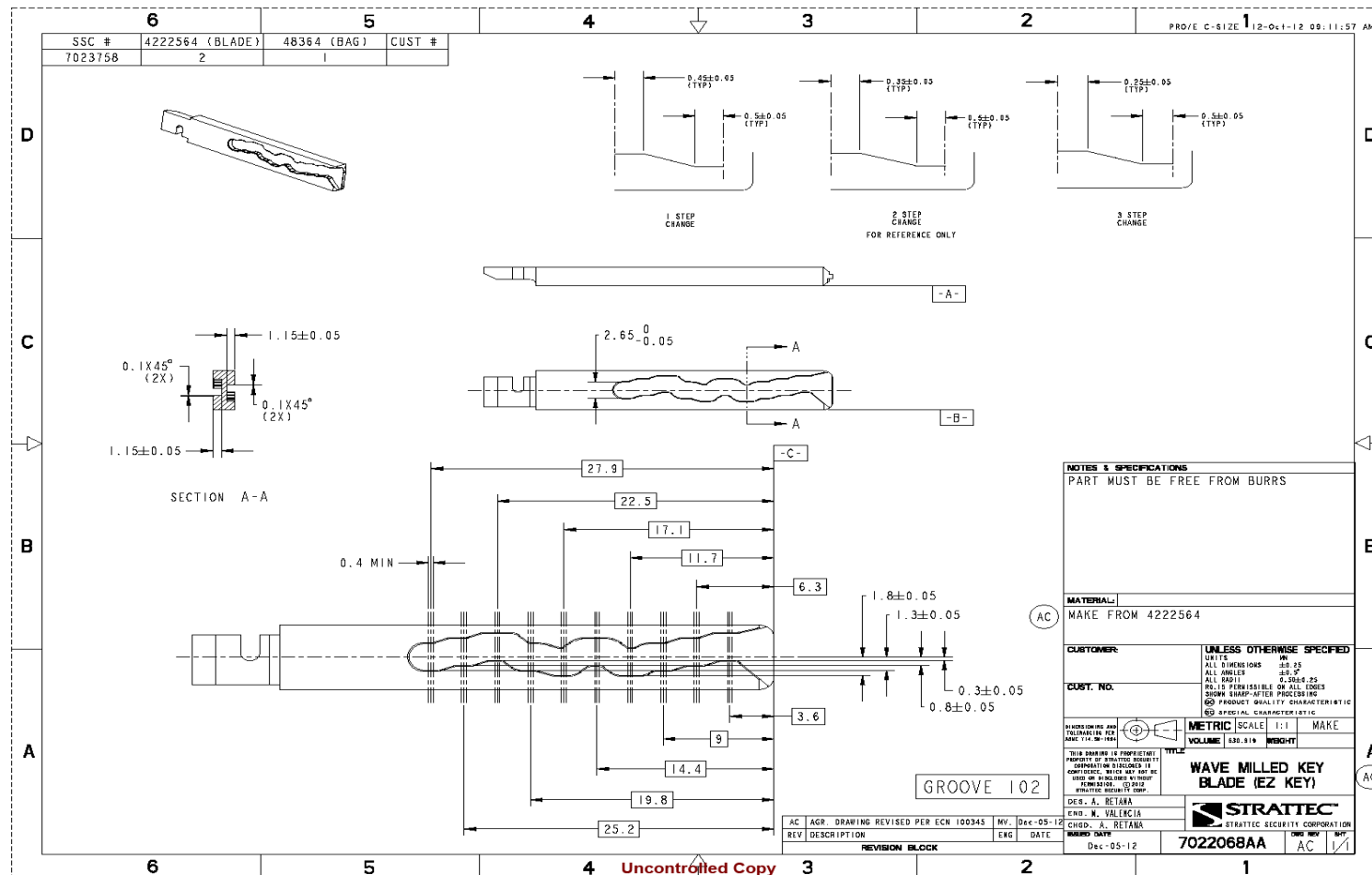


PINNING INSTRUCTIONS GM SIDE MILL TRUCK



SIDE MILLED 102 GROOVE SPECS – 10 CUT



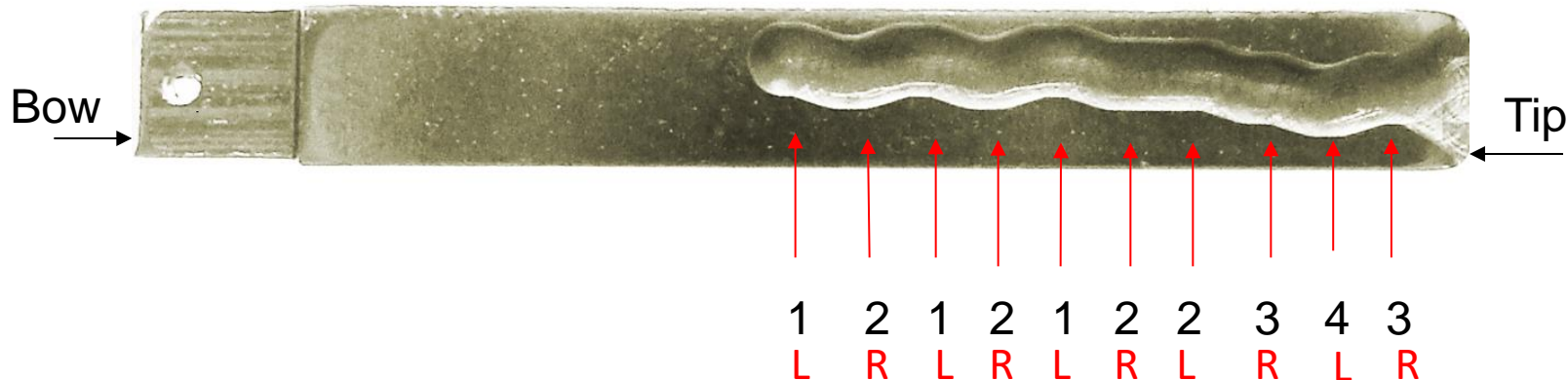
GM SIDE MILL TUMBLER POSITIONS

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)

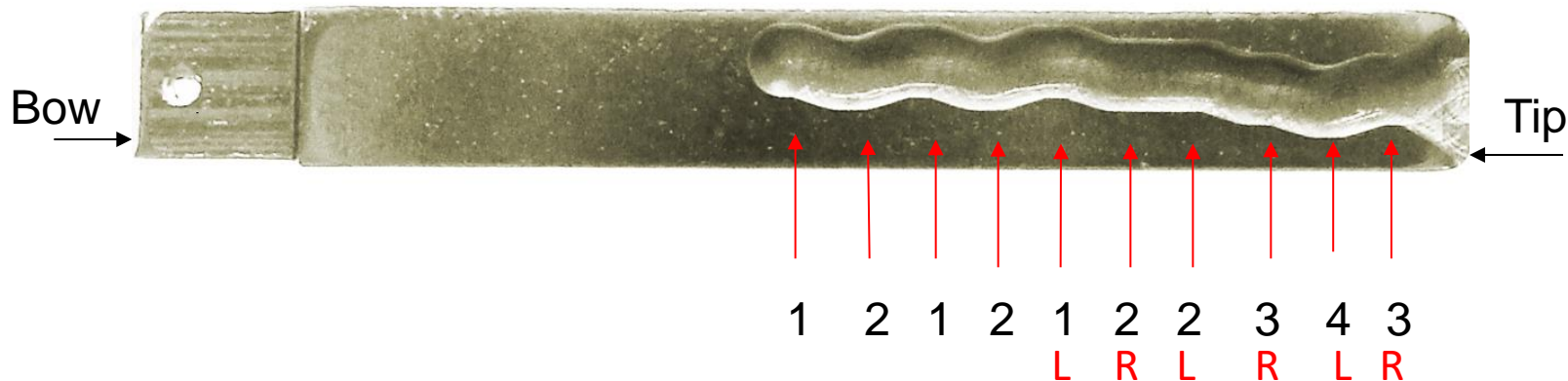


Door Pinning – Side Mill Truck

- 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 1**
 2L - 4201933 - **Need 1**
 3L - 4201936 - 0 needed
 4L - 4201937 - **Need 1**

1R – 4201934 – 0 needed
 2R – 4201935 - **Need 1**
 3R – 4201938 - **Need 2**
 4R – 4201939 - 0 needed



Door Pinning Diagram – Side Mill Truck

4) With the key fully inserted into the cylinder, install it into the case (4). Hold the case and the lever while pressing in on the cylinder and rotate 90 degrees. Remove the key being careful to ensure cylinder is locked in case.

5) Install the lock cylinder cap by aligning the open window with the corresponding protrusion area of the case. Snap into place with light hand pressure.

