

**PART A. INSTRUCTION SHEET FOR LOCK SERVICE PACK  
5F9Z-11582-BA, 4G7Z-11582-BA, 2L2Z-11582-B, 4L3Z-11582-BB AND 7U5Z-11582-B**

Item #	Part Number	Description	Used In Package	Quantity
A	SK 5F9A-11582-AA	Instruction Sheet (48357)	All	1
B1	324341	Tumbler # 1	All	4
B2	324342	Tumbler # 2	All	4
B3	324343	Tumbler # 3	All	4
B4	324344	Tumbler # 4	All	4
B5	324345	Tumbler # 5	All	4
C	46969	Tumbler Springs	All	8
D1	312971	Cylinder	5F9Z-11582-BA 4L3Z-11582-BB 7U5Z-11582-B 4G7Z-11582-BA	1 1 1 1
D2	312617	Cylinder	2L2Z-11582-B	1
E1	691950	Case Sub-Assembly	5F9Z-11582-BA	1
E2	692435	Case Sub-Assembly	4G7Z-11582-BA	1
E3	691211	Case Sub-Assembly	2L2Z-11582-B	1
E4	692262	Case Sub-Assembly	4L3Z-11582-BB	1
E5	5902626	Case Sub-Assembly	7U5Z-11582-B	1
F	48039	Grease Pack	All	1
G1	312966	Cap	5F9Z-11582-BA 4G7Z-11582-BA 2L2Z-11582-B 4L3Z-11582-BB	1
G2	313176	Cap	7U5Z-11582-B	1
H	312615	Actuator	All	1
I	381902	Retainer, Actuator	All	1
J	95372	Roll Pin	4G7Z-11582-BA	1
K	95225	Retainer, Clip	4G7Z-11582-BA 2L2Z-11582-B 4L3Z-11582-BB 7U5Z-11582-B	1 1 1 1

**NOTE: This Instruction Sheet is not an inspection document. Not all parts listed are included in all packages.**

**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						

2. Select the required tumblers (B) according to the key cut depths, for key stations 1, 3, 4, 5, 6, 7, and 8. For example, if the key cut depths codes are 53214124, then use B5 for Station 1, use B3 for Station 3, B2 for Station 4, B1 for Station 5, B4 for Station 6, and B1 for Station 7, etc. and ignore Station 2.
3. Apply grease to the actuator pocket located in the head of cylinder (D) (refer to Figure 4).
4. Insert actuator (H) into pocket located in the head of cylinder (D) (refer to Figure 1).
5. Apply actuator retainer (I) to clip over actuator (H). The leg of the actuator retainer clip (K) must fit into groove on the cylinder (D) head (refer to Figure 5).
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).
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 stations 1 and 3 through 8.
8. Insert the key into the keyhole and verify that all tumblers (B) are flush with the lock cylinder sub-assembly's exterior surface.
9. Apply grease to the outer surface of the cylinder (D) with the key still in the cylinder, ensuring that the areas above and in between the tumblers are coated (refer to Figure 6).
10. Place cap (G) in case head, locating case (E) and cap (G) notches for proper fit (only locates one way).
11. View through back of case (E) and align key slot on cap (G) with small slot on case (E) by rotating about 5 degrees clockwise.
12. Slide cylinder (D) into the back of the case (E) by depressing each (raised) tumbler (B) until it is flush with the cylinder (D). If cylinder (D) does not drop all the way into the case the cap (G) may not be located properly. Rotate a small amount until cylinder (D) drops in fully.
13. Rotate cylinder (D) clockwise in case (E) to seat tumblers (B) into tumbler slots. You will hear the tumblers (B) snap into place.
14. If the original lock contained a black retainer clip (K) - then install a new clip (K) onto the back of the cylinder (D) by spreading it open using snap ring pliers (or equivalent) and placing it over the tail end of the cylinder (D). Locate the retainer clip (K) so that it aligns to the relief notches in the back of the cylinder (D) - refer to Figure 7 for proper orientation of the clip (K) on the cylinder.
15. Insert key and verify function of lock.

**NOTE: For Ford GT part number 4G7Z-11582-BA (only).**

Insert roll pin (J) in hole in case (E) until it is flush with the outside diameter of case (E), (refer to Figure 2).



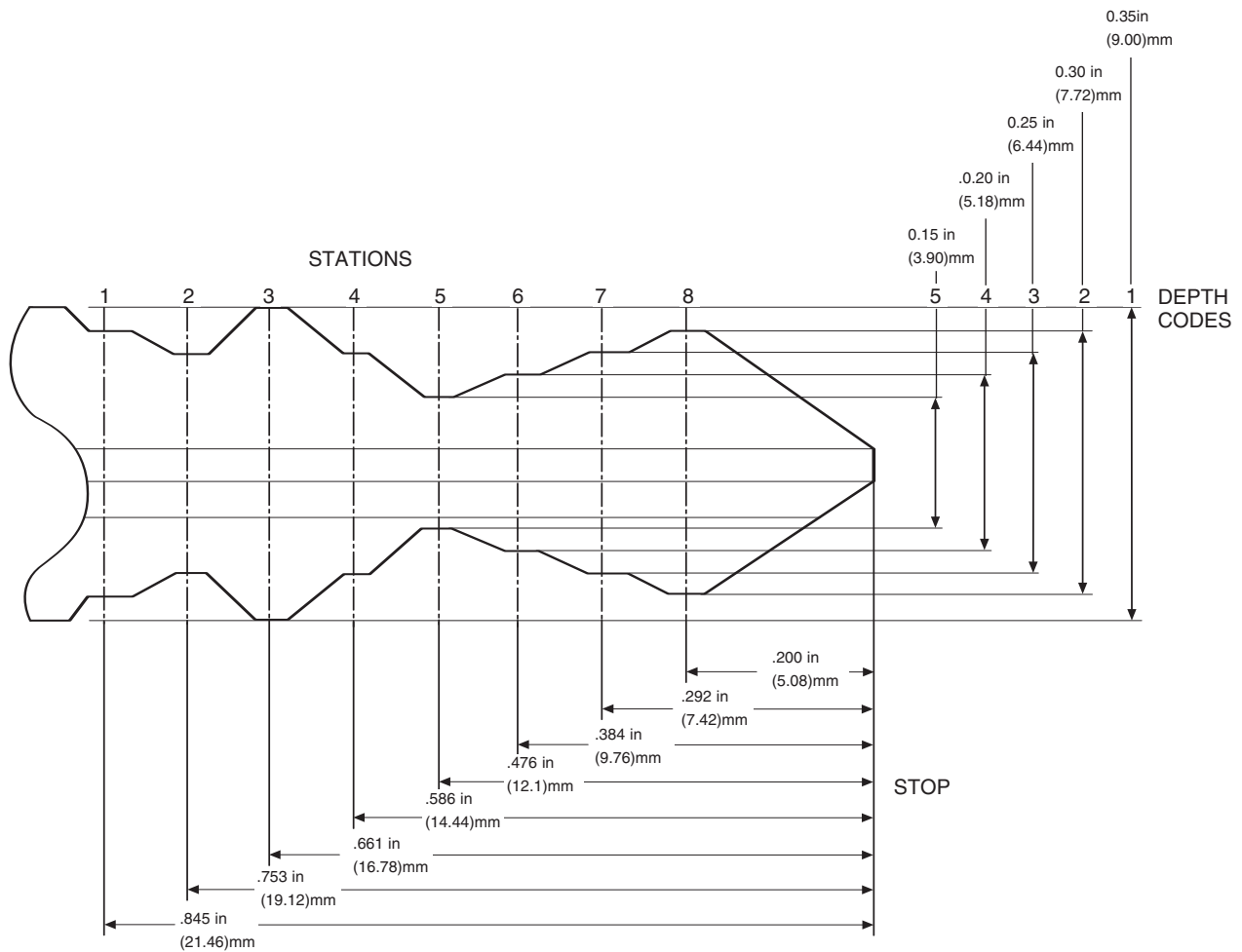


FIGURE 1

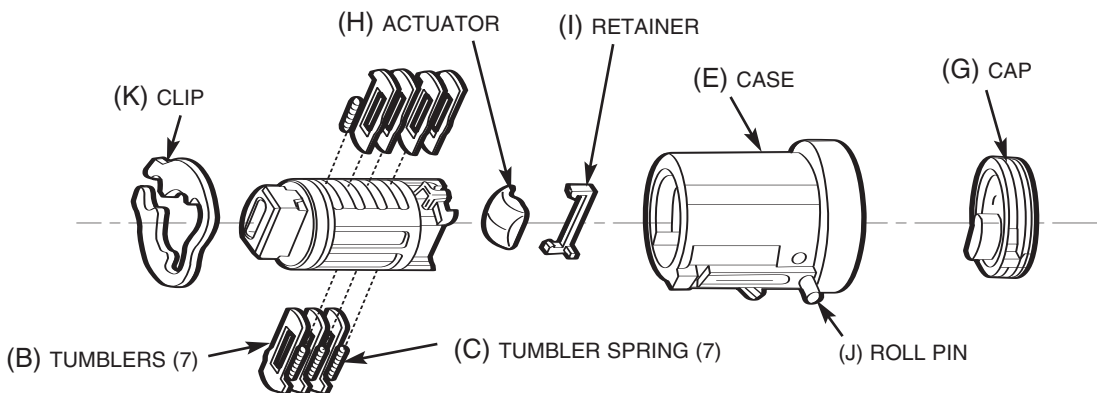
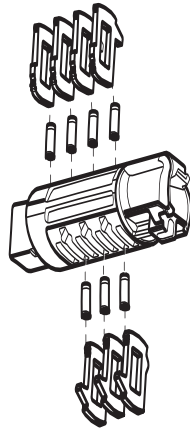


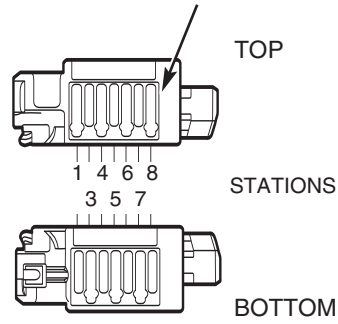
FIGURE 2



**NOTE: FOUR (4) SPRING HOLES ON THE TOP**



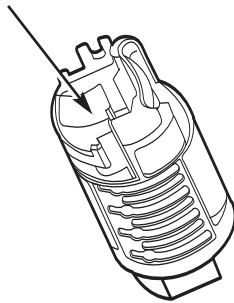
TUMBLERS SLOTS



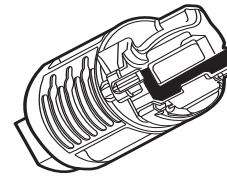
**NOTE: THREE (3) SPRING HOLES ON THE BOTTOM OF CYLINDER**

**FIGURE 3**

LUBRICATE CYLINDER ACTUATOR POCKET

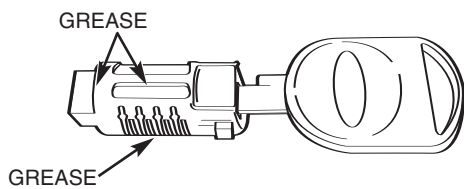


**FIGURE 4**

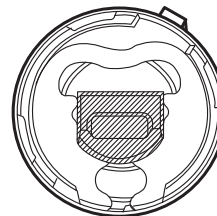


**FIGURE 5**

LUBRICATE TUMBLERS (B)



**FIGURE 6**



**FIGURE 7**



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SHEET 4 OF 4

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