

# GENERAL MOTORS

## INSTRUCTION SHEET FOR ASSEMBLING AND CODING IGNITION LOCK

The ignition lock cylinder uses only eight of the ten cut positions, 2 through 9. The ignition cylinder tumblers (3) are located on alternate sides of the cylinder (1). They are snap-in and self-retaining. 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 assembly (1) so that the side with the tumbler spring pocket located closest to the head of the cylinder is facing up.
2. Insert tumbler spring (2) into each of the spring pockets of the cylinder assembly.
3. The first tumbler (3) to be loaded will be the second key cut position, the second number in the key code. Install the first tumbler in the slot over the spring. Install the remaining tumblers for cuts 4, 6, and 8 following the key code and same process. Pressing the tumblers in place until they are secure.
4. Rotate cylinder assembly. Insert tumbler spring into the spring into each of the spring pockets of the cylinder assembly.
5. The first tumbler to be loaded will be the third key cut position, the third number in the key code. Install the first tumbler in the slot over the spring. Install the remaining tumblers for cuts 5, 7, and 9 following the key code and same process. Pressing the tumblers in place until they are secure.
6. 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.
7. Lightly lubricate the outside surfaces in the tumbler area of the lock body and down the key slot using the provided grease. Insert and extract key 5 times to lubricate the keyway.
8. 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.

