DoD Lock Program

NAVFAC Engineering and Expeditionary Warfare Center

1100 23rd Avenue, Port Hueneme, CA 93043

(800) 290-7607 or (805) 982-1212

https://exwc.navfac.navy.mil/go/locks

Instructions for

High Security Padlock

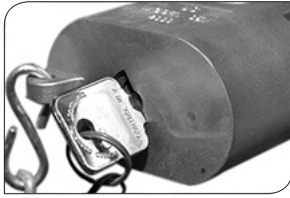# Shipboard Conversion

Date: 4/12/2021

Revised: 03/07/2023

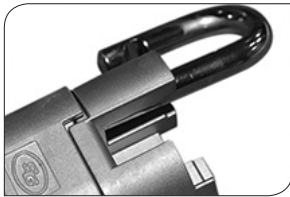# HIGH SECURITY PADLOCK SHACKLE REMOVAL PROCESS FOR SHIPBOARD USE:

Tools Required: 3/32" Punch, Hammer
Optional Tools: Vise, Grinder

1. DISASSEMBLE:

A. Insert control key (key with square bow) and rotate 90° counterclockwise to service position.

B. Lift shackle until shackle's toe is exposed, and rotate shackle 180° to position toe away from upper case.
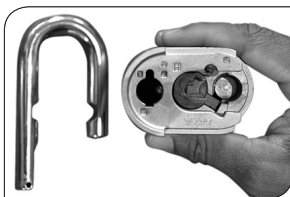
C. Slide upper and lower cases apart; set lower case aside. Ensure locking ball is retained in each case.

D. Rotate shackle 180° to position shackle's toe back towards upper case, then fully insert shackle into upper case. If available, place heel of shackle in vise.
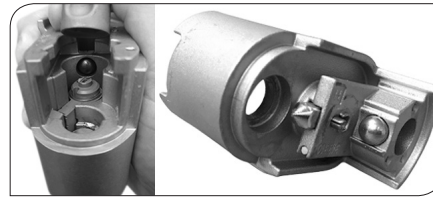
E. Using 3/32" punch and hammer, punch out pin located on the heel of the shackle. *Note: If unable to punch pin out, a grinder may be used to grind pin until it is flush with the shackle on both sides.*

F. Remove shackle from upper case.

2. REASSEMBLE:

A. Verify Lower case is fully assembled (w/ cap, lock cylinder, one locking ball, and cam) and upper case has one locking ball.

B. With control key in the service position, slide upper case and lower case together. Note: If cases don't slide together, re-check lower case components to ensure parts are properly seated to each other and retry.

3. OPERATIONAL TEST:

A. Re-insert detached shackle.

B. Rotate control key clockwise to locked position and remove control key.

C. Insert operator key (key with round bow) and rotate 90° clockwise to unlocked position.

D. Remove shackle and repeat steps multiple times to ensure operation is satisfactory.

Note: Shackle must be removed from padlock with an operator key before it can be used on a shipboard hasp.

4. INSTALLATION ON MIL-DTL-24653 SHIPBOARD HASP:

A. With padlock shackle removed and door open, attach padlock to the MIL-DTL-24653's affixed shackle.

B. Rotate operator key 90° counterclockwise to locked position, and remove key.

C. Test padlock operation with an operator key several times. Ensure padlock can be removed from shipboard hasp when key is rotated 90° clockwise to unlocked position.

D. Once lock operates satisfactorily, remove lock from hasp, close door and re-install lock to secure door.

Note: Do not discard removed shackles, as they are used to service padlocks and store padlocks without retained keys.

Note: Padlocks without inserted shackles or padlock service tools, must be stored with retained operator keys "only".

Note: Using control keys to operate or store padlocks may cause unintended padlock disassembly.