



I. SAFETY INSTRUCTIONS

A. Use only ½” diameter shank router bit

Using a smaller shank could result in injury to the operator due to the distance the shank must protrude outside the router collet.

B. Begin routing with router base firmly against template and router bit retracted

C. DO NOT insert router bit through template slot with router running

This will greatly increase the risk of injury to the operator and increase the potential of permanent damage to templates and the fixture.

D. DO NOT lift router base from template until router bit has come to a stop

This will greatly increase the risk of injury to the operator and increase the potential of permanent damage to templates and the fixture.

E. Avoid cutting materials with nails or knots

Inspect for and remove all nails and attempt to lay out cuts between knots.

F. Make multiple shallow cuts instead of one deep cut

2. RECOMMENDED EQUIPMENT USED WITH THE T-MASTER

A. ROUTER

BOSI 617EVS 2HP Plunge Router or equivalent (recommended because of quick change template guide)

B. BITS

½” diameter x 4-1/2” long router bit; FST 072 or equivalent. (use with 5/8” OD guide)

For T-strike plates only; use a ½” diameter Top-Bearing Bit (SAF85) without the template guide.

C. TEMPLATE GUIDE

5/8” outside diameter guide: POR42045 or BOSI 113 or equivalent (use with ½” dia bit)

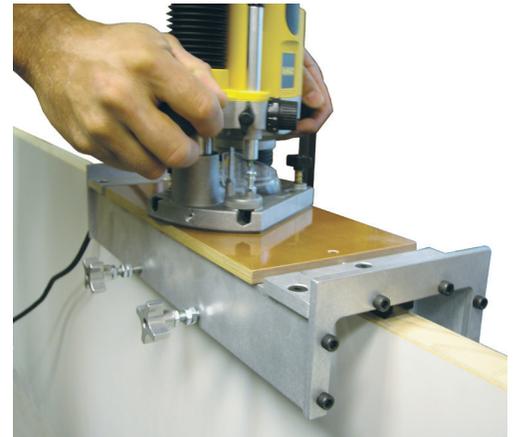
3. ADJUSTMENT

Centering of the template on the door is accomplished by adjusting the knobs on the side of the template that has the jamb nuts. The two knobs adjusted “OUT” all the way adjusts the template for a 1-3/4” door. Adjusting the knobs “IN” all the way adjusts the template for a 1-3/8” door. To install or remove a template after initial centering you need only tighten or loosen the clamp knobs on one side of the template. (Centerlines have been provided for any special alignment).

The unit position lengthwise on the door is determined by measuring usually from the top of the door.

Set the plunge router for two depth settings – 1) for strike plate thickness, and 2) for latch pocket depth. It may take multiple plunge adjustments on some latch pockets.

OPERATIONAL INSTRUCTIONS

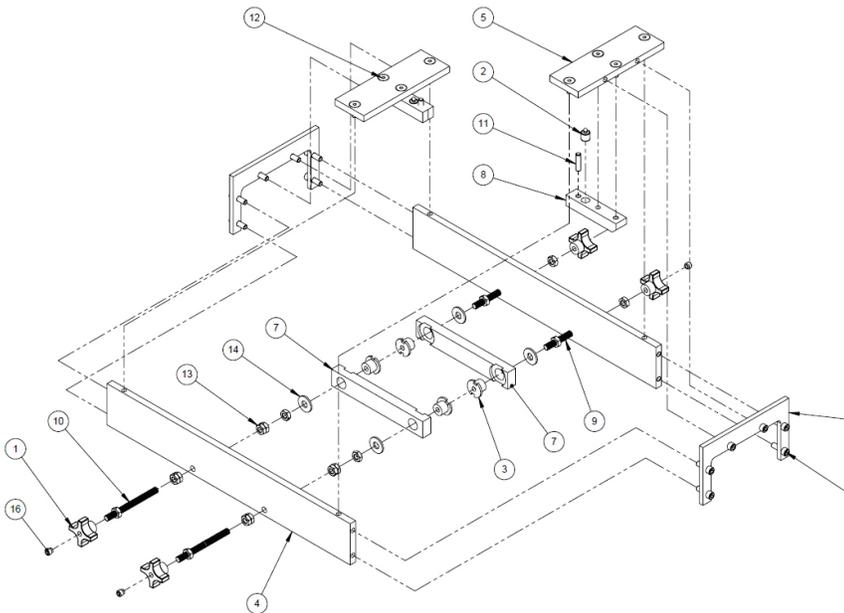


The T-Master is designed for the installation of lock hardware in the edge of a door with or without the T-astragal installed.

4. OPERATION

- Slide the template over the T-astagal from the door end. Center the template (refer to 4-first bullet above) and clamp it firmly to the door. While tightening clamps, be sure the template stays square to the door face. The template should only touch the high point of the bevel on the astragal.
- Most strike plates require the use of two templates; one for the pocket and one for the plate itself. Once the fixture has been clamped into position, templates can be exchanged to do the required machining without readjustment.
- For T-strike plates, begin with the strike plate template and 5/8" template guide REMOVED (the bearing on the Norfield SAF 85 router bit acts as the template guide). Place the router on the template with the bit retracted. Plunge the bit to the strike plate depth and position router so the bit is not in contact with wood before starting the motor. **CAUTION – Care needs to be taken when starting the router motor that the bit does not grab the wood which could cause injury or damage to the templates.** When the motor has reached full speed follow the template to make the strike plate mortise. **CAUTION – Let the router motor come to a complete stop before removing it from the template. This will prevent injury or damage to templates.** Install the 5/8" template guide on the router (disconnect the electrical power during this installation). Remove the strike plate template and install the pocket template. With the router bit fully retracted place the router on the template. Start the router motor and make plunge cuts of approximately 1/2" deep until the desired depth is achieved. **REMEMBER --let the motor stop before removing the router from the template.**
- For all other plates, begin with the strike plate template and 5/8" template guide installed. Place the router on the template with the bit retracted. Plunge the bit to the strike plate depth and position the router so the bit is not in contact with wood before starting the motor. **CAUTION – Care needs to be taken when starting the router motor that the bit does not grab the wood, causing injury or damage to the templates.** When the motor has reached full speed, follow the template to make the strike plate mortise. **CAUTION – Let the router motor come to a complete stop before removing from the template. This will prevent injury or damage to the templates.** Remove the strike plate template and install the pocket template. With the router bit fully retracted, place the router on the template. Start the router motor and make plunge cuts of approximately 1/2" deep until the desired depth is achieved. **REMEMBER – let the motor stop before removing the router from the template.**

5. ASSEMBLY



Diag#	Part#	Descript	Qty
1	13-505	KNOB	4
2	13-579	Pin	2
3	7572-004	Clamp Nut	4
4	7707-001	SIDE PLATE	2
5	7707-002	GUIDE PLATE	2
6	7707-003	END PLATE	2
7	7707-004	Clamp	2
8	7707-005	Door Guide	2
9	9510-300	5/16-18 x 3" REDI-THREAD	2
10	9510-350	5/16-18 x 3-1/2" Threaded Shaft	2
11	*****	1/4" X 1" DOWEL PIN	2
12	*****	1/4-20 x 3/4" FHCS	8
13	*****	5/16-18 HEX JAMB NUT	16
14	*****	5/16 FLAT WASHER	4
15	*****	1/4-20 X 3/4" SHCS	12
16	*****	5/16-18 X 1/4 SS	4

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