

PART A. INSTRUCTION SHEET FOR LOCK SERVICE PACK 5F1Z-7443432-BA

KIT — 5F1Z-7443432-BA			
Item #	Part Number	Description	Quantity
A	SK 5F1A-7443432-AA	Instruction Sheet (48415)	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	47757	Pad	1
F	48039	Grease Pack	1
G	311817	Lock Case	1
H	322648	Shutter Cover (Black)	1
I	56034	Torsion Spring	1
J	381228	Lever	1
K	381918	Driver	1
L	322622	Eyelets	2
M	56035	Compression Spring	1
N	56031	Shutter Spring	1
O	596656	Shutter Assembly	1
P	381226	Front Housing	1
Q	598020	Rear Housing Assembly	1

NOTE: 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 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



2. Verify that a shutter is installed in the front of the lock cylinder sub-assembly. If not, then insert the shutter spring into the round hole at the front of the lock cylinder and the shutter into the rectangular depression located at the front of the lock cylinder.
3. Select the required tumblers (B1-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 (D1 or D2).
5. Insert the required tumblers (B1-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. Insert the key into the keyhole and verify that all tumblers are flush with lock cylinder sub-assembly's exterior surface.
7. With the key in the lock cylinder sub-assembly, apply the included grease (F) to the tumbler wards.
8. With the key in the lock cylinder sub-assembly, insert the lock cylinder sub-assembly into the lock case. Rotate the lock cylinder sub-assembly 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 sub-assembly.
9. Rotate the lock cylinder sub-assembly within the lock case and remove the key from the lock cylinder sub-assembly while keeping the lock cylinder sub-assembly within the lock case.
10. Assembly shutter cover over the lock case. Make sure the shutter cover is oriented such that the slots on the shutter cover match the lugs on the outer surface of the lock case.
11. Assembly torsion spring (I) to the back of the lock case by locating one of the legs to the back of case and rotate to engage the other leg to case.
12. Use the key to check the operation of the lock.
13. Insert the completed lock into the back of the front housing from the back.
14. Install driver over the shaft protruding from the back of the lock cylinder.
15. Insert the lever into the back of the rear housing in such an orientation that a protruding detent pin on the arm of the lever faces the back of the rear housing (refer to Figure 5).
16. Insert the compression spring into the front of the rear housing and then fit the completed front housing assembly over the other end of the compression spring (refer to Figure 6). Use two (2) 3/8 inch binder clips (not included) to hold the two housings together.
17. Insert one eyelet into each of the matching mounting holes on the housings (refer to Figure 7).
18. Insert the portions of the housing assemblies, which have the eyelets, inserted into a vise and compress the eyelets until they have deformed enough to hold the two (2) housings together.
19. Remove the binder clips and use the key to check the operation of the lock.
20. Install the pad to the front side of the front housing.



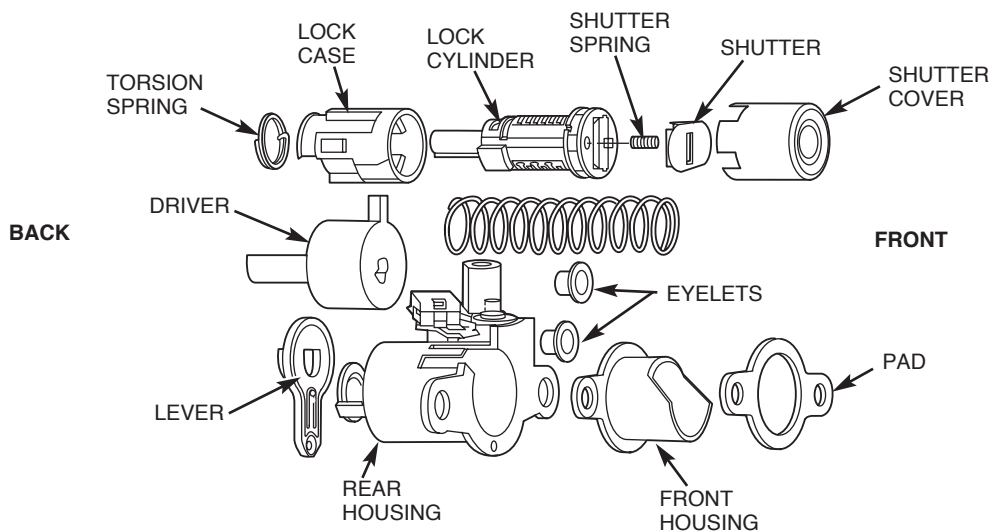


FIGURE 1

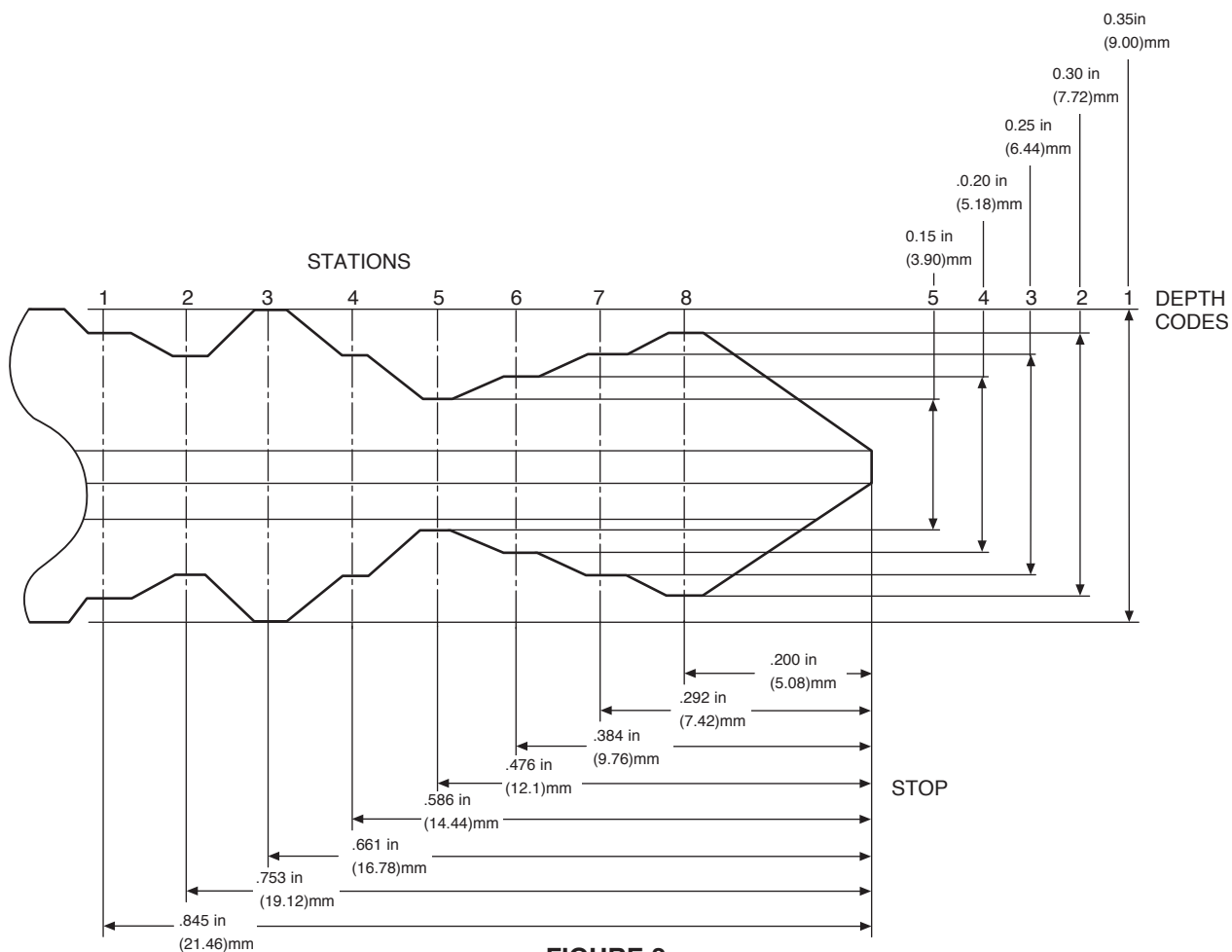


FIGURE 2



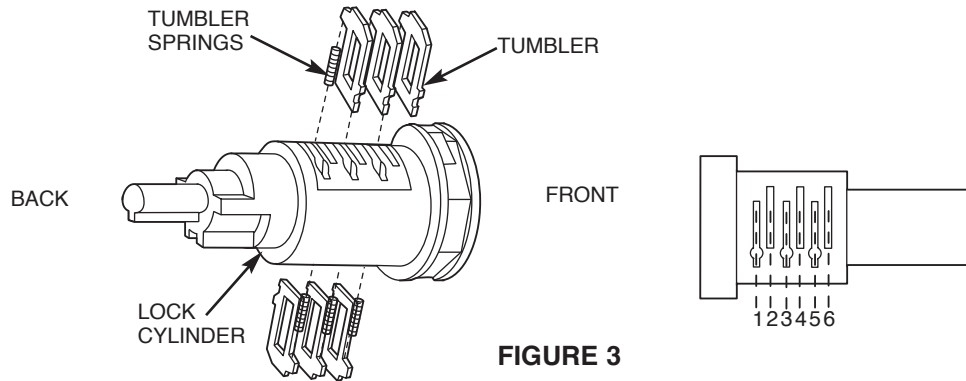


FIGURE 3

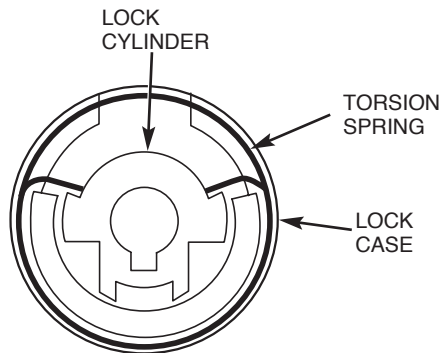


FIGURE 4

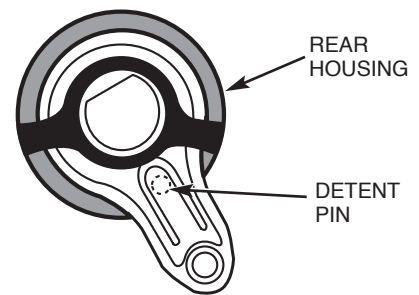


FIGURE 5

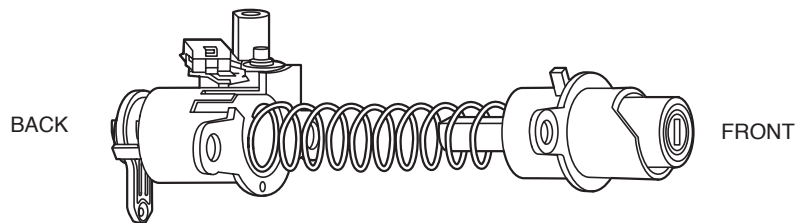


FIGURE 6

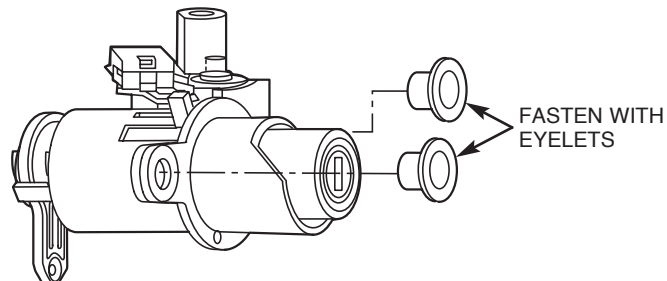


FIGURE 7

