

**2021 FORD**

# **IGNITION AND DOOR PINNING INSTRUCTIONS**

## **2021 F150 INTERNAL 2 TRACK**

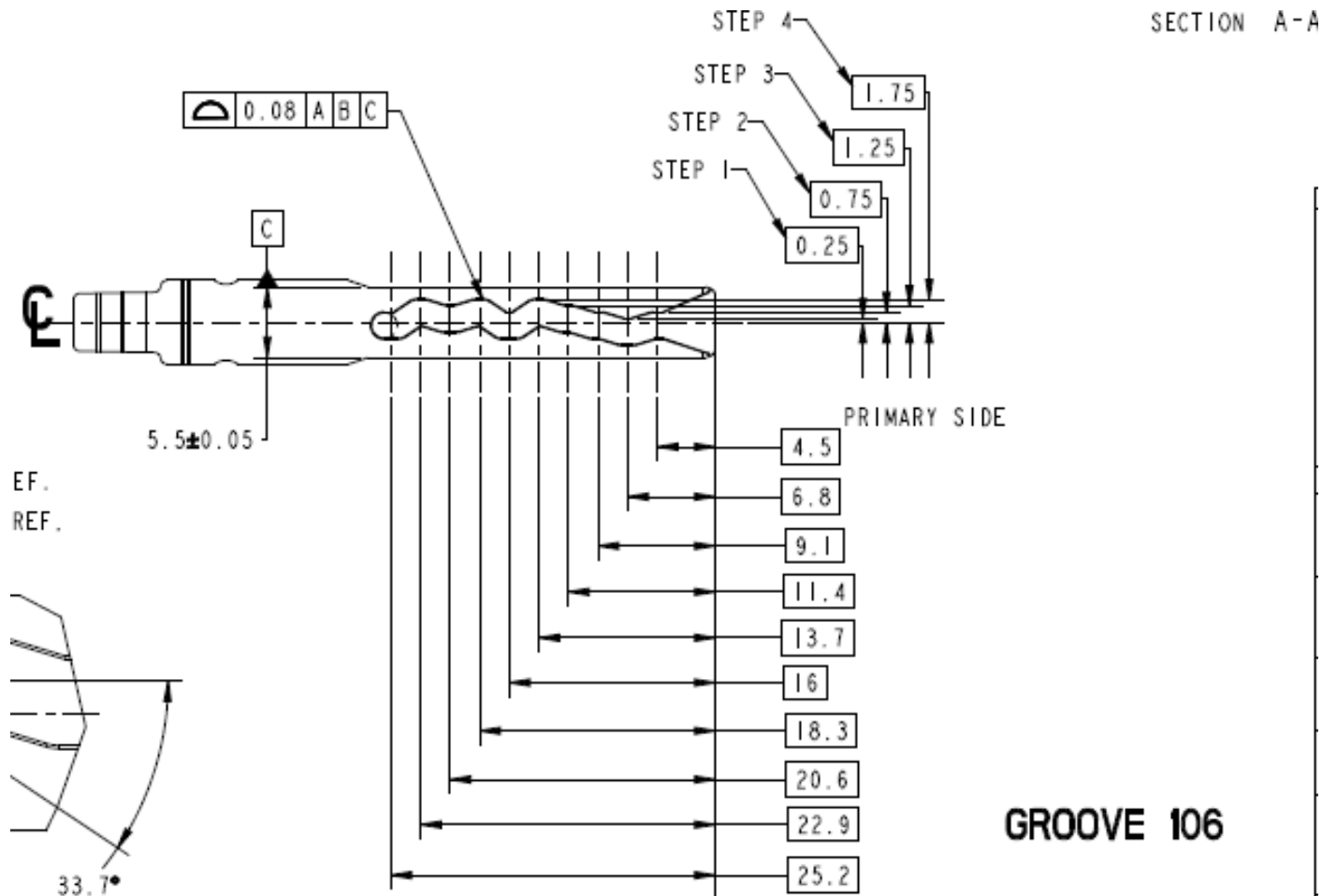


## **FORD 2 TRACK KEY CODE SERIES**

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- **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 door education pack Part  
Number - 7041164

- 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 Door

## Door Stations

- Use Stations 1 – 10

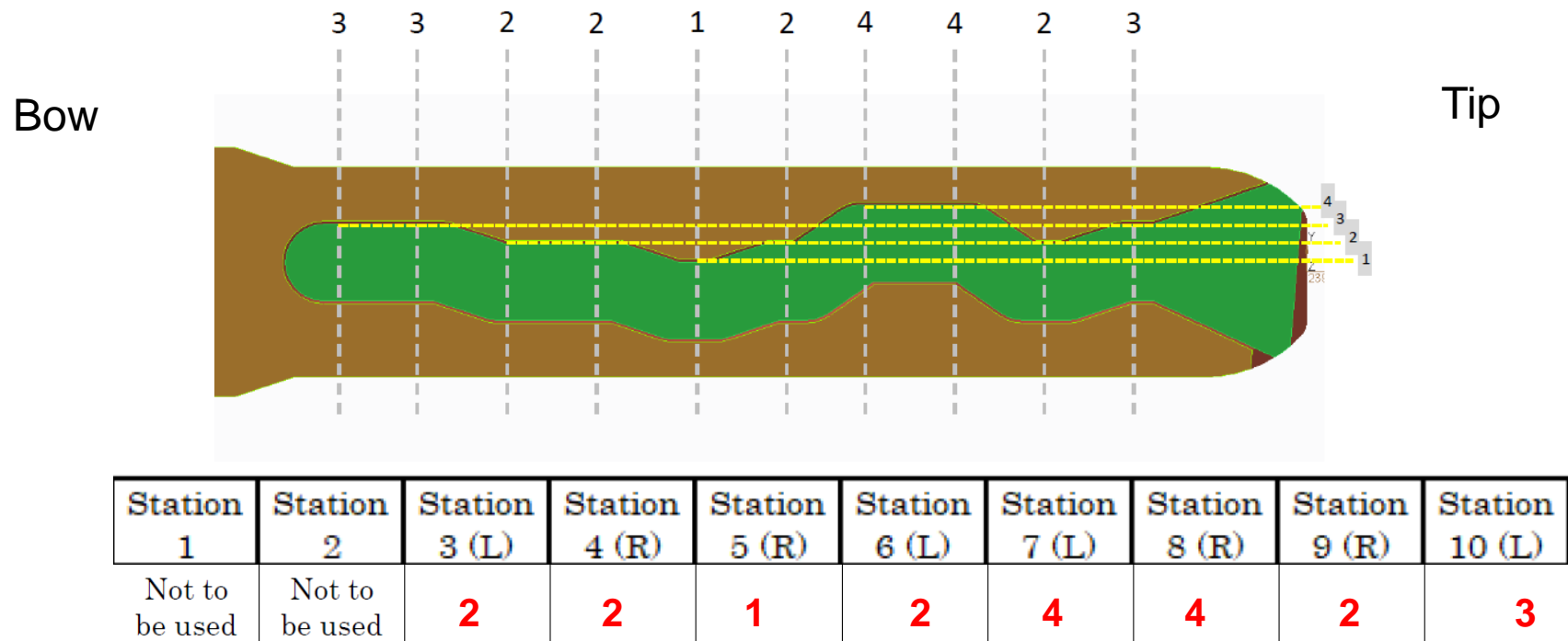


Figure 1

# FORD 2 TRACK PINNING – F150 Door

## Tumbler Identification and Pinning

\*Tumbler bags marked as follows:

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

\***Needed** for the exercise

# FORD 2 TRACK PINNING – F150 DOOR

## ■ Cylinder Orientation and tumbler placement

5. Insert one tumbler spring (4631974) into each of the holes located at the end of the tumbler wards on the lock cylinder top side ( figure 2) **Note - Stations 1 and 2 are not used in the door lock**

6. Insert the required tumblers into the tumbler slots (Top side) in the proper orientation and in the sequence that match the key cut depths for stations 3 -10(refer to figure 2)

7 While holding down the tumblers, turn the cylinder and repeat steps 5 and 6 for the bottom side (refer to figure 3)

Figure 2

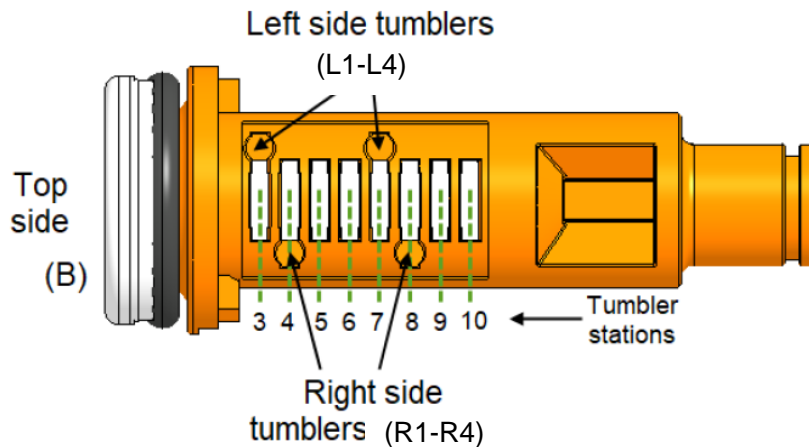
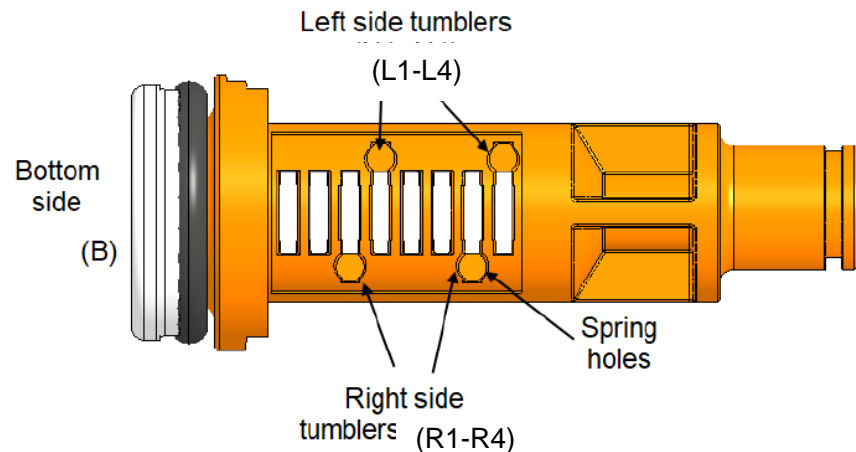


Figure 3



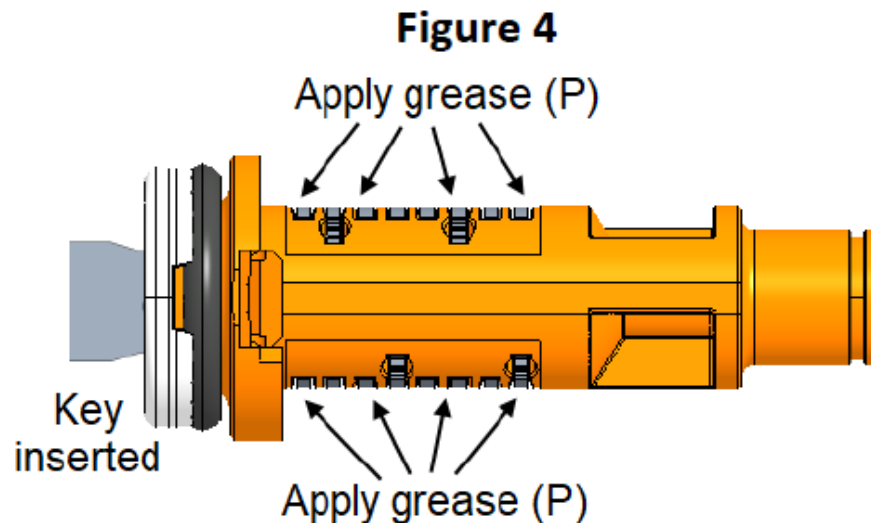
# FORD 2 TRACK PINNING – F150 DOOR

## ■ Cylinder Orientation and tumbler placement

8. Insert the key into the keyhole and verify that all installed tumblers are flush with the cylinder exterior surface (refer to figure 4). Do not pull out the key. Tumblers will fall out!

9. If at least one of the tumblers is not flush, carefully remove the key and verify that the tumbler selection matches to the key cut depth codes. Replace the tumblers as required.

10. Apply grease 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 4)





# FORD 2 TRACK PINNING – F150 DOOR

## ■ Cylinder case assemble

11. Slide the tumbled and greased cylinder(B) into the sleeve (G) (refer to figure 5)

12. Hold the back part of cylinder (B) and carefully remove the key. (refer to figure 6).

The cylinder cannot be removed from the sleeve (G) at this point; if this occurs, the tumblers will fall out.

13. Slide the cylinder/sleeve assembly into the case (D) through the bigger diameter by pushing the sleeve (G) out(refer to figure 7). Do not push the cylinder; if this occurs, the tumblers will fall out.

Figure 5

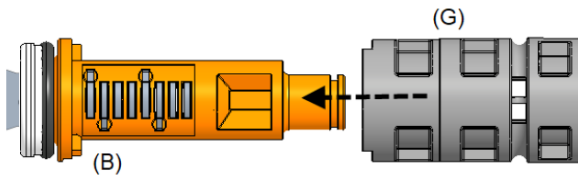


Figure 6

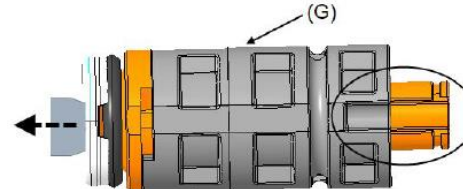
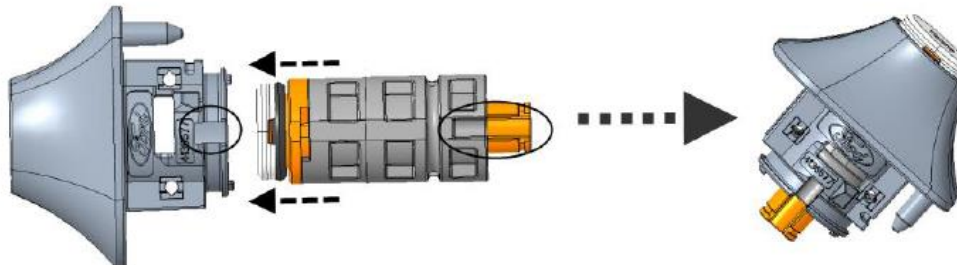


Figure 7



# FORD 2 TRACK PINNING – F150 DOOR

## ■ Cylinder case assembly

14. Use a chisel or punch to deform both stacking points at the top side of the case (D) (refer to figure 8)
15. Insert each retainer bar (H) to the stacking points from the bottom side of the case (D) (refer to figure 9)
16. Verify the retainer bars (H) are under flush of the stacking points and deform the stacking points to keep the retainer bars (H) into position (refer to figure 9)

Figure 8

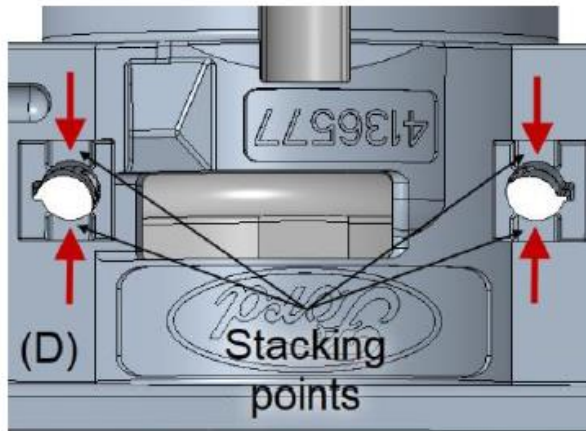
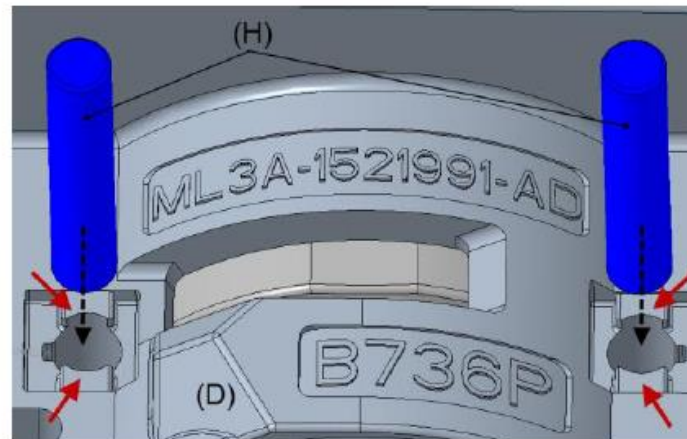


Figure 9



# FORD 2 TRACK PINNING – F150 DOOR

## ■ Cylinder case assembly

17. Align the sleeve (G) and case (D) cavity for the roller(J) and insert the roller (J) (refer to figure 10)

18. Assemble the spiral spring (I) around the case (D) cavity and roller (J) with at least 2 spring coils against the roller (J) (refer to figure 11).

Figure 10

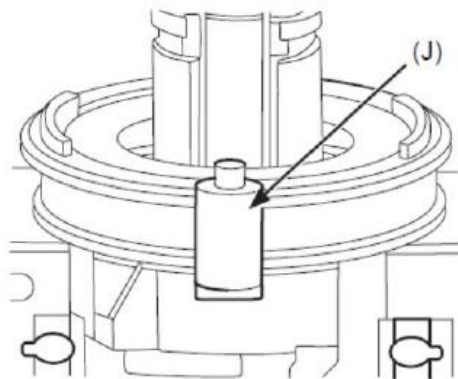
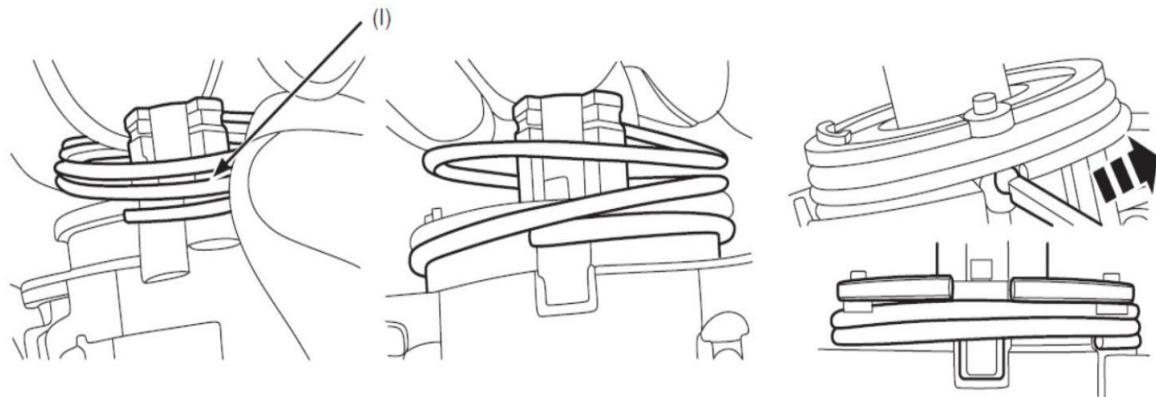


Figure 11



# FORD 2 TRACK PINNING – F150 DOOR

## ■ Cylinder case assembly

19. Collocate the clutch (K) and lever (E) onto the back part of the cylinder (B) and hold them with the retainer ring (F) by using retainer ring pliers ( refer to figures 12 and 13)
20. Install the gasket (M) ( refer to figure 14 )
21. Use the key to check proper operation of the lock.

Figure 12

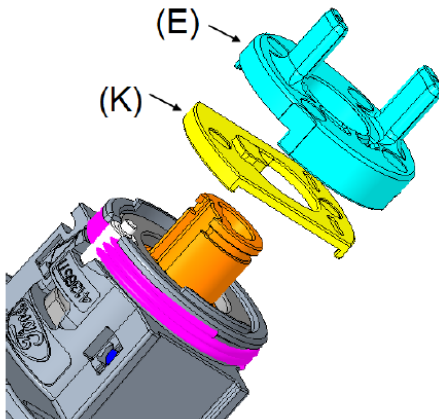


Figure 13

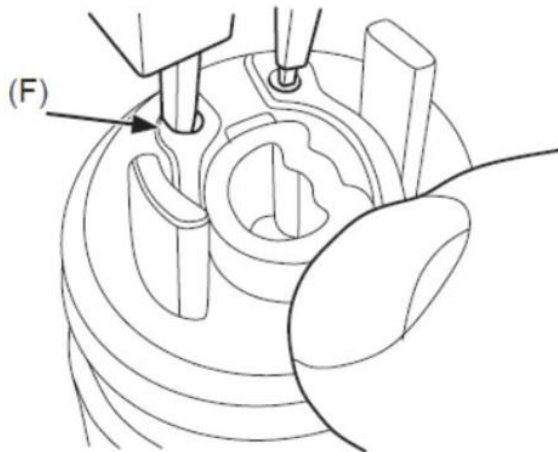


Figure 14

