



# TH31

## Lock Cylinder

**Uniform  
Procedures For  
Collision Repair  
UPCR**

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v.4.0



### 1. Description

This procedure describes methods for replacing a panel-mounted lock cylinder. Inspection and evaluation requirements are also included.



### 2. Purpose

The purpose of this procedure is to provide industry-accepted requirements for performing high-quality repair of panel-mounted lock cylinders. This procedure is intended for use by professionals who are qualified through training and experience.



### 3. Referenced Documents

The following documents are considered part of this procedure by reference.

#### 3.1 Procedures

PS01 Personnel Safety

#### 3.2 Other Information

Recycled parts information

Vehicle-specific repair information



## 4. Equipment And Material Requirements

### 4.1 Equipment

The use of clip removal tools is included in this procedure.



## 5. Damage Analysis

### 5.1 General Damage

Inspect a lock cylinder for these conditions:

- visible damage
- corrosion
- improper operation
- loose or improper mounting
- damaged, or out-of-position, lock rods
- damaged gasket
- signs of tampering or forced entry

Do not attempt to repair a damaged lock cylinder or attaching lock parts. Determine whether the lock cylinder or other lock parts require replacement. Replacement lock cylinders must be rekeyed to match the other lock cylinders on the vehicle. Verify the availability of replacement parts.



## 6. Personnel Safety

### 6.1 General Safety

General safety information is in **PS01**.

### 6.2 Express Power Window Safety

Disconnect the power window switch before working inside doors equipped with express power windows.



## 7. Environmental Safety

Does not apply.



## 8. Vehicle Protection

### 8.1 Lock Cylinder Adjacent Areas

To protect the adjacent areas when replacing a lock cylinder:

- Use the proper clip removal tools on door and lock cylinder clips.
- Do not force the lock cylinder from its mounting.
- Do not force the key when opening the lock.



## 9. Repair Procedure

### 9.1 Door Lock Cylinder Removal

To remove a door lock cylinder:

- 1. Raise the window.
- 2. Remove the interior door trim panel, if required.
- 3. Disconnect the electrical connector from the door lock, if required.
- 4. Disconnect the lock rod from the door latch. Replace locking clips or retainers, if required by the vehicle maker.
- 5. Remove the locking clip holding the lock cylinder to the door.
- 6. Remove any door lock fasteners.
- 7. Remove the door lock cylinder.

### 9.2 Door Lock Cylinder Installation

To install a replacement door lock cylinder:

- 1. Verify that the replacement lock cylinder is keyed the same as the other exterior locks on the vehicle.
- 2. Position the door lock cylinder on the door and install the fasteners. Torque the fasteners to the vehicle maker's recommendations, if required.
- 3. Install the retaining clip. Duplicate the original installation method, ensuring that the clip is facing in the original direction.
- 4. Reconnect the lock rod to the door latch.
- 5. Reconnect the electrical connector to the door lock cylinder, if required.
- 6. Check manual and power operation of lock.
- 7. Reinstall the water shield and interior door trim panel.
- 8. Continue vehicle reassembly.

### 9.3 Deck-Lid, Hatch, Liftgate, Or Tailgate Lock Cylinder Removal

**(cont'd)**



## 9. Repair Procedure (cont'd)

To remove a rear compartment lock cylinder:

- 1. Open the rear compartment.
- 2. Remove the parts required for access to the lock cylinder, and to prevent damage.
- 3. Remove the retaining rivets or fasteners, if required.
- 4. Disconnect the lock rod, if required.
- 5. Remove the lock cylinder.

### 9.4 Deck-Lid, Hatch, Or Liftgate Lock Cylinder Installation

To install a rear compartment lock cylinder:

- 1. Verify that the replacement lock cylinder is keyed the same as the other exterior locks on the vehicle.
- 2. Install the replacement lock cylinder, duplicating the original mounting methods.
- 3. Make sure the replacement lock cylinder is properly positioned and any applicable spacers are installed.
- 4. Reconnect the lock rods, if required.
- 5. Install rivets or other fasteners, if required. Torque the fasteners to the vehicle maker's recommendations.
- 6. Reinstall all parts removed for access.
- 7. Test the lock cylinder for proper operation before closing the rear compartment.  
See **11.1**.



## 10. Use Of Recycled (Salvage) Parts

### 10.1 Condition Of Salvage Parts

Do not use salvage lock cylinders with these conditions:

- visible damage
- damaged or missing mounting locations
- replacement lock cylinder is unable to be keyed the same as the other exterior locks on the vehicle



# 11. Inspection And Testing

## 11.1 Inspection Of Lock Cylinders

Inspect a replaced lock cylinder for these conditions:

- proper mounting and position
- lock rods installed in the proper position
- proper operation in both manual and power modes
- ease of operation with the proper key

Correct any defects.