

1993 SATURN SERVICE INSTRUCTIONS



 BRIGGS & STRATTON TECHNOLOGIES

SATURN CONTINUES TO GROW!

Saturn Offers 4 Models

SL	Sports Sedan
SL2	Sports Touring Sedan
SC	Sports Coupe
SW	Station Wagon

KEY DETAIL



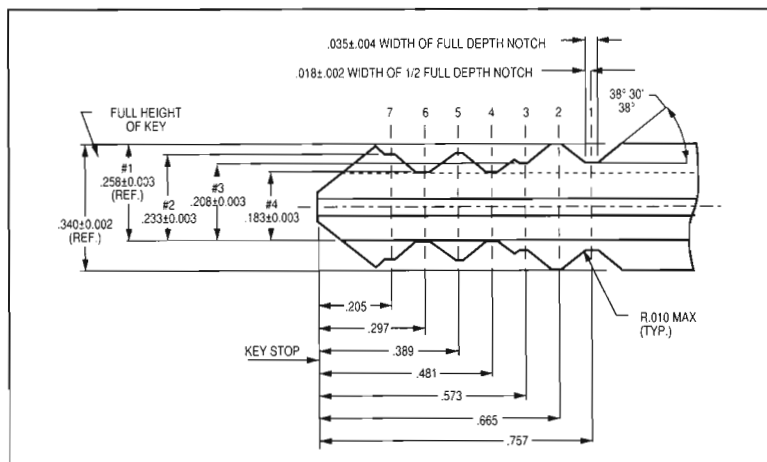
- 1.) Key is double sided and reversible.
- 2.) Single key operates all locks.
- 3.) Code series: R000-R999
T000-T394
 - a.) The "R/T" code will not be stamped on any Locks.
 - b.) A plastic bag with a bar coded paper label will accompany the car to the dealership. The last 4 characters of bar code label identify the key code.



SATURN KEY BITTINGS R000-R999 T000-T394






CODE	MASTER	IGNITION	DOOR	R/C
R000	4421213	442121	42121	21213
R001	4234244	423424	23424	34244
			22121	31213

DEPTH AND SPACING DETAIL



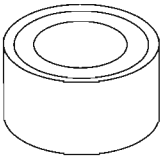
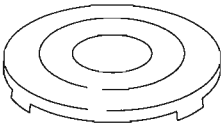
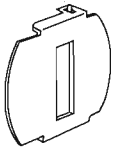

- 1.) The key is gauged from the tip of the key.
- 2.) Codes are listed bow to tip.
- 3.) Keys use 7 cuts and 4 depths.

TUMBLER DETAIL

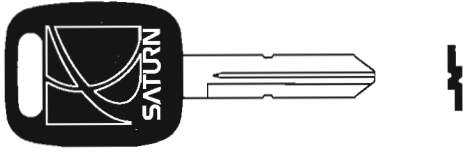
				
A 321761 TUMBLER #1	B 321762 TUMBLER #2	C 321763 TUMBLER #3	D 321764 TUMBLER #4	E 46890 TUMBLER SPRING

- 1.) Four tumblers are used that correspond to key cuts. 4 depths = 4 corresponding tumblers
- 2.) All tumblers have numbers stamped on them.
- 3.) Tumblers are snap-in design.

CAPS-N-SHUTTERS

	Standard Snap Cap (Door) (Tailgate 4 Door)	Service Cap (Tailgate 2+2)	Unit Shutters All	Shutter Springs All
CHROME	 321687	 321899	 594753	 46912

CODING INSTRUCTIONS

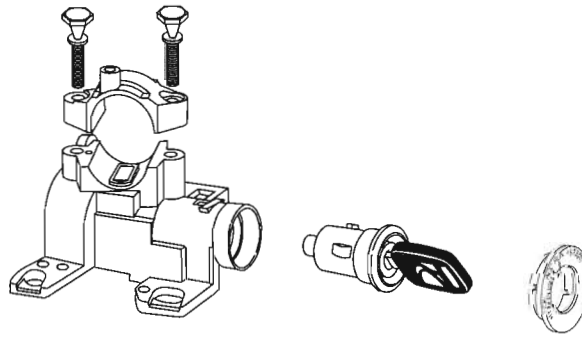


BITTING CHART

Lock Assembly	1	2	3	4	5	6	7	
Ignition	x	x	x	x	x	x		1st 6 cuts
Door		x	x	x	x	x		
Rear Compartment			x	x	x	x	x	Last 5 cuts

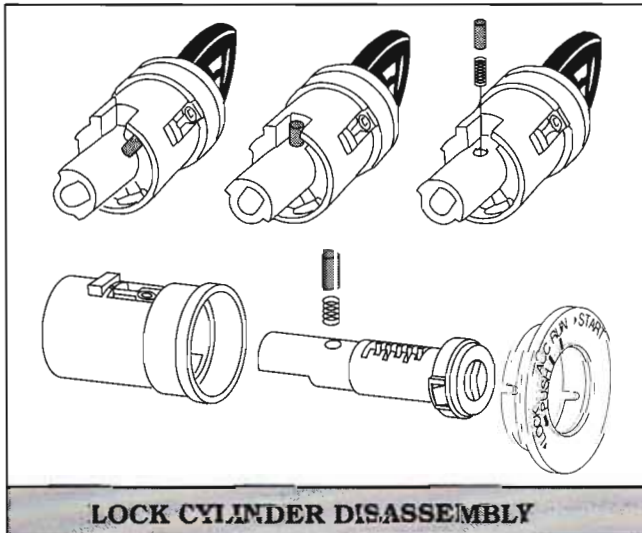
- 1.) Determine bitting of the key from codebook or key.
- 2.) From the bitting chart, determine tumbler positions required for lock service.
- 3.) Install appropriate springs and tumblers.
- 4.) Snap into place.
- 5.) Test with key.

IGNITION



LOCK CYLINDER REMOVAL






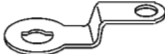
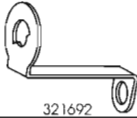






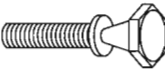
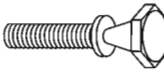













- 1.) Remove snap-on trim bezel. (Bezel should be replaced)
- 2.) Turn key to Accessory position and depress rectangular retainer block.
- 3.) Remove lock cylinder and sleeve from housing.



LOCK CYLINDER DISASSEMBLY

- 1.) Turn key clockwise to stop.
- 2.) Carefully depress spring loaded retainer pin and turn cylinder clockwise, until retainer pin appears in insertion slot.
- 3.) **Pin is loose and will FLY, use EXTREME CARE.**

SATURN SERVICE KIT 701678

 47615	 46906	 321976	 46949		
 321688	 321691	 321692	 94566	 380715	 380540
 380705	 380706	 380706	 94431	 94431	 83331
 321687	 321687	 321899	 321899	 594753	 46912
 321761	 321762	 321763	 321764	 46890	 46859

701678 SERVICE KIT CONTAINS

Tumbler #1	321761	100
Tumbler #2	321762	100
Tumbler #3	321763	100
Tumbler #4	321764	100
Tumbler springs	46890	100
Shutter springs	46912	100
Locking Springs	46859	100
E-Clip	94566	50
Pin	83331	50
Rod Retainer (Door)	380715	20
Shutter	594753	10
Rod Retainer (Tailgate)	380540	6
Shear Bolt	94431	6
Gasket (2+2 Tailgate)	47615	5
Snap Cap	321687	5
Service Cap	321899	5
Pawl(Standard)	321688	5
Pawl(Electric)	321691	5
Pawl(Tailgate)	321692	5
Return Spring (Tailgate)	46906	4
Bezel Ignition	380706	3
Return Spring (Tailgate 5 Dr.)	46949	4
Pawl (Tailgate 5 Dr.)	321976	5