

STRATTEC Security Corporation

Fiesta Pinning Exercise - 2012 Side Mill



2010 GM Ford Side Mill Cut Key Reading

Key Reading by Cuts

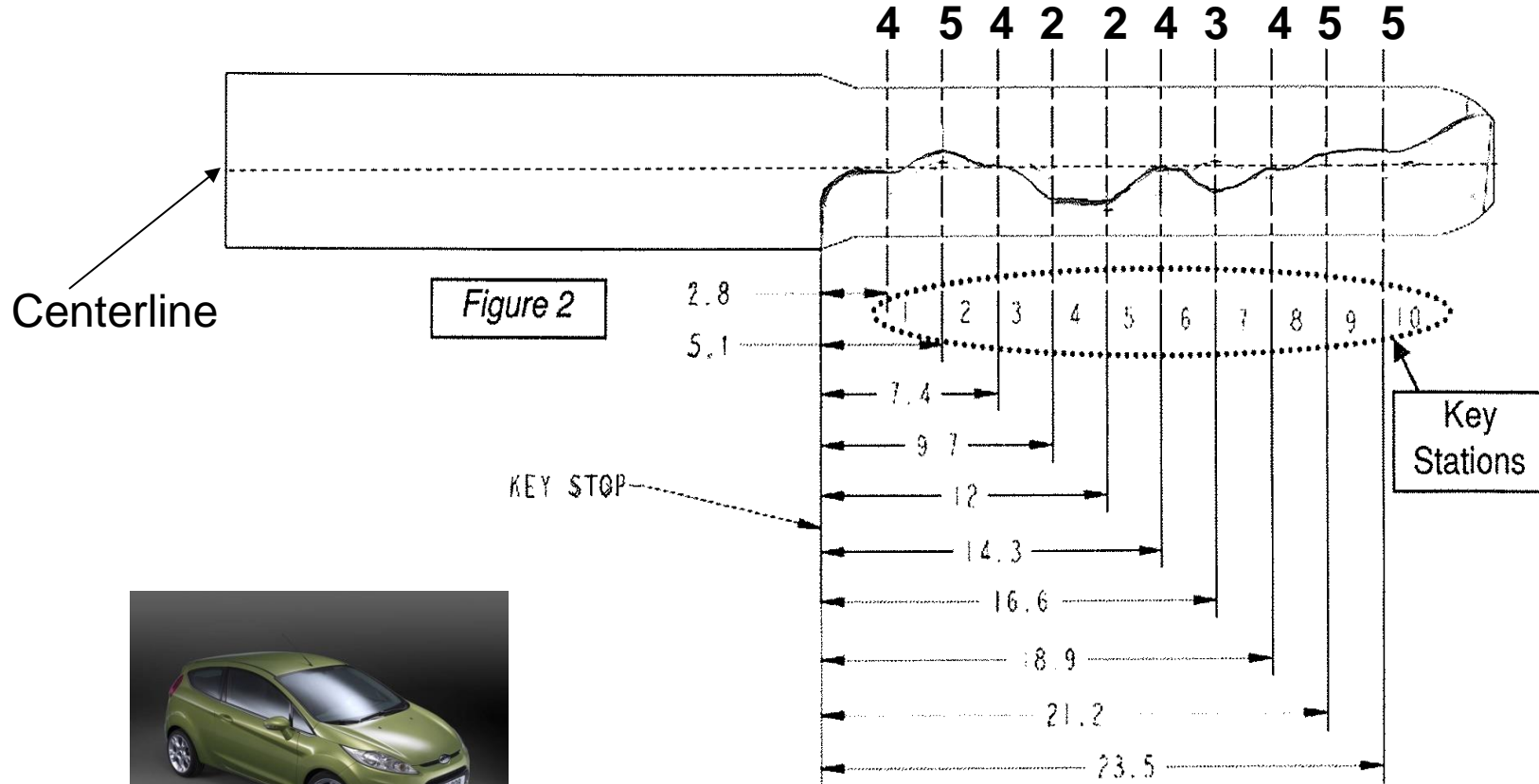
- 1) Start with the keybow to the left and the tip of the key pointing to the right
- 2) Observe the cuts on the lower half of the key
- 3) A cut nearest the centerline of the blank is a “4” cut and a cut nearest outer edge of the blank is a 1 cut
- 4) See example in Figure 2 for the exercise

2012 Ford

2012 Ford Fiesta – Ignition Spacings Stations

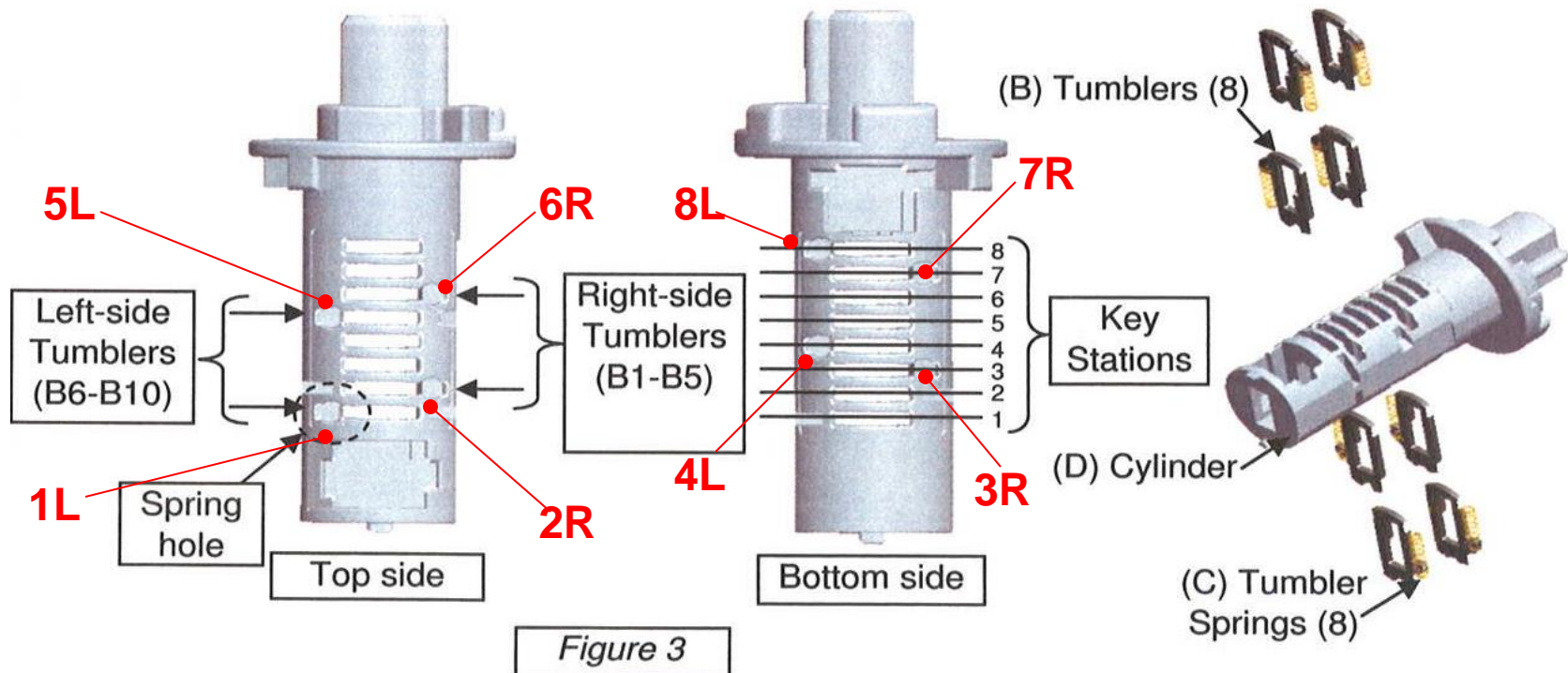
Eng Code 09001

(Use Stations 1 – 8 Only)



2012 Ford

2012 Ford Fiesta – Cylinder Orientation and tumbler placement ignition



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

2012 Ford Ford Side Mill Pinning Ignition

Tumbler Identification and Pinning

*Tumbler bags marked as follows:

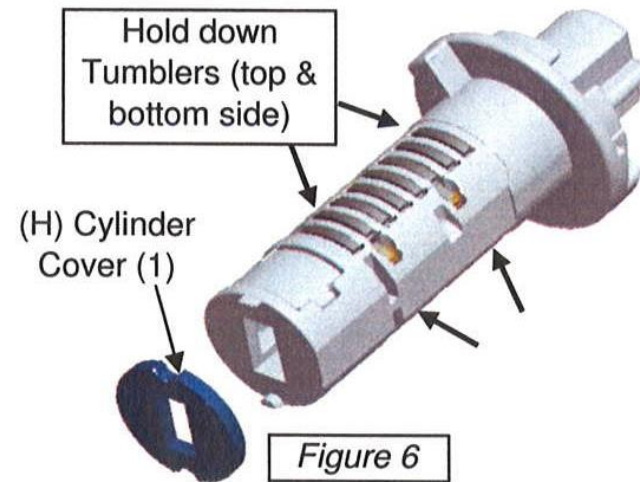
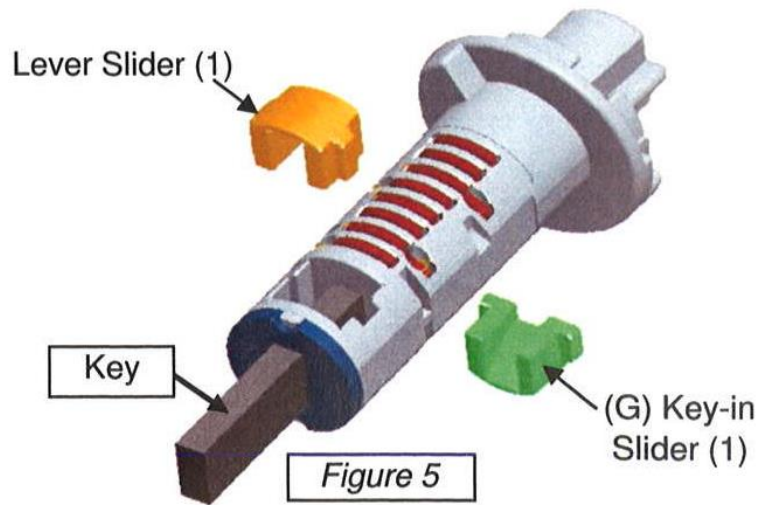
1L - 4211971 – not used	1R – 4211961 – not used
2L - 4211972 – 2 total	2R – 4211962 – not used
3L - 4211973 – not used	3R – 4211963 - 1 total
4L - 4211974 – 2 total	4R – 4211964 – 2 total
5L - 4211975 – not used	5R - 4211965 - 1 total

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

***7021038** is the education kit. **7020058** is the production kit available at the distributor.

Tumbler Insertion

- 1) Start with the left tumblers and populate stations 1, 4, 5 and 8. Station 1 is on the bottom when held vertically. 2 stations are on the front left side and 2 stations are on the back left side. **Populate 1 and 5, , rotate cylinder 180 degrees and populate 4 and 8** (See figure 3 for reference). Spring hole and tumbler slots should be greased for retention (4L, 2L, 2L, 4L)
- 2) Next, follow with the right hand tumblers and populate stations 2, 3, 6 and 7 . Again 2 stations are on the front right side and 2 stations are on the back right side . **Populate 2 and 6, rotate 180 degrees and populate 3 and 7**(See figure 3 for reference) Spring hole and tumbler slots should be greased to aid retention (5R, 4R, 4R, 3R)
- 3) Check tumbler placement with the coded cut key, **not the key with all 5 depths**. If tumblers are fully recessed, replace with 5 depth key to complete assembly of cylinder into case. Also install Cylinder cover (H) at this time Refer to figure 5 and 6.



Cylinder Case Assembly

4) Apply grease to the inner surface of the housing subassembly (1) as shown in figure 4 below.

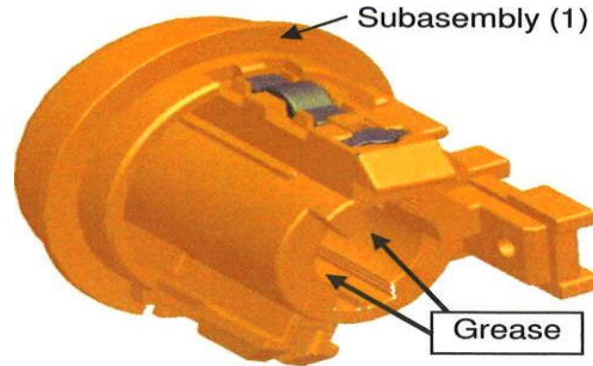


Figure 4

5) Install the lever slider (F) and key-in Slider (G) into their respective slots.

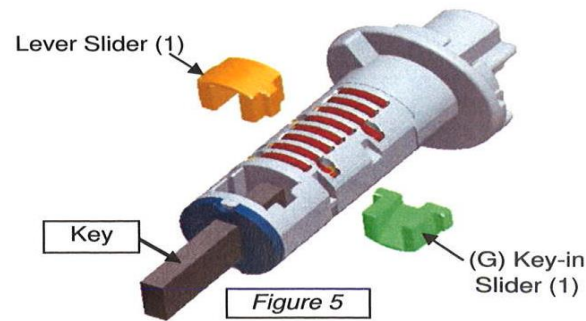
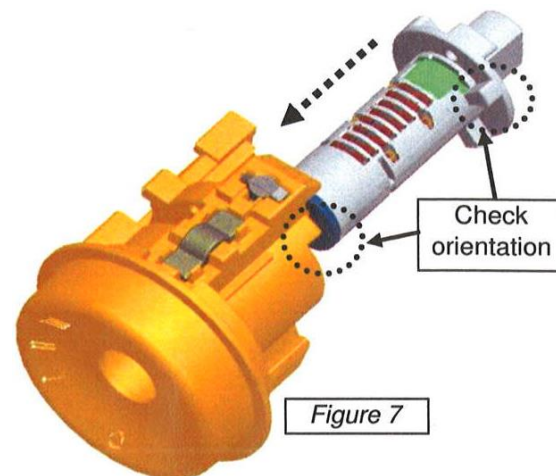


Figure 5

Cylinder Case/Housing Assembly – Cont.

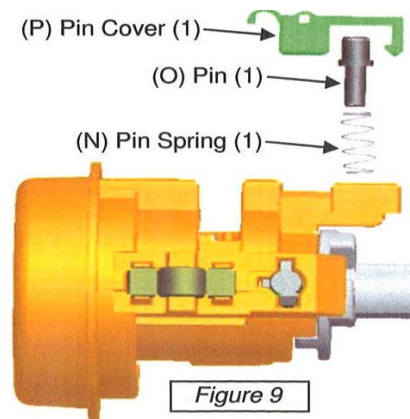
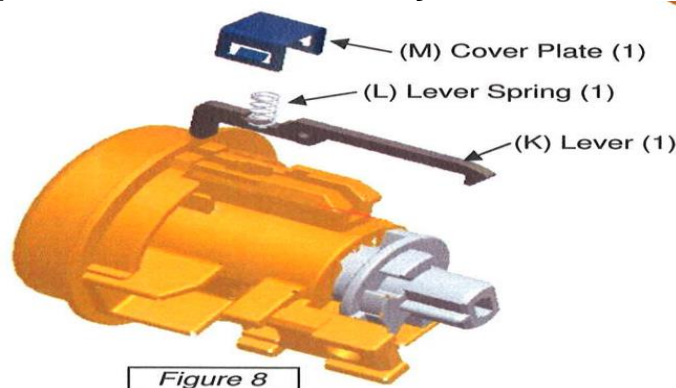
6) Fully install the cylinder into the housing in the proper orientation. Reference figure 7.



7) Install lever (K) then lever spring (L) and finally cover-plate (M) into housing (E). Make sure to install

the cover-plate all the way . Reference figure 8

8) Install pin spring (N) then pin (O) and finally pin-cover (P) into housing (E). Make sure the pin-cover snap fits all around and fully seats. Reference figure 9



2012 Ford Tumbling Side Mill Ignition

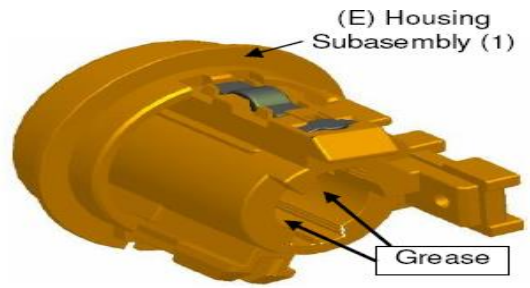


Figure 4

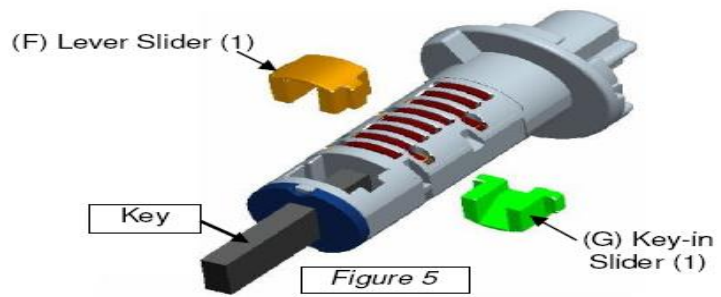


Figure 5

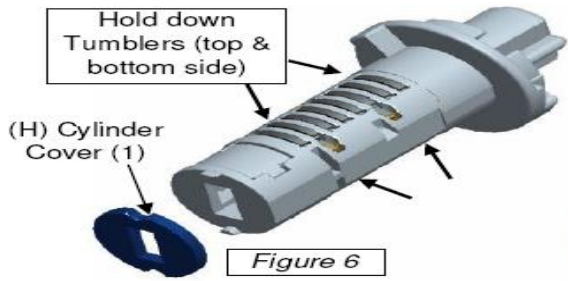


Figure 6

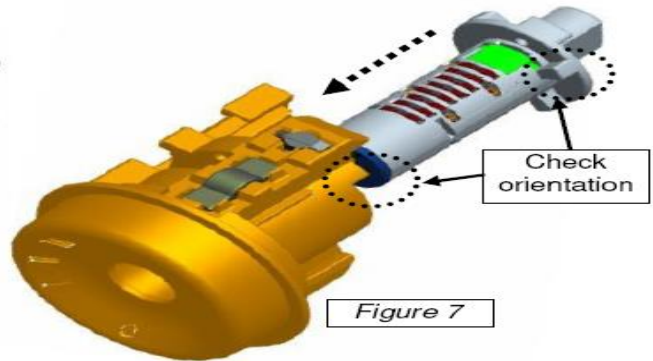


Figure 7

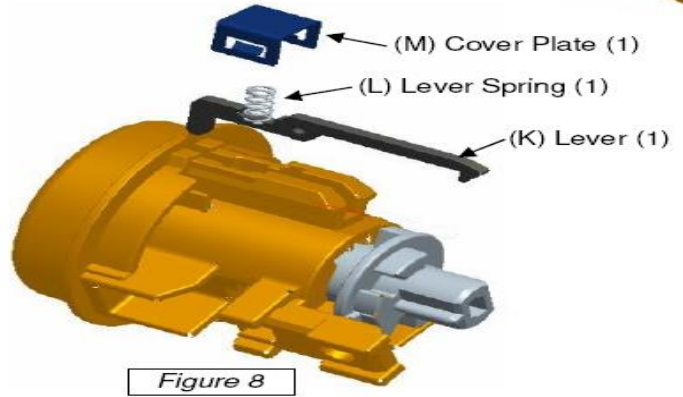


Figure 8

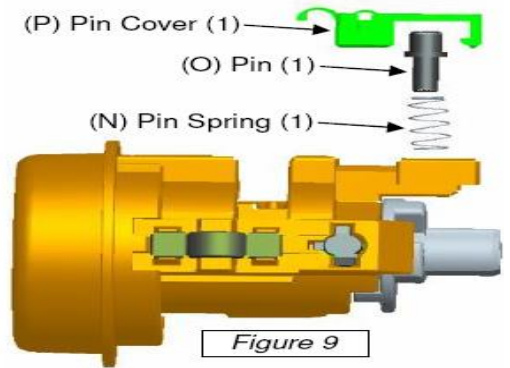


Figure 9

