

# GENERAL MOTORS

## INSTRUCTION SHEET FOR ASSEMBLING AND CODING IGNITION LOCK

The ignition lock cylinder uses only nine of the ten cut positions, 1 through 9. The ignition cylinder tumblers (2) are all located on one side of the cylinder (1) and not self-retaining. A retainer (4) secures the tumblers. It follows the key code with the first tumbler being the first depth of the key code, closest to the head of the key.

1. Hold the ignition cylinder (1) so that the side with the tumbler spring wells is facing up.
2. The first tumbler (2) to be loaded will be the first key cut position, the first number in the key code. Install the first tumbler in the slot nearest the head of the lock cylinder. Install the remaining tumblers following the key code.
3. Insert tumbler springs (3) into the spring wells on top of the tumblers.
4. Insert the retainer (4) over the springs making sure the springs are not misaligned. Secure by stacking cylinder material over edges of the retainer with either a flat head screwdriver or center punch on each of the four corners of the retainer.
5. Inspect for correct loading of the tumblers by inserting the key into cylinder. The side bar should drop flush with the lock cylinder body diameter.
6. Lightly lubricate the outside surfaces in the tumbler area of the lock body and down the key slot using the supplied grease. Insert and extract key 5 times to lubricate the keyway.
7. Line-up the lock to the run position. Insert lock in steering column. Rotate lock to key out position and remove key. Insert key and rotate lock 3 times to distribute the grease from the lock to column housing inside diameter.

