

2021 FORD

IGNITION AND DOOR PINNING INSTRUCTIONS

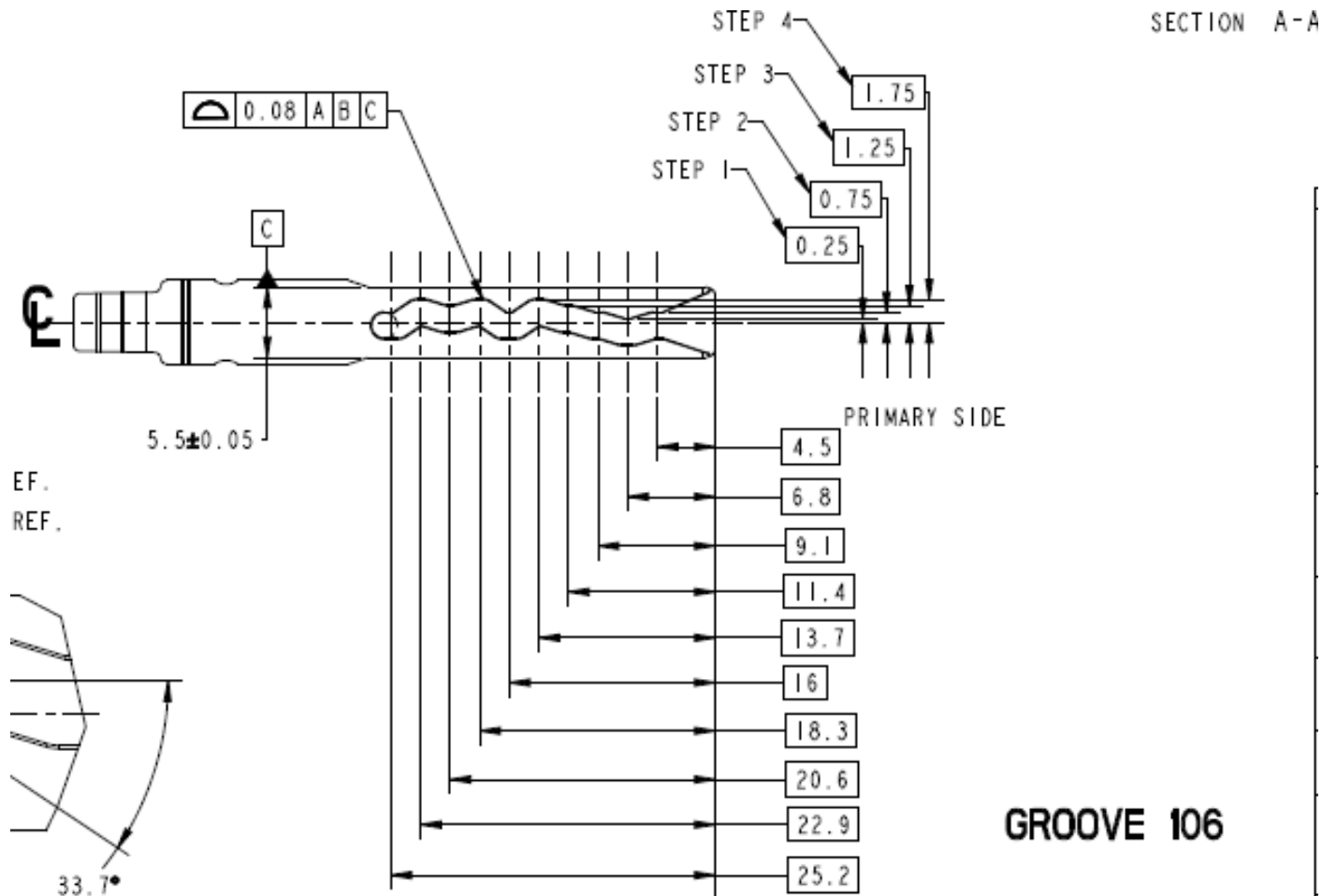
2021 F150 INTERNAL 2 TRACK



FORD 2 TRACK KEY CODE SERIES

- **Ford North America programs Model Year 2021 and 2021 F150, More vehicles to follow with keyway**
- **Codes Series P0001-P3711**

FORD 2 TRACK KEY DEPTH AND SPACING



FORD 2 TRACK CUT KEY READING

Key Reading by Cuts

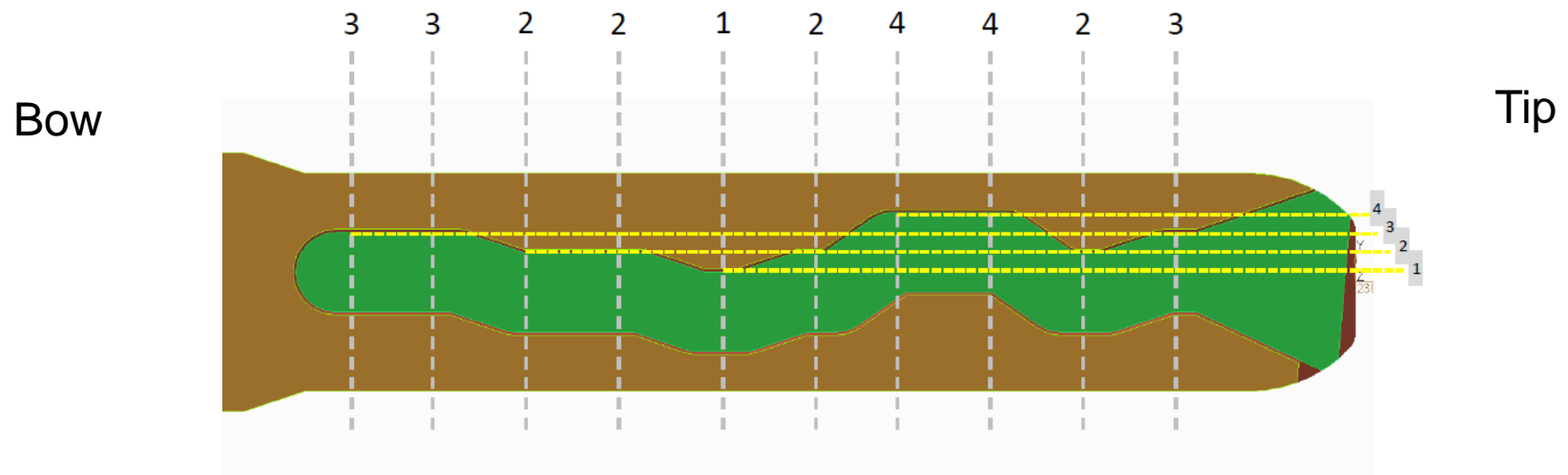
Key found in ignition education pack
Part Number - 7041165

- 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 4 cut
- 4) See example in next slide Figure 1 for the exercise

FORD 2 TRACK PINNING – F150 IGNITION

Ignition Stations

- Use Stations 1 – 10



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)
3	3	2	2	1	2	4	4	2	3

Figure 1

FORD 2 TRACK PINNING – F150 IGNITION

Tumbler Identification and Pinning

*Tumbler bags marked as follows:

1L - 4236825 – 1 total	1R – 4236821 – not used
2L - 4236826 – 2 total	2R – 4236822 – 2 total
3L - 4236827 – 1 total	3R – 4236823 – 2 total
4L - 4236828 – 1 total	4R – 4236824 – 1 total

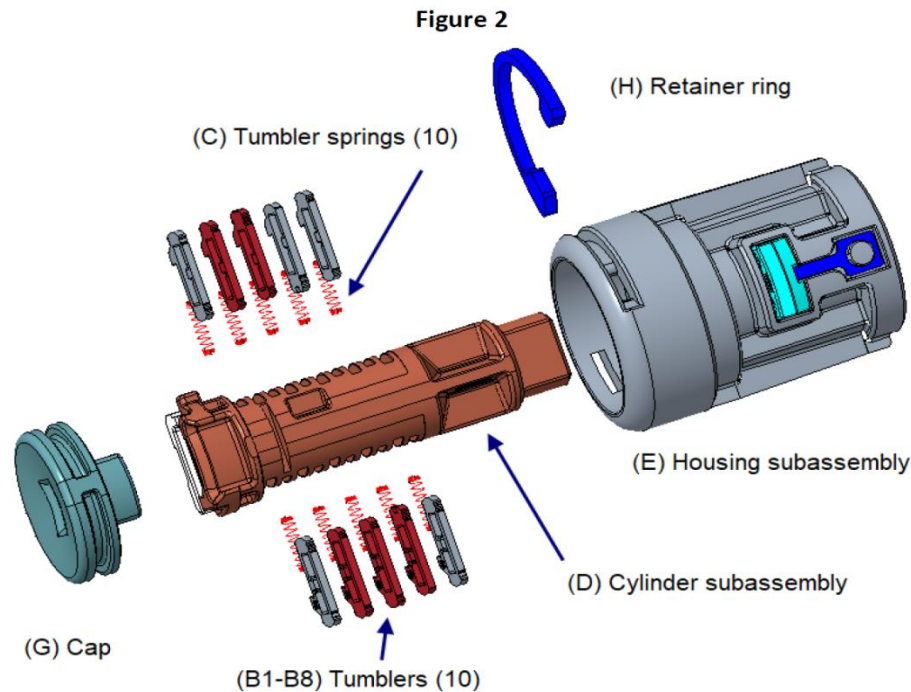
***Needed** for the exercise

FORD 2 TRACK PINNING - IGNITION

■ Cylinder Orientation and tumbler placement

5. Select the required tumblers according to the key cut depths (refer to figure 1)

6. Insert one tumbler spring (4631974) into each of the holes located at the end of the tumbler wards on the lock cylinder subassembly top side (refer to figures 2 and 3)



Note: Four (4) Spring Holes on top & four (4) spring holes on bottom

FORD 2 TRACK PINNING - IGNITION

- Cylinder Orientation and tumbler placement

Figure 3

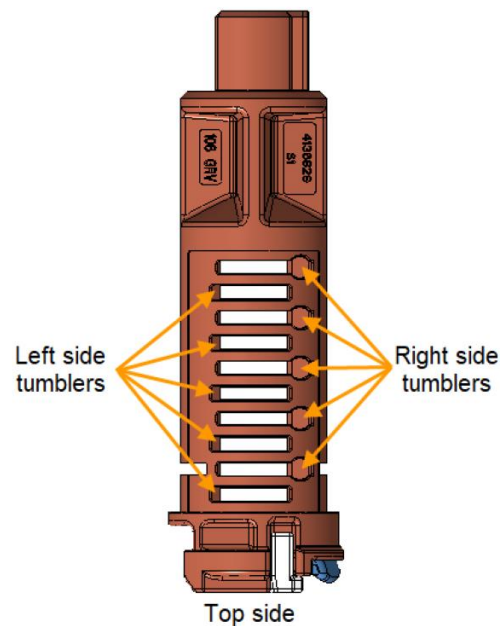
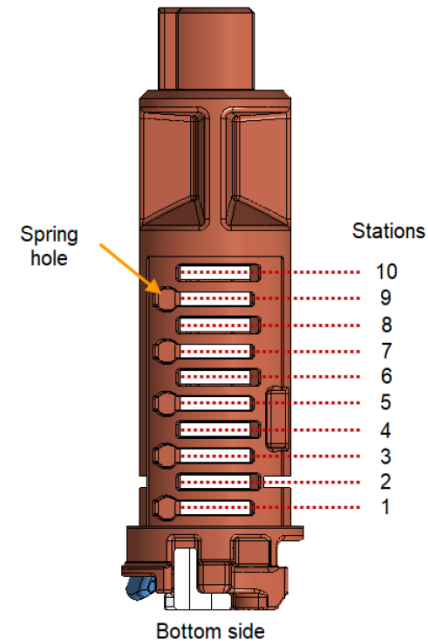


Figure 4

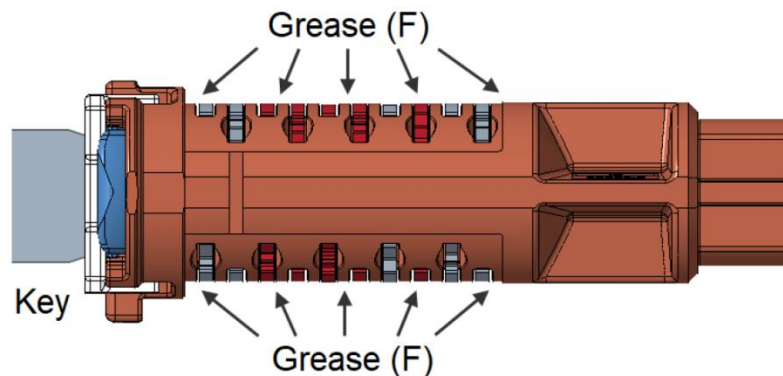


FORD 2 TRACK PINNING – F150 IGNITION

■ Cylinder Orientation and tumbler placement

7. Insert the required tumblers into the tumbler slots (top side) in the proper orientation(refer to figures 2 and 3), and in the sequence that match the key cut depths for stations 1 through 10.
8. While holding down the tumblers, turn the cylinder subassembly and repeat steps 6 and 7 for the bottom side(refer to figure 2 and 4)
9. Insert the key into the keyhole and verify that all installed tumblers are flush with the cylinder subassembly exterior surface.

Figure 5



FORD 2 TRACK PINNING – F150 IGNITION

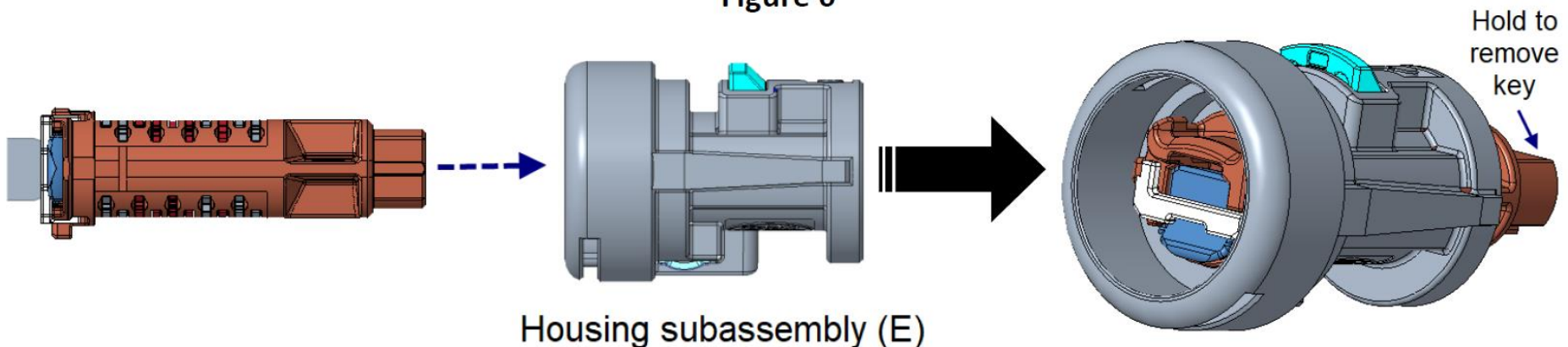
■ Cylinder Orientation and tumbler placement

10. Apply grease to the outer surface of the cylinder subassembly with the key still inserted, ensuring that the areas above and in between the tumblers are coated (figure 5)

11. Slide the tumbled and greased cylinder subassembly into the housing by rotating the cylinder counterclockwise until the stop is reached (Figure 6)

12. Hold the back part of the cylinder and carefully remove the key (figure 6) If the cylinder is not held tight during key removal, tumblers can fall out.

Figure 6



FORD 2 TRACK PINNING – F150 IGNITION

■ Cylinder Orientation and tumbler placement

13. Drop the cap into the cylinder housing sub assembly aligning the cap protrusion with the cylinder slot (refer to figure 7)

14. Insert the key once again to bring the cap flush with the housing (figure 7)

15. With the key inserted and in the OFF position, assemble the bigger tab of the retainer ring into the appropriate housing slot (figure 8), then apply pressure over the retainer ring to pre-align it into the housing ring groove (figure 9)

Figure 7

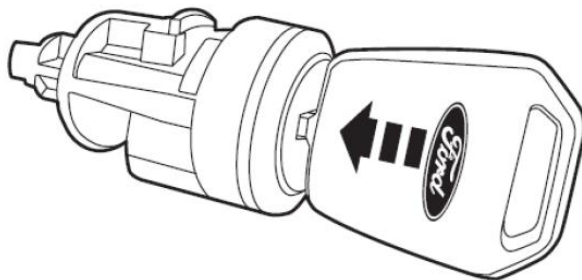


Figure 8



Figure 9



FORD 2 TRACK PINNING – F150 IGNITION

■ Cylinder Orientation and tumbler placement

16. With the help of a suitable rigid surface, fully insert the smaller side of the retainer ring into the corresponding housing slot by rotating the assembly while pushing it down against the ring (figure 10)

17. Verify the function of the lock with the key inserted.

Figure 10

