

I. OPERATION

OPERATIONAL INSTRUCTIONS

A. Mark edge of door

Mark the edge of the door where the center of the hole needs to be bored. Using the Scribe marks on the fixture, position the fixture over the marked line. Securely clamp the fixture in place. Be sure the unit does not slip out of position while clamping in place.

B. Insert bushing

Choose the bushing size required and place bushing into the fixture. Secure the bushing in place with the button head cap screw.

The drill bit should be mounted in a heavy-duty 1/2" drill. An 18" OAL drill bit (or shorter) can be used with the fixture mounted on the door. For a deeper hole, drill a hole using the fixture with a shorter bit (e.g. 18"), then remove the fixture, replace short drill bit with longer drill bit. Using the pre-drilled hole as a pilot-hole, drill the additional depth required.

C. Using the stop bar

If you are going to replicate the hole in a quantity of doors, use the stop bar to set the distance of the hole from the edge of the door. This is especially useful when boring for extended flushbolts and ball catches. After the fixture is set in place, and the position is determined to be accurate, loosen the thumbscrews for the stop bar; slide the bar down to hit against the door edge. Tighten thumbscrews. Fixture is now preset to reproduce a hole a constant distance from the door edge.

CAUTION: Obtaining a true and straight hole requires some operator technique. The drill bit will be encountering a wide variety of materials which can deflect the drill direction. The following are techniques that have proven to give the best results.

1. Keep drill bit properly sharpened.
2. Do not force the bit. Let it cut so it can maintain the proper direction.
3. Clear the bit of chips frequently.



The Masterline Drillmaster Fixture is designed to guide a drill bit securely in the edge of a door. The unit is designed to be used on 1-3/8" to 2" thick doors and to self-center the position of the hole on the door edge. Bushing sizes available range from 3/8" to 1" in 1/8" increments. A Stop Bar is also included to aid in reproducing a hole in the same location through a batch of doors.

2. OPTIONAL DRILL GUIDE BUSHINGS

7715-012	3/8"	Guide Bushing
7715-016	1/2"	Guide Bushing
7715-020	5/8"	Guide Bushing
7715-024	3/4"	Guide Bushing
7715-028	7/8"	Guide Bushing
7715-032	1"	Guide Bushing

AS A REMINDER:

IMPORTANT SAFETY INSTRUCTIONS

WARNING: When using electric tools, basic precautions should be followed to reduce the risk of fire, electric shock and personal injury.

READ & FOLLOW ALL INSTRUCTIONS: This tool was designed for specific applications. Norfield Industries strongly recommends that this tool NOT be modified and/or used for applications other than those for which it was designed.

If you have any questions about additional applications or uses, DO NOT attempt those uses or modifications until you have been advised by a qualified Norfield Representative. Any and all modifications to or misuses of the tool will void all warranties.

A. Avoid dangerous environments

Do not expose equipment to rain or use in damp conditions.

Do not use tool in presence of flammable liquids or gases.

B. Dress properly

Do not wear loose clothing or jewelry. Loose clothing, drawstrings and jewelry can be caught in moving parts. Wear protective hair covering to contain long hair.

C. ALWAYS use safety glasses

D. Maintain machine tools properly

Keep cutters sharp and clean for better and safer performance.

Always use correct-size cutters.

Inspect all electrical cords periodically and replace if damaged.

E. Disconnect electrical supply cord

Always disconnect cord before servicing, cleaning, changing cutters or adding accessories.

F. Stay alert

Watch what you are doing. Use common sense. Do not operate equipment when you are tired or under the influence of medication, alcohol or drugs.

SAVE THESE INSTRUCTIONS