

D0008557 Modified cylinder Assembly

Instructions to pre assemble modified cylinder before dispatch

 Difficulty Easy

 Duration 10 minute(s)

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Comments

Introduction

Parts required

D0008557 modified cylinder x 1
F0000016 M6 x 30 socket cap x 2
F0000018 M6 x 40 socket cap x 2
M0000180 spring x 2

Tools required

5mm Hex key
Loctite 270 thread lock

Step 1 - Remove Original fasteners on locking mechanism

Remove 4 off original shallow head fasteners (if still fitted after cylinder modification)) that hold locking assembly onto cylinder and dispose



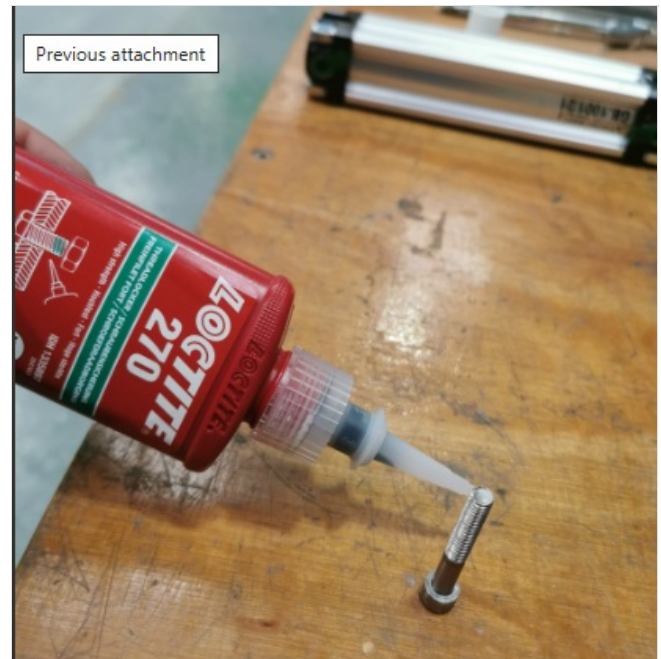
Step 2 - Ensure Cylinder and locking unit are orientated correctly

Ensure cylinder and locking unit are orientated correctly as shown



Step 3 - Loctite 270 MUST be used

Ensure all bolts fitted have Loctite 270 applied



Step 4 - Add 1st fixings

Fit 2 off M0000180 springs to F0000018 M6 x 40 socket caps as shown and fit to cylinder



...Only wind the socket caps in 2 turns to allow fitment of next step socket caps



Step 5 - Add 2nd fixings

Fit 2 off F0000016 M6 x 30 socket caps as shown



Step 6 - Tighten all fixings

Tighten all for socket caps until the bottom out at the base of the threaded hole on the cylinder



Step 7 - Check movement

Check locking assembly can move by hand when pulled in the direction shown by approximately 5mm, and springs back to its original position by spring pressure alone



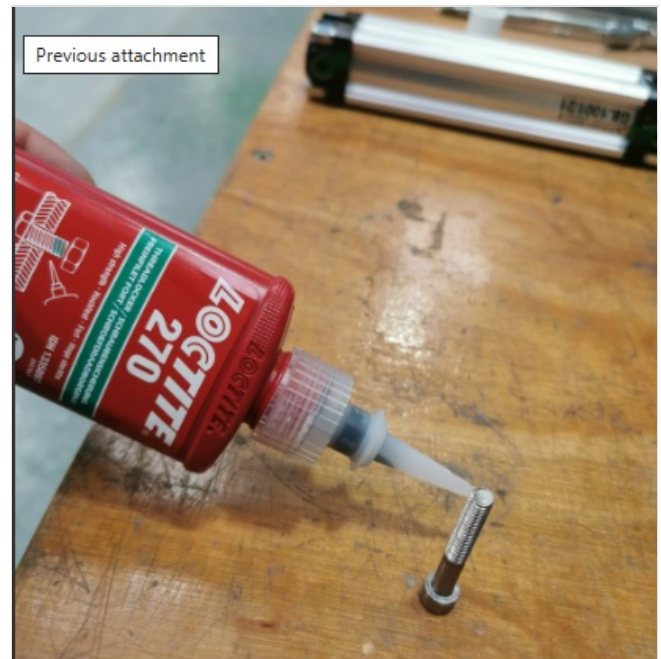
Step 8 - Ensure Cylinder and locking unit are orientated correctly

Ensure cylinder and locking unit are orientated correctly as shown



Step 9 - Loctite 270 MUST be used

Ensure all bolts fitted have Loctite 270 applied



Step 10 - Add 1st fixings

Fit 2 off M0000180 springs to F0000018 M6 x 40 socket caps as shown and fit to cylinder



...Only wind the socket caps in 2 turns to allow fitment of next step socket caps



Step 11 - Add 2nd fixings

Fit 2 off F0000016 M6 x 30 socket caps as shown



Step 12 - Tighten all fixings

Tighten all for socket caps until the bottom out at the base of the threaded hole on the cylinder



Step 13 - Check movement

Check locking assembly can move by hand when pulled in the direction shown,
And springs back to its original position by spring pressure alone

