

## Pinning Chart for Sargent Degree LFIC

<b>PINNING CHART</b>						
1. TOP PIN						
2. BUILD-UP PIN						
3. MASTER PIN (if applicable)						
4. BOTTOM PIN/ANGLE	/	/	/	/	/	
<b>Verify that sum of rows equal:</b>	10	10	13	13	10	10

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

CONTROL KEY BITTING/ANGLE	/	/	/	/	/	/
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### 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 combinated 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 cut.
  - 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.