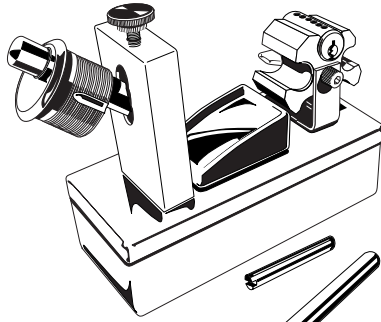


# Instructions



## Illuminated Pin Station

No. IPIN-99



### PLUG DIAMETERS:

.404" / 10.26mm  
.504" / 12.80mm  
.508" / 12.90mm  
.512" / 13.00mm  
.556" / 14.12mm

### FOLLOWER DIAMETERS:

.395" / 10.00mm	Green	No. IF-395
.495" / 12.60mm	Red	No. IF-495
.550" / 14.00mm	Amber	No. IF-550

This station comes with illuminated followers that brighten up the inside of cylinder housings with natural light, and a multi-size plug holder. Use center hole in box to secure to your work bench. **NOTE: Keep screw loose enough to allow station to pivot, allowing you to work on each side.**

### INSTRUCTIONS:

1. Match correct size slot in multiple plug holder and insert plug with chambers facing up as shown in Fig. 1.
2. Load bottom pins into plug as shown in Fig. 2.
3. Select correct size translucent follower and position into retainer and secure as shown in Fig. 3.
4. Position cylinder housing onto the end of the translucent follower as shown in Fig. 4.

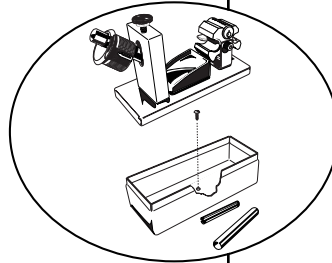


Fig. 1

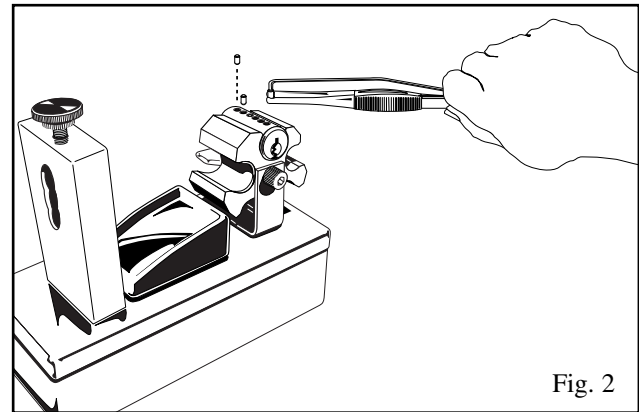


Fig. 2

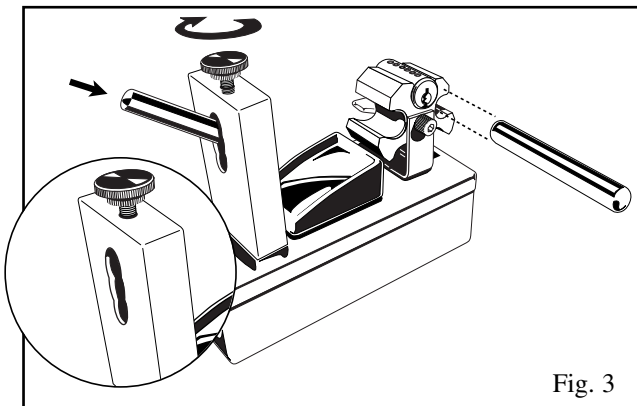


Fig. 3

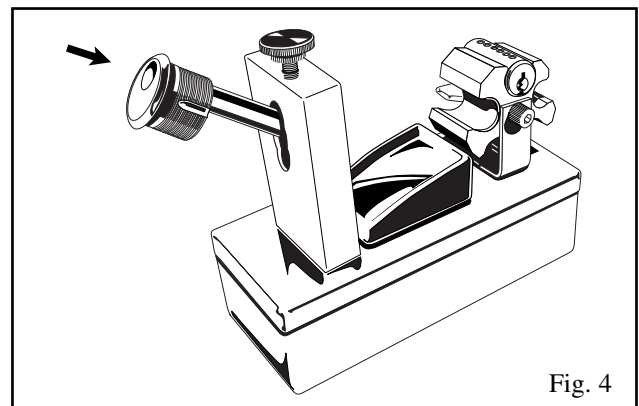


Fig. 4

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(continued)

## Illuminated Pin Station instructions (continued)



5. Using HPC Pin Tumbler Tweezers with Pin Pushing Attachment (No. TPT-5), load springs and top pins into cylinder housing and move cylinder housing toward follower as chambers are filled as shown in Fig. 5. The mirror will reflect light into the translucent follower and illuminate the inside of the cylinder housing.
6. Continue loading springs and top pins until all chambers are filled. See Fig. 6.
7. Remove plug from multiple plug housing and align with protruding end of follower. See Fig. 7.
8. Introduce plug into housing, sliding cylinder housing upward from follower to assemble lock as shown in Fig. 8.

