



1825 VIA BURTON
ANAHEIM CA 92806
714-772-5202 / FAX 714-772-2302
EMAIL: MAIL@MAJORMFG.COM
WEB: WWW.MAJORMFG.COM

**INSTRUCTIONS
FOR
HIT-66-200
LOCK MORTISER**

**WHEN USING POWER TOOLS
ALWAYS WEAR
EYE AND EAR PROTECTION!!**

THINK SAFETY!!

**WHEN USING POWER TOOLS
ALWAYS WEAR
EYE PROTECTION!!**

Before attempting any installation know how to safely use the power tools involved. Be sure all bits and cutters are sharp and in good condition and all power tools and extension cords are in good working order and properly grounded. **AND MOST IMPORTANTLY, BE SURE TO WEAR, EYE AND EAR PROTECTION.**

Copyright 2012—Major Manufacturing Inc



Attach the mortiser attachment to the HIT-66 clamp set using the supplied 1/4-20 x 1-1/2" socket screws. The mortiser is held to the HIT-66 clamp system with two screws on top and two on the bottom. Leave all screws loose at this time.

NOTE: The HIT-66 clamps shown are not part of the HIT-66-200 mortiser set and must be purchased as a separate item.



Once all screws have been installed they can be tightened.



Slide the mortise bit into the unit and slide the stop collar on the end of the shaft.



With both clamps opened equally, install both inside and outside templates to the HIT-66 clamp as shown. Do not tighten the 10-32 screws at this time. When all screws have been loosely installed, then it is ok to tighten.



The next part to attach to the template is the alignment guide. When installed, it will align the mortise pocket to the drill guide. Notice the scribe mark in the picture at the left. The guide can be attached to either template, it is attached with two 10-32 x 3/4" flat head socket screws.



There are two clamps on the rod guides, one top and one bottom. When aligned to the top and bottom scribe lines on the guide plate, they will limit the travel. They are set up for a standard 6-1/2" mortise. The bottom of the top clamp should be on the top line, and the top of the bottom clamp should be on the bottom line. Tighten the screws when adjusted. To change the size of the mortise, use the scribe lines as a guide and adjust accordingly. To change the size of the mortise by 1/8" move each clamp 1/16" in the desired direction.





Using a pencil, establish the centerline of the mortise pocket as shown at left. Put the mortise unit on the door and align as shown on the right. Tighten the clamp knobs top and bottom alternating between the top and bottom clamp. Do not attempt to tighten one clamp all the way at once.



Touch the bit to the door edge and measure the depth that you want to drill. Tighten the stop collar, this will limit the depth of the mortise pocket.



Attach a drill motor to the cutter shaft and tighten the chuck.



Start at the bottom and drill a hole to depth. Back out the bit to clear the chips, do not attempt to drill the hole to depth all at once. Use a moderate drill speed 350 to 500 rpm.

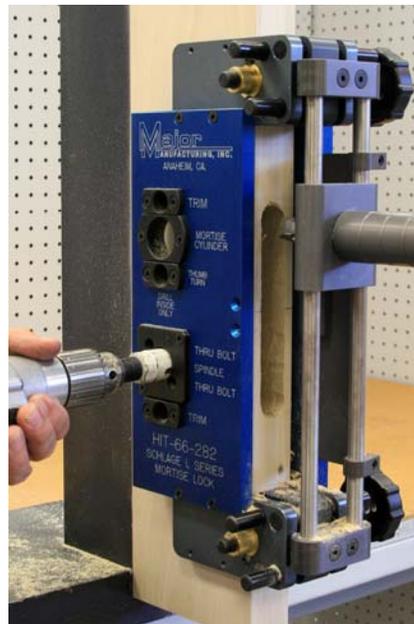


Drill a second hole above the first and continue up the door.



Once you have several holes drilled you can drill out between the webs.

Once the webs have been drilled out the cutter can be moved in and out up and down to clean out the pocket.



When the pocket has been completed, the lock function holes can be drilled. Make sure the mortise bit has been pulled out of the pocket!

The template shown is for a Schlage Mortise Lock, most of our HIT-66 Series will work with the mortiser. Follow the directions for the template used.

Here the spindle hole is being drilled to the mortise pocket.



Thru bolt holes being drilled on both sides of the door.

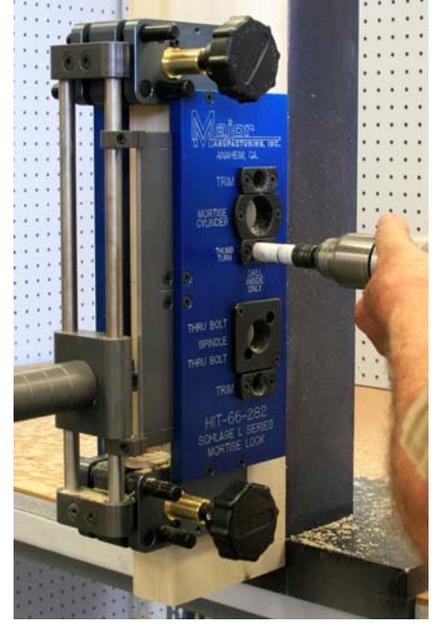




Thru bolt holes for the trim being drilled half way from both sides of the door.



Mortise cylinder hole being drilled to the pocket on the outside of the door.



Thumb turn hole being drilled on the right. This hole is drilled on the inside of the door to the pocket.



When all holes have been drilled, remove the template from the door.

Completed install shown at right.





This was the original layout line that we drew in the beginning. It can be used to center one of our router jigs to route the faceplate opening.



The prep is now ready for faceplate routing.

That's all there is to it!

Visit our web site at www.majormfg.com to see our complete line of tools and accessories.

While there, sign up for our new product releases and we will email them direct to you.