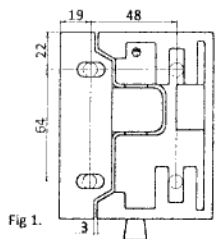


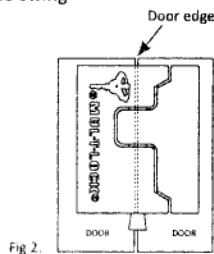
①

**Installation with screws**

Mark position of fixing screws (Fig 1).  
 Drill holes for M8 screws.  
 Allow a gap of 3 mm between lock parts.  
 Screws position can be slightly adjusted according to installation.

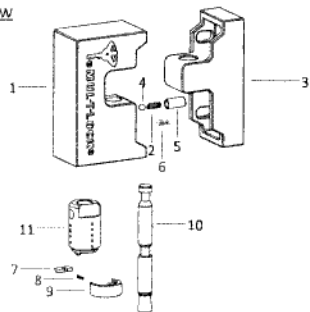


HaspLock position for double swing door or sliding door (Fig 2).



⑤

**General view**

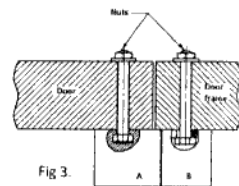


No.	Description	P/N
1	Lock body	28220251
2	Spring for locking pin	28220216
3	Mounting body	28220252
4	Ball bearing 5 mm	89400025
5	Locking pin	28220218
6	Hex head screw M4x10	31110410
7	Shutter	28220214
8	Spring for shutter	28220209
9	Protecting cover	28220211
10	Bolt	28220222
11	Cylinder assy.	N/A
12	Stopper screw	83100003

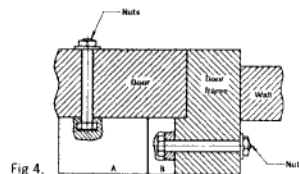
②

Place the HaspLock on the door. Slightly fasten M8 fixing screws with screw nuts (Fig 3).

**Note:** Check that the door can be opened and closed properly before complete tightening of the screws.



When using side screws, drill through holes in the frame, mount the screws and secure with nuts (Fig 4).



**Note:** Rivet or weld the nuts in order to protect from unauthorized disassembling.

⑥

**HaspLock service**

Unlock padlock with operating key.  
 Mount disassembling ring on bolt narrow part and remove the bolt by pulling it out carefully (Fig 8).

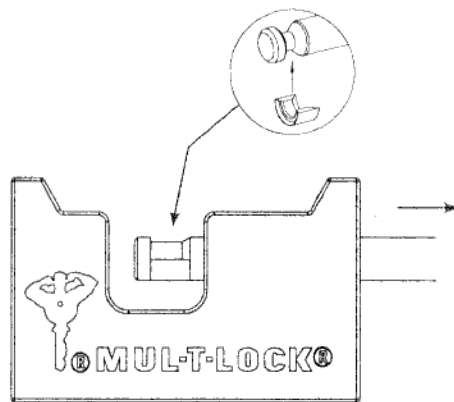


Fig 8.

③

**Installation by welding**

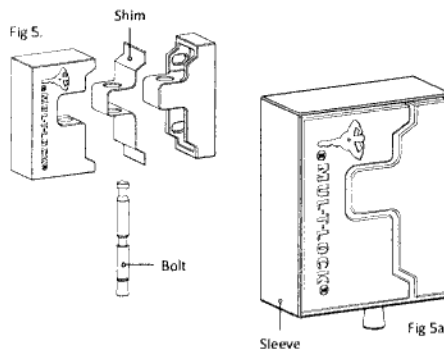
**Warning:**

To avoid any damage to the cylinder and mechanism remove them from HaspLock housing prior to the welding process.

See cylinder removal process on para. 6-9.

Clean surface to be welded from paint/dirt/grease etc. Insert the supplied shim between the two parts (Fig 5). Hold the two parts and the shim and mount on the supplied sleeve.

Insert the locking bolt to ensure proper alignment of the parts (Fig 5a). Take the bolt out.



⑦

Take out locking pin (5) spring (2) and steel ball (4). Use a T-handle Allen key (2mm) to unscrew cylinder fixing screw (6) (Fig 9).

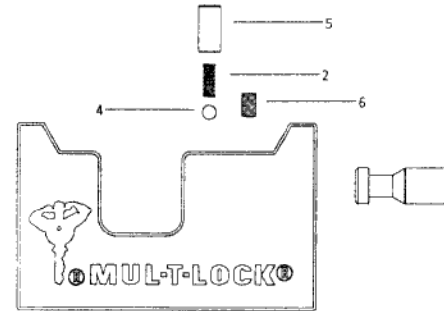


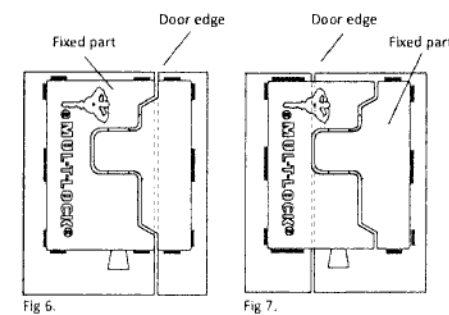
Fig 9.

④

Use standard carbon electrodes to weld the HaspLock temporarily in few welding points. Remove the shim and the sleeve. Check a free movement of the bolt inside the two parts. Check for proper operation of the door.

Complete welding areas. Seal cylinder and bolt openings and paint over the welded parts with appropriate rust-resistant paint. Note: when completing assemble the cylinder and mechanism. See service chapter on Para. 13-14. Check for proper operation of the lock and the door.

See two options (Fig 6) for left swing door and (Fig 7) for right swing door.



⑧

Pull cylinder (11) out from lock body (Fig 10) with operating key.  
 Take out operating key and remove cylinder protecting shield. Pay attention to the shutter and shutter spring.

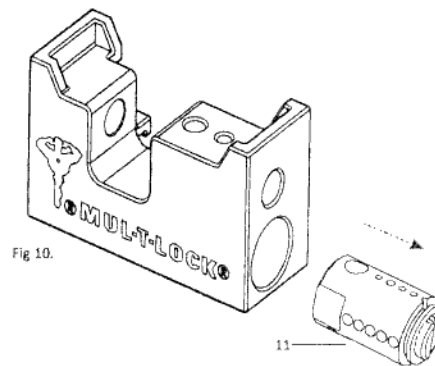


Fig 10.

⑨

Unscrew stopper screw (12) (Fig 11). Hold the plug pressed in as it may be pulled out. With operating key rotate cylinder plug 180° (plug pins opposite to body pins).

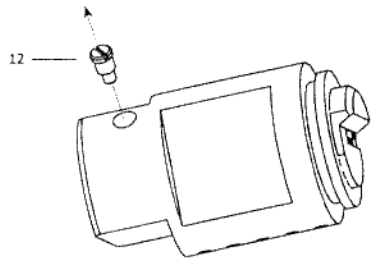


Fig 11.

⑩

At this stage it is possible to re-key the cylinder without removing the plug. Keep holding the plug pressed and take out the plug pins. Reassemble the new pins according to the new combination. Check for proper shear line with the new key.

**Note:** If plug removal is required rotate the plug to a safe removal position (Fig 12). Use a follower and carefully push the plug out (Fig 12a).

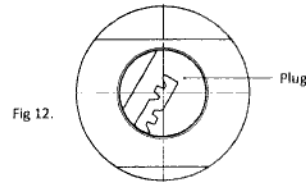


Fig 12.

Plug removal/insertion position

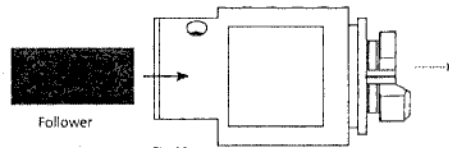


Fig 12a.

⑪

Insert the plug and push the follower out (Fig 13).

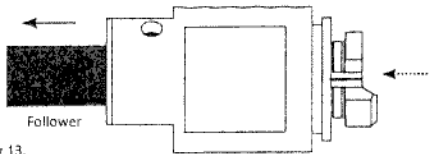


Fig 13.

**Note:** Plug should be rotated to the insertion position as shown in para 10 fig 12.

Rotate plug until locking. Tighten stopper screw (12) to cylinder body (Fig 14). Check for proper operation of the cylinder.

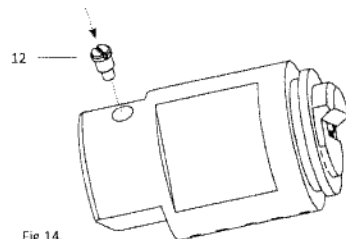


Fig 14.

⑫

Place shutter (7) and shutter spring (8). Install cylinder protector shield (9) over shutter and shutter spring (Fig 15).

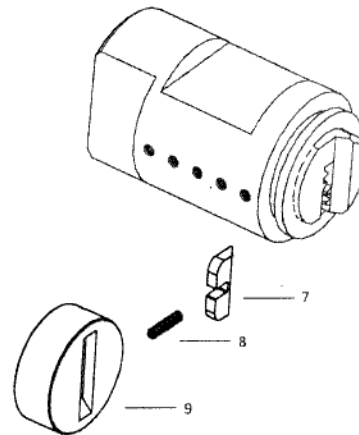
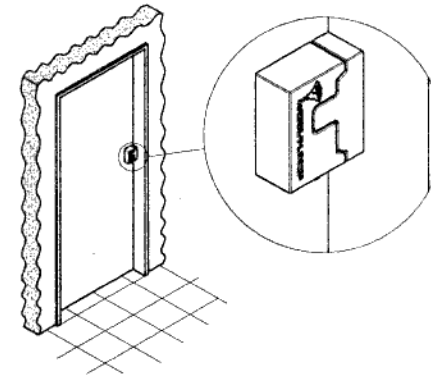


Fig 15.



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⑬

Insert cylinder and verify that the cylinder is in open position. Use a T-handle Allen key (2mm) to tighten fixing screw (6). Insert steel ball (4) spring (2) and locking pin (5). Press and hold the parts (Fig 16).

**Note:** When attempting to assemble in vertical position (after mounting) it is advisable to apply a small amount of grease on the steel ball (4) to keep it from falling.

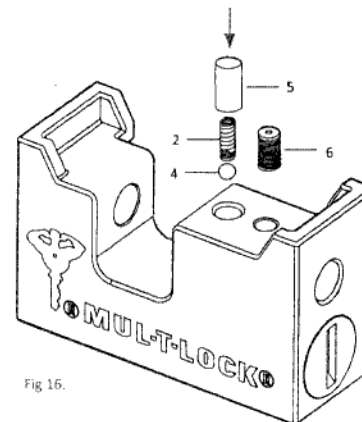
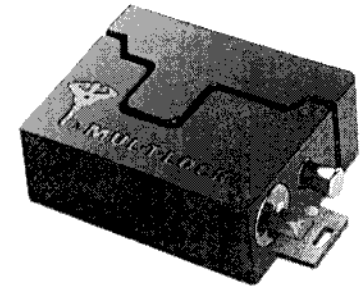


Fig 16.

# HaspLock

## Installation and Service Instructions



⑭

Mount disassembling ring on the bolt narrow part and push the bolt in. Remove bolt disassembling ring (Fig 17). Check for proper operation of the lock.

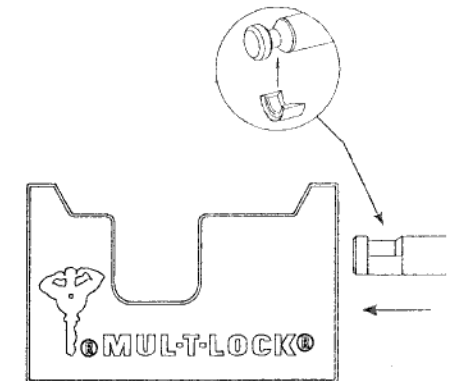


Fig 17.