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 2).

   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 shutter spring (M) into the round hole at the front of the lock cylinder (D), if not installed already.

3. Insert the shutter assembly (L) into the rectangular depression with notches at the long ends, located at the front of the lock cylinder (D), if not installed already.

4. Select the required tumblers (B1, B2, B3, B4, or B5) 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, etc. Stations 7 and 8 are not used.

5. Insert one tumbler spring (C) into the each of the holes located at the end of the tumbler slots on the lock cylinder sub-assembly (D).

6. Insert the required tumblers (B1, B2, B3, B4, or B5) into the 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.

7. Insert the key into the key hole and verify that all tumblers are flush with the lock cylinder sub-assembly's exterior surface.

8. With the key inserted, apply the included grease (E) to the lock cylinder sub-assembly.

9. With the key in the lock cylinder sub-assembly, insert the lock cylinder sub-assembly into the lock case (F).

10. Rotate the lock cylinder sub-assembly within the lock case at least ten (10) times so that the grease (E) applied to the lock cylinder sub-assembly is distributed along the inner surface of the lock case (F) and the exterior surface of the lock cylinder sub-assembly.

PART A. INSTRUCTION SHEET FOR LOCK SERVICE PACK XW4Z-5421990-CB, 5W4Z-5421991-BB AND 4R3Z-6321991-AA

11. Position the key in a vertical orientation and remove the key from the lock cylinder sub-assembly (D) while keeping the lock cylinder sub-assembly (D) within the lock case (F).

12. Place the shutter cover (I) over the lock case and the lock cylinder. Use a pair of small pliers to gently bend the four tabs on the shutter cover (I) inward toward the center of the lock case to secure the lock cylinder (D) within the lock case (F).

13. Install the return spring (J) on the tail end of the lock cylinder sub-assembly using fingernails or a spring winding tool. Install the white spacer (K) (if so equipped - Lincoln LS) with the recessed side towards the return spring (J) on to the tail end of the lock cylinder sub-assembly, or install the anti-theft switch (if so equipped - Mustang) on to the tail end of the lock cylinder sub-assembly in the same orientation as noted in step A on page 1 to retain the spring on the lever. This assembly should hold itself together. Press this assembly, with the white spacer (K) towards the lock assembly on to the tail section of the lock and retain with the E-clip (H).

14. Carefully assemble the lock lever on to the tail end of the lock cylinder sub-assembly in the same orientation as noted in step A on page 1 and secure using the E-clip (H).

15. Use the key to check the operation of the lock.

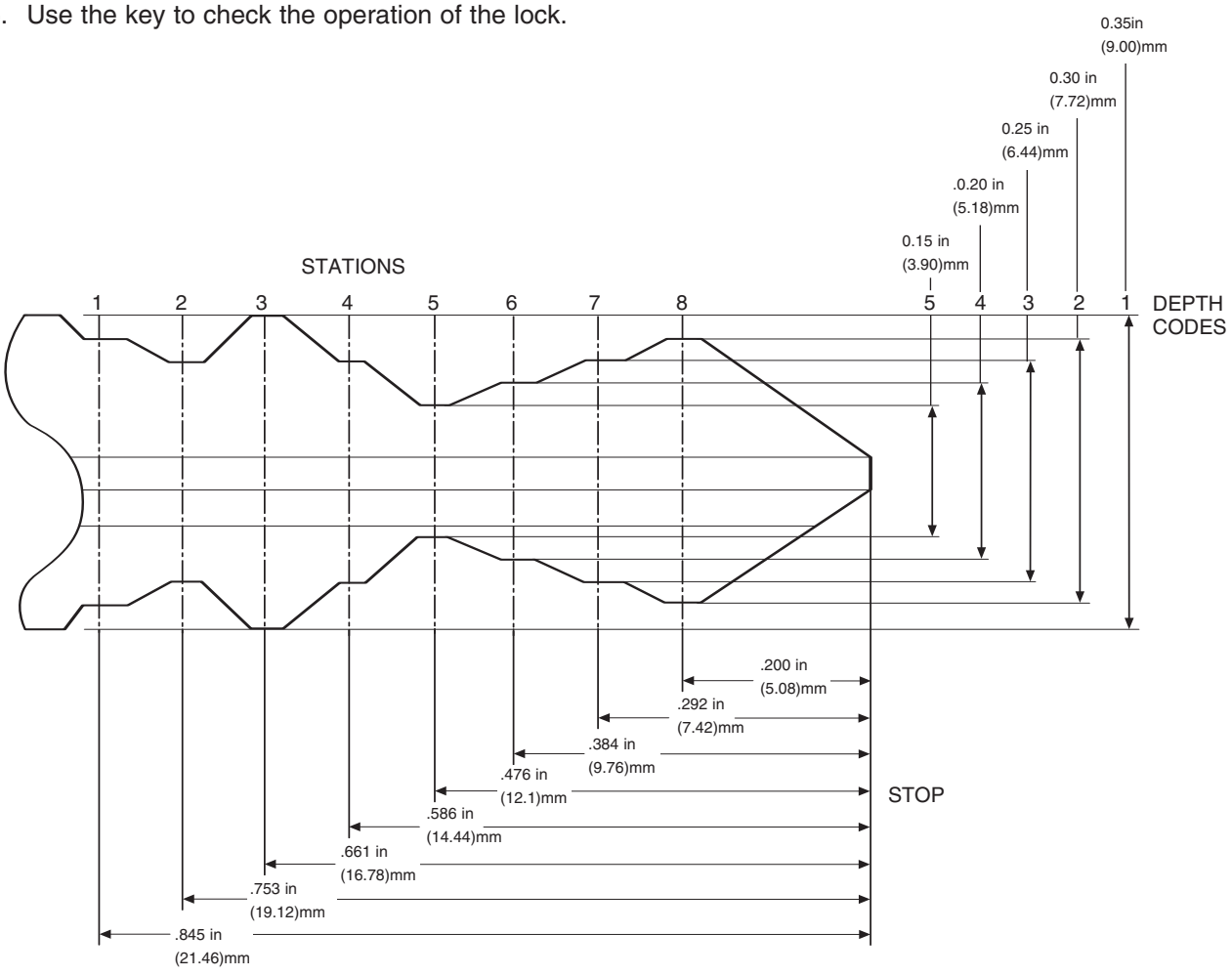

FIGURE 1

PART A. INSTRUCTION SHEET FOR LOCK SERVICE PACK XW4Z-5421990-CB, 5W4Z-5421991-BB AND 4R3Z-6321991-AA

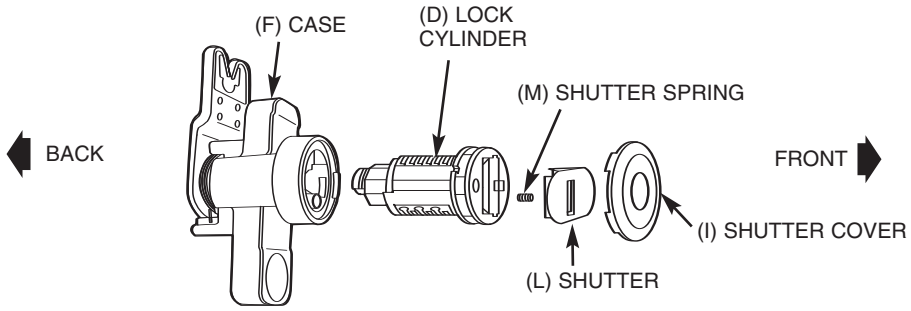

FIGURE 2

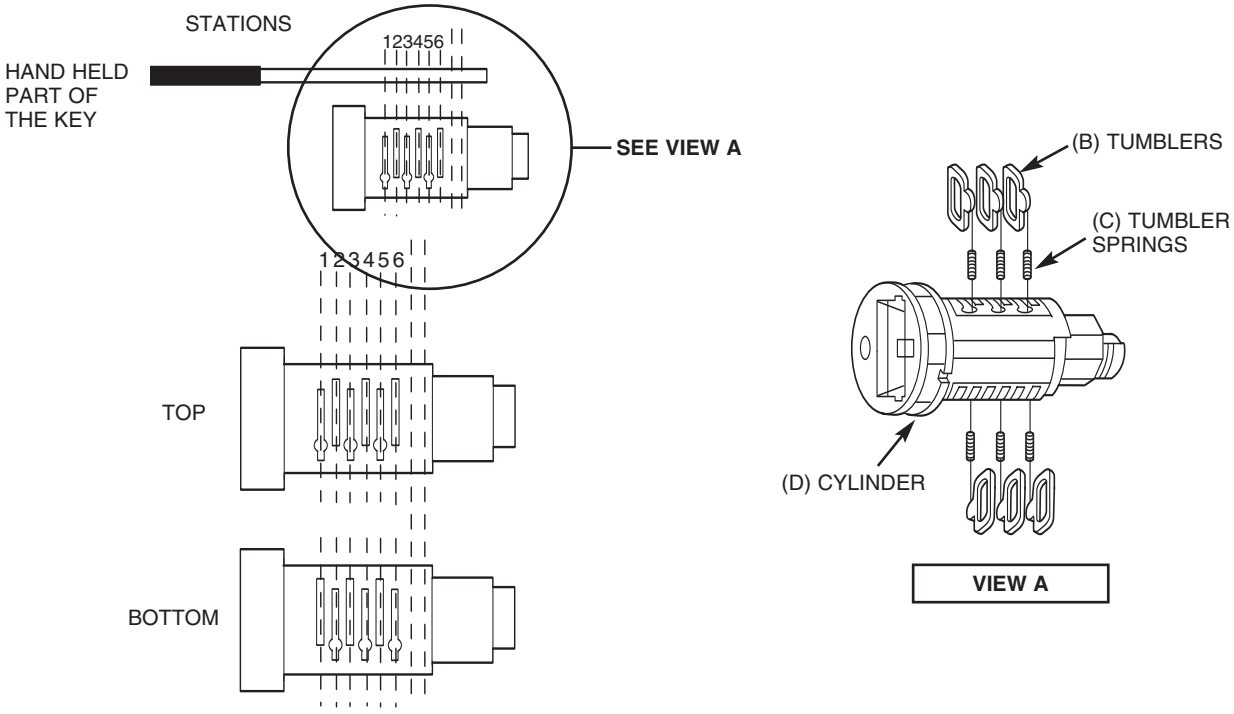

FIGURE 3

PART A. INSTRUCTION SHEET FOR LOCK SERVICE PACK XW4Z-5421990-CB, 5W4Z-5421991-BB AND 4R3Z-6321991-AA

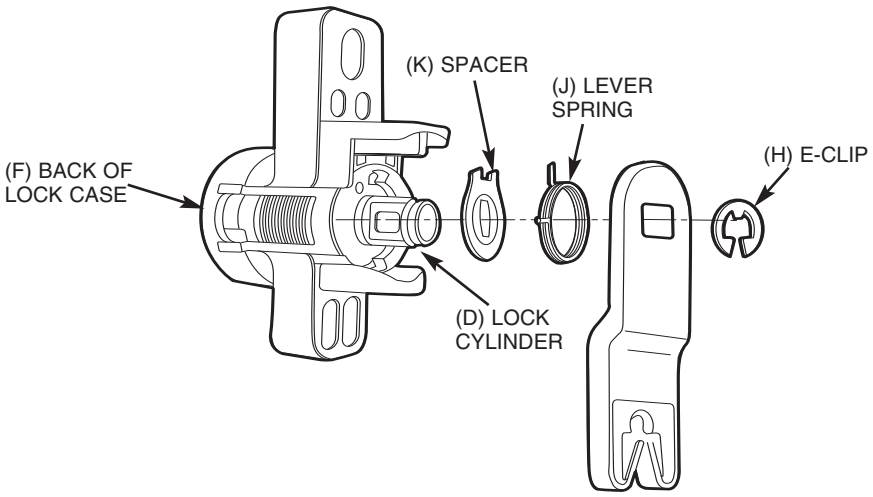

FIGURE 4

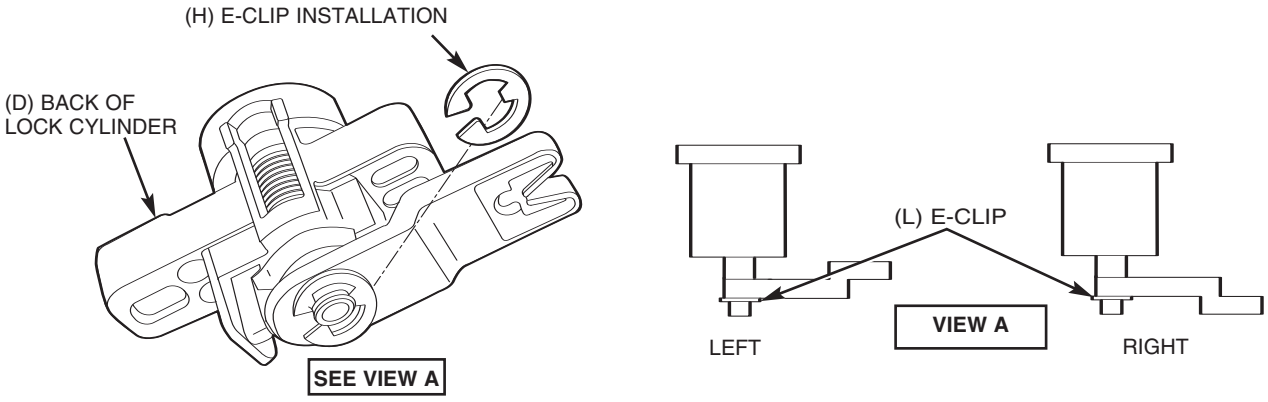

FIGURE 5

PART A. INSTRUCTION SHEET FOR LOCK SERVICE PACK XW4Z-5421990-CB, 5W4Z-5421991-BB AND 4R3Z-6321991-AA