PART A. INSTRUCTION SHEET FOR LOCK SERVICE PACK 7L2Z-7843432-B

KIT - 7L2Z-7843432-B			
Item #	**Part Number**	**Description**	**Quantity**
A	SK 7L2A-7843432-BA	Instruction Sheet (48470)	1
B1	324341	Tumbler # 1	4
B2	324342	Tumbler # 2	4
B3	324343	Tumbler # 3	4
B4	342344	Tumbler # 4	4
B5	342345	Tumbler # 5	4
C	46969	Tumbler Springs	8
D	692865	Cylinder Sub-Assembly	1
E	48039	Grease Pack	1
F	312624	Case	1
G	56210	Compression Spring	1
H	48234	Gasket	1
I	381896	O-ring	1
J	323824	Case Cap	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

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2. Select the required tumblers (B1- B5) according to the key cut depths for the 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, and ignore Station 5, Station 6, Station 7, and Station 8.

3. 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).

4. Insert the required tumblers (B1- B5) into the tumbler wards in the proper orientation (refer to Figure 3), and in the sequence that matches the key cut depths, for key stations 1, 2, 3, and 4.

5. Insert the key into the key hole and verify that all tumblers drop flush with the lock cylinder sub-assembly's exterior surface, remove key.

6. Place O-ring (I) around cylinder sub-assembly's stainless steel cap from the front, and set flush against the groove towards the back of the cylinder cap.

7. Apply the supplied grease (E) to the tumbler wards and at the inner face of the case cap (J) where the O-ring will seat.

8. Insert the compression spring (G) into the case (F).

9. Place cap on the cylinder sub-assembly, resting it on the o-ring. Insert the key in the lock cylinder sub-assembly while gently pushing on tumblers. Then insert the lock cylinder sub-assembly fully into the case on top of the spring by lining up the groove on the cylinder with the groove on the case (refer to Figure 4).

   NOTE: Be sure to fully insert the lock cylinder sub-assembly in the case. When cylinder is depressed, the top of the cylinder sub-assembly MUST be flush with top of case.

10. Hold sub-assembly flush with the top of the case and crimp cap tabs tight and flush with bottom of case.

11. Rotate and push in the lock cylinder sub-assembly in the lock case at least ten (10) times so that the grease applied to the tumbler wards is evenly distributed along the inner surface of the lock case and the exterior surface of the lock cylinder sub-assembly (also check that lock operates correctly).

12. Slide gasket (H) from the back of the case, and rest gasket on the lip at the front of the case (where the case cap was just crimped).

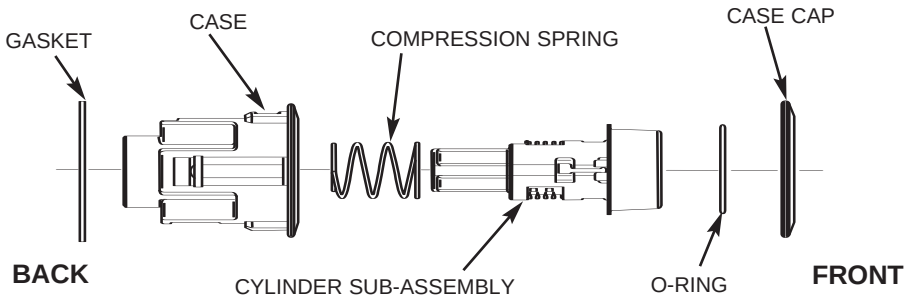

FIGURE 1

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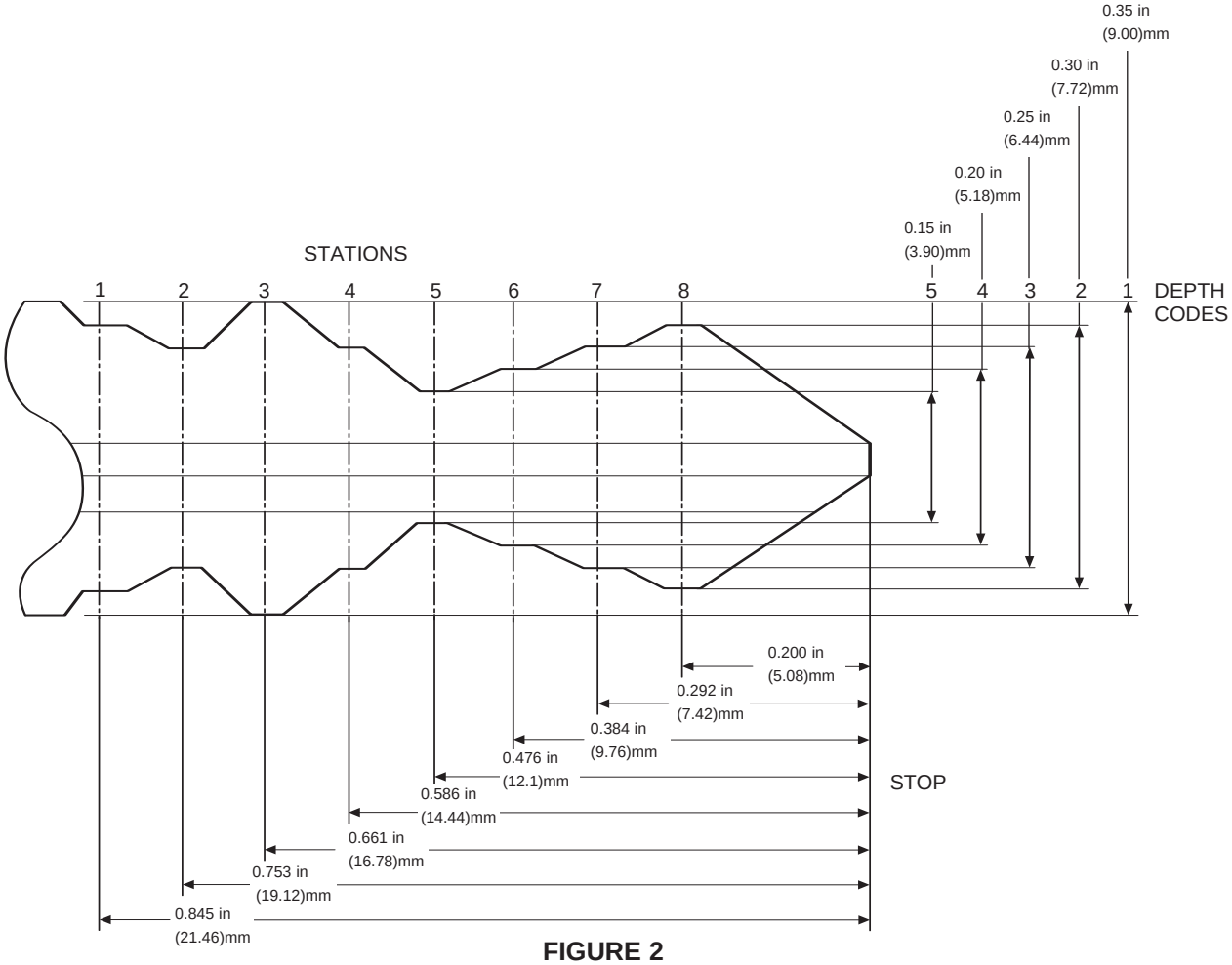

FIGURE 2

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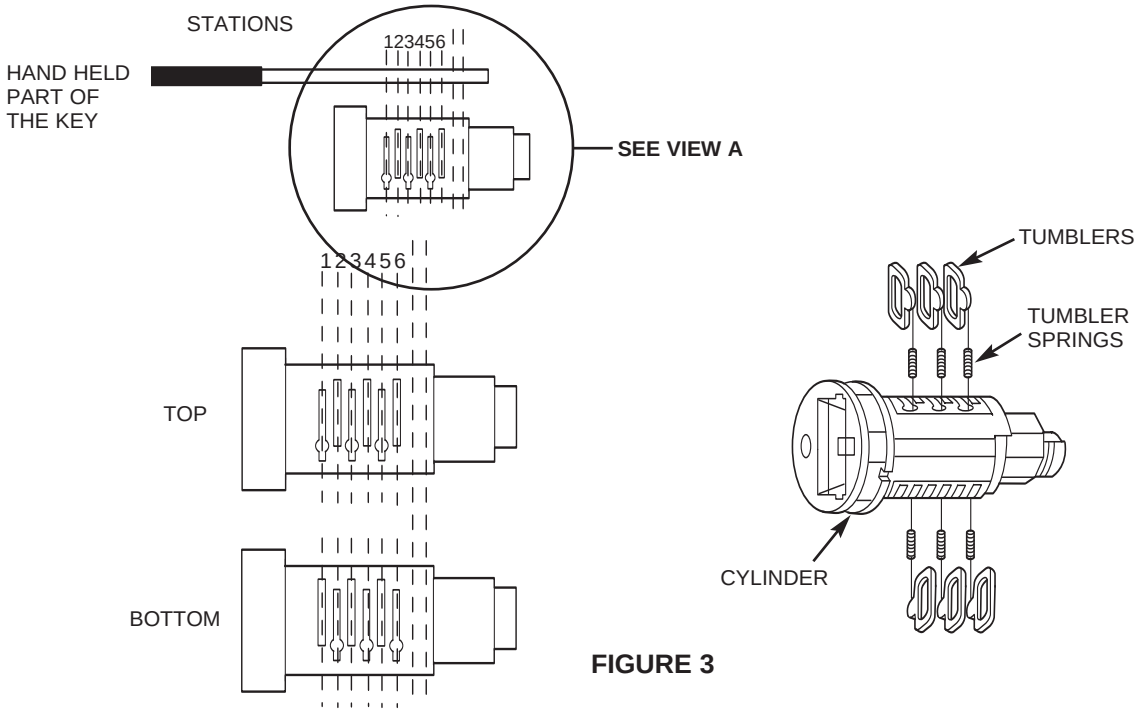

FIGURE 3

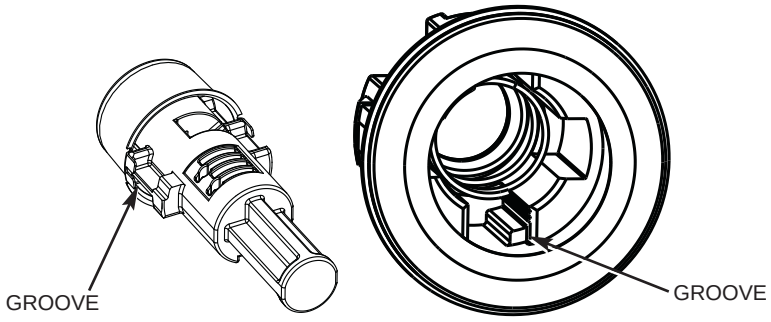

FIGURE 4

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