

# GENERAL MOTORS

## INSTRUCTION SHEET FOR ASSEMBLING AND CODING INTERNAL LOCKS

The internal lock cylinder only uses four of the ten cut positions, 7 through 10. The tumbler positions are on one side and self-retaining. After removing the current lock, identify the direction the lever is 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 four spring wells.
3. Install the first tumbler (3) for key cut position 7 in the slot nearest to the front of the lock cylinder. Install the remaining tumblers following the key cod.
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. 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.
7. Apply lubricant to cylinder body and tumbler surfaces along with a small amount in head of cylinder using the supplied grease.
8. Install spring (4) into the spring well in head section of cylinder.
9. Snap the shutter assembly (5) into cylinder.
10. Assemble cylinder into case (6).
11. Place the lock cylinder cap (7) on top of cylinder/case assembly. Roll cap tabs to underside of case. Verify cap is sure secure and pulled tight to case.
12. Assemble lever (8) to lock. Use e-clip (9) to retain lever assembly.
13. Insert the key into the lock and function lock to check for proper assembly and smooth operation.
14. Assemble to vehicle using the new lock clip.

