

I. OPERATION

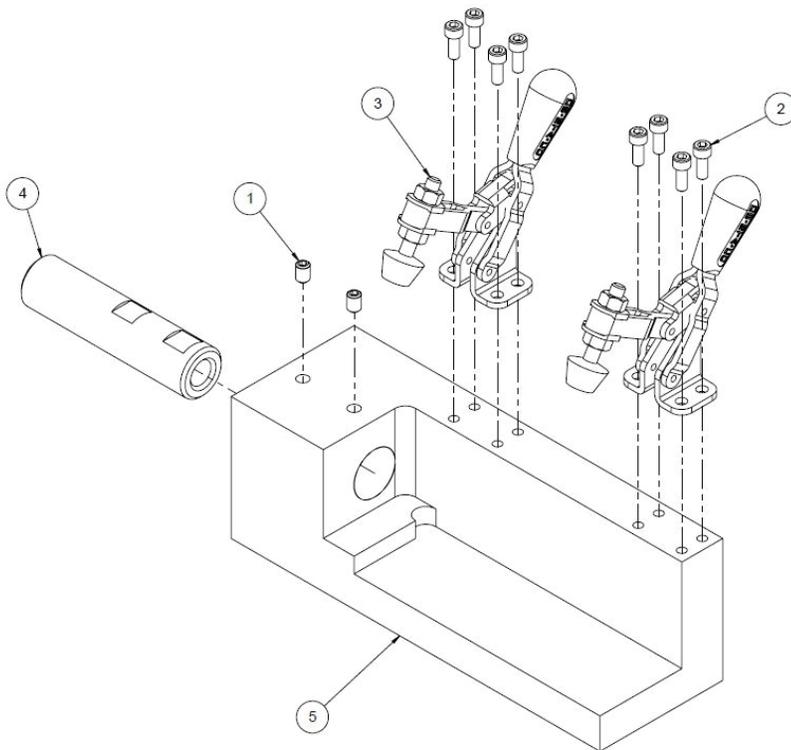
A. Adjust clamp bolts

Adjust the clamp bolts so the unit is firmly held on the door corner. The drill bit should be mounted in a heavy-duty 1/2" drill. A 12" deep hole can be drilled with the fixture mounted on the door. For a 16" deep hole drill a 12" deep hole using the fixture, then remove the fixture and drill the additional 4".

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.

2. REPLACEMENT PARTS



OPERATIONAL INSTRUCTIONS



The Extension Flush Bolt Drill Fixture is designed to drill a 1/2" diameter hole up to 16" long in a door for the extension rod on a flush bolt. The unit is primarily designed to be used on 1-3/4" thick doors and to position the center of the hole 3/4" from the door edge. Shims can be used for applications on thinner doors or if the hole location is to be less than 3/4" from the edge.

Diag#	Part#	Description	Qty
1	*****	1/4-20 x 3/8" Set Screw	2
2	*****	10-24 x 1/2" SHCS	8
3	13-578	Clamp	2
4	7708-001	Drill Bushing	1
5	7708-003	Flush Bolt Drill Plate	1
(Optional)	FUL256	1/2" DIA X 18" OAL BRAD POINT DRILL BIT	

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