

# GENERAL MOTORS

## INSTRUCTION SHEET FOR ASSEMBLING AND CODING INTERNAL LOCKS

The internal lock cylinder only uses five of the ten cut positions, 6 through 10. The tumbler positions are on one side and self-retaining. After removing the current lock, identify the direction the lever and rod clip are attached to the tail of the lock.

1. Hold the cylinder (1) so the side with tumbler spring wells faces up.
2. Insert tumbler springs (2) into the five spring wells.
3. Install the first tumbler (3) for key cut position 6 in the slot closest to the cylinder head. Install the remaining tumblers following the key code.
4. Press the tumblers in place until they are secure.
5. Check for correct loading of the tumblers by inserting the key into cylinder. All of the tumblers should be flush with the lock cylinder body.
6. Insert key into cylinder, assemble the cylinder into the cylinder case (4) by locating the end of the cylinder body with the lug feature inside the end of the cylinder case. Rotating cylinder CW to secure in case.
7. Assemble rod clip (6) to lever (5) using the recorded lever information.
8. Assemble lever to lock. Use e-clip (7) to retain lever assembly.
9. Insert key into the lock and function lock to check for proper assembly and smooth operation.

