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DIRECTIONS FOR MCE-100 MORTISE CYLINDER EXTENSION DRILL GUIDE



Major

MANUFACTURING, INC.



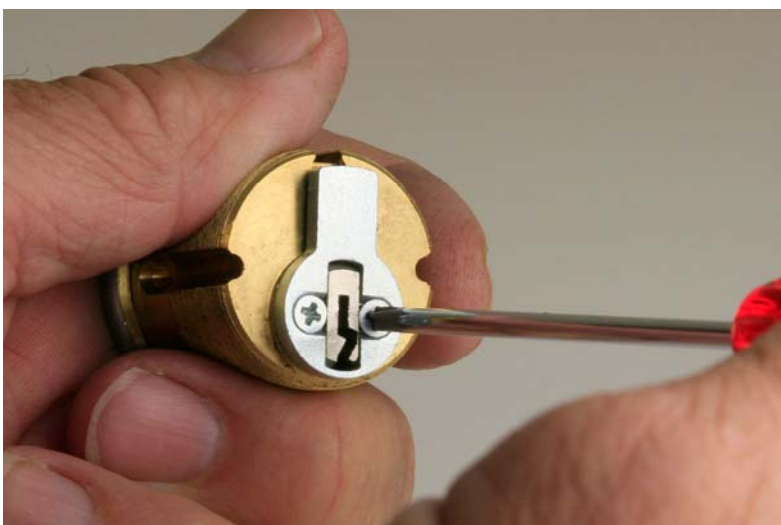
The MCE-100 drill guide is made up of a clamp to securely hold a mortise cylinder when drilling and tapping the required mounting holes. There is also the drill guide plate (gray) and tapping plate (red). Also included is the #29 drill bit with a stop and a 8-32 tap with a handle.



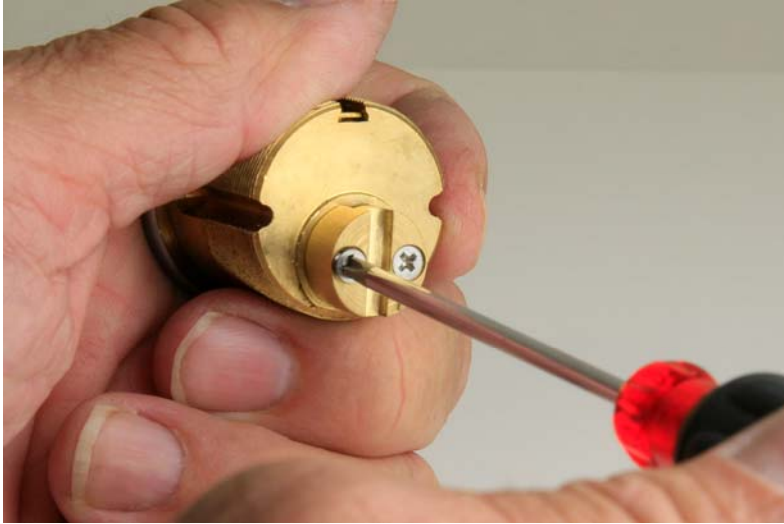
Mortise cylinder to be extended



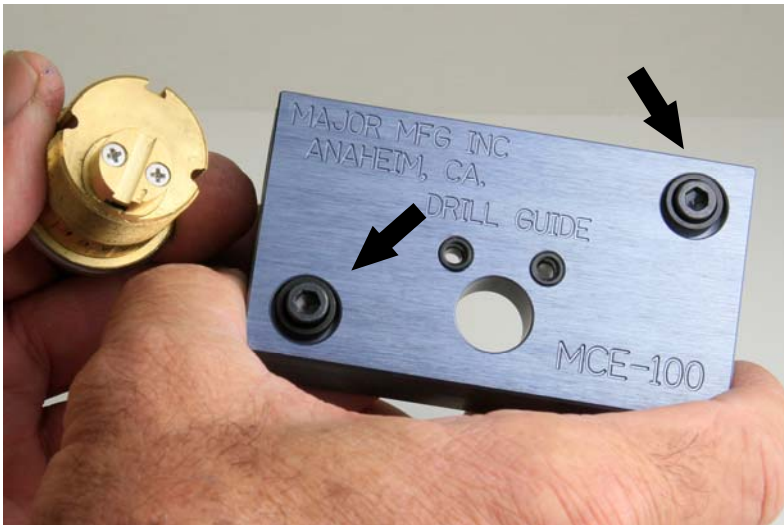
Extension kit and proper drive cam needed for the modification.



Remove the factory cam.



Install the proper cam driver in place of the lock cam. Use the screws provided, the original screws will be too short.



Install the drill guide plate (gray plate) on the cylinder clamp. Do not tighten the mounting screws (see arrows) at this time. The drive cam must be installed at this time, it is used to center the mounting holes.



There are two ball bearing detents inside the cylinder clamp. The detents will center the mortise cylinder in the clamp.



Make sure the mortise cylinder bottoms on the drill guide. There should be no space between the clamp and the drill guide.



Rotate the key and make sure the cylinder rotates freely on the drill guide. This will insure that everything will be aligned when drilling.



Once the cylinder rotates freely in the drill guide tighten the two cap screws. After the guide has been tightened, check to make sure the cylinder still turns free, if not, readjust. This step is important to insure a good working modification.



Tighten the mortise cylinder in the clamp unit.



Drill both holes with a #29 drill bit. Adjust the stop on the drill bit so the hole is drilled to a depth of about 3/4" (Adjust the stop so it is 1-1/4" above the tip of the drill bit.) This will allow plenty of room for to tap to the depth needed without bottoming out.



Remove the drill guide from the cylinder clamp. Do not remove the mortise cylinder at this time.



Install the tap guide on the clamp. The cap screws should be loose to allow the guide to float. This will allow the guide to self-align.



Be sure to lube tap with a cutting oil prior to tapping holes.



With the use of the red tap guide tap the first hole. Back out the tap frequently to clear chips from work.



Loosen the cap screw on the cylinder vise and remove the mortise cylinder.



These are the finished mounting holes for the extension unit.



Set the plug extender on the cam driver.

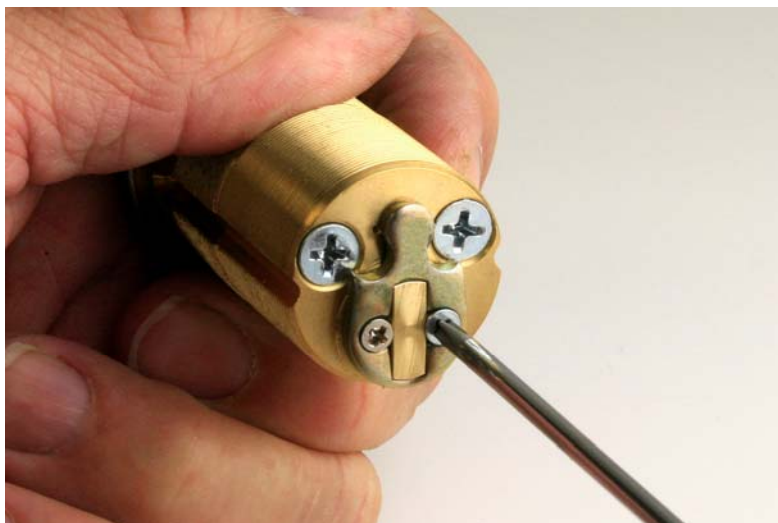


The plug extension will just set on the cam driver, it is captured by the housing when installed.

Put the housing over the extension and make sure the plug extension mates with the cylinder plug, see arrow.



Use the supplied 8-32 flat head screws to attach the extension unit to the mortise cylinder.



The mortise extension unit is designed to accept a Kaba Ilco brand cam. The use of other brands may not fit correctly and cause a problem with proper operation.

That's all there is to it!



The following drive cams are available.
Proper cam screws are included with
drive cam.

Visit our web site for
updates to this list.

MCE-D1
AMERICAN
KABA ILCO
LSDA
MARKS
SCHLAGE
U.S. LOCK
USCAN

MCE-D4
ARROW LOCK
SARGENT

MCE-D8
YALE

MCE-D5
CORBIN/RUSSWIN

MCE-D9
ASSA

MCE-D2
SCHLAGE PRIMUS

MCE-D6
GMS-IC CORE

MCE-D10
SCHLAGE LG FORMAT
I/C

MCE-D3
MEDECO

MCE-D7
GMS-STD.

