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**INSTRUCTIONS  
FOR  
HIT-66-275 TEMPLATE  
FOR  
SARGENT "IN" SERIES  
MORTISE LOCK**

**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.**

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# Drill Bit Types



All hole saws are not created equal. A cheap hole saw from a home improvement center or one that has been dropped can be out of round and will not fit the drill bushings in our templates. When using hole saws, pull the hole saw out of the cut frequently to clear chips.



Shown above is a standard twist drill bit. They can be used on both wood or steel doors. Be sure to back out the bit when drilling to clear chips.



Shown above and at right is a brad point bit. They will produce a very clean hole in a wood door. Use at a low speed and back the bit out to clear chips. Do not use on a steel door.



Shown above is a tri-flute drill bit. Do not attempt to use this in a drill guide. The lack of bearing surface will cause the bit to jam.



Shown above is a spade or paddle type bit. Do not attempt to use this in any drill guide. There is no bearing surface and you will jam the bit.



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.

**NOTE: The HIT-66 clamps shown are not part of the HIT-66-275 template set and must be purchased as a separate item.**



Install the drill guide for the optional external DPS to the front of the HIT-66 clamps as shown. Do not tighten the 1/4-20 screws at this time. When all screws have been loosely installed, then it is ok to tighten.



Install the alignment guide to either side of the template set. This is used to align the template with the mortise pocket.



Shown at left is a standard mortise pocket, we will use this as a basis for the Sargent IN Lock install.



Install the mortise lock positioning plate. The plate will fit into the 1-1/4" x 8" faceplate cut out. There will be a 3/8" diameter pin centered on the plate. There is no top or bottom to worry about. Use the screws supplied with the mortise lock.



Slide the HIT-66 alignment fixture over the alignment pin and tighten to door. Alternate tightening between the top and bottom clamp. Do not attempt to tighten one clamp all the way at once.



There are two overlapping holes for drill bushings. One is for an optional outside cylinder, the other is for a wire chase. The hardened drill guides must be correctly installed for the hand of the door.

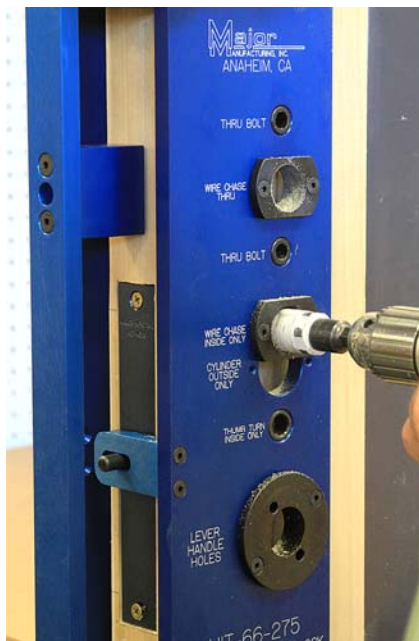




Start by drilling the two 3/8" thru bolt holes. Drill half way from both sides of the door.



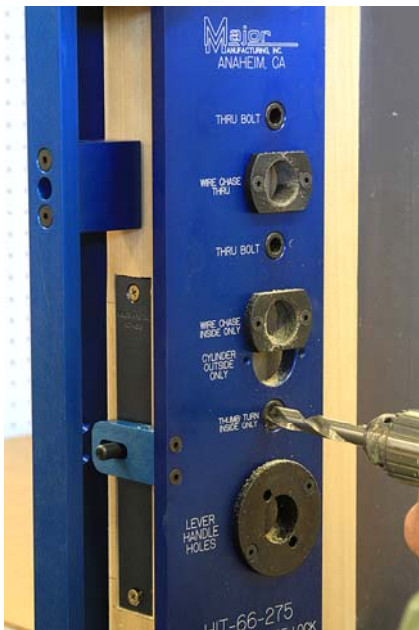
With a 1" hole saw drill the top wire chase hole. This hole goes through the door. Drill half way from both sides of the door. Back the hole saw out once or twice when drilling to clear the chips from the cut.



With the 1" hole saw still in the drill, drill the inside wire chase hole. This hole is drilled to the mortise pocket on the inside only. Back the hole saw out once or twice when drilling to clear the chips from the cut.



Change to a 1-1/4" hole saw and drill for the mortise cylinder if required. This hole is drilled on the outside of the door to the mortise pocket. Back the hole saw out once or twice when drilling to clear the chips from the cut.



If using a thumb turn, use a 1/2" drill bit and drill the inside of the door to the mortise pocket.



With a 1/4" drill bit, drill the holes for the lever posts. Drill these holes before drilling the center hole. Drill half way from both sides of the door.





Use a 1-1/8" hole saw and drill for the lever spindle. Drill this hole half way from both sides of the door. Back the hole saw out once or twice when drilling to clear the chips from the cut.



If installing the optional external DPS, drill this hole with a 3/8" drill bit to the wire chase hole. Be sure to back the drill bit all the way out of the guide to clear chips.



If installing on a steel door, see below.



If installing on a steel door, increase the 3/8" hole to 3/4" with the use of a step drill.





Outside



Inside

**Completed installation**

**That's all there is to it!**

**Visit our web site at [www.majormfg.com](http://www.majormfg.com) for more information on lock templates and a complete listing of all the tools we have available. While there, sign up for our newsletter and we will email new product information directly to you.**