



ATTENTION: Refer to the appropriate shop manual for your vehicle to obtain specific service procedures for this part. If you do not have a service manual or lack the skill to install this part, it is recommended that you seek the services of a qualified technician. Pay special attention to all cautions and warnings included in the shop manual. Read and follow all instructions carefully.

Ford Expedition 1999, Ford F-150 1999, Ford F-250 1999

Ford PATs Key Learn Procedure for Dorman Products Remanufactured Instrument Clusters

The cluster you have received has been fully rebuilt and tested. During the remanufacturing process we remove all previously stored keys from its memory. The application for this cluster uses a *transponder key*, which is a small transmitter in the head of the ignition key to ensure that the vehicle cannot be easily stolen.

To install this cluster you must have a MINIMUM of 2 keys. If you only have one key, or if the keys you have are "clones" (these are aftermarket keys that have their unique identification transponder number copied) the cluster will not fully program and the vehicle will NOT start. If you are unsure or know you don't have two unique keys, we have enclosed and attached to the cluster a NEW key blank. Simply take it to a local locksmith or hardware store and have the key cut to match your existing keys. You now are certain you have two unique keys (the one provided with the cluster and the one you already have for the vehicle).

1. Install the cluster into the vehicle making sure to connect the wiring harness to the back of the cluster.
2. Insert the first key to be programmed into the ignition and turn it from the "LOCK" position to the "RUN" position. DO NOT START OR TRY TO START THE VEHICLE. Wait at least one second and turn the key back to the "LOCK" position and remove the key.
3. WAIT 5 SECONDS
4. Insert the second key into the ignition and turn to the "RUN" position. Wait at least one second and turn the key back to the "LOCK" position and remove the key.

Your two keys should now be programmed to the remanufactured Dorman instrument cluster.

5. WAIT 5 SECONDS or longer

Insert any of the two keys into the ignition and start the vehicle. If the programming was successful, the anti-theft light (seen in images below) will remain on for 3 seconds and then turn off after the vehicle starts. If the programming has failed, the light will blink rapidly as the car is trying to start and crank. If this occurs, simply unplug the cluster and wait 5 minutes. Repeat the above programming steps.

Disclaimer:

Even though every attempt is made to ensure this information is complete and accurate, it is impossible to account for all possible circumstances or situations. Please consult with a qualified auto technician before attempting to perform any work you are not qualified to do. Automobiles can be hazardous to work on; be sure to take all necessary safety precautions. Failure to do so may result in property damage or personal injury. Certain motor vehicle standards and performance requirements may apply to your motor vehicle (such as Federal Motor Vehicle Safety Standards by the National Highway Traffic Safety Administration). Be sure that your work is performed in accordance with such standards and that you do not disable any motor vehicle safety feature.



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Cluster with NO Tachometer – theft light location



Cluster with Tachometer – theft light location

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