

## PART A. INSTRUCTION SHEET FOR LOCK SERVICE PACK 4L3Z-1543262-BC

KIT - 4L3Z-1543262-BC				
Item #	Part Number	Description	Used in Package	Quantity
A	SK 4L3A-1543262-BC	Instruction Sheet (48433)	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
D	312723	Cylinder Sub-Assembly	ALL	1
E	312724	Lock Case	ALL	1
F	48039	Grease Pack	ALL	1
G	596656	Shutter Assembly	ALL	1
H	56031	Shutter Spring	ALL	1
I	322535	Shutter Cover (Stainless)	ALL	1
J	48291	Gasket	ALL	1
K	381979	Spacer	ALL	1
L	93442	E-Clip	ALL	1
M	323970	Lever	ALL	1
N	691753	Cover	ALL	1

**NOTE:** This Instruction Sheet is not an inspection document.

### **SERVICE PROCEDURE:**

- 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.
  - 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.
  - 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).
  - Using the customer's key, measure the key cut depth at each key station (refer to Figure 2).

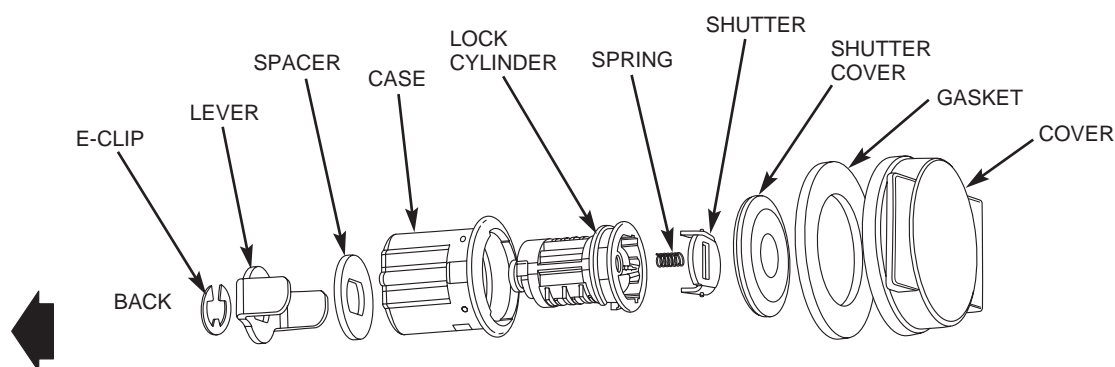
Write down the key cut depths, in terms of the depth code, not the actual measurements of the depths, in the following order:

Station 1	Station 2	Station 3	Station 4	Station 5	Station 6	Station 7	Station 8

- Insert the shutter spring (H) into the round hole at the front of the lock cylinder and the shutter assembly (G) into the rectangular depression located at the front of the lock cylinder.
- Select the required tumblers (B1-B5) according to the key cut depths, for key stations 4, 5, 6, 7 and 8. For example, if the key cut depths codes are 53214124, then use B1 for Station 4, B4 for Station 5, B1 for Station 6, B2 for Station 7, B4 for Station 8 and ignore Station 1, 2, and Station 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).
- 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 4, 5, 6, 7, and 8.



6. Insert the key into the keyhole and verify that all tumblers are flush with the 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 (E).
  9. 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.
  10. After rotating the lock remove the key from the lock cylinder sub-assembly while keeping the lock cylinder sub-assembly within the lock case.
  11. Refer to Figure 4 to place the shutter cover (H) in the depression on crimping tool (Rotunda Tool number 501-051, refer to the instructions for the crimping tool). Place the lock case on top of the shutter cover (make sure that the lock cylinder sub-assembly does not fall out of the lock case). To secure the cover to the head of the lock case, use the swing arm on the crimping tool to crimp the four tabs on the shutter cover.
  12. Apply the self sticking gasket (J) to the back of the flip cover (N).
  13. Insert the lock assembly through the hole in the cover and align the case lug with the notch on the cover. Snap cover closed over lock face.
  14. Assemble the spacer to the back of the lock. Place lever (M) on top of spacer (K) with the legs to the front of the lock (refer to Figure 1).
  15. Install the E-clip (L) to the back of the lock cylinder sub-assembly to secure the lever.
- Note: The tab on the E-clip should fit into the indentation on the back of the lock cylinder sub-assembly. Depress the spacer to allow the e-clip to seat into the indentation. (Refer to Figure 5) for proper orientation of the E-clip.**
16. Use the key to check the operations of the lock.
  17. Install the completed lock to the hole of the bumper located to the right of the license plate. Lock will only enter hole in one direction.



**FIGURE 1**



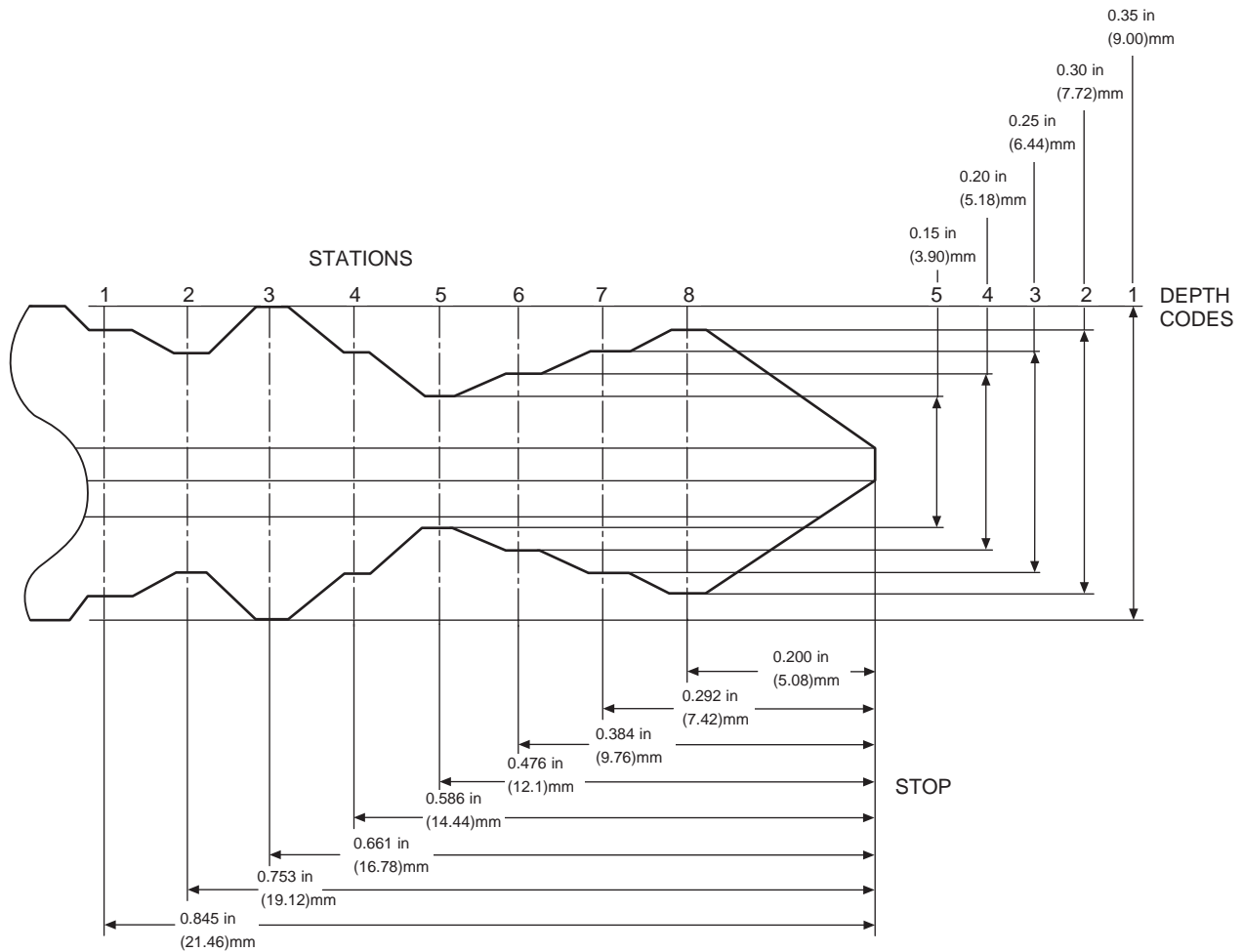


FIGURE 2

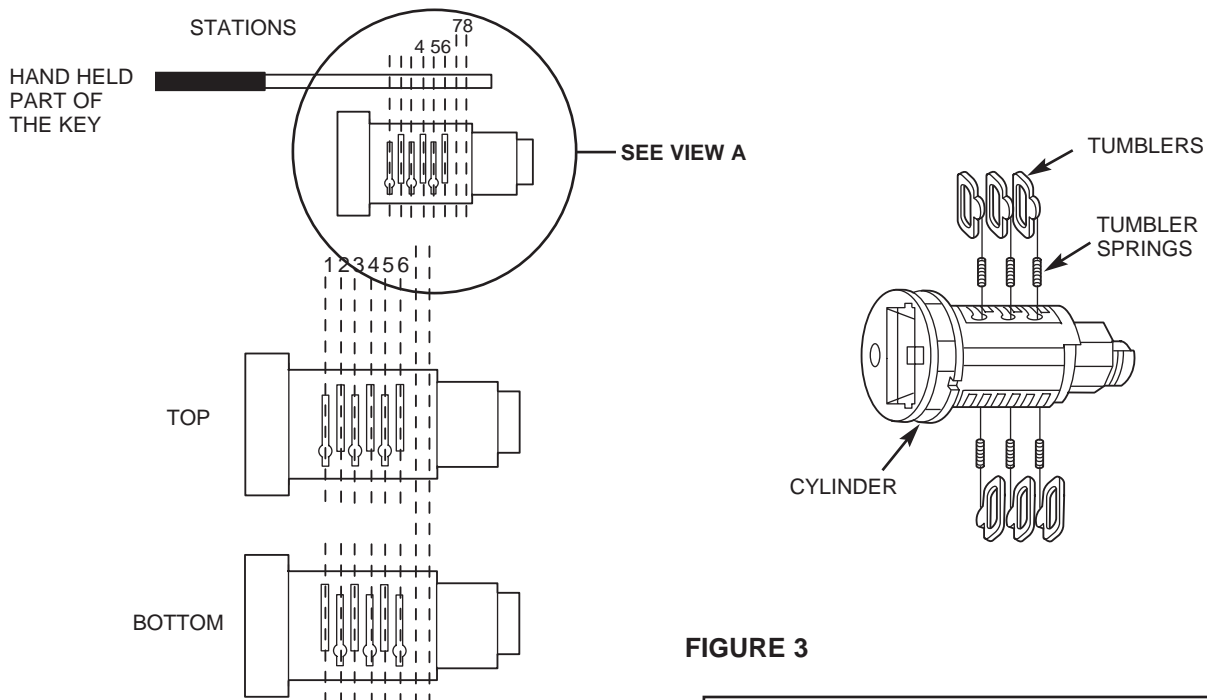
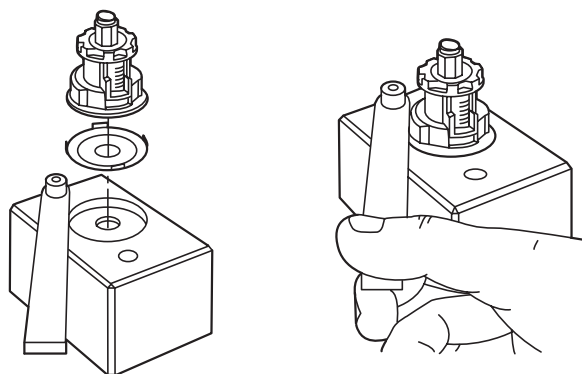
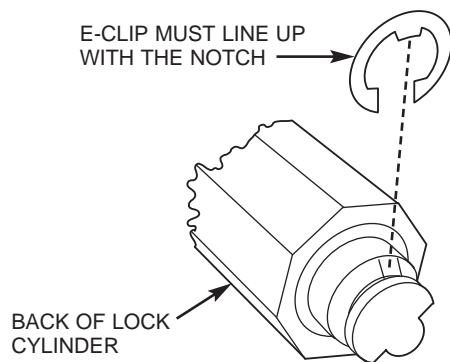


FIGURE 3





**FIGURE 4**



**SEE VIEW A  
FIGURE 5**

