

Custom Laser-Engraved MCP Key Covers

SINUMERIK ONE MACHINE CONTROL PANELS · GENUINE SIEMENS BLANKS

TP-MCPKEY

Datasheet Rev A · 2026-09-19

think-plc.com/shop



Engraved covers placed on the SINUMERIK ONE MCP 1500 front (layout per Siemens equipment manual A5E52027171B). The same covers fit every SINUMERIK ONE MCP.

Every mechanical key on a SINUMERIK ONE machine control panel carries an interchangeable cover, and Siemens supplies unlabeled laser-markable FE-grey covers for machine-specific symbols. Think-PLC stocks those blanks and marks them in-house on a fiber laser. Design online from the symbol library, typed text or your own PNG, SVG or DXF; see the mark on the key and on the panel; order per key. Each order line carries its artwork, and the shop engraves from that line.



Fits	SINUMERIK ONE MCP 1500, MCP 1900, MCP 2200, MCP 2400 (mechanical keys, interchangeable covers)
Blank	Siemens square key cover, laser-markable, FE-grey: 6FC5348-0AP00-3AA0 (49 pcs) / 6FC5303-0AF27-1AA0 (90 pcs)
Cover size	Approx. 18 x 17.5 mm, 20 mm key pitch; usable mark area approx. 14.5 x 13 mm (nominal, verify on the Siemens DXF template)
Marking	Fiber laser, white contrast mark in the cover material; no ink, film or overlay; symbol, text, vector line art or raster logo
Artwork	Built-in library (main functions, operating modes, axes, machine functions), bold text up to 3 lines, PNG/JPG/SVG rasterized at 96 x 86 dots, DXF as vectors
Order	Per key, one line per design; artwork string TPKEY1 . . . on the order line; printed proof with every shipment
Lead time	From stock; typical small orders ship within days

SIEMENS REPLACEMENT KEY COVER SETS (PRODUCT NOTE 109802036)

Article number	Description	Qty	Color	Contents
6FC5248-0AF21-0AA0	Square key cover for insert plates	90	transparent	No insert plates; for paper or film labels
6FC5303-0AF27-1AA0	Square key cover, laser-markable	90	FE-grey	Unlabeled
6FC5348-0AP00-3AA0	Square key cover, laser-markable	49	FE-grey	Unlabeled: the blank Think-PLC engraves
6FC5348-0AP00-3AB0	Standard symbols (MCP delivery state)	49	FE-grey	15 operating mode, 15 customer, 15 axis, 2 feed, 2 spindle
6FC5348-0AP00-3AC0	Main-function symbols	49	FE-grey	7 each: Reset, Cycle Stop/Start, Feed Stop/Start, Spindle Stop/Start
6FC5348-0AP00-3AD0	Turning symbols	49	FE-grey	6 each: +C -C +X -X +Y -Y +Z -Z, 1 blank

HOW IT IS MADE

- Design online**
Symbol, text or upload; size and position on the key; placed on the MCP 1500 layout or ordered loose by quantity.
- Artwork on the order**
Add to cart: one line per design with the engraving data attached; printable proof.
- Laser marking**
The shop decodes the order into 1:1 SVG and 600 dpi files and marks the blanks in a full-set fixture.
- Inspect and bag**
Checked against the proof, bagged per design with key positions, shipped with the proof sheet.
- Snap on**
Pull the old cover, press the new one on; no tools, no panel disassembly.
- Reorder**
The artwork stays on the order, so replacements are a repeat order.

Artwork rules. Black on white or transparent; keep strokes at least 0.3 mm at final size; the mark is a single white tone, so photographs and gradients become a threshold image (preview it before ordering). DXF: lines, arcs, circles, polylines and splines are engraved as 0.3 mm strokes; text entities in a DXF are ignored, so convert text to outlines first.

Genuine Siemens blanks
FE-grey laser-markable covers

Fiber laser, in-house
Permanent white mark

Made in NC
Engraved in Winston-Salem

Any artwork
Library, text, PNG, SVG, DXF