

**STRATTEC Security Corporation**

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# Fiesta Pinning Exercise - 2012 Side Mill



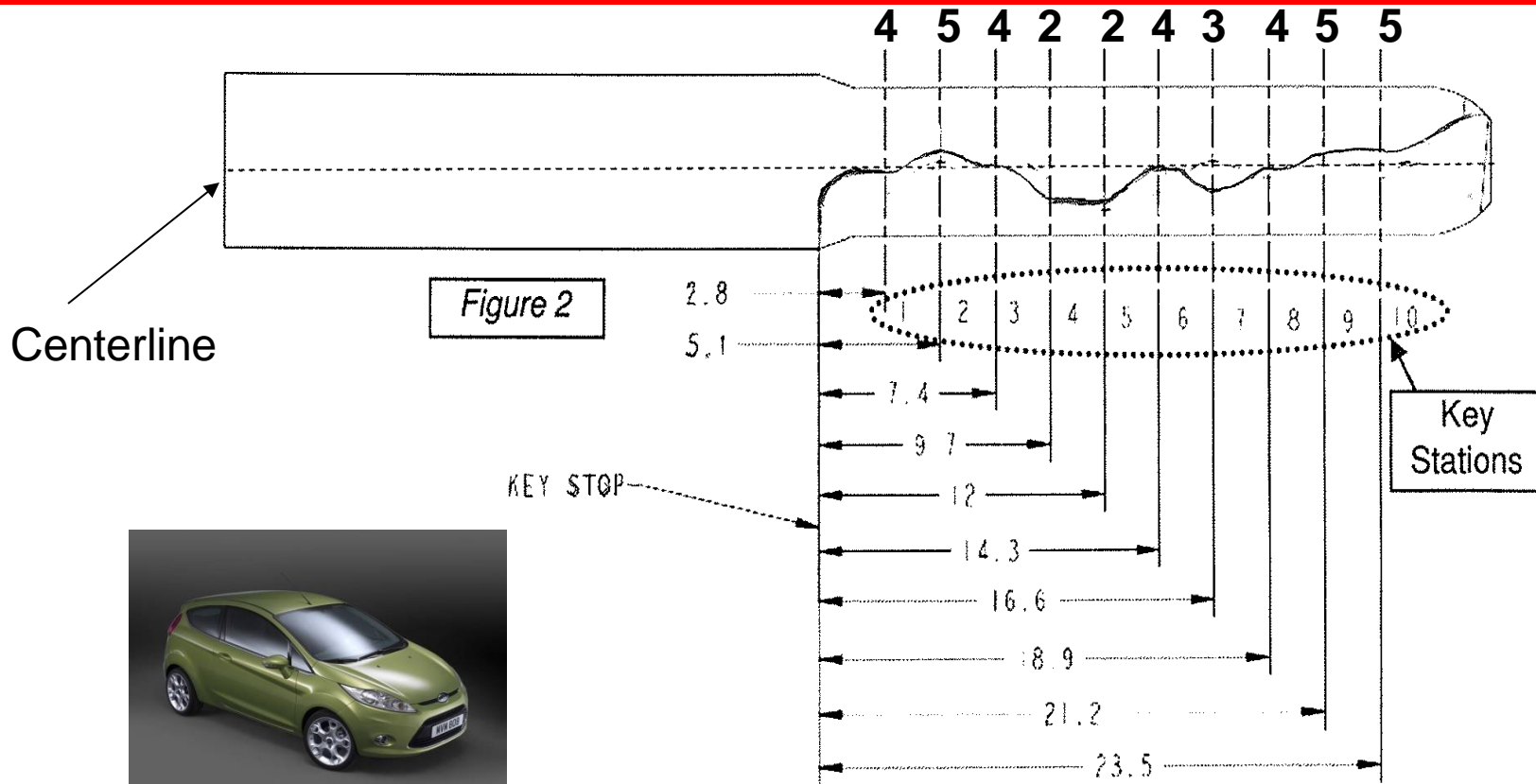
## **2010 GM Ford Side Mill Cut Key Reading**

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### Key Reading by Cuts

- 1) Start with the keybow to the left and the tip of the key pointing to the right
- 2) Observe the cuts on the lower half of the key
- 3) A cut nearest the centerline of the blank is a “4” cut and a cut nearest outer edge of the blank is a 1 cut
- 4) See example in Figure 2 for the exercise

# 2012 Ford 2012 Ford Fiesta – Door Spacings Stations Eng Code 09001 (Use Stations 1 – 10 Only)



## 2012 Ford Ford Side Mill Pinning Door

### Tumbler Identification and Pinning

\*Tumbler bags marked as follows:

1L - 4211971 – not used	1R – 4211961 – not used
<b>2L - 4211972 – 2 total</b>	2R – 4211962 – not used
3L - 4211973 – not used	<b>3R – 4211963 - 1 total</b>
<b>4L - 4211974 – 2 total</b>	<b>4R – 4211964 – 2 total</b>
<b>5L - 4211975 – 1 total</b>	<b>5R - 4211965 - 2 total</b>

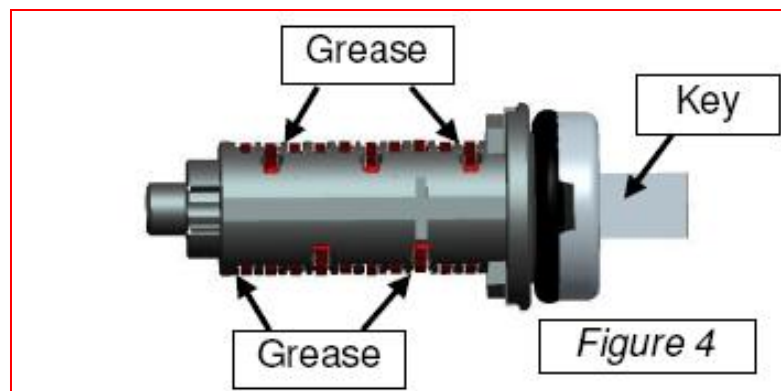
\***Needed** for the exercise – 2L, 4L and 3R, 4R, 5R , 5L

\***7020057** is the production kit available at the distributor.

## 2012 Ford Tumbling Side Mill Door

### Tumbler Insertion

1. Select the required Tumblers (B1-B10) according to the key cut depths for each key station (1-10). Note that there are Right (B1-B5) and Left (B6-B10) side Tumblers.
2. Insert one Tumbler-Spring (C) into each of the holes located at the end of the slots found on the Cylinder Sub-Assembly (D) top-side, ref. figure 3.
3. Insert the required Tumblers (B1-B10) into the tumbler slots (top-side) in the proper orientation (ref. figure 3), and in the sequence that match the key cut depths for stations 1-10.
4. While holding down the Tumblers, turn the Cylinder (D) and repeat steps 3 and 4 for the bottom-side, ref. figure 3.
5. Insert the key into the keyhole and verify that all installed tumblers are flush with the Cylinder (D) exterior surface. Do not pull out the Key. If you do, the tumblers will fall out.
6. Apply grease to the outer surface of the Cylinder (D) with the key still inserted, ensuring that the areas above and in between the tumblers are coated (ref. figure 4).



# 2012 Ford

## 2012 Ford Fiesta – Cylinder Orientation and tumbler placement - Door

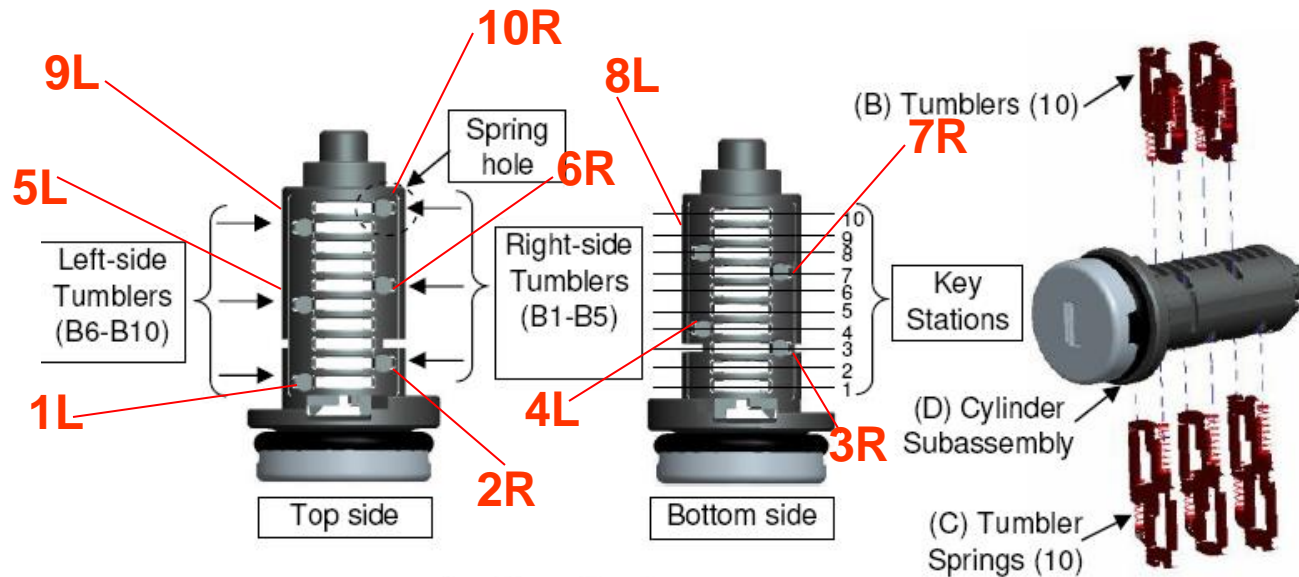


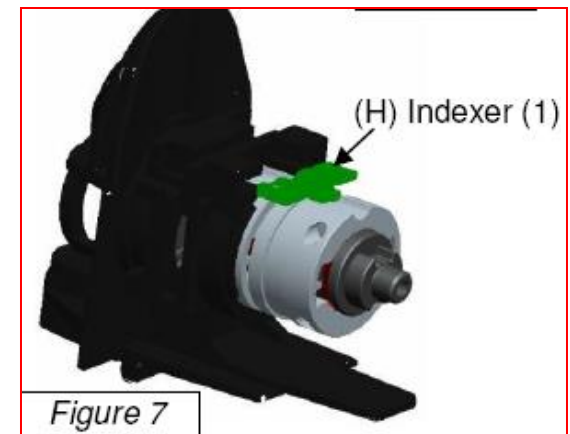
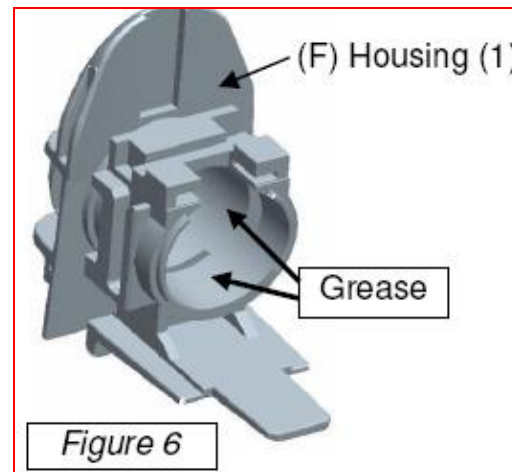
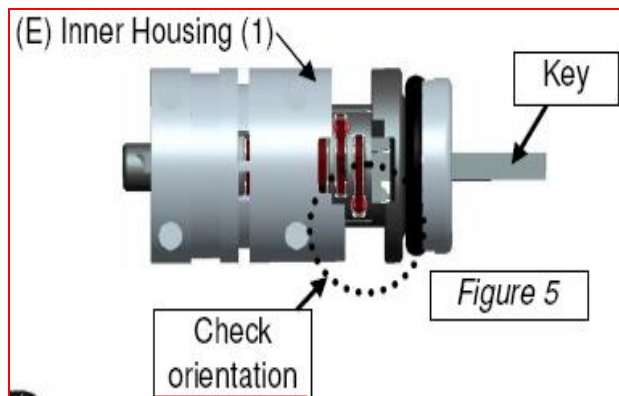
Figure 3

Station 1 (L)	Station 2 (R)	Station 3 (R)	Station 4 (L)	Station 5 (L)	Station 6 (R)	Station 7 (R)	Station 8 (L)	Station 9 (L)	Station 10 (R)
4	5	4	2	2	4	3	4	5	5

## 2012 Ford Tumbling Side Mill Door

### Tumbler Insertion

7. Install the tumbled & greased Cylinder inside the Inner-Housing (E). Check for proper orientation (ref. figure 5). Pull out the Key.
8. Apply grease to the inner surface of the Housing (F), ref. figure 6.
9. Partially install the subassembly (D & E) into the Housing (F). Then, install the Indexer (H) in the Housing (F). Finally, fully install the all the components (D, E & H), ref. figure 7.

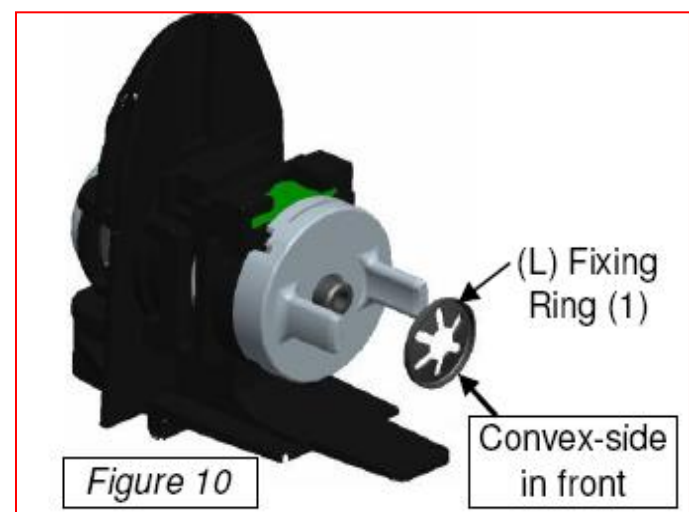
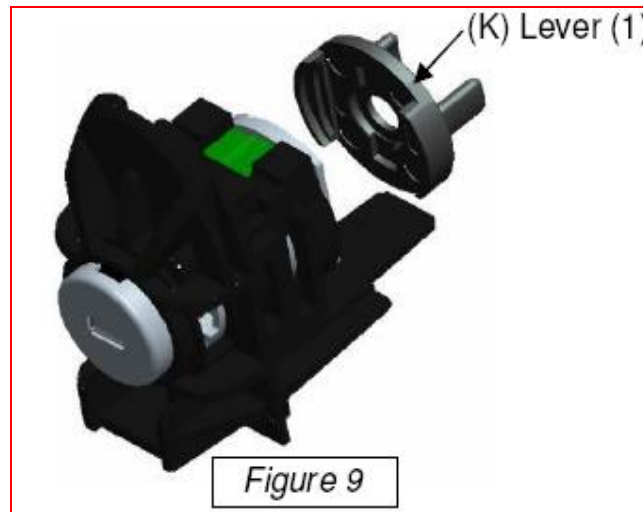
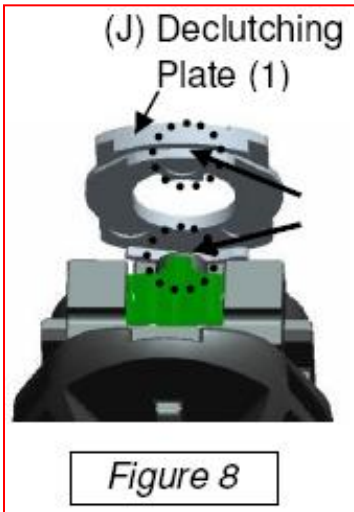




## 2012 Ford Tumbling Side Mill Door

### Tumbler Insertion

10. Install the Declutching Plate (J) onto the Cylinder (D). Make sure the Indexer (H) is located inside the groove, ref. figure 8.
11. Install the Lever (K) onto the Declutching Plate (J), see figure 9.
12. Fully install the Fixing Ring (L) onto the Cylinder (D), ref. figure 10.

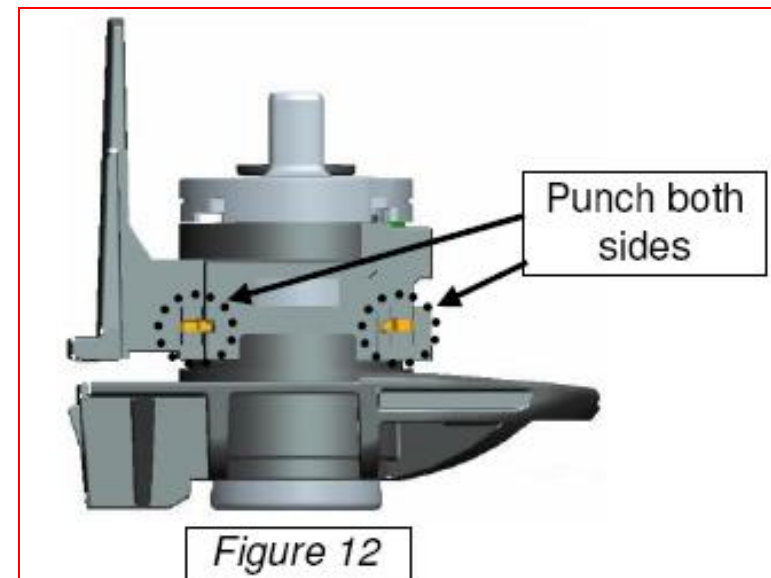
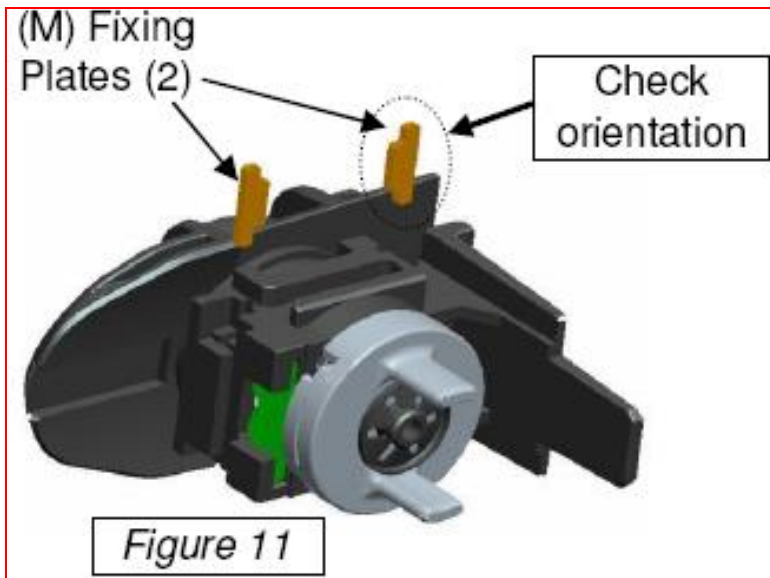




## 2012 Ford Tumbling Side Mill Door

### Tumbler Insertion

13. Fully install (1) Fixing Plate (M) into each Housing (F) slot, see figure 11.
14. Using a suitable Punch-tool deform the Housing (F) to secure the Fixing Plates (M) in place, ref. figure 12.
15. Use the Key to check the operation of the Lock.



# 2012 Ford Tumbling Side Mill Door

