two functions: adjustment for tension and centering. Your new treadmill comes pre-adjusted from the factory for tension and centering. Please follow the procedures below if the belt shifts left or right or if the belt slips while walking:

## WALKING BELT HAS SHIFTING TO THE LEFT (Diagram 1)

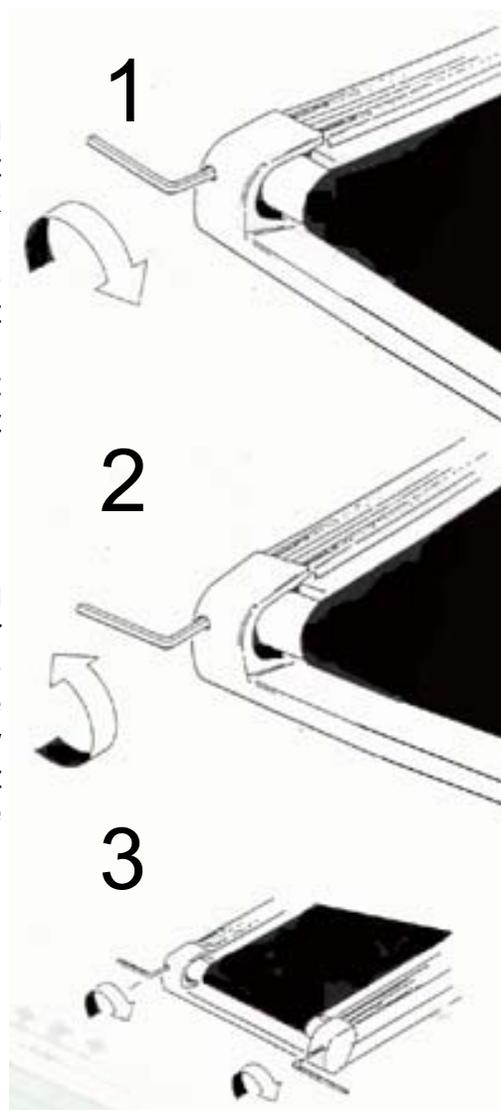
First, unplug the power cord from the surge protector. Using the hex key provided, turn the left rear roller adjustment bolt  $\frac{1}{4}$  turn in the clockwise direction. Plug the power cord back into the surge protector and run the treadmill at 2.5 mph. You should see the belt start to correct itself, moving back towards the center. Repeat the above procedure until the walking belt is centered. It may be necessary to set walking belt tension once you have completed this procedure if the belt feels like it is slipping while walking. Refer to below to the “Walking Belt Slipping” instructions.

## WALKING BELT HAS SHIFTING TO THE RIGHT (Diagram 2)

First, unplug the power cord from the surge protector. Using the hex key provided, turn the right rear roller adjustment bolt  $\frac{1}{4}$  turn in the clockwise direction. Plug the power cord back into the surge protector and run the treadmill at 2.5 mph. You should see the belt start to correct itself, moving back towards the center. Repeat the above procedure until the walking belt is centered. It may be necessary to set walking belt tension once you have completed this procedure if the belt feels like it is slipping while walking. Refer to below to the “Walking Belt Slipping” instructions.

## WALKING BELT IS SLIPPING DURING USE (Diagram 3)

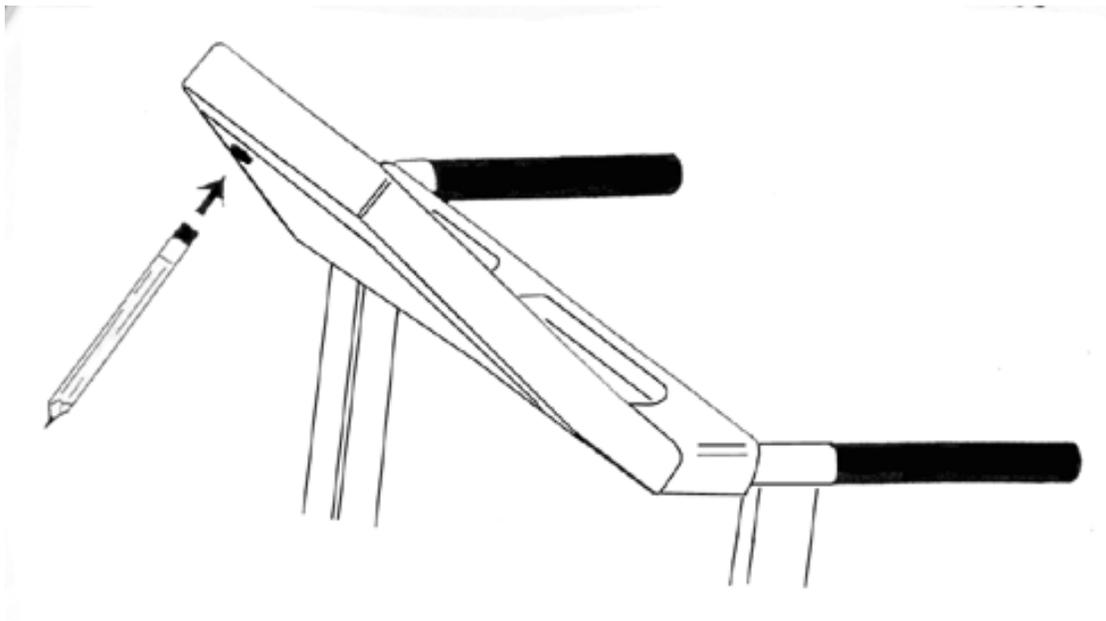
First, unplug the power cord from the surge protector. Using the hex key provided, turn both left and right rear roller adjustment bolts the same distance, usually a  $\frac{1}{4}$  turn in the clockwise direction. Plug the power cord back into the surge protector and run the treadmill at 2.5 mph. You should now walk on the belt to determine if the belt is still slipping. Repeat the above procedure until the walking belt is not slipping. The tension should be just tight enough not to slip.



# Change Miles per hour to Kilometers per hour

Your treadmill will operate in British Units (miles per hour) or International Units (kilometers per hour). All treadmills are calibrated at the factory for British Units (miles per hour). To change the display to read in kilometers, follow the steps described here:

- 1) Power is turned OFF on the console. Attach the magnet safety key to the console.
- 2) Activate the calibration mode switch by inserting the eraser end of a pencil into the opening in the backside of the console (see diagram below).
- 3) Depressing the calibration mode switch TWICE and CL21 should appear in the TIME window.  
(On the Keys 800, 'mph or kph' will be flashing in the SPEED window)
- 4) Pressing the the SPEED +/- button will activate choice, then press "ENTER PROGRAM."
- 5) To accept the setting, press the POWER button.



# Maintenance Instructions

**WARNING!** Before performing any maintenance to your treadmill, always unplug the power cord from the surge protector.

## CLEANING

Routine cleaning of your Keys Fitness treadmill will extend the life of your treadmill. **WARNING!** To prevent electrical shock, be sure the power to the treadmill is OFF and the unit unplugged from the wall electrical outlet before attempting any cleaning or maintenance.

**AFTER EACH WORKOUT:** Wipe off the console and other treadmill surfaces with a clean, water dampened soft cloth to remove excess perspiration. **USE NO CHEMICALS.**

**WEEKLY:** Use of a treadmill mat is recommended for ease of cleaning. Dirt from your shoes contacts the belt and eventually makes it to underneath the treadmill. Vacuum underneath treadmill once a week.

## DECK LUBRICATION

The treadmill deck and belt have been pre-lubricated at the factory. However, it is recommended that the walking board be checked periodically for lubrication to ensure optimal treadmill performance.

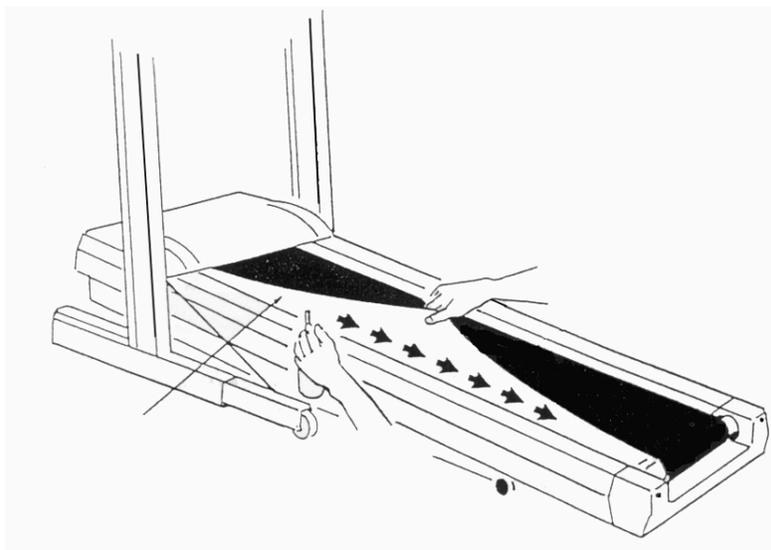
Every 30 days or 30 hours of operation, lift the sides of the walking belt and feel the top surface of the walking board as far under as you can reach. If you feel signs of silicone, no further lubrication is required. If it feels dry to the touch, follow the instructions below.

Please use Lube 'N Walk or silicone spray such as Napa 8300. (Ask your treadmill dealer or call us)

### TO APPLY LUBRICANT TO THE WALKING BOARD

- 1) Position the walking belt so that the seam is located on top and in the center of the center of the walking board.
- 2) Insert the spray nozzle into the spray head of the lubricant can.
- 3) While lifting the side of the walking belt, position the spray nozzle between the walking belt and the board approximately 6" from the front of the treadmill. Apply the silicone spray to the walking board, moving from the front of the treadmill to the rear. Repeat this on the other side of the belt. Spray approximately 4 seconds on each side.
- 4) Allow the silicone to 'set' for one minute before using the treadmill.

**WARNING: Do not overlubricate the walking board. Excess lubricant should be wiped off with a clean towel.**



# Troubleshooting Guide

## Treadmill will not start.

- 1) Is the RED Safety Key Attached to the Console?
- 2) Make sure the power cord is plugged into a surge protector, the surge protector is plugged into a properly grounded outlet, and the surge protector is turned on. (Refer to "Power Requirements")
- 3) Check the circuit breaker located on the front of the treadmill. If the switch protrudes, it has tripped. Wait five minutes and then press the switch back in.
- 4) Check the house electrical breaker box and the circuit breaker for the room the treadmill is located in. If it has tripped, reset or have an electrician replace the breaker in home.
- 5) Have an electrician check for inadequate voltage at the outlet.

## Treadmill loses power during use.

- 1) Check the circuit breaker located on the front of the treadmill. If the switch protrudes, it has tripped. Wait five minutes and then press the switch back in.
- 2) Check the house electrical breaker box and the circuit breaker for the room the treadmill is located in. If it has tripped, reset or have an electrician replace the breaker in home.
- 3) If treadmill still will not operate, please call Keys Technical Service at (888) 340-0482.

## Treadmill walking belt slows during use.

- 1) Check to make sure the treadmill is securely plugged into an UL-listed surge protector, rated at 15 amps, with a 14-gauge cord of five feet or less and the surge protector is securely plugged into the outlet.
- 2) If treadmill still will not operate, please call Keys Technical Service at (888) 340-0482.

## Treadmill walking belt slips or is not centered on rear roller.

- 1) Refer to "Belt Adjustment and Tension" section.
- 2) Need help? Call Keys Technical Service at (888) 340-0482.

## Treadmill Error Messages.

2) Your treadmill is equipped with a software package that enables error messages to be displayed when there is a problem. **To avoid possible damage to the treadmill and the possibility of injury, do not operate the treadmill until the problem is corrected. Call Keys Technical Service at (888) 340-0482.**



Parts List - KEYS 800 Treadmill

KEY #	PART #	DESCRIPTION	QTY	KEY #	PART #	DESCRIPTION	QTY
1	23-0064	UPRIGHT ASSEMBLY D. GRY	1	53	08-0004	CIRCUIT BREAKER 15 AMP	1
2	23-0063	DECK ASSEMBLY D GRY	1	58	14-0069	END CAP DECAL	2
3	23-0050	FRONT ELEVATION ASSEMBLY	1	67	02-0004	SCREW, 8X 5/8 PHIL PH	29
7	19-0014	MOTOR MOUNTING BRACKET	1	68	02-0005	SCREW, 8X 5/8 PHIL PH HILO	12
8	19-0015	MOTOR COVER BRACKET	7	69	02-0006	BOLT, 5/16 X 5 - 1/2 SHOULDER BOLT	1
10	19-0019	BELT GUIDE	2	70	02-0007	5/16-18 NYLOCK NUT	3
13	06-0089	BASE PAN MOTOR	1	71	02-0008	SCREW, 5/16-18 X 3/4 HEX	3
16	05-0007	SIDE BOARD EXTRUSION	2	72	02-0009	NUT, 5/16-18 WHIZLOC	3
22	06-0080	FAN 5" 8mm bore	1	76	02-0013	LOCK WASHER, 1/4	8
25	06-0005	DOME PLUG	4	77	02-0014	SCREW, 1/4-20 X 2 - 1/2 HEX	10
26	06-0105	MOTOR COVER	1	79	02-0016	SCREW, 3/8-16 X 2 - 1/2 HEX	1
27	06-0008	END CAP	1	83	02-0020	SCREW, 1/4-20 X 2-1/2 SOCKET HEAD	2
34	10-0002	BOARD ISOLATOR	8	84	02-0021	WASHER, 9/32 X 5/8 X 1/8	3
35	10-0003	FOAM GRIP	2	85	02-0022	NUT, 10-24 NYLOCK	4
36	08-0077	FERRITE CORE	1	87	02-0024	CARRIAGE BOLT 5/16 X 1	2
37	12-0022	ACTUATOR (ELEVATION MOTOR)	1		02-0028	MAGNETIC KILL SWITCH SAFETY KEY RED	1
38	12-0023	DRIVE MOTOR	1	94	02-0031	SCREW, 3/8-16 X 1 3/4 HEX	1
39	03-0003	WALKING BOARD	1	99	02-0036	SCREW, GREEN HEAD 8 X 5/8 PPH	2
40	04-0008	WALKING BELT 18" X 105"	1	101	02-0038	HEX WRENCH 3/16 NOT SHOWN	1
41	04-0004	POLY V BELT	1		06-0024	HEX WRENCH PLASTIC CLIP (not shown)	1
42	06-0003	PULLEY vx0086 8 GR	1				1
42	09-0012	FRONT ROLLER (with 06-0003 pulley)	1	104	14-0027	EMERGENCY STOP DECAL	1
43	09-0013	REAR ROLLER	1	105	06-0014	BUSHING, STRAIN RELIEF	1
44	13-0011	POWER CORD	1	107	06-0016	WIRE TIES NOT SHOWN	10
45	13-0003	ENCODER HARNESS	1	108	06-0021	WIRE CLAMP NOT SHOWN	5
48	13-0016	CONTROL PANEL HARNESS	1	109	06-0022	RESET GUIDE TUBE NOT SHOWN	1
49	13-0007	BREAKER WIRE 6" NOT SHOWN	1				
50	24-0111	CONSOLE ASSEMBLY 5 WIN LCD (not shown)	1				
51	08-0014	MOTOR CONTROLLER	1				
52	08-0047	OPTICAL ENCODER	1				

**KEYS 800 Treadmill KEYS FITNESS PRODUCTS, LP – LIMITED WARRANTY**



**PLEASE CONSULT YOUR PHYSICIAN BEFORE USING THIS PRODUCT.**

This Limited Warranty applies in the United States, Canada, and Mexico to products manufactured or distributed by Keys Fitness Products, LP ("Keys") under the KEYS brand name. The warranty period to the original purchaser is (lifetime) on the frame, (3) years on the motor, (2) years on parts, and (1) year labor.

Keys warrants that the Product you have purchased for non-commercial, personal, family, or household use from Keys or from an authorized Keys reseller is free from defects in materials or workmanship under normal use during the warranty period. Your sales receipt, showing the date of purchase of the Product, is your proof of the date of purchase. This warranty only extends to you, the original purchaser. It is not transferable to anyone who subsequently purchases the Product from you. It excludes expendable parts. This Limited Warranty becomes VALID ONLY if the treadmill is assembled/installed by a Keys Fitness authorized dealer/technician unless otherwise authorized by Keys Fitness in writing (if anyone other than a Keys Fitness authorized dealer/technician assembles a Keys Fitness treadmill the warranty will be void unless accompanied by written authorization by Keys Fitness).

During the warranty period Keys will at no additional charge, repair or replace (at Keys' option) the product if it becomes defective, malfunctions, or otherwise fails to conform with this Limited Warranty under normal non-commercial, personal, family or household use. In repairing the Product, Keys may replace defective parts, or at the option of Keys, serviceable used parts that are equivalent to new parts in performance. All exchanged parts and Products replaced under this warranty will become the property of Keys. Keys reserves the right to change manufacturers of any part to cover any existing warranty.

To obtain warranty service, you must contact a Keys authorized service technician or Keys Fitness at our phone numbers located in this manual. Any parts determined to be defective must be returned to Keys to obtain warranty service. You must prepay any shipping charges, export taxes, custom duties and taxes, or any other charges associated with transportation of the parts or Product. In addition, you are responsible for insuring any parts or Product shipped or returned. You assume the risk of loss during shipment. You must present Keys with proof-of-purchase documents (including the date of purchase). Any evidence of alteration, erasing or forgery of proof-of-purchase documents will be cause to void this Limited Warranty.

This warranty does not extend to any product not purchased from Keys or from an authorized Keys reseller. This Limited Warranty does not extend to any Product that has been damaged or rendered defective; (a) as a result of accident, misuse, or abuse; (b) by the use of parts not manufactured or sold by Keys; (c) by modification of the Product or normal wear and tear; (d) operation on incorrect power supplies; or (e) as a result of service by anyone other than Keys, or an authorized Keys warranty service provider. Product on which the serial number has been defaced or removed is not eligible for warranty service. Should any Product be submitted for warranty service be found ineligible therefore, an estimate of repair cost will furnished and the repair will be made if requested by you upon Keys' receipt of payment or acceptable arrangements for payment.

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