

# **PINNING INSTRUCTIONS GM SIDE MILL TRUCK**



PRO/E C-SIZE 112-0-1-12 09:11:57 AM

6 5 4 3 2 1

SSC # 4222564 (BLADE) 48364 (BAG) CUST #  
7023758 2 1

D

C

B

A

0.1X45° (2X)  
1.15±0.05  
0.1X45° (2X)  
1.15±0.05

SECTION A-A

2.65<sup>+0</sup><sub>-0.05</sub>

27.9  
22.5  
17.1  
11.7  
6.3  
1.8±0.05  
1.3±0.05  
0.3±0.05  
0.8±0.05  
3.6  
9  
14.4  
19.8  
25.2

0.4 MIN

1 STEP CHANGE  
2 STEP CHANGE  
3 STEP CHANGE

FOR REFERENCE ONLY

-A-  
-B-  
-C-

GROOVE 102

NOTES & SPECIFICATIONS  
PART MUST BE FREE FROM BURRS

MATERIAL:  
MAKE FROM 4222564

CUSTOMER:  
UNLESS OTHERWISE SPECIFIED  
UNITS: MM  
ALL DIMENSIONS: ±0.05  
ALL ANGLES: ±0.5°  
ALL RADIUS: 0.25±0.25  
POLISH FINISH ON ALL EDGES  
SHOW SHARP-UP AFTER PROCESSING  
GO PRODUCT QUALITY CHARACTERISTIC  
NO SPECIAL CHARACTERISTIC

CUST. NO.

INSPECTION AND TOLERANCES PER ASME Y14.5-1994

METRIC SCALE 1:1 MAKE  
VOLUME 530.919 WEIGHT

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BAORD DATE  
Dec-05-12

STRATTEC  
STRATTEC SECURITY CORPORATION

7022068AA

AC REV 1

REVISION BLOCK

AC AGR. DRAWING REVISED PER ECN 100343  
REV DESCRIPTION  
M.V. Dec-05-12  
ENG DATE

4 Uncontrolled Copy

# GM SIDE MILL TUMBLER POSITIONS

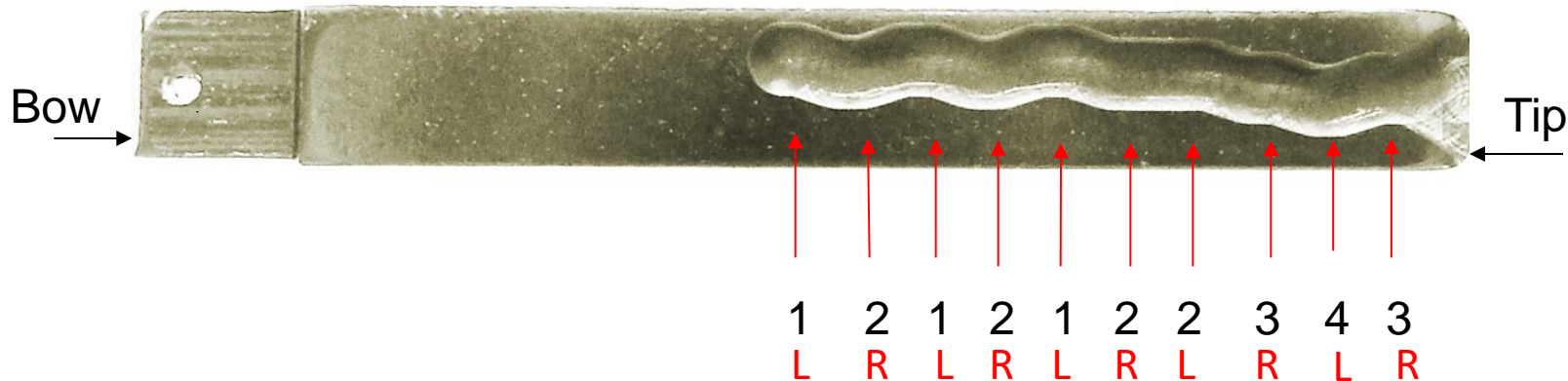
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Ward	<u>12345678910</u>	
Ign	XXXXXXX	1-7
Door	XXXXXX	5-10(LH and RH)
Stowage	XXX	1-3
Endgate	XXXXX	6-10
Spare	XXXXX	6-10

# SIDE MILL CUT KEY READING

## Key Reading by Cuts

- 1) Start with the keybow to the left and the tip of the key pointing to the right
- 2) Observe the cuts on the lower half of the key
- 3) A cut nearest the centerline of the blank is a “1” cut and a cut nearest outer edge of the blank is a 4 cut
- 4) In the Example Below: (V0001 Engineering code)



## Ignition Pinning – Side Mill Truck

- 1) Starting by loading the tumblers on the left side
- 2) The left side is the tumbler slot closest to the head of the lock cylinder with a spring hole. Grease slots and load springs on this side.
- 3) After left side is populated, rotate 180 and fill the right side populating spring holes first and adding grease for tumbler retention.

1L - 4201932 – **Need 3**

1R – 4201934 – 0 needed

2L - 4201933 - **Need 1**

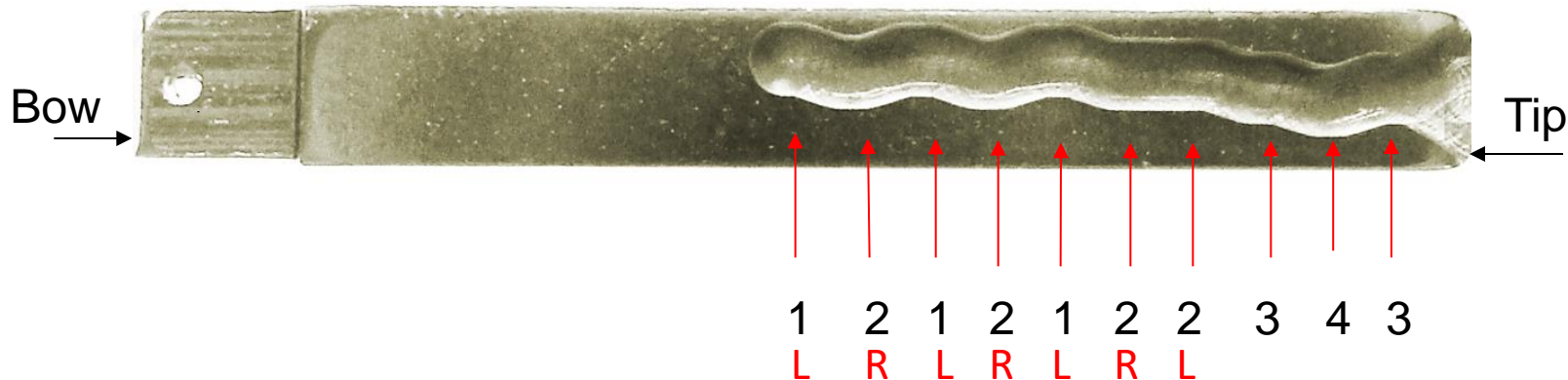
2R – 4201935 - **Need 3**

3L - 4201936 - 0 needed

3R – 4201938 - 0 needed

4L - 4201937 - 0 needed

4R – 4201939 - 0 needed



\*Cuts 8,9 and 10 not used for the ignition.

## Ignition Pinning Diagram – Side Mill Truck

4) Slide sleeve(4) over cylinder to secure tumblers. Do not remove key. Rotate sleeve to match slot for actuator component tab, insert actuator (5), and then rotate back until tumblers snap into sleeve slot.

5) Insert reatainer spring (6) and retainer(7) and finally insert retainer collar(8) until reainer snaps.

6) Insert wingless knob (9) as shown.

