

## PART A. INSTRUCTION SHEET FOR LOCK SERVICE PACK JX7Z-18168-H

Item #	Part number	Description	Quantity
A	SKJX7A-220K51-MA	Instruction Sheet (4739544)	1
B	5939501	Cylinder, Cap & Shutter assembly	1
C	4631974	Tumbler spring	10
D	4131978	Housing	1
E	4131985	Lever	1
F	4231986	Retainer ring	1
G	4131980	Sleeve (Inner case)	1
H	4331981	Retainer bar	2
I	4631982	Spiral spring	1
J	4331983	Roller	1
K	4131984	Clutch	1
L	4812508	O-Ring	1
M	4831395	Gasket	1
N1	4231964	Tumbler L1	3
N2	4231965	Tumbler L2	3
N3	4231966	Tumbler L3	3
N4	4231967	Tumbler L4	3
N5	4231968	Tumbler L5	3
N6	4231969	Tumbler R1	3
N7	4231970	Tumbler R2	3
N8	4231971	Tumbler R3	3
N9	4231972	Tumbler R4	3
N10	4231973	Tumbler R5	3
N11		Grease	1

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

### SERVICE PROCEDURE:

- Determine the matching key cut depth at each key station. Either of the following two 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).
  - Using the customer's key, measure the key cut depth at each key station (Refer to Figure 1). Write down the key cut depths, in terms of the depth code, note the actual measurements of the depths in the following order:

Depth Codes	Station 1 (L)	Station 2 (R)	Station 3 (R)	Station 4 (L)	Station 5 (L)	Station 6 (R)	Station 7 (R)	Station 8 (L)	Station 9 (L)	Station 10 (R)

SKJX7A-220K51-MA

SHEET 1 OF 4



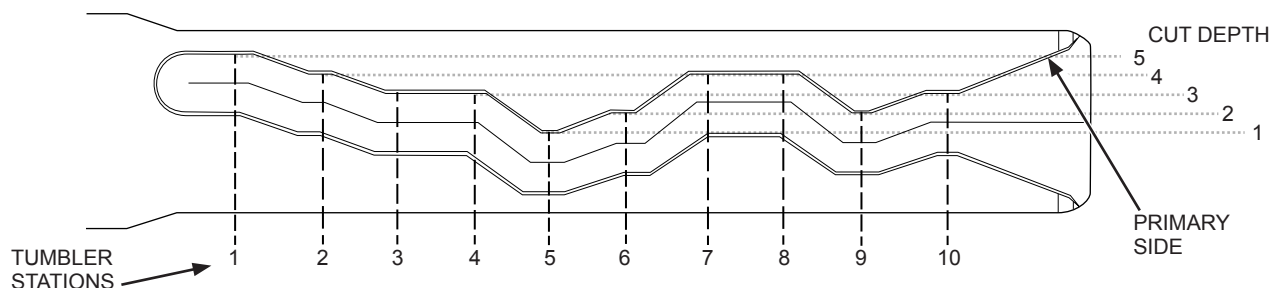
PART A. INSTRUCTION SHEET FOR LOCK SERVICE  
PACK JX7Z-18168-H

CPR © 2011 FORD MOTOR COMPANY  
DARBORN, MICHIGAN 48121  
11-20

4739544AB

UNCONTROLLED COPY

2. Take the cylinder assembly (B) and verify O-Ring (L) presence (Refer to Figure 2.1). Select the required tumblers (N1-N10) according to the key cut depths. For example, if the key cut depths codes are 5433124423, then use N8 for station 10, use N2 for station 9, N4 for station 8, N9 for station 7, N7 for station 6, etc. (Refer to Figure 2.2). Note that there are Right (N6 - N10) and Left (N1 - N-5) side tumblers.
3. Insert one Tumbler-Spring (C) into each of the holes located at the end of the tumblers wards on the lock Cylinder (B) top side (Refer to Figure 3.1).
4. Insert the required Tumblers (N1-N10) into the tumbler slots (top-side) in the proper orientation (Refer to Figure 3.1), and in the sequence that match the key cut depths for stations 1-10. While holding down the Tumblers, turn the Cylinder (B) and repeat steps 3 and 4 for the bottom-side (Refer to Figure 3.2).
5. Insert the key into the keyhole and verify that all installed tumblers are flush with the Cylinder (B) exterior surface (Refer to Figure 4). DO NOT PULL OUT THE KEY. If you do, the tumblers will fall out.
6. Apply grease to the outer surface of the Cylinder (B) with the key still inserted, ensuring that the areas above and in between the tumblers are coated. (Refer to Figure 4).
7. Insert the cylinder into the Sleeve (G), hold the cylinder tail and remove the key (Refer to Figure 5.1). Insert the cylinder/sleeve into the Case (D) for the bigger diameter; to complete the assembly push the sleeve. (Refer to Figure 5.2). Push the sleeve diameter to finish the assembly. Do not push the cylinder tail.
8. Use a chisel or another tool to deform the stacking points in one side of the case (D) (Refer to Figure 6.1). Then insert one Retainer Bar (H) for the opposite side in each cavity (Refer to Figure 6.2), verify that Retainers (H) are under flush of the stacking points and deform the stacking points to keep the retainer bars (H) into position (Refer to Figure 6.3).
9. Insert the Roller (J) in the case cavity on the Case (D) (Refer to Figure 7.1). Assembly the Spiral spring (I) around the case cavity and Roller (Refer to Figure 7.2) ensure there are two spring coils against the Roller (J).
10. Put the Clutch (K) and Lever (E) into cylinder tail (Refer to Figure 8.1). Use a retainer ring priers to put the Retainer ring (F) to hold the lever and clutch. (Refer to Figure 8.2).
11. Install the gasket (M). (Refer to Figure 9).
12. Use the key to check the Lock proper operation.



**FIGURE 1**  
**KEY CODE FOR EXAMPLE PURPOSE: 5433124423**



CPR © 2000 FORD MOTOR COMPANY  
DARBORN, MICHIGAN 48121  
11-20

**SKJX7A-220K51-MA**

**SHEET 2 OF 4**

**PART A. INSTRUCTION SHEET FOR LOCK SERVICE**  
**PACK JX7Z-18168-H**

**UNCONTROLLED COPY**

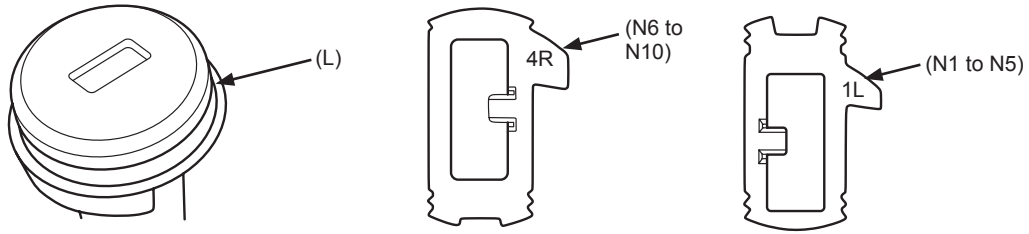


FIGURE 2.1

	Station 1	Station 2	Station 3	Station 4	Station 5	Station 6	Station 7	Station 8	Station 9	Station 10
Depth	(L)	(R)	(R)	(L)	(L)	(R)	(R)	(L)	(L)	(R)
Codes	5	4	3	3	1	2	4	4	2	3

FIGURE 2.2

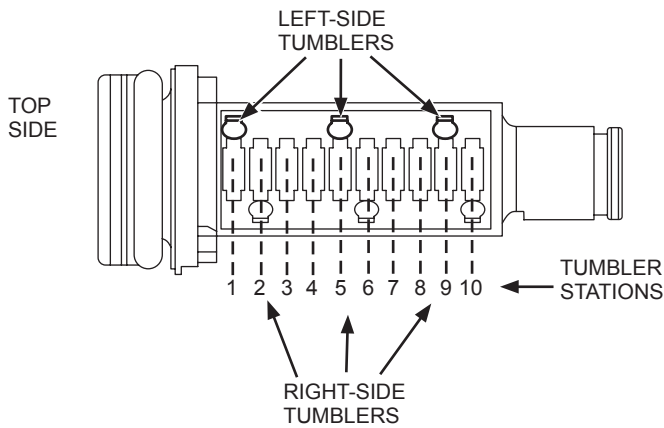


FIGURE 3.1

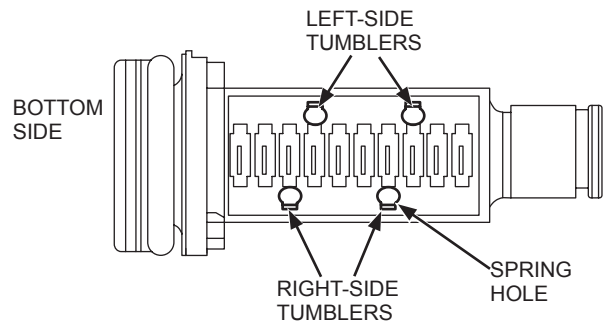


FIGURE 3.2

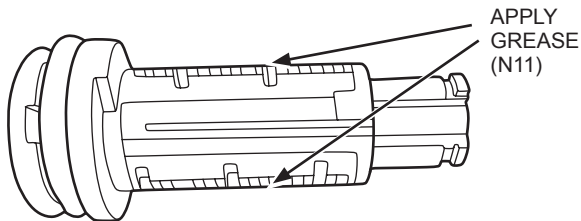


FIGURE 4

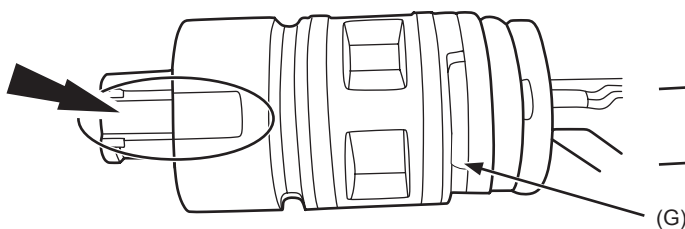


FIGURE 5.1  
ALIGN THE ROLLER SLOT TO CYLINDER GROOVE  
HOLD CYLINDER TAIL AND REMOVE KEY

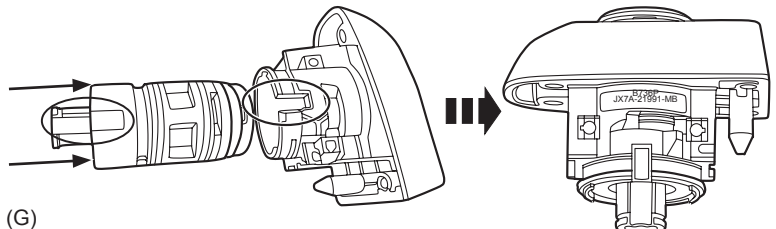


FIGURE 5.2



CPR © 2011 FORD MOTOR COMPANY  
DARBORN, MICHIGAN 48121  
11-20

SKJX7A-220K51-MA

SHEET 3 OF 4

PART A. INSTRUCTION SHEET FOR LOCK SERVICE  
PACK JX7Z-18168-H

UNCONTROLLED COPY

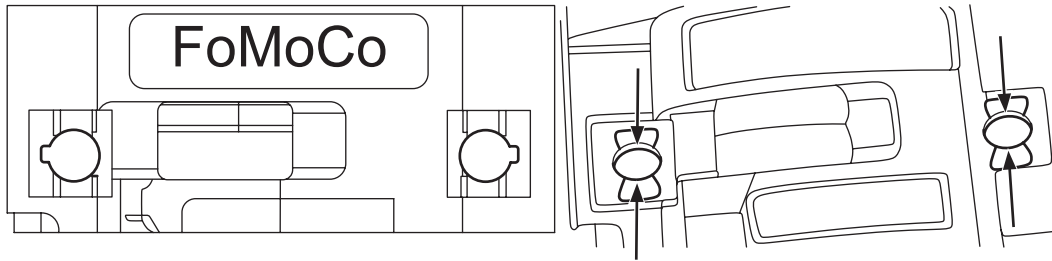


FIGURE 6.1

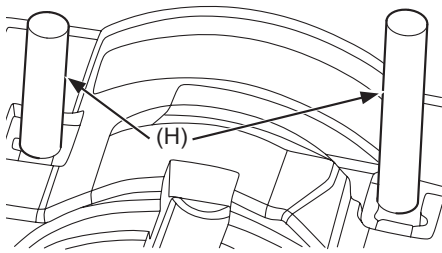


FIGURE 6.2

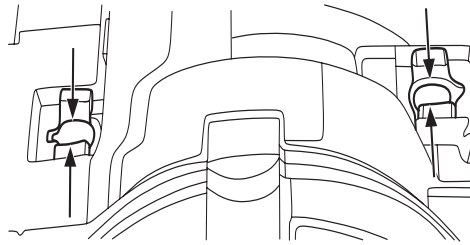


FIGURE 6.3

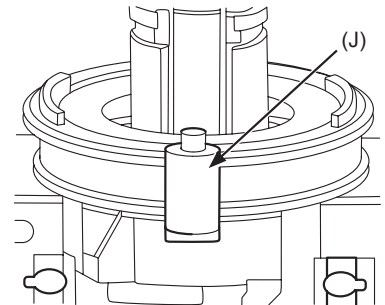


FIGURE 7.1

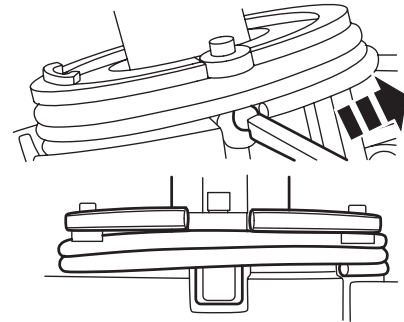
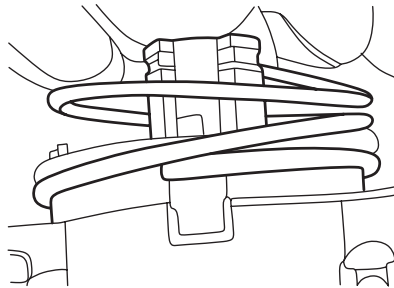
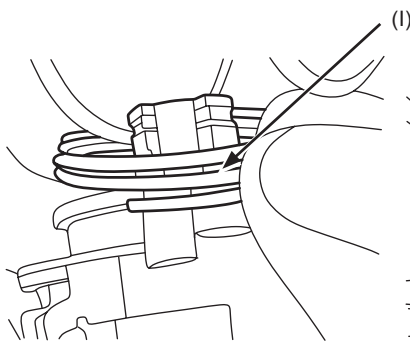


FIGURE 7.2

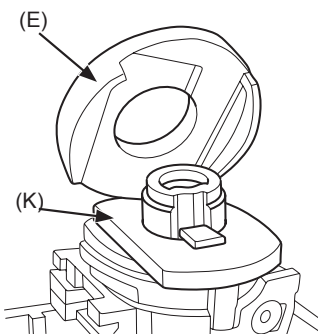


FIGURE 8.1

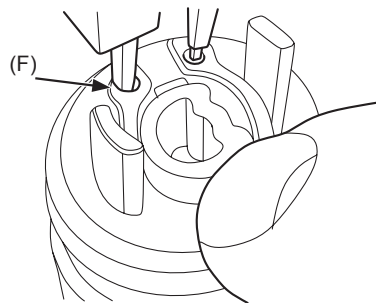


FIGURE 8.2

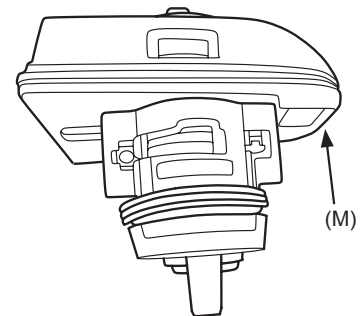


FIGURE 9

SKJX7A-220K51-MA

SHEET 4 OF 4



CPR © 2000 FORD MOTOR COMPANY  
DARBORN, MICHIGAN 48121  
11-20

PART A. INSTRUCTION SHEET FOR LOCK SERVICE  
PACK JX7Z-18168-H

UNCONTROLLED COPY