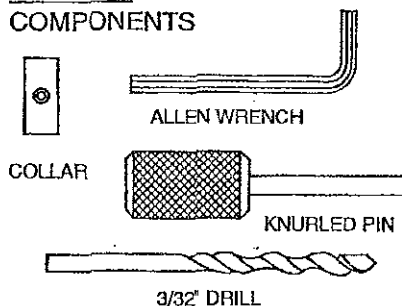


439 FIELD CONSTRUCTION KEYING KIT USED FOR SARGENT CONVENTIONAL CYLINDERS ONLY

FIGURE A
COMPONENTS



Drilling Block (See Fig. B)
1mm Balls (Qty. 500)

FIGURE B
SETTING DRILL DEPTH

Hold drill firmly in bottom of adjusting hole. Slip on collar, push against block, and tighten set screw.

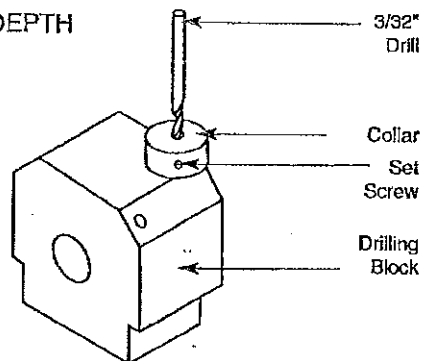
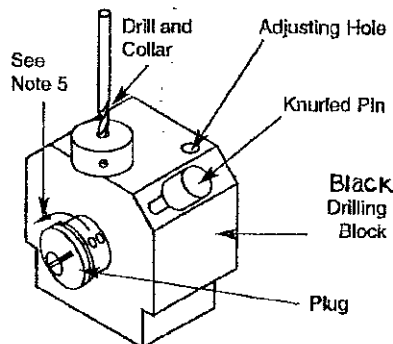


FIGURE C
DRILLING THE PLUG

Procedure for drilling holes in cylinder plug

1. Chamber to be used for construction key (lost ball) load is determined by the bitings selected in the master key system.
2. Insert plug into drilling block.
3. Insert knurled pin thru drilling block into plug pin hole.
4. Drill as shown in Fig. C.
5. Rotate plug 70° and drill the opposite side in the same manner.

TO ASSURE PROPER HOLE DEPTH, BE SURE COLLAR CONTACTS DRILLING BLOCK



INSTRUCTIONS FOR FIELD KEYING OF LOST BALL CONSTRUCTION MASTER KEYING:

Creating a New Field Generated Master Key System Using the Lost Ball Feature

- The lost ball feature can only be used in chambers 2 through 5. For XC cylinders use chambers 3 through 6
- Using the fixture, drill the plug of the cylinder in two places in the location of the chamber selected for the construction feature
- The construction balls (3) should be placed between the bottom pin and master split in the chamber selected for the construction feature
- The chamber to be used for the lost ball feature is determined by the biting selections in the Master Key System
- The biting of the Top Master Key (TMK) for the system must always contain a #8 cut between positions 2 through 5 for standard cylinders and 3 through 6 for XC
- The position on the TMK that was chosen for the #8 cut should always be used when generating change key bitings for the construction key system
- Always use the change key to void the construction feature
- The Construction Master Keys (CMK) will have a #10 biting cut in the same position as the TMK's #8 biting, all other bitings will be the same as the TMK

Introducing the Lost Ball Feature into an Existing Master Key System

- If the existing master key system's TMK has a #8 cut in its biting and the #10 cut has not been used for any key in that position, then the lost ball feature can be added to the system
- If the system is a Grand Master level or higher and the master level keys have been selected in this position, the lost ball feature would have to be voided by the master level keys instead of the change keys
- If the key system is existing and the TMK does not have a #8 biting, contact the SARGENT Key Records department to determine if Construction Keying Mastering is feasible