

Sargent 6300 LFIC Pinning Worksheet

PINNING CHART						
1. TOP PIN						
2. BUILD-UP PIN						
3. MASTER PIN (if applicable)						
4. BOTTOM PIN						
Verify that sum of rows equal:	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 1/1/09, Sargent uses hollow top pins and special diameter springs in control chambers.
Make sure to use the appropriate pins and springs when pinning.

Bottom Pins

1 = .170"	6 = .270"
2 = .190"	7 = .290"
3 = .210"	8 = .310"
4 = .230"	9 = .330"
5 = .250"	10 = .350"

Build-Up/Master/Top Pins

2 = .040"	9 = .180"
3 = .060"	10 = .200"
4 = .080"	11 = .220"
5 = .100"	12 = .240"
6 = .120"	13 = .260"
7 = .140"	14 = .280"
8 = .160"	