PART A. INSTRUCTION SHEET FOR LOCK SERVICE PACK F87Z-7843432-CB

KIT — F87Z-7843432-CB			
Item #	**Part Number**	**Description**	**Quantity**
A	SK F87B-7843432-CB	Instruction Sheet (48426)	1
B1	324341	Tumbler # 1	4
B2	324342	Tumbler # 2	4
B3	324343	Tumbler # 3	4
B4	324344	Tumbler # 4	4
B5	324345	Tumbler # 5	4
C	46969	Tumbler Springs	8
D	311815	Cylinder Sub-Assembly	1
E	38039	Grease Pack	1
F	311817	Lock Case	1
G	322648	Shutter Cover (Black)	1
H	56034	Torsion Spring	1
I	381356	Driver	1
J	381357	Lever	1
K	381358	Shaft	1
L	322622	Eyelets	2
M	56066	Compression Spring	1
N	56031	Shutter Spring	1
O	596656	Shutter Assembly	1
P	381576	Spacer	1
Q	381282	Retainer	1
R	599241	Housing Assembly	1
S	381289	Front Housing	1
T	93442	Retainer	1

NOTE: This Instruction Sheet is not an inspection document.

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

PART A. INSTRUCTION SHEET FOR LOCK SERVICE PACK F87Z-7843432-CB

SHEET # 48426AA1

2. Insert the shutter spring (N) into round hole at the front of the lock cylinder (D) and insert the shutter assembly (O) into the rectangular hole at the front of the lock cylinder (D).
3. 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. and ignore Station 7 and Station 8.
4. Insert one tumbler spring (C) into each of the holes located at the end of the tumbler wards on the lock cylinder sub-assembly (D).
5. Insert the required tumblers (B1, B2, B3, B4,or B5) into tumbler wards 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.
6. With the key in the lock cylinder, apply the included grease (E) to the tumbler wards.
7. With the key in the lock cylinder, insert the lock cylinder into the lock case (F).
8. Rotate the lock cylinder within the lock case at least ten times so that the grease applied to the tumbler wards is distributed along the inner surface of the lock case and the exterior surface of the lock cylinder.
9. Remove the key from the lock cylinder while keeping the lock cylinder within the lock case.
10. Install shutter cover (G) over the lock case (F). Make sure the shutter cover (G) is oriented such that the slots on the shutter cover (G) match the lugs on the outer surface of the lock case (F).
11. Assemble the torsion spring (H) to the back of the lock cylinder and the lock case as shown in Figure 4.
12. Use the key to check the operation of the lock.
13. Insert the completed lock into the front housing (S), from the back of the front housing (R).
14. Install the driver (I) over the shaft protruding from the back of the lock cylinder.
15. (Refer to Figure 5). Insert the lever (J) into the back of the rear housing (R) in such an orientation that a protruding detent pin on the arm of the lever (J) faces the back of the rear housing (R).
16. (Refer to Figure 6). Insert the compression spring (M) into the front of the rear housing (R) and then fit the completed front housing (S) (with the lock, the front housing, and the driver) over the other end of the compression spring. Use two (2) 3/8 inch binder clips (not included) to hold the two (2) housings together.
17. (Refer to Figure 7). Insert one eyelet (L) into each of the matching holes on the housings.
18. Insert the portions of the housings which already have the eyelets and the matching holes into a vice and use the vice to compress the eyelets until the eyelets have deformed enough to hold the two (2) housings together.
19. Remove the 3/8 inch binder clips and use the key to check the operation of the lock.

PART A. INSTRUCTION SHEET FOR LOCK SERVICE PACK F87Z-7843432-CB

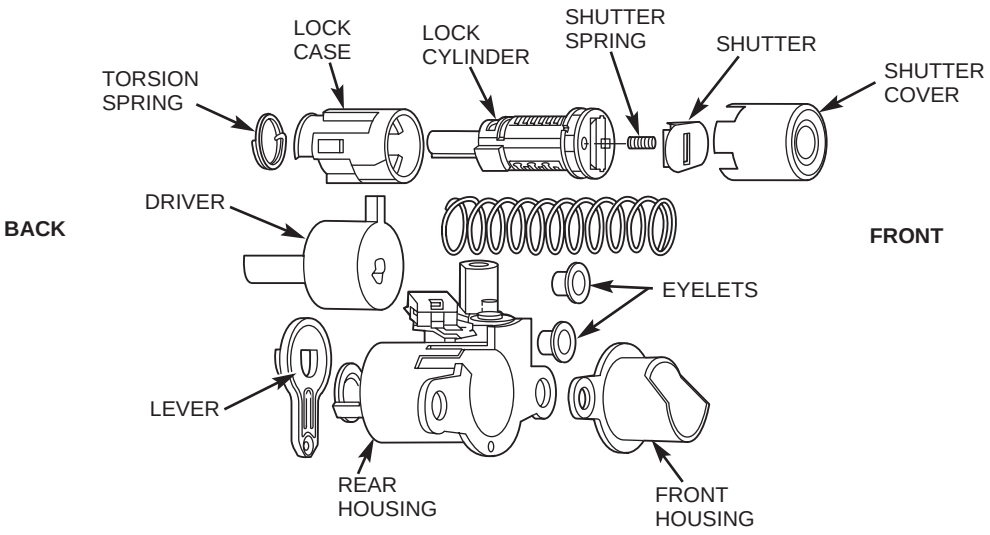

FIGURE 1

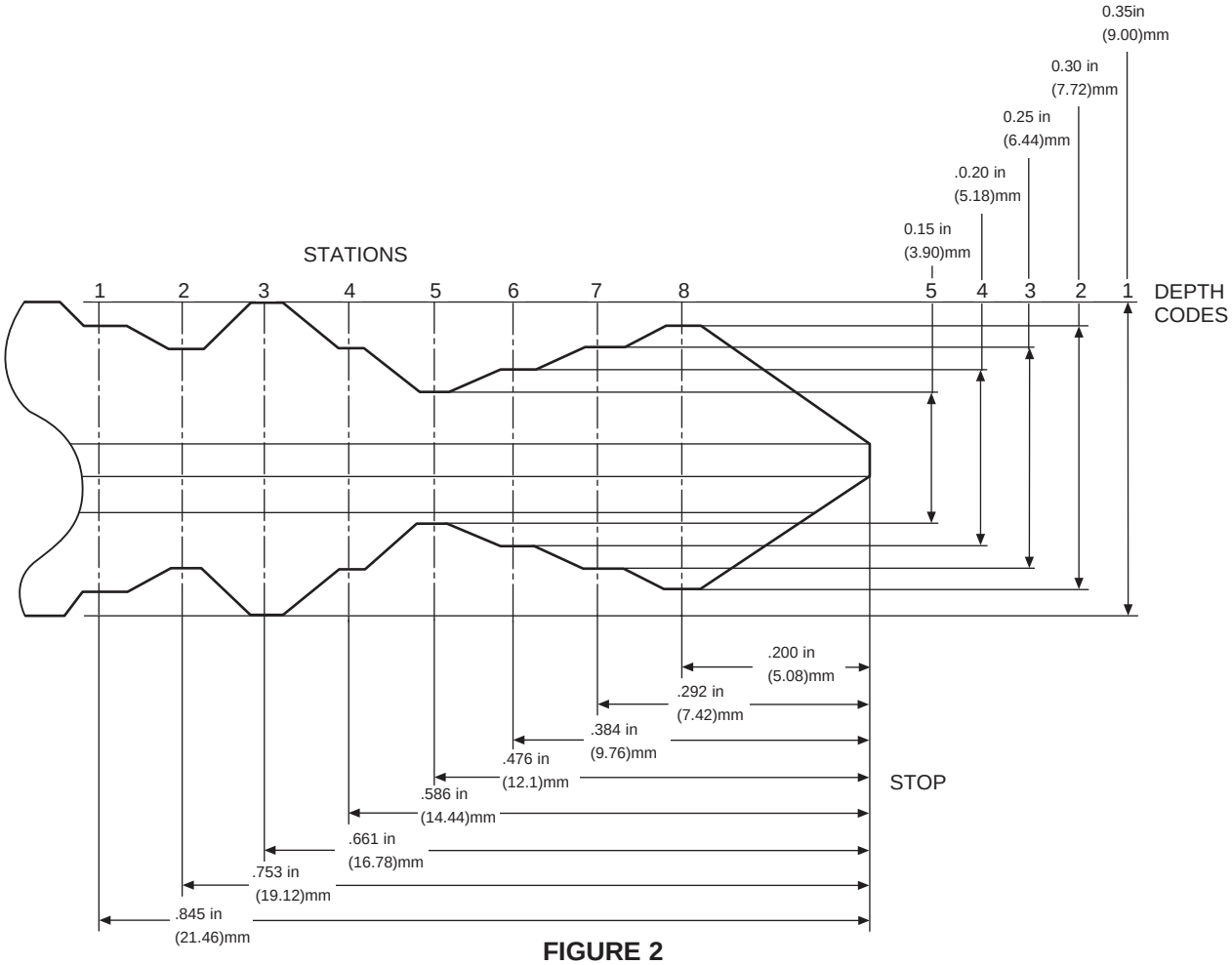

FIGURE 2

PART A. INSTRUCTION SHEET FOR LOCK SERVICE PACK F87Z-7843432-CB

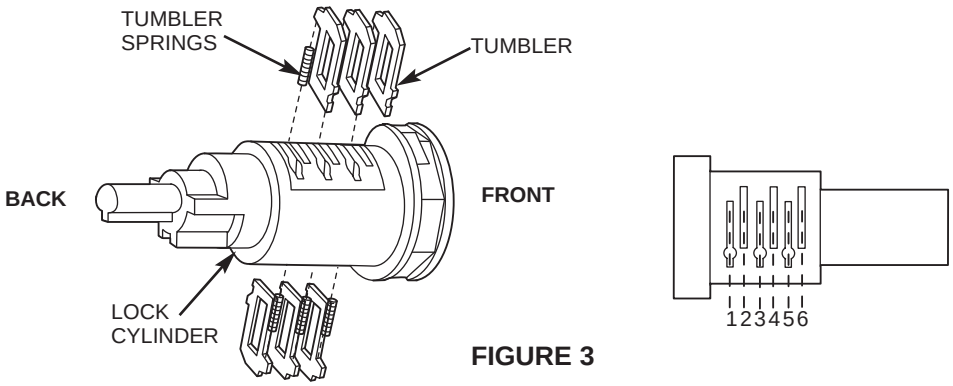

FIGURE 3

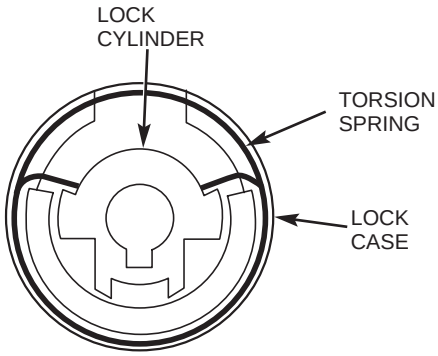

FIGURE 4

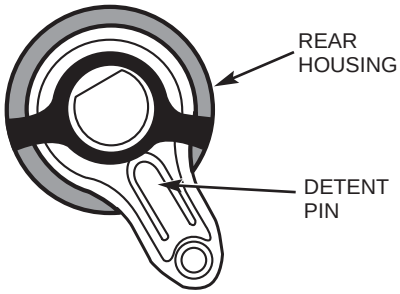

FIGURE 5

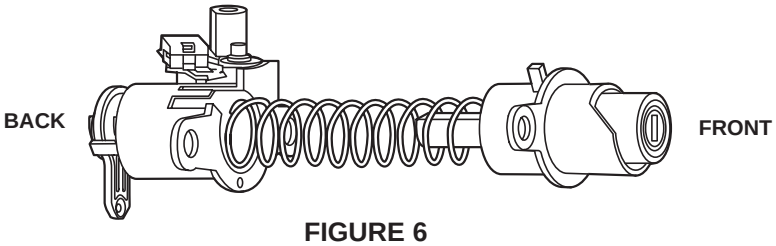

FIGURE 6

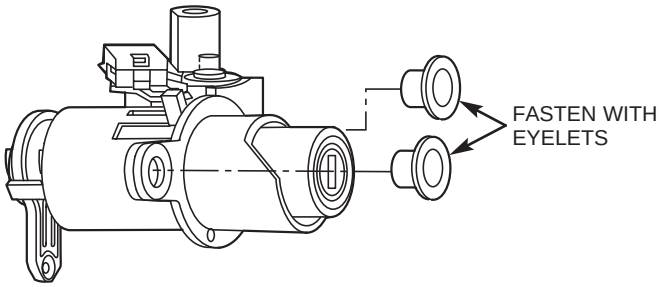

FIGURE 7

PART A. INSTRUCTION SHEET FOR LOCK SERVICE PACK F87Z-7843432-CB