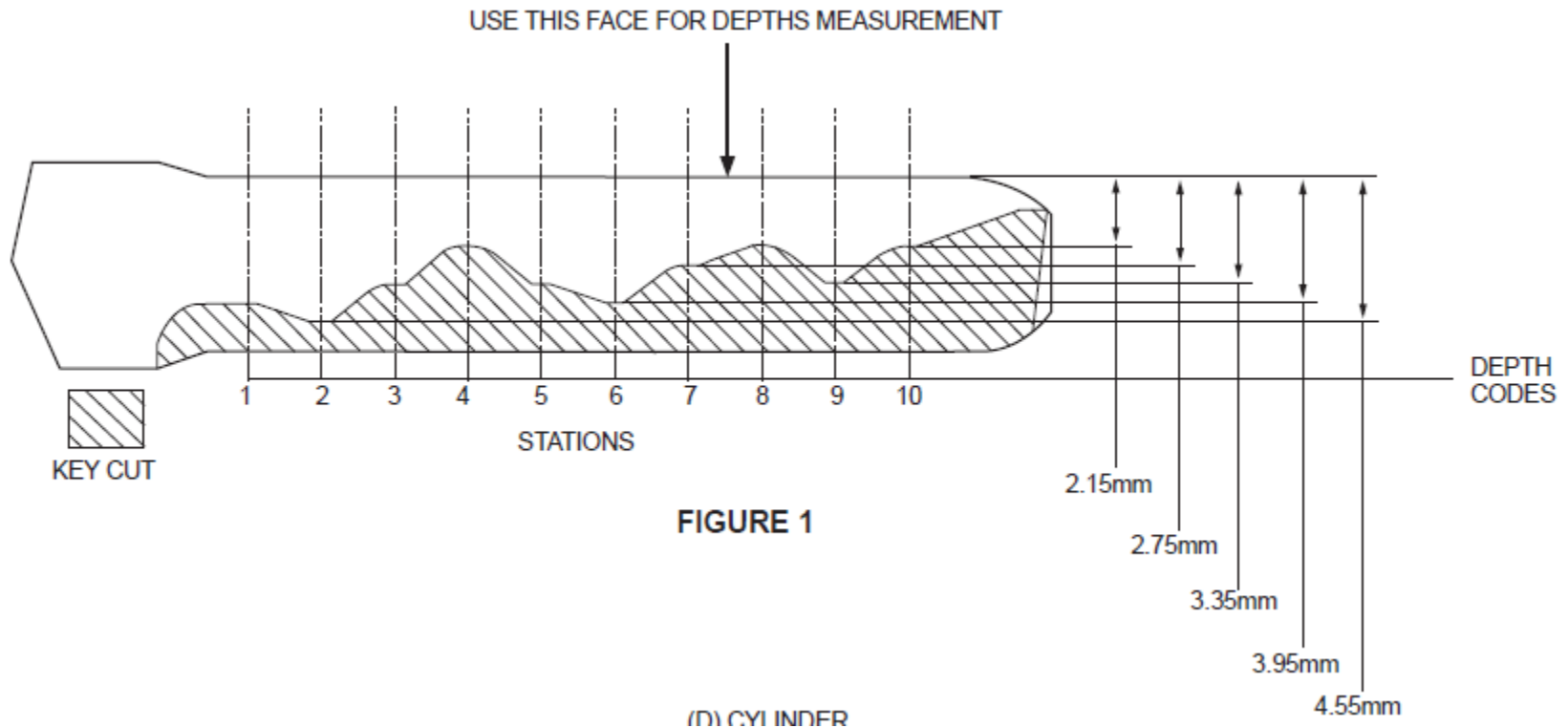


PINNING INSTRUCTIONS 2015 FORD TRUCK



FORD TRUCK DEPTH CODES HIGH SECURITY



FORD SIDE MILL CUT KEY READING

Key Reading by Cuts

Key found in door education pack Part
Number - 7026866

- 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 next slide Figure 2 for the exercise

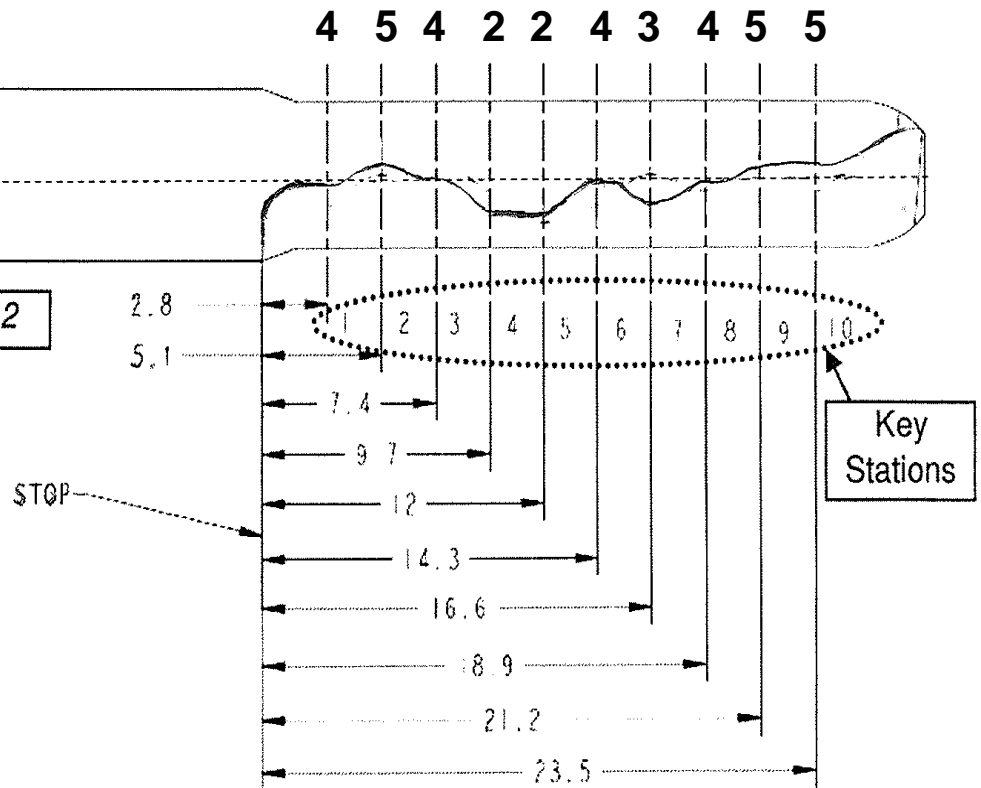
FORD TRUCK

DOOR STATIONS

- Use Stations 4 – 10 Only
- Eng Code 09001

Centerline

Figure 2



FORD TRUCK SIDE MILL PINNING DOOR

Tumbler Identification and Pinning

*Tumbler bags marked as follows:

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

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

PINNING TRUCK SIDE MILL DOOR

1. Insert the shutter spring (J) into the round hole at the front of the lock cylinder (D) (refer to Figure 2), if not installed already.
2. Insert the shutter assembly (G) into the rectangular depression with notches at the long ends, located at the front of the lock cylinder (D) (refer to Figure 2), if not installed already.

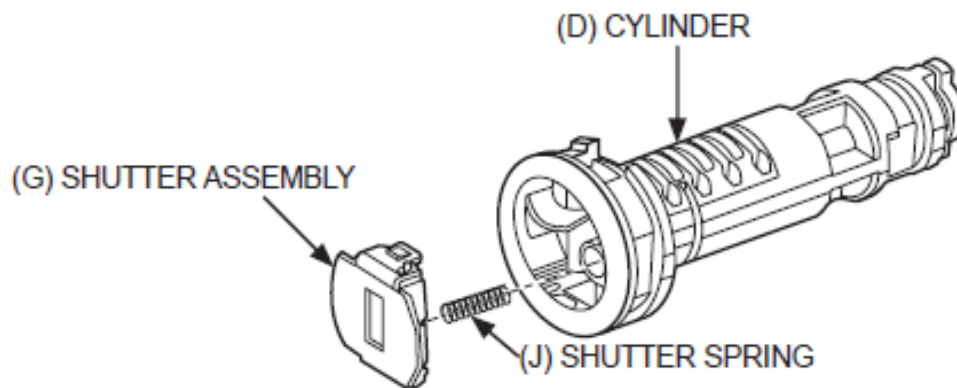


FIGURE 2

PINNING TRUCK SIDE MILL DOOR

3. Select the required tumblers (B1 – B10) according to the key cut depths, for key stations 4, 5, 6, 7, 8, 9 and 10. Ignore stations 1, 2 and 3.

NOTE: There are Right (B1 – B5) and Left (B6 – B10) side Tumblers.

4. Insert one Tumbler-Spring (C) into each of the holes located at the end of the tumblers wards on the lock Cylinder (D) top side, (refer to Figure 3).

5. Insert the required Tumblers (B1 – B10) into the tumbler slots (top-side) in the proper orientation (refer to Figure 2), and in the sequence that match the key cut depths for stations 4 – 10.

6. While holding down the Tumblers, turn the Cylinder (D) and repeat steps 3 and 4 for the bottom side, (refer to Figure 3)

7. 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.

FORD TRUCK DOOR

■ Cylinder Orientation and tumbler placement

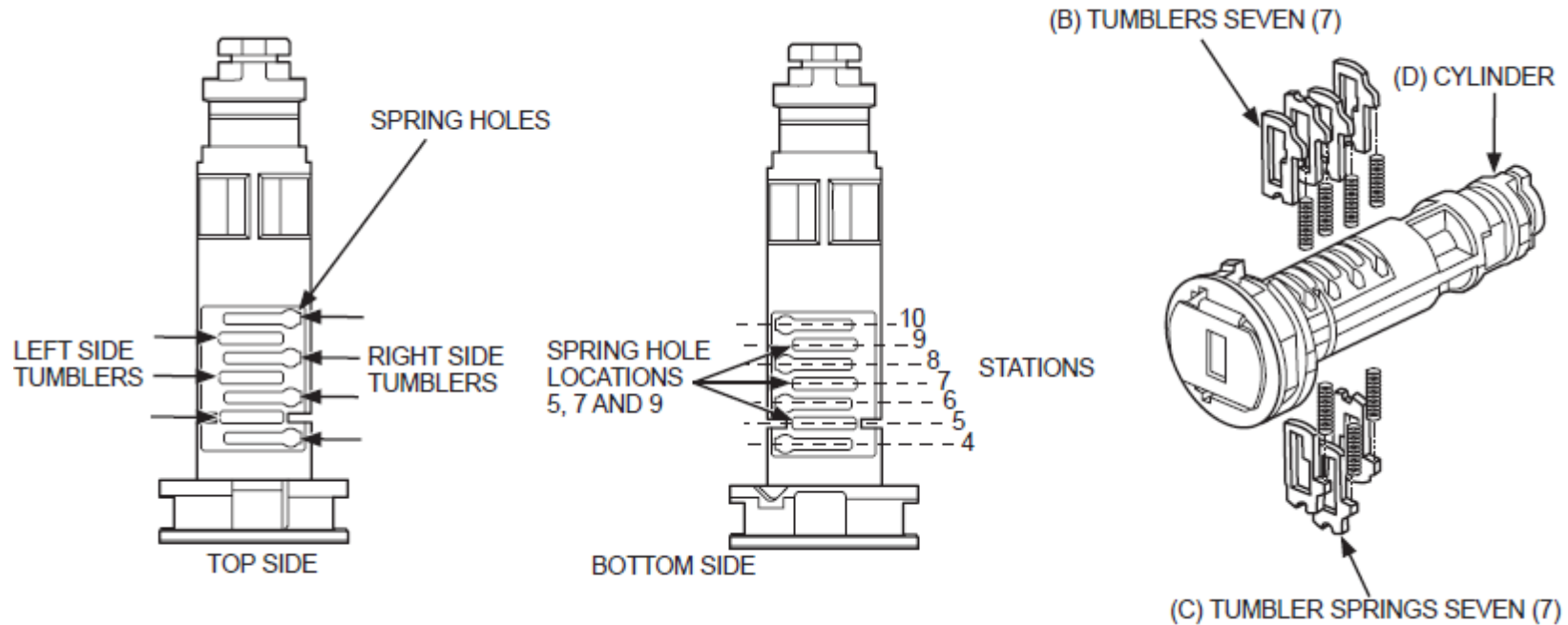


FIGURE 3

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

PINNING TRUCK SIDE MILL DOOR

8. 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, (refer to Figure 4).
9. Apply grease to detent pin pocket in Housing (E). After greasing drop Spring (L) and Detent Pin (K) into pocket in this sequence, (refer to Figure 5).

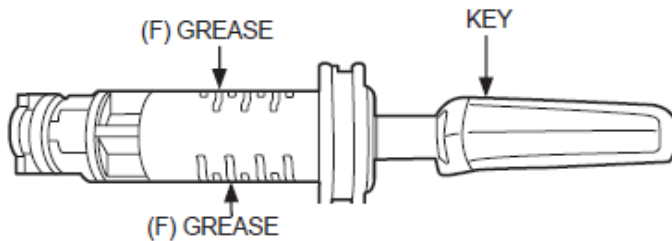


FIGURE 4

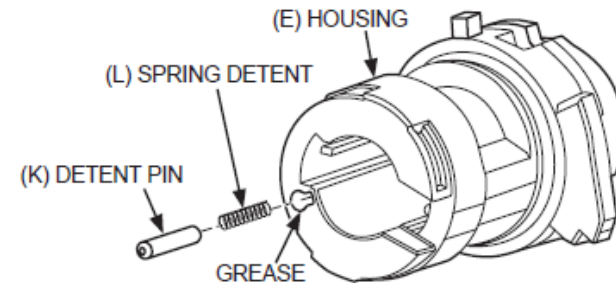
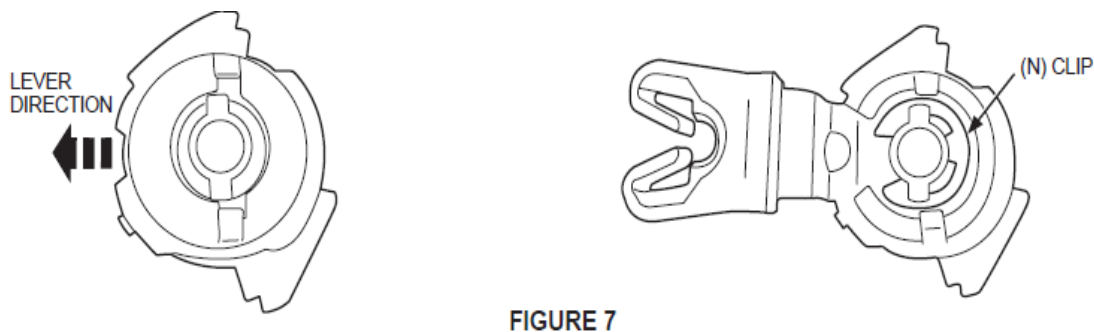
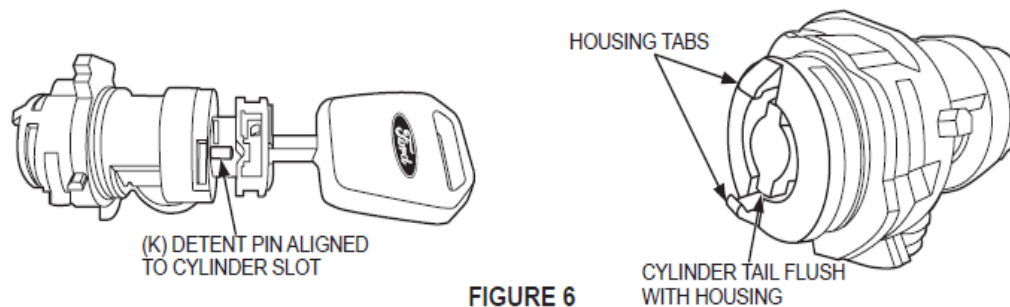


FIGURE 5

PINNING TRUCK SIDE MILL DOOR

10. Slide the tumbled and greased Cylinder (D) inside the Housing (E) with the proper orientation until cylinder tail is flush with housing (refer to Figure 6), then slide Lever (M) between the two housing tabs with the proper lever orientation (refer to Figures 6 and 7) until Lever slots are aligned with cylinder guides. Finally slide cylinder through lever and install Clip (N), (refer to Figure 7).



PINNING TRUCK SIDE MILL DOOR

11. Remove Key and install Cap (H) onto Lock. Check for proper Cap orientation (refer to Figure 8). Using a suitable punch tool deform cap at four (4) locations to secure it in (refer to Figure 8).
12. Install O-ring (P) onto Housing (E) groove (refer to Figure 9). Be sure O-ring is not rolled.
13. Use the key to check the Lock proper operation.

