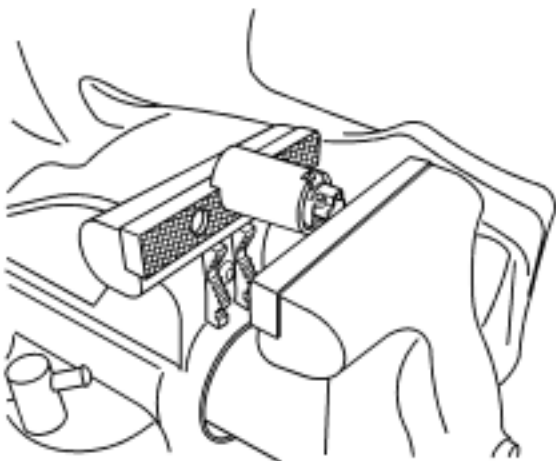
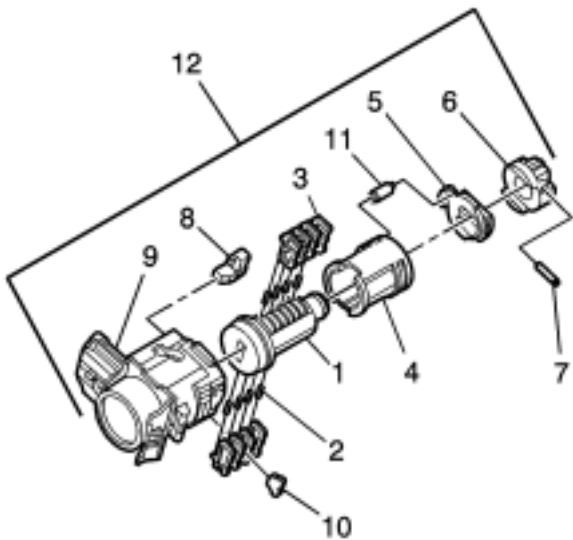


12. Load the cylinder into the *BO-49753* assembly tool so that the clutch (1) indexes with the notch in the opening of the tool (2).



13. Load the assembly tool with the lock cylinder into a vice and tighten the vice **ONLY** enough to hold the tool and lock the cylinder in place.



- 14. Insert the roll pin (7) into the driver (6) and install it using a 1/16inch pin punch.
- 15. Insert the buffer (8) in the case (9), verify the buffer is properly seated.
- 16. Install the free wheel pin (11) in the sleeve (4) and clutch (5) and insert the assembly into the case (9).
- 17. With the lock cylinder assembly installed in the case (9), install the retainer (10) and stake the retainer in place using a small punch and hammer to peen the case material onto the exposed ends of the installed retainer (10).
- 18. Insert the key into the lock and function the lock to check for proper assembly and smooth operation.