



I. SAFETY RULES FOR FLUSH BOLT FIXTURE

OPERATIONAL INSTRUCTIONS

A. Use ONLY 1/2" diameter shank router bit

Using a smaller size shank could result in injury to operator due to the length of shank which must protrude outside the router collet.

B. Always begin routing with router base firmly against fixture...

and router guide and bit outside of fixture slot.

C. Do not attempt to insert router bit down through fixture slot to begin routing

This will greatly increase the risk of injury to the operator and also increase the potential of permanent damage to the top plates of the flushbolt fixture.

D. Do not lift router base from flushbolt fixture...

until after router bit rotation has stopped and router guide and bit are fully retracted outside of fixture slot.

E. Avoid cutting materials with nails or knots

Inspect for and remove all nails. Cutting through knots or glued material may compromise finished product.



2. SUPPLEMENTAL EQUIPMENT AND DATA

A. Use of flushbolt fixture requires:

1-1/2 HP Router

POR690 or equivalent

3/4" Diameter 1/2" shank router bit

WH11085 or equivalent

Fixture template guide and nut

POR42030 Guide or equivalent

POR42237 Lock-Nut or equivalent

3. ADJUSTMENT

A. Router bit must protrude approximately 1-5/8" from router base

B. Adjustment tabs provided to accommodate differences in hardware sizes

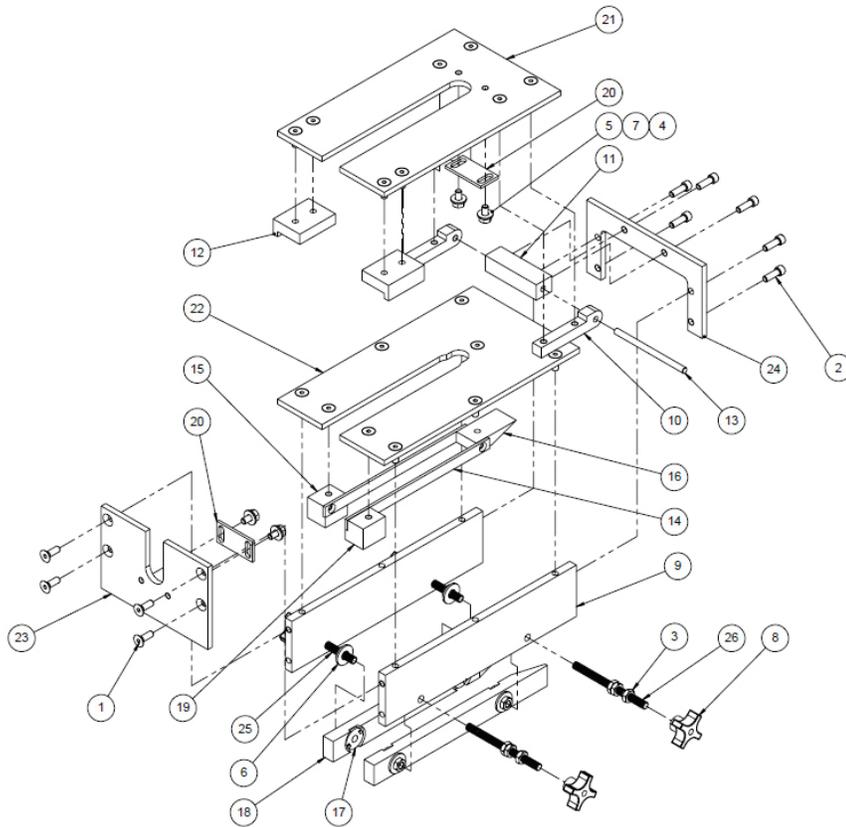
They are located at the ends of the fixture slots and can be adjusted by loosening the hex head screws, moving the tab and then securely tightening the screws

C. Centering of Fixture on Door...

is accomplished by adjusting the knobs on the side of the fixture that contains jam nuts. The two knobs adjusted "OUT" all the way adjusts the fixture for a 1-3/4" door. Adjusting the knobs "IN" all the way adjusts the fixture for a 1-3/8" door. To install or remove fixture after initial centering, you need only tighten or loosen the clamp knobs on one side of the fixture.

4. OPERATION

- A. Slide the fixture over the T-astragal from the door end. Center the fixture (refer to 4 C above) and clamp it firmly to the door. While tightening clamps, be sure the fixture stays square to the door face. The fixture should only touch the high point of the bevel on the astragal.
- B. Begin routing with the router base firmly against the top of the fixture and the router guide and bit outside of fixture slot. Move router the full length of the fixture slot and then reverse direction until router guide and bit are fully retracted from the fixture slot before lifting router base from fixture.
- C. Raise hinged plate on top of fixture and repeat Step B for plunge rout.
- D. Loosen the unlocked clamp knobs to remove the flushbolt fixture from door.



Diag#	Part#	Description	Qty	Diag#	Part#	Description	Qty
1	*****	1/4-20 x 3/4" FHCS	21	14	7572-001	SPACER	2
2	*****	1/4-20 x 3/4" SHCS	6	15	7572-002	SPACER BLOCK	1
3	*****	5/16-18 Hex Jamb Nut	16	16	7572-003	DOOR GUIDE	1
4	*****	1/4" Lock Washer	4	17	7572-004	CLAMP NUT	4
5	*****	1/4" Flat Washer	4	18	7572-005	CLAMP	2
6	*****	5/16 Flat washer	4	19	7572-006	SPACER BLOCK	1
7	*****	1/4-20 x 1/2" Hex Bolt	4	20	7573-001	STOP PLATE	2
8	13-505	Knob	4	21	7574-001	HINGED PLATE	1
9	7570-002	SIDE PLATE	2	22	7574-002	TOP PLATE I	
10	7571-003	PIVOT	2	23	7574-003	END PLATE	1
11	7571-004	PIVOT BLOCK	1	24	7575-001	PIVOT PLATE	1
12	7571-005	GUIDE BLOCK	2	25	9510-350	5/16-18 x 3-1/2" Threaded Shaft	2
13	7571-006	PIVOT PIN	1	26	9510-400	5/16-18 x 4" Threaded Shaft	2

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