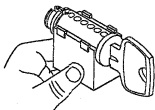


HOW TO ASSEMBLE SARGENT SIGNATURE CYLINDERS

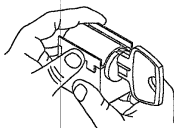
LOADING SIGNATURE CYLINDER PLUGS

1.



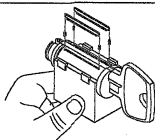
Insert cylinder plug, with correct bitted and dimpled key, into base of service tool. Select bottom and master pins from from key bitting list. Load cylinder plug with appropriate pins.

2.



Snap on cover onto service tool. Rotate cylinder plug 180° (pins will drop into holes within service tool).

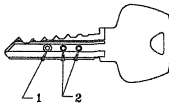
3.



Expose offset bar slots in cylinder plug by removing service tool cap. Place offset bar springs into offset bar holes in cylinder plug. Insert offset bars into slots in cylinder plug. (Be sure bars are oriented according to the following guide)

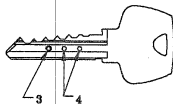
GUIDE TO OFFSET BAR ORIENTATION

For Keys with 1 & 2 dimple depths (Inboard bar orientation)=face witness mark away from key.
 For Keys with 3 & 4 dimple depths (Outboard bar orientation)=face witness mark toward key.



1 & 2
DEEP DIMPLE
DEPTHS SHOWN

DIMPLE IDENTIFICATION

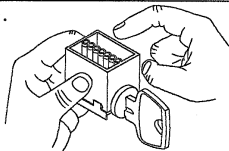


3 & 4
SHALLOW DIMPLE
DEPTHS SHOWN

HOW TO ASSEMBLE SARGENT SIGNATURE CYLINDERS

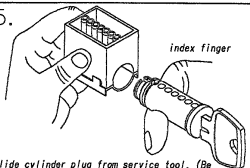
LOADING SIGNATURE CYLINDER PLUGS

4.



Snap on cover to service tool. Turn service tool upside down. Tap the top or bottom of service tool. (this will allow pins to drop back into cylinder plug)

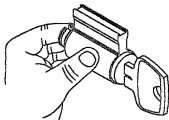
5.



Slide cylinder plug from service tool. (Be sure to place your index finger on the under side of the cylinder plug. This is to keep offset bars from dropping out.)

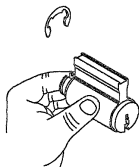
For body loading information refer to cylinder body Instruction sheet A7079A

6.



Load cylinder plug into cylinder body.

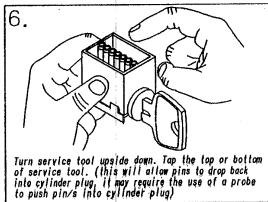
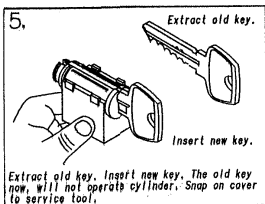
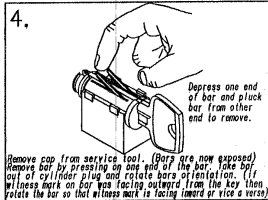
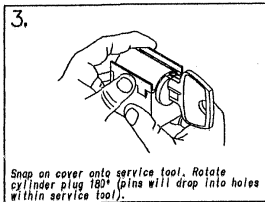
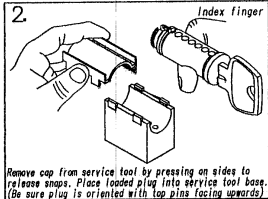
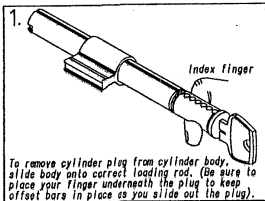
7.



Assemble correct retainer, cap or cam onto back of cylinder plug.

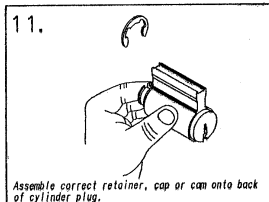
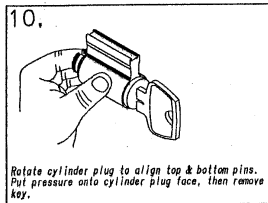
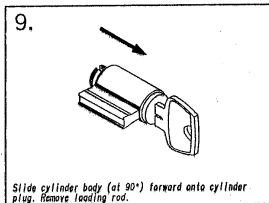
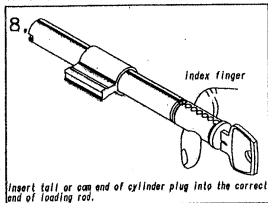
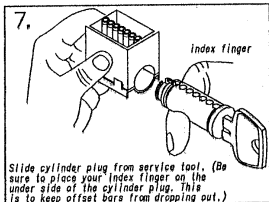
HOW TO ASSEMBLE SARGENT SIGNATURE CYLINDERS

HOW TO REVERSE OFFSET BAR ORIENTATION



HOW TO ASSEMBLE SARGENT SIGNATURE CYLINDERS

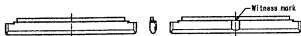
HOW TO REVERSE OFFSET BAR ORIENTATION



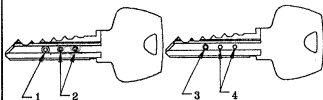
GUIDE TO OFFSET BAR ORIENTATION

For Keys with 1 & 2 dimple depths (Inboard bar orientation)-face witness mark away from key.

For Keys with 3 & 4 dimple depths (Outboard bar orientation)-face witness mark toward key.



DIMPLE IDENTIFICATION



1 & 2
DEEP
DIMPLE
DEPTHS
SHOWN

3 & 4
SHALLOW
DIMPLE
DEPTHS
SHOWN