



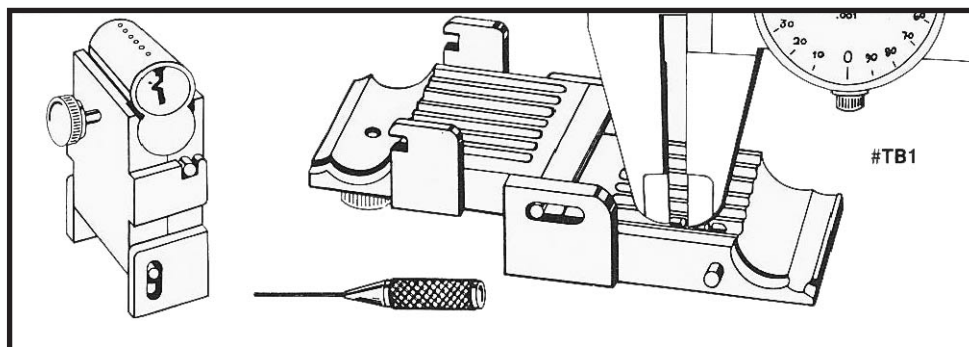
THE DE CODING BLOCK

#TB1



1. Before use, make sure "THE BLOCK" is free from dirt and chips. If the core to be decoded was removed by drilling, be sure it is free from chips before it is inserted into THE BLOCK
2. To prevent accidental opening when filled with pin stacks, THE BLOCK cannot be opened with a core in place. As a result, THE BLOCK must be in a fully closed position before a core is able to slide into it from the side. Also, the red set screw must be backed out to allow entry of the core.
3. Slide the core into THE BLOCK so that its small ejector holes face outward so that the core's control lug faces away from THE BLOCK's set screw. When properly inserted, the core's face will be flush with the left-hand edge of the tool as it is viewed from the front.
4. Tighten the set screw and place THE BLOCK in an upright position.
5. Gently drive an ejector pin down through the small holes; be sure to push the pin stacks all the way into the tool.
6. Place "THE BLOCK" in a horizontal position, loosen the set screw, and then carefully slide the core from "THE BLOCK".
7. Slide the upper portion of THE BLOCK back and swing it open until the set screw rests on the bench surface.

To use "THE BLOCK" for FALCON interchangeable cores, the spring cover and springs must be removed first. If desired, the cover may be released while the core is in "THE BLOCK" by driving an ejector pin down into two or more chambers. By placing the tool in a horizontal position, the core is able to slide out to the side where the springs and cover are removed. After reinserting the core, place "THE BLOCK" in a vertical position and proceed as in the previous instructions.



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DECODING FOR CONTROL KEY BITTING WITH 'THE BLOCK'

Using dial calipers as in the illustration on the other side, it is not necessary to remove the pins (wafers) from 'THE BLOCK' to measure their lengths.

It is a good idea to first measure the total heights of each of the pin stacks- they should all be the same. If any of the stacks are shorter or longer than the others, this will usually indicate that an incorrect top pin was used in that stack. Add the amount the top pin is too short, or subtract the amount the top pin is too tall from the length that the top pin should be.

Example: All stacks but one measure .400, one stack measures .436. Since $.436 - .400 = .036$, the correct top pin length will be .036 less than the one currently in the stack.)

Since there are three different increment systems used in interchangeable cores, it is important to be sure which system the core you have was pinned to. By measuring the lengths of at least two pins and locating their length in one of the following charts, their system may be determined:

A2 SYSTEM

2/.025	5/.062	8/.100	11/.137	14/.175	17/.212
3/.037	6/.075	9/.112	12/.150	15/.187	18/.225
4/.050	7/.087	10/.125	13/.162	16/.200	19/.237

(A3) SYSTEM

1- .018	4- .072	7- .126	10- .180	13- .234
2- .036	5- .090	8- .144	11- .198	
3- .054	6- .108	9- .162	12- .216	

Once the system in use has been determined and all of the top pins have been found to be correct (or any that were incorrect have had their amount noted), measure the top pins to find their control key bitting in accordance with the following:

A2 SYSTEM

1. Measure the top pin's decimal length.
2. Divide the decimal by .0125 (to the nearest whole number).
3. Subtract the number from 13. This is the control bitting.

A3 SYSTEM

1. Measure the top pin's decimal length.
3. Divide the decimal by .018 (to the nearest whole number).
3. Subtract the number from 9. This is the control bitting.