Sargent Degree (DG2 & DG3)

MACS: 4

Increment: .030"

Progression: Single Step

E.P.D. .502"

Included Angle: 86°

Root Cut: .015"

Key Origination	
Blackhawk	N/A
CodeMax	DSD #390
HPC Blitz	C390
HPC Punch	N/A
ITL	298

Root Depths*		
Number	Actual	Reference
1	.271"	.259"
2	.241"	.229"
3	.211"	.199"
4	.181"	.169"
5	.151"	.139"
6	.121"	.109"

Spacing	
1	.244"
2	.414"
3	.584"
4	.754"
5	.924"
6	1.094"

T.F.C: .244"

B.C.C: .170"

	Left	Center	Right
Cut Angles	-20°	0°	+20°

Notes
1) Read and cut bow-to-tip.
2) Chambers 1-5 use L, C, R angled pins. Chamber 6 uses same bottom pins (conical) as for DG1 cylinders.
3) Actual depths are as measured with a micrometer.
4) ITL uses 3M3 insert.

	1	2	3	4	5	6	7	8	9	
Bottom Pins	.231"	.261"	.291"	.321"	.351"	.381"				
Master Pins	.030"	.060"	.090"	.120"	.150"					
Driver Pins	.030"	.060"	.090"	.120"	.150"	.180"	.210"	.240"	.270"	

	1	2	3	4	5	6	7	8	9	
Control Drivers (LFIC)	.030"	.060"	.090"	.120"	.150"	N/A	.210"	.240"	.270"	
	10	**11**								
	.300"	.330"								

*Degree cylinders have constant plug totals. For fixed cores and non-control chambers in LFIC stack height is 10, for LFIC control chambers stack height is 13.

Notes: