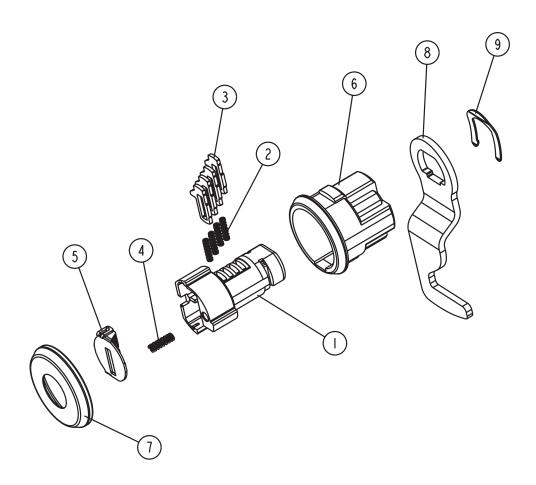
GENERAL MOTORS

INSTRUCTION SHEET FOR ASSEMBLING AND CODING INTERNAL LOCKS

The internal lock cylinder only uses four of the ten cut positions, 7 through 10. The tumbler positions are on one side and self-retaining. After removing the current lock, identify the direction the lever is attached to the tail of the lock.

- 1. Hold the cylinder (1) so the side with tumbler spring wells faces up.
- 2. Insert tumbler springs (2) into the four spring wells.
- 3. Install the first tumbler (3) for key cut position 7 in the slot nearest to the front of the lock cylinder. Install the remaining tumblers following the key cod.
- 4. Press the tumblers in place until they are secure.
- 5. Check for correct loading of the tumblers by inserting the key into cylinder. All of the tumblers should be flush with the lock cylinder body.
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- 7. Apply lubricant to cylinder body and tumbler surfaces along with a small amount in head of cylinder using the supplied grease.
- 8. Install spring (4) into the spring well in head section of cylinder.
- 9. Snap the shutter assembly (5) into cylinder.
- 10. Assemble cylinder into case (6).
- 11. Place the lock cylinder cap (7) on top of cylinder/case assembly. Roll cap tabs to underside of case. Verify cap is sure secure and pulled tight to case.
- 12. Assemble lever (8) to lock. Use e-clip (9) to retain lever assembly.
- 13. Insert the key into the lock and function lock to check for proper assembly and smooth operation.
- 14. Assemble to vehicle using the new lock clip.



REV.-05/05 48466AA1