

SERVICE PROCEDURE:

1. Determine the matching key cut depth at each key station, any of the following three methods may be used to determine the key cut depth at each key station.
 - 1a. Use the OEM key code provided with the vehicle and look up the cut pattern in the key code table. (The selling dealer should have the key code or the customer may be able to provide it.) A key code table comes with the Rotunda Key Cutter, Part No. 011 00215.
 - 1b. Use a "key decoder" to determine each cut height. A decoder may be included with the Rotunda Key Cutter, Part No. 011 00215 or can be ordered separately through Rotunda Part No. 011 RMT61. Equivalent decoders are commonly available through the locksmith industry. (A key decoder is a plate with an elongated slot corresponding to the different key cut heights.)
 - 1c. Using the customer's key, measure the key cut depth at each key station (refer to Figure 1).

Write down the key cut depths, in terms of the depth code, not the actual measurements of the depths, in the following order:

Station 1	Station 2	Station 3	Station 4	Station 5	Station 6	Station 7	Station 8
						X	X

2. Insert the detent spring (I) into groove located on the interior surface of the lock case (F).
3. Insert the detent pin (J) into the groove located on the interior surface of the lock case (F).
4. Insert the shutter spring (L) into the round hole at the front of the lock cylinder (D) and the shutter assembly (K) into the rectangular depression located at the front of the lock cylinder (D).
5. Select the required tumblers (B) according to the key cut depths, for key stations 1, 2, 3, 4, 5 and 6. For example, if the key cut depths codes are 53214124, then use B5 for Station 1, B3 for Station 2, B2 for Station 3, B1 for Station 4, B4 for Station 5, etc. Stations 7 and 8 are not used.
6. Insert one (1) tumbler spring (C) into each of the holes located at the end of the tumbler slots on the lock cylinder (D) sub-assembly.
7. Insert the required tumblers (B) into tumbler slots in the proper orientation (refer to Figure 3) and in the sequence that match the key cut depths, for key stations 1, 2, 3, 4, 5 and 6.
8. Insert the key into the keyhole and verify that all tumblers (B) are flush with the lock cylinder (D) sub-assembly's exterior surface.
9. With the key in the lock cylinder (D) sub-assembly, apply the included grease (E) to the tumbler slots.
10. With the key in the lock cylinder (D) sub-assembly, insert the lock sub-assembly into the lock case (F).
11. Rotate the lock cylinder (D) sub-assembly within the lock case (F) at least ten (10) times so that the grease applied to the tumbler slots is distributed along the inner surface of the lock case (F) and the exterior surface of the lock cylinder (D) sub-assembly.



12. Position the key in a vertical orientation and remove the key from the lock cylinder (D) sub-assembly while keeping the lock cylinder (D) sub-assembly within the lock case (F).
13. Place the shutter cover (H) over the lock case (F) and the lock cylinder (D). Use a pair of small pliers to gently bend the four (4) tabs on the shutter cover (H) inward toward the center of the lock case (F) to secure the lock cylinder (D) within the lock case (F).
14. Use the key to verify the lock rotates (smoothly) in both directions.
15. If the original lock contained a switch, be sure the rotary and the stationary parts of the anti-theft switch are properly aligned. Look at the side of the switch that is facing the lock. Locate the notch on the rotary part of the switch. This notch should be aligned with a thin groove located on the stationary part of the switch near the wires of the switch. Assemble the anti-theft switch on the back of the lock in the orientation recorded in steps A and B above. When assembling the anti-theft switch to the lock, do not rotate the rotary part of the anti-theft switch with respect the stationary part of the anti-theft switch or vice versa (refer to Figure 5).
16. Assemble the lever on to the back of the lock in the orientation recorded in steps A and B above and attach the E-clip (G) to retain the lever (and switch if so equipped) to the lock, refer to Figure 6 for E-clip alignment.
17. Use the key to verify the lock still rotates (smoothly) in both directions.

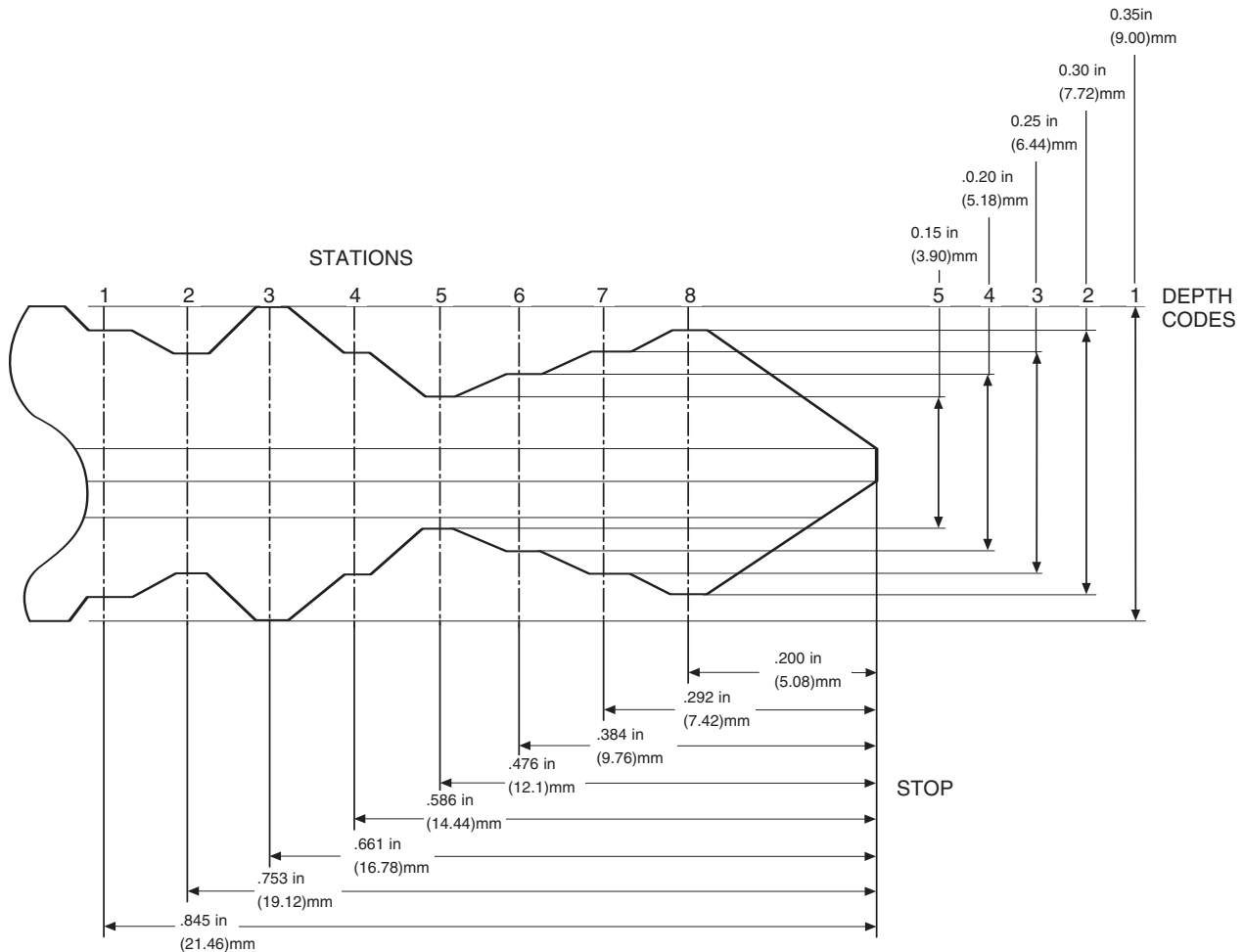


FIGURE 1



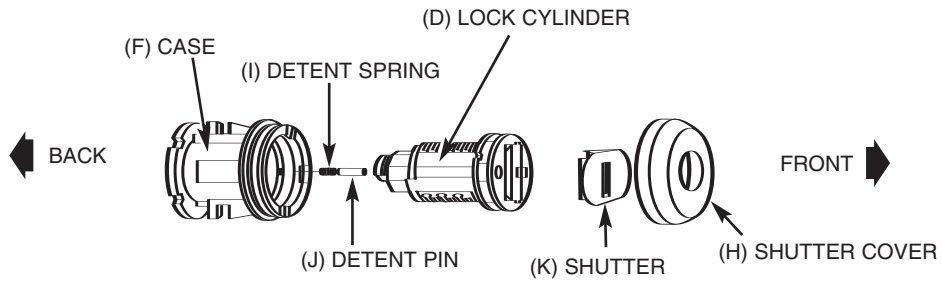


FIGURE 2

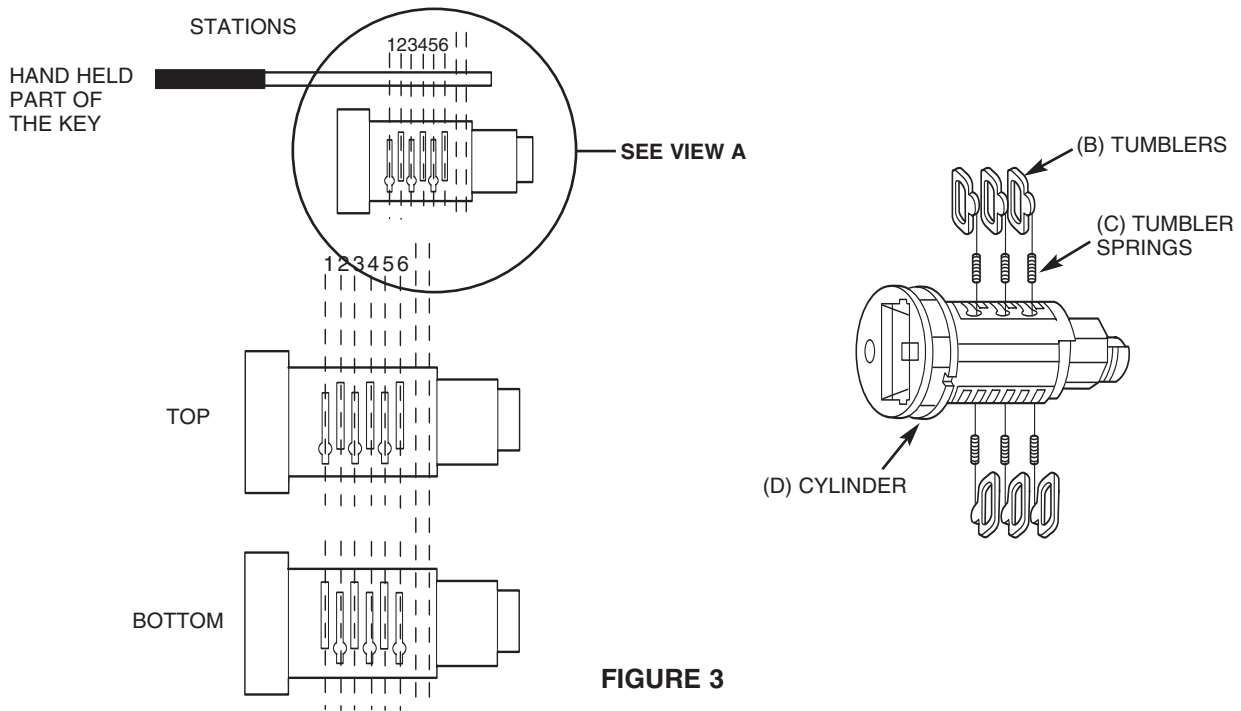


FIGURE 3



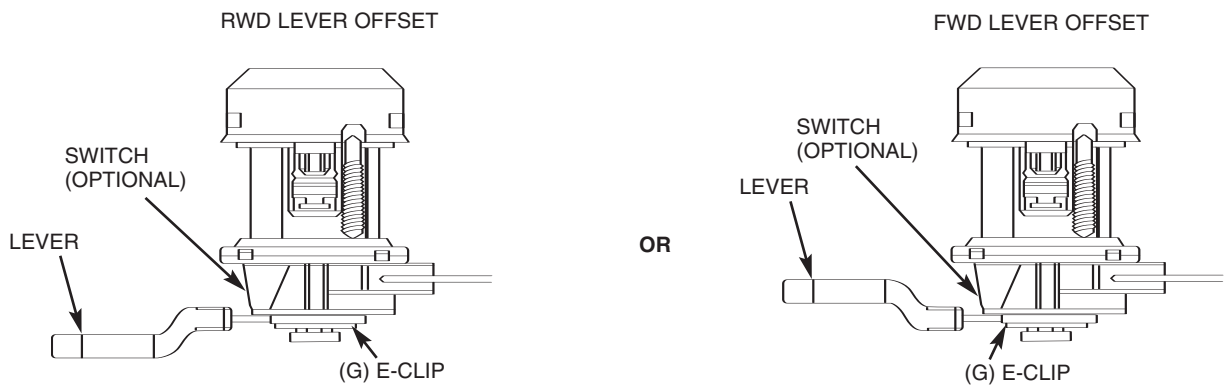


FIGURE 4

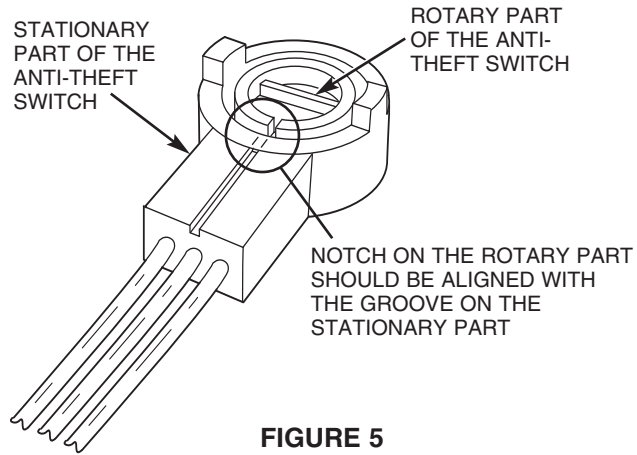


FIGURE 5

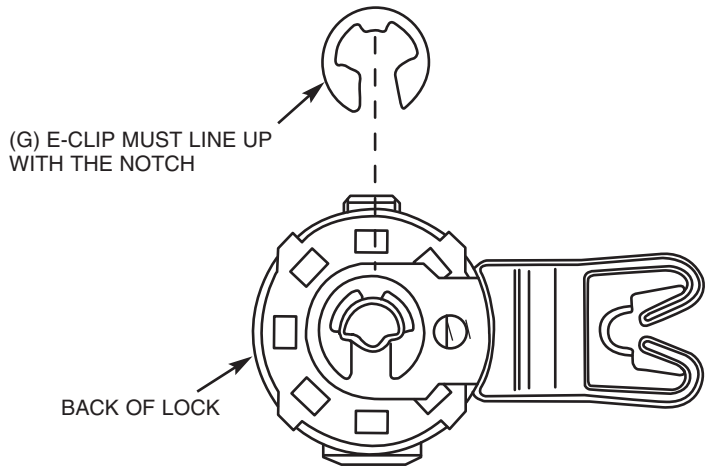


FIGURE 6

