

2020 FORD



IGNITION AND DOOR PINNING INSTRUCTIONS 2019 -2020 INTERNAL 2 TRACK ESCAPE/LINCOLN CORSAIR(MKC) 106 Groove



WITTE • STRATTEC • ADAC

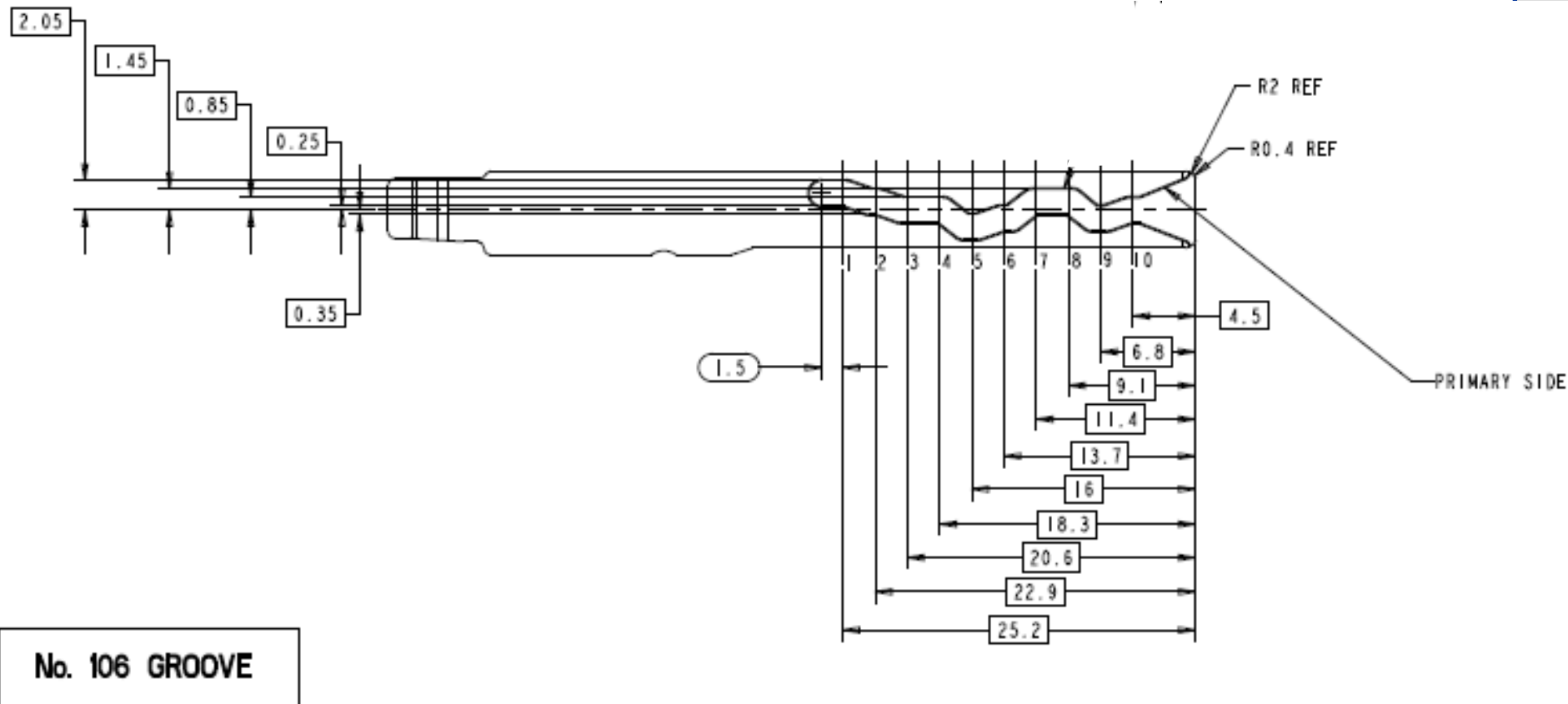


VEHICLE ACCESS SYSTEMS TECHNOLOGY

FORD 2 TRACK KEY CODE SERIES

- **Ford North America
programs Model Year 2020
CX482 (Escape) & CX483
(MKC/Corsair)**
- **Codes Series 30001-31544**

FORD 2 TRACK KEY DEPTH AND SPACING



FORD 2 TRACK CUT KEY READING

Key Reading by Cuts

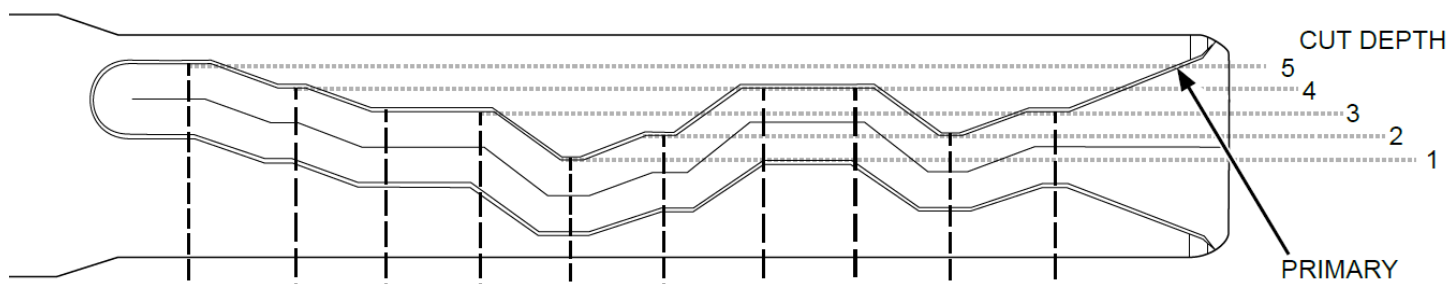
Key found in ignition education pack
Part Number - 7039965

- 1) Start with the key bow to the left and the tip of the key pointing to the right
- 2) Observe the cuts on the upper or primary half of the key
- 3) A cut nearest the centerline of the blank is a “1” cut and a cut nearest outer edge of the blank is a 5 cut
- 4) See example in next slide Figure 1 for the exercise

FORD 2 TRACK PINNING - IGNITION

■ Key reading procedure

1. Determine the matching key cut depth at each station
2. Using the cut key, measure the key cut depth at each station (refer to figure 1) and write down the corresponding key cut depths in terms of depth code, not the actual measurements of the depths in this chart.



Depth Codes	Station 1	Station 2 (L)	Station 3 (R)	Station 4 (R)	Station 5 (R)	Station 6 (R)	Station 7 (R)	Station 8 (R)	Station 9 (R)	Station 10 (R)
	Not to be used									

FORD 2 TRACK PINNING - IGNITION

Ignition Stations

- Use Stations 2 – 10 Only
- Eng Code 2087X

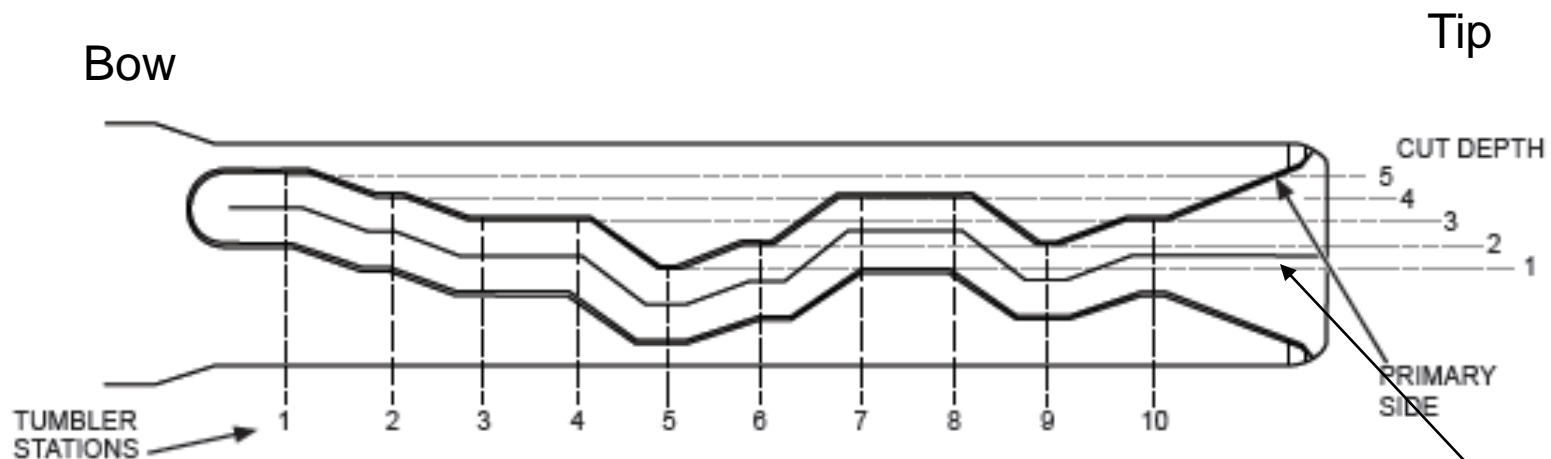


FIGURE 1

	Station 1	Station 2 (L)	Station 3 (R)	Station 4 (R)	Station 5 (R)	Station 6 (R)	Station 7 (R)	Station 8 (R)	Station 9 (R)	Station 10 (R)
Depth Codes	Not to be used	4	3	3	1	2	4	4	2	3

FORD 2 TRACK PINNING - IGNITION

Tumbler Identification and Pinning

*Tumbler bags marked as follows:

1L - 4231964 – not used	1R – 4231969 – 1 total
2L - 4231965 – not used	2R – 4231970 – 2 total
3L - 4231966 – not used	3R – 4231971 – 3 total
4L - 4231967 – 1 total	4R – 4231972 – 2 total
5L - 4231968 – not used	5R - 4231973 - not used

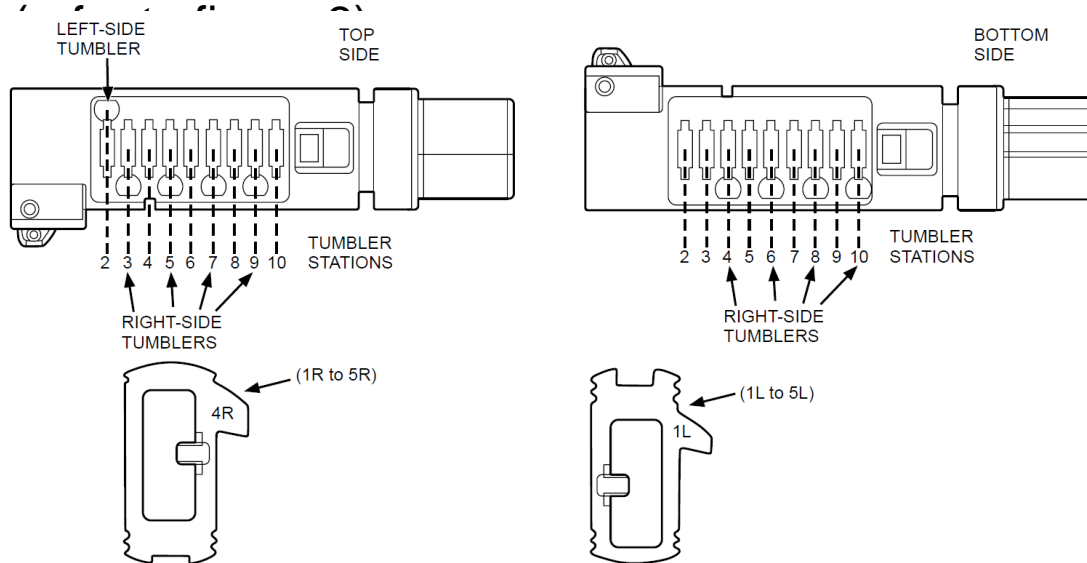
***Needed** for the exercise

FORD 2 TRACK PINNING - IGNITION

■ Cylinder Orientation and tumbler placement

3. Select the required tumblers according to the key cut depths. (refer to figure 2)

4. Insert the required tumblers into the tumbler slots (top-side) in the proper orientation



Station 1	Station 2 (L)	Station 3 (R)	Station 4 (R)	Station 5 (R)	Station 6 (R)	Station 7 (R)	Station 8 (R)	Station 9 (R)	Station 10 (R)
Not Used	4	3	3	1	2	4	4	2	3

FIGURE 2

FORD 2 TRACK PINNING - IGNITION

- Cylinder Orientation and tumbler placement

5. While holding down the tumblers, turn the cylinder and repeat steps 4 and 5 for the bottom side. (refer to figure 4)

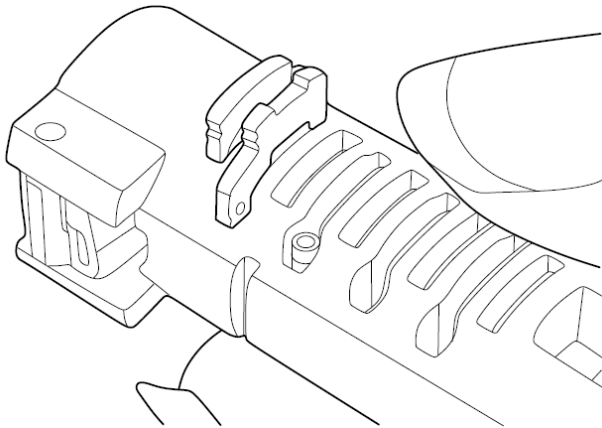
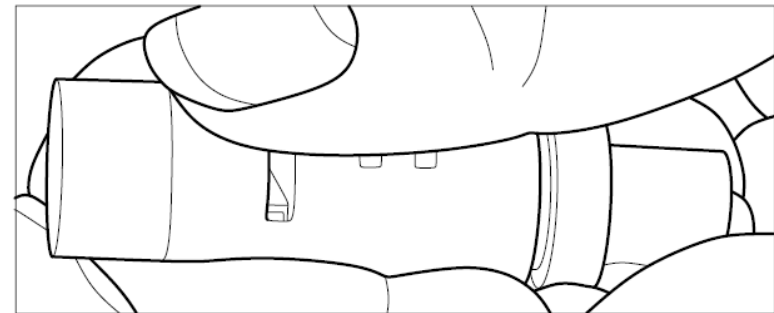
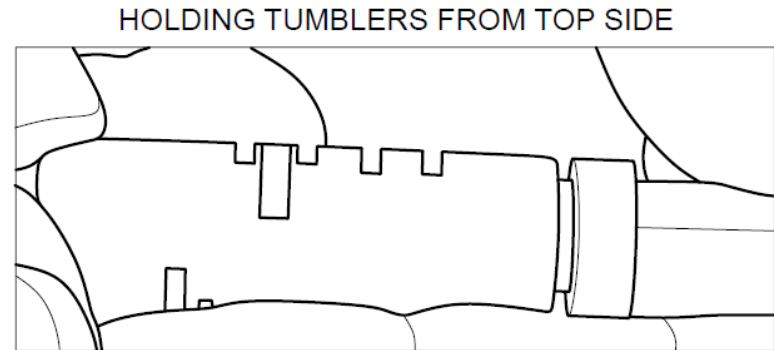


FIGURE 3



HOLDING ALL TUMBLERS PRIOR TO KEY INSERTION

FIGURE 4

FORD 2 TRACK PINNING - IGNITION

■ Assembly

6. Insert the key into the keyhole and verify that all installed tumblers are flush with the cylinder exterior surface (refer to figure 5). Do not pull the key out. If you do, the tumblers will fall out as they are not snap in or self retaining.
7. If at least one of the tumblers is not flush, carefully remove the key and verify that the tumbler selection matches the key cut depth codes. Replace tumblers as required.
8. Apply grease to the actuator (refer to figure 7) and to the outer surface of the cylinder with the key still inserted, ensuring that the areas above and in between the tumblers are coated (refer to figure 5)

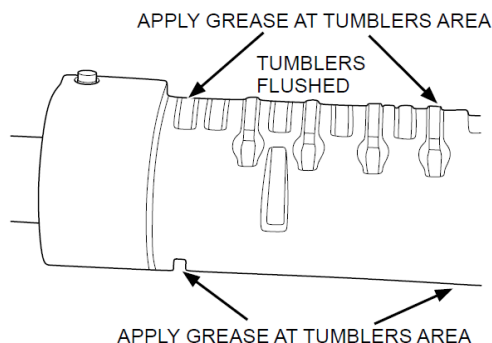


FIGURE 5

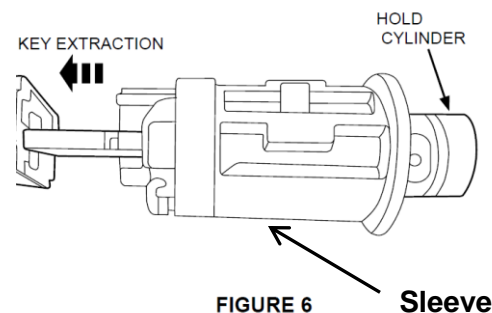


FIGURE 6

FORD 2 TRACK PINNING - IGNITION

■ Assembly

9. Slide the tumbled and greased cylinder in side the sleeve
10. Hold the back part of the cylinder and carefully remove the key (refer to figure 6). Cylinder cannot be removed from housing at this point, if this occurs, the tumblers will fall out.
11. Collocate the dust flap above the cylinder and sleeve and the locking pin at the side
12. Insert the cylinder/sleeve into the case until the locking pin pops up on the case cavity.(refer to figure 8). Don't push the cylinder otherwise the tumblers will fall out.
13. Insert the c-clip at the back part of the cylinder(refer to figure 8)
14. Insert the retainer in the case cavity on the case (refer to figure 9)
15. Assemble the leaf spring from the back of the case until the retainer pops up at the case cavity.
16. Use the key to make sure the lock is operating properly.

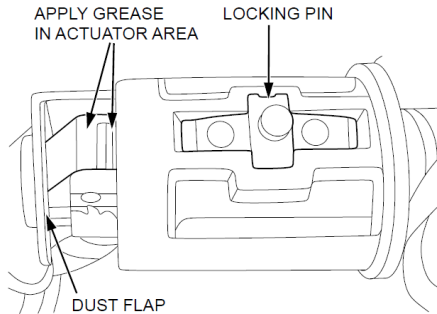


FIGURE 7

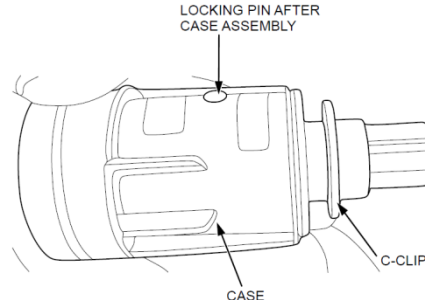


FIGURE 8

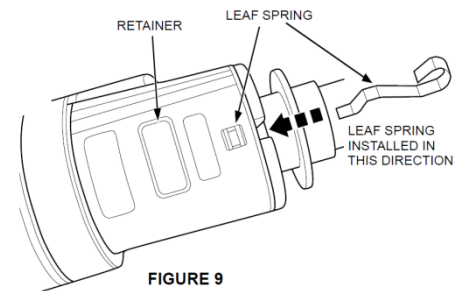


FIGURE 9