Pinning Chart for Sargent Degree LFIC

PINNING CHART

1. TOP PIN
2. BUILD-UP PIN
3. MASTER PIN (if applicable)
4. BOTTOM PIN/ANGLE

Verify that sum of rows equal: 10 10 13 13 10 10

TOP MASTER KEY BITTING/ANGLE
OPERATING/CHANGE KEY BITTING/ANGLE
CONTROL KEY BITTING/ANGLE

Sargent Degree LFIC Combinating Rules

1. DG1 cores and cylinders do not use angled bottom pins, DG2/DG3 do.
2. For DG2/DG3, same angle is used across all levels of keys.
3. Stack height of non-control chambers must equal 10, control chambers must equal 13.
4. Non-control chambers are combined in conventional manner.
5. For control chambers the rules are as follows:
   a. Top pin formula: 7 - Control Cut = Top Pin
   b. Build-Up pin formula: (Control Cut + 6) - (Plug Total) = Build-Up Pin
   c. Master pin length is determined by the deepest cut minus the shallowest operating
   d. Bottom pin length is determined by shallowest operating cut.
6. Angled bottom pins can not be used in the 6th chamber due to space limitations in the core's design.

Sargent's conical pins (Sargent Part No. DG-0021 through DG-0026) must only be used in this chamber.
Substitute equivalent depths between angled and conical pins.