

## Servicing Instructions for Model 951 Series Cast Body Padlock

### Disassembly

1. Insert the "Control Key" and rotate it ¼ turn counterclockwise.

2. Lift the padlock shackle and rotate it ½ turn.

3. Slide the upper case and lower case sections apart, as illustrated at the left in Figure 1. Set the upper case aside.

4. Rotate the "Control Key" back to the locked position and remove it.

5. Covering the top of the lower case, turn it upside down to remove the key cylinder, key cap, cam, and the heel side locking ball.

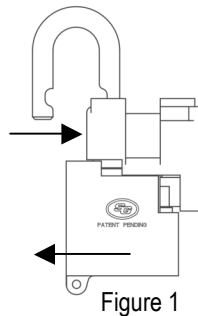


Figure 1

### Cleaning and Lubrication

1. Clean all surfaces with mineral spirits or a comparable cleaning solvent.

**WARNING:**  
**USE CLEANING SOLVENTS ONLY IN A WELL-VENTILATED AREA.**

2. Prior to reassembly, the upper case assembly must be lubricated using a lubricant conforming to Department of Defense Specification MIL-G21164. See Figure 2 for lubrication points.

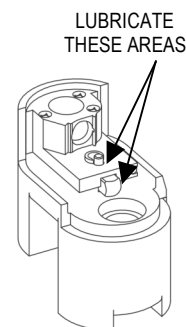


Figure 2

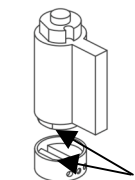


Figure 3  
ALIGN THE FLAT OF THE  
CAP WITH THE FLAT OF  
THE CYLINDER

### Assembly

1. Place the key cap over the end of the key cylinder. Align the flat of the key cap to the flat of the cylinder, as shown in Figure 3.

2. With the lower case held upside down, align the key cylinder with the cylinder opening in the case and insert the key cap and key cylinder into the lower case, as shown in Figure 4.

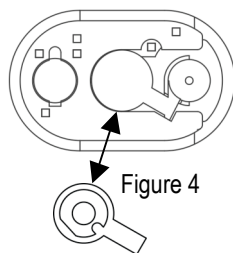
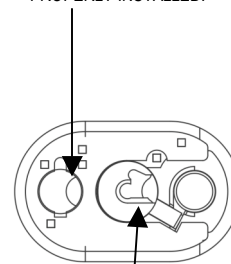


Figure 4

EDGE OF LOCKING BALL  
CAN BE SEEN THROUGH  
SHACKLE HOLE WHEN  
PROPERLY INSTALLED.



GROOVE OF CAM MUST BE IN  
THIS POSITION WHEN  
CONTROL KEY IS ROTATED  
FOR ASSEMBLY

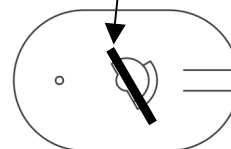


Figure 5

3. Turn the lower case right side up and apply downward pressure on the key cylinder as you insert the "Control Key" and rotate it ¼ turn counterclockwise. The key needs to remain in the lock for now.

4. Install the locking ball removed in disassembly step 5. Pass it over the top of the key cylinder to place it in the circular opening between the cylinder cavity and the shackle cavity.

5. Place the cam on top of the cylinder. Make sure the cam is aligned as shown in Figure 5 after installation.

6. Slide the upper case assembly back on to the lower case (see Figure 1).

7. Rotate the shackle so that it can be inserted into the shackle hole. Once the shackle is closed, turn the key ¼ turn clockwise and remove the key.

### Operations Check

**Note: It is recommended that the lock be operated several times to insure it is working properly.**

1. Insert the operator key and rotate it ¼ turn clockwise.

2. Lift the shackle and rotate ½ turn.

3. Insure the upper and lower case will not slide apart.

**Note: if the upper and lower case sections slide apart, the "Control Key" was turned clockwise instead of counterclockwise during assembly. Go back to step 4 of the assembly instructions.**