

## Sargent 6300 LFIC Pinning Worksheet

<http://www.lockreference.com>

<b>PINNING CHART</b>						
1. TOP PIN						
2. BUILD-UP PIN						
3. MASTER PIN (if applicable)						
4. BOTTOM PIN						
<b>Verify that sum of rows equal:</b>	15	15	20	20	15	15

TOP MASTER KEY BITTING						
OPERATING/CHANGE KEY BITTING						

CONTROL KEY BITTING						
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### Sargent 6300 LFIC Combining Rules

1. Stack height of non-control chambers must equal 15, control chambers must equal 20.
2. Non-control chambers are combined in conventional manner.
3. For control chambers the rules are as follows:
  - a. **Top** pin formula:  $12 - \text{Control Cut} = \text{Top Pin}$
  - b. **Build-Up** pin formula:  $(\text{Control Cut} + 8) - (\text{Plug Total}) = \text{Build-Up Pin}$
  - c. **Master** pin length is determined by the deepest cut minus the shallowest operating cut.
  - d. **Bottom** pin length is determined by shallowest operating cut.
4. Since 1/1/99, Sargent uses hollow top pins and special diameter springs in control chambers. Make sure to use the appropriate pins and springs when pinning.

<u>Bottom Pins</u>		<u>Build-Up/Master/Top Pins</u>	
1 = .170"	6 = .270"	2 = .040"	9 = .180"
2 = .190"	7 = .290"	3 = .060"	10 = .200"
3 = .210"	8 = .310"	4 = .080"	11 = .220"
4 = .230"	9 = .330"	5 = .100"	12 = .240"
5 = .250"	10 = .350"	6 = .120"	13 = .260"
		7 = .140"	14 = .280"
		8 = .160"	