

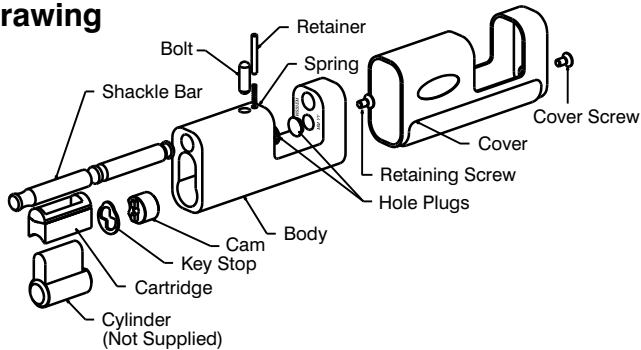


Lockmakers since 1780

## Fitting Instructions

How to fit a euro profile cylinder to a  
**Stronghold® BULLIT™ WS50EM** lock

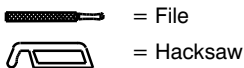
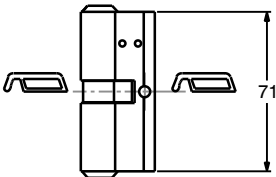
### Assembly Drawing



### How to modify a Euro Profile Cylinder

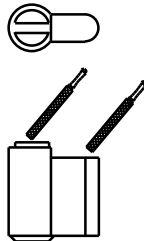
1

A single or double cylinder can be modified. A 71mm equal sided double is recommended.



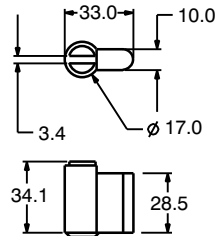
2

Modify it by cutting and filing.



3

The modified cylinder should have these dimensions which are critical



N.B. Remember you now have two cylinders, more keys may be required.

### Henry Squire & Sons Limited

Hilton Cross Business Park, Cannock Road, Featherstone, Wolverhampton, WV10 7QZ

Tel: 01902 308050

Fax: 01902 308051

E-Mail: [info@henry-squire.co.uk](mailto:info@henry-squire.co.uk)

Website: [www.squirelocks.co.uk](http://www.squirelocks.co.uk)



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Fig. 1

(view from key entry end)

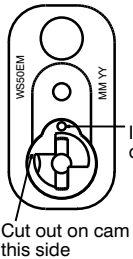


Fig. 2

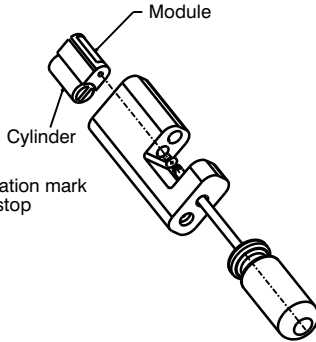


Fig. 3

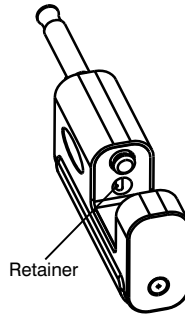
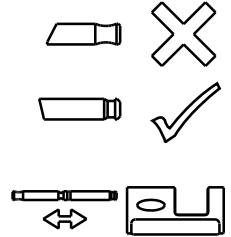


Fig. 4



## Fitting Instructions

### IMPORTANT NOTES: READ ALL INSTRUCTION BEFORE PROCEEDING.

**NOTE:** - DO NOT REMOVE OR REPLACE THE SHACKLE BAR WITH THE COVER REMOVED (Danger of flying parts) .

1. Modify a euro cylinder to the dimensions shown (How to modify a euro cylinder)
  2. Remove the Cover, Shackle Bar and the module from the lock body,
  3. Check that the Cam and Key stop are in place and correctly aligned (fig 1)
  4. Insert the key into the cylinder unit (DO NOT TURN THE KEY) and insert the unit/module into the lock body. Operate the key so that the cylinder locates on the cam
  5. Insert the Module screw (identified by the pink Coating on the thread) through the body and tighten to hold the module in place (fig 2)
  6. Insert the Spring followed by the retainer into the small hole in the top of the body ensure that they are pushed fully home.
  7. Insert the bolt into the larger hole in the top of the body.
  8. Replace the Cover and secure with the Cover screw.
  9. With the key turned to the open position use a pair of suitable bent long nose pliers to firmly grasp the retainer through the hole (fig3) and push down the retainer at the same time fully insert the Shackle bar.
- IMPORTANT:** Ensure that the Shackle bar is correctly aligned (fig4)
10. Check that the lock functions correctly.
  11. Insert the hole plugs.